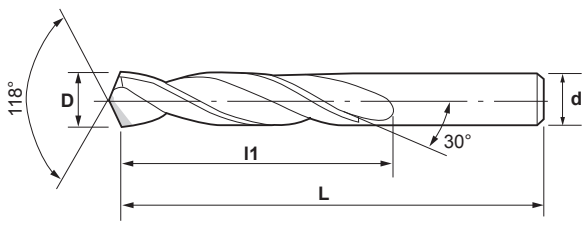
METRIC

Beam Drill - Twist

VN-DTD & VN-DTDL Type

- Solid Carbide with Mono-block diamond twist drill.
- 30° Helix.



VN-DTD

CATALOG NUMBER	STK	DIMENSIONS			
		D	l1	L	d
VN-DTD-092	☐	9.2	80	200	9.2
VN-DTD-093	☐	9.3	80	200	9.3
VN-DTD-094	☐	9.4	80	200	9.4
VN-DTD-095	•	9.5	80	200	9.5
VN-DTD-096	☐	9.6	80	200	9.6
VN-DTD-097	☐	9.7	80	200	9.7
VN-DTD-098	☐	9.8	80	200	9.8
VN-DTD-099	☐	9.9	80	200	9.9
VN-DTD-100	•	10.0	80	200	10.0
VN-DTD-101	☐	10.1	80	200	10.1
VN-DTD-102	☐	10.2	80	200	10.2
VN-DTD-103	☐	10.3	80	200	10.3
VN-DTD-104	☐	10.4	80	200	10.4
VN-DTD-105	•	10.5	80	200	10.5
VN-DTD-106	☐	10.6	80	200	10.6
VN-DTD-107	☐	10.7	80	200	10.7
VN-DTD-108	☐	10.8	80	200	10.8
VN-DTD-109	☐	10.9	80	200	10.9
VN-DTD-110	•	11.0	120	250	11.0
VN-DTD-111	☐	11.1	120	250	11.1
VN-DTD-112	☐	11.2	120	250	11.2
VN-DTD-113	☐	11.3	120	250	11.3
VN-DTD-114	☐	11.4	120	250	11.4
VN-DTD-115	•	11.5	120	250	11.5
VN-DTD-116	☐	11.6	120	250	11.6
VN-DTD-117	☐	11.7	120	250	11.7
VN-DTD-118	☐	11.8	120	250	11.8
VN-DTD-119	☐	11.9	120	250	11.9
VN-DTD-120	•	12.0	120	250	12.0

VN-DTDL

CATALOG NUMBER	STK	DIMENSIONS			
		D	l1	L	d
VN-DTDL-012	☐	1.2	20	150	1.2
VN-DTDL-015	☐	1.5	20	150	1.5
VN-DTDL-018	☐	1.8	20	150	1.8
VN-DTDL-020	☐	2.0	30	150	2.0
VN-DTDL-022	☐	2.2	30	150	2.2
VN-DTDL-025	☐	2.5	30	150	2.5
VN-DTDL-031	☐	3.1	40	150	3.1
VN-DTDL-037	☐	3.7	40	150	3.7
VN-DTDL-043	☐	4.3	40	150	4.3
VN-DTDL-049	☐	4.9	40	150	4.9

- **Stocked standard**
- ☐ **Inquire regarding delivery**

Beam Drill - Cutting Data

METRIC

Recommended Cutting Data for VN-DRD, VN-DTD, VN-DTDL, VN-DFD, VN-DVT

Drill Dia.	Material									
	Aluminum Alloy (Less than 13% Si)		Aluminum Alloy (13%-30% Si)		MMC (Ceramic content up to 30%)		FPR		Copper Alloy, Plastic, Magnesium Alloy	
	min $^{-1}$	mm/rev	min $^{-1}$	mm/rev	min $^{-1}$	mm/rev	min $^{-1}$	mm/rev	min $^{-1}$	mm/rev
0.5	20,000	0.005 ~ 0.01	12,000	0.005 ~ 0.01	10,000	0.005 ~ 0.01	10,000	0.005 ~ 0.01	10,000	0.005 ~ 0.01
1	15,000	0.01 ~ 0.03	10,000	0.01 ~ 0.03	10,000	0.01 ~ 0.03	10,000	0.01 ~ 0.03	10,000	0.01 ~ 0.03
1.5	14,000	0.03 ~ 0.06	9,000	0.03 ~ 0.06	10,000	0.02 ~ 0.05	10,000	0.02 ~ 0.05	10,000	0.02 ~ 0.05
2	13,000	0.05 ~ 0.15	8,000	0.05 ~ 0.15	8,500	0.02 ~ 0.08	9,000	0.03 ~ 0.06	9,000	0.03 ~ 0.06
3	12,000	0.08 ~ 0.2	8,000	0.08 ~ 0.2	8,000	0.03 ~ 0.1	8,000	0.04 ~ 0.08	8,000	0.04 ~ 0.08
4	12,000	0.1 ~ 0.25	8,000	0.1 ~ 0.25	7,500	0.04 ~ 0.12	7,500	0.06 ~ 0.12	7,500	0.06 ~ 0.12
5	12,000	0.15 ~ 0.3	7,700	0.15 ~ 0.3	6,500	0.5 ~.14	6,500	0.08 ~ 0.15	6,500	0.08 ~ 0.15
6	12,000	0.15 ~ 0.3	6,500	0.15 ~ 0.3	5,300	0.06 ~ 0.15	5,500	0.1 ~ 0.18	5,500	0.1 ~ 0.18
7	12,000	0.15 ~ 0.3	5,500	0.15 ~ 0.3	4,500	0.07 ~ 0.16	5,000	0.12 ~ 0.2	5,000	0.12 ~ 0.2
8	12,000	0.15 ~ 0.3	5,000	0.15 ~ 0.3	4,000	0.08 ~ 0.18	4,500	0.12 ~ 0.2	4,500	0.12 ~ 0.2
9	12,000	0.15 ~ 0.3	4,200	0.15 ~ 0.3	3,500	0.09 ~ 0.19	4,000	0.12 ~ 0.2	4,000	0.12 ~ 0.2
10	10,000	0.15 ~ 0.3	3,800	0.15 ~ 0.3	3,200	0.1 ~ 0.2	3,500	0.12 ~ 0.2	3,500	0.12 ~ 0.2
11	9,000	0.15 ~ 0.3	3,500	0.15 ~ 0.3	3,000	0.11 ~ 0.2	3,000	0.12 ~ 0.2	3,000	0.12 ~ 0.2
12	8,000	0.15 ~ 0.3	3,300	0.15 ~ 0.3	2,800	0.12 ~ 0.2	2,800	0.12 ~ 0.2	2,800	0.12 ~ 0.2

Note: Use VN-DFD type for Aluminum Alloy only and reduce 30% feed speed.