

MAGIC DRILLS - NC-SPOTTING 90°

Cutting Condition																
RTDN90 / RTDN120 / RTDN142																
Material	Non Alloy Steels		Alloy Steels		Soft Grey Cast Iron		Hard grey cast iron		Stainless Steels		Al-Si Alloys, Si<10%		Al-Si Alloys, Si>10%		Ti, Ni Alloys Steels	
Strength	< 700 N/mm		< 1000 N/mm		<HB240,GG25		<HB300,GG40									
Drilling Speed	65~75 m/min		45~55 m/min		80~100 m/min		50~70 m/min		30~40 m/min		150~170 m/min		110~130 m/min		33~38 m/min	
Diameter	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6.0	3,900	0.080	2,850	0.080	5,200	0.090	3,800	0.090	2,000	0.070	8,800	0.110	7,100	0.110	1,950	0.070
8.0	2,900	0.100	2,150	0.100	3,900	0.120	2,850	0.120	1,500	0.090	6,600	0.150	5,350	0.150	1,450	0.090
10.0	2,350	0.120	1,700	0.120	3,100	0.160	2,300	0.160	1,200	0.110	5,300	0.190	4,250	0.190	1,200	0.110
12.0	1,950	0.140	1,450	0.140	2,600	0.200	1,900	0.200	1,000	0.130	4,450	0.230	3,550	0.230	980	0.130
16.0	1,450	0.170	1,100	0.170	1,950	0.240	1,450	0.240	755	0.170	3,300	0.270	2,650	0.270	735	0.170
20.0	1,150	0.190	850	0.190	1,550	0.280	1,150	0.280	590	0.200	2,650	0.310	2,150	0.310	590	0.200

N=R.P.M

S=Feed per Revolution(mm/rev.)

ECO-CUT

WIDE-CUT

HARD-CUT

ALU-CUT

D-CUT

SUS CUT

MAGIC DRILLS