

General purpose Internal coolant Drills

N-Star Drill

KORLOY
TECH-NEWS






- Improved cutting edge design reduces initial cutting forces
- Flute designed for high hardness and excellent chip evacuation



CONTENTS

NDPGH SERIES

Designation	Standard	Flute	Geometry	Length			coolant	Margin	Tolerance	Cutting Dia (mm)		Page
				3D	5D	8D				Min	Max	
NDPGH503	◆◇	2 Flute		○			Internal	Single	m7	3	20	5
NDPGH505	◆◇				○		Internal	Single	m7	3	20	8
NDPGH508	◆◇					○	Internal	Single	m7	3	16	11
Recommended Cutting Condition											14	

◆ Metric ◇ Inch

NDPGH SERIES

Characteristics

1. Designed for a wide range of work materials
2. New flute design provides larger volume of fluid to cool the cutting edge
3. XR thinning provides excellent chip evacuation and reduced cutting forces
4. Wider flutes minimizes chip packing

Product Lineup

- 3D: DIN 6537 · HB/HE Shank
- 5D: DIN 6537 · HB/HE Shank
- 8D: DIN 6537 · HB/HE Shank

XR Thinning

- Excellent chip evacuation
- Provides improved chipping resistance and prevents drill breakage
- Streamlined thinning shape reduces cutting forces

New Flute Geometry

- Lower cutting temperatures are possible due to higher volume of coolant
- Excellent chip evacuation

Improved Cooling

Reduced Chip Packing

- Wider flute design provides excellent chip evacuation
- Designed to reduce the friction in the flute surface for improved chip evacuation

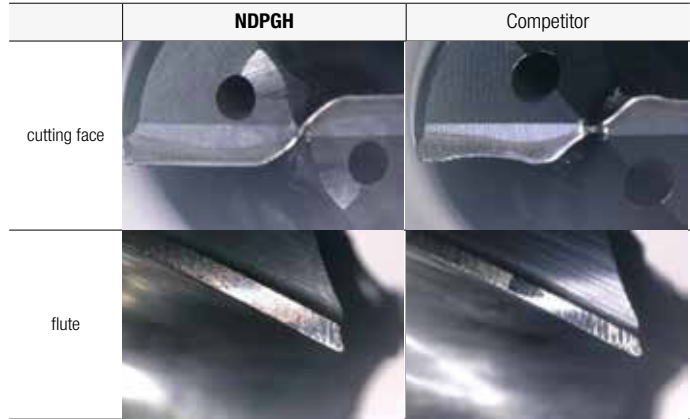
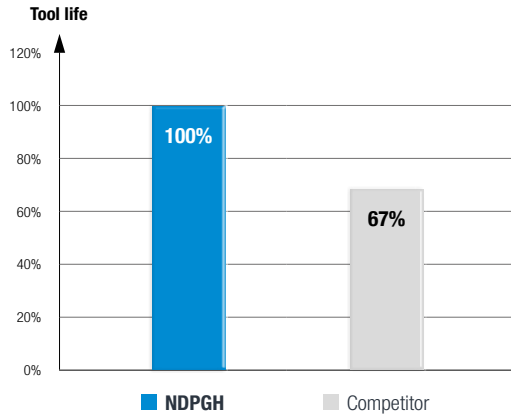
Code system

*If expressed as an integer, the decimal point is omitted

NDP	G	H	5	05	060	D
General purpose Internal coolant Drill	Work piece G: General Purpose H: Oil-Hole Coolant	Coolant Type H: Oil-Hole Coolant	Grade 5 Grade	Working Depth 03: 3D 05: 5D 08: 8D	Cutting Dia (Ø) 030: Ø 3.0 060: Ø 6.0 103: Ø 10.3	Standard D: DIN

Case Study

Carbon Steel

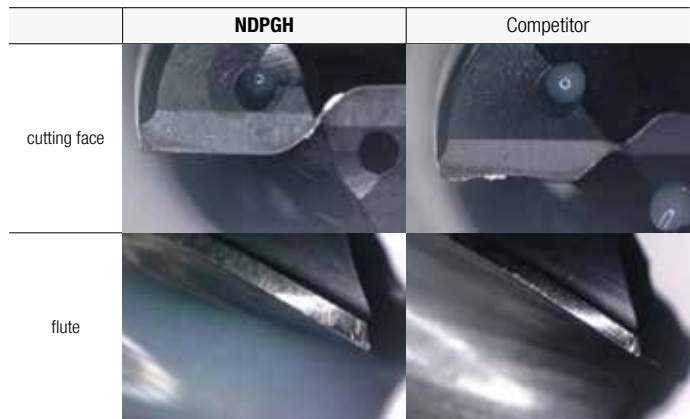
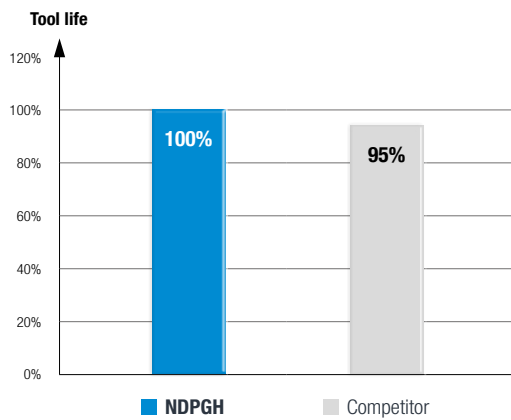


• SPEC: NDPGH505060D (D6.0-44/82-6)

• Cutting Condition

Vc	rpm	fn	Feed	Ap	Coolant
100	5,300	0.24	1,272	30	Inner

Alloy Steel

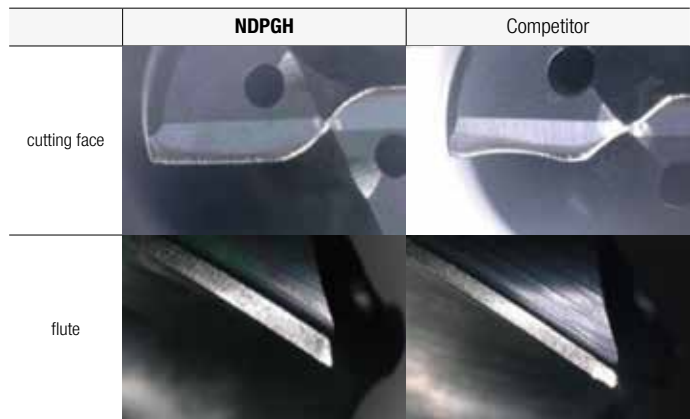
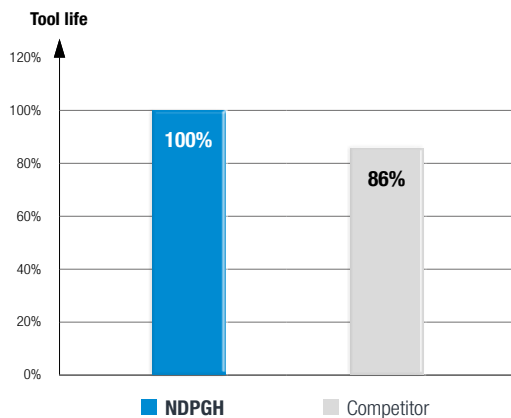


• SPEC: NDPGH505060D (D6.0-44/82-6)

