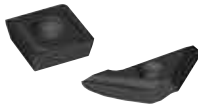


Modular Drills

Tool Selection Guide



modular drills with internal coolant channel	grade/series	standard*						standard range					
		● first choice ○ alternate choice						diameter range					
		P	M	K	N	S	H						
								hole tolerance	D1 mm min-max	D1 inch min-max		drilling depth L/D1	
TOP DRILL M1™ with front clamping mechanism													
	TOP DRILL M1 inserts	WU25PD**	●	○	●				IT9-IT11	7,94-25,99	.3125-1.1023	—	
	chamfering inserts	TopSTEP SH— WP20PH	●	○	○	●	○		—	12,50-36,01	.4921-1.4177	—	
		TopSTEP VG— WP20PH	●	○	○	○	○		—				
	TOP DRILL M1 bodies	—							—	7,94≤Ø<9,50	.3125≤Ø<.3740	max 3-8 x D	
										9,50≤Ø<11,00	.3740≤Ø<.4331		
										11,00≤Ø<12,50	.4331≤Ø<.4921		
										12,50≤Ø<14,00	.4921≤Ø<.5512		
										14,00≤Ø<15,50	.5512≤Ø<.6102		
										15,50≤Ø<16,50	.6102≤Ø<.6496		
										16,50≤Ø<20,50	.6496≤Ø<.8071		
										20,50≤Ø<21,00	.8071≤Ø<.8268		
										21,00≤Ø<25,99	.8268≤Ø<1.023		

* Apart from our standard drills, we can offer you a wide variety of special coating solutions and edge preparations to fulfill all your needs.
If a specific drill is not suitable for your workpiece material, please contact your WIDIA™ distributor for available options.

** Grade WU25PD™ was previously named K20FTIAIN.