
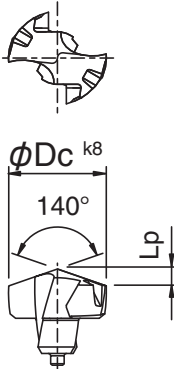


MagicDrill® Insert for DRC

Insert	Description	Dimension (mm)		PVD Coated Carbide	Applicable Toolholder ➔ K7~K9, K12~K14									
		øDc	Lp	PR0315										
  <table border="1" data-bbox="360 974 572 1243"> <caption>k8 tolerance</caption> <thead> <tr> <th>øDc</th> <th>k8(mm)</th> </tr> </thead> <tbody> <tr> <td>7.94 10.00</td> <td>+0.022 0</td> </tr> <tr> <td>10.10 18.00</td> <td>+0.027 0</td> </tr> <tr> <td>18.10 25.50</td> <td>+0.033 0</td> </tr> </tbody> </table> <p data-bbox="360 1249 572 1321">k8 is the dimension tolerance of the insert. It is not the dimension tolerance of the cutting diameter.</p>	øDc	k8(mm)	7.94 10.00	+0.022 0	10.10 18.00	+0.027 0	18.10 25.50	+0.033 0	DC	1900M-SC	19.00	3.46	●	SS20-DRC190M-O SF25-DRC190M-O
	øDc	k8(mm)												
	7.94 10.00	+0.022 0												
	10.10 18.00	+0.027 0												
	18.10 25.50	+0.033 0												
	1910M-SC	19.10	3.47	●										
	1920M-SC	19.20	3.49	●										
	1930M-SC	19.30	3.51	●										
	1940M-SC	19.40	3.53	●										
	1950M-SC	19.50	3.55	●										
	1960M-SC	19.60	3.56	●										
	1970M-SC	19.70	3.58	●										
	1980M-SC	19.80	3.60	●										
	1990M-SC	19.90	3.62	●										
	DC	2000M-SC	20.00	3.64	●	SS25-DRC200M-O SF25-DRC200M-O								
	2010M-SC	20.10	3.66	●										
	2020M-SC	20.20	3.67	●										
	2030M-SC	20.30	3.69	●										
	2040M-SC	20.40	3.71	●										
	2050M-SC	20.50	3.73	●										
	2060M-SC	20.60	3.75	●										
	2070M-SC	20.70	3.77	●										
	2080M-SC	20.80	3.78	●										
	2090M-SC	20.90	3.80	●										
	2099M-SC	20.99	3.82	●										
	DC	2100M-SC	21.00	3.82	●	SS25-DRC210M-O SF25-DRC210M-O								
	2150M-SC	21.50	3.91	●										
	2200M-SC	22.00	4.00	●	SS25-DRC220M-O SF25-DRC220M-O									
	2250M-SC	22.50	4.09	●										
	2300M-SC	23.00	4.18	●	SS25-DRC230M-O SF25-DRC230M-O									
2350M-SC	23.50	4.27	●											
2400M-SC	24.00	4.37	●	SS25-DRC240M-O SF25-DRC240M-O										
2450M-SC	24.50	4.46	●											
2500M-SC	25.00	4.55	●	SS32-DRC250M-O SF25-DRC250M-O										
2550M-SC	25.50	4.64	●											

K



Drilling

Q&A

- Q-1** Is re-grinding possible?
- A-1** We don't recommend it. Grinding of edge nose chisel is not possible.
- Q-2** How large would the cutting hole be to the insert diameter (øDc)?
- A-2** The machining hole with SCM 435, comparing to the insert diameter(øDc), will be about +0.020~+0.040mm.

K6

DC inserts are sold in 1 piece boxes

● : Std. Item