

The Right Tool at the Right Time



**High Performance Solid Carbide
Deep Hole Drills,**
for depths up to 30 x Diameter



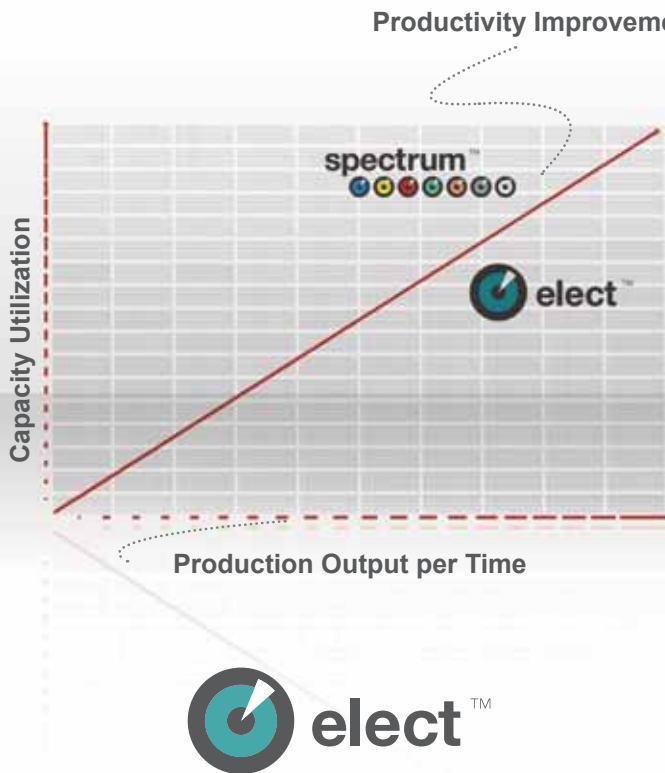
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Your Productivity *Our Vision*

At Dormer, we understand that each customer is different. One customer's priority may be to maximize capacity utilization, while another's may be to increase production output per time.

To help our customers choose the tool that best meets their requirements, Dormer classifies its rotary tooling ranges under one of the following two productivity classes:



	spectrum	elect P	elect M	elect K	elect N	elect S	elect H	elect O
Steel	●	●	●	●	●	●	●	●
Stainless Steel	●	●	●	●	●	●	●	●
Cast Iron	●	●	●	●	●	●	●	●
Non ferrous material	●	●	●	●	●	●	●	●
Heat resistant super alloys	●	●	●	●	●	●	●	●
Hardened Materials	●	●	●	●	●	●	●	●
Other	●	●	●	●	●	●	●	●



Products carrying the **Elect™** brand identify Dormer's best performing tools for one specific material or application, satisfying the need for high output per time.

In the case of material specific tools, a letter, relating to the **ISO** material classifications, will be added to the brand mark to denote material suitability e.g. **Elect™** denotes that this is a top performing tool for steel. In the case of application specific tools (e.g. deep hole drills or thread milling cutters) the term "APP" will be used to form the brand mark **Elect APP™**.

Tools carrying the **Spectrum™** brand indicate excellent productivity over a multitude of materials, providing high capacity utilization and versatility.

The brand mark incorporates a visual reference to every **ISO** material color code, denoting that these products are suitable for a range of applications or material types.

Features & Benefits

Material

Micrograin carbide.

Surface Treatment

Dormer's proprietary Super-Flow coating has been specifically developed to optimize performance of the Elect APP™ drills for deep holes, offering:

- A smooth surface to assist chip evacuation
- Greater stability of cutting edges
- Outstanding wear resistance
- High hardness/toughness properties and oxidation stability
- Exceptional chip evacuation capabilities in all recommended materials, even at drilling depths of 30 x Ø
- Significantly increased tool life and productivity

The R570 (8 x Ø) and R571 (12 x Ø) drills are coated along the entire length of the flute. For drills above 12 x Ø, the Super-Flow coating is applied to the drill tip followed by a unique finishing treatment, to facilitate chip evacuation at greater depths and also to reduce torque.

ACM™ (Advanced Chip Management) Flute Geometry

Dormer's proven ACM™ (Advanced Chip Management) flute geometry promotes ample flute volume along the length of the drill and encourages the formation of small, manageable chips, ensuring efficient evacuation in deep hole drilling applications. In addition, ACM™ ensures consistent forces throughout the drilling cycle for even tool wear and therefore prolonged tool life.

Point Geometry

Specially designed point helps to reduce thrust forces and provides clearance for the high feeds recommended on Elect APP™ drill ranges for deep holes.

Edge Preparation

The consistent edge preparation on Elect APP™ drills for deep holes protects the cutting edges from premature chipping and flaking, with subsequent benefits to tool life.

Double offset margins

Dormer's patented double offset margins on diameters of 5mm and above offer greater stability to the drilling operation, reducing chatter and improving hole concentricity (R572, R573, R575).

Internal Coolant

Internal coolant holes deliver cutting fluid directly to the tip of the drill, cooling the cutting area and efficiently evacuating chips away from the hole. This allows for high speeds and feeds, resulting in high productivity and lower cost per hole.



Shank

To DIN 6535 HA.

Hole Depth

Drilling depths up to $30 \times \varnothing$ are achievable without the need for pecking throughout the full diameter range. For depths of $>12 \times \varnothing$ to $30 \times \varnothing$, a complementary solid carbide pilot drill (R470) with 150° point angle has been developed for pre-drilling to a maximum depth of $3 \times \varnothing$ (minimum recommended depth $1.5 \times \varnothing$). This enables greater accuracy in drill location and minimal hole run out when drilling deep holes.

Regrinding

All Elect APP™ drills for deep holes can be reground and recoated at a Dormer regrinding center, in order to provide repeatable tool performance.

Range

R570 ($8 \times \varnothing$), 3.0 – 20.0mm and 1/8" – 5/8"
R571 ($12 \times \varnothing$), 3.0 – 20.0mm and 1/8" – 21/32"
R572 ($15 \times \varnothing$), 3.0 – 12.0mm and 1/8" – 29/64"
R573 ($20 \times \varnothing$), 3.0 – 12.0mm and 1/8" – 29/64"
R575 ($30 \times \varnothing$), 3.0 – 8.0mm and 1/8" – 5/16"

R470 pilot drill, 3.0 – 12.0mm and 1/8" – 29/64"
(for pilot drilling $>12 \times \varnothing$ to $30 \times \varnothing$).

Tool Holding

The Elect APP™ drill ranges for deep holes are designed to be used with a high precision chuck such as Dormer HydroGrip®, for optimum hole quality and minimal run out.

Application Methods

The Elect APP™ drills for deep holes have proven application methods for cross hole and angled face drilling. Speeds and feeds recommended for use with these applications are a starting point and may be modified to increase productivity, taking into consideration all other elements in the machining process - machine tool, tool holder, workpiece and clamping system.



