

UNI DRILL 503

SOLID CARBIDE TWIST DRILL

DIN 6539, TO 3 x D Plain w/o Coolant Hole
Short type, TiN, TiAlN FUTURA-coated, cylindrical shank cutting dia, equal dia, right hand cut.

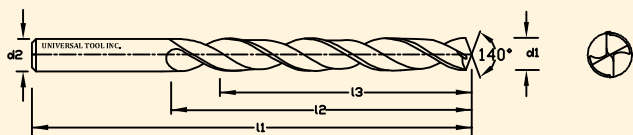
GEOMETRY AND APPLICATION

Point grind: special point. CNC grinding/point angle :140°/ Side rack angle: 30°/ Web thickness : reinforced / Profile: Special chip flute geometry.

High performance spiral twist drill for highest bore hole quality and economical output for drilling of cast iron, malleable cast iron, steel, steel casting, Cr-Ni-steels, heat resisting steel, non-ferrous metals. Specially suited for NC-drilling with great feeds per rev.

Also offered on intermediate sizes on & with internal Thro' Coolant

L3 = Hole depth



Contd

(UNI DRILL 503) SOLID CARBIDE TWIST DRILL (3 X D)

Order aNo.	d1	d2	L1	L2	L3	Z	Prices
503-0057	5.7	5.7	66	28	20	2	
503-0058	5.8	5.8	66	28	20	2	
503-0059	5.9	5.9	66	28	20	2	
503-0060	6.0	6.0	66	28	20	2	
503-0061	6.1	6.1	66	28	20	2	
503-0062	6.2	6.2	66	28	20	2	
503-0063	6.3	6.3	66	28	20	2	
503-0064	6.4	6.4	66	28	20	2	
503-0065	6.5	6.5	79	34	24	2	
503-0066	6.6	6.6	79	34	24	2	
503-0067	6.7	6.7	79	34	24	2	
503-0068	6.8	6.8	79	34	24	2	
503-0069	6.9	6.9	79	34	24	2	
503-0070	7.0	7.0	79	34	24	2	
503-0071	7.1	7.1	79	34	24	2	
503-0072	7.2	7.2	79	34	24	2	
503-0073	7.3	7.3	79	34	24	2	
503-0074	7.4	7.4	79	34	24	2	
503-0075	7.5	7.5	79	41	29	2	
503-0076	7.6	7.6	79	41	29	2	
503-0077	7.7	7.7	79	41	29	2	
503-0078	7.8	7.8	79	41	29	2	
503-0079	7.9	7.9	79	41	29	2	
503-0080	8.0	8.0	79	41	29	2	
503-0081	8.1	8.1	79	41	29	2	
503-0082	8.2	8.2	79	41	29	2	
503-0083	8.3	8.3	79	41	29	2	
503-0084	8.4	8.4	79	41	29	2	
503-0085	8.5	8.5	89	47	35	2	
503-0086	8.6	8.6	89	47	35	2	
503-0087	8.7	8.7	89	47	35	2	
503-0088	8.8	8.8	89	47	35	2	
503-0089	8.9	8.9	89	47	35	2	
503-0090	9.0	9.0	89	47	35	2	
503-0091	9.1	9.1	89	47	35	2	
503-0092	9.2	9.2	89	47	35	2	
503-0093	9.3	9.3	89	47	35	2	
503-0094	9.4	9.4	89	47	35	2	
503-0095	9.5	9.5	89	47	35	2	
503-0096	9.6	9.6	89	47	35	2	
503-0097	9.7	9.7	89	47	35	2	
503-0098	9.8	9.8	89	47	35	2	
503-0099	9.9	9.9	89	47	35	2	
503-0100	10.0	10.0	89	47	35	2	
503-0101	10.1	10.1	89	47	35	2	

Order No.	d1	d2	L1	L2	L3	Z
503-0030	3.0	3.0	62	20	14	2
503-0031	3.1	3.1	62	20	14	2
503-0032	3.2	3.2	62	20	14	2
503-0033	3.3	3.3	62	20	14	2
503-0034	3.4	3.4	62	20	14	2
503-0035	3.5	3.5	62	20	14	2
503-0036	3.6	3.6	62	20	14	2
503-0037	3.7	3.7	62	20	14	2
503-0038	3.8	3.8	62	20	14	2
503-0039	3.9	3.9	62	20	14	2
503-0040	4.0	4.0	66	24	17	2
503-0041	4.1	4.1	66	24	17	2
503-0042	4.2	4.2	66	24	17	2
503-0043	4.3	4.3	66	24	17	2
503-0044	4.4	4.4	66	24	17	2
503-0045	4.5	4.5	66	24	17	2
503-0046	4.6	4.6	66	24	17	2
503-0047	4.7	4.7	66	24	17	2
503-0048	4.8	4.8	66	24	17	2
503-0049	4.9	4.9	66	24	17	2
503-0050	5.0	5.0	66	28	20	2
503-0051	5.1	5.1	66	28	20	2
503-0052	5.2	5.2	66	28	20	2
503-0053	5.3	5.3	66	28	20	2
503-0054	5.4	5.4	66	28	20	2
503-0055	5.5	5.5	66	28	20	2
503-0056	5.6	5.6	66	28	20	2

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(UNI DRILL 503) SOLID CARBIDE TWIST DRILL (3 X D)

Order No.	d1	d2	L1	L2	L3	Z
503-0102	10.2	10.2	102	55	40	2
503-0103	10.3	10.3	102	55	40	2
503-0104	10.4	10.4	102	55	40	2
503-0105	10.5	10.5	102	55	40	2
503-0106	10.6	10.6	102	55	40	2
503-0107	10.7	10.7	102	55	40	2
503-0108	10.8	10.8	102	55	40	2
503-0109	10.9	10.9	102	55	40	2
503-0110	11.0	11.0	102	55	40	2
503-0111	11.1	11.1	102	55	40	2
503-0112	11.2	11.2	102	55	40	2
503-0113	11.3	11.3	102	55	40	2
503-0114	11.4	11.4	102	55	40	2
503-0115	11.5	11.5	102	55	40	2
503-0116	11.6	11.6	102	55	40	2
503-0117	11.7	11.7	102	55	40	2
503-0118	11.8	11.8	102	55	40	2
503-0119	11.9	11.9	102	55	40	2
503-0120	12.0	12.0	102	55	40	2
503-0125	12.5	12.5	107	60	43	2
503-0128	12.8	12.8	107	60	43	2
503-0130	13.0	13.0	107	60	43	2
503-0135	13.5	13.5	107	60	43	2
503-0139	13.9	13.9	107	60	43	2
503-0140	14.0	14.0	107	60	43	2
503-0145	14.5	14.5	115	65	45	2
503-0149	14.9	14.9	115	65	45	2
503-0150	15.0	15.0	115	65	45	2
503-0155	15.5	15.5	115	65	45	2
503-0160	16.0	16.0	115	65	45	2
503-0165	16.5	16.5	123	73	51	2
503-0170	17.0	17.0	123	73	51	2
503-0175	17.5	17.5	123	73	51	2
503-0180	18.0	18.0	123	73	51	2
503-0185	18.5	18.5	131	79	55	2
503-0190	19.0	19.0	131	79	55	2
503-0195	19.5	19.5	131	79	55	2
503-0200	20.0	20.0	131	79	55	2
503-0210	21.0	21.0	165	104	75	2
503-0220	22.0	22.0	165	104	75	2
503-0230	23.0	23.0	165	104	75	2
503-0240	24.0	24.0	165	104	75	2
503-0250	25.0	25.0	165	104	75	2
503-0260	26.0	26.0	173	126	75	2
503-0270	27.0	27.0	173	126	75	2

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SOLID CARBIDE TWIST DRILL

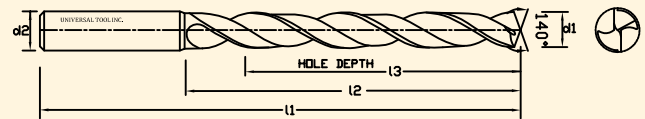
DIN 6537 B to 3 x D (Similar to Sandvik Delta 'c')

GOMETRY AND APPLICATION

Point grind: Special point, CNC- grinding/point angle : 140°/
Side rack angle: 30° / Web thickness : reinforced / Profile :special chip
flute geometry.

High performance spiral twist drill for highest bore hole quality and
economical out-put for drilling of cast iron, malleable iron , steel
casting, Cr-Ni-Steels, heatresisting steel, non -ferrous metals. Specially
suited for NC-drilling with great feeds per rev.

L3 = Hole depth w/o coolant



Order No.	d1	d2	L1	L2	L3	Z
504-0030	3.00	6.00	62	20	14	2
504-0033	3.30	6.00	62	20	14	2
504-0035	3.50	6.00	62	20	14	2
504-0040	4.00	6.00	66	24	17	2
504-0042	4.20	6.00	66	24	17	2
504-0045	4.50	6.00	66	24	17	2
504-0050	5.00	6.00	66	28	20	2
504-0055	5.50	6.00	66	28	20	2
504-0060	6.00	6.00	66	28	20	2
504-0065	6.50	8.00	79	34	24	2
504-0066	6.60	8.00	79	34	24	2
504-0068	6.80	8.00	79	34	24	2
504-0070	7.00	8.00	79	34	24	2
504-0075	7.50	8.00	79	41	29	2
504-0080	8.00	8.00	79	41	29	2
504-0085	8.50	10.00	89	47	35	2
504-0090	9.00	10.00	89	47	35	2
504-0095	9.50	10.00	89	47	35	2
504-0100	10.00	10.00	89	47	35	2
504-0102	10.20	12.00	102	55	40	2
504-0105	10.50	12.00	102	55	40	2
504-0110	11.00	12.00	102	55	40	2
504-0115	11.50	12.00	102	55	40	2
504-0118	11.80	12.00	102	55	40	2
504-0120	12.00	12.00	102	55	40	2
504-0125	12.50	14.00	107	60	43	2
504-0130	13.00	14.00	107	60	43	2
504-0135	13.50	14.00	107	60	43	2
504-0140	14.00	14.00	107	60	43	2

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(UNI DRILL 504) SOLID CARBIDE TWIST DRILL (3 X D)

Order No.	d1	d2	L1	L2	L3	Z
504-0145	14.50	16.00	115	65	45	2
504-0150	15.50	16.00	115	85	45	2
504-0160	16.00	16.00	115	85	45	2
504-0165	16.50	18.00	123	73	51	2
504-0170	17.00	18.00	123	73	51	2
504-0175	17.50	18.00	123	73	51	2
504-0180	18.00	18.00	123	73	51	2
504-0185	18.50	20.00	131	79	55	2
504-0190	19.00	20.00	131	79	55	2
504-0195	19.50	20.00	131	79	55	2
504-0200	20.00	20.00	131	79	55	2
504-0220	22.00	25.00	165	105	75	2
504-0240	24.00	25.00	165	105	75	2
504-0250	25.00	25.00	165	105	75	2
504-0260	26.00	32.00	190	126	90	2
504-0280	28.00	32.00	190	126	90	2
504-0300	30.50	32.00	190	126	90	2
504-0320	32.00	32.00	190	126	90	2
504-0340	34.00	32.00	190	126	90	2
504-0360	36.00	32.00	190	126	90	2
504-0380	38.00	32.00	190	126	90	2
504-0400	40.00	32.00	190	126	90	2

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SOLID CARBIDE TWIST DRILL

DIN 6537 B TO 5 X D

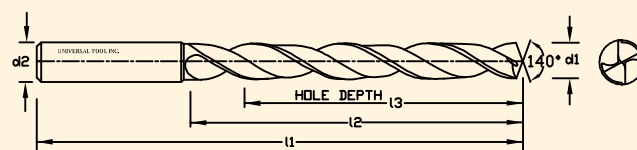
Short type, TiN-TiAlN- coated, cylindrical shank
With clamping fixture DIN 6535 HE, right hand cut..

GEOMETRY AND APPLICATION

Point grind: Special point, CNC grinding/point angle : 140°/ side rack angle : 30°/ Web thickness: reinforced/ profile: Special chip flute geometry. High performance spiral twist drill for highest bore hole quality and economical out-put. For drilling of cast iron, malleable cast iron, steel casting, Cr-Ni-Steels, heat resisting steel, non-ferrous metals. Specially suited for NC-drilling with great feeds per rev.

