

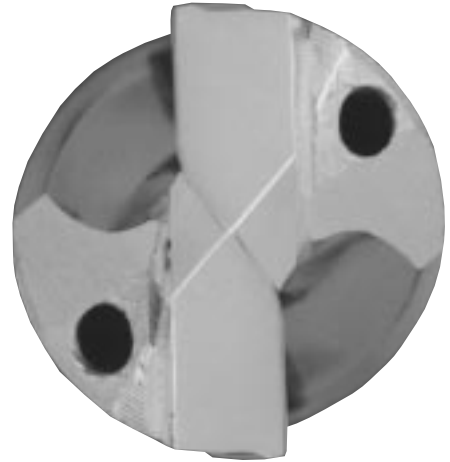
BRS TYPE DRILL

- For drilling of stainless steel and mild steel.
- BRS type drill with high rake cutting edge is recommended for high efficiency drilling.
- Regrindable drill.



FEATURES OF **BRS TYPE DRILL**

- **BRS** TYPE DRILL has high rake cutting edge.
(helix angle 30°)
- **BRS** TYPE DRILL is recommended for drilling stainless steel and mild steel.
- **BRS** TYPE DRILL increases productivity of 5 times over to H.S.S. when drilling stainless steel.
- **BRS** TYPE DRILL with coating layers consisting of titanium compound increases tool life ten times.



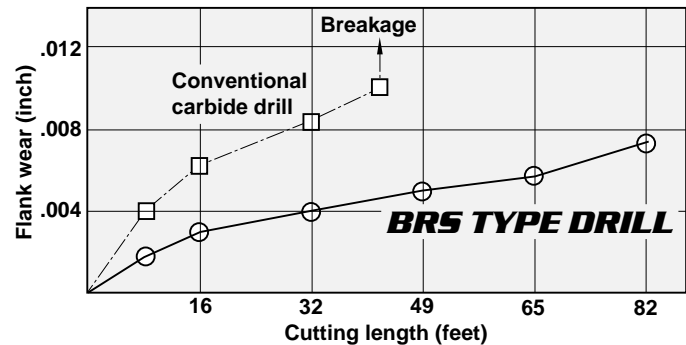
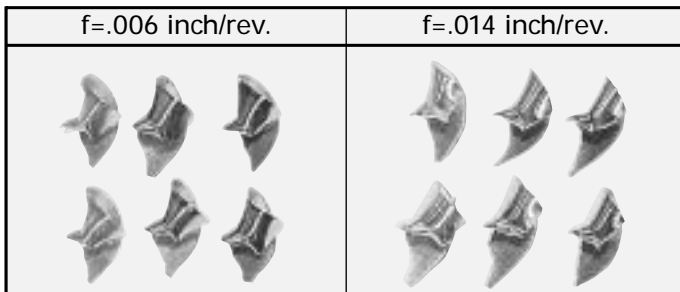
CUTTING PERFORMANCE OF **BRS TYPE DRILL**

1. Chip Control

Work Material : stainless steel (304)
Cutting speed : V=260 feet/min.
Drill : BRS2000S25

2. Cutting performance

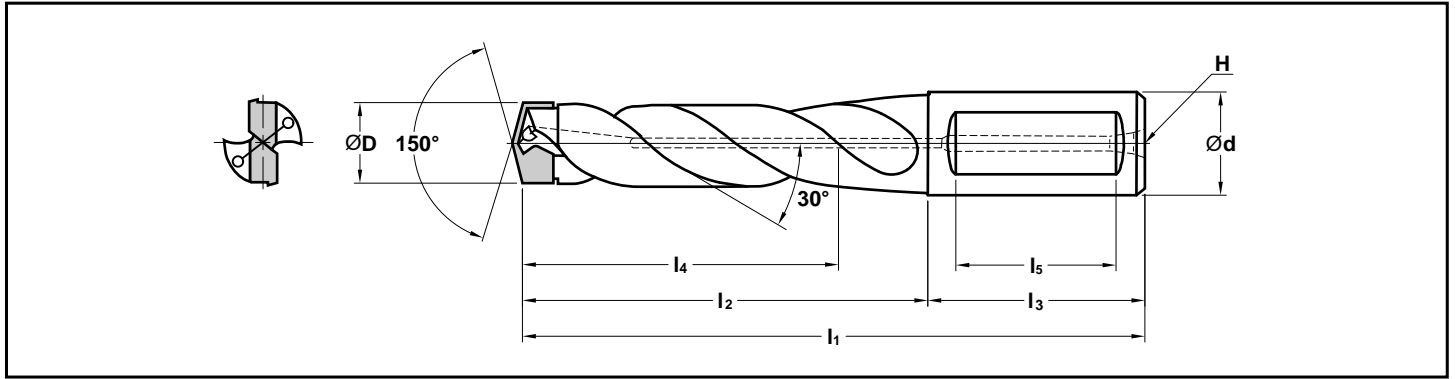
Work Material : stainless steel
Cutting speed : V=200 feet/min.
Drill : BRS2000S25 (L/D=3)
Hole depth : 2.36 inch/rev.
Feed rate : f=.010 inch/rev.



