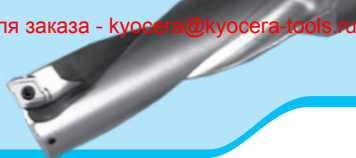


Magic Drill DRZ



DRZ Recommended Cutting Conditions (Coolant)

Workpiece Material	Recommended Insert Grades (Cutting Speed Vc: sfm)										Cutting Diameter ØDc (inch)	Holder Type (Cutting Depth)			
	MEGACOAT			PVD Coated Carbide						Carbide		2D	3D	4D	5D
	PR1230	PR1225	PR1210	PR660	PR830	PR915	PR1025	PR930	PR905	KW10					
	Standard SP SU	Standard SP SU	Standard	Standard SP SU	Standard SP	Standard	Standard SP SU	Standard SP	Standard	Standard SP					
Low Carbon Steel	★	☆	-	☆	☆	☆	☆	☆	-	-	0.512~0.610	.0024~.0039	.0024~.0039	.0016~.0032	-
	400-725	400-725	-	400-725	400-800	400-800	400-725	400-725	-	-	0.630~0.1.024	.0032~.0059	.0032~.0059	.0024~.0047	-
											0.1.063~0.1.968	.0032~.0071	.0032~.0059	.0024~.0047	.0020~.0035
											0.1.969~	.0032~.0071	.0032~.0059	.0024~.0047	-
Carbon Steel	★	☆	-	☆	☆	☆	☆	☆	-	-	0.512~0.610	.0024~.0039	.0024~.0039	.0016~.0032	-
	325-525	325-525	-	325-525	400-600	400-600	325-525	325-525	-	-	0.630~0.1.024	.0032~.0059	.0032~.0059	.0024~.0047	-
											0.1.063~0.1.968	.0032~.0071	.0032~.0059	.0024~.0047	.0020~.0035
											0.1.969~	.0032~.0071	.0032~.0059	.0024~.0047	-
Alloy Steel	★	☆	-	☆	☆	☆	☆	☆	-	-	0.512~0.610	.0024~.0039	.0024~.0039	.0016~.0032	-
	250-460	250-460	-	250-460	325-525	325-525	250-460	250-460	-	-	0.630~0.1.024	.0032~.0059	.0032~.0059	.0024~.0047	-
											0.1.063~0.1.968	.0032~.0071	.0032~.0059	.0024~.0047	.0020~.0035
											0.1.969~	.0032~.0071	.0032~.0059	.0024~.0047	-
Mold Steel	★	☆	-	☆	☆	☆	☆	☆	-	-	0.512~0.610	.0016~.0032	.0016~.0032	.0012~.0028	-
	230-425	230-425	-	230-425	250-500	250-500	230-425	230-425	-	-	0.630~0.1.024	.0032~.0047	.0024~.0039	.0024~.0032	-
											0.1.063~0.1.968	.0032~.0059	.0024~.0047	.0024~.0039	.0016~.0028
											0.1.969~	.0032~.0059	.0024~.0047	.0024~.0039	-
Stainless Steel (Austenitic related)	☆	★	-	☆	☆	☆	☆	☆	-	-	0.512~0.610	.0016~.0032	.0016~.0032	.0012~.0024	-
	200-400	200-400	-	200-400	230-460	230-460	200-400	200-400	-	-	0.630~0.1.024	.0024~.0039	.0024~.0039	.0016~.0032	-
											0.1.063~0.1.968	.0024~.0039	.0024~.0047	.0016~.0032	.0016~.0028
											0.1.969~	.0024~.0047	.0024~.0047	.0016~.0032	-
Gray Cast Iron	-	-	★	-	-	-	-	-	☆	☆	0.512~0.610	.0032~.0047	.0032~.0039	.0024~.0032	-
			325-500	-	-	-	-	-	325-500	325-400	0.630~0.1.024	.0039~.0.18	.0039~.0059	.0032~.0047	-
											0.1.063~0.1.968	.0039~.0078	.0039~.0.18	.0032~.0059	.0024~.0039
											0.1.969~	.0039~.0078	.0039~.0.18	.0032~.0059	-
Nodular Cast Iron	-	-	★	-	-	-	-	-	☆	☆	0.512~0.610	.0032~.0047	.0032~.0039	.0024~.0032	-
			250-400	-	-	-	-	-	250-400	250-325	0.630~0.1.024	.0039~.0.18	.0039~.0059	.0032~.0047	-
											0.1.063~0.1.968	.0039~.0078	.0039~.0.18	.0032~.0059	.0024~.0039
											0.1.969~	.0039~.0078	.0039~.0.18	.0032~.0059	-
Non-ferrous Metals	-	-	-	-	-	-	-	-	-	★	0.512~0.610	.0024~.0047	.0024~.0039	.0016~.0032	-
										600-2000	0.630~0.1.024	.0032~.0071	.0032~.0059	.0024~.0059	-
											0.1.063~0.1.968	.0032~.0078	.0032~.0071	.0024~.0059	.0020~.0039
											0.1.969~	.0032~.0078	.0032~.0071	.0024~.0059	-
Titanium Alloys	-	-	-	-	-	-	-	-	-	★	0.512~0.610	.0020~.0024	.0020~.0024	.0020~.0024	-
										130-230	0.630~0.1.024	.0020~.0028	.0020~.0028	.0020~.0028	-
											0.1.063~0.1.968	.0024~.0032	.0024~.0032	.0024~.0032	.0016~.0020
											0.1.969~	.0024~.0032	.0024~.0032	.0024~.0032	-

• Apply a sufficient amount of coolant.

★ 1st Recommendation ☆: 2nd Recommendation



Magic Drill DRZ

Drilling