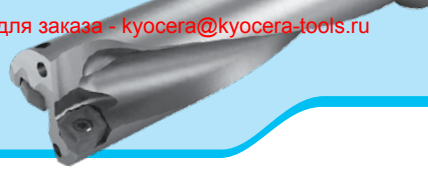


Magic Drill DRX

Metric-Metric (4xD)



● 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	
S40 -DRX390M-4-14 -DRX400M-4-14 -DRX410M-4-14 -DRX420M-4-14 -DRX430M-4-14 -DRX440M-4-14 -DRX450M-4-14 -DRX460M-4-14 -DRX470M-4-14	○	2	39	257	188	156	40	55	+2.8			ZXMT140408○○
	○		40	261	192	160			+2.5			
	○		41	265	196	164			+2.3			
	○		42	269	200	168			+2.0			
	○		43	273	204	172			+1.8			
	○		44	277	208	176			+1.5			
	○		45	281	212	180			+1.3			
	○		46	285	216	184			+1.0			
	○		47	289	220	188			+0.8			
	S50 -DRX480M-4-17 -DRX490M-4-17 -DRX500M-4-17 -DRX510M-4-17 -DRX520M-4-17 -DRX530M-4-17 -DRX540M-4-17 -DRX550M-4-17 -DRX560M-4-17 -DRX570M-4-17 -DRX580M-4-17 -DRX590M-4-17 -DRX600M-4-17		○	2	48	290			221			
○		49	294		225	196	+3.5					
○		50	298		229	200	+3.3					
○		51	302		233	204	+3.0					
○		52	306		237	208	+2.8					
○		53	310		241	212	+2.5					
○		54	314		245	216	+2.3					
○		55	318		249	220	+2.0					
○		56	322		253	224	+1.8					
○		57	326		257	228	+1.5					
○		58	330		261	232	+1.3					
○		59	334		265	236	+1.0					
○		60	338		269	240	+0.8					

- When offset machining, reduce feed rate to .002ipr or less
- See ● Page 77 for Adjustable Sleeve SHE.

● : Stock Standard
○ : World Express

Recommended Cutting Conditions ● Page 35

● DRX Cutting Tolerance (3D Type)

Dc	Cutting Tolerance (mm)
Ø12~Ø26	+0.25
	-0.10
Ø27~Ø38	+0.30
	-0.15
Ø39~Ø60	+0.35
	-0.20

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

● DRX Cutting Tolerance (5D Type)

Dc	Cutting Tolerance (mm)	Dc	Cutting Tolerance (mm)	Dc	Cutting Tolerance (mm)
Ø14~Ø26	+0.30	Ø27~Ø38	+0.35	Ø39~Ø60	+0.40
	-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

Drilling