Also offered on intermediate sizes on request

L3 = Hole depth w/o coolant



Order No.	d1	d2	L1	L2	L3	Z
505-0030	3.00	6.00	66	28	23	2
505-0031	3.10	6.00	66	28	23	2
505-0032	3.20	6.00	66	28	23	2
505-0033	3.30	6.00	66	28	23	2
505-0034	3.40	6.00	66	28	23	2
505-0035	3.50	6.00	66	28	23	2
505-0036	3.60	6.00	66	28	23	2
505-0037	3.70	6.00	66	28	23	2
505-0038	3.80	6.00	74	36	29	2
505-0039	3.90	6.00	74	36	29	2
505-0040	4.00	6.00	74	36	29	2
505-0041	4.10	6.00	74	36	29	2
505-0042	4.20	6.00	74	36	29	2
505-0043	4.30	6.00	74	36	29	2
505-0044	4.40	6.00	74	36	29	2
505-0045	4.50	6.00	74	36	29	2
505-0046	4.60	6.00	74	36	29	2
505-0047	4.70	6.00	74	36	29	2
505-0048	4.80	6.00	82	44	35	2
505-0049	4.90	6.00	82	44	35	2
505-0050	5.00	6.00	82	44	35	2
505-0051	5.10	6.00	82	44	35	2
505-0052	5.20	6.00	82	44	35	2
505-0053	5.30	6.00	82	44	35	2
505-0054	5.40	6.00	82	44	35	2
505-0055	5.50	6.00	82	44	35	2
505-0056	5.60	6.00	82	44	35	2

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(UNI DRILL 505) SOLID CARBIDE TWIST DRILL
DIN 6537 B TO 5 X D

Order No.	d1	d2	L1	L2	L3	Z
505-0057	5.70	6.00	82	44	35	2
505-0058	5.80	6.00	82	44	35	2
505-0059	5.90	6.00	82	44	35	2
505-0060	6.00	6.00	82	44	35	2
505-0061	6.10	8.00	91	53	43	2
505-0062	6.20	8.00	91	53	43	2
505-0063	6.30	8.00	91	53	43	2
505-0064	6.40	8.00	91	53	43	2
505-0065	6.50	8.00	91	53	43	2
505-0066	6.60	8.00	91	53	43	2
505-0067	6.70	8.00	91	53	43	2
505-0068	6.80	8.00	91	53	43	2
505-0069	6.90	8.00	91	53	43	2
505-0070	7.00	8.00	91	53	43	2
505-0071	7.10	8.00	91	53	43	2
505-0072	7.20	8.00	91	53	43	2
505-0073	7.30	8.00	91	53	43	2
505-0074	7.40	8.00	91	53	43	2
505-0075	7.50	8.00	91	53	43	2
505-0076	7.60	8.00	91	53	43	2
505-0077	7.70	8.00	91	53	43	2
505-0078	7.80	8.00	91	53	43	2
505-0079	7.90	8.00	91	53	43	2
505-0080	8.00	8.00	91	53	43	2
505-0081	8.10	10.00	103	61	49	2
505-0082	8.20	10.00	103	61	49	2
505-0083	8.30	10.00	103	61	49	2
505-0084	8.40	10.00	103	61	49	2
505-0085	8.50	10.00	103	61	49	2
505-0086	8.60	10.00	103	61	49	2
505-0087	8.70	10.00	103	61	49	2
505-0088	8.70	10.00	103	61	49	2
505-0089	8.80	10.00	103	61	49	2
505-0090	9.00	10.00	103	61	49	2
505-0091	9.10	10.00	103	61	49	2
505-0092	9.20	10.00	103	61	49	2
505-0093	9.30	10.00	103	61	49	2
505-0094	9.40	10.00	103	61	49	2
505-0095	9.50	10.00	103	61	49	2
505-0096	9.60	10.00	103	61	49	2
505-0097	9.70	10.00	103	61	49	2
505-0098	9.80	10.00	103	61	49	2
505-0099	9.90	10.00	103	61	49	2
505-0100	10.00	10.00	103	61	49	2

Contd

(UNI DRILL 505) SOLID CARBIDE TWIST DRILL
DIN 6537 B TO 5 X D

Order No.	d1	d2	L1	L2	L3	Z
505-0101	10.10	12.00	118	71	56	2
505-0102	10.20	12.00	118	71	56	2
505-0103	10.30	12.00	118	71	56	2
505-0104	10.40	12.00	118	71	56	2
505-0105	10.50	12.00	118	71	56	2
505-0106	10.60	12.00	118	71	56	2
505-0107	10.70	12.00	118	71	56	2
505-0108	10.80	12.00	118	71	56	2
505-0109	10.90	12.00	118	71	56	2
505-0110	11.00	12.00	118	71	56	2
505-0111	11.10	12.00	118	71	56	2
505-0112	11.20	12.00	118	71	56	2
505-0113	11.30	12.00	118	71	56	2
505-0114	11.40	12.00	118	71	56	2
505-0115	11.50	12.00	118	71	56	2
505-0116	11.60	12.00	118	71	56	2
505-0117	11.70	12.00	118	71	56	2
505-0118	11.80	12.00	118	71	56	2
505-0119	11.90	12.00	118	71	56	2
505-0120	12.00	12.00	118	71	56	2
505-0125	12.50	14.00	124	77	60	2
505-0128	12.80	14.00	124	77	60	2
505-0130	13.00	14.00	124	77	60	2
505-0135	13.50	14.00	124	77	60	2
505-0138	13.80	14.00	124	77	60	2
505-0140	14.00	14.00	124	77	60	2
505-0145	14.50	16.00	133	83	63	2
505-0148	14.80	16.00	133	83	63	2
505-0150	15.00	16.00	133	83	63	2
505-0155	15.50	16.00	133	83	63	2
505-0158	15.80	16.00	133	83	63	2
505-0160	16.00	16.00	133	83	63	2
505-0180	18.00	18.00	143	93	71	2
505-0200	20.00	20.00	153	101	77	2
505-0220	22.00	22.00	160	105	79	2
505-0240	24.00	24.00	160	105	79	2

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UNI DRILL 506

SOLID CARBIDE TWIST DRILL

TiN/TiAlN COOLANT DIN 6537 TO 3 X D

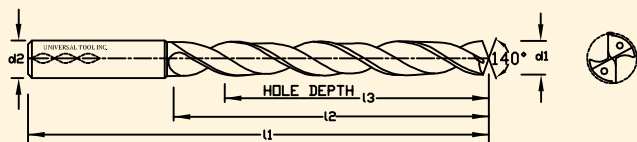
Short type, TiN-TiAlN- coated, cylindrical shank with clamping fixture DIN 6535 HEK, right hand cut.

GEOMETRY AND APPLICATION

Point grind : special point. CNC grinding/point angle : 140°/
Side rack angle : 30°/ Web thickness : reinforced / Profile :Special chip flute geometry.

High performance spiral twist drill for highest bore hole quality and economical out-put for drilling of cast iron, malleable cast iron , steel, steel casting, Cr-Ni-steels, heatresisting steel, non-ferrous metals . Specially suited for NC-drilling with great feeds per rev.

L3 = Hole depth Thro coolant



Contd

(UNI DRILL 506) SOLID CARBIDE TWIST DRILL THRO COOLANT DIN 6537 TO 3 X D

Order No.	d1	d2	L1	L2	L3	Z
506-0064	6.4	8.0	79	34	24	2
506-0065	6.5	8.0	79	34	24	2
506-0066	6.6	8.0	79	34	24	2
506-0067	6.7	8.0	79	34	24	2
506-0068	6.8	8.0	79	34	24	2
506-0069	6.9	8.0	79	34	24	2
506-0070	7.0	8.0	79	34	24	2
506-0071	7.1	8.0	79	41	29	2
506-0072	7.2	8.0	79	41	29	2
506-0073	7.3	8.0	79	41	29	2
506-0074	7.4	8.0	79	41	29	2
506-0075	7.5	8.0	79	41	29	2
506-0076	7.6	8.0	79	41	29	2
506-0077	7.7	8.0	79	41	29	2
506-0078	7.8	8.0	79	41	29	2
506-0079	7.9	8.0	79	41	29	2
506-0080	8.0	8.0	79	41	29	2
506-0081	8.1	10.0	89	47	35	2
506-0082	8.2	10.0	89	47	35	2
506-0083	8.3	10.0	89	47	35	2
506-0084	8.4	10.0	89	47	35	2
506-0085	8.5	10.0	89	47	35	2
506-0086	8.6	10.0	89	47	35	2
506-0087	8.7	10.0	89	47	35	2
506-0088	8.8	10.0	89	47	35	2
506-0089	8.9	10.0	89	47	35	2
506-0090	9.0	10.0	89	47	35	2
506-0091	9.1	10.0	89	47	35	2
506-0092	9.2	10.0	89	47	35	2
506-0093	9.3	10.0	89	47	35	2
506-0094	9.4	10.0	89	47	35	2
506-0095	9.5	10.0	89	47	35	2
506-0096	9.6	10.0	89	47	35	2
506-0097	9.7	10.0	89	47	35	2
506-0098	9.8	10.0	89	47	35	2
506-0099	9.9	10.0	89	47	35	2
506-0100	10.0	10.0	89	47	35	2
506-0102	10.2	12.0	102	55	40	2
506-0105	10.5	12.0	102	55	40	2
506-0108	10.8	12.0	102	55	40	2
506-0109	10.9	12.0	102	55	40	2
506-0110	11.0	12.0	102	55	40	2
506-0112	11.2	12.0	102	55	40	2
506-0115	11.5	12.0	102	55	40	2

Order No.	d1	d2	L1	L2	L3	Z
506-0040	4.0	6.0	66	24	17	2
506-0041	4.1	6.0	66	24	17	2
506-0042	4.2	6.0	66	24	17	2
506-0043	4.3	6.0	66	24	17	2
506-0044	4.4	6.0	66	24	17	2
506-0045	4.5	6.0	66	24	17	2
506-0046	4.6	6.0	66	24	17	2
506-0047	4.7	6.0	66	24	17	2
506-0048	4.8	6.0	66	28	20	2
506-0049	4.9	6.0	66	28	20	2
506-0050	5.0	6.0	66	28	20	2
506-0051	5.1	6.0	66	28	20	2
506-0052	5.2	6.0	66	28	20	2
506-0053	5.3	6.0	66	28	20	2
506-0054	5.4	6.0	66	28	20	2
506-0055	5.5	6.0	66	28	20	2
506-0056	5.6	6.0	66	28	20	2
506-0057	5.7	6.0	66	28	20	2
506-0058	5.8	6.0	66	28	20	2
506-0059	5.9	6.0	66	28	20	2
506-0060	6.0	6.0	66	28	20	2
506-0061	6.1	8.0	79	34	24	2
506-0062	6.2	8.0	79	34	24	2
506-0063	6.3	8.0	79	34	24	2

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(UNI DRILL 506) SOLID CARBIDE TWIST DRILL
THRO COOLANT DIN 6537 TO 3 X D

Order No.	d1	d2	L1	L2	L3	Z
506-0118	11.8	12.0	102	55	40	2
506-0120	12.0	12.0	102	55	40	2
506-0125	12.5	14.0	107	60	43	2
506-0127	12.7	14.0	107	60	43	2
506-0130	13.0	14.0	107	60	43	2
506-0135	13.5	14.0	107	60	43	2
506-0140	14.0	14.0	107	60	43	2
506-0145	14.5	16.0	115	65	45	2
506-0150	15.0	16.0	115	65	45	2
506-0155	15.5	16.0	115	65	45	2
506-0160	16.0	18.0	115	65	45	2
506-0165	16.5	18.0	123	73	51	2
506-0170	17.5	18.0	123	73	51	2
506-0175	17.5	18.0	123	73	51	2
506-0180	18.0	18.0	123	73	51	2
506-0185	18.5	20.0	131	73	55	2
506-0190	19.0	20.0	131	79	55	2
506-0195	19.5	20.0	131	79	55	2
506-0200	20.0	20.0	131	79	55	2
506-0220	22.0	25.0	165	105	75	2
506-0240	24.0	25.0	165	105	75	2
506-0250	25.0	25.0	165	105	75	2

UNI DRILL 507

SOLID CARBIDE TWIST DRILL

THRO COOLANT, DIN 6537 TO 5 X D

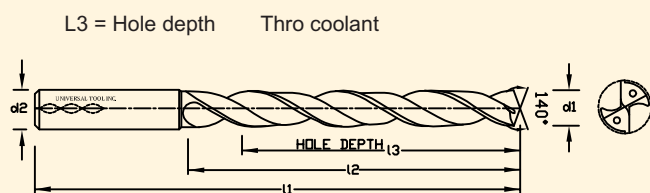
Long type, TiN-TiAlN- coated, cylindrical shank with clamping fixture DIN 6535 HEK, right hand cut.

GEOMETRY AND APPLICATION

Point grind : special point. CNC grinding/point angle : 140°/
Side rack angle : 30°/ Web thickness : reinforced / profile : special chip flute geometry.

High performance spiral twist drill for highest bore hole quality and economical output for drilling of cast iron, malleable cast iron, steel casting, Cr-Ni-steels, heat resisting steel, non-ferrous metals. Specially suited for NC-drilling with great feeds per rev.

Also offered on intermediate sizes on request.



