













Solid Carbide Drills

Tool Selection Guide



solid carbide drills for external coolant or dry machining		series	grade	standard						hole tolerance	standard range		
				● first choice ○ alternate choice							diameter range		drilling depth L/D1
				P	M	K	N	S	H		min-max	min-max	
	VariDrill™ multiple-material drilling	VDS20	WU25PD	●	●	●	●	●	○	IT9-IT10	1,0-20,0	.0394-.7874	3 x-5 x
	TOP DRILL S™ for steel application-specific drilling	TDS202	WP20PD	●	○	○	○	○	○	IT9-IT10	3,0-20,0	.1181-.7874	5 x D
	TOP DRILL S for cast iron application-specific drilling	TDS212	WK15PD	○	○	●	○	○	○	IT9-IT10	3,0-20,0	.1181-.7874	5 x D
	TOP DRILL S+™ multiple-application drilling	TDS301	WU25PD	●	○	●	○	○	○	IT9-IT10	3,0-20,0	.1181-.7874	3 x D

solid carbide drills with internal coolant channel		series	grade	standard						hole tolerance	standard range		
				● first choice ○ alternate choice							diameter range		drilling depth L/D1
				P	M	K	N	S	H		min-max	min-max	
	VariDrill multiple-material drilling	VDS40	WU25PD	●	●	●	●	●	○	IT9-IT10	1,0-20,0	.0394-.7874	3 x-8 x
	TOP DRILL S for steel application-specific drilling	TDS40	WP20PD	●	○	○	○	○	○	IT9-IT10	3,0-20,0	.1181-.7874	3 x-8 x
	TOP DRILL S for cast iron application-specific drilling	TDS41	WK15PD	○	○	●	○	○	○	IT9-IT10	3,0-20,0	.1181-.7874	3 x-8 x
	TOP DRILL S+ multiple-application drilling	TDS50	WU25PD	●	○	●	○	○	○	IT9-IT10	3,0-20,0	.1181-.7874	3 x-8 x
	TOP DRILL S+ 12 x D deep-hole drilling without piloting	TDS504	WU20PD	●	●	●	○	○	○	IT9-IT10	3,0-20,0	.1181-.7874	3 x-8 x
	TOP DRILL Deep superior deep-hole drilling	TDD10	WU20PD	●	○	●	○	○	○	IT9-IT10	3,0-20,0	.1181-.5118	15 x- 30 x
	TOP DRILL G™ difficult drilling applications	TDG53	WN10HD	○	○	○	●	○	○	IT8-IT9	3,0-20,0	.1181-.7874	5 x-12 x
	TOP DRILL Flat-Bottom for flat-bottom applications	TDF51	WU20PD	●	○	●	○	○	○	IT9-IT10	-	-	-
			WN15HD	○	○	○	●	○	○	IT9-IT10	-	-	-

