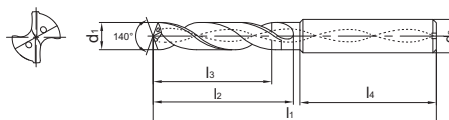


UD drill 5xD**Steel, stainless steel, heat-resistant alloys****1536UD05C**

- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG305
1536UD05C-0300	*	3	6	66	28	23	36	●
1536UD05C-0310	*	3.1	6	66	28	23	36	●
1536UD05C-0320	*	3.2	6	66	28	23	36	○
1536UD05C-0330	*	3.3	6	66	28	23	36	●
1536UD05C-0340	*	3.4	6	66	28	23	36	●
1536UD05C-0350	*	3.5	6	66	28	23	36	●
1536UD05C-0360	*	3.6	6	66	28	23	36	○
1536UD05C-0370	*	3.7	6	66	28	23	36	●
1536UD05C-0380	*	3.8	6	74	36	29	36	●
1536UD05C-0390	*	3.9	6	74	36	29	36	○
1536UD05C-0400	*	4	6	74	36	29	36	●
1536UD05C-0410	*	4.1	6	74	36	29	36	○
1536UD05C-0420	*	4.2	6	74	36	29	36	●
1536UD05C-0430	*	4.3	6	74	36	29	36	○
1536UD05C-0440	*	4.4	6	74	36	29	36	○
1536UD05C-0450	*	4.5	6	74	36	29	36	●
1536UD05C-0460	*	4.6	6	74	36	29	36	○
1536UD05C-0465	*	4.65	6	74	36	29	36	●
1536UD05C-0470	*	4.7	6	74	36	29	36	○
1536UD05C-0480	*	4.8	6	82	44	35	36	○
1536UD05C-0490	*	4.9	6	82	44	35	36	○
1536UD05C-0500	*	5	6	82	44	35	36	●
1536UD05C-0510	*	5.1	6	82	44	35	36	●
1536UD05C-0520	*	5.2	6	82	44	35	36	●
1536UD05C-0530	*	5.3	6	82	44	35	36	○
1536UD05C-0540	*	5.4	6	82	44	35	36	○
1536UD05C-0550	*	5.5	6	82	44	35	36	●
1536UD05C-0560	*	5.6	6	82	44	35	36	○
1536UD05C-0570	*	5.7	6	82	44	35	36	○
1536UD05C-0580	*	5.8	6	82	44	35	36	●
1536UD05C-0590	*	5.9	6	82	44	35	36	○
1536UD05C-0600	*	6	6	82	44	35	36	●
1536UD05C-0610	*	6.1	8	91	53	43	36	○
1536UD05C-0620	*	6.2	8	91	53	43	36	○
1536UD05C-0630	*	6.3	8	91	53	43	36	○
1536UD05C-0640	*	6.4	8	91	53	43	36	○
1536UD05C-0650	*	6.5	8	91	53	43	36	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓			✓	

