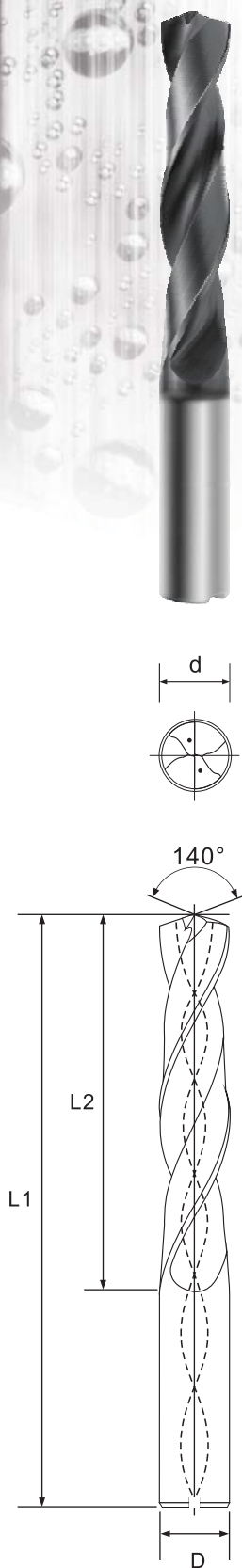




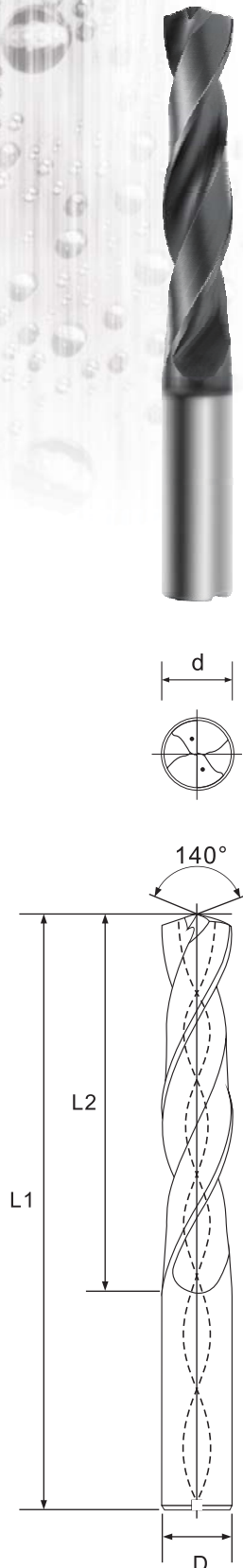
nAcro 3SDC Solid Coolant Drill



Model	Diameter d	Length of Cut L2	Shank Diameter D	Full Length L1
3SDC0412	4.1	25	5	78L
3SDC0422	4.2	25	5	78L
3SDC0432	4.3	25	5	78L
3SDC0442	4.4	25	5	78L
3SDC0452	4.5	25	5	78L
3SDC0462	4.6	28	5	78L
3SDC0472	4.7	28	5	78L
3SDC0482	4.8	28	5	78L
3SDC0492	4.9	28	5	78L
3SDC0502	5	28	5	78L
3SDC0512	5.1	31	6	82L
3SDC0522	5.2	31	6	82L
3SDC0532	5.3	31	6	82L
3SDC0542	5.4	31	6	82L
3SDC0552	5.5	31	6	82L
3SDC0562	5.6	33	6	82L
3SDC0572	5.7	33	6	82L
3SDC0582	5.8	33	6	82L
3SDC0592	5.9	33	6	82L
3SDC0602	6	33	6	82L
3SDC0612	6.1	36	7	88L
3SDC0622	6.2	36	7	88L
3SDC0632	6.3	36	7	88L
3SDC0642	6.4	36	7	88L
3SDC0652	6.5	36	7	88L
3SDC0662	6.6	39	7	88L
3SDC0672	6.7	39	7	88L
3SDC0682	6.8	39	7	88L
3SDC0692	6.9	39	7	88L
3SDC0702	7	39	7	88L
3SDC0712	7.1	42	8	94L
3SDC0722	7.2	42	8	94L
3SDC0732	7.3	42	8	94L
3SDC0742	7.4	42	8	94L
3SDC0752	7.5	42	8	94L
3SDC0762	7.6	44	8	94L
3SDC0772	7.7	44	8	94L
3SDC0782	7.8	44	8	94L
3SDC0792	7.9	44	8	94L
3SDC0802	8	44	8	94L
3SDC0812	8.1	47	9	100L
3SDC0822	8.2	47	9	100L
3SDC0832	8.3	47	9	100L
3SDC0842	8.4	47	9	100L
3SDC0852	8.5	47	9	100L
3SDC0862	8.6	50	9	100L
3SDC0872	8.7	50	9	100L
3SDC0882	8.8	50	9	100L
3SDC0892	8.9	50	9	100L
3SDC0902	9	50	9	100L
3SDC0912	9.1	53	10	106L
3SDC0922	9.2	53	10	106L
3SDC0932	9.3	53	10	106L
3SDC0942	9.4	53	10	106L
3SDC0952	9.5	53	10	106L
3SDC0962	9.6	55	10	106L
3SDC0972	9.7	55	10	106L
3SDC0982	9.8	55	10	106L
3SDC0992	9.9	55	10	106L
3SDC1002	10	55	10	106L