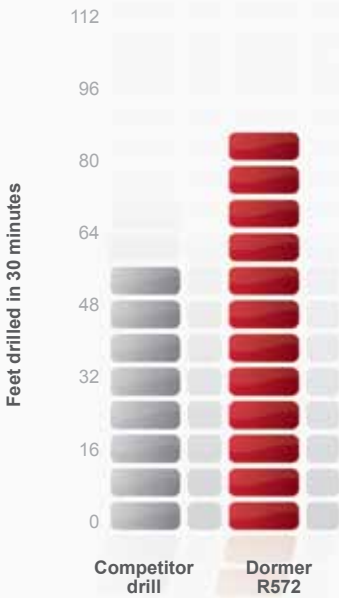
Customer *Benefits*

- Accurate deep holes to depths up to $30 \times \varnothing$ without the need for pecking.
- High speeds and feeds allow greater productivity and therefore lower cost per hole.
- Fast and efficient chip evacuation reduces machine downtime and increases tool life.
- Consistent forces throughout the drilling cycle ensure a **stable drilling operation**, resulting in negligible chatter and improved hole concentricity.
- Enhanced centering capabilities.
- Internal coolant holes ensure a reduction of heat generated in the cutting zone for **trouble-free machining** and excellent chip management.
- Honed cutting edges prevent premature chipping or flaking and result in **increased tool life**.
- Reduced torque, reduced thrust forces.
- Designed to be reconditioned to further extend tool life.
- Pilot drilling technique on drilling depths of $>12 \times \varnothing$, to achieve **greater accuracy** and minimal hole run out.
- Proven application methods for cross hole drilling and angled face drilling.



Field Test

R572, Elect APP™ drill, 15 x D



Customer: Die & mold industry, Sweden
Application: Horizontal drilling operation
Target: To increase productivity
Material: DIN 1.2344, ESR (AMG 1.4 Alloy Steel), and Orvar Supreme (AMG 1.5 Alloy steel, hardened and tempered)

Drill Diameter: 10.3mm
Drilling depth: 5.5"

Cutting Conditions: **Vc: 295 ft/min, 2781rpm**
(Dormer drill) **Vf:0.013 inches/rev, 36 inches/min**

Cutting Conditions: **Vc: 180 ft/min, 1700rpm**
(Competitor drill) **Vf:0.013 inches/rev, 22 inches/min**

Tool life: Based on 30 minutes cutting time.
Pilot drill: Dormer pilot drill 10.3mm to a depth of 0.6"

Coolant pressure: 1160 PSI

Result

The Dormer R572 Elect APP™ drill and the competitor drill were used in a horizontal application to drill to a depth of 5.5" at manufacturers' recommended cutting conditions. As the graph shows, productivity of the Dormer R572 Elect APP™ drill is more than 60% higher than that of the competitor drill, measured in feet drilled in 30 minutes.

Application Material Groups (AMG)

How To Use This AMG Chart:

1. Determine your Workpiece Material. Select Material from the AMG Chart below.
2. Use the icons to find product features.
3. Find the Surface Feet per minute (SFM)
 - example: 426V, 426 = SFM, V = Alpha code to find your feed rate.
 - To calculate the cutting feed rate, please refer to the chart below

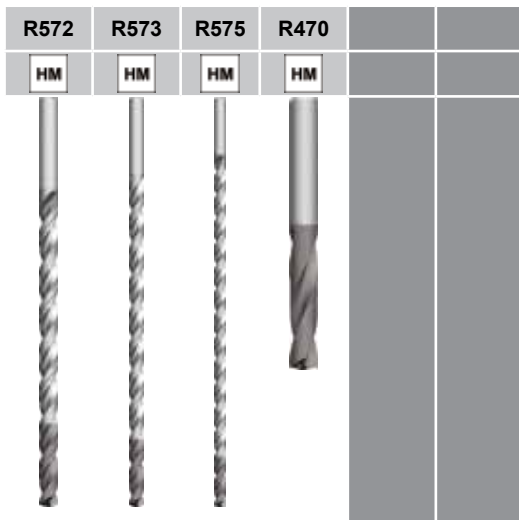
■ = Excellent for Application (see pages 10 - 17) ● = Good for Application

Fn	Ø									
	3mm/ 1/8"	4mm/ 5/32"	5mm/ 3/16"	6mm/ 1/4"	8mm/ 5/16"	10mm/ 3/8"	12mm/ 1/2"	15mm/ 9/16"	16mm/ 5/8"	20mm/ 3/4"
U	0.0028	0.0031	0.0035	0.0042	0.0055	0.0067	0.0079	0.0088	0.0091	0.0094
V	0.0039	0.0045	0.0051	0.0060	0.0079	0.0098	0.0110	0.0122	0.0126	0.0134
W	0.0051	0.0059	0.0067	0.0079	0.0102	0.0130	0.0150	0.0165	0.0169	0.0177
X	0.0059	0.0071	0.0083	0.0098	0.0130	0.0165	0.0189	0.0210	0.0217	0.0228
Inches/Rev ± 25%										



3.00 - 20.00 3.00 - 20.00

Application Material Groups (AMG) With Examples		Hardness HB	10	12
*For more examples of application materials, please consult the Dormer Product Selector Program				
1. Steel	1.1 Magnetic soft steel	12L14, 12L15	<120	426V 426V
	1.2 Structural Steel/ case carburising steel	1005-1025, 1214, 1215, A36	<200	394V 394V
	1.3 Plain Carbon steel	1030-1060, 1050-1060, 1144-1146	<250	361V 361V
	1.4 Alloy steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	<250	328W 328W
	1.5 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>250<350	295W 295W
	1.6 Alloy steel/ Hardened and tempered steel	4140,4340,52100,8620 H11-H41,A2,D2,01,P20,420	>350	262V 262V
	1.7 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	49-55HRC	
2. Stainless Steel	1.8 Alloy steel Hardened	A2-D2, H10-H41, L1-L6, M1-M42, T1	55-63HRC	
	2.1 Free machining Stainless Steel	200, 303, 416, 420F, 430F, 440	<250	115V 115V
	2.2 Austenitic	301, 302, 304, 316, 321, 330, CUSTOM 455, AM-350	<250	98V 98V
	2.3 Ferritic + Austenitic, Martensitic	318-329, 400-446, 15-4PH, 17-4PH. DUPLEX	<300	82V 82V
3. Cast Iron	2.4 Precipitation Hardened	15-5PH, Custom 450 17-4PH	<300	82U 82U
	3.1 Lamellar graphite	Grey, G10, Gg40, J431C, A48 CLASS 20	<150	377W 377W
	3.2 Lamellar graphite	Grey, GG25-Gg40, J158, A48 CLASS 40-60	>150<300	377W 377W
	3.3 Nodular graphite/ Malleable Cast Iron	A220, A436, A439, A602, Black, GGG40-GGG70	<200	246V 246V
4. Titanium	3.4 Nodular graphite/ Malleable Cast Iron	Black Gts/Gtw, J434C	>200<300	246V 246V
	4.1 Titanium, unalloyed	Commercially Pure	<200	
	4.2 Titanium, alloyed	6A14V, 6A14V-2Sn, Monel, Monel K	<270	
5. Nickel	4.3 Titanium, alloyed	6A14V-4Mo, 7A14V-4Mo, 4911-4967	>270<350	
	5.1 Nickel, unalloyed	Commercially Pure, 17644, 200, 5553	<150	
	5.2 Nickel, alloyed	Monel 400, Hastelloy C, Inconel 625, Waspaloy	<270	
6. Copper	5.3 Nickel, alloyed	Inconel 718, Nimonic 75-95, Rene 41, Inconel 825, A286	>270<350	
	6.1 Copper	Commercially Pure	<100	410V 410V
	6.2 β-Brass, Bronze	314-340, 350-370	<200	722V 722V
	6.3 α-Brass	Alloyed Cu + Al + Fe, Long Chipping	<200	722V 722V
7. Aluminium Magnesium	6.4 High Strength Bronze	Ampco® 18-25	<470	328U 328U
	7.1 Al, Mg, unalloyed	Commercially Pure	<100	886X 886X
	7.2 Al alloyed, Si<0.5%	6061 T6, 7075, 314-340	<150	886X 886X
	7.3 Al alloyed, Si>0.5%<10%	6061 T6, 380-390	<120	590W 590W
8. Synthetic Materials	7.4 Al alloyed, Si>10% Mg alloys	Magnesium Whisker Reinforced	<120	295W 295W
	8.1 Thermoplastics	Ultradim, Polystrol	---	
	8.2 Thermosetting plastics	Bakelint, Pertinax	---	
9. Hard Mat.	8.3 Reinforced plastic materials	CFK, GFKAFK	---	
	9.1 Cermets (Metal-ceramics)	Ferrotic	<550	
10. Graphite	10.1 Standard graphite	---		