Contd

(UNI DRILL 507) SOLID CARBIDE TWIST DRILL
(THRO COOLANT) DIN 6537 TO 5 X D

Order No.	d1	d2	L1	L2	L3	Z
507-0030	3.0	6.0	66	28	23	2
507-0032	3.2	6.0	66	28	23	2
507-0033	3.3	6.0	66	28	23	2
507-0035	3.5	6.0	66	28	23	2
507-0038	3.8	6.0	74	36	29	2
507-0040	4.0	6.0	74	36	29	2
507-0041	4.1	6.0	74	36	29	2
507-0042	4.2	6.0	74	36	29	2
507-0043	4.3	6.0	74	36	29	2
507-0044	4.4	6.0	74	36	29	2
507-0045	4.5	6.0	74	36	29	2
507-0046	4.6	6.0	74	36	29	2
507-0047	4.7	6.0	74	36	29	2
507-0048	4.8	6.0	82	44	35	2
507-0049	4.9	6.0	82	44	35	2
507-0050	5.0	6.0	82	44	35	2
507-0051	5.1	6.0	82	44	35	2
507-0052	5.2	6.0	82	44	35	2
507-0053	5.3	6.0	82	44	35	2
507-0054	5.4	6.0	82	44	35	2
507-0055	5.5	6.0	82	44	35	2
507-0056	5.6	6.0	82	44	35	2
507-0057	5.7	6.0	82	44	35	2
507-0058	5.8	6.0	82	44	35	2
507-0059	5.9	6.0	82	44	35	2
507-0060	6.0	6.0	82	44	35	2
507-0061	6.1	8.0	91	53	43	2
507-0062	6.2	8.0	91	53	43	2
507-0063	6.3	8.0	91	53	43	2
507-0064	6.4	8.0	91	53	43	2
507-0065	6.5	8.0	91	53	43	2
507-0066	6.6	8.0	91	53	43	2
507-0067	6.7	8.0	91	53	43	2
507-0068	6.8	8.0	91	53	43	2
507-0069	6.9	8.0	91	53	43	2
507-0070	7.0	8.0	91	53	43	2
507-0071	7.1	8.0	91	53	43	2
507-0072	7.2	8.0	91	53	43	2
507-0073	7.3	8.0	91	53	43	2
507-0074	7.4	8.0	91	53	43	2
507-0075	7.5	8.0	91	53	43	2
507-0076	7.6	8.0	91	53	43	2
507-0077	7.7	8.0	91	53	43	2
507-0078	7.8	8.0	91	53	43	2

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(UNI DRILL 507) SOLID CARBIDE TWIST DRILL
(THRO COOLANT) DIN 6537 TO 5 X D

Order No.	d1	d2	L1	L2	L3	Z
507-0079	7.9	8.0	91	53	43	2
507-0080	8.0	8.0	91	53	43	2
507-0081	8.1	10.0	103	61	49	2
507-0082	8.2	10.0	103	61	49	2
507-0083	8.3	10.0	103	61	49	2
507-0084	8.4	10.0	103	61	49	2
507-0085	8.5	10.0	103	61	49	2
507-0086	8.6	10.0	103	61	49	2
507-0087	8.7	10.0	103	61	49	2
507-0088	8.8	10.0	103	61	49	2
507-0089	8.9	10.0	103	61	49	2
507-0090	9.0	10.0	103	61	49	2
507-0091	9.1	10.0	103	61	49	2
507-0092	9.2	10.0	103	61	49	2
507-0093	9.3	10.0	103	61	49	2
507-0094	9.4	10.0	103	61	49	2
507-0095	9.5	10.0	103	61	49	2
507-0096	9.6	10.0	103	61	49	2
507-0097	9.7	10.0	103	61	49	2
507-0098	9.8	10.0	103	61	49	2
507-0099	9.9	10.0	103	61	49	2
507-0100	10.0	10.0	103	61	49	2
507-0101	10.1	12.0	118	71	56	2
507-0102	10.2	12.0	118	71	56	2
507-0103	10.3	12.0	118	71	56	2
507-0104	10.4	12.0	118	71	56	2
507-0105	10.5	12.0	118	71	56	2
507-0106	10.6	12.0	118	71	56	2
507-0107	10.7	12.0	118	71	56	2
507-0108	10.8	12.0	118	71	56	2
507-0109	10.9	12.0	118	71	56	2
507-0110	11.0	12.0	118	71	56	2
507-0112	11.2	12.0	118	71	56	2
507-0115	11.5	12.0	118	71	56	2
507-0118	11.8	12.0	118	71	56	2
507-0120	12.0	12.0	118	71	56	2
507-0121	12.1	14.0	124	77	60	2
507-0122	12.2	14.0	124	77	60	2
507-0123	12.3	14.0	124	77	60	2
507-0124	12.4	14.0	124	77	60	2
507-0125	12.5	14.0	124	77	60	2
507-0127	12.7	14.0	124	77	60	2
507-0130	13.0	14.0	124	77	60	2
507-0135	13.5	14.0	124	77	60	2

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(UNI DRILL 507) SOLID CARBIDE TWIST DRILL
(THRO COOLANT) DIN 6537 TO 5 X D

Order No.	d1	d2	L1	L2	L3	Z
507-0140	14.0	14.0	124	77	60	2
507-0145	14.5	16.0	133	83	63	2
507-0150	15.0	16.0	133	83	63	2
507-0155	15.5	16.0	133	83	63	2
507-0160	16.0	16.0	133	83	63	2
507-0165	16.5	18.0	143	93	71	2
507-0170	17.0	18.0	143	93	71	2
507-0175	17.5	18.0	143	93	71	2
507-0180	18.0	18.0	143	93	71	2
507-0185	18.5	20.0	153	101	77	2
507-0190	19.0	20.0	153	101	77	2
507-0195	19.5	20.0	153	101	77	2
507-0200	20.0	20.0	153	101	77	2
507-0220	22.0	25.0	213	155	125	2

UNI DRILL 508

SOLID CARBIDE TWIST DRILL

(THRO COOLANT) , DIN 6537 to 7 X D

Extra long type, TiN-TiAlN- coated, with internal coolant and steel shank, right hand cut, cylindrical shank with clamping.

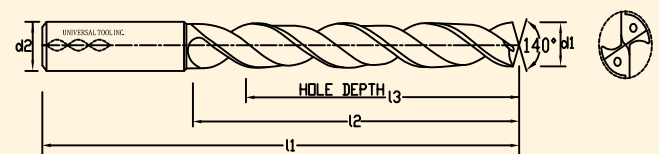
GOMETRY AND APPLICATION

Point grind : special point CNC grinding/point angle : 140°/

Side rack angle : 30°/ Web thickness : reinforced / Profile :Specialchip flute geometry.

High performance spiral twist drill for highest bore hole quality and economical output for drilling of cast iron, malleable cast iron , steel, steel casting, Cr-Ni-steels, heat resisting steel, non-ferrous metals . Specially suited for NC-drilling with great feeds per rev.

L3 = Hole depth Thro coolant



Order No.	d1	d2	L1	L2	L3	Z
508-0050	5.0	6.0	90	50	41	2
508-0055	5.5	6.0	97	57	48	2
508-0060	6.0	6.0	97	57	48	2

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Contd

(UNI DRILL 508) SOLID CARBIDE TWIST DRILL
(THRO COOLANT) , DIN 6537 to 7 X D

Order No.	d1	d2	L1	L2	L3	Z
508-0065	6.5	8.0	106	66	56	2
508-0068	6.8	8.0	106	66	56	2
508-0070	7.0	8.0	116	76	66	2
508-0075	7.5	8.0	116	76	66	2
508-0078	7.8	8.0	116	76	66	2
508-0080	8.0	8.0	116	76	66	2
508-0085	8.5	10.0	131	87	75	2
508-0090	9.0	10.0	131	87	75	2
508-0095	9.5	10.0	140	98	84	2
508-0100	10.0	10.0	140	98	84	2
508-0102	10.2	12.0	145	98	84	2
508-0105	10.5	12.0	145	98	84	2
508-0110	11.0	12.0	145	98	84	2
508-0115	11.5	12.0	145	98	84	2
508-0120	12.0	12.0	145	98	84	2
508-0125	12.5	14.0	161	114	98	2
508-0130	13.0	14.0	161	114	98	2
508-0135	13.5	14.0	161	114	98	2
508-0140	14.0	14.0	161	114	98	2
508-0145	14.5	16.0	181	131	112	2
508-0150	15.0	16.0	181	131	112	2
508-0155	15.5	16.0	181	131	112	2
508-0160	16.0	16.0	181	131	112	2
508-0165	16.5	18.0	197	147	126	2
508-0170	17.0	18.0	197	147	126	2
508-0175	17.5	18.0	197	147	126	2
508-0180	18.0	18.0	197	147	126	2
508-0185	18.5	20.0	216	164	140	2
508-0190	19.0	20.0	216	164	140	2
508-0195	19.5	20.0	216	164	140	2
508-0200	20.0	20.0	216	164	140	2
508-0220	22.0	25.0	263	205	182	2
508-0240	24.0	25.0	263	205	182	2
508-0250	25.0	25.0	263	205	182	2
508-0280	28.0	32.0	294	230	196	2
508-0300	30.0	32.0	310	246	210	2
508-0320	32.0	32.0	310	246	210	2
508-0340	34.0	32.0	310	246	210	2

UNI DRILL 536

SOLID CARBIDE TWIST DRILL

L x D = 12

GOMETRY AND APPLICATION

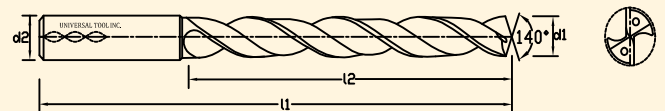
Point grind : special point. CNC grinding/point angle : 140°/

Side rack angle : 30°/ Web thickness : reinforced / profile : special chip flute geometry.

High performance spiral twist drill for highest bore hole quality and economical output for drilling of cast iron, malleable cast iron, steel casting, Cr-Ni-steels, heat resisting steel, non-ferrous metals. Specially suited for NC-drilling with great feeds per rev.

Also offered on intermediate sizes on request.

Thro coolant



Order No	d1 m7	L3	L2	L1	d2
536-0040	4.00	58	77	121	6
536-0042	4.20	58	77	121	6
536-0045	4.50	58	77	121	6
536-0050	5.00	68	82	121	6
536-0055	5.50	68	82	121	6
536-0060	6.00	68	82	121	6
536-0065	6.50	68	82	121	6
536-0068	6.80	90	106	146	8
536-0070	7.00	90	106	146	8
536-0075	7.50	90	106	146	8
536-0078	7.80	90	106	146	8
536-0080	8.00	90	106	146	8
536-0085	8.50	75	112	130	10
536-0088	8.80	75	112	130	10
536-0090	9.00	75	112	130	10
536-0092	9.20	75	112	130	10
536-0095	9.50	75	112	130	10
536-0010	10.00	75	112	130	10
536-0010	10.20	139	159	209	12
536-0010	10.50	139	159	209	12
536-0010	10.80	139	159	209	12
536-0011	11.00	139	159	209	12
536-0011	11.50	139	159	209	12
536-0011	11.80	139	159	209	12
536-0012	12.00	139	159	209	12
536-0012	12.50	162	183	233	14

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(UNI DRILL 536) SOLID CARBIDE Twist Drill

Order No	d1 m7	L3	L2	L1	d2
536-0012	12.80	162	183	233	14
536-0013	13.00	162	183	233	14
536-0013	13.50	162	183	233	14
536-0013	13.80	162	183	233	14
536-0014	14.00	162	183	233	14
536-0014	14.50	162	183	233	14
536-0014	14.80	184	209	260	16
536-0015	15.00	184	209	260	16
536-0015	15.50	184	209	260	16
536-0015	15.80	184	209	260	16
536-0016	16.00	184	209	260	16
536-0016	16.50	207	231	284	18
536-0017	17.00	207	231	284	18
536-0017	17.50	207	231	284	18
536-0017	17.80	207	231	284	18
536-0018	18.00	207	231	284	18
536-0018	18.50	230	255	308	20
536-0018	18.90	230	255	308	20
536-0019	19.00	230	255	308	20
536-0019	19.50	230	255	308	20
536-0019	19.80	230	255	308	20
536-0020	20.00	230	255	308	20
536-0022	22.00	230	255	308	22
536-0025	25.00	230	255	308	25
536-0026	26.00	230	255	308	26
536-0028	28.00	230	255	308	28
536-0030	30.00	230	255	308	30

UNI DRILL 537

SOLID CARBIDE DRILL

LxD-20

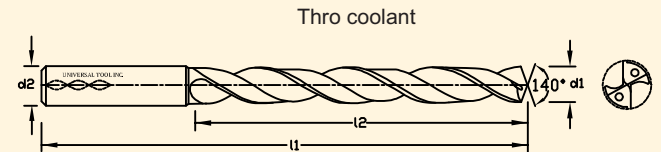
GOMETRY AND APPLICATION

Point grind: Special point. CNC grinding/point angle: 140°/

Side rack angle: 30°/web thickness: reinforced/profile: special chip flute geometry.

High performance spiral twist drill for highest bore hole quality and economical output for drilling of cast iron, malleable cast iron, steel casting, Cr-Ni-steels, heat resisting steel, non-ferrous metals. Specially suited for NC drilling with great feeds pre rev.

Also offered on intermediate sizes on request.



Order No	d1 m7	d2	L1	L2
537-0020	2	4	92	50
537-0022	2.2	4	92	50
537-0023	2.3	4	92	50
537-0024	2.4	4	112	70
537-0025	2.5	4	112	70
537-0027	2.7	4	112	70
537-0028	2.8	4	112	70
537-0030	3	6	120	80
537-0032	3.2	6	120	80
537-0033	3.3	6	120	80
537-0035	3.5	6	120	80
537-0038	3.8	6	130	90
537-0040	4	6	130	90
537-0042	4.2	6	160	110
537-0045	4.5	6	160	110
537-0048	4.8	6	160	120
537-0050	5	6	160	120
537-0055	5.5	6	185	140
537-0058	5.8	6	185	140
537-0060	6	6	185	140
537-0065	6.5	8	210	155
537-0068	6.8	8	210	160
537-0070	7	8	210	160
537-0078	7.8	8	230	180
537-0080	8	8	230	180
537-0085	8.5	10	260	195
537-0088	8.8	10	290	230
537-0098	9.8	10	290	230
537-0010	10	10	290	230
537-0010	10.2	12	315	270
537-0010	10.8	12	315	270
537-0011	11.8	12	315	270
537-0012	12	12	315	270

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World Class Tools From
World Class Universal Tool

UNI DRILL 538

SOLID CARBIDE DRILL

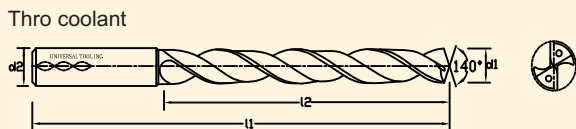
LxD-25

GOMETRY AND APPLICATION

Point grind: Special point. CNC grinding/point angle: 140°/
Side rack angle: 30°/web thickness: reinforced/profile: special chip flute geometry.

High performance spiral twist drill for highest bore hole quality and economical output for drilling of cast iron, malleable cast iron, steel casting, Cr-Ni-steels, heat resisting steel, non-ferrous metals. Specially suited for NC drilling with great feeds pre rev.

Also offered on intermediate sizes on request.