nACro 3SDC Solid Coolant Drill



Model	Diameter d	Length of Cut L2	Shank Diameter D	Full Length L1
3SDC1012	10.1	58	11	116L
3SDC1022	10.2	58	11	116L
3SDC1032	10.3	58	11	116L
3SDC1042	10.4	58	11	116L
3SDC1052	10.5	58	11	116L
3SDC1062	10.6	61	11	116L
3SDC1072	10.7	61	11	116L
3SDC1082	10.8	61	11	116L
3SDC1092	10.9	61	11	116L
3SDC1102	11	61	11	116L
3SDC1112	11.1	64	12	122L
3SDC1122	11.2	64	12	122L
3SDC1132	11.3	64	12	122L
3SDC1142	11.4	64	12	122L
3SDC1152	11.5	64	12	122L
3SDC1162	11.6	66	12	122L
3SDC1172	11.7	66	12	122L
3SDC1182	11.8	66	12	122L
3SDC1192	11.9	66	12	122L
3SDC1202	12	66	12	122L
3SDC1212	12.1	69	13	128L
3SDC1222	12.2	69	13	128L
3SDC1232	12.3	69	13	128L
3SDC1242	12.4	69	13	128L
3SDC1252	12.5	69	13	128L
3SDC1262	12.6	72	13	128L
3SDC1272	12.7	72	13	128L
3SDC1282	12.8	72	13	128L
3SDC1292	12.9	72	13	128L
3SDC1302	13	72	13	128L
3SDC1312	13.1	75	14	134L
3SDC1322	13.2	75	14	134L
3SDC1332	13.3	75	14	134L
3SDC1342	13.4	75	14	134L
3SDC1352	13.5	75	14	134L
3SDC1362	13.6	77	14	134L
3SDC1372	13.7	77	14	134L
3SDC1382	13.8	77	14	134L
3SDC1392	13.9	77	14	134L
3SDC1402	14	77	14	134L
3SDC1412	14.1	80	15	140L
3SDC1422	14.2	80	15	140L
3SDC1432	14.3	80	15	140L
3SDC1442	14.4	80	15	140L
3SDC1452	14.5	80	15	140L
3SDC1462	14.6	83	15	140L
3SDC1472	14.7	83	15	140L
3SDC1482	14.8	83	15	140L
3SDC1492	14.9	83	15	140L
3SDC1502	15	83	15	140L
3SDC1512	15.1	86	16	146L
3SDC1522	15.2	86	16	146L
3SDC1532	15.3	86	16	146L
3SDC1542	15.4	86	16	146L
3SDC1552	15.5	86	16	146L
3SDC1562	15.6	88	16	146L
3SDC1572	15.7	88	16	146L
3SDC1582	15.8	88	16	146L
3SDC1592	15.9	88	16	146L
3SDC1602	16	88	16	146L