• Cutting Condition

Vc	rpm	fn	Feed	Ap	Coolant
90	4,250	0.20	850	30	Inner

Stainless Steel



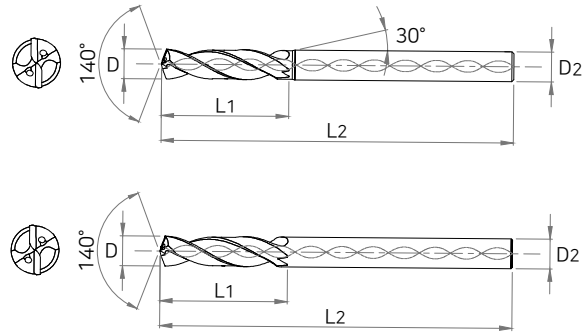
• SPEC : NDPGH505060D (D6.0-44/82-6)

• Cutting Condition

Vc	rpm	fn	Feed	Ap	Coolant
60	3,175	0.14	445	19	Inner

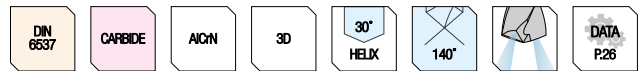
NDPGH503

General purpose Internal coolant Drill



Tolerance

Cutting Dia (mm)		Shank Dia h6
- D3	+0.002-+0.012	
D3.1-D6	+0.004-+0.016	
D6.1-D10	+0.006-+0.021	
D10.1-D18	+0.007-+0.025	
D18.1-D20	+0.008-+0.029	



Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH503030D	3.0	20	62	6	-	-	▲
NDPGH503031D	3.1	20	62	6	-	-	▲
NDPGH50303175D	3.175	20	62	6	-	-	▲
NDPGH503032D	3.2	20	62	6	-	-	▲
NDPGH503033D	3.3	20	62	6	M4x0.7	WH1-4	▲
NDPGH503034D	3.4	20	62	6	M4x0.7	WH5-6	▲
NDPGH503035D	3.5	20	62	6	-	-	▲
NDPGH50303572D	3.572	20	62	6	-	-	▲
NDPGH503036D	3.6	20	62	6	-	-	▲
NDPGH503037D	3.7	20	62	6	-	-	▲
NDPGH503038D	3.8	24	66	6	-	-	▲
NDPGH503039D	3.9	24	66	6	-	-	▲
NDPGH50303969D	3.969	24	66	6	-	-	▲
NDPGH503040D	4.0	24	66	6	-	-	▲
NDPGH50304039D	4.039	24	66	6	-	-	▲
NDPGH503041D	4.1	24	66	6	-	-	▲
NDPGH503042D	4.2	24	66	6	M5x0.8	WH1-4	▲
NDPGH503043D	4.3	24	66	6	M5x0.8	WH5-6	▲
NDPGH50304366D	4.366	24	66	6	-	-	▲
NDPGH503044D	4.4	24	66	6	-	-	▲
NDPGH503045D	4.5	24	66	6	-	-	▲
NDPGH503046D	4.6	24	66	6	-	-	▲
NDPGH503047D	4.7	24	66	6	-	-	▲
NDPGH50304763D	4.763	28	66	6	-	-	▲
NDPGH503048D	4.8	28	66	6	-	-	▲
NDPGH503049D	4.9	28	66	6	-	-	▲
NDPGH503050D	5.0	28	66	6	M6x1.0	WH1-4	▲
NDPGH503051D	5.1	28	66	6	M6x1.0	WH5-6	▲
NDPGH50305159D	5.159	28	66	6	-	-	▲
NDPGH503052D	5.2	28	66	6	-	-	▲
NDPGH503053D	5.3	28	66	6	-	-	▲

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH503054D	5.4	28	66	6	-	-	▲
NDPGH503055D	5.5	28	66	6	-	-	▲
NDPGH50305556D	5.558	28	66	6	-	-	▲
NDPGH503056D	5.6	28	66	6	-	-	▲
NDPGH503057D	5.7	28	66	6	-	-	▲
NDPGH503058D	5.8	28	66	6	-	-	▲
NDPGH503059D	5.9	28	66	6	-	-	▲
NDPGH50305953D	5.953	28	66	6	-	-	▲
NDPGH503060D	6.0	28	66	6	-	-	▲
NDPGH503061D	6.1	34	79	8	-	-	▲
NDPGH503062D	6.2	34	79	8	-	-	▲
NDPGH503063D	6.3	34	79	8	-	-	▲
NDPGH5030635D	6.35	34	79	8	-	-	▲
NDPGH503064D	6.4	34	79	8	-	-	▲
NDPGH503065D	6.5	34	79	8	-	-	▲
NDPGH50306528D	6.528	34	79	8	-	-	▲
NDPGH503066D	6.6	34	79	8	-	-	▲
NDPGH503067D	6.7	34	79	8	-	-	▲
NDPGH50306747D	6.747	34	79	8	-	-	▲
NDPGH503068D	6.8	34	79	8	M8x1.25	WH1-4	▲
NDPGH503069D	6.9	34	79	8	M8x1.25	WH5-6	▲
NDPGH503070D	7.0	34	79	8	M8x1.0	WH1-4	▲
NDPGH503071D	7.1	41	79	8	M8x1.0	WH5-6	▲
NDPGH50307144D	7.144	41	79	8	-	-	▲
NDPGH503072D	7.2	41	79	8	-	-	▲
NDPGH503073D	7.3	41	79	8	-	-	▲
NDPGH503074D	7.4	41	79	8	-	-	▲
NDPGH503075D	7.5	41	79	8	-	-	▲
NDPGH50307541D	7.541	41	79	8	-	-	▲
NDPGH503076D	7.6	41	79	8	-	-	▲
NDPGH503077D	7.7	41	79	8	-	-	▲

▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

Applicable Work Materials

○ : Good ◎ : Excellent

P			H		M	K	N
Carbon Steel - HB225	Alloy Steel HB225-325	Prehardened Steel HRc30-50	Hardened Steel		Stainless	Cast Iron	Non-ferrous & Aluminum
			SKD61 -HRc55	SKD11 HRc55-			
◎	◎	◎	○		◎	○	○