3.00 - 12.00	3.00 - 12.00	3.00 - 8.00	3.00 - 12.00

14	15	16	17	AMG	ISO
426V	384U	384U	410W	1.1	P
394V	354U	354U	377W	1.2	P
361V	325U	325U	361W	1.3	P
328W	295V	295V	312V	1.4	P
295W	266V	266V	246V	1.5	P
262V	236U	236U	213U	1.6	P
				1.7	H
				1.8	H
				2.1	M
115V	105U	105U	180V	2.2	M
98V	89U	89U	115V	2.3	M
82V	75U	75U	98U	2.4	M
82U	75T	75T	98U	3.1	K
377W	341V	341V	361W	3.2	K
377W	341V	341V	361W	3.3	K
246V	223U	223U	262V	3.4	K
246V	223U	223U	262V	4.1	S
			180V	4.2	S
			148V	4.3	S
			131U	5.1	S
				5.2	S
				5.3	S
			410W	6.1	N
			722W	6.2	N
			722W	6.3	N
			328V	6.4	N
886X	797W	797W	820W	7.1	N
886X	797W	797W	820W	7.2	N
590W	531V	531V	656V	7.3	N
295W	266V	266V	492V	7.4	N
				8.1	O
				8.2	O
				8.3	O
				9.1	H
				10.1	O

Page # for easy reference

R570

• Elect APP™ Drill for deep holes

• Foret Elect APP™ pour trous profonds

• Broca Elect APP™ para agujeros profundos



R570



- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 3.1 3.2 3.3 3.4 7.2 7.3 7.4
- 2.3 2.4 6.1 6.2 6.3 6.4 7.1

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	EDP # or Stock No.	e-Code
	3.00	0.1181	37	79	36	6	0622261	R5703.0
	3.10	0.1220	37	79	36	6	0629048	R5703.1
1/8	3.18	0.1250	37	79	36	6	0032909	R5701/8
	3.20	0.1260	37	79	36	6	0628713	R5703.2
	3.30	0.1299	37	79	36	6	0622278	R5703.3
	3.40	0.1339	37	79	36	6	0622285	R5703.4
	3.50	0.1378	37	79	36	6	0622292	R5703.5
9/64	3.57	0.1406	37	79	36	6	0032916	R5709/64
	3.70	0.1457	37	79	36	6	0622308	R5703.7
	3.80	0.1496	48	90	36	6	0628720	R5703.8
5/32	3.97	0.1563	48	90	36	6	0032923	R5705/32
	4.00	0.1575	48	90	36	6	0622315	R5704.0
	4.10	0.1614	48	90	36	6	0628737	R5704.1
	4.20	0.1654	48	90	36	6	0622322	R5704.2
	4.30	0.1693	48	90	36	6	0622599	R5704.3
11/64	4.37	0.1719	48	90	36	6	0032930	R57011/64
	4.50	0.1772	48	90	36	6	0622339	R5704.5
	4.60	0.1811	48	90	36	6	0622346	R5704.6
3/16	4.76	0.1875	62	104	36	6	0032947	R5703/16
	4.80	0.1890	62	104	36	6	0628928	R5704.8
	5.00	0.1969	62	104	36	6	0622353	R5705.0
	5.10	0.2008	62	104	36	6	0622360	R5705.1
13/64	5.16	0.2031	62	104	36	6	0032954	R57013/64
	5.20	0.2047	62	104	36	6	0622377	R5705.2
	5.50	0.2165	62	104	36	6	0622384	R5705.5
7/32	5.56	0.2188	62	104	36	6	0032961	R5707/32
	5.70	0.2244	62	104	36	6	0632895	R5705.7
	5.80	0.2283	62	104	36	6	0628744	R5705.8
15/64	5.95	0.2344	62	104	36	6	0032978	R57015/64
	6.00	0.2362	62	104	36	6	0622391	R5706.0
	6.10	0.2402	84	126	36	8	0135365	R5706.1
	6.20	0.2441	84	126	36	8	0622407	R5706.2
1/4	6.35	0.2500	84	126	36	8	0622513	R5701/4
	6.50	0.2559	84	126	36	8	0622414	R5706.5
	6.60	0.2598	84	126	36	8	0135372	R5706.6