Order No	d1 m7	d2	L1	L2
538- 0030	3	6	135	98
538- 0035	3.5	6	150	110
538- 0040	4	6	160	120
538- 0045	4.5	6	180	135
538- 0050	5	6	180	135
538- 0055	5.5	6	205	168
538- 0060	6	6	205	168
538- 0065	6.5	8	240	200
538- 0070	7	8	240	200
538- 0080	8	8	260	220
538- 0085	8.5	10	285	240
538- 0010	10	10	310	270

UNI DRILL 539

SOLID CARBIDE DRILL

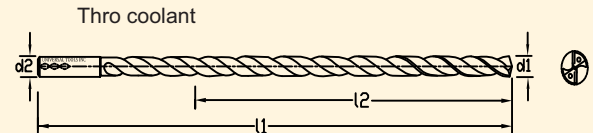
LxD-30

GOMETRY AND APPLICATION

Point grind: Spiral poi. CNC grinding/point angle: 140°/
Side rack angle: 30°/web thickness: reinforced/profile: special chip flute geometry.

High performance spiral twist drill for highest bore hole quality & economical output for drilling of cast iron, malleable cast iron, steel casting, Cr-Ni-steels, heat resisting steel, non-ferrous metal. Specially suited for NC drilling with great feeds pre rev.

Also offered on intermediate sizes on request.



Order No	d1 m7	d2	L1	L2
539-0020	2	4	115	70
539-0022	2.2	4	115	70
539-0023	2.3	4	115	70
539-0024	2.4	4	138	90
539-0025	2.5	4	138	90
539-0027	2.7	4	138	90
539-0028	2.8	4	138	90
539-0030	3	6	150	105
539-0032	3.2	6	150	105
539-0033	3.3	6	185	135
539-0035	3.5	6	185	135
539-0038	3.8	6	185	135
539-0040	4	6	185	135
539-0042	4.2	6	185	135
539-0045	4.5	6	215	165
539-0048	4.8	6	215	165
539-0050	5	6	215	165
539-0055	5.5	6	230	180
539-0058	5.8	6	230	180
539-0060	6	6	230	180
539-0065	6.5	8	280	215
539-0068	6.8	8	280	230
539-0070	7	8	280	230
539-0078	7.8	8	315	265
539-0080	8	8	315	265
539-0085	8.5	10	350	295
539-0088	8.8	10	380	330
539-0098	9.8	10	380	330
539-0010	10	10	380	330
539-0010	10.2	12	430	380
539-0010	10.8	12	430	380
539-0011	11.8	12	430	380
539-0012	12	12	430	380

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World Class Tools From
World Class Universal Tool

UNI DRILL 530

CARBIDE TIPPED DRILL

L X D=7 Thro Coolant

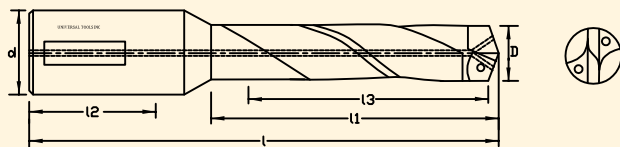
Similar to (BRK Type)

GOMETRY AND APPLICATION

Point angle 140° or 150° for high productivity and for deep holes offered in brazed with LX D=7.

Also offered on intermediate sizes on request.

L3 = Hole depth Thro coolant



UNI DRILL 531

CARBIDE TIPPED DRILL

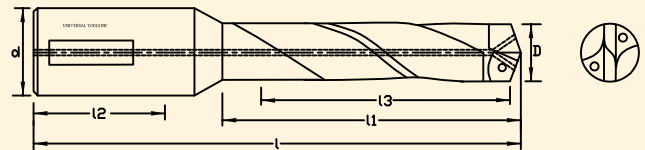
Similar to (BRM Type) L X D=5 Thro Coolant

GOMETRY AND APPLICATION

Point angle 140° or 150° for high productivity and for deep holes offered in brazed with LX D

Also offered on intermediate sizes on request.

L3 = Hole depth Thro coolant



Order no	Drill	Range	d	L1	L2	L3	L4
530-0140	14.00	14.00-14.50	16	174	126	48	112
530-0150	15.00	14.51-15.50	20	185	135	50	120
530-0160	16.00	15.51-16.50	20	194	144	50	128
530-0170	17.00	16.51-17.50	20	203	153	50	136
530-0180	18.00	17.51-18.50	20	212	162	50	144
530-0190	19.00	18.51-19.50	25	227	171	56	152
530-0200	20.00	19.51-20.50	25	236	180	56	160
530-0210	21.00	20.51-21.50	25	245	189	56	168
530-0220	22.00	22.51-22.50	25	254	198	56	176
530-0230	23.00	22.51-23.50	25	263	207	56	184
530-0240	24.00	23.51-24.50	32	276	216	60	192
530-0250	25.00	24.51-25.50	32	285	225	60	200
530-0260	26.00	25.51-26.50	32	294	234	60	208
530-0270	27.00	26.51-27.50	32	303	243	60	216
530-0280	28.00	27.51-28.50	32	312	252	60	224
530-0290	29.00	28.51-29.50	32	321	261	60	232
530-0300	30.00	29.51-33.50	32	330	270	60	240
530-0350	35.00	33.51-38.50	32	330	270	60	248
530-0350	40.00	38.50-43.50	32	330	270	60	240
530-0350	45.00	43.51-48.50	32	330	270	60	240
530-0350	50.00	48.51-53.50	32	330	270	60	240
530-0350	55.00	53.51-58.50	32	330	270	60	240
530-0350	60.00	58.51-60.00	32	330	270	60	240

Order no	Drill	Range	d	L1	L2	L3	L4	L5	PRICES
531-0140	14.00	14.00-14.50	16	140	92	48	78	35	
531-0145	14.50	14.00-14.50	16	140	92	48	78	35	
531-0150	15.00	14.51-15.50	20	150	100	50	85	35	
531-0155	15.50	14.51-15.50	20	150	100	50	85	35	
531-0160	16.00	15.51-16.50	20	155	105	50	89	35	
531-0165	16.50	15.51-16.50	20	155	105	50	89	35	
531-0170	17.00	16.51-17.50	20	165	115	50	98	35	
531-0175	17.50	16.51-17.50	20	165	115	50	98	35	
531-0180	18.00	17.51-18.50	20	170	120	50	102	35	
531-0185	18.50	17.51-18.50	20	170	120	50	102	35	
531-0190	19.00	18.51-19.50	25	180	224	56	105	43	
531-0195	19.50	18.51-19.50	25	180	224	56	105	43	
531-0200	20.00	19.51-20.50	25	190	134	56	114	43	
531-0205	20.50	19.51-20.50	25	190	134	56	114	43	
531-0210	21.00	20.51-21.50	25	195	139	56	118	43	
531-0215	21.50	20.51-21.50	25	195	139	56	118	43	
531-0220	22.00	22.51-22.50	25	200	144	56	122	43	
531-0225	22.50	22.51-22.50	25	200	144	56	122	43	
531-0230	23.00	22.51-23.50	25	205	149	56	126	43	
531-0235	23.50	22.51-23.50	25	205	149	56	126	43	
531-0240	24.00	23.51-24.50	32	220	160	60	136	48	
531-0245	24.50	23.51-24.50	32	220	160	60	136	48	
531-0250	25.00	24.51-25.50	32	225	165	60	140	48	
531-0255	25.50	24.51-25.50	32	225	165	60	140	48	
531-0260	26.00	25.51-26.50	32	230	170	60	144	48	
531-0265	26.50	25.51-26.50	32	230	170	60	144	48	
531-0270	27.00	26.51-27.50	32	235	175	60	148	48	
531-0275	27.50	26.51-27.50	32	235	175	60	148	48	
531-0280	28.00	27.51-28.50	32	245	185	60	157	48	

Contd

UNI DRILL 501

SOLID CARBIDE TWIST DRILL

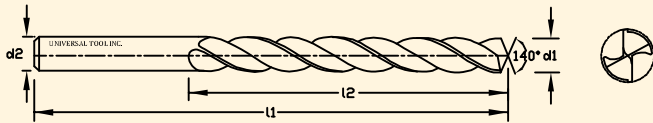
Type N. cylinder shank, right hand cut, DIN 6539 (1897)

GOMETRY AND APPLICATION

Point grind: 4 facet ground/point angle: 120°/
Side rack angle: 30°/ Profile: Standard

Universal application with great efficiency. Suitable for almost all materials.

Especially for drilling of heat resistant steel . Cr-Ni-Steel, Alu -alloy with high percentage of silicon and other difficult to machine



Contd

(UNI DRILL 501) SOLID CARBIDE TWIST DRILL

Order No.	d1	d2	L1	L2	Z	Prices
501-0040	4.00	4.00	55	22	2	
501-0041	4.10	4.10	55	22	2	
501-0042	4.20	4.20	55	22	2	
501-0043	4.30	4.30	58	24	2	
501-0044	4.40	4.40	58	24	2	
501-0045	4.50	4.50	58	24	2	
501-0046	4.60	4.60	58	24	2	
501-0047	4.70	4.70	58	24	2	
501-0048	4.80	4.80	62	26	2	
501-0049	4.90	4.90	62	26	2	
501-0050	5.00	5.00	62	26	2	
501-0051	5.10	5.10	62	26	2	
501-0052	5.20	5.20	62	26	2	
501-0053	5.30	5.30	62	28	2	
501-0054	5.40	5.40	66	28	2	
501-0055	5.50	5.50	66	28	2	
501-0056	5.60	5.60	66	28	2	
501-0057	5.70	5.70	66	28	2	
501-0058	5.80	5.80	66	28	2	
501-0059	5.90	5.90	66	28	2	
501-0060	6.00	6.00	66	28	2	
501-0061	6.10	6.10	70	31	2	
501-0062	6.20	6.20	70	31	2	
501-0063	6.30	6.30	70	31	2	
501-0064	6.40	6.40	70	31	2	
501-0065	6.50	6.50	70	31	2	
501-0068	6.80	6.80	74	34	2	
501-0070	7.00	7.00	74	34	2	
501-0075	7.50	7.50	74	34	2	
501-0078	7.80	7.80	79	37	2	
501-0080	8.00	8.00	79	37	2	
501-0085	8.50	8.50	79	37	2	
501-0090	9.00	9.00	84	40	2	
501-0095	9.50	9.50	84	40	2	
501-0100	10.00	10.00	89	43	2	
501-0102	10.20	10.20	89	43	2	
501-0105	10.50	10.50	89	43	2	
501-0110	11.00	11.00	95	47	2	
501-0115	11.50	11.50	95	47	2	
501-0120	12.00	12.00	102	51	2	
501-0125	12.50	12.50	102	51	2	
501-0130	13.00	13.00	102	51	2	
501-0140	14.00	14.00	107	54	2	
501-0150	15.00	15.00	111	56	2	

ABOVE 1/28 SIZE ON REQUEST

Available in Tin Tialn & x LC Coating • Uni AL Geometry for Aluminum

Order No.	d1	d2	L1	L2	Z	Prices
501-0010	1.00	1.00	26	6	2	
501-0011	1.10	1.10	28	7	2	
501-0012	1.20	1.20	30	8	2	
501-0013	1.30	1.30	30	8	2	
501-0014	1.40	1.40	32	9	2	
501-0015	1.50	1.50	32	9	2	
501-0016	1.60	1.60	34	10	2	
501-0017	1.70	1.70	34	10	2	
501-0018	1.80	1.80	36	11	2	
501-0019	1.90	1.90	36	11	2	
501-0020	2.00	2.00	38	12	2	
501-0021	2.10	2.10	38	12	2	
501-0022	2.20	2.20	40	13	2	
501-0023	2.30	2.30	40	13	2	
501-0024	2.40	2.40	43	14	2	
501-0025	2.50	2.50	43	14	2	
501-0026	2.60	2.60	43	14	2	
501-0027	2.70	2.70	46	16	2	
501-0028	2.80	2.80	46	16	2	
501-0029	2.90	2.90	46	16	2	
501-0030	3.00	3.00	46	16	2	
501-0031	3.10	3.10	49	18	2	
501-0032	3.20	3.20	49	18	2	
501-0033	3.30	3.30	49	18	2	
501-0034	3.40	3.40	52	20	2	
501-0035	3.50	3.50	52	20	2	
501-0036	3.60	3.60	52	20	2	
501-0037	3.70	3.70	52	20	2	
501-0038	3.80	3.80	55	22	2	
501-0039	3.90	3.90	55	22	2	

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UNIVERSAL ENGG. & MFG. INDUSTRY

F-2 BLOCK SHD 8, MIDC, PIMPRI, PUNE 411 018 (INDIA)

TEL : (+91) - 020-46765151 / 52, Cell : 9970396322. Fax (+91) - 020 - 46780213

E-mail : info@universaltoolindia.net, universaltoolinc@yahoo.com Website : www.universaltool.co.in

UNI DRILL 502

SOLID CARBIDE TWIST DRILL

Type N. Cylinder Shank, **right hand cut**, acc. DIN 338
(Small dia series **Long type**)

GEOMETRY AND APPLICATION

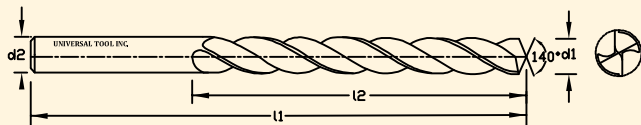
Point grind: 4 facet ground/point angle: 120°/140°

Side rack angle: 30°/ Profile: Standard

Particularly Suitable for drilling of steel and aluminium up to approximately 600N/mm³

Especially designed for the re-working of step drills

Also offered on intermediate sizes on request.