NDPGH503

General purpose Internal coolant Drill

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH503078D	7.8	41	79	8	-	-	▲
NDPGH503079D	7.9	41	79	8	-	-	▲
NDPGH50307938D	7.938	41	79	8	-	-	▲
NDPGH503080D	8.0	41	79	8	-	-	▲
NDPGH503081D	8.1	47	89	10	-	-	▲
NDPGH503082D	8.2	47	89	10	-	-	▲
NDPGH503083D	8.3	47	89	10	-	-	▲
NDPGH50308334D	8.334	47	89	10	-	-	▲
NDPGH503084D	8.4	47	89	10	-	-	▲
NDPGH50308433D	8.433	47	89	10	-	-	▲
NDPGH503085D	8.5	47	89	10	M10x1.5	WH1-4	▲
NDPGH503086D	8.6	47	89	10	M10x1.5	WH5-6	▲
NDPGH503087D	8.7	47	89	10	-	-	▲
NDPGH50308731D	8.731	47	89	10	-	-	▲
NDPGH503088D	8.8	47	89	10	M10x1.25	WH1-4	▲
NDPGH503089D	8.9	47	89	10	M10x1.25	WH5-6	▲
NDPGH503090D	9.0	47	89	10	M10x1.0	WH1-4	▲
NDPGH503091D	9.1	47	89	10	M10x1.0	WH5-6	▲
NDPGH50309128D	9.128	47	89	10	-	-	▲
NDPGH503092D	9.2	47	89	10	-	-	▲
NDPGH503093D	9.3	47	89	10	-	-	▲
NDPGH50309347D	9.347	47	89	10	-	-	▲
NDPGH503094D	9.4	47	89	10	-	-	▲
NDPGH503095D	9.5	47	89	10	-	-	▲
NDPGH50309525D	9.525	47	89	10	-	-	▲
NDPGH503096D	9.6	47	89	10	-	-	▲
NDPGH503097D	9.7	47	89	10	-	-	▲
NDPGH503098D	9.8	47	89	10	-	-	▲
NDPGH503099D	9.9	47	89	10	-	-	▲
NDPGH50309922D	9.922	47	89	10	-	-	▲
NDPGH503100D	10.0	47	89	10	-	-	▲
NDPGH503101D	10.1	55	102	12	-	-	▲
NDPGH503102D	10.2	55	102	12	-	-	▲
NDPGH503103D	10.3	55	102	12	M12x1.75	WH1-2	▲
NDPGH50310319D	10.319	55	102	12	M12x1.75	WH3-4	▲
NDPGH503104D	10.4	55	102	12	M12x1.75	WH5-6	▲
NDPGH503105D	10.5	55	102	12	M12x1.5	WH1-4	▲
NDPGH503106D	10.6	55	102	12	M12x1.5	WH5-6	▲
NDPGH503107D	10.7	55	102	12	-	-	▲
NDPGH50310716D	10.716	55	102	12	-	-	▲
NDPGH503108D	10.8	55	102	12	M12x1.25	WH1-4	▲
NDPGH503109D	10.9	55	102	12	M12x1.25	WH5-6	▲
NDPGH503110D	11.0	55	102	12	M12x1.0	WH1-4	▲
NDPGH503111D	11.1	55	102	12	M12x1.0	WH5-6	▲
NDPGH50311113D	11.113	55	102	12	-	-	▲
NDPGH503112D	11.2	55	102	12	-	-	▲
NDPGH503113D	11.3	55	102	12	-	-	▲
NDPGH503114D	11.4	55	102	12	-	-	▲
NDPGH503115D	11.5	55	102	12	-	-	▲

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH50311509D	11.509	55	102	12	-	-	▲
NDPGH503116D	11.6	55	102	12	-	-	▲
NDPGH503117D	11.7	55	102	12	-	-	▲
NDPGH503118D	11.8	55	102	12	-	-	▲
NDPGH503119D	11.9	55	102	12	-	-	▲
NDPGH50311906D	11.906	55	102	12	-	-	▲
NDPGH503120D	12.0	55	102	12	M14x2.0	WH1-4	▲
NDPGH503121D	12.1	60	107	14	M14x2.0	WH5-6	▲
NDPGH503122D	12.2	60	107	14	-	-	▲
NDPGH503123D	12.3	60	107	14	-	-	▲
NDPGH50312303D	12.303	60	107	14	-	-	▲
NDPGH503124D	12.4	60	107	14	-	-	▲
NDPGH503125D	12.5	60	107	14	M14x1.5	WH1-4	▲
NDPGH503126D	12.6	60	107	14	M14x1.5	WH5-6	▲
NDPGH503127D	12.7	60	107	14	-	-	▲
NDPGH503128D	12.8	60	107	14	-	-	▲
NDPGH503129D	12.9	60	107	14	-	-	▲
NDPGH503130D	13.0	60	107	14	-	-	▲
NDPGH503131D	13.1	60	107	14	-	-	▲
NDPGH503132D	13.2	60	107	14	-	-	▲
NDPGH503133D	13.3	60	107	14	-	-	▲
NDPGH503134D	13.4	60	107	14	-	-	▲
NDPGH503135D	13.5	60	107	14	-	-	▲
NDPGH503136D	13.6	60	107	14	-	-	▲
NDPGH503137D	13.7	60	107	14	-	-	▲
NDPGH503138D	13.8	60	107	14	-	-	▲
NDPGH50313891D	13.891	60	107	14	-	-	▲
NDPGH503139D	13.9	60	107	14	-	-	▲
NDPGH503140D	14.0	60	107	14	M16x2.0	WH1-4	▲
NDPGH503141D	14.1	65	115	16	M16x2.0	WH5-6	▲
NDPGH503142D	14.2	65	115	16	-	-	▲
NDPGH50314288D	14.288	65	115	16	-	-	▲
NDPGH503143D	14.3	65	115	16	-	-	▲
NDPGH503144D	14.4	65	115	16	-	-	▲
NDPGH503145D	14.5	65	115	16	M16x1.5	WH1-4	▲
NDPGH503146D	14.6	65	115	16	M16x1.5	WH5-6	▲
NDPGH50314684D	14.684	65	115	16	-	-	▲
NDPGH503147D	14.7	65	115	16	-	-	▲
NDPGH503148D	14.8	65	115	16	-	-	▲
NDPGH503149D	14.9	65	115	16	-	-	▲
NDPGH503150D	15.0	65	115	16	-	-	▲
NDPGH50315081D	15.081	65	115	16	-	-	▲
NDPGH503151D	15.1	65	115	16	-	-	▲
NDPGH503152D	15.2	65	115	16	-	-	▲
NDPGH503153D	15.3	65	115	16	-	-	▲
NDPGH503154D	15.4	65	115	16	-	-	▲
NDPGH50315478D	15.478	65	115	16	-	-	▲
NDPGH503155D	15.5	65	115	16	M18x2.5	WH1-4	▲
NDPGH503156D	15.6	65	115	16	M18x2.5	WH5-6	▲

▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

Applicable Work Materials

○ : Good ◎ : Excellent

P			H		M	K	N
Carbon Steel - HB225	Alloy Steel HB225-325	Prehardened Steel HRc30-50	Hardened Steel		Stainless	Cast Iron	Non-ferrous & Aluminum
			SKD61 -HRc55	SKD11 HRc55-			
◎	◎	◎	○		◎	○	○

NDPGH503

General purpose Internal coolant Drill

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH503157D	15.7	65	115	16	-	-	▲
NDPGH503158D	15.8	65	115	16	-	-	▲
NDPGH50315875D	15.875	65	115	16	-	-	▲
NDPGH503159D	15.9	65	115	16	-	-	▲
NDPGH503160D	16.0	65	115	16	-	-	▲
NDPGH50316272D	16.272	73	123	18	-	-	▲
NDPGH503165D	16.5	73	123	18	M18x1.5	WH1-6	▲
NDPGH50316669D	16.669	73	123	18	-	-	▲
NDPGH503170D	17.0	73	123	18	-	-	▲
NDPGH50317066D	17.066	73	123	18	-	-	▲
NDPGH50317463D	17.463	73	123	18	-	-	▲
NDPGH503175D	17.5	73	123	18	M20x2.5	WH1-6	▲

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH50317859D	17.859	73	123	18	-	-	▲
NDPGH503180D	18.0	73	123	18	-	-	▲
NDPGH50318256D	18.256	79	131	20	-	-	▲
NDPGH503185D	18.5	79	131	20	M20x1.5	WH1-6	▲
NDPGH50318654D	18.654	79	131	20	-	-	▲
NDPGH503190D	19.0	79	131	20	-	-	▲
NDPGH5031905D	19.050	79	131	20	-	-	▲
NDPGH5031925D	19.25	79	131	20	-	-	▲
NDPGH50319447D	19.447	79	131	20	-	-	▲
NDPGH503195D	19.5	79	131	20	M22x2.5	WH1-6	▲
NDPGH50319844D	19.844	79	131	20	-	-	▲
NDPGH503200D	20.0	79	131	20	-	-	▲

▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

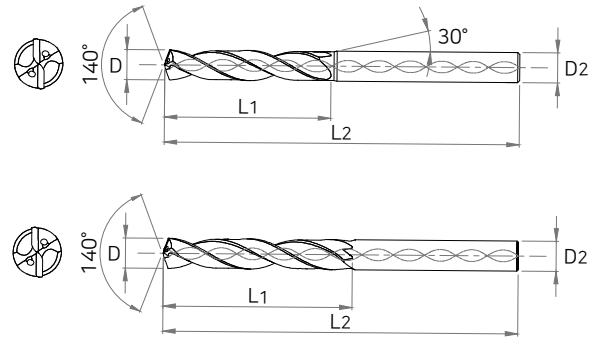
Applicable Work Materials

○ : Good ◎ : Excellent

P			H		M	K	N
Carbon Steel - HB225	Alloy Steel HB225-325	Prehardened Steel HRc30-50	Hardened Steel		Stainless	Cast Iron	Non-ferrous & Aluminum
			SKD61 -HRc55	SKD11 HRc55-			
◎	◎	◎	○		◎	○	○

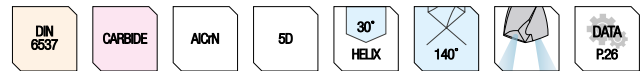
NDPGH505

General purpose Internal coolant Drill



Tolerance

Cutting Dia (mm)		Shank Dia
- D3	+0.002-+0.012	
D3.1-D6	+0.004-+0.016	
D6.1-D10	+0.006-+0.021	
D10.1-D18	+0.007-+0.025	
D18.1-D20	+0.008-+0.029	



Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH505030D	3.0	28	66	6	-	-	▲
NDPGH505031D	3.1	28	66	6	-	-	▲
NDPGH50503175D	3.175	28	66	6	-	-	▲
NDPGH505032D	3.2	28	66	6	-	-	▲
NDPGH505033D	3.3	28	66	6	M4x0.7	WH1-4	▲
NDPGH505034D	3.4	28	66	6	M4x0.7	WH 5-6	▲
NDPGH505035D	3.5	28	66	6	-	-	▲
NDPGH50503572D	3.572	28	66	6	-	-	▲
NDPGH505036D	3.6	28	66	6	-	-	▲
NDPGH505037D	3.7	28	66	6	-	-	▲
NDPGH505038D	3.8	36	74	6	-	-	▲
NDPGH505039D	3.9	36	74	6	-	-	▲
NDPGH50503969D	3.969	36	74	6	-	-	▲
NDPGH505040D	4.0	36	74	6	-	-	▲
NDPGH50504039D	4.039	36	74	6	-	-	▲
NDPGH505041D	4.1	36	74	6	-	-	▲
NDPGH505042D	4.2	36	74	6	M5x0.8	WH1-4	▲
NDPGH505043D	4.3	36	74	6	M5x0.8	WH5-6	▲
NDPGH50504366D	4.366	36	74	6	-	-	▲
NDPGH505044D	4.4	36	74	6	-	-	▲
NDPGH505045D	4.5	36	74	6	-	-	▲
NDPGH505046D	4.6	36	74	6	-	-	▲
NDPGH505047D	4.7	36	74	6	-	-	▲
NDPGH50504763D	4.763	36	74	6	-	-	▲
NDPGH505048D	4.8	44	82	6	-	-	▲
NDPGH505049D	4.9	44	82	6	-	-	▲
NDPGH505050D	5.0	44	82	6	M6x1.0	WH1-4	▲
NDPGH505051D	5.1	44	82	6	M6x1.0	WH5-6	▲
NDPGH50505159D	5.159	44	82	6	-	-	▲
NDPGH505052D	5.2	44	82	6	-	-	▲
NDPGH505053D	5.3	44	82	6	-	-	▲

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH505054D	5.4	44	82	6	-	-	▲
NDPGH505055D	5.5	44	82	6	-	-	▲
NDPGH50505556D	5.558	44	82	6	-	-	▲
NDPGH505056D	5.6	44	82	6	-	-	▲
NDPGH505057D	5.7	44	82	6	-	-	▲
NDPGH505058D	5.8	44	82	6	-	-	▲
NDPGH505059D	5.9	44	82	6	-	-	▲
NDPGH50505953D	5.953	44	82	6	-	-	▲
NDPGH505060D	6.0	44	82	6	-	-	▲
NDPGH505061D	6.1	53	91	8	-	-	▲
NDPGH505062D	6.2	53	91	8	-	-	▲
NDPGH505063D	6.3	53	91	8	-	-	▲
NDPGH5050635D	6.35	53	91	8	-	-	▲
NDPGH505064D	6.4	53	91	8	-	-	▲
NDPGH505065D	6.5	53	91	8	-	-	▲
NDPGH50506528D	6.528	53	91	8	-	-	▲
NDPGH505066D	6.6	53	91	8	-	-	▲
NDPGH505067D	6.7	53	91	8	-	-	▲
NDPGH50506747D	6.747	53	91	8	-	-	▲
NDPGH505068D	6.8	53	91	8	M8x1.25	WH1-4	▲
NDPGH505069D	6.9	53	91	8	M8x1.25	WH5-6	▲
NDPGH505070D	7.0	53	91	8	M8x1.0	WH1-4	▲
NDPGH505071D	7.1	53	91	8	M8x1.0	WH5-6	▲
NDPGH50507144D	7.144	53	91	8	-	-	▲
NDPGH505072D	7.2	53	91	8	-	-	▲
NDPGH505073D	7.3	53	91	8	-	-	▲
NDPGH505074D	7.4	53	91	8	-	-	▲
NDPGH505075D	7.5	53	91	8	-	-	▲
NDPGH50507541D	7.541	53	91	8	-	-	▲
NDPGH505076D	7.6	53	91	8	-	-	▲
NDPGH505077D	7.7	53	91	8	-	-	▲

▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

Applicable Work Materials

○ : Good ◎ : Excellent

P			H		M	K	N
Carbon Steel - HB225	Alloy Steel HB225-325	Prehardened Steel HRc30-50	Hardened Steel		Stainless	Cast Iron	Non-ferrous & Aluminum
			SKD61 -HRc55	SKD11 HRc55-			
◎	◎	◎	○		◎	○	○