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	EDP # or Stock No.	e-Code
	6.70	0.2638	84	126	36	8	0135389	R5706.7
17/64	6.75	0.2656	84	126	36	8	0622568	R57017/64
	6.80	0.2677	84	126	36	8	0622421	R5706.8
	6.90	0.2717	84	126	36	8	0622629	R5706.9
	7.00	0.2756	84	126	36	8	0622438	R5707.0
9/32	7.14	0.2812	84	126	36	8	0622698	R5709/32
	7.20	0.2835	84	126	36	8	0632901	R5707.2
	7.40	0.2913	84	126	36	8	0622636	R5707.4
	7.50	0.2953	84	126	36	8	0622445	R5707.5
19/64	7.54	0.2969	84	126	36	8	0004722	R57019/64
	7.60	0.2992	84	126	36	8	0135396	R5707.6
	7.70	0.3031	84	126	36	8	0135402	R5707.7
	7.80	0.3071	84	126	36	8	0622452	R5707.8
5/16	7.94	0.3125	84	126	36	8	0622605	R5705/16
	8.00	0.3150	84	126	36	8	0622469	R5708.0
	8.10	0.3189	106	152	40	10	0135419	R5708.1
	8.20	0.3228	106	152	40	10	0135426	R5708.2
21/64	8.33	0.3281	106	152	40	10	0004739	R57021/64
	8.40	0.3307	106	152	40	10	0135433	R5708.4
	8.50	0.3346	106	152	40	10	0622476	R5708.5
	8.60	0.3386	106	152	40	10	0622650	R5708.6
	8.70	0.3425	106	152	40	10	0622667	R5708.7
11/32	8.73	0.3437	106	152	40	10	0622537	R57011/32
	8.80	0.3465	106	152	40	10	0628751	R5708.8
	9.00	0.3543	106	152	40	10	0622483	R5709.0
23/64	9.13	0.3594	106	152	40	10	0622575	R57023/64
	9.30	0.3661	106	152	40	10	0622674	R5709.3
	9.50	0.3740	106	152	40	10	0622490	R5709.5
3/8	9.53	0.3750	106	152	40	10	0622582	R5703/8
	9.80	0.3858	106	152	40	10	0135440	R5709.8
	9.90	0.3898	106	152	40	10	0628768	R5709.9
25/64	9.92	0.3906	106	152	40	10	0004746	R57025/64
	10.00	0.3937	106	152	40	10	0622186	R57010.0
	10.20	0.4016	128	180	45	12	0622193	R57010.2
	10.30	0.4055	128	180	45	12	0622209	R57010.3
13/32	10.32	0.4063	128	180	45	12	0622544	R57013/32

R570

d₁ Øm7 Inch	d₁ Øm₇ mm	d₁ decimal Inch	l₂ mm	l₁ mm	l₃ mm	d₂ Ø mm	EDP # or Stock No.	e-Code
	10.40	0.4094	128	180	45	12	0622520	R57010.4
	10.50	0.4134	128	180	45	12	0622216	R57010.5
27/64	10.72	0.4219	128	180	45	12	0004753	R57027/64
	11.00	0.4331	128	180	45	12	0622223	R57011.0
7/16	11.11	0.4375	128	180	45	12	0622643	R5707/16
	11.20	0.4409	128	180	45	12	0622230	R57011.2
	11.50	0.4528	128	180	45	12	0622247	R57011.5
29/64	11.51	0.4531	128	180	45	12	0004913	R57029/64
	11.80	0.4646	128	180	45	12	0628584	R57011.8
15/32	11.91	0.4687	128	180	45	12	0032985	R57015/32
	12.00	0.4724	128	180	45	12	0622254	R57012.0
	12.20	0.4803	151	202	48	14	0628591	R57012.2
31/64	12.30	0.4844	151	202	48	14	0004937	R57031/64
	12.50	0.4921	151	202	48	14	0628607	R57012.5
1/2	12.70	0.5000	151	202	48	14	0622506	R5701/2
	12.80	0.5039	151	202	48	14	0135457	R57012.8
	13.00	0.5118	151	202	48	14	0628614	R57013.0
33/64	13.10	0.5156	151	202	48	14	0032992	R57033/64
17/32	13.49	0.5313	151	202	48	14	0622551	R57017/32
	13.50	0.5315	151	202	48	14	0628621	R57013.5
	13.70	0.5394	151	202	48	14	0628409	R57013.7
35/64	13.89	0.5469	151	202	48	14	0033005	R57035/64

d₁ Øm7 Inch	d₁ Øm₇ mm	d₁ decimal Inch	l₂ mm	l₁ mm	l₃ mm	d₂ Ø mm	EDP # or Stock No.	e-Code
	14.00	0.5512	151	202	48	14	0628638	R57014.0
	14.20	0.5591	172	227	48	16	0628645	R57014.2
	14.25	0.5610	172	227	48	16	0628652	R57014.25
9/16	14.29	0.5625	172	227	48	16	0622681	R5709/16
	14.50	0.5709	172	227	48	16	0628669	R57014.5
37/64	14.68	0.5781	172	227	48	16	0033012	R57037/64
	14.70	0.5787	172	227	48	16	0628416	R57014.7
	15.00	0.5906	172	227	48	16	0628676	R57015.0
19/32	15.08	0.5937	172	227	48	16	0033029	R57019/32
	15.10	0.5945	172	227	48	16	0628683	R57015.1
39/64	15.48	0.6094	172	227	48	16	0033036	R57039/64
	15.50	0.6102	172	227	48	16	0628690	R57015.5
	15.70	0.6181	172	227	48	16	0628423	R57015.7
5/8	15.88	0.6250	172	227	48	16	0622612	R5705/8
	16.00	0.6299	172	227	48	16	0628706	R57016.0
	17.00	0.6693	194	246	48	18	0135464	R57017.0
	17.50	0.6890	194	246	48	18	0135471	R57017.5
	18.00	0.7087	194	246	48	18	0135488	R57018.0
	18.50	0.7283	215	269	50	20	0135495	R57018.5
	19.00	0.7480	215	269	50	20	0135501	R57019.0
	19.50	0.7677	215	269	50	20	0135518	R57019.5
	20.00	0.7874	215	269	50	20	0135525	R57020.0

R571

• Elect APP™ Drill for deep holes

• Foret Elect APP™ pour trous profonds

• Broca Elect APP™ para agujeros profundos



NEW

2009.02

R571



- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 3.1 3.2 3.3 3.4 7.2 7.3 7.4
- 2.3 2.4 6.1 6.2 6.3 6.4 7.1