Contd

(UNI DRILL 502) SOLID CARBIDE TWIST DRILL (Long Series)

Order No.	d1	d2	L1	L2	Z	Prices
502-0038	3.80	3.80	75	43	2	
502-0039	3.90	3.90	75	43	2	
502-0040	4.00	4.00	75	43	2	
502-0041	4.10	4.10	75	43	2	
502-0042	4.20	4.20	75	43	2	
502-0043	4.30	4.30	80	47	2	
502-0044	4.40	4.40	80	47	2	
502-0045	4.50	4.50	80	47	2	
502-0046	4.60	4.60	80	47	2	
502-0047	4.70	4.70	80	47	2	
502-0048	4.80	4.80	86	52	2	
502-0049	4.90	4.90	86	52	2	
502-0050	5.00	5.00	86	52	2	
502-0051	5.10	5.10	86	52	2	
502-0052	5.20	5.20	86	52	2	
502-0053	5.30	5.30	86	52	2	
502-0054	5.40	5.40	93	57	2	
502-0055	5.50	5.50	93	57	2	
502-0056	5.60	5.60	93	57	2	
502-0057	5.70	5.70	93	57	2	
502-0058	5.80	5.80	93	57	2	
502-0059	5.90	5.90	93	57	2	
502-0060	6.00	6.00	93	57	2	
502-0061	6.10	6.10	101	63	2	
502-0062	6.20	6.20	101	63	2	
502-0063	6.30	6.30	101	63	2	
502-0064	6.40	6.40	101	63	2	
502-0065	6.50	6.50	101	63	2	
502-0068	6.80	6.80	109	69	2	
502-0070	7.00	7.00	109	69	2	
502-0075	7.50	7.50	109	69	2	
502-0080	8.00	8.00	117	75	2	
502-0085	8.50	8.50	117	75	2	
502-0090	9.00	9.00	125	81	2	
502-0095	9.50	9.50	125	81	2	
502-0100	10.00	10.00	133	87	2	
502-0102	10.20	10.20	133	87	2	
502-0105	10.50	10.50	133	87	2	

ALSO OFFERD ABOVE Ø 16 UPTO Ø 40

Order No.	d1	d2	L1	L2	Z	Prices
502-0010	1.00	1.00	34	12	2	
502-0011	1.10	1.10	36	14	2	
502-0012	1.20	1.20	38	16	2	
502-0013	1.30	1.30	38	16	2	
502-0014	1.40	1.40	40	18	2	
502-0015	1.50	1.50	40	18	2	
502-0016	1.60	1.60	43	20	2	
502-0017	1.70	1.70	43	20	2	
502-0018	1.80	1.80	46	22	2	
502-0019	1.90	1.90	46	22	2	
502-0020	2.00	2.00	49	24	2	
502-0021	2.10	2.10	49	24	2	
502-0022	2.20	2.20	53	27	2	
502-0023	2.30	2.30	53	27	2	
502-0024	2.40	2.40	57	30	2	
502-0025	2.50	2.50	57	30	2	
502-0026	2.60	2.60	57	30	2	
502-0027	2.70	2.70	61	33	2	
502-0028	2.80	2.80	61	33	2	
502-0029	2.90	2.90	61	33	2	
502-0030	3.00	3.00	61	33	2	
502-0031	3.10	3.10	65	36	2	
502-0032	3.20	3.20	65	36	2	
502-0033	3.30	3.30	65	36	2	
502-0034	3.40	3.40	70	39	2	
502-0035	3.50	3.50	70	39	2	
502-0036	3.60	3.60	70	39	2	
502-0037	3.70	3.70	70	39	2	

Contd

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UNI DRILL 511

SOLID CARBIDE TWIST DRILL

(coredrill) long

Type N. cylinder shank, right hand cut, 3 cutting edges, solid point, DIN 338

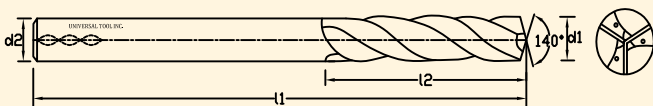
GOMETRY AND APPLICATION

Point Grind: 4 facet ground/point angle: 140° /

Side rack angle: 30° / profile: Standard

To be used by all modern machines having rigid spindles and very good connectivity for long straight bore holes and for most

Thro coolant



Order No.	d1	d2	L1	L2	Z	Prices
511- 00.30	3.0	3.0	61	33	3	
511- 0035	3.5	3.5	70	39	3	
511- 0040	4.0	4.0	75	43	3	
511- 0045	4.5	4.5	80	47	3	
511- 0050	5.0	5.0	86	52	3	
511- 0055	5.5	5.5	93	57	3	
511- 0060	6.0	6.0	93	57	3	
511- 0065	6.5	6.5	101	63	3	
511- 0070	7.0	7.0	109	69	3	
511- 0075	7.5	7.5	109	69	3	
511- 0080	8.0	8.0	117	75	3	
511- 0085	8.5	8.5	117	75	3	
511- 0090	9.0	9.0	125	81	3	
511- 0095	9.5	9.5	125	81	3	
511- 0100	10.0	10.0	133	87	3	
511- 0102	10.2	10.2	133	87	3	
511- 0105	10.5	10.5	133	87	3	
511- 0108	10.8	10.8	142	94	3	
511- 0110	11.0	11.0	142	94	3	
511- 0115	11.5	11.5	142	94	3	
511- 0120	12.0	12.0	151	101	3	
511-0130	13.0	13.0	151	101	3	
511- 0140	14.0	14.0	160	108	3	
511- 0150	15.0	15.0	169	114	3	
511- 0160	16.0	16.0	178	120	3	
511- 0180	18.0	18.0	178	120	3	
511- 0200	20.0	20.0	178	120	3	
511- 0220	22.0	22.0	178	120	3	
511- 0250	25.0	25.0	178	120	3	
511- 0300	30.00	30.00	178	120	3	
511- 0320	32.00	32.00	178	120	3	

Contd

(UNI DRILL 511) SOLID CARBIDE TWIST DRILL

Order No.	d1	d2	L1	L2	Z	Prices
511- 0340	34.00	34.00	178	120	3	
511- 0360	36.00	36.00	178	120	3	
511- 0380	38.00	38.00	178	120	3	
511- 0400	40.00	40.00	178	120	3	
511- 0450	45.00	45.00	178	120	3	
511- 0500	50.00	50.00	178	120	3	

UNI DRILL 512

SOLID CARBIDE 3S' SPIRAL POINT

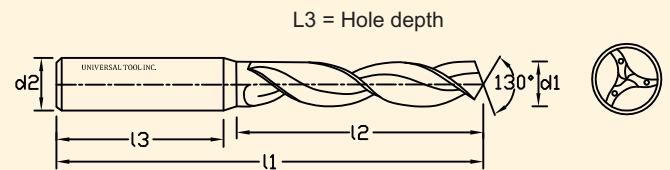
(Similar to Kennametal 'TF'geometry.) thro coolant

GOMETRY AND APPLICATION

Shank forms to DIN 6535 form HE whistle flat specially good for ductile material like aluminium. Also on request without thro coolant good self centering properties, no need to use Center Drill.

Also offered on intermediate sizes on request

Thro coolant



Order No.	d1	d2	L1	L3	L2	Prices
512-0030	3.00	6	66	28	36	
512-0035	3.50	6	66	28	36	
512-0045	4.50	6	74	36	36	
512-0050	5.00	6	82	44	36	
512-0055A	5.50	6	82	44	36	
512-0060	6.00	6	82	44	36	
512-0065	6.50	8	91	53	36	
512-0070	7.00	8	91	53	36	
512-0075	7.50	8	91	53	36	
512-0080	8.00	8	91	53	36	
512-0085	8.50	10	103	61	40	
512-0090	9.00	10	103	61	40	
512-0095	9.50	10	103	61	40	
512-0100	10.00	10	103	61	40	
512-0105	10.50	12	118	71	45	
512-0110	11.00	12	118	71	45	

Contd

Contd

Contd

(UNI DRILL 512) SOLID CARBIDE 3S' SPIRAL POINT

Order No.	d1 m7	d2 h6	L1 mm	L2 mm	L4	Prices
512-0115	11.50	12	118	71	45	
512-0120	12.00	12	118	71	45	
512-0125	12.50	14	124	77	45	
512-0130	13.00	14	124	77	45	
512-0135	13.50	14	124	77	45	
512-0140	14.00	14	124	77	45	
512-0145	14.50	16	133	83	48	
512-0150	15.00	16	133	83	48	
512-0155	15.50	16	133	83	48	
512-0160	16.00	16	133	83	48	
512-0165	16.50	18	143	93	48	
512-0170	17.00	18	143	93	48	
512-0175	17.50	18	143	93	48	
512-0177	17.70	18	143	93	48	
512-0180	18.00	18	143	93	48	
512-0185	18.50	20	153	10	50	
512-0187	18.75	20	153	10	50	
512-0189	18.90	20	153	10	50	
512-0190	19.00	20	153	10	50	
512-0195	19.50	20	153	10	50	
512-0200	20.00	20	153	10	50	
512-0205	20.50	20	153	11	50	
512-0210	21.00	20	153	11	50	
512-0215	21.50	20	153	11	50	
512-0220	22.00	20	153	11	50	
512-0225	22.50	20	153	11	50	
512-0230	23.00	20	153	11	50	
512-0240	24.00	20	153	11	50	
512-0250	25.00	20	153	11	50	
512-0260	26.00	20	153	11	50	
512-0280	28.00	20	153	11	50	
512-0300	30.00	20	153	11	50	
512-0320	32.00	20	153	11	50	
512-0340	34.00	20	153	11	50	
512-0360	36.00	20	153	11	50	
512-0380	38.00	20	153	11	50	
512-0400	40.00	20	153	11	50	
512-0450	45.00	20	153	11	50	
512-0500	50.00	20	153	112	50	

UNI DRILL 510

SOLID CARBIDE 3 FLUTE BORE IN DRILL :

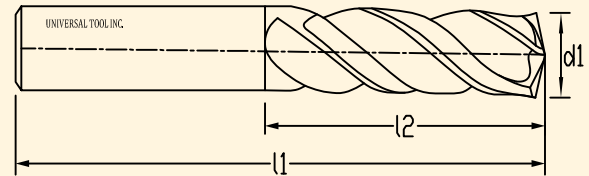
(3 FL right hand cut)

GOMETRY AND APPLICATION

Over all length acc. to DIN 6539, modified flute length with modified DIN 6539

For high penetration rates in soft long chipping materials such as wrought aluminium and brass & other ductile material.

Intermediate sizes on request



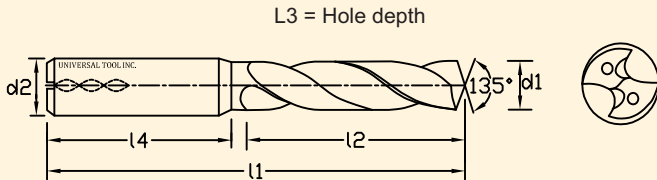
Order No.	d1mm	L1	L2	Prices
510-0020	2.0	46	23	
510-0025	2.5	49	23	
510-0030	3.00	46	23	
510-0035	3.50	52	26	
510-0042	4.20	55	30	
510-0045	4.50	58	31	
510-0048	4.80	62	34	
510-0050	5.00	62	36	
510-0052	5.20	62	36	
510-0055	5.50	66	39	
510-0060	6.00	66	40	
510-0065	6.50	70	43	
510-0070	7.00	74	46	
510-0080	8.00	79	49	
510-0090	9.00	84	55	
510-0100	10.00	89	56	
510-0110	11.00	95	61	
510-0120	12.00	102	66	
510-0130	13.00	102	66	
510-0140	14.00	107	66	
510-0150	15.00	111	72	
510-0160	16.00	115	75	
510-0170	17.00	118	75	
510-0180	18.00	123	77	
510-0190	19.00	123	77	
510-0200	20.00	131	80	
510-0220	22.00	150	95	
510-0240	24.00	150	95	
510-0260	26.00	150	95	
510-0280	28.00	150	95	
510-0300	30.00	150	95	

UNI DRILL 509

SOLID CARBIDE 'S' SPIRAL POINT

Long type, TiN-TiAlN- coated, cylindrical shank with clamping fixture DIN 6535 HEK, right hand cut (similar to Kenametal "SE" geometry) thro coolant. Shank forms to DIN 6535 Type A

Thro coolant



Order No.	d1	d2	L1	L2	L3	L4
509-0040	4.00	6	74	36	29	36
509-0041	4.10	6	74	36	29	36
509-0042	4.20	6	74	36	29	36
509-0043	4.30	6	74	36	29	36
509-0044	4.40	6	74	36	29	36
509-0045	4.50	6	74	36	29	36
509-0046	4.60	6	74	36	29	36
509-0047	4.70	6	74	36	29	36
509-0048	4.80	6	82	44	35	36
509-0049	4.90	6	82	44	35	36
509-0050	5.00	6	82	44	35	36
509-0051	5.10	6	82	44	35	36
509-0052	5.20	6	82	44	35	36
509-0053	5.30	6	82	44	35	36
509-0054	5.40	6	82	44	35	36
509-0055	5.50	6	82	44	35	36
509-0056	5.60	6	82	44	35	36
509-0057	5.70	6	82	44	35	36
509-0058	5.80	6	82	44	35	36
509-0059	5.90	6	82	44	35	36
509-0060	6.00	6	82	44	35	36
509-0061	6.10	8	91	53	43	36
509-0062	6.20	8	91	53	43	36
509-0063	6.30	8	91	53	43	36
509-0064	6.40	8	91	53	43	36
509-0065	6.50	8	91	53	43	36
509-0066	6.60	8	91	53	43	36
509-0067	6.70	8	91	53	43	36
509-0068	6.80	8	91	53	43	36

Contd

(UNI DRILL 509) SOLID CARBIDE 'S' SPIRAL POINT

Order No.	d1	d2	L1	L2	L3	L4
509-0040	4.00	6	74	36	29	36
509-0045	4.50	6	74	36	29	36
509-0050	5.00	6	82	44	35	36
509-0055	5.50	6	82	44	35	36
509-0060	6.00	6	82	44	35	36
509-0065	6.50	8	91	53	43	36
509-0070	7.00	8	91	53	43	36
509-0075	7.50	8	91	53	43	36
509-0080	8.00	8	91	53	49	40
509-0085	8.50	10	103	61	49	40
509-0090	9.00	10	103	61	49	40
509-0095	9.50	10	103	61	49	40
509-0100	10.00	10	103	61	49	40
509-0105	10.50	12	118	71	56	45
509-0110	11.00	12	118	71	56	45
509-0115	11.50	12	118	71	56	45
509-0120	12.00	12	118	71	56	45
509-0125	12.50	14	124	77	60	45
509-0130	13.00	14	124	77	60	45
509-0135	13.50	14	124	77	60	45
509-0140	14.00	14	124	77	60	45
509-0145	14.50	16	133	83	63	48
509-0150	15.00	16	133	83	63	48
509-0155	15.50	16	133	83	63	48
509-0160	16.00	16	133	83	63	48
509-0165	16.50	18	143	93	71	48
509-0170	17.00	18	143	93	71	48
509-0175	17.50	18	143	93	71	48
509-0180	18.00	18	143	93	71	48
509-0185	18.50	20	153	101	77	50
509-0190	19.00	20	153	101	77	50
509-0195	19.50	20	153	101	77	50
509-0200	20.00	20	153	101	77	50
509-0300	30.00	20	153	101	77	50
509-0380	38.00	20	153	101	77	50
509-0400	40.00	20	153	101	77	50
509-0450	45.00	20	153	101	77	50

Contd

UNI DRILL 523

SOLID CARBIDE STEP DRILL

For production of tapping drill holes with countersinking.