NDPGH505

General purpose Internal coolant Drill

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH505078D	7.8	53	91	8	-	-	▲
NDPGH505079D	7.9	53	91	8	-	-	▲
NDPGH50507938D	7.938	53	91	8	-	-	▲
NDPGH505080D	8.0	53	91	8	-	-	▲
NDPGH505081D	8.1	61	103	10	-	-	▲
NDPGH505082D	8.2	61	103	10	-	-	▲
NDPGH505083D	8.3	61	103	10	-	-	▲
NDPGH50508334D	8.334	61	103	10	-	-	▲
NDPGH505084D	8.4	61	103	10	-	-	▲
NDPGH50508433D	8.433	61	103	10	-	-	▲
NDPGH505085D	8.5	61	103	10	M10x1.5	WH1-4	▲
NDPGH505086D	8.6	61	103	10	M10x1.5	WH5-6	▲
NDPGH505087D	8.7	61	103	10	-	-	▲
NDPGH50508731D	8.731	61	103	10	-	-	▲
NDPGH505088D	8.8	61	103	10	M10x1.25	WH1-4	▲
NDPGH505089D	8.9	61	103	10	M10x1.25	WH5-6	▲
NDPGH505090D	9.0	61	103	10	M10x1.0	WH1-4	▲
NDPGH505091D	9.1	61	103	10	M10x1.0	WH5-6	▲
NDPGH50509128D	9.128	61	103	10	-	-	▲
NDPGH505092D	9.2	61	103	10	-	-	▲
NDPGH505093D	9.3	61	103	10	-	-	▲
NDPGH50509347D	9.347	61	103	10	-	-	▲
NDPGH505094D	9.4	61	103	10	-	-	▲
NDPGH505095D	9.5	61	103	10	-	-	▲
NDPGH50509525D	9.525	61	103	10	-	-	▲
NDPGH505096D	9.6	61	103	10	-	-	▲
NDPGH505097D	9.7	61	103	10	-	-	▲
NDPGH505098D	9.8	61	103	10	-	-	▲
NDPGH505099D	9.9	61	103	10	-	-	▲
NDPGH50509922D	9.922	61	103	10	-	-	▲
NDPGH505100D	10.0	61	103	10	-	-	▲
NDPGH505101D	10.1	71	118	12	-	-	▲
NDPGH505102D	10.2	71	118	12	-	-	▲
NDPGH505103D	10.3	71	118	12	M12x1.75	WH1-2	▲
NDPGH50510319D	10.319	71	118	12	M12x1.75	WH3-4	▲
NDPGH505104D	10.4	71	118	12	M12x1.75	WH5-6	▲
NDPGH505105D	10.5	71	118	12	M12x1.5	WH1-4	▲
NDPGH505106D	10.6	71	118	12	M12x1.5	WH5-6	▲
NDPGH505107D	10.7	71	118	12	-	-	▲
NDPGH50510716D	10.716	71	118	12	-	-	▲
NDPGH505108D	10.8	71	118	12	M12x1.25	WH1-4	▲
NDPGH505109D	10.9	71	118	12	M12x1.25	WH5-6	▲
NDPGH505110D	11.0	71	118	12	M12x1.0	WH1-4	▲
NDPGH505111D	11.1	71	118	12	M12x1.0	WH5-6	▲
NDPGH50511113D	11.113	71	118	12	-	-	▲
NDPGH505112D	11.2	71	118	12	-	-	▲
NDPGH505113D	11.3	71	118	12	-	-	▲
NDPGH505114D	11.4	71	118	12	-	-	▲
NDPGH505115D	11.5	71	118	12	-	-	▲

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH50511509D	11.509	71	118	12	-	-	▲
NDPGH505116D	11.6	71	118	12	-	-	▲
NDPGH505117D	11.7	71	118	12	-	-	▲
NDPGH505118D	11.8	71	118	12	-	-	▲
NDPGH505119D	11.9	71	118	12	-	-	▲
NDPGH50511906D	11.906	71	118	12	-	-	▲
NDPGH505120D	12.0	71	118	12	M14x2.0	WH1-4	▲
NDPGH505121D	12.1	77	124	14	M14x2.0	WH5-6	▲
NDPGH505122D	12.2	77	124	14	-	-	▲
NDPGH505123D	12.3	77	124	14	-	-	▲
NDPGH50512303D	12.303	77	124	14	-	-	▲
NDPGH505124D	12.4	77	124	14	-	-	▲
NDPGH505125D	12.5	77	124	14	M14x1.5	WH1-4	▲
NDPGH505126D	12.6	77	124	14	M14x1.5	WH5-6	▲
NDPGH505127D	12.7	77	124	14	-	-	▲
NDPGH505128D	12.8	77	124	14	-	-	▲
NDPGH505129D	12.9	77	124	14	-	-	▲
NDPGH505130D	13.0	77	124	14	-	-	▲
NDPGH505131D	13.1	77	124	14	-	-	▲
NDPGH505132D	13.2	77	124	14	-	-	▲
NDPGH505133D	13.3	77	124	14	-	-	▲
NDPGH505134D	13.4	77	124	14	-	-	▲
NDPGH505135D	13.5	77	124	14	-	-	▲
NDPGH505136D	13.6	77	124	14	-	-	▲
NDPGH505137D	13.7	77	124	14	-	-	▲
NDPGH505138D	13.8	77	124	14	-	-	▲
NDPGH50513891D	13.891	77	124	14	-	-	▲
NDPGH505139D	13.9	77	124	14	-	-	▲
NDPGH505140D	14.0	77	124	14	M16x2.0	WH1-4	▲
NDPGH505141D	14.1	83	133	16	M16x2.0	WH5-6	▲
NDPGH505142D	14.2	83	133	16	-	-	▲
NDPGH50514288D	14.288	83	133	16	-	-	▲
NDPGH505143D	14.3	83	133	16	-	-	▲
NDPGH505144D	14.4	83	133	16	-	-	▲
NDPGH505145D	14.5	83	133	16	M16x1.5	WH1-4	▲
NDPGH505146D	14.6	83	133	16	M16x1.5	WH5-6	▲
NDPGH50514684D	14.684	83	133	16	-	-	▲
NDPGH505147D	14.7	83	133	16	-	-	▲
NDPGH505148D	14.8	83	133	16	-	-	▲
NDPGH505149D	14.9	83	133	16	-	-	▲
NDPGH505150D	15.0	83	133	16	-	-	▲
NDPGH50515081D	15.081	83	133	16	-	-	▲
NDPGH505151D	15.1	83	133	16	-	-	▲
NDPGH505152D	15.2	83	133	16	-	-	▲
NDPGH505153D	15.3	83	133	16	-	-	▲
NDPGH505154D	15.4	83	133	16	-	-	▲
NDPGH50515478D	15.478	83	133	16	-	-	▲
NDPGH505155D	15.5	83	133	16	M18x2.5	WH1-4	▲
NDPGH505156D	15.6	83	133	16	M18x2.5	WH5-6	▲

▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

Applicable Work Materials

○ : Good ◎ : Excellent

P			H		M	K	N
Carbon Steel - HB225	Alloy Steel HB225-325	Prehardened Steel HRc30-50	Hardened Steel		Stainless	Cast Iron	Non-ferrous & Aluminum
			SKD61 -HRc55	SKD11 HRc55-			
◎	◎	◎	○		◎	○	○

NDPGH505

General purpose Internal coolant Drill

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH505157D	15.7	83	133	16	-	-	▲
NDPGH505158D	15.8	83	133	16	-	-	▲
NDPGH50515875D	15.875	83	133	16	-	-	▲
NDPGH505159D	15.9	83	133	16	-	-	▲
NDPGH505160D	16.0	83	133	16	-	-	▲
NDPGH50516272D	16.272	93	143	18	-	-	▲
NDPGH505165D	16.5	93	143	18	M18x1.5	WH1-6	▲
NDPGH50516669D	16.669	93	143	18	-	-	▲
NDPGH505170D	17.0	93	143	18	-	-	▲
NDPGH50517066D	17.066	93	143	18	-	-	▲
NDPGH50517463D	17.463	93	143	18	-	-	▲
NDPGH505175D	17.5	93	143	18	M20x2.5	WH1-6	▲

