



OSAWA

D R I L L S & E N D M I L L S



HF Selection

05 2022

	ITEM No.	PAGE	
HF UNI < 40 HRC, 45° chamfer	HF840	4	
	HF440	4	
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HF UNI < 40 HRC, roughing	HF844	4	
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HF UNI SC < 40 HRC, 45° chamfer + corner radius	HF871	8	
HF HARD 30÷55 HRC, 45° chamfer	HF850	8	
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ALU unequal pitch, square	HFAL4	10	
ALU unequal pitch, corner radius	HFAL3	10	
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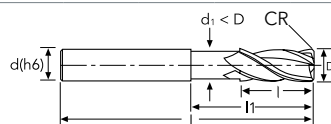
HF842 - catalogue page 401



HF442 - catalogue page 405

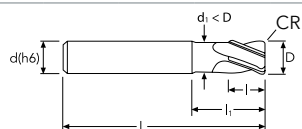


HF443 - catalogue page 410



						HF842					HF442	HF443
P						★					★	★
M						★					★	★
K						★					★	★
N												
S						★					★	★
H												
D	CR	d(h6)	I	L	€	I	l1	d1	L	€	€	
3	0.30	6				9	15	2.80	57	20,43	20,43	
3	0.50	6				9	15	2.80	57	20,43	20,43	
4	0.30	6	11	57	20,43	11	18	3.80	57	20,43	20,43	
4	0.50	6	11	57	20,43	11	18	3.80	57	20,43	20,43	
5	0.30	6	13	57	20,43	13	19	4.80	57	20,43		
5	0.50	6	13	57	20,43	13	19	4.80	57	20,43	20,43	
6	0.30	6	13	57	20,43	13	20	5.80	57	20,43		
6	0.50	6	13	57	20,43	13	20	5.80	57	20,43	20,43	
6	1.00	6	13	57	20,43	13	20	5.80	57	20,43	20,43	
8	0.50	8	20	64	28,96	20	26	7.80	64	28,96	28,96	
8	1.00	8	20	64	28,96	20	26	7.80	64	28,96	28,96	
10	0.50	10	22	72	42,79	22	30	9.80	72	42,79	42,79	
10	1.00	10	22	72	42,79	22	30	9.80	72	42,79	42,79	
12	0.50	12	26	83	55,18	26	36	11.80	83	55,18	55,18	
12	1.00	12	26	83	55,18	26	36	11.80	83	55,18	55,18	
12	2.00	12	26	83	55,18							
12	3.00	12	26	83	55,18							
14	1.00	14	26	83	73,77	26	36	13.70	83	73,77	73,77	
16	1.00	16	32	92	96,18	32	42	15.70	92	96,18	96,18	
16	2.00	16	32	92	96,18	32	42	15.70	92	96,18		
16	3.00	16	32	92	96,18							
18	1.00	18	32	92	134,35							
20	1.00	20	38	104	148,49	38	50	19.70	104	148,49	150,28	
20	2.00	20	38	104	148,49	38	50	19.70	104	148,49		
20	3.00	20	38	104	155,92							

HF342 - catalogue page 398



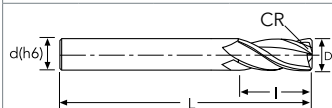
							HF342
P							★
M							★
K							★
N							
S							★
H							
D	CR	d(h6)	I	l1	d1	L	€
3	0.20	6	5	9	2.80	50	17,79
4	0.20	6	6	12	3.80	50	17,79
5	0.20	6	8	14	4.80	50	17,79
6	0.30	6	9	18	5.80	55	17,79
8	0.50	8	12	24	7.80	60	24,12
10	1.00	10	15	30	9.80	70	35,90
12	1.00	12	18	35	11.80	80	45,43



HF942 - catalogue page 418

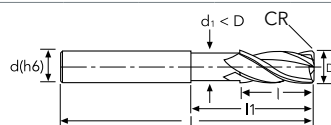


HF943 - catalogue page 422



					HF942	HF943
P					★	★
M					★	★
K					★	★
N						
S					★	★
H						
D	CR	d(h6)	I	L	€	€
4	0.10	6	19	75	25,69	27,11
5	0.10	6	19	75	25,69	27,11
6	0.10	6	25	75	25,69	27,11
8	0.20	8	30	75	34,98	36,68
10	0.20	10	40	100	56,72	58,99
12	0.30	12	45	100	75,03	77,30
16	0.30	16	65	125	151,56	155,54
20	0.30	20	65	125	217,70	221,96