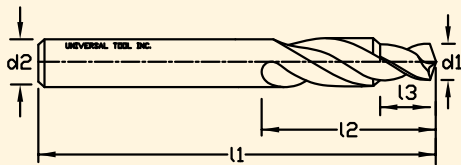
GOMETRY AND APPLICATION

For production of tapping with countersinking. Drills for tap holes. Also available for other kind of threads such as UNC-UNF, metric fine pipe thread etc.

For tapping drill holes for thread cutting (T). For thread forming (F) with 90° degree inch chamfer angle, on request chamfer angle 120° degree inch etc.

**Material like cast-iron, Aluminium, Brass, bronze, steels, aluminium with silicon Content etc.

Thro coolant



Order No.	d1	d2	L1	L2	L3	Z	T/F	Prices
523-M3A	2.50	6.0	62	20	8.8	2	T	
523-M3B	2.75	6.0	62	20	8.8	2	F	
523-M4A	3.30	6.0	62	20	11.4	2	T	
523-M4B	3.65	6.0	62	20	11.4	2	F	
523-M5A	4.20	6.0	66	26	13.5	2	T	
523-M5B	4.65	6.0	66	28	13.5	2	F	
523-M6A	5.00	8.0	79	34	16.5	2	T	
523-M6B	5.55	8.0	79	34	16.5	2	F	
523-M8A	6.80	10.0	89	47	21.0	2	T	
523-M8B	7.40	10.0	89	47	21.0	2	F	
523-M10A	8.50	12.0	102	55	25.5	2	T	
523-M10B	9.35	12.0	102	55	25.5	2	F	
523-M12A	10.2	14.0	107	60	30.0	2	T	
523-M12B	11.2	14.0	107	60	30.0	2	F	
523-M14A	12.0	16.0	115	65	34.5	2	T	
523-M14B	13.2	16.0	115	65	34.5	2	F	
523-M16A	14.0	18.0	123	73	38.5	2	T	
523-M16B	15.1	18.0	123	73	38.5	2	F	
523-M18A	15.5	20.0	131	79	43.5	2	T	
523-M18B	16.0	20.0	131	79	43.5	2	F	
523-M20A	17.5	22.0	147	89	47.5	2	T	
523-M20B	18.9	22.0	147	89	47.5	2	F	
523-M22	19.5	24.0	149	90	51.5	2	T	
523-M24	21.0	26.0	152	97	56.5	2	T	
523-M27	24.0	30.0	160	103	62.5	2	T	
523-M30	26.0	33.0	170	110	70.0	2	T	

Contd

UNI DRILL 524

SOLID CARBIDE STEP DRILL

DIN 8378

Countersink angle 90°, type M, cylindrical shank, right hand cut.

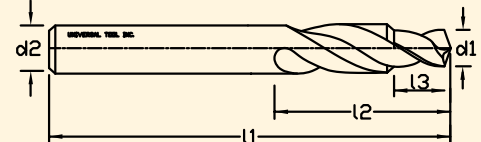
GOMETRY AND APPLICATION

Standard sub land drill for economical drilling of tap holes acc.

Din 336 part 1, and countersinks acc.DIN ISO 273. with chamfer angle 90° degree

Inch on request chamfer angle 120° degree inch chamfer angle.

Thro coolant



Order No.	d1	d2	L1	L2	L3	Z	Prices
524- M3	2.50	3.40	70	39	8.8	2	
524- M4	3.30	4.50	80	47	11.4	2	
524- M5	4.20	5.50	93	57	13.6	2	
524- M6A	5.00	6.60	101	63	16.5	2	
524- M6B	6.80	9.00	125	81	21.0	2	
524- M6C	8.50	11.0	142	94	25.5	2	
524- M12	10.2	13.50	160	108	30.0	2	
524- M14	12.0	15.50	178	120	34.5	2	
524- M16	14.0	15.50	191	130	38.5	2	
524- M18	15.5	17.50	205	140	43.5	2	
524- M20	17.5	20.00	210	150	47.5	2	
524- M22	19.5	24.00	215	160	51.5	2	
524- M24	21.0	26.00	220	165	56.5	2	
524- M27	24.0	30.00	230	175	62.5	2	
524- M30	26.5	33.00	240	185	70.0	2	

UNI DRILL 522

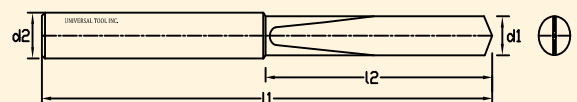
SOLID CARBIDE FLAT DRILL

Type M. CYLINDRICAL HAND CUT

GOMETRY AND APPLICATION

Point grind : 4facet ground/point angle: 120° / web thickness: Standard web taper: standard / profile: straight fluted

For drilling grey cast iron, chill casting, annealed casting, steel with high tensile and hardened steel.



Order No.	d1	d2	L1	L2	Z	Prices
522-0015	1.50	3.00	38	8		
522-0020	2.00	3.00	38	9		

Contd

(UNI DRILL 522) SOLID CARBIDE FLAT DRILL

Order No.	d1	d2	L1	L2	Z	Prices
522-0025	2.50	3.00	38	10		
522-0030	3.00	3.00	38	10		
522-0035	3.50	3.50	50	20		
522-0040	4.00	4.00	50	20		
522-0045	4.50	4.50	50	20		
522-0050	5.00	5.00	50	20		
522-0060	6.00	6.00	50	30		
522-0080	8.00	8.00	50	30		
522-0100	10.00	10.00	50	30		

UNI DRILL 527

SOLID CARBIDE NC SPOTTING

(HEAVY DUTY) (90° & 120° Point angle)

NOTE:

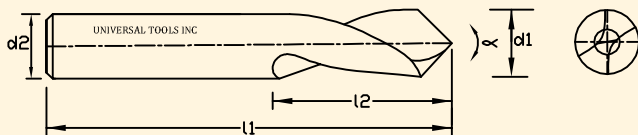
This Tools supplied in RH cutting Cutting 120 Degree point angle

(a)TiN coated offered on request.

(b)Any special length & flute length

(c)90° plain angle.

While ordering please mention order no. and point angle 90° degree or 120° degree.



Order No.	Dia	L2	L1	SHANK	Prices
527- 0030	3	8	46	3	
527- 0040	4	9	55	4	
527- 0050	5	10	62	5	
527- 0060	6	15	66	6	
527- 0080	8	17	79	8	
527- 0100	10	20	89	10	
527- 0120	12	25	102	12	
527- 0160	16	35	115	16	
527- 0200	20	40	131	20	
527- 0250	25	50	151	25	
527- 0280	28	50	151	25	
527- 0300	30	50	160	25	
527- 0320	32	55	170	25	
527- 0340	34	60	180	32	
527- 0360	36	60	180	32	

UNI DRILL 526

SOLID CARBIDE NC CENTER DRILL

(90° & 120° POINT ANGLE) (ALSO WITH THRO COOLANT HOLES)

NOTE:

ABOVE TOOL WILL BE SUPPLIED WITH SOLID POINT & 2 CUTTING EDGES ST. SHANK.

SHANK DIA WILL BE SAME AS DRILL DIA.

While ordering please mention ordering no. and point angle 90° degree or 120° degree.

Also offered on Request in.

(a) Helical right hand / left hand and st. flute.

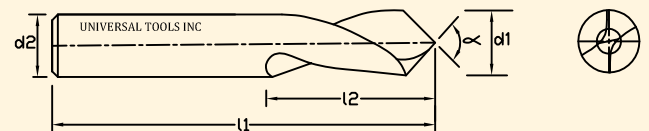
(b) Lug type construction with morse taper / st. shank in steel.

(c) TiN coated and TiAlN coated.

(d) Any special length & flute length

(e) Intermediate sizes

While ordering please mention order No. basic dia & point angle.



Order No.	Normal Dia	L1	L2	Prices
526-0060	6.0	50	18	
526-0063	6.35(1/4")	50	18	
526-0080	8.0	60	20	
526-0095	9.52(3/8")	60	22	
526-0100	10.0	60	22	
526-0120	12.0	60	25	
526-0127	12.7(1/2")	60	25	
526-0160	16.0	75	25	
526-0190	19.05(3/4")	75	28	
526-0200	20.0	75	28	
526-0250	25.0	75	28	
526-0280	28.0	100	30	
526-0300	30.0	100	34	
526-0320	32.0	100	35	

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UNI DRILL 528

SOLID CARBIDE CENTER DRILL FORM 'R'

Cylinder shank, right hand cut, DNN 333 R

GOMETRY AND APPLICATION

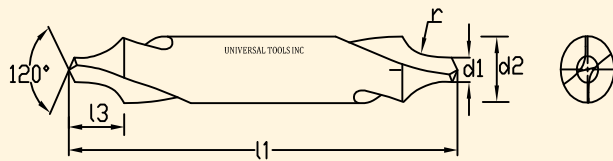
Point grind: point angle: 120°/

Standard design as specified similar DIN 333R.

Manufacture of centre holes 600 in steel of high resistance different types of casting and aluminium with a high percentage of silicium and other hard to machine materials.

Apply for 60 centre holes without protecting chamfer.

Also offered on intermediate size on request.



Order No.	d1	d2	L1	L3	Z	Prices
528- 0005	0.50	3.15	25.0	2.12	2	
528- 0008	0.80	3.15	25.0	2.65	2	
528- 0010	1.00	3.15	31.5	3.00	2	
528- 0012	1.25	3.15	31.5	3.35	2	
528- 0016	1.60	4.00	35.5	4.25	2	
528- 0020	2.00	5.00	40.0	5.30	2	
528- 0025	2.50	6.30	45.0	6.70	2	
528- 0031	3.15	8.00	50.0	8.50	2	
528- 0040	4.00	10.00	56.0	10.60	2	
528- 0050	5.00	12.50	63.0	13.20	2	
528- 0063	6.3	16.00	71.0	17.00	2	
528- 0080	8.00	20.00	80.0	20.00	2	
528- 0100	10.00	25.00	100	22.00	2	
528- 0125	12.5	31.50	125	25.00	2	

UNI DRILL 540

SOLID CARBIDE CENTER DRILL FORM 'A'

Cylinder shank, right hand cut, COUNTER SINK ANGLE 60°, DIN 333, DIN 333A

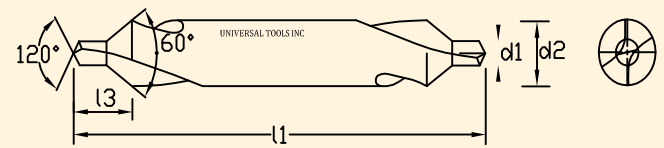
GOMETRY AND APPLICATION

Point grind: point angle : 120°/

Profile : Standard design as specified similar DIN 333 A.

Producing of centre holes 60° in steel of high resistance different types of casting and aluminium with a high percentage of silicium and other hard to machine materials.

Also offered on intermediate sizes on request



ORDER	Size	d1	d2	L1	
540-0005		0.5	3.15	25	
540-0008		0.8	3.15	25	
540-0010		1	3.15	31	
540-0012		1.25	3.15	31	
540-0016		1.6	4	35	
540-0020		2	5	40	
540-0025		2.5	6.3	45	
540-0031		3.15	8	50	
540-0040		4	10	56	
540-0050		5	12.5	63	
540-0063		6.3	16	71	
540-0080		8	20	80	
540-0010		10	25	100	
540-0012		12.5	31	125	
540-0030	1	.3/64	3.17	38	
540-0010	2	.1/16	4.76	44	
540-0030	3	.3/32	6.35	51	
540-0010	4	.1/8	7.94	57	
540-0030	5	.3/16	11.11.	63	
540-0010	6	.1/4	15.87	76	
540-0050	7	.5/16	19.05	89	

World Class Tools From
World Class Universal Tool

UNI DRILL 541

SOLID CARBIDE CENTER DRILL FORM 'B'

GOMETRY AND APPLICATION

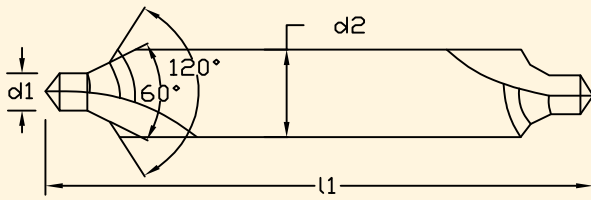
Point grind: point angle: 120°/

Standard design as specified similar DIN 333 R.