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH50517859D	17.859	93	143	18	-	-	▲
NDPGH505180D	18.0	93	143	18	-	-	▲
NDPGH50518256D	18.256	101	153	20	-	-	▲
NDPGH505185D	18.5	101	153	20	M20x1.5	WH1-6	▲
NDPGH50518654D	18.654	101	153	20	-	-	▲
NDPGH505190D	19.0	101	153	20	-	-	▲
NDPGH5051905D	19.050	101	153	20	-	-	▲
NDPGH5051925D	19.25	101	153	20	-	-	▲
NDPGH50519447D	19.447	101	153	20	-	-	▲
NDPGH505195D	19.5	101	153	20	M22x2.5	WH1-6	▲
NDPGH50519844D	19.844	101	153	20	-	-	▲
NDPGH505200D	20.0	101	153	20	-	-	▲

▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

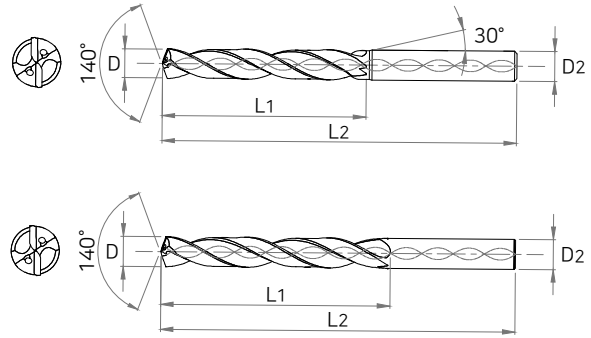
Applicable Work Materials

○ : Good ◎ : Excellent

P			H		M	K	N
Carbon Steel - HB225	Alloy Steel HB225-325	Prehardened Steel HRc30-50	Hardened Steel		Stainless	Cast Iron	Non-ferrous & Aluminum
			SKD61 -HRc55	SKD11 HRc55-			
◎	◎	◎	○		◎	○	○

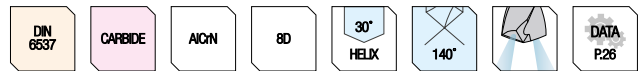
NDPGH508

General purpose Internal coolant Drill



Tolerance

Cutting Dia (mm)		Shank Dia h6
- D3	+0.002-+0.012	
D3.1-D6	+0.004-+0.016	
D6.1-D10	+0.006-+0.021	
D10.1-D18	+0.007-+0.025	
D18.1-D20	+0.008-+0.029	



Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH508030D	3.0	31	74	6	-	-	▲
NDPGH508031D	3.1	36	81	6	-	-	▲
NDPGH50803175D	3.175	36	81	6	-	-	▲
NDPGH508032D	3.2	36	81	6	-	-	▲
NDPGH508033D	3.3	36	81	6	M4x0.7	WH1-4	▲
NDPGH508034D	3.4	36	81	6	M4x0.7	WH 5-6	▲
NDPGH508035D	3.5	36	81	6	-	-	▲
NDPGH50803572D	3.572	41	86	6	-	-	▲
NDPGH508036D	3.6	41	86	6	-	-	▲
NDPGH508037D	3.7	41	86	6	-	-	▲
NDPGH508038D	3.8	41	86	6	-	-	▲
NDPGH508039D	3.9	41	86	6	-	-	▲
NDPGH50803969D	3.969	41	86	6	-	-	▲
NDPGH508040D	4.0	41	86	6	-	-	▲
NDPGH50804039D	4.039	46	91	6	-	-	▲
NDPGH508041D	4.1	46	91	6	-	-	▲
NDPGH508042D	4.2	46	91	6	M5x0.8	WH1-4	▲
NDPGH508043D	4.3	46	91	6	M5x0.8	WH5-6	▲
NDPGH50804366D	4.366	46	91	6	-	-	▲
NDPGH508044D	4.4	46	91	6	-	-	▲
NDPGH508045D	4.5	46	91	6	-	-	▲
NDPGH508046D	4.6	51	96	6	-	-	▲
NDPGH508047D	4.7	51	96	6	-	-	▲
NDPGH50804763D	4.763	51	96	6	-	-	▲
NDPGH508048D	4.8	51	96	6	-	-	▲
NDPGH508049D	4.9	51	96	6	-	-	▲
NDPGH508050D	5.0	51	96	6	M6x1.0	WH1-4	▲
NDPGH508051D	5.1	57	102	6	M6x1.0	WH5-6	▲
NDPGH50805159D	5.159	57	102	6	-	-	▲
NDPGH508052D	5.2	57	102	6	-	-	▲
NDPGH508053D	5.3	57	102	6	-	-	▲

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH508054D	5.4	57	102	6	-	-	▲
NDPGH508055D	5.5	57	102	6	-	-	▲
NDPGH50805556D	5.558	62	107	6	-	-	▲
NDPGH508056D	5.6	62	107	6	-	-	▲
NDPGH508057D	5.7	62	107	6	-	-	▲
NDPGH508058D	5.8	62	107	6	-	-	▲
NDPGH508059D	5.9	62	107	6	-	-	▲
NDPGH50805953D	5.953	62	107	6	-	-	▲
NDPGH508060D	6.0	62	107	6	-	-	▲
NDPGH508061D	6.1	71	116	8	-	-	▲
NDPGH508062D	6.2	71	116	8	-	-	▲
NDPGH508063D	6.3	71	116	8	-	-	▲
NDPGH5080635D	6.35	71	116	8	-	-	▲
NDPGH508064D	6.4	71	116	8	-	-	▲
NDPGH508065D	6.5	71	116	8	-	-	▲
NDPGH50806528D	6.528	71	116	8	-	-	▲
NDPGH508066D	6.6	71	116	8	-	-	▲
NDPGH508067D	6.7	71	116	8	-	-	▲
NDPGH50806747D	6.747	71	116	8	-	-	▲
NDPGH508068D	6.8	71	116	8	M8x1.25	WH1-4	▲
NDPGH508069D	6.9	71	116	8	M8x1.25	WH5-6	▲
NDPGH508070D	7.0	71	116	8	M8x1.0	WH1-4	▲
NDPGH508071D	7.1	81	126	8	M8x1.0	WH5-6	▲
NDPGH50807144D	7.144	81	126	8	-	-	▲
NDPGH508072D	7.2	81	126	8	-	-	▲
NDPGH508073D	7.3	81	126	8	-	-	▲
NDPGH508074D	7.4	81	126	8	-	-	▲
NDPGH508075D	7.5	81	126	8	-	-	▲
NDPGH50807541D	7.541	81	126	8	-	-	▲
NDPGH508076D	7.6	81	126	8	-	-	▲
NDPGH508077D	7.7	81	126	8	-	-	▲

▲: Stock item Europe ●: Stock item Korea ○: Production on demand

Applicable Work Materials

○: Good ◎: Excellent

P			H		M	K	N
Carbon Steel - HB225	Alloy Steel HB225-325	Prehardened Steel HRc30-50	Hardened Steel		Stainless	Cast Iron	Non-ferrous & Aluminum
			SKD61 -HRc55	SKD11 HRc55-			
◎	◎	◎	○		◎	○	○