nACro nACro Drills with Coolant-hole

Drilling in wet condition

nACro nACro Drills with Coolant-hole

Work Material	Structural Steels, Carbon Steels, Cast Irons SS,SC,FC		Alloy Steels, Pre-hardened Steels SCM,NAK		Mold Steels, Hardened Steels (30~40HRC)		Hardened Steels (40~50HRC)		Ductile Cast Irons (FCD450)	
	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min
Drill Dia. (mm)										
5	9600	1700	6400	1100	4500	780	3200	480	6400	640
8	6000	1600	4000	1100	2800	750	2000	460	4000	640
10	4800	1500	3200	1000	2200	710	1600	440	3200	640
12	4000	1500	2700	1000	1900	700	1300	410	2700	640
16	3000	1300	2000	900	1400	630	1000	380	2000	620

nACro nACro Drills with Coolant-hole

Work Material	Structural Steels, Carbon Steels, Cast Irons SS,SC,FC		Alloy Steels, Pre-hardened Steels SCM,NAK		Mold Steels, Hardened Steels (30~40HRC)		Hardened Steels (40~50HRC)		Ductile Cast Irons (FCD450)	
	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min
Drill Dia. (mm)										
5	9600	1550	6400	1000	4500	700	3200	430	6400	580
8	6000	1450	4000	1000	2800	680	2000	400	4000	580
10	4800	1350	3200	900	2200	640	1600	400	3200	580
12	4000	1350	2700	900	1900	630	1300	370	2700	580
16	3000	1200	2000	800	1400	570	1000	340	2000	560

nACro nACro Drills with Coolant-hole

Work Material	Structural Steels, Carbon Steels, Cast Irons SS,SC,FC		Alloy Steels, Pre-hardened Steels SCM,NAK		Mold Steels, Hardened Steels (30~40HRC)		Hardened Steels (40~50HRC)		Ductile Cast Irons (FCD450)	
	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min
Drill Dia. (mm)										
5	9600	1310	6400	840	4500	590	3200	350	6400	420
8	6000	1210	4000	840	2800	570	2000	320	4000	420
10	4800	1110	3200	740	2200	530	1600	320	3200	420
12	4000	1110	2700	740	1900	520	1300	290	2700	420
16	3000	960	2000	640	1400	460	1000	260	2000	400

Drilling in Oil Mist

nACro nACro Drills with Coolant-hole

Work Material	Structural Steels, Carbon Steels, Cast Irons SS,SC,FC		Alloy Steels, Pre-hardened Steels SCM,NAK		Mold Steels, Hardened Steels (30~40HRC)		Hardened Steels (40~50HRC)		Ductile Cast Irons (FCD450)	
	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min
Drill Dia. (mm)										
5	5800	790	3800	520	2700	360	1900	210	3800	380
8	3600	740	2400	500	1700	350	1200	200	2400	380
10	2900	730	1900	470	1300	330	1000	200	1900	370
12	2400	690	1600	460	1100	330	800	180	1600	370
16	1800	620	1200	420	800	270	600	170	1200	370

nACro nACro Drills with Coolant-hole

Work Material	Structural Steels, Carbon Steels, Cast Irons SS,SC,FC		Alloy Steels, Pre-hardened Steels SCM,NAK		Mold Steels, Hardened Steels (30~40HRC)		Hardened Steels (40~50HRC)		Ductile Cast Irons (FCD450)	
	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min
Drill Dia. (mm)										
5	5800	720	3800	470	2700	330	1900	200	3800	340
8	3600	670	2400	460	1700	320	1200	190	2400	340
10	2900	660	1900	420	1300	310	1000	190	1900	330
12	2400	620	1600	420	1100	300	800	170	1600	330
16	1800	560	1200	380	800	250	600	160	1200	330

nACro nACro Drills with Coolant-hole

Work Material	Structural Steels, Carbon Steels, Cast Irons SS,SC,FC		Alloy Steels, Pre-hardened Steels SCM,NAK		Mold Steels, Hardened Steels (30~40HRC)		Hardened Steels (40~50HRC)		Ductile Cast Irons (FCD450)	
	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min	Rotation min ⁻¹	Feed mm/min
Drill Dia. (mm)										
5	5800	580	3800	380	2700	260	1900	150	3800	250
8	3600	530	2400	360	1700	250	1200	140	2400	240
10	2900	520	1900	330	1300	250	1000	140	1900	240
12	2400	480	1600	320	1100	230	800	120	1600	230
16	1800	420	1200	280	800	190	600	110	1200	230