Manufacture of centre holes 60° in steel of high resistance different types of casting and aluminium with a high percentage of silicium and other hard to machine materials.

Apply for 60 centre holes without Protecting chamfer.

Also offered on intermediate sizes on request



UNI DRILL 532

SOLID CARBIDE CENTER DRILL

(WITH EXTRA LENGTH)

Extra long series Acc to DIN 332 A

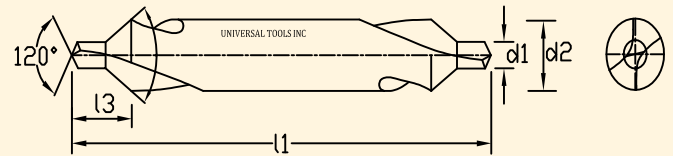
GOMETRY AND APPLICATION

Point grind: point angle: 120°/

Profile: Standard design as specified similar DIN 333A.

Manufacture of centre holes 600 in steel of high resistance different types of casting and aluminium with a high percentage of silicium and other hard to machine materials.

Also offered on intermediate size on request.



ORDER	Size	d1	d2	l1	PRICES
541-0010		1	4	35.5	
541-0012		1.25	5	40	
541-0016		1.6	6.3	45	
541-0002		2	8	50	
541-0025		2.5	10	56	
541-0031		3.15	11.2	60	
541-0040		4	14	67	
541-0050		5	18	75	
541-0063		6.3	20	80	
541-0080		8	25	100	
541-0010		10	31.5	125	
541-0100	1	3/64	3.17	31.3	
541-0120	12	1/16	4.76	47.2	
541-0130	13	3/32	6.35	50.4	
541-0140	14	7/64	7.94	53.5	
541-0150	15	5/32	11.11	69.4	
541-0160	16	3/16	12.7	75.8	
541-0170	17	7/32	15.87	82.1	
541-0180	18	1/4	19.05	88.5	

Order No.	D1	D2	L1	Prices
532- 0007	0.75	3.50	120	
532- 0010	1.00	4.00	120	
532- 0015	1.50	5.00	120	
532- 0020A	2.00	6.00	120	
532- 0025A	2.50	8.00	120	
532- 0030A	3.00	8.00	120	
532- 0030B	3.00	10.0	120	
532- 0040A	4.00	10.0	120	
532- 0040B	4.00	12.0	120	
532- 0020B	2.00	5.0	200	
532- 0025B	2.50	6.3	200	
53 2-0031	3.15	8.0	200	
532- 0040C	4.00	10.0	200	
532- 0040C	5.00	12.5	200	
532- 0040C	6.30	16.0	200	
532- 0040C	8.00	20.0	200	
532- 0040C	10.00	25.0	200	

World Class Tools From
World Class Universal Tool

UNI DRILL 519

SOLID CARBIDE TWIST DRILL-PARA TYPE

(Parabolic) Flute Type

With reinforced cylindrical shank right hand cut, acc. DIN. 338

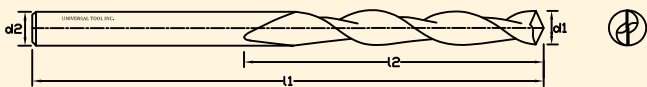
GOMETRY AND APPLICATION

Point grind: 4facet ground/point angle: 130° / web thinned chisel edge: DIN 1412 from B/ side rack angle: 30° web thickness : reinforced.

Side rack angle: 30° / profile: Standard

Universal application particularly suitable for machining of Cr-Ni-steels, highly resistance steels aluminium with high percentage of silicon, optimal chip transport due to Parabolic- flute form. Also on request with thro coolant drills.

Intermediate sizes on request



Order No.	d1	d2	L1	L2	Z	Prices
519-0010	1.00	1.00	34	12	2	
519-0011	1.10	1.10	36	14	2	
519-0012	1.20	1.20	38	16	2	
519-0013	1.30	1.30	38	16	2	
519-0014	1.40	1.40	40	18	2	
519-0015	1.50	1.50	40	18	2	
519-0016	1.60	1.60	43	20	2	
519-0017	1.70	1.70	43	20	2	
519-0018	1.80	1.80	46	22	2	
519-0019	1.90	1.90	46	22	2	
519-0020	2.00	2.00	49	24	2	
519-0021	2.10	2.10	49	24	2	
519-0022	2.20	2.20	53	27	2	
519-0023	2.30	2.30	53	27	2	
519-0024	2.40	2.40	57	30	2	
519-0025	2.50	2.50	57	30	2	
519-0026	2.60	2.60	57	30	2	
519-0027	2.70	2.70	61	33	2	
519-0028	2.80	2.80	61	33	2	
519-0029	2.90	2.90	61	33	2	
519-0300	3.00	3.00	61	33	2	
519-0035	3.50	3.50	70	39	2	
519-0040	4.00	4.00	75	43	2	
519-0045	4.50	4.50	80	47	2	
519-0050	5.00	5.00	86	52	2	
519-0055	5.50	5.50	93	57	2	
519-0060	6.00	6.00	93	57	2	
519-0065	6.50	6.50	101	63	2	
519-0070	7.00	7.00	109	69	2	
519-0080	8.00	8.00	117	75	2	
519-0090	9.00	9.00	125	81	2	
519-0100	10.00	10.00	133	87	2	

UNI DRILL 513

SOLID CARBIDE STEP BURNISHING DRILL

Long type, with two straight flutes thro' coolant

GOMETRY AND APPLICATION

DIN 6537, right hand cut cylindrical shank acc. DIN 6535 HAK, point angle 140°

For production of tapping drill holes with countersinking. Drills for tap holes. Also available for other kind of threads such as UNC-UNF, metric fine pipe thread, etc.

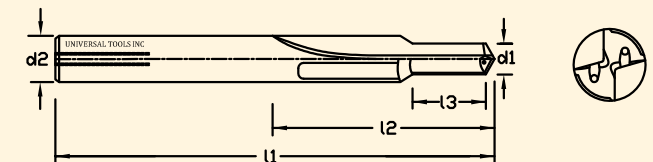
For tapping drill holes for threads cutting (T). For thread forming (F) with 90 degree incl chamfer angle, on request chamfer angle 120 degree incl etc.

Machining of short chipping materials like cast iron, malleable cast iron, aluminium with silicon content, copper with zinc and bronze.

Excellent performance with best surface finish.

Precise dimensions and precise positioning.

w/o coolant



*Note: the length of the flute for this type of tool is 2,5x D 2 larger than effective length.

Order No.	d1	d2	L1	L2	L3	T/F	Prices
513-M3A	2.50	6.0	62	20	8.8	T	
513-M3B	2.75	6.0	62	20	8.8	F	
513-M4A	3.30	6.0	62	20	11.4	T	
513-M4B	3.65	6.0	62	20	11.4	F	
513-M5A	4.20	6.0	66	26	13.5	T	
513-M5B	4.65	6.0	66	28	13.5	F	
513-M6A	5.00	8.0	79	34	16.5	T	
513-M6B	5.55	8.0	79	34	16.5	F	
513-M8A	6.80	10.0	89	47	21.0	T	
513-M8B	7.40	10.0	89	47	21.0	F	
513-M10A	8.50	12.0	102	55	25.5	T	
513-M10B	9.35	12.0	102	55	25.5	F	
513-M12A	10.2	14.0	107	60	30.0	T	
513-M12B	11.2	14.0	107	60	30.0	F	
513-M14A	12.0	16.0	115	65	34.5	T	
513-M14B	13.2	16.0	115	65	34.5	F	
513-M16A	14.0	18.0	123	73	38.5	T	
513-M16B	15.1	18.0	123	73	38.5	F	
513-M18A	15.5	20.0	131	79	43.5	T	
513-M18B	16.0	20.0	131	79	43.5	F	
513-M20A	17.5	22.0	147	89	47.5	T	
513-M20B	18.9	22.0	147	89	47.5	F	

Contd

Contd

(UNI DRILL 513) SOLID CARBIDE STEP BURNISHING DRILL
Long type, with two straight flutes (thro coolant)

Order No.	d1	d2	L1	L2	L3	T/F	Prices
513-M22	19.5	24.0	149	90	51.5	T	
513-M24	21.0	26.0	152	97	56.5	T	
513-M27	24.0	30.0	160	103	62.5	T	
513-M30	26.0	33.0	170	110	70.0	T	

Note: (A) While order Affix SC/IC after Order

SC= Solid Carbide w/o Coolant

IC= Solid Carbide with internal Coolant

Eg- 513M3ASC or 513M3A

UNI DRILL 514

SOLID CARBIDE BURNISHING DRILL

L X D =3

Long type, with two straight flutes and thro' coolant

GOMETRY AND APPLICATION

DIN 6537, right hand cut cylindrical shank acc.

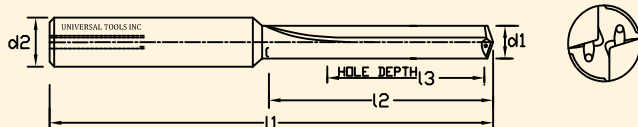
DIN 6535 HAK, point angle 140°

Machining of short chipping materials like cast iron, malleable cast iron, aluminium with silicon content, copper with zinc and bronze.

Excellent performance with best surface finish.

Precise dimensions and precise positioning.

L3 = Hole depth



Order No.	d1	d2	L1	L2	L3	Prices
514-0040	4.00	6.0	66	24	17	
514-0042	4.20	6.0	66	24	17	
514-0050	5.00	6.0	66	28	20	
514-0060	6.00	6.0	66	28	20	
514-0068	6.80	8.0	79	34	24	
514-0070	7.00	8.0	79	34	24	
514-0080	8.00	8.0	79	41	29	
514-0085	8.50	10.0	89	47	35	
514-0090	9.00	10.0	89	47	35	
514-0100	10.00	10.0	89	47	35	
514-0102	10.20	12.0	102	55	40	
514-0105	10.50	12.0	102	55	40	
514-0110	11.00	12.0	102	55	40	

Contd

Contd

(UNI DRILL 514) SOLID CARBIDE BURNISHING DRILL
L X D =3

Order No.	d1	d2	L1	L2	L3	Prices
514-0040	4.00	6.0	66	24	17	2
514-0042	4.20	6.0	66	24	17	2
514-0050	5.00	6.0	66	28	20	2
514-0060	6.00	6.0	66	28	20	2

Note: (A) While order Affix SC/IC after Order

SC= Solid Carbide w/o Coolant

IC= Solid Carbide with internal Coolant

UNI DRILL 515

SOLID CARBIDE BURNISHING DRILL

L X D =5

Long type, with two straight flutes thro' coolant

GOMETRY AND APPLICATION

DIN 6537, right hand cut cylindrical shank acc. DIN 6535 HAK, point angle 140°

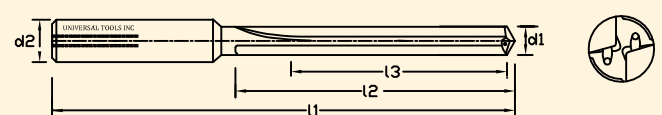
Machining of short chipping materials like iron, malleable cast iron, aluminium with silicon content, copper with zinc and bronze.

Excellent performance with best surface finish.

Precise dimensions and precise positioning.

Also offered on intermediate sizes on request.

L3 = Hole depth Thro coolant



Order No.	d1	d2	L1	L2	L3	Prices
515-0040	4.0	6.0	74	36	29	
515-0042	4.2	6.0	74	36	29	
515-0050	5.0	6.0	82	44	35	
515-0060	6.0	6.0	82	44	35	
515-0068	6.8	8.0	91	53	43	
515-0070	7.0	8.0	91	53	43	
515-0080	8.0	8.0	91	53	43	
515-0085	8.5	10.0	103	61	49	
515-0090	9.0	10.0	103	61	49	
515-0100	10.0	10.0	103	61	49	
515-0102	10.2	12.0	118	71	56	

Contd

Contd

(UNI DRILL 515) SOLID CARBIDE 3S' SPIRAL POINT L X D =5

Order No.	d1	d2	L1	L2	L3	Prices
515-0105	10.5	10.5	118	71	56	
515-0110	11.0	11.0	118	71	56	
515-0120	12.0	12.0	118	71	56	
515-0140	14.0	14.0	124	77	56	
515-0160	16.0	16.0	133	83	63	
515-0180	18.0	18.0	143	93	71	
515-0200	20.0	20.0	153	101	77	
515-0210	21.0	21.0	160	105	79	
515-0220	22.0	22.0	160	105	79	
515-0230	23.0	25.0	160	105	79	
515-0240	24.0	25.0	160	105	79	
515-0250	25.0	25.0	160	105	79	
515-0260	26.0	32.0	170	120	100	
515-0270	27.0	32.0	170	120	100	
515-0280	28.0	32.0	170	120	100	
515-0290	29.0	32.0	170	120	100	
515-0300	30.0	32.0	170	120	100	
515-0320	32.0	32.0	170	120	100	
515-0340	34.0	32.0	170	120	100	
515-0360	36.0	32.0	170	120	100	
515-0380	38.0	32.0	170	120	100	
515-0400	40.0	32.0	170	120	100	
515-0450	45.0	32.0	170	120	100	
515-0500	50.0	32.0	170	120	100	

UNI DRILL 516

SOLID CARBIDE BURNISHING DRILL

L X D =7

Extra long type, with two straight flutes thro' coolant

GOMETRY AND APPLICATION

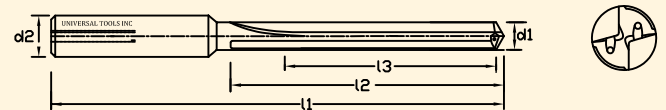
Right hand cut with cylindrical shank acc. DIN 6535 HAK point angle 140°

Machining of short chipping materials like iron, malleable cast iron, aluminium with silicon content, copper with zinc and bronze.

