

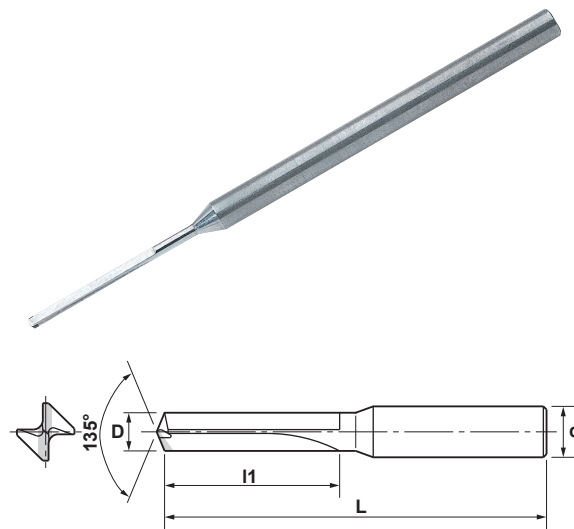
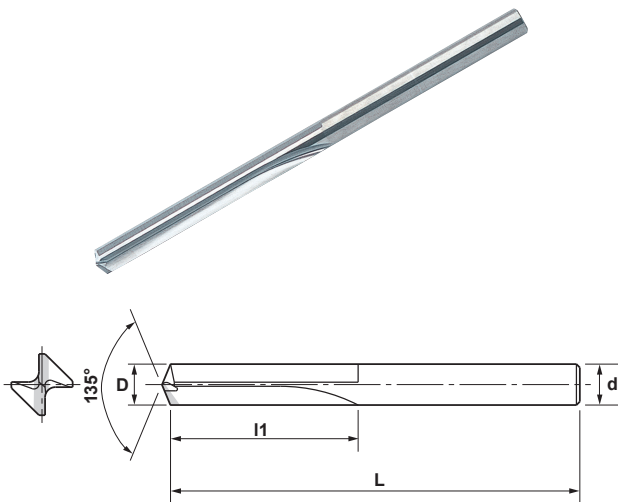


METRIC

Beam Drill - Burnishing

VN-DFD & VN-DVT Type

- VN-DFD - Solid Carbide with Mono-block diamond burnishing drill.
- VN-DVT - Solid Carbide with Mono-block diamond burnishing drill for roll tapping.



VN-DFD

CATALOG NUMBER	STK	DIMENSIONS			
		D	l1	L	d
VN-DFD-102	<input type="checkbox"/>	10.2	70	115	10.2
VN-DFD-103	<input type="checkbox"/>	10.3	70	115	10.3
VN-DFD-104	<input type="checkbox"/>	10.4	70	115	10.4
VN-DFD-105	<input type="checkbox"/>	10.5	70	115	10.5
VN-DFD-106	<input type="checkbox"/>	10.6	70	115	10.6
VN-DFD-107	<input type="checkbox"/>	10.7	70	115	10.7
VN-DFD-108	<input type="checkbox"/>	10.8	70	115	10.8
VN-DFD-109	<input type="checkbox"/>	10.9	70	115	10.9
VN-DFD-110	<input type="checkbox"/>	11.0	70	115	11.0
VN-DFD-111	<input type="checkbox"/>	11.1	70	115	11.1
VN-DFD-112	<input type="checkbox"/>	11.2	70	115	11.2
VN-DFD-113	<input type="checkbox"/>	11.3	70	115	11.3
VN-DRD-114	<input type="checkbox"/>	11.4	70	115	11.4
VN-DFD-115	<input type="checkbox"/>	11.5	70	115	11.5
VN-DFD-116	<input type="checkbox"/>	11.6	80	140	11.6
VN-DFD-117	<input type="checkbox"/>	11.7	80	140	11.7
VN-DFD-118	<input type="checkbox"/>	11.8	80	140	11.8
VN-DFD-119	<input type="checkbox"/>	11.9	80	140	11.9
VN-DFD-120	<input type="checkbox"/>	12.0	80	140	12.0

- Stocked standard
- Inquire regarding delivery

VN-DVT

CATALOG NUMBER	STK	DIMENSIONS				
		D	l1	L	d	Tap Size
VN-DVT-M1	<input type="checkbox"/>	0.88	10	45	3	M1X0.25
VN-DVT-M1.2	<input type="checkbox"/>	1.08	12	45	3	M1.2X0.25
VN-DVT-M1.4	<input type="checkbox"/>	1.254	15	55	3	M1.4X0.30
VN-DVT-M1.6	<input type="checkbox"/>	1.42	18	55	3	M1.6X0.35
VN-DVT-M1.7	<input type="checkbox"/>	1.525	18	55	3	M1.7X0.35
VN-DVT-M2	<input type="checkbox"/>	1.8	20	55	3	M2X0.4
VN-DVT-M2.3	<input type="checkbox"/>	2.1	20	55	3	M2.3X0.4
VN-DVT-M2.5	<input type="checkbox"/>	2.27	22	55	3	M2.5X0.45
VN-DVT-M2.6	<input type="checkbox"/>	2.37	22	55	3	M2.6X0.45
VN-DVT-M3	<input type="checkbox"/>	2.76	22	55	3	M3X0.5
VN-DVT-M3.5	<input type="checkbox"/>	3.195	25	60	4	M3.5X0.6
VN-DVT-M4	<input type="checkbox"/>	3.65	25	60	4	M4X0.7
VN-DVT-M5	<input type="checkbox"/>	4.595	25	70	6	M5X0.8
VN-DVT-M6	<input type="checkbox"/>	5.48	30	80	6	M6X1.0
VN-DVT-M8	<input type="checkbox"/>	7.345	40	90	8	M8X1.25
VN-DVT-M10	<input type="checkbox"/>	9.19	50	110	10	M10X1.5
VN-DVT-M12	<input type="checkbox"/>	11.045	60	120	12	M12X1.75

- Stocked standard
- Inquire regarding delivery

Beam Drill - Cutting Data



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 ~ 1.4	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.