HF542 - catalogue page 415



							HF542
P							★
M							★
K							★
N							
S							★
H							
D	CR	d(h6)	I	I1	d1	L	€
6	0.30	6	12	30	5.80	75	24,01
6	0.50	6	12	30	5.80	75	24,01
6	1.00	6	12	30	5.80	75	24,80
6	0.30	6	12	30	5.80	100	27,28
6	0.50	6	12	30	5.80	100	27,28
6	1.00	6	12	30	5.80	100	28,07
8	0.50	8	16	40	7.80	100	37,92
8	1.00	8	16	40	7.80	100	37,92
8	2.00	8	16	40	7.80	100	38,71
10	0.50	10	20	50	9.80	125	59,27
10	1.00	10	20	50	9.80	125	59,27
10	2.00	10	20	50	9.80	125	60,06
12	0.50	12	24	60	11.80	125	78,79
12	1.00	12	24	60	11.80	125	79,58
12	2.00	12	24	60	11.80	125	80,64
12	3.00	12	24	60	11.80	125	82,75
12	0.50	12	24	60	11.80	150	89,23
12	1.00	12	24	60	11.80	150	90,02
12	2.00	12	24	60	11.80	150	91,08
12	3.00	12	24	60	11.80	150	93,19
16	0.50	16	32	80	15.70	150	142,01
16	1.00	16	32	80	15.70	150	142,80
16	2.00	16	32	80	15.70	150	143,85
16	3.00	16	32	80	15.70	150	145,97
16	4.00	16	32	80	15.70	150	146,50
20	0.50	20	40	100	19.70	150	204,16
20	1.00	20	40	100	19.70	150	204,95
20	2.00	20	40	100	19.70	150	206,01
20	3.00	20	40	100	19.70	150	208,13
20	4.00	20	40	100	19.70	150	208,65



HF642 - catalogue page 426



OSAWA NORM	MG PV300	<40 HRC	36°/37°/38°	RADIUS	Z5
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HF643 - catalogue page 429



OSAWA NORM	MG PV300	<40 HRC	36°/37°/38°	RADIUS	Z5
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HF742 - catalogue page 432

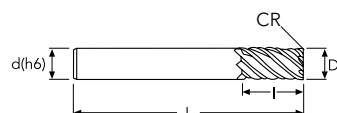


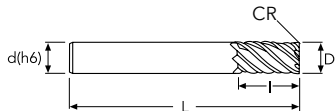
OSAWA NORM	MG PV300	<40 HRC	36°/37°/38°	RADIUS	Z5
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HF743 - catalogue page 435



OSAWA NORM	MG PV300	<40 HRC	36°/37°/38°	RADIUS	Z5
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					HF642	HF643		HF742	HF743	
P					★	★		★	★	
M					★	★		★	★	
K					★	★		★	★	
N										
S					★	★		★	★	
H										
D	CR	d(h6)	I	L	€	€	I	L	€	€
4	0.10	6	12	57	25,32	26,71				
5	0.10	6	13	57	25,32	26,71				
6	0.10	6	13	57	25,32	26,71	25	75	30,06	31,45
8	0.20	8	20	64	36,14	37,81	25	75	39,17	40,85
10	0.20	10	22	72	47,24	49,47	38	100	58,30	60,53
12	0.30	12	26	83	66,71	68,94	45	100	76,03	78,25
16	0.30	16	32	92	107,28	111,18	55	125	154,86	158,75
20	0.30	20	38	104	182,23	186,41	65	125	217,17	221,35



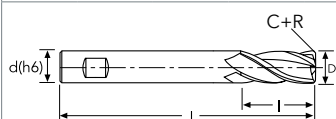
HF871 - catalogue page 438

OSAWA
NORMMG
PV300<40
HRC

VH 36°/39°

C+R

Z4 UP



HF871

P					★
M					★
K					★
N					
S					★
H					
D	C+R	d(h6)	I	L	€
1	0.1	4	3	50	15,32
1.5	0.1	4	4.5	50	15,32
2	0.1	4	6.5	50	15,32
2.5	0.1	4	6.5	50	15,32
3	0.1	6	9	50	16,62
3.5	0.1	6	11	57	19,26
4	0.1	6	11	57	16,62
4.5	0.1	6	13	57	19,26
5	0.1	6	13	57	16,62
5.5	0.1	6	13	57	19,26
6	0.1	6	13	64	16,62
7	0.2	8	20	64	27,07
8	0.2	8	20	72	24,00
9	0.2	10	22	72	39,95
10	0.2	10	22	83	35,21
11	0.2	12	26	83	50,59
12	0.2	12	26	83	45,21
13	0.2	14	26	83	68,22
14	0.2	14	26	92	65,42
15	0.2	16	32	92	86,94
16	0.2	16	32	92	78,40
18	0.2	18	32	104	112,18
20	0.2	20	38	104	126,23

