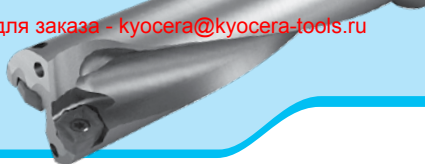




# Magic Drill DRX

Metric-Metric (3xD)



## ● 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-3-14 -DRX400M-3-14 -DRX410M-3-14 -DRX420M-3-14 -DRX430M-3-14 -DRX440M-3-14 -DRX450M-3-14 -DRX460M-3-14 -DRX470M-3-14	○	2	39	218	149	117	40	55	+2.8	SB-5090TR	DT-20	ZXMT140408ss						
	○		40	221	152	120			+2.5									
	○		41	224	155	123			+2.3									
	○		42	227	158	126			+2.0									
	○		43	230	161	129			+1.8									
	○		44	233	164	132			+1.5									
	○		45	236	167	135			+1.3									
	○		46	239	170	138			+1.0									
	○		47	242	173	141			+0.8									
S40 -DRX480M-3-17 -DRX490M-3-17 -DRX500M-3-17 -DRX510M-3-17 -DRX520M-3-17 -DRX530M-3-17 -DRX540M-3-17 -DRX550M-3-17 -DRX560M-3-17 -DRX570M-3-17 -DRX580M-3-17 -DRX590M-3-17 -DRX600M-3-17	○	2	48	242	173	144	40	60	+3.8	SB-60120TR	DT-25	ZXMT170608ss						
	○		49	245	176	147			+3.5									
	○		50	248	179	150			+3.3									
	○		51	251	182	153			+3.0									
	○		52	254	185	156			+2.8									
	○		53	257	188	159			+2.5									
	○		54	260	191	162			+2.3									
	○		55	263	194	165			+2.0									
	○		56	266	197	168			+1.8									
	○		57	269	200	171			+1.5									
	○		58	272	203	174			+1.3									
	○		59	275	206	177			+1.0									
	○		60	278	209	180			+0.8									
	○												65					

- 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 (3D Type)

Dc	Cutting Tolerance (mm)
Ø12~Ø26	+0.20
	-0.10
Ø26.5~Ø38	+0.25
	-0.15
Ø39~Ø60	+0.30
	-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

Drilling