RECOMMENDED CUTTING CONDITIONS OF **BRS TYPE DRILL**

Work Material	Drill diameter	1.2-25/32		51/64-1-3/16	
	Cutting conditions	Cutting speed	Feed rate	Cutting speed	Feed rate
		(feet/min.)	(inch/rev.)	(feet/min.)	(inch/rev.)
	Hardness (HB)				
Structural steel	80-140	160-260-300	.008-.012-.016	180-260-310	.010-.014-.018
Carbon steel	Under 230	150-200-230	.008-.012-.016	150-210-260	.008-.014-.018
	230-300	130-180-210	.006-.010-.014	130-200-250	.006-.012-.016
Alloy steel	Under 230	150-180-210	.006-.010-.012	150-200-230	.006-.012-.016
	230-300	130-160-200	.006-.008-.012	130-180-210	.006-.010-.014
Stainless steel	—	160-230-300	.006-.010-.014	200-260-330	.008-.012-.016

BRS TYPE DRILL



Order Number	Stock	Drill Diameter (D)		Dimensions (inch)										
		FRACTION DIA.	DECIMAL DIA.	d	l ₁	l ₂	l ₃	l ₄	l ₅	H				
BRS0032	+	1/2	.500	5/8	4-39/64	2-47/64	1-7/8	2-9/64	1-3/8	1/8 NPT				
BRS0033	+	33/64	.5156					4-13/16			2-15/16	2-19/64		
BRS0034	+	17/32	.5313					5-1/64			3-9/64	2-29/64		
BRS0035	+	35/64	.5469		3/4	5-9/64	3-9/64	2			2-29/64	1-1/2		
BRS0036	+	9/16	.5625								5-21/64		3-21/64	2-39/64
BRS0037	+	37/64	.5781								5-35/64		3-35/64	2-49/64
BRS0038	+	19/32	.5938	5-47/64		3-47/64	2-59/64							
BRS0039	+	39/64	.6094	1		5-63/64	3-47/64	2-1/4	2-59/64		1-3/4			
BRS0040	+	5/8	.6250						6-13/64				3-61/64	3-7/64
BRS0041	+	41/64	.6406		6-25/64				4-9/64			3-17/64		
BRS0042	+	21/32	.6563		6-39/64	4-23/64	3-27/64							
BRS0043	+	43/64	.6719		6-51/64	4-35/64	3-37/64							
BRS0044	+	11/16	.6875		7-1/64	4-49/64	3-47/64							
BRS0045	+	45/64	.7031	1-1/4	7-21/64	4-61/64	3-57/64	1-7/8	1/4 NPT					
BRS0046	+	23/32	.7188							7-35/64	5-11/64	4-3/64		
BRS0047	+	47/64	.7344							7-47/64	5-23/64	4-13/64		
BRS0048	+	3/4	.7500		7-61/64	5-37/64	4-23/64							
BRS0049	+	49/64	.7656		8-9/64	5-49/64	4-33/64							
BRS0050	+	25/32	.7813		8-23/64	5-63/64	4-43/64							
BRS0051	+	51/64	.7969	1	8-9/64	5-49/64	4-33/64	1-3/4		1/8 NPT				
BRS0052	+	13/16	.8125								6-39/64	4-23/64	3-27/64	
BRS0053	+	53/64	.8281								6-51/64	4-35/64	3-37/64	
BRS0054	+	27/32	.8438		7-1/64	4-49/64	3-47/64							
BRS0055	+	55/64	.8594		1-1/4	7-21/64	4-61/64				3-57/64	1-7/8	1/4 NPT	
BRS0056	+	7/8	.8750											7-35/64
BRS0057	+	57/64	.8906	7-47/64				5-23/64	4-13/64					
BRS0058	+	29/32	.9063	7-61/64		5-37/64	4-23/64							
BRS0059	+	59/64	.9219	8-9/64		5-49/64	4-33/64							
BRS0060	+	15/16	.9375	8-23/64		5-63/64	4-43/64							
BRS0061	+	61/64	.9531	1	8-9/64	5-49/64	4-33/64	1-3/4	1/8 NPT					
BRS0062	+	31/32	.9688								6-39/64	4-23/64		3-27/64
BRS0063	+	63/64	.9844							6-51/64	4-35/64	3-37/64		
BRS0100	+	1	1.000		7-1/64	4-49/64	3-47/64							
BRS0101	+	1-1/64	1.0156		1-1/4	7-21/64	4-61/64			3-57/64	1-7/8	1/4 NPT		
BRS0102	+	1-1/31	1.0313											7-35/64
BRS0103	+	1-3/64	1.0469	7-47/64				5-23/64					4-13/64	
BRS0104	+	1-1/16	1.0625	7-61/64		5-37/64	4-23/64							
BRS0105	+	1-5/64	1.0781	8-9/64		5-49/64	4-33/64							
BRS0106	+	1-3/32	1.0938	8-23/64		5-63/64	4-43/64							
BRS0107	+	1-7/64	1.1094	1	8-9/64	5-49/64	4-33/64	1-3/4		1/8 NPT				
BRS0108	+	1-1/8	1.1250								6-39/64		4-23/64	3-27/64
BRS0109	+	1-9/64	1.1406						6-51/64		4-35/64		3-37/64	
BRS0110	+	1-5/32	1.1563		7-1/64	4-49/64	3-47/64							
BRS0111	+	1-11/64	1.1719		1-1/4	7-21/64	4-61/64		3-57/64		1-7/8		1/4 NPT	
BRS0112	+	1-3/16	1.1875											7-35/64

