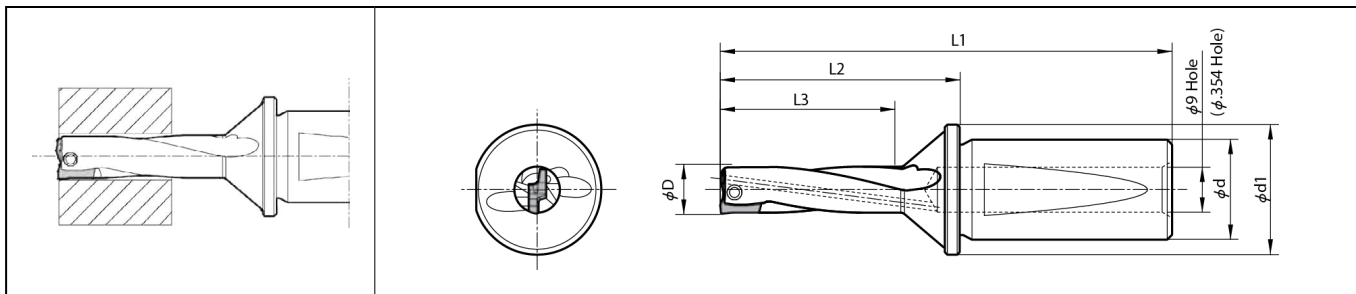




DRS Drills



Toolholder Dimensions

Description	Stock	No. of Insert	Unit	Dimension					Max. Offset (Radial)	Spare Parts			Applicable Inserts ➔ Page 51	
				ØD	L1	L2	L3	Ød		Ød1	Insert Screw	Wrench		
S75 -DRS10035	●	1	inch	0.394 (10.0mm)	3.602	1.909	1.378	0.75	1.023	+0.008	SB-2080TR	FT-6	-	DS100
-DRS10537	●	1		0.413 (10.5mm)	3.657	1.964	1.457	0.75	1.023	+0.008				DS105
-DRS11038	●	1		0.433 (11.0mm)	3.759	2.066	1.516	0.75	1.023	+0.008				DS110
-DRS11540	●	1		0.453 (11.5mm)	3.828	2.135	1.594	0.75	1.023	+0.008	SB-2290TR	DS115		
-DRS12042	●	1		0.472 (12.0mm)	3.898	2.205	1.654	0.75	1.023	+0.008	SB-25100TR	-	DT-7	DS120
-DRS12544	●	1		0.492 (12.5mm)	3.967	2.274	1.732	0.75	1.023	+0.008	SB-25100TR	-	DT-7	DS120
S20 -DRS10035	○	1	mm	10.0	92	49	35.0	20	26	+0.2	SB-2080TR	FT-6	-	DS100
-DRS10235	○	1		10.2	92	49	35.0	20	26	+0.2				DS105
-DRS10336	○	1		10.3	92	49	36.0	20	26	+0.2				DS110
-DRS10537	○	1		10.5	93	50	37.0	20	26	+0.2				DS115
-DRS11038	○	1		11.0	96	53	38.5	20	26	+0.2	SB-2290TR	DS115		
-DRS11540	○	1		11.5	97	54	40.5	20	26	+0.2	SB-25100TR	-	DT-7	DS120
-DRS12042	○	1		12.0	99	56	42.0	20	26	+0.2	SB-25100TR	-	DT-7	DS120
-DRS12544	○	1		12.5	101	58	44.0	20	26	+0.2	SB-25100TR	-	DT-7	DS120

● : Stock Standard
○ : World Express

DRS Recommended Cutting Conditions

Workpiece Material	Recommended Grade (sfm)			Feed Rate (ipr)
	MEGACOAT		PVD Coated Carbide	
	PR1230	PR1210	PR660	
Low Carbon Steel	★ 270~330	-	☆ 270~330	.0024
Carbon Steel	★ 270~330	-	☆ 270~330	.003~.004
Alloy Steel	★ 270	-	☆ 270	.0016~.0024
Mold Steel	★ 270	-	☆ 270	.0016~.0024
Stainless Steel (Austenitic related)	★ 230~270	-	☆ 230~270	.002~.0024
Gray Cast Iron	-	★ 80~100	-	.003~.004

- Apply a sufficient amount of coolant.
- If cutting speed is decreased too much from above condition, chip evacuation will deteriorate.
If the feed rate is increased too much from above condition, inner edge chip evacuation will deteriorate.
If the feed rate is decreased too much from above condition, outer edge chip evacuation will deteriorate.
- If chips become long and are entangled with the tool when low carbon steel cutting, increase the cutting speed to 400-500 SFM.
If this doesn't solve the problem, try peck feeding.
[How to peck feed]
(1)Cut .04-.08 in (2)Return .004 in (3)Repeat (1)and (2)

Small Dia. Magic Drill (DRS) • Hole Bottom Shape (inch)

ØD	A	B	C
0.394	0.087	0.110	0.008
0.402	0.087	0.114	0.008
0.406	0.091	0.114	0.008
0.413	0.091	0.118	0.008
0.433	0.094	0.122	0.008
0.453	0.098	0.126	0.008
0.472	0.110	0.126	0.012
0.492	0.114	0.130	0.016

