

MAGIC - CENTER DRILLS FORM A (60°)

Cutting Condition								
RTDC60								
Material	Mild Steels		Alloys Steels				Stainless Steels	
Strength	< 700 N/mm		~HRC 23		~HRC 32			
Diameter	SPEED	FEED	SPEED	FEED	SPEED	FEED	SPEED	FEED
1.0	30~50	0.01~0.03	30~50	0.01~0.03	20~40	0.01~0.03	15~25	0.01~0.03
2.0		0.01~0.035		0.01~0.035		0.01~0.035		0.01~0.035
3.0		0.015~0.05		0.015~0.05		0.015~0.05		0.015~0.05
4.0		0.02~0.06		0.02~0.06		0.02~0.06		0.02~0.06
5.0		0.03~0.07		0.03~0.07		0.03~0.07		0.03~0.07
6.0		0.04~0.07		0.04~0.07		0.04~0.07		0.04~0.07

SPEED(Shank Dia)=m/min

FEED(Drill Dia)=mm/rev

ECO-CUT

WIDE-CUT

HARD-CUT

ALU-CUT

D-CUT

SUS CUT

MAGIC DRILLS