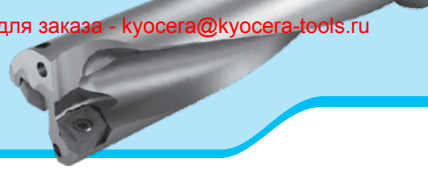




Magic Drill DRX

Metric-Metric (2xD)



● Toolholder Dimensions

Description	Stock	No. of insert	Dimension (mm)					Max. Offset (Radial) (mm)	Spare Parts		Applicable Insert ● Page 25	
			ØDc	L1	L2	L3	Ød		Ød1	Insert Screw		Wrench
												
S40 -DRX390M-2-14 -DRX400M-2-14 -DRX410M-2-14 -DRX420M-2-14 -DRX430M-2-14 -DRX440M-2-14 -DRX450M-2-14 -DRX460M-2-14 -DRX470M-2-14	○	2	39	179	110	78	40	55	+2.8	SB-5090TR	DT-20	ZXMT140408ss
	○		40	181	112	80			+2.5			
	○		41	183	114	82			+2.3			
	○		42	185	116	84			+2.0			
	○		43	187	118	86			+1.8			
	○		44	189	120	88			+1.5			
	○		45	191	122	90			+1.3			
	○		46	193	124	92			+1.0			
	○		47	195	126	94			+0.8			
S40 -DRX480M-2-17 -DRX490M-2-17 -DRX500M-2-17 -DRX510M-2-17 -DRX520M-2-17 -DRX530M-2-17 -DRX540M-2-17 -DRX550M-2-17 -DRX560M-2-17 -DRX570M-2-17 -DRX580M-2-17 -DRX590M-2-17 -DRX600M-2-17	○	2	48	194	125	96	40	60	+3.8	SB-60120TR	DT-25	ZXMT170608ss
	○		49	196	127	98			+3.5			
	○		50	198	129	100			+3.3			
	○		51	200	131	102			+3.0			
	○		52	202	133	104			+2.8			
	○		53	204	135	106			+2.5			
	○		54	206	137	108		+2.3				
	○		55	208	139	110		+2.0				
	○		56	210	141	112		+1.8				
	○		57	212	143	114		+1.5				
	○		58	214	145	116		+1.3				
	○		59	216	147	118		+1.0				
	○		60	218	149	120		+0.8				

● When offset machining, reduce feed rate to .003ipr or less

● See ● Page 77 for Adjustable Sleeve SHE.

● : Stock Standard

○ : World Express

Recommended Cutting Conditions ● Page 35

● Cutting Tolerance (2D Type)

Dc	Cutting Tolerance (mm)	Dc	Cutting Tolerance (mm)	Dc	Cutting Tolerance (mm)
Ø12~Ø26	+0.20	Ø27~Ø38	+0.25	Ø39~Ø60	+0.30
	-0.10		-0.15		-0.20

* Listed tolerance is guideline numbers.

These guideline numbers may be variable depending on machines, workpieces, clamping conditions and cutting conditions.

● Magic Drill (DRX) Hole Bottom Shape (Available for 2xD, 3xD, 4xD and 5xD type) (mm)

ØDc	A	B	C	ØDc	A	B	C	ØDc	A	B	C	
12.0	1.8	4.2	0.5	24.5	3.2	9.1	0.8	39.0	5.8	13.7	1.5	
12.5		4.5		25.0		9.3		40.0		14.2		
13.0		4.7		25.5		9.6		41.0		14.7		
13.5	2	4.8	0.5	26.0	3.9	9.8	1.0	42.0	7.1	15.2	1.6	
14.0		5.0		26.5		9.4		43.0		15.7		
14.5		5.3		27.0		9.6		44.0		16.2		
15.0		5.5		27.5		9.9		45.0		16.7		
15.5		5.8		28.0		10.1		46.0		17.2		
16.0		6.0		28.5		10.4		47.0		17.7		
16.5	2.4	6.3	0.6	29.0	4.7	10.6	1.1	48.0	7.1	16.9	1.7	
17.0		6.5		29.5		10.9		49.0		17.4		
17.5		6.8		30.0		11.1		50.0		17.9		
18.0		7.0		30.5		11.4		51.0		18.4		
18.5		6.9		31.0		11.6		52.0		18.9		
19.0		7.1		31.5		11.9		53.0		19.4		
19.5	3.2	7.4	0.7	32.0	4.7	11.3	1.2	54.0	7.1	19.9	2.0	
20.0		7.6		33.0		11.8		55.0		20.4		
20.5		7.9		34.0		12.3		56.0		20.9		
21.0		8.1		35.0		12.8		57.0		21.4		
21.5		8.4		36.0		13.3		58.0		21.9		
22.0		7.8		37.0		13.8		59.0		22.4		
22.5	3.2	8.1	0.8	38.0	4.7	14.3	1.3	60.0	7.1	22.9	2.1	
23.0		8.3										
23.5		8.6										
24.0	8.8											

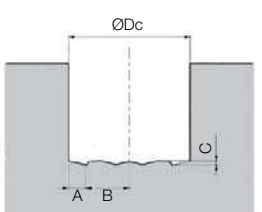


Chart above is for 2xD, 3xD, 4xD, and 5xD drills.
* Figure above are nominal sizes.
(Varies from -0.004" to +0.004" depending on work material and cutting conditions)

Drilling
Magic Drill DRX