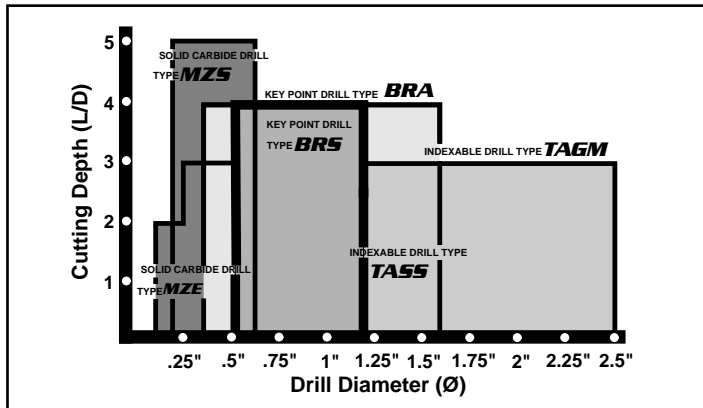
+: Stock

BRS TYPE DRILL

Order Number (metric shank)	Stock	Dimensions (Metric)									
		D	l ₁	l ₂	l ₃	l ₄	Ød	H			
BRS1400S16		14.00	114	66	48	52	16	1/8 NPT			
BRS1450S16		14.50									
BRS1500S20		15.00	126	76	50	61	20				
BRS1550S20		15.50									
BRS1600S20		16.00	131	81		65					
BRS1650S20		16.50									
BRS1700S20		17.00	137	86	69						
BRS1750S20		17.50									
BRS1800S20		18.00	141	91	73						
BRS1850S20		18.50									
BRS1900S25		19.00	157	101	56	77	25				
BRS1950S25		19.50									
BRS2000S25		20.00									
BRS2050S25		20.50									
BRS2100S25		21.00									
BRS2150S25		21.50									
BRS2200S25		22.00	162	106	60	84	32				
BRS2250S25		22.50									
BRS2300S25		23.00									
BRS2350S25		23.50									
BRS2400S32		24.00				171		111	60	87	1/4 NPT
BRS2450S32		24.50									
BRS2500S32		25.00									
BRS2550S32		25.50									
BRS2600S32		26.00	176	116	60	90					
BRS2650S32		26.50									
BRS2700S32		27.00									
BRS2750S32		27.50									
BRS2800S32		28.00	181	121	60	93					
BRS2850S32		28.50									
BRS2900S32		29.00	186	126	60	97					
BRS2950S32		29.50									
BRS3000S32		30.00									

: Non Stock

MITSUBISHI CARBIDE DRILLING SYSTEM



MITSUBISHI MATERIALS U.S.A. CORPORATION

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