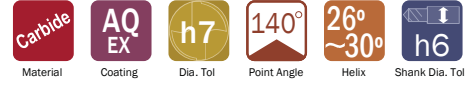


HIGH PERFORMANCE DRILLS

Aqua Drill EX Oil Hole 30D



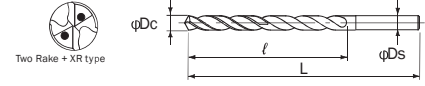
LIST 9620 Metric sizes

LIST 9621 Fractional sizes

• U.S. stock item

■ Special order

NEW



EDP #	Size	Fractional Equivalent	Decimal Equivalent	Flute Length ℓ	Overall Length L	Shank Dia. Ds	Stock	
								Dc
0727150	3.00		0.1181	99	149	4	•	
0732180	3.10		0.1220	116	166		•	
1519464	3.18	1/8	0.1250				•	
0732196	3.20		0.1260				•	
0732201	3.30		0.1299				•	
0732218	3.40		0.1339				•	
0727166	3.50		0.1378				•	
	3.57	9/64	0.1400				•	
0732224	3.60		0.1417				•	
0732230	3.70		0.1457				132	182
0732247	3.80		0.1496			•		
0732253	3.90		0.1535	•				
1519544	3.97	5/32	0.1563	•				
0727172	4.00		0.1575	•				
0732260	4.10		0.1614	149	199	•		
0732276	4.20		0.1654			•		
0732282	4.30		0.1693			•		
	4.37	11/64	0.1718			•		
0732299	4.40		0.1732			•		
0727189	4.50		0.1772			165	215	•
0732304	4.60		0.1811					•
0732310	4.70		0.1850					•
1519550	4.76	3/16	0.1875					•
0732327	4.80		0.1890					•
0732333	4.90		0.1929	•				
0727195	5.00		0.1969	182	232			•
0732340	5.10		0.2008					•
	5.16	13/64	0.2031					•
0732356	5.20		0.2047					•
0732362	5.30		0.2087			•		
0732379	5.40		0.2126			•		
	5.41	#3	0.2129			•		
0727200	5.50		0.2165			•		

EDP #	Size	Fractional Equivalent	Decimal Equivalent	Flute Length ℓ	Overall Length L	Shank Dia. Ds	Stock		
								Dc	ℓ
	5.56	7/32	0.2188	198	248	6	■		
0732385	5.60		0.2205				•		
0732391	5.70		0.2244				•		
0732407	5.80		0.2283				•		
0732413	5.90		0.2323				•		
	5.95	15/64	0.2343				•		
0727217	6.00		0.2361				215	265	•
0732420	6.10		0.2402						•
0732436	6.20		0.2441						•
0732442	6.30		0.2480						•
1519509	6.35	1/4	0.2500	•					
0732459	6.40		0.2520	231	281	•			
0727223	6.50		0.2559			•			
0732465	6.60		0.2598			•			
0732471	6.70		0.2638			•			
	6.75	17/64	0.2656			•			
0732488	6.80		0.2677			•			
0732494	6.90		0.2717			•			
0727230	7.00		0.2756			248	298	•	
0732500	7.10		0.2795					•	
	7.14	9/32	0.2813					•	
0732516	7.20		0.2835	•					
0732522	7.30		0.2874	•					
0732539	7.40		0.2913	•					
0727246	7.50		0.2953	264	314			•	
	7.54	19/64	0.2968					•	
0732545	7.60		0.2992					•	
0732551	7.70		0.3031					•	
0732568	7.80		0.3071			•			
0732574	7.90		0.3110			•			
	7.94	5/16	0.3125			•			
0727252	8.00		0.3150			•			

Drilling Conditions - Wet

L9618, L9619, L9620, L9621 (25D, 30D)

Work Material	Structural Steels Carbon Steels (~200HB)		Alloy Steels Heat Treated Steels (20~30 HRC)		Mold Steels Hardened Steels (30~40 Hrc)		Ductile Cast Irons		Stainless Steel			
	Drilling Dia.											
	Metric	Decimal	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)		
Drill Dia. (mm./inches)	3.0	0.1181	11500	0.004	7600	0.003	6700	0.003	6700	0.004	6700	0.003
	4.0	0.1575	8600	0.005	5700	0.004	5000	0.004	5000	0.005	5000	0.004
	5.0	0.1969	7600	0.006	5100	0.005	4500	0.004	4500	0.006	4500	0.005
	6.0	0.2362	6400	0.007	4200	0.006	3700	0.005	3700	0.007	3700	0.007
	7.0	0.2756	5500	0.008	3600	0.006	3200	0.006	3200	0.008	3200	0.008
	8.0	0.3150	4800	0.009	3200	0.007	2800	0.007	2800	0.009	2800	0.009

⚠ WARNING: Cancer - www.P65Warnings.ca.gov

Warnings on using the drilling condition tables

1. Adjust drilling condition according to the rigidity of machine or work clamp state.
2. The table values condition are for drilling with water-soluble cutting fluid or mist.
3. Reduce RPM and feed speeds by 30% for non-water-soluble cutting fluid.
4. Use the internal lubricating oil hole.
5. Non-step drilling is possible. However, a work material and drilling condition to chip removal may be worse. In that case, add step feed or review the drilling condition. For holes deeper than 20D in stainless steels, recommend in step feed.
6. In step feed, return to the entrance hole.
7. Step feed interval is about 0.5~1xD.
8. Recommend pre-drilling of guide holes. Depth is 2~3xD.
9. Recommend the AQDEXOHPLT for guide drilling. Recommend the diameter that is 0.03mm larger than the deep hole drill.

Drilling Conditions - MQL

L9618, L9619, L9620, L9621 (25D, 30D)

Work Material	Structural Steels Carbon Steels (~200HB)		Alloy Steels Heat Treated Steels (20~30 HRC)		Mold Steels Hardened Steels (30~40 Hrc)		Ductile Cast Irons			
	Drilling Dia.									
	Metric	Decimal	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)		
Drill Dia. (mm./inches)	3.0	0.1181	7700	0.004	6700	0.003	5700	0.003	5700	0.003
	4.0	0.1575	5700	0.005	5000	0.004	4300	0.004	4300	0.004
	5.0	0.1969	5100	0.006	4450	0.005	3800	0.005	3800	0.006
	6.0	0.2362	4200	0.007	3700	0.005	3200	0.005	3200	0.007
	7.0	0.2756	3600	0.008	3200	0.006	2700	0.006	2700	0.008
	8.0	0.3150	3200	0.009	2800	0.007	2400	0.007	2400	0.009

Warnings on using the drilling condition tables

1. Adjust drilling condition according to the rigidity of machine or work clamp state.
2. The table values condition are for drilling with MQL.
3. Non-step drilling is possible. However, a work material and drilling condition to chip removal may be worse. In that case, add step feed or review the drilling condition.
4. In step feed, return to the entrance hole.
5. Step feed interval is about 0.5~1xD.
6. Recommend pre-drilling of guide holes. Depth is 2~3xD.
7. Recommend the AQDEXOHPLT for guide drilling. Recommend the diameter that is 0.03mm larger than the deep hole drill.
8. It is non-application for stainless. Please drill with Wet.

CARBIDE DRILLS