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

Nonstandard order > C150

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UD drill 5xD

Steel, stainless steel, heat-resistant alloys

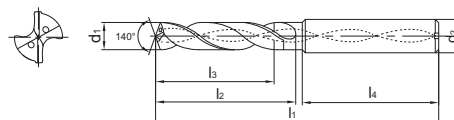
1536UD05C



- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG305
1536UD05C-0660	*	6.6	8	91	53	43	36	○
1536UD05C-0670	*	6.7	8	91	53	43	36	●
1536UD05C-0680	*	6.8	8	91	53	43	36	●
1536UD05C-0690	*	6.9	8	91	53	43	36	○
1536UD05C-0700	*	7	8	91	53	43	36	●
1536UD05C-0710	*	7.1	8	91	53	43	36	○
1536UD05C-0720	*	7.2	8	91	53	43	36	○
1536UD05C-0730	*	7.3	8	91	53	43	36	○
1536UD05C-0740	*	7.4	8	91	53	43	36	●
1536UD05C-0750	*	7.5	8	91	53	43	36	●
1536UD05C-0760	*	7.6	8	91	53	43	36	○
1536UD05C-0770	*	7.7	8	91	53	43	36	○
1536UD05C-0780	*	7.8	8	91	53	43	36	○
1536UD05C-0790	*	7.9	8	91	53	43	36	○
1536UD05C-0800	*	8	8	91	53	43	36	●
1536UD05C-0810	*	8.1	10	103	61	49	40	○
1536UD05C-0820	*	8.2	10	103	61	49	40	○
1536UD05C-0830	*	8.3	10	103	61	49	40	●
1536UD05C-0840	*	8.4	10	103	61	49	40	●
1536UD05C-0850	*	8.5	10	103	61	49	40	●
1536UD05C-0860	*	8.6	10	103	61	49	40	○
1536UD05C-0870	*	8.7	10	103	61	49	40	○
1536UD05C-0880	*	8.8	10	103	61	49	40	○
1536UD05C-0890	*	8.9	10	103	61	49	40	○
1536UD05C-0900	*	9	10	103	61	49	40	●
1536UD05C-0910	*	9.1	10	103	61	49	40	○
1536UD05C-0920	*	9.2	10	103	61	49	40	○
1536UD05C-0930	*	9.3	10	103	61	49	40	●
1536UD05C-0940	*	9.4	10	103	61	49	40	○
1536UD05C-0950	*	9.5	10	103	61	49	40	●
1536UD05C-0960	*	9.6	10	103	61	49	40	○
1536UD05C-0970	*	9.7	10	103	61	49	40	○
1536UD05C-0980	*	9.8	10	103	61	49	40	○
1536UD05C-0990	*	9.9	10	103	61	49	40	○
1536UD05C-1000	*	10	10	103	61	49	40	●
1536UD05C-1020	*	10.2	12	118	71	56	45	●
1536UD05C-1050	*	10.5	12	118	71	56	45	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓			✓	

✓ Very suitable

✓ Suitable

System code > C44

Machining instructions > C201

Cutting data > C144

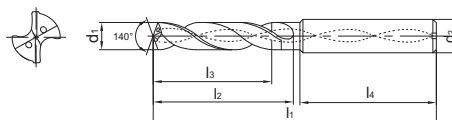
Nonstandard order > C150

UD drill 5xD**Steel, stainless steel, heat-resistant alloys****1536UD05C**

- Type of shank DIN 6535HA
- Coolant exit, axial concentric



External coolant



Article	*	Dimensions [mm]						Grade
		d ₁ (m7)	d ₂ (h6)	l ₁	l ₂	l ₃	l ₄	KDG305
1536UD05C-1100	*	11	12	118	71	56	45	●
1536UD05C-1150	*	11.5	12	118	71	56	45	●
1536UD05C-1200	*	12	12	118	71	56	45	●
1536UD05C-1250	*	12.5	14	124	77	60	45	●
1536UD05C-1300	*	13	14	124	77	60	45	●
1536UD05C-1350	*	13.5	14	124	77	60	45	●
1536UD05C-1400	*	14	14	124	77	60	45	●
1536UD05C-1450	*	14.5	16	133	83	63	48	●
1536UD05C-1500	*	15	16	133	83	63	48	●
1536UD05C-1550	*	15.5	16	133	83	63	48	●
1536UD05C-1600	*	16	16	133	83	63	48	●
1536UD05C-1650	*	16.5	18	143	93	71	48	●
1536UD05C-1700	*	17	18	143	93	71	48	●
1536UD05C-1750	*	17.5	18	143	93	71	48	●
1536UD05C-1800	*	18	18	143	93	71	48	●
1536UD05C-1850	*	18.5	20	153	101	77	50	●
1536UD05C-1900	*	19	20	153	101	77	50	●
1536UD05C-1950	*	19.5	20	153	101	77	50	●
1536UD05C-2000	*	20	20	153	101	77	50	●