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	EDP # or Stock No.	e-Code	d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	EDP # or Stock No.	e-Code
	3.00	0.1181	52	94	36	6	0622087	R5713.0	17/64	6.75	0.2656	116	158	36	8	0032541	R571117/64
	3.10	0.1220	52	94	36	6	0622094	R5713.1		6.80	0.2677	116	158	36	8	0020678	R5716.8
1/8	3.17	0.1250	52	94	36	6	0032466	R5711/8		6.90	0.2717	116	158	36	8	0020685	R5716.9
	3.20	0.1260	52	94	36	6	0622100	R5713.2		7.00	0.2756	116	158	36	8	0020692	R5717.0
	3.30	0.1299	52	94	36	6	0622117	R5713.3	9/32	7.14	0.2813	116	158	36	8	0032886	R5719/32
	3.40	0.1339	52	94	36	6	0622124	R5713.4		7.40	0.2913	116	158	36	8	0020708	R5717.4
	3.50	0.1378	52	94	36	6	0622131	R5713.5		7.50	0.2953	116	158	36	8	0020715	R5717.5
9/64	3.57	0.1406	52	94	36	6	0032473	R5719/64	19/64	7.54	0.2969	116	158	36	8	0032558	R57119/64
	3.70	0.1457	52	94	36	6	0019139	R5713.7		7.60	0.2992	116	158	36	8	0020722	R5717.6
	3.80	0.1496	67	109	36	6	0019146	R5713.8		7.70	0.3031	116	158	36	8	0020739	R5717.7
5/32	3.97	0.1563	67	109	36	6	0032480	R5715/32		7.80	0.3071	116	158	36	8	0020746	R5717.8
	4.00	0.1575	67	109	36	6	0019276	R5714.0	5/16	7.94	0.3125	116	158	36	8	0032893	R5715/16
	4.10	0.1614	67	109	36	6	0019283	R5714.1		8.00	0.3150	116	158	36	8	0020753	R5718.0
	4.20	0.1654	67	109	36	6	0019306	R5714.2		8.10	0.3189	146	192	40	10	0020760	R5718.1
	4.30	0.1693	67	109	36	6	0019313	R5714.3		8.20	0.3228	146	192	40	10	0020777	R5718.2
11/64	4.37	0.1719	67	109	36	6	0032497	R57111/64	21/64	8.33	0.3281	146	192	40	10	0032565	R57121/64
	4.50	0.1772	67	109	36	6	0019405	R5714.5		8.40	0.3307	146	192	40	10	0020784	R5718.4
	4.60	0.1811	67	109	36	6	0020548	R5714.6		8.50	0.3346	146	192	40	10	0020791	R5718.5
3/16	4.76	0.1875	86	128	36	6	0032862	R5713/16		8.60	0.3386	146	192	40	10	0020807	R5718.6
	4.80	0.1890	86	128	36	6	0020555	R5714.8		8.70	0.3425	146	192	40	10	0020814	R5718.7
	5.00	0.1969	86	128	36	6	0020562	R5715.0	11/32	8.73	0.3437	146	192	40	10	0032572	R57111/32
	5.10	0.2008	86	128	36	6	0020579	R5715.1		8.80	0.3465	146	192	40	10	0020821	R5718.8
13/64	5.16	0.2031	86	128	36	6	0032503	R57113/64		9.00	0.3543	146	192	40	10	0020838	R5719.0
	5.20	0.2047	86	128	36	6	0020586	R5715.2	23/64	9.13	0.3594	146	192	40	10	0032589	R57123/64
	5.50	0.2165	86	128	36	6	0020593	R5715.5		9.30	0.3661	146	192	40	10	0020845	R5719.3
7/32	5.56	0.2188	86	128	36	6	0032879	R5717/32		9.50	0.3740	146	192	40	10	0020852	R5719.5
	5.80	0.2283	86	128	36	6	0020609	R5715.8	3/8	9.53	0.3750	146	192	40	10	0032596	R5713/8
15/64	5.95	0.2344	86	128	36	6	0032510	R57115/64		9.80	0.3858	146	192	40	10	0020869	R5719.8
	6.00	0.2362	86	128	36	6	0020616	R5716.0	25/64	9.92	0.3906	146	192	40	10	0032602	R57125/64
	6.10	0.2402	116	158	36	8	0020623	R5716.1		10.00	0.3937	146	192	40	10	0020876	R57110.0
	6.20	0.2441	116	158	36	8	0020630	R5716.2		10.20	0.4016	176	228	45	12	0020883	R57110.2
	6.30	0.2480	116	158	36	8	0032527	R5716.3		10.30	0.4055	176	228	45	12	0020890	R57110.3
1/4	6.35	0.2500	116	158	36	8	0032534	R5711/4	13/32	10.32	0.4063	176	228	45	12	0032619	R57113/32
	6.50	0.2559	116	158	36	8	0020647	R5716.5		10.40	0.4094	176	228	45	12	0020906	R57110.4
	6.60	0.2598	116	158	36	8	0020654	R5716.6		10.50	0.4134	176	228	45	12	0020913	R57110.5
	6.70	0.2638	116	158	36	8	0020661	R5716.7	27/64	10.72	0.4219	176	228	45	12	0032626	R57127/64

R571

d_1 Øm7 Inch	d_1 Øm ₇ mm	d_1 decimal Inch	l_2 mm	l_1 mm	l_3 mm	d_2 Ø mm	EDP # or Stock No.	e-Code
	11.00	0.4331	176	228	45	12	0020920	R57111.0
7/16	11.11	0.4375	176	228	45	12	0032633	R57117/16
	11.20	0.4409	176	228	45	12	0020937	R57111.2
	11.50	0.4528	176	228	45	12	0020944	R57111.5
29/64	11.51	0.4531	176	228	45	12	0032640	R57129/64
	11.80	0.4646	176	228	45	12	0020951	R57111.8
15/32	11.91	0.4687	176	228	45	12	0032657	R57115/32
	12.00	0.4724	176	228	45	12	0020968	R57112.0
31/64	12.30	0.4844	207	258	45	14	0032664	R57131/64
	12.50	0.4921	207	258	45	14	0020975	R57112.5
1/2	12.70	0.5000	207	258	45	14	0032671	R5711/2
	12.80	0.5039	207	258	45	14	0020982	R57112.8
	13.00	0.5118	207	258	45	14	0020999	R57113.0
33/64	13.10	0.5156	207	258	45	14	0032688	R57133/64
17/32	13.49	0.5313	207	258	45	14	0032695	R57117/32
	13.50	0.5315	207	258	45	14	0021002	R57113.5
35/64	13.89	0.5469	207	258	45	14	0032701	R57135/64
	14.00	0.5512	207	258	45	14	0021019	R57114.0
	14.25	0.5610	236	291	48	16	0032718	R57114.25
9/16	14.29	0.5625	236	291	48	16	0032725	R5719/16
	14.50	0.5709	236	291	48	16	0021026	R57114.5
37/64	14.68	0.5781	236	291	48	16	0032732	R57137/64

d_1 Øm7 Inch	d_1 Øm ₇ mm	d_1 decimal Inch	l_2 mm	l_1 mm	l_3 mm	d_2 Ø mm	EDP # or Stock No.	e-Code
	15.00	0.5906	236	291	48	16	0021033	R57115.0
19/32	15.08	0.5937	236	291	48	16	0032749	R57119/32
39/64	15.47	0.6094	236	291	48	16	0032756	R57139/64
	15.50	0.6102	236	291	48	16	0021040	R57115.5
5/8	15.88	0.6250	236	291	48	16	0032763	R5715/8
	16.00	0.6299	236	291	48	16	0021057	R57116.0
	16.50	0.6496	266	318	48	18	0035016	R57116.5
21/32	16.67	0.6563	266	318	48	18	0179574	R57121/32
	18.80	0.6614	266	318	48	18	0035030	R57116.8
	17.00	0.6693	266	318	48	18	0035054	R57117.0
	17.50	0.6890	266	318	48	18	0035078	R57117.5
	17.80	0.7008	266	318	48	18	0035085	R57117.8
	18.00	0.7087	266	318	48	18	0035092	R57118.0
	18.50	0.7283	295	349	50	20	0035108	R57118.5
	18.80	0.7402	295	349	50	20	0035115	R57118.8
	19.00	0.7480	295	349	50	20	0035122	R57119.0
	19.50	0.7677	295	349	50	20	0035139	R57119.5
	19.80	0.7795	295	349	50	20	0035146	R57119.8
	20.00	0.7874	295	349	50	20	0035177	R57120.0

R572

• Elect APP™ Drill for deep holes

• Foret Elect APP™ pour trous profonds

• Broca Elect APP™ para agujeros profundos



NEW

2010.09

R572

For pilot drilling, use R470 / Pour percer l'avant-trou, utiliser le foret R470 / Para agujeros piloto, utilizar R470



- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 3.1 3.2 3.3 3.4 7.2 7.3 7.4
- 2.3 2.4 7.1

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	EDP # or Stock No.	e-Code
	3.00	0.1181	54	96	36	6	0637968	R5723.0
1/8	3.17	0.1250	57	99	36	6	0637975	R5721/8
	3.30	0.1299	59	101	36	6	0637982	R5723.3
	3.50	0.1378	63	105	36	6	0637999	R5723.5
9/64	3.57	0.1406	64	106	36	6	0638002	R5729/64
	3.80	0.1496	68	110	36	6	0638019	R5723.8
5/32	3.97	0.1563	71	113	36	6	0638026	R5725/32
	4.00	0.1575	72	114	36	6	0638033	R5724.0
	4.20	0.1654	76	118	36	6	0638040	R5724.2
11/64	4.37	0.1719	79	121	36	6	0638057	R57211/64
	4.50	0.1772	81	123	36	6	0638064	R5724.5
3/16	4.76	0.1875	86	128	36	6	0638071	R5723/16
	4.80	0.1890	86	128	36	6	0638088	R5724.8
	5.00	0.1969	90	132	36	6	0638095	R5725.0
13/64	5.16	0.2031	93	135	36	6	0638101	R57213/64
	5.50	0.2165	99	141	36	6	0638118	R5725.5
7/32	5.56	0.2188	100	142	36	6	0638125	R5727/32
	5.80	0.2283	104	146	36	6	0638132	R5725.8
15/64	5.95	0.2344	107	149	36	6	0638149	R57215/64
	6.00	0.2362	108	150	36	6	0638156	R5726.0
1/4	6.35	0.2500	114	156	36	8	0638163	R5721/4
	6.50	0.2559	117	159	36	8	0638170	R5726.5
17/64	6.75	0.2656	121	163	36	8	0638187	R57217/64
	6.80	0.2677	122	164	36	8	0638194	R5726.8
	7.00	0.2756	126	168	36	8	0638200	R5727.0
9/32	7.14	0.2813	129	171	36	8	0638217	R5729/32

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	EDP # or Stock No.	e-Code
	7.50	0.2953	135	177	36	8	0638224	R5727.5
19/64	7.54	0.2969	136	178	36	8	0638231	R57219/64
	7.80	0.3071	140	182	36	8	0638248	R5727.8
5/16	7.94	0.3125	143	185	36	8	0638255	R5725/16
	8.00	0.3150	144	186	36	8	0638262	R5728.0
21/64	8.33	0.3281	150	202	40	10	0638279	R57221/64
	8.50	0.3346	153	205	40	10	0638286	R5728.5
11/32	8.73	0.3437	157	209	40	10	0638293	R57211/32
	9.00	0.3543	162	214	40	10	0638309	R5729.0
23/64	9.13	0.3594	164	216	40	10	0638316	R57223/64
	9.50	0.3740	171	223	40	10	0638323	R5729.5
3/8	9.53	0.3750	171	223	40	10	0638330	R5723/8
	9.80	0.3858	176	228	40	10	0638347	R5729.8
25/64	9.92	0.3906	179	231	40	10	0638354	R57225/64
	10.00	0.3937	180	232	40	10	0638361	R57210.0
	10.30	0.4055	185	237	45	12	0638378	R57210.3
13/32	10.32	0.4063	186	238	45	12	0638385	R57213/32
	10.50	0.4134	189	241	45	12	0638392	R57210.5
27/64	10.72	0.4219	193	245	45	12	0638408	R57227/64
	11.00	0.4331	198	250	45	12	0638415	R57211.0
7/16	11.11	0.4375	200	252	45	12	0638422	R5727/16
	11.50	0.4528	207	259	45	12	0638439	R57211.5
29/64	11.51	0.4531	207	259	45	12	0638446	R57229/64
	11.80	0.4646	212	264	45	12	0638453	R57211.8
	12.00	0.4724	216	268	45	12	0638460	R57212.0

R573

- Elect APP™ Drill for deep holes
- Foret Elect APP™ pour trous profonds
- Broca Elect APP™ para agujeros profundos



NEW

2010.09

R573

For pilot drilling, use R470 / Pour percer l'avant-trou, utiliser le foret R470 / Para agujeros piloto, utilizar R470

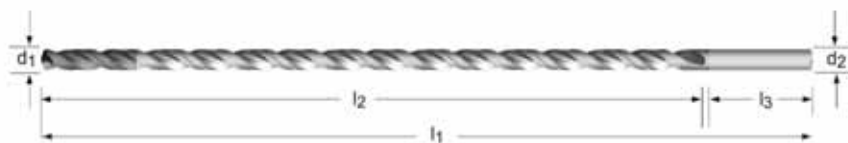


- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 3.1 3.2 3.3 3.4 7.2 7.3 7.4
- 2.3 2.4 7.1

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	EDP # or Stock No.	e-Code	d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	EDP # or Stock No.	e-Code
	3.00	0.1181	69	111	36	6	0638477	R5733.0		7.50	0.2953	172	214	36	8	0638736	R5737.5
1/8	3.17	0.1250	73	115	36	6	0638484	R5731/8	19/64	7.54	0.2969	173	215	36	8	0638743	R57319/64
	3.30	0.1299	76	118	36	6	0638491	R5733.3		7.80	0.3071	179	221	36	8	0638750	R5737.8
	3.50	0.1378	80	122	36	6	0638507	R5733.5	5/16	7.94	0.3125	183	225	36	8	0638767	R5735/16
9/64	3.57	0.1406	82	124	36	6	0638514	R5739/64		8.00	0.3150	184	226	36	8	0638774	R5738.0
	3.80	0.1496	87	129	36	6	0638521	R5733.8	21/64	8.33	0.3281	192	238	40	10	0638781	R57321/64
5/32	3.97	0.1563	91	133	36	6	0638538	R5735/32		8.50	0.3346	195	241	40	10	0638798	R5738.5
	4.00	0.1575	92	134	36	6	0638545	R5734.0	11/32	8.73	0.3437	201	247	40	10	0638804	R57311/32
	4.20	0.1654	97	139	36	6	0638552	R5734.2		9.00	0.3543	207	253	40	10	0638811	R5739.0
11/64	4.37	0.1719	100	142	36	6	0638569	R57311/64	23/64	9.13	0.3594	210	256	40	10	0638828	R57323/64
	4.50	0.1772	103	145	36	6	0638576	R5734.5		9.50	0.3740	218	264	40	10	0638835	R5739.5
3/16	4.76	0.1875	110	152	36	6	0638583	R5733/16	3/8	9.53	0.3750	219	265	40	10	0638842	R5733/8
	4.80	0.1890	110	152	36	6	0638590	R5734.8		9.80	0.3858	225	271	40	10	0638859	R5739.8
	5.00	0.1969	115	157	36	6	0638606	R5735.0	25/64	9.92	0.3906	228	274	40	10	0638866	R57325/64
13/64	5.16	0.2031	119	161	36	6	0638613	R57313/64		10.00	0.3937	230	276	40	10	0638873	R57310.0
	5.50	0.2165	126	168	36	6	0638620	R5735.5		10.30	0.4055	237	291	45	12	0638880	R57310.3
7/32	5.56	0.2188	128	170	36	6	0638637	R5737/32	13/32	10.32	0.4063	237	291	45	12	0638897	R57313/32
	5.80	0.2283	133	175	36	6	0638644	R5735.8		10.50	0.4134	241	295	45	12	0638903	R57310.5
15/64	5.95	0.2344	137	179	36	6	0638651	R57315/64	27/64	10.72	0.4219	246	300	45	12	0638910	R57327/64
	6.00	0.2362	138	180	36	6	0638668	R5736.0		11.00	0.4331	253	307	45	12	0638927	R57311.0
1/4	6.35	0.2500	146	188	36	8	0638675	R5731/4	7/16	11.11	0.4375	256	310	45	12	0638934	R5737/16
	6.50	0.2559	149	191	36	8	0638682	R5736.5		11.50	0.4528	264	318	45	12	0638941	R57311.5
17/64	6.75	0.2656	155	197	36	8	0638699	R57317/64	29/64	11.51	0.4531	265	319	45	12	0638958	R57329/64
	6.80	0.2677	156	198	36	8	0638705	R5736.8		11.80	0.4646	271	325	45	12	0638965	R57311.8
	7.00	0.2756	161	203	36	8	0638712	R5737.0		12.00	0.4724	276	330	45	12	0638972	R57312.0
9/32	7.14	0.2813	164	206	36	8	0638729	R5739/32									