* cylindrical shank: Ø1mm+2.5mm

HF HARD - UP - 45° chamfer

HF850 - catalogue page 443



HF450 - catalogue page 447



HF451 - catalogue page 451

OSAWA
NORMMG
PV30030÷55
HRC

40°

C45°

Z4 UP

OSAWA
NORMMG
PV30030÷55
HRC

40°

C45°

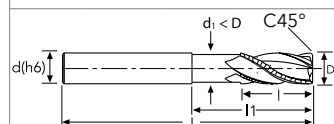
Z4 UP

OSAWA
NORMMG
PV30030÷55
HRC

40°

C45°

Z4 UP



HF850

HF450

HF451

P					★					★	★
M					★					★	★
K					★					★	★
N											
S					★					★	★
H					★					★	★
D	C45°	d(h6)	I	L	€	I	I1	d1	L	€	€
3	0.10	6	9	57	22,71	9	15	2.80	57	22,70	22,70
4	0.10	6	11	57	22,71	11	18	3.80	57	22,70	22,70
5	0.10	6	13	57	22,71	13	19	4.80	57	22,70	22,70
6	0.10	6	13	57	22,71	13	20	5.80	57	22,70	22,70
8	0.20	8	20	64	32,18	20	26	7.80	64	32,18	32,18
10	0.20	10	22	72	47,53	22	30	9.80	72	47,53	47,53
12	0.20	12	26	83	61,28	26	36	11.80	83	61,28	61,28
14	0.30	14	32	90	81,94	26	36	13.70	83	81,93	81,93
16	0.30	16	32	92	106,85	32	42	15.70	92	106,84	106,84
20	0.40	20	38	104	164,96	38	50	19.70	104	164,96	164,96



HF852 - catalogue page 455



OSAWA
NORM

MG
PV300

30÷55
HRC

40°

RADIUS

Z4 UP

HF452 - catalogue page 459



OSAWA
NORM

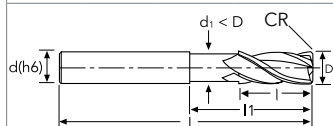
MG
PV300

30÷55
HRC

40°

RADIUS

Z4 UP



					HF852					HF452
P					★					★
M					★					★
K					★					★
N										
S					★					★
H					★					★
D	C+R	d(h6)	I	L	€	I	I1	d1	L	€
3	0.30	6				9	15	2.80	57	24,96
3	0.50	6				9	15	2.80	57	24,96
4	0.30	6	11	57	24,96	11	18	3.80	57	24,96
4	0.50	6	11	57	24,96	11	18	3.80	57	24,96
5	0.30	6	15	57	24,96					
5	0.50	6	15	57	24,96	13	19	4.80	57	24,96
6	0.30	6	13	57	24,96					
6	0.50	6	13	57	24,96	13	20	5.80	57	24,96
6	1.00	6	13	57	24,96	13	20	5.80	57	24,96
8	0.50	8	20	64	35,41	20	26	7.80	64	35,41
8	1.00	8	20	64	35,41	20	26	7.80	64	35,41
10	0.50	10	22	72	52,29	22	30	9.80	72	52,29
10	1.00	10	22	72	52,29	22	30	9.80	72	52,29
12	0.50	12	26	83	67,44	26	36	11.80	83	67,44
12	1.00	12	26	83	67,44	26	36	11.80	83	67,44
12	2.00	12	26	83	67,44					
12	3.00	12	26	83	67,44					
14	1.00	14	26	83	90,16					
16	1.00	16	32	92	117,55	32	42	15.70	92	117,53
16	2.00	16	32	92	117,55	32	42	15.70	92	117,53
20	1.00	20	38	104	181,44	38	50	19.70	104	181,44
20	2.00	20	38	104	181,44	38	50	19.70	104	181,44



HFAL4 - catalogue page 478


OSAWA
NORM

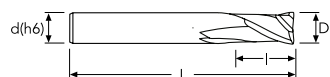
ALU

MG
BR

40°

SQUARE

Z4 UP



HFAL4

P		
M		
K		
N		★
S		
H		
D(e8)		€
3		18,53
4		18,53
5		18,53
6		18,53
8		26,23
10		38,77
12		49,97
14		66,80
16		87,10
20		141,19

ALU - Corner radius

HFAL3 - catalogue page 481


OSAWA
NORM

ALU

MG
POLISHED

30°

RADIUS

Z3 UP



HFAL3

P					
M					
K					
N					★
S					
H					
D	CR	d(h6)	I	L	€
2	0.10	6	6.5	50	20,07
3	0.10	6	9	50	20,07
4	0.10	6	12	50	20,07
5	0.10	6	15	50	20,07
6	0.10	6	20	60	23,05
8	0.10	8	20	64	32,57
10	0.10	10	22	75	46,14
12	0.10	12	25	75	61,06
14	0.10	14	32	90	90,09
16	0.10	16	32	90	113,90
20	0.10	20	38	100	167,51





ALU

MG
BR



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