

High-Performance Solid Carbide Drills



Dynapoint TX Drills with Coolant

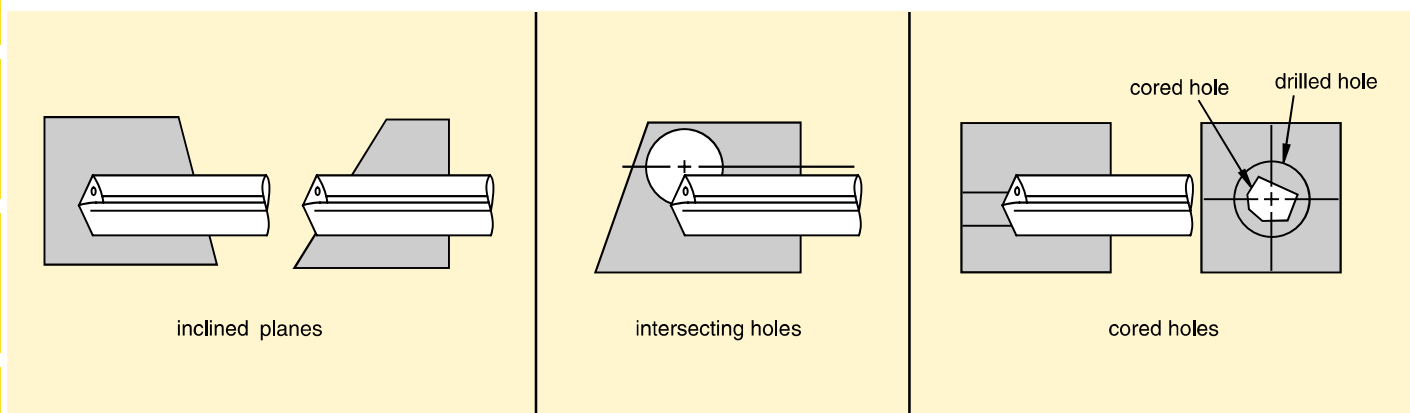
Starting Recommendations

workpiece material group	hardness/type	geometry	grade	sfm	starting recommendation for feed (ipr) by drill diameter													
					.125	.156	.187	.250	.375	.500	.625	.750	.875	1.00				
					3,0	4,0	5,0	6,5	9,5	12,5	16,0	19,0	21,0	25,0				
gray cast irons	(120-320 HB)	TX411	KF1	300	.003	.003	.004	.006	.008	.012	.015	.018	.022	.024	.024			
				360	.004	.005	.006	.008	.012	.015	.018	.022	.024	.028	.028			
				390	.006	.007	.009	.013	.016	.019	.023	.027	.030	.032	.032			
free-machining and low-silicon aluminum alloys	hypoeutectic (<12.2% Si)	TX411	KF1	600	.003	.004	.005	.006	.009	.012	.017	.020	.022	.024	.024			
				750	.004	.005	.006	.008	.011	.015	.020	.022	.024	.030	.030			
				1000	.006	.007	.010	.012	.017	.021	.023	.025	.030	.034	.034			
miscellaneous non-ferrous materials		TX411	KF1	400	.003	.004	.005	.006	.009	.012	.015	.017	.020	.020	.020			
				525	.004	.005	.006	.008	.011	.015	.017	.020	.020	.022	.022			
				700	.006	.007	.010	.012	.015	.018	.020	.022	.022	.024	.024			

NOTES: These are starting condition guidelines only. The machine tool, fixturing, toolholding, part configuration, and coolant capability may significantly influence specific applications. The bold font represents recommended starting parameters. The regular font represents the range of cutting parameters. Use proper and safe machining practices. Make the set-up as rigid as possible. Decrease sfm as material hardness increases.

TX Drill Applications

The excellent stability of the TX drill allows it to be used for drilling through inclined planes, intersecting holes, and cored holes.



- Solid Carbide Drills
- Combination Tools
- Modular Drills
- Indexable Drills
- QpV Drills
- Twist Drills/Taps & Dies
- Counterboring Tools
- Rotating Boring Tools
- Holemaking Tech Data
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