R575

- Elect APP™ Drill for deep holes
- Foret Elect APP™ pour trous profonds
- Broca Elect APP™ para agujeros profundos



NEW

2010.09

R575

For pilot drilling, use R470 / Pour percer l'avant-trou, utiliser le foret R470 / Para agujeros piloto, utilizar R470



- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 3.1 3.2 3.3 3.4 7.2 7.3 7.4
- 2.3 2.4 7.1

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	EDP # or Stock No.	e-Code
1/8	3.00	0.1181	99	141	36	6	0638989	R5753.0
	3.17	0.1250	105	147	36	6	0638996	R5751/8
	3.50	0.1378	115	157	36	6	0639009	R5753.5
9/64	3.57	0.1406	118	160	36	6	0639016	R5759/64
	3.97	0.1563	131	173	36	6	0639023	R5755/32
11/64	4.00	0.1575	132	174	36	6	0639030	R5754.0
	4.37	0.1719	144	186	36	6	0639047	R57511/64
3/16	4.50	0.1772	148	190	36	6	0639054	R5754.5
	4.76	0.1875	157	199	36	6	0639061	R5753/16
13/64	5.00	0.1969	165	207	36	6	0639078	R5755.0
	5.16	0.2031	170	212	36	6	0639085	R57513/64
	5.50	0.2165	181	223	36	6	0639092	R5755.5

d ₁ Øm7 Inch	d ₁ Øm ₇ mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	EDP # or Stock No.	e-Code
7/32	5.56	0.2188	183	225	36	6	0639108	R5757/32
	5.95	0.2344	196	238	36	6	0639115	R57515/64
1/4	6.00	0.2362	198	240	36	6	0639122	R5756.0
	6.35	0.2500	210	252	36	8	0639139	R5751/4
17/64	6.50	0.2559	214	256	36	8	0639146	R5756.5
	6.75	0.2656	223	265	36	8	0639153	R57517/64
9/32	7.00	0.2756	231	273	36	8	0639160	R5757.0
	7.14	0.2813	236	278	36	8	0639177	R5759/32
19/64	7.50	0.2953	247	289	36	8	0639184	R5757.5
	7.54	0.2969	249	291	36	8	0639191	R57519/64
5/16	7.94	0.3125	262	304	36	8	0639207	R5755/16
	8.00	0.3150	264	306	36	8	0639214	R5758.0

R470

• Pilot Drill for Elect APP™ deep hole drills

• Foret guide pour foret Elect APP™ pour trous profonds

• Brocas piloto para brocas Elect APP™ para agujeros profundos



NEW

2010.09

R470

For use with R572, R573, R575 / Utiliser avec les forets R572, R573, R575 / Para utilizar con R572, R573, R575



- 1.1 1.2 1.3 1.4 1.5 1.6 2.1 2.2 3.1 3.2 3.3 3.4 4.1 4.2 4.3 6.1 6.2 6.3 6.4 7.1
- 7.2 7.3 7.4
- 2.3 2.4

d ₁ Ø _{p7} Inch	d ₁ Ø _{p7} mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	EDP # or Stock No.	e-Code
	3.00	0.1181	20	62	36	6	0639221	R4703.0
1/8	3.17	0.1250	20	62	36	6	0639238	R4701/8
	3.30	0.1299	20	62	36	6	0639245	R4703.3
	3.50	0.1378	20	62	36	6	0639252	R4703.5
9/64	3.57	0.1406	20	62	36	6	0639269	R4709/64
	3.80	0.1496	24	66	36	6	0639276	R4703.8
5/32	3.97	0.1563	24	66	36	6	0639283	R4705/32
	4.00	0.1575	24	66	36	6	0639290	R4704.0
	4.20	0.1654	24	66	36	6	0639306	R4704.2
11/64	4.37	0.1719	24	66	36	6	0639313	R47011/64
	4.50	0.1772	24	66	36	6	0639320	R4704.5
3/16	4.76	0.1875	28	66	36	6	0639337	R4703/16
	4.80	0.1890	28	66	36	6	0639344	R4704.8
	5.00	0.1969	28	66	36	6	0639351	R4705.0
13/64	5.16	0.2031	28	66	36	6	0639368	R47013/64
	5.50	0.2165	28	66	36	6	0639375	R4705.5
7/32	5.56	0.2188	28	66	36	6	0639382	R4707/32
	5.80	0.2283	28	66	36	6	0639399	R4705.8
15/64	5.95	0.2344	28	66	36	6	0639405	R47015/64
	6.00	0.2362	28	66	36	6	0639412	R4706.0
1/4	6.35	0.2500	34	79	36	8	0639429	R4701/4
	6.50	0.2559	34	79	36	8	0639436	R4706.5
17/64	6.75	0.2656	34	79	36	8	0639443	R47017/64
	6.80	0.2677	34	79	36	8	0639450	R4706.8
	7.00	0.2756	34	79	36	8	0639467	R4707.0
9/32	7.14	0.2813	41	79	36	8	0639474	R4709/32

