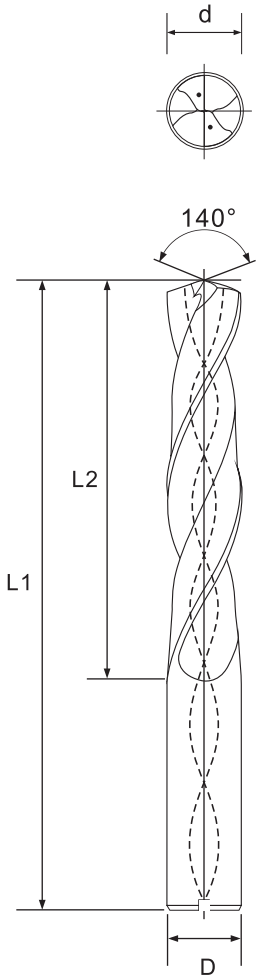
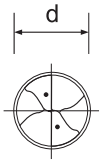
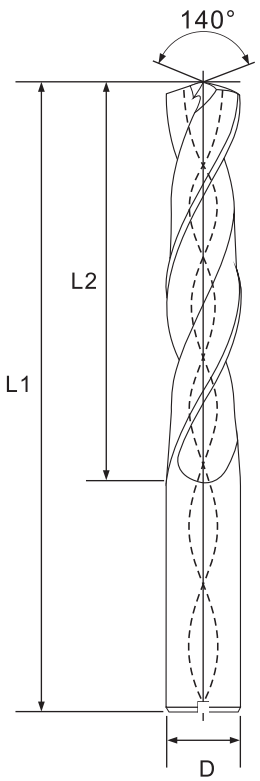


nACro 8SDC Solid Coolant Drill

Mode	Diameter d	Length of Cut L2	Shank Diameter D	Full Length L1
8SDC0302	3	34	6	72L
8SDC0312	3.1	34	6	72L
8SDC0322	3.2	34	6	72L
8SDC0332	3.3	34	6	72L
8SDC0342	3.4	34	6	72L
8SDC0352	3.5	34	6	72L
8SDC0362	3.6	34	6	72L
8SDC0372	3.7	34	6	72L
8SDC0382	3.8	43	6	81L
8SDC0392	3.9	43	6	81L
8SDC0402	4	43	6	81L
8SDC0412	4.1	43	6	81L
8SDC0422	4.2	43	6	81L
8SDC0432	4.3	43	6	81L
8SDC0442	4.4	43	6	81L
8SDC0452	4.5	43	6	81L
8SDC0462	4.6	43	6	81L
8SDC0472	4.7	43	6	81L
8SDC0482	4.8	57	6	95L
8SDC0492	4.9	57	6	95L
8SDC0502	5	57	6	95L
8SDC0512	5.1	57	6	95L
8SDC0522	5.2	57	6	95L
8SDC0532	5.3	57	6	95L
8SDC0542	5.4	57	6	95L
8SDC0552	5.5	57	6	95L
8SDC0562	5.6	57	6	95L
8SDC0572	5.7	57	6	95L
8SDC0582	5.8	57	6	95L
8SDC0592	5.9	57	6	95L
8SDC0602	6	57	6	95L
8SDC0612	6.1	76	8	114L
8SDC0622	6.2	76	8	114L
8SDC0632	6.3	76	8	114L
8SDC0642	6.4	76	8	114L
8SDC0652	6.5	76	8	114L
8SDC0662	6.6	76	8	114L
8SDC0672	6.7	76	8	114L
8SDC0682	6.8	76	8	114L
8SDC0692	6.9	76	8	114L
8SDC0702	7	76	8	114L
8SDC0712	7.1	76	8	114L
8SDC0722	7.2	76	8	114L
8SDC0732	7.3	76	8	114L
8SDC0742	7.4	76	8	114L
8SDC0752	7.5	76	8	114L





nACro 8SDC Solid Coolant Drill

Mode	Diameter d	Length of Cut L2	Shank Diameter D	Full Length L1
8SDC0762	7.6	76	8	114L
8SDC0772	7.7	76	8	114L
8SDC0782	7.8	76	8	114L
8SDC0792	7.9	76	8	114L
8SDC0802	8	76	8	114L
8SDC0812	8.1	95	10	142L
8SDC0822	8.2	95	10	142L
8SDC0832	8.3	95	10	142L
8SDC0842	8.4	95	10	142L
8SDC0852	8.5	95	10	142L
8SDC0862	8.6	95	10	142L
8SDC0872	8.7	95	10	142L
8SDC0882	8.8	95	10	142L
8SDC0892	8.9	95	10	142L
8SDC0902	9	95	10	142L
8SDC0912	9.1	95	10	142L
8SDC0922	9.2	95	10	142L
8SDC0932	9.3	95	10	142L
8SDC0942	9.4	95	10	142L
8SDC0952	9.5	95	10	142L
8SDC0962	9.6	95	10	142L
8SDC0972	9.7	95	10	142L
8SDC0982	9.8	95	10	142L
8SDC0992	9.9	95	10	142L
8SDC1002	10	95	10	142L
8SDC1012	10.1	114	12	162L
8SDC1022	10.2	114	12	162L
8SDC1032	10.3	114	12	162L
8SDC1042	10.4	114	12	162L
8SDC1052	10.5	114	12	162L
8SDC1062	10.6	114	12	162L
8SDC1072	10.7	114	12	162L
8SDC1082	10.8	114	12	162L
8SDC1092	10.9	114	12	162L
8SDC1102	11	114	12	162L
8SDC1112	11.1	114	12	162L
8SDC1122	11.2	114	12	162L
8SDC1132	11.3	114	12	162L
8SDC1142	11.4	114	12	162L
8SDC1152	11.5	114	12	162L
8SDC1162	11.6	114	12	162L
8SDC1172	11.7	114	12	162L
8SDC1182	11.8	114	12	162L
8SDC1192	11.9	114	12	162L
8SDC1202	12	114	12	162L

nACro nACro Drills with Coolant-hole

Drilling in wet condition

nACro nACro Drills with Coolant-hole

Work Material / Drilling Condition / Drill Dia.(mm)	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
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 / Drilling Condition / Drill Dia.(mm)	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
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 / Drilling Condition / Drill Dia.(mm)	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
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 / Drilling Condition / Drill Dia.(mm)	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
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 / Drilling Condition / Drill Dia.(mm)	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
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 / Drilling Condition / Drill Dia.(mm)	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
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