Excellent performance with best surface finish.

Precise dimensions and precise positioning.

L3 = Hole depth Thro coolant



Order No.	d1	d2	L1	L2	L3	Prices
516-0040	4.0	6.0	78	37	28	
516-0042	4.2	6.0	78	37	28	
516-0050	5.0	6.0	88	49	35	
516-0060	6.0	6.0	88	49	35	
516-0068	6.8	8.0	104	66	48	
516-0070	7.0	8.0	104	66	49	
516-0080	8.0	8.0	104	66	56	
516-0085	8.5	10.0	140	98	70	
516-0090	9.0	10.0	140	98	70	
516-0100	10.0	10.0	140	98	70	
516-0102	10.2	12.0	145	98	74	
516-0105	10.5	12.0	145	98	74	
516-0110	11.0	12.0	145	98	74	
516-0120	12.0	12.0	145	98	84	
516-0140	14.0	14.0	161	114	98	
516-0160	16.0	16.0	181	131	112	
516-0180	18.0	18.0	197	147	126	
516-0200	20.0	20.0	216	164	140	
516-0210	21.0	25.0	263	205	182	
516-0220	22.0	25.0	263	205	182	
516-0240	24.0	25.0	263	205	182	
516-0260	26.0	26.0	263	205	183	
516-0300	30.0	30.0	310	246	210	
516-0320	32.0	32.0	310	246	210	
516-0350	35.0	32.0	310	246	210	
516-0400	40.0	32.0	310	246	210	

World Class Tools From
World Class Universal Tool

UNI DRILL 517

SOLID CARBIDE BURNISHING DRILL

(long) L X D = 8 thro' coolant

Long for all short chipping materials, such as cast iron, brass and AISi alloy

GOMETRY AND APPLICATION

Dimension according to Universal standard long, 2cutting edges, right-hand cutting straight-fluted, 4-lands of a twist drill, for depth up to approx. BxD, straight shank according to DIN 6535 HAK, high performance bit geometry.

Machining of short chipping materials like cast iron, malleable cast iron, aluminium with silicon content, copper with zinc and bronze.

Excellent performance with best surface finish.

Precise dimension and precise positioning.

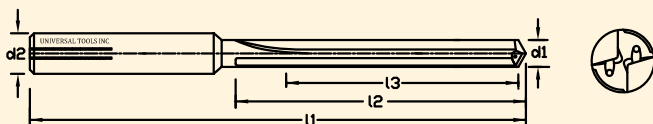
Note: (A) While order Affix SC/IC after Order

SC= Solid Carbide w/o Coolant

IC= Solid Carbide with internal Coolant

Eg- 5160040SC or 5160040

L3 = Hole depth Thro coolant



Order No.	d1	L3	L2	L1	d2	Prices
517-0050	5.0	46	60	98	6	
517-0055	5.5	46	60	98	6	
517-0058	5.8	46	60	98	6	
517-0060	6.0	46	60	98	6	
517-0065	6.5	60	76	114	8	
517-0068	6.8	60	76	114	8	
517-0070	7.0	60	76	114	8	
517-0075	7.5	60	76	114	8	
517-0078	7.8	60	76	114	8	
517-0080	8.0	60	76	114	8	
517-0085	8.5	74	92	134	10	
517-0088	8.8	74	92	134	10	
517-0090	9.0	74	92	134	10	
517-0092	9.2	74	92	134	10	
517-0095	9.5	74	92	134	10	
517-0098	9.8	74	92	134	10	
517-0100	10.0	74	92	134	10	
517-0102	10.2	88	108	155	12	
517-0105	10.5	88	108	155	12	
517-0108	10.8	88	108	155	12	
517-0110	11.0	88	108	155	12	
517-0115	11.5	88	108	155	12	
517-0118	11.8	88	108	155	12	
517-0120	12.0	88	108	155	12	
517-0125	12.5	104	125	172	14	

Contd

(UNI DRILL 517) SOLID CARBIDE BURNISHING DRILL

(long) L X D = 8 Thro Coolant

Order No.	d1	L3	L2	L1	d2	Prices
517-0128	12.8	104	125	172	14	
517-0130	13.0	104	125	172	14	
517-0135	13.5	104	125	172	14	
517-0138	13.8	104	125	172	14	
517-0140	14.0	104	125	172	14	
517-0145	14.5	120	143	193	16	
517-0148	14.8	120	143	193	16	
517-0150	15.0	120	143	193	16	
517-0155	15.5	120	143	193	16	
517-0158	15.8	120	143	193	16	
517-0160	16.0	120	143	193	16	
517-0165	16.5	138	160	210	18	
517-0170	17.0	138	160	210	18	
517-0175	17.5	138	160	210	18	
517-0178	17.8	138	160	210	18	
517-0180	18.0	138	160	210	18	
517-0185	18.5	152	177	229	20	
517-0190	19.0	152	177	229	20	
517-0195	19.5	152	177	229	20	
517-0198	19.8	152	177	229	20	
517-0200	20.0	152	177	229	20	
517-0210	21.0	152	177	229	20	
517-0220	22.0	152	177	229	20	
517-0230	23.0	152	177	229	20	
517-0240	24.0	152	177	229	20	
517-0250	25.0	190	210	265	25	
517-0260	26.0	190	210	265	26	
517-0270	27.0	190	210	265	28	
517-0280	28.0	190	210	265	28	
517-0290	29.0	190	210	265	32	
517-0300	30.0	220	250	310	32	
517-0320	32.0	220	250	310	32	
517-0340	34.0	220	250	310	32	
517-0360	36.0	220	250	310	32	
517-0380	38.0	220	250	310	32	
517-0400	40.0	220	250	310	32	
517-0450	45.0	220	250	310	32	
517-0500	50.0	220	250	310	32	

Contd

UNI DRILL 518

SOLID CARBIDE BURNISHING DRILL

(EXTRA Long) L X D = 12 thro' coolant

GOMETRY AND APPLICATION

Long for all short chipping materials, such as cast iron, brass and Al-Si alloy

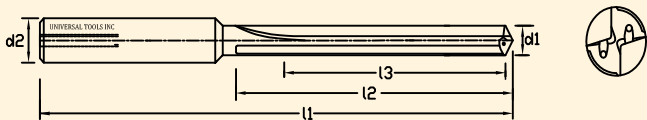
Dimension according to Universal standard long, 2cutting edges, right-hand cutting straight-fluted, 4-lands of a twist drill, for depth upto approx, BxD, straight shank according to DIN 6535 HAK, high performance bit geometry.

Machining of short chipping materials like cast iron, malleable cast iron, aluminium with silicon content, copper with zinc and bronze.

Excellent performance with best surface finish.

Precise dimension and precise positioning.

L3 = Hole depth Thro coolant



Order No.	d1	L3	L2	L1	d2	Prices
518-0040	4.00	58	77	121	6	
518-0042	4.20	58	77	121	6	
518-0045	4.50	58	77	121	6	
518-0050	5.00	68	82	121	6	
518-0055	5.50	68	82	121	6	
518-0058	5.80	68	82	121	6	
518-0060	6.00	68	82	121	6	
518-0065	6.50	90	106	146	8	
518-0068	6.80	90	106	146	8	
518-0070	7.00	90	106	146	8	
518-0075	7.50	90	106	146	8	
518-0078	7.80	90	106	146	8	
518-0080	8.00	90	106	146	8	
518-0085	8.50	75	112	130	10	
518-0088	8.80	75	112	130	10	
518-0090	9.00	75	112	130	10	
518-0092	9.20	75	112	130	10	
518-0095	9.50	75	112	130	10	
518-0100	10.00	75	112	130	10	
518-0102	10.20	139	159	209	12	
518-0105	10.50	139	159	209	12	
518-0108	10.80	139	159	209	12	
518-0110	11.00	139	159	209	12	
518-0115	11.50	139	159	209	12	
518-0118	11.80	139	159	209	12	
518-0120	12.00	139	159	209	12	

Contd

Contd

(UNI DRILL 518) SOLID CARBIDE BURNISHING DRILL (EXTRA Long) L X D = 12 Thro Coolant

Order No.	d1	L3	L2	L1	d2	Prices
518-0125	12.50	162	183	233	14	
518-0128	12.80	162	183	233	14	
518-0130	13.00	162	183	233	14	
518-0135	13.50	162	183	233	14	
518-0138	13.80	162	183	233	14	
518-0140	14.00	162	183	233	14	
518-0145	14.50	184	209	260	16	
518-0148	14.80	184	209	260	16	
518-0150	15.00	184	209	260	16	
518-0155	15.50	184	209	260	16	
518-0158	15.80	184	209	260	16	
518-0160	16.00	184	209	260	16	
518-0165	16.50	207	231	284	18	
518-0170	17.00	207	231	284	18	
518-0175	17.50	207	231	284	18	
518-0178	17.80	207	231	284	18	
518-0180	18.00	207	231	284	18	
518-0185	18.50	230	255	308	20	
518-0189	18.90	230	255	308	20	
518-0190	19.00	230	255	308	20	
518-0195	19.50	230	255	308	20	
518-0198	19.80	230	255	308	20	
518-0200	20.00	230	255	308	20	
518-0220	22.00	230	255	308	22	
518-0250	25.00	230	255	308	25	
518-0260	26.00	230	255	308	26	
518-0280	28.00	230	255	308	28	
518-0300	30.00	230	255	308	30	

World Class Tools From
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UNI DRILL 533

SOLID CARBIDE TWO FLUTED GUN DRILLS

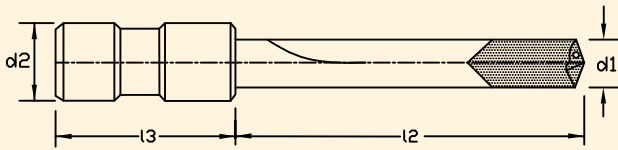
(THROUGH COOLANT)

NOTE:

ABOVE TOOL WILL BE SUPPLIED WITH ST. SHANK FLUTE.

Also offered on Request in.

- i) Lug type construction with morse taper / st. shank in steel.
- ii) TiN coated and TiAlN coated
- iii) Left hand cutting right hand cutting or st. flutes.
- iv) Any special length & flute length
- v) Intermediate sizes



ORDER NO	Range dia	Body length L2	Shank length Type 1 L3	Shank length Type 2 L3	PRICES
533-0080	8-8.9	65	48	40	
533-0090	9-9.5	70	48	40	
533-0100	10-10.9	75	48	40	
533-0110	11-11.9	80	48	40	
533-0120A	12-12.4	85	48	40	
533-0120B	12.5-12.9	85	53	50	
533-0130	13-13.5	95	53	50	
533-0140	14-14.5	100	53	50	
533-0150	15-15.5	105	53	50	
533-0160	16-16.5	110	53	50	
533-0170	17-17.5	115	53	50	
533-0180	18-18.5	125	53	50	
533-0190	19-19.5	130	53	50	
533-0196	19.6-20	135	53	50	
533-0201	20.1-20.9	135	60	55	
533-0210	21-21.9	140	60	55	
533-0220	22-22.9	145	60	55	
533-0230	23-23.9	150	60	55	
533-0240	24-24.5	155	60	55	
533-0246	24.6-25	160	60	55	
533-0251	25.1-28	180	60	55	
533-0281	28.1-32	180	60	55	
533-0301	32.1-36	180	60	55	

UNI - LUG DRILL 534

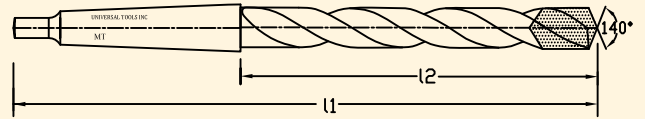
SOLID CARBIDE LUGGED DRILL

(Taper shank)

NOTE:

ALSO OFFERED ON REQUEST IN:

- 1. Thro' coolant lugged design.
- 2. Full solid carbide length but only shank is steel either in Taper shank or st. shank.
- 3. TiN coated and TiAlN coated.
- 4. Left hand cutting right hand cutting or st. flutes
- 5. Any special length & flute length
- 6. Intermediate sizes.



Order No	Dia Range D	Fl L2	OAL L1	Morse Taper Shank	Prices
534-0050	5-6	50	140	1	
534-0061	6.1-7	50	140	1	
534-0071	7.1-8	50	140	1	
534-0081	8.1-9	50	140	1	
534-0101	10.1-11	50	140	1	
534-0111	11.1-12	50	140	1	
534-0121	12.1-13	56	146	1	
534-0131	13.1-14	56	146	1	
534-0141	14.1-15	63	168	2	
534-0151	15.1-16	63	168	2	
534-0161	16.1-17	70	175	2	
534-0171	17.1-18	70	175	2	
534-0181	18.1-19	80	185	2	
534-0191	19.1-20	80	185	2	
534-0201	20.1-21	90	215	3	
534-0211	21.1-22	90	215	3	
534-0221	22.1-23	100	225	3	
534-0231	23.1-24	100	225	3	
534-0241	24.1-25	100	225	3	
534-0251	25.1-26	110	260	4	
534-0261	26.1-27	110	260	4	
534-0271	27.1-28	110	260	4	
534-0281	28.1-29	125	275	4	
534-0291	29.1-30	125	275	4	
534-0301	30.1-31	125	275	4	
534-0311	31.1-32	125	275	5	
534-0321	32.1-40	125	275	5	
534-0331	40.1-50	125	275	5	