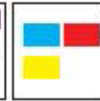
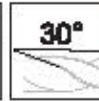
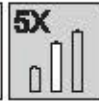


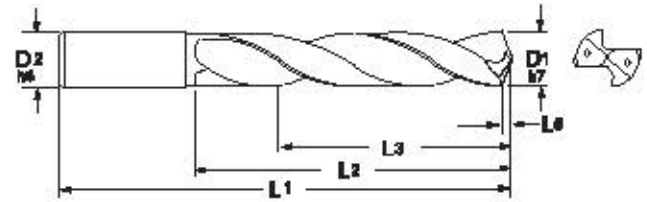
Twister® HPD Series HPDSR & HPDCR



Designed for high performance drilling in a broad range of materials.



- Self centering point that eliminates the need for spot drilling.
- 45° corner chamfer angle helps material break out on through hole applications and minimizes burrs.
- h7 OD tolerance for precision holes.
- ALtima® Coating provides high toughness with low friction.
- 5X Diameter with solid and coolant through options.
- 4.1mm-16.0mm manufactured to DIN 6537L.



- h6 Shank OD Tolerance for shrink fit applications.
- Material Applications: Carbon Steels, Austenitic Stainless Steels and Titanium.
- An economical choice perfect for job shop and batch production work requiring a high performance drill option.

ALtima®				Diameter		Shank	OAL	Flute Length	Drill Length	Point Length
HPDSR		HPDCR		D1 (h7)		D2 (h6)	L1	L2	L3	L5
Tool No.	EDP	Tool No.	EDP	mm	Decimal	mm	mm	mm	mm	mm
HPDSR 0300A	21840	HPDCR 0300A	21700	3.0	.1181	3	66	28	23	0.46
HPDSR1200A	21972	HPDCR 1200A	21628	3.05	.1200	4	66	28	23	0.47
HPDSR 0310A	21841	HPDCR 0310A	21701	3.1	.1220	4	66	28	23	0.48
HPDSR1250A	21973	HPDCR 1250A	21629	3.18	.1250	4	66	28	23	0.49
HPDSR 0320A	21842	HPDCR 0320A	21702	3.2	.1260	4	66	28	23	0.49
HPDSR1285A	21974	HPDCR 1285A	21630	3.26	.1285	4	66	28	23	0.50
HPDSR 0330A	21843	HPDCR 0330A	21703	3.3	.1299	4	66	28	23	0.51
HPDSR 0340A	21844	HPDCR 0340A	21704	3.4	.1339	4	66	28	23	0.52
HPDSR1360A	21975	HPDCR 1360A	21631	3.45	.1360	4	66	28	23	0.53
HPDSR 0350A	21845	HPDCR 0350A	21705	3.5	.1378	4	66	28	23	0.54
HPDSR 0360A	21846	HPDCR 0360A	21706	3.6	.1417	4	66	28	23	0.55
HPDSR 0370A	21847	HPDCR 0370A	21707	3.7	.1457	4	66	28	23	0.57
HPDSR 0380A	21848	HPDCR 0380A	21708	3.8	.1496	4	74	36	29	0.58
HPDSR 0390A	21849	HPDCR 0390A	21709	3.9	.1535	4	74	36	29	0.60
HPD SR1562A	21976	HPDCR1562A	21632	3.97	.1562	4	74	36	29	0.61
HPDSR 0400A	21850	HPDCR 0400A	21710	4.0	.1575	4	74	36	29	0.61
HPD SR1590A	21977	HPDCR1590A	21633	4.04	.1590	6	74	36	29	0.62
HPDSR 0410A	21851	HPDCR 0410A	21711	4.1	.1614	6	74	36	29	0.64
HPDSR 0420A	21852	HPDCR 0420A	21712	4.2	.1654	6	74	36	29	0.64
HPDSR 0430A	21853	HPDCR 0430A	21713	4.3	.1693	6	74	36	29	0.66
HPDSR 0440A	21854	HPDCR 0440A	21714	4.4	.1732	6	74	36	29	0.67
HPDSR 0460A	21855	HPDCR 0460A	21715	4.5	.1772	6	74	36	29	0.69
HPDSR 0460A	21856	HPDCR 0460A	21716	4.6	.1811	6	74	36	29	0.71
HPDSR 0470A	21857	HPDCR 0470A	21717	4.7	.1850	6	74	36	29	0.72

Corner Chamfer Width		
D1	Width Inch	Width mm
3.0 - 4.0	.003 - .007	.076 - .178
4.1 - 6.0	.005 - .009	.127 - .229
6.1 - 8.0	.007 - .012	.178 - .305
8.1 - 10.0	.009 - .015	.229 - .381
10.1 - 12.0	.012 - .018	.305 - .457
12.1 - 16.0	.014 - .020	.355 - .508

Inch	
D1	Tolerance (h7)
.0000 - .1181	+0/- .00039
.1182 - .2362	+0/- .00047
.2363 - .3937	+0/- .00059
.3938 - .6250	+0/- .00071

Inch	
D2	Tolerance (h6)
.0000 - .1181	+0/- .00024
.1182 - .2362	+0/- .00031
.2363 - .3937	+0/- .00035
.3938 - .6250	+0/- .00043

Metric (mm)	
D1	Tolerance (h7)
0 - 3	+0/- .010
3.01 - 6	+0/- .012
6.01 - 10.0	+0/- .015
10.01 - 16.0	+0/- .018

Metric (mm)	
D2	Tolerance (h6)
0 - 3	+0/- .006
3.01 - 6	+0/- .008
6.01 - 10.0	+0/- .009
10.01 - 16.0	+0/- .011