d ₁ Ø _{p7} Inch	d ₁ Ø _{p7} mm	d ₁ decimal Inch	l ₂ mm	l ₁ mm	l ₃ mm	d ₂ Ø mm	EDP # or Stock No.	e-Code
	7.50	0.2953	41	79	36	8	0639481	R4707.5
19/64	7.54	0.2969	41	79	36	8	0639498	R47019/64
	7.80	0.3071	41	79	36	8	0639504	R4707.8
5/16	7.94	0.3125	41	79	36	8	0639511	R4705/16
	8.00	0.3150	41	79	36	8	0639528	R4708.0
21/64	8.33	0.3281	47	89	40	10	0639535	R47021/64
	8.50	0.3346	47	89	40	10	0639542	R4708.5
11/32	8.73	0.3437	47	89	40	10	0639559	R47011/32
	9.00	0.3543	47	89	40	10	0639566	R4709.0
23/64	9.13	0.3594	47	89	40	10	0639573	R47023/64
	9.50	0.3740	47	89	40	10	0639580	R4709.5
3/8	9.52	0.3750	47	89	40	10	0639597	R4703/8
	9.80	0.3858	47	89	40	10	0639603	R4709.8
25/64	9.92	0.3906	47	89	40	10	0639610	R47025/64
	10.00	0.3937	47	89	40	10	0639627	R47010.0
	10.30	0.4055	55	102	45	12	0639634	R47010.3
13/32	10.32	0.4063	55	102	45	12	0639641	R47013/32
	10.50	0.4134	55	102	45	12	0639658	R47010.5
27/64	10.72	0.4219	55	102	45	12	0639665	R47027/64
	11.00	0.4331	55	102	45	12	0639672	R47011.0
7/16	11.11	0.4375	55	102	45	12	0639689	R4707/16
	11.50	0.4528	55	102	45	12	0639696	R47011.5
29/64	11.51	0.4531	55	102	45	12	0639702	R47029/64
	11.80	0.4646	55	102	45	12	0639719	R47011.8
	12.00	0.4724	55	102	45	12	0639726	R47012.0

Drilling Hints and Tips

with Elect APP™ drills for deep holes

Deep hole drilling with pilot hole ($>12 \times \text{Ø}$ only)

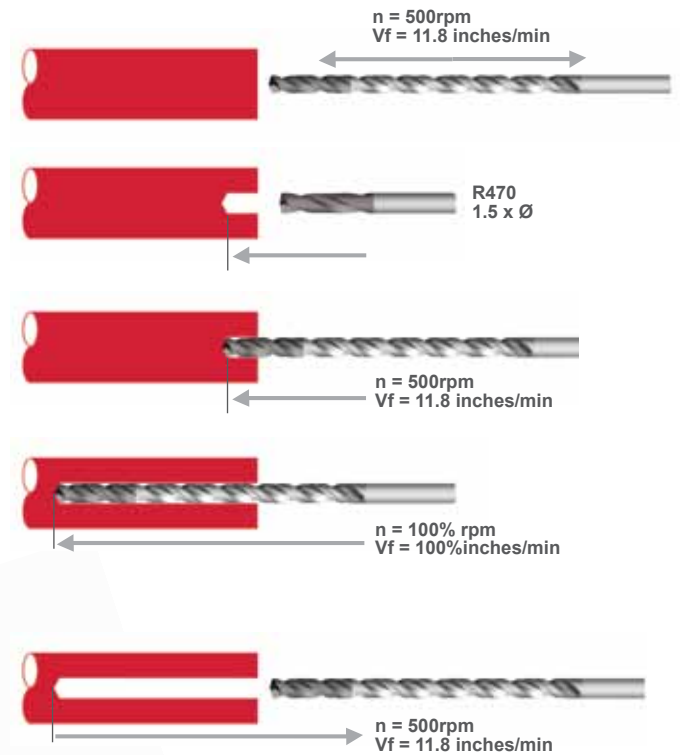
Do not run the drill at greater than 500rpm and 11.8 inches/min when outside a pilot hole.

1) Pilot drill $1.5 \times \text{Ø}$.

2) Engage deep hole drill at low speed/feed (500rpm and 11.8 inches/min) to 1mm (0.04") above depth of pilot.

3) Turn on coolant (min 290 PSI), recommended speed and feed to full depth - no pecking required.

4) Remove drill at low speed and feed (500rpm and 11.8 inches/min).



R470 - Pilot Drill



Deep hole drilling with cross hole

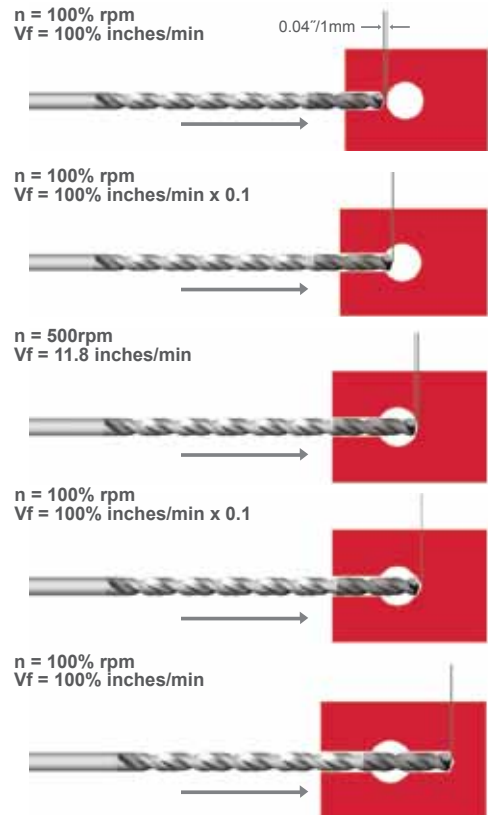
Drill at recommended speed and feed until 0.04" (1mm) from cross hole.

Break into cross hole at recommended speed and with recommended feed x 0.1.

When outer corners of the drill have fully entered cross hole, use 500rpm and 11.8 inches/min to move across the hole.

Stop before drill comes into contact with opposite surface, then use recommended speed and 0.1 x recommended feed.

When outer corners of the drill are fully engaged, use recommended speed and feed to continue drilling.

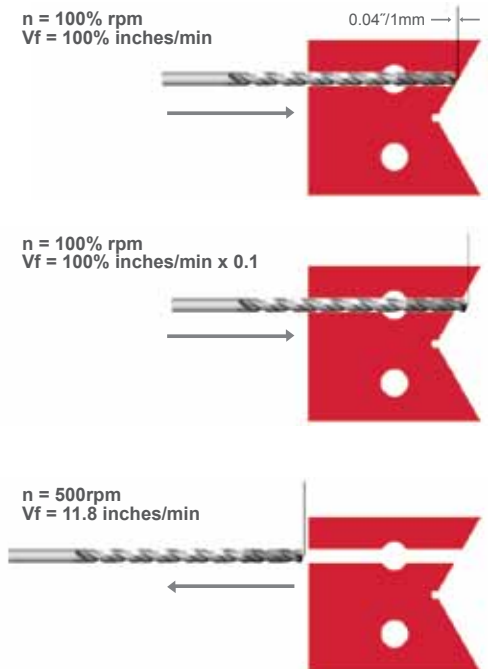


Deep hole drilling exit on angled face

Drill at recommended speed and feed until 0.04" (1mm) from angled face.

Break across angled face at recommended speed and with 0.1 x recommended feed.

When outer corners of drill have fully cleared angled face, retract at 500rpm and 11.8 inches/min.



For other applications in deep hole drilling, please contact your Precision Dormer technical sales representative.