● Ex stock ○ On demand

* With internal cooling

Application field

P	M	K	N	S	H
✓	✓			✓	

✓ Very suitable

✓ Suitable

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Type	
Code	Description
1	Forets

1

Shank type	
Code	Description
1	Straight shank
2	Square shank DIN 10
3	Double flattened straight shank DIN 1809
5	Straight shank DIN 6535 HA
6	Weldon shank DIN 6535 HB
7	Whistle Notch shank DIN 6535 HE
9	Morse taper shank

2

Drill type	
Code	Description
0	Twist drill
3	Universal twist drill
4	NC tapping device
5	Step drill
6	Three-lips drill
7	Straight flute drill
8	Deep hole drill

3

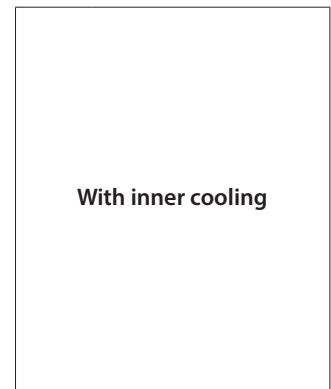
Tool length	
Code	Description
1	DIN 338
2	DIN 1897
3	QJ/ZZQ(TO)01.001.002
4	DIN 6537 K
5	DIN 6539
6	DIN 6537 L
7	Factory standard ZCC-C
8	Factory standard ZCC-D
9	Factory standard ZCC-E

4

Application	
Code	Description
UD	Twist drills for tough materials
GD	Twist drills for high feeds
SU	Twist drill for general machining
SUK	Twist drill for cast iron
SL	Twist drill for deep hole drilling
SLK	Deep hole drill for cast iron
SP	Pilot drill
SH	Twist drill for hardened materials
SC	Twist drill for non-ferrous metals and cast iron
PA	Three-lips drill for non-ferrous metals and cast iron
PC	Straight flute drill for non-ferrous metals and cast iron

5

L/D relation		Angle	
Drill		NC tapping device	
Code	Description	Code	Description
03	3 x D	90	90°
05	5 x D	120	120°
08	8 x D		
10	10 x D		
12	12 x D		
15	15 x D		
20	20 x D		
30	30 x D		

6


With inner cooling

7

Bore diameter [mm]	
Code	Description
0200	2,0
0850	8,5
1800	18,0
...	

8

Shank diameter [mm]	
Code	Description
S	4,0

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A

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a Boring



b Drilling



c Profile drilling



d Centering

A

Turning

Coated cemented carbide PVD

Grade	Grade description
KDG303	PVD coated P10–P20/M10–M20/K10–K20 carbide grade for steel, stainless steel and cast iron. Good wear resistance and toughness for a wide application field.

B

Milling

KDG304	PVD coated carbide substrate for machining caststeel and cast iron. Optimised toughness for high feeds.
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KDG305	PVD coated carbide substrate for machining stainless steel and HRSA. High process reliability due to improved wear resistance.
---------------	--

C

Drilling

Uncoated cemented carbide

Grade	Grade description
YK20F	Uncoated K20 carbide substrate for steel, cast iron and non ferrous materials.

D

Technical
Information

YK30F	Uncoated K30 carbide substrate for steel, stainless steel, cast iron and non ferrous materials.
--------------	---

E

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IMPORTANT INFORMATION

Recommended applications for the **UD series**

Feed calculator

ISO group	Material	Cutting speed v_c (m/min)	Feed factor F_m
M	Stainless steels	80	0,02
S	Ni- / Co-based alloys	40	0,01
S	Titanium alloys	60	0,012

Formula: feed per revolution (F_n) $D \times F_m$
Example: drill diameter (D) 10 mm
material stainless steel

$$F_n = 10 \text{ mm} \times 0,02 = 0,2 \text{ mm/r}$$



Fig.: 1536UD05C