NDPGH508

General purpose Internal coolant Drill

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH508078D	7.8	81	126	8	-	-	▲
NDPGH508079D	7.9	81	126	8	-	-	▲
NDPGH50807938D	7.938	81	126	8	-	-	▲
NDPGH508080D	8.0	81	126	8	-	-	▲
NDPGH508081D	8.1	92	137	10	-	-	▲
NDPGH508082D	8.2	92	137	10	-	-	▲
NDPGH508083D	8.3	92	137	10	-	-	▲
NDPGH50808334D	8.334	92	137	10	-	-	▲
NDPGH508084D	8.4	92	137	10	-	-	▲
NDPGH50808433D	8.433	92	137	10	-	-	▲
NDPGH508085D	8.5	92	137	10	M10x1.5	WH1-4	▲
NDPGH508086D	8.6	92	137	10	M10x1.5	WH5-6	▲
NDPGH508087D	8.7	92	137	10	-	-	▲
NDPGH50808731D	8.731	92	137	10	-	-	▲
NDPGH508088D	8.8	92	137	10	M10x1.25	WH1-4	▲
NDPGH508089D	8.9	92	137	10	M10x1.25	WH5-6	▲
NDPGH508090D	9.0	92	137	10	M10x1.0	WH1-4	▲
NDPGH508091D	9.1	102	147	10	M10x1.0	WH5-6	▲
NDPGH50809128D	9.128	102	147	10	-	-	▲
NDPGH508092D	9.2	102	147	10	-	-	▲
NDPGH508093D	9.3	102	147	10	-	-	▲
NDPGH50809347D	9.347	102	147	10	-	-	▲
NDPGH508094D	9.4	102	147	10	-	-	▲
NDPGH508095D	9.5	102	147	10	-	-	▲
NDPGH50809525D	9.525	102	147	10	-	-	▲
NDPGH508096D	9.6	102	147	10	-	-	▲
NDPGH508097D	9.7	102	147	10	-	-	▲
NDPGH508098D	9.8	102	147	10	-	-	▲
NDPGH508099D	9.9	102	147	10	-	-	▲
NDPGH50809922D	9.922	102	147	10	-	-	▲
NDPGH508100D	10.0	102	147	10	-	-	▲
NDPGH508101D	10.1	113	158	12	-	-	▲
NDPGH508102D	10.2	113	158	12	-	-	▲
NDPGH508103D	10.3	113	158	12	M12x1.75	WH1-2	▲
NDPGH50810319D	10.319	113	158	12	M12x1.75	WH3-4	▲
NDPGH508104D	10.4	113	158	12	M12x1.75	WH5-6	▲
NDPGH508105D	10.5	113	158	12	M12x1.5	WH1-4	▲
NDPGH508106D	10.6	113	158	12	M12x1.5	WH5-6	▲
NDPGH508107D	10.7	113	158	12	-	-	▲
NDPGH50810716D	10.716	113	158	12	-	-	▲
NDPGH508108D	10.8	113	158	12	M12x1.25	WH1-4	▲
NDPGH508109D	10.9	113	158	12	M12x1.25	WH5-6	▲
NDPGH508110D	11.0	113	158	12	M12x1.0	WH1-4	▲
NDPGH508111D	11.1	123	168	12	M12x1.0	WH5-6	▲
NDPGH50811113D	11.113	123	168	12	-	-	▲
NDPGH508112D	11.2	123	168	12	-	-	▲
NDPGH508113D	11.3	123	168	12	-	-	▲
NDPGH508114D	11.4	123	168	12	-	-	▲
NDPGH508115D	11.5	123	168	12	-	-	▲

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH50811509D	11.509	123	168	12	-	-	▲
NDPGH508116D	11.6	123	168	12	-	-	▲
NDPGH508117D	11.7	123	168	12	-	-	▲
NDPGH508118D	11.8	123	168	12	-	-	▲
NDPGH508119D	11.9	123	168	12	-	-	▲
NDPGH50811906D	11.906	123	168	12	-	-	▲
NDPGH508120D	12.0	123	168	12	M14x2.0	WH1-4	▲
NDPGH508121D	12.1	134	179	14	M14x2.0	WH5-6	▲
NDPGH508122D	12.2	134	179	14	-	-	▲
NDPGH508123D	12.3	134	179	14	-	-	▲
NDPGH50812303D	12.303	134	179	14	-	-	▲
NDPGH508124D	12.4	134	179	14	-	-	▲
NDPGH508125D	12.5	134	179	14	M14x1.5	WH1-4	▲
NDPGH508126D	12.6	134	179	14	M14x1.5	WH5-6	▲
NDPGH508127D	12.7	134	179	14	-	-	▲
NDPGH508128D	12.8	134	179	14	-	-	▲
NDPGH508129D	12.9	134	179	14	-	-	▲
NDPGH508130D	13.0	134	179	14	-	-	▲
NDPGH508131D	13.1	144	189	14	-	-	▲
NDPGH508132D	13.2	144	189	14	-	-	▲
NDPGH508133D	13.3	144	189	14	-	-	▲
NDPGH508134D	13.4	144	189	14	-	-	▲
NDPGH508135D	13.5	144	189	14	-	-	▲
NDPGH508136D	13.6	144	189	14	-	-	▲
NDPGH508137D	13.7	144	189	14	-	-	▲
NDPGH508138D	13.8	144	189	14	-	-	▲
NDPGH50813891D	13.891	144	189	14	-	-	▲
NDPGH508139D	13.9	144	189	14	-	-	▲
NDPGH508140D	14.0	144	189	14	M16x2.0	WH1-4	▲
NDPGH508141D	14.1	155	200	16	M16x2.0	WH5-6	▲
NDPGH508142D	14.2	155	200	16	-	-	▲
NDPGH50814288D	14.288	155	200	16	-	-	▲
NDPGH508143D	14.3	155	200	16	-	-	▲
NDPGH508144D	14.4	155	200	16	-	-	▲
NDPGH508145D	14.5	155	200	16	M16x1.5	WH1-4	▲
NDPGH508146D	14.6	155	200	16	M16x1.5	WH5-6	▲
NDPGH50814684D	14.684	155	200	16	-	-	▲
NDPGH508147D	14.7	155	200	16	-	-	▲
NDPGH508148D	14.8	155	200	16	-	-	▲
NDPGH508149D	14.9	155	200	16	-	-	▲
NDPGH508150D	15.0	155	200	16	-	-	▲
NDPGH50815081D	15.081	165	210	16	-	-	▲
NDPGH508151D	15.1	165	210	16	-	-	▲
NDPGH508152D	15.2	165	210	16	-	-	▲
NDPGH508153D	15.3	165	210	16	-	-	▲
NDPGH508154D	15.4	165	210	16	-	-	▲
NDPGH50815478D	15.478	165	210	16	-	-	▲
NDPGH508155D	15.5	165	210	16	M18x2.5	WH1-4	▲
NDPGH508156D	15.6	165	210	16	M18x2.5	WH5-6	▲

▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

Applicable Work Materials

○ : Good ◎ : Excellent

P			H		M	K	N
Carbon Steel - HB225	Alloy Steel HB225-325	Prehardened Steel HRc30-50	Hardened Steel		Stainless	Cast Iron	Non-ferrous & Aluminum
			SKD61 -HRc55	SKD11 HRc55-			
◎	◎	◎	○		◎	○	○

NDPGH508

General purpose Internal coolant Drill

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH508157D	15.7	165	210	16	-	-	▲
NDPGH508158D	15.8	165	210	16	-	-	▲
NDPGH50815875D	15.875	165	210	16	-	-	▲

Designation	SIZES (mm)				Applicable Tap		Stock
	D	L1	L2	D2	Size	Limit	
NDPGH508159D	15.9	165	210	16	-	-	▲
NDPGH508160D	16.0	165	210	16	-	-	▲

