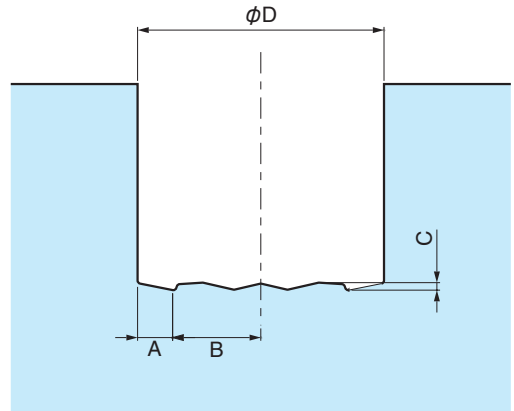
DRZ Hole Bottom Shape (Available for 2xD, 3xD, 4xD, 5xD type) (mm)

øD	A	B	C
13.0	2.1	4.4	0.4
13.5		4.7	
14.0		4.9	
14.5		5.2	
15.0		5.4	0.5
15.5		5.7	
16.0	2.7	5.3	0.6
16.5		5.6	
17.0		5.8	
17.5		6.1	
18.0		6.3	
18.5		6.6	0.7
19.0		6.8	
19.5		7.1	
20.0		7.3	
20.5		7.6	
21.0		7.8	0.8

øD	A	B	C
21.5	3.1	7.7	0.6
22.0		7.9	
22.5		8.2	
23.0		8.4	
23.5		8.7	0.7
24.0		8.9	
24.5		9.2	
25.0		9.4	
25.5		9.7	
26.0		9.9	
26.5		10.2	
27.0	4.0	9.5	0.7
27.5		9.8	
28.0		10.0	
28.5		10.3	
29.0		10.5	
29.5		10.8	0.8
30.0		11.0	
30.5		11.3	
31.0		11.5	
31.5		11.8	
32.0		12.0	
32.5		12.3	

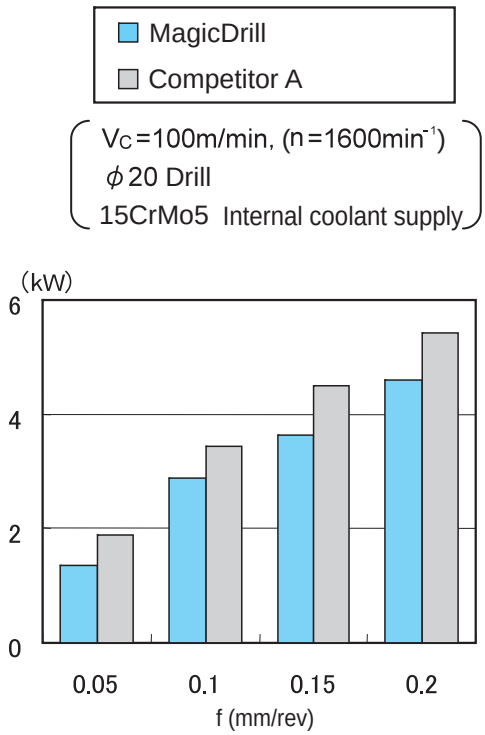
øD	A	B	C
33.0	5.7	10.8	0.8
34.0		11.3	
35.0		11.8	
36.0		12.3	
37.0		12.8	
38.0		13.3	0.9
39.0		13.8	
40.0		14.3	
41.0	6.5	14.0	1.0
42.0		14.5	
43.0		15.0	
44.0		15.5	
45.0		16.0	
46.0		16.5	
47.0		17.0	
48.0		17.5	1.1
49.0		18.0	
50.0		18.5	
51.0		19.0	
52.0		19.5	
53.0		20.0	
54.0	8.5	18.5	1.2
55.0		19.0	
56.0		19.5	
57.0		20.0	
58.0		20.5	
59.0		21.0	



* Above amount is standard value
(Varies within ±0.1mm depending on workpiece materials and cutting conditions)

Required Power

■ ø20 Cutting Power Comparison



■ Case Study

MagicDrill Dia.		ø16	ø27	ø50	ø50
Machine		Competitor A	Competitor B	Competitor C	Competitor D
Machine Power		AC 5.5 / 7.5 kW	AC 5.5 / 7.5 kW	AC 5.5 / 7.5 kW	AC 5.5 / 7.5 kW
Cutting Conditions	Vc (m/min)	150	130 / 150	120	110 / 157
	f (mm/rev)	0.06	0.13	0.1	0.08 / 0.12
Workpiece Material		1.0040 - St42-2	1.7220 - 34CrMo4	1.7262 - 15CrMo5	1.0040 - St42-2
Required Power (Load Meter values)		60%	80% / 95%	100%	60% / 100%
Remarks		-	-	With conventional drill, limited up to ø40	-

Formula for calculating required power (approximate value) R33