

Technical Section - Deep Hole Drilling Guidelines

For use with APX Drills 8xD & greater (Depths to Diameter)



T-A & BENZ T-A

BENZSYS

APX

Revolution & Core Drill

ASC 320 Solid Carbide

AccuPort 432

Criterion

Thread Milling

Special Tooling

1



Approach
50RPM Max
300 mm/min

Coolant Off

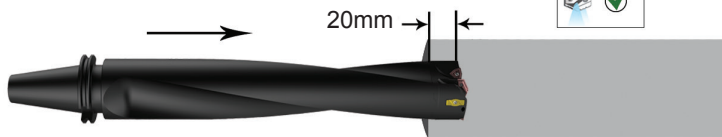


Feed the longer drill within 1.5 mm short of the workpiece at a maximum of 50 RPM and 300 mm/min feed rate

2

Feed In
Speed at 75% of recommended start
Feed at 50% of recommended start

Coolant On

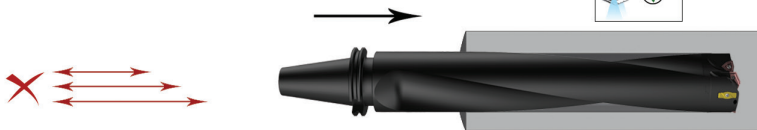


Drill 20mm deep at 75% recommended speed and 50% recommended feed to establish hole

3

Deep Hole Drilling - Blind
100% RPM
100% mm/rev

Coolant On



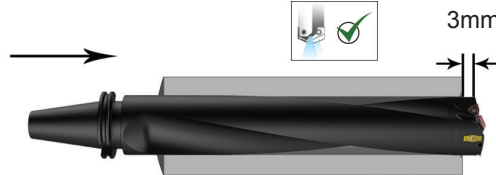
Drill to full depth at recommended speed and feed for longer drills, according to Allied speed and feed charts

No peck cycle recommended

4

Deep Hole Drilling - At Breakout
50% RPM
100% mm/rev

Coolant On



* For Through Holes Only*

- Reduce speed by 50% prior to breakout

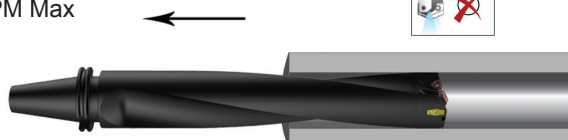
- Do not breakout more than 3 mm past the full diameter of drill

5



Drill Retract
50 RPM Max

Coolant Off



Reduce speed to maximum of 50 RPM before retracting from hole

WARNING Tool failure can cause serious injury. To prevent:

NEVER rotate these tool holders more than 50RPM without proper engagement with a workpiece or fixture. Failure to do so could result in tool failure and/or personal injury. Visit www.alliedmaxcut.com for the most up-to-date information and procedures. Technical assistance is also available for your specific applications.