▲ : Stock item Europe ● : Stock item Korea ○ : Production on demand

Applicable Work Materials

○ : Good ◎ : Excellent

P			H		M	K	N
Carbon Steel - HB225	Alloy Steel HB225-325	Prehardened Steel HRc30-50	Hardened Steel		Stainless	Cast Iron	Non-ferrous & Aluminum
			SKD61 -HRc55	SKD11 HRc55-			
◎	◎	◎	○		◎	○	○

Recommended cutting conditions

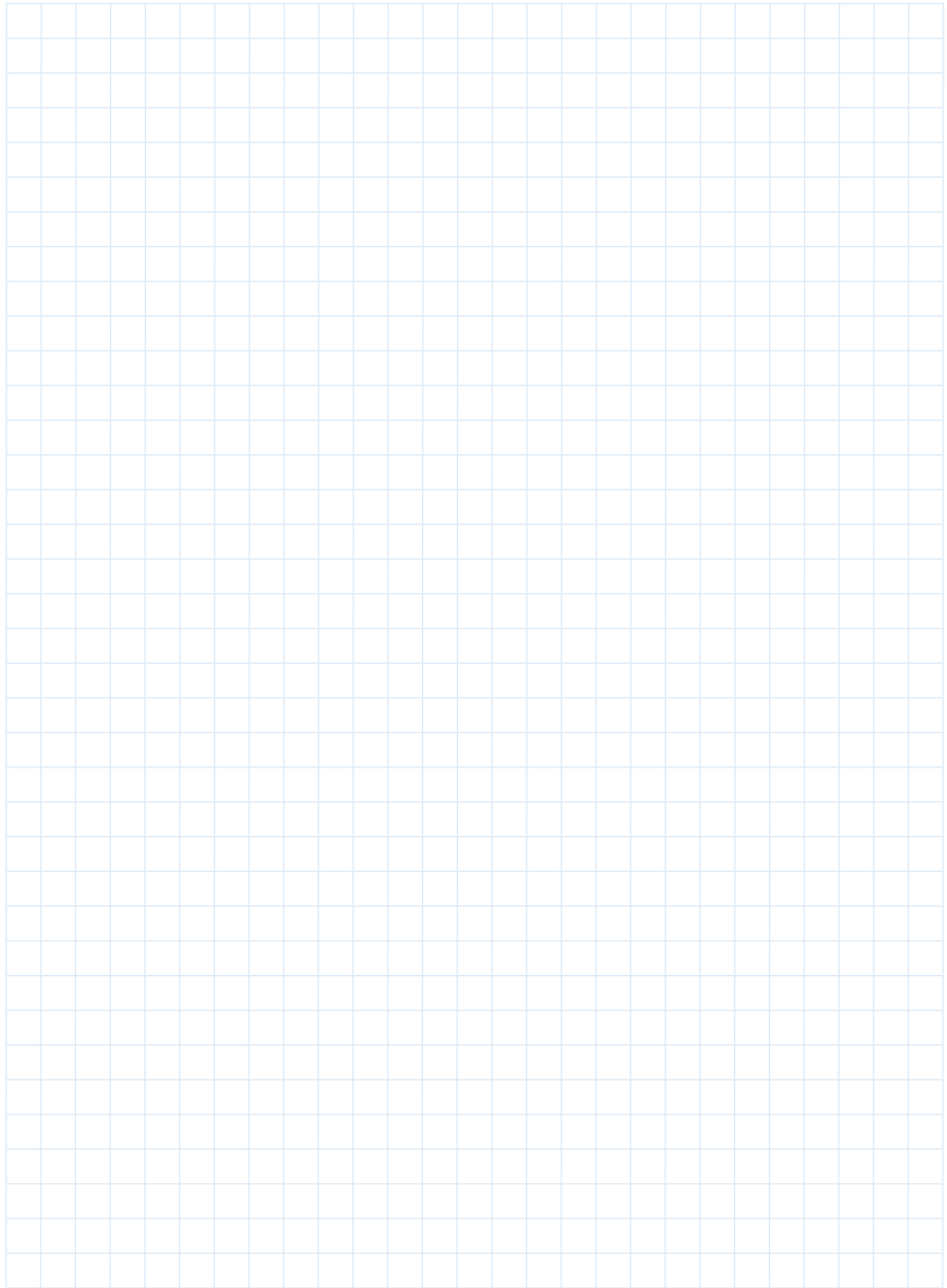
NDPGH 503, 505, 508 SERIES ► Internal Coolant

Work Material	P						K				M		N	
	Carbon Steels, Alloy Steels -900N/mm ² / -HRC28		Alloy Steels -1,100N/mm ² HRC28-35		Alloy Steels, Hardened Steels -HRC40		Cast Iron -350N/mm ²		Ductile Iron 400-600N/mm ²		Stainless Steels		Aluminum Alloy Non-Ferrous Materials	
Drill Diameter	RPM	fn (mm/rev)	RPM	fn (mm/rev)	RPM	fn (mm/rev)	RPM	fn (mm/rev)	RPM	fn (mm/rev)	RPM	fn (mm/rev)	RPM	fn (mm/rev)
3	10,600	0.09	8,000	0.09	4,800	0.08	10,600	0.09	8,500	0.09	5,800	0.09	19,100	0.007
4	8,000	0.14	6,000	0.14	3,600	0.10	8,000	0.14	6,400	0.14	4,400	0.14	14,320	0.01
6	5,300	0.17	4,000	0.17	2,400	0.14	5,300	0.17	4,200	0.21	2,900	0.17	9,550	0.01
8	4,000	0.21	3,000	0.21	1,800	0.18	4,000	0.21	3,200	0.24	2,200	0.21	7,160	0.011
10	3,200	0.29	2,400	0.29	1,400	0.22	3,200	0.29	2,500	0.26	1,800	0.29	5,730	0.011
12	2,700	0.27	2,000	0.27	1,200	0.24	2,700	0.27	2,100	0.28	1,500	0.27	4,770	0.012
14	2,300	0.29	1,700	0.29	1,000	0.26	2,300	0.29	1,800	0.31	1,300	0.29	4,090	0.013
16	2,000	0.31	1,500	0.31	900	0.29	2,000	0.31	1,600	0.33	1,100	0.31	3,580	0.013
18	1,800	0.33	1,300	0.33	800	0.32	1,800	0.33	1,400	0.35	1,000	0.33	3,180	0.014
20	1,600	0.35	1,200	0.35	700	0.34	1,600	0.35	1,300	0.37	900	0.35	2,860	0.015

In actual machining, the condition should be adjusted according to the machining shape, purpose and machine type.

* 8D: apply 75 % of above cutting condition.

Notes



For the safe metalcutting

- Use safety supplies such as protective gloves to prevent possible injury while touching the edge of tools.
- Use safety glasses or safety cover to hedge possible dangers. Inappropriate usage or excessive cutting condition may lead tool's breakage or even the fragment's scattering.
- Clamp the workpiece tightly enough to prevent its movement while its machining.

Properly manage the tool change phase because the inordinately used tool can be easily broken under the excessive cutting load or severe wear, and it may threaten the operator's safety.

- Use safety cover because chips evacuated during cutting are hot and sharp and may cause burns and cuts. To remove chips safely, stop machining, put on protective gloves, and use a hook or other tools.

- Prepare for fire prevention measures as the use of the non-water soluble cutting oil may cause fire.
- Use safety cover and other safety supplies because the spare parts or the inserts can be pulled out due to centrifugal force while high speed machining.



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