

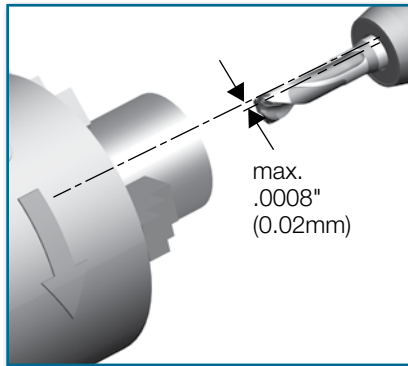
Magic Drill DRC



Precautions for Use

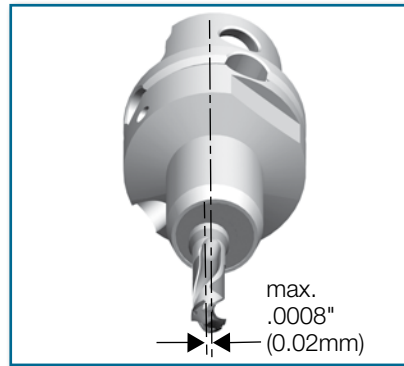
● Core Deviation

1) If drill is stationary



The max runout between the drill and spindle should not exceed 0.0008.

2) If drill is rotating



The max runout allowable on the drill is 0.0008



Magic Drill DRC

Drilling

Applicable Workpieces

Application	Workpiece Shape	Caution for machining
Flat Face		<ol style="list-style-type: none"> Due to good chip control, peck drilling is not necessary for soft steel like 1015. When machining 304, for hole depths of more than 2.5D, utilize the step machining process. In order to have smooth chip removal, we recommend internal coolant.
Stacked Plates		<ol style="list-style-type: none"> Fix stacked plates securely to ensure they do not slip while machining.
Hole Expansion		<ol style="list-style-type: none"> If the overlap amount is less than $1/3 \times D$, machining is possible.
Concave Surface		<ol style="list-style-type: none"> When machining concave holes set the feed rates at half or less than continuous hole machining.
Pipe Material		<ol style="list-style-type: none"> Hole machining above the centerline of the pipe is possible. Do not machine on curved surface areas.

Not Recommended Workpieces

Application	Workpiece Shape
Slanted Surface	

Application	Workpiece Shape
Half Cylindrical	

Application	Workpiece Shape
Cored Hole	