

**WIDIN** POWER MAX DRILL SERIES  
**TECHNICAL DATA**

**SF508 SERIES**

**Special Feature**

**1**  
Design that focuses on chip evacuation, improving machinability and chip evacuation of deep hole machining.

**2**  
Stable material adaption prevents unexpected breakage and increases the rigidity of the tool through the design of the straight edge.

**3**  
The unique special pre-treatment technique improves the surface roughness of the flute groove and improves the adhesion to the coating, thereby improving the quality level.

**4**  
Material Structure / Coating Structure  
AlCrN-based coating with a multi-layer structure preventing crack.

**Improvement points**

- Improved durability and chipping resistance by applying new thin film AlCrN coating- Applied special thinning to minimize cutting resistance
- Smooth coating surface reduces frictional resistance and improves chip evacuation
- Excellent chipping and defect resistance by adopting stable drill material

**TECHNICAL DATA**

Application V	Carbon steel (C45) SCM 415/420		Carbon steel (S45C) SCM 435/440		SUJ2-SUS440		SKD11 HRc34-43		HRc43-48		SKD11 HRc46-53		Cast Iron FC 250-350		Ductile FC 400-500	
	80-150m/min	80-150m/min	63-100m/min	40-70m/min	32-50m/min	25-40m/min	80-150m/min	63-100m/min	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR
3	12,000	.004	13,000	.004	7,600	.004	8,400	.004	5,300	.004	3,800	.003	12,000	.004	8,500	.004
4	9,500	.005	10,000	.005	5,700	.005	4,800	.005	4,000	.004	2,900	.003	9,000	.005	6,300	.005
5	7,800	.006	8,000	.006	4,600	.006	3,800	.006	3,200	.005	2,300	.004	7,600	.005	5,100	.006
6	6,400	.007	6,600	.007	3,800	.007	3,200	.007	2,600	.006	1,900	.005	6,400	.007	4,250	.007
8	4,800	.008	5,000	.008	2,900	.008	2,400	.008	2,000	.007	1,450	.006	4,800	.008	3,200	.008
10	3,800	.009	4,000	.009	2,300	.009	1,900	.009	1,600	.008	1,150	.007	3,800	.009	2,550	.009
12	3,200	.010	3,300	.010	1,900	.010	1,600	.010	1,300	.008	950	.007	3,200	.010	2,100	.010
14	2,700	.011	2,800	.011	1,600	.011	1,300	.011	1,100	.008	800	.006	2,700	.011	1,800	.011
16	2,400	.012	2,500	.012	1,400	.012	1,200	.012	1,000	.008	700	.006	2,400	.012	1,600	.012
18	2,100	.013	2,200	.013	1,300	.013	1,100	.013	900	.007	650	.005	2,100	.013	1,400	.013
20	1,900	.014	2,000	.014	1,150	.014	1,000	.014	800	.007	600	.005	1,900	.014	1,250	.014

RPM = rev./min.  
IPR = inch/rev.

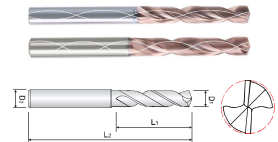
**WIDIN** Drill for High Speed cutting  
**POWER MAX DRILL**

**SF508 SERIES**

8xD

DRILLS / 2 FLUTES / 8xD / SOLID CARBIDE / INTERNAL COOLANT / SINGLE MARGIN / AlCrN COATING

EDP NO.  
D1 = Ø / A2/D1 (2) = S1 to 6  
D1 = Ø / A2/D1 (2) = 6, to 10  
D1 = Ø / A2/D1 (2) = 10, to 18  
D1 = Ø / A2/D1 (2) = 18 to 25  
D2 = H6



EDP NO.	Cutting Diameter			Cutting Length	Overall Length	Shank Diameter
	8xD	D1				
SF508	Decimal	Fraction	Metric	L1	L2	D2
SF50808	0.1181"	-	3.000	43.00	80.00	5.00
SF50809	0.1250"	-	3.175	43.00	80.00	4.00
SF50810	0.1250"	1/8"	3.175	43.00	80.00	4.00
SF50812	0.1250"	-	3.200	43.00	80.00	4.00
SF50815	0.1299"	-	3.300	43.00	80.00	4.00
SF50818	0.1338"	-	3.400	43.00	80.00	4.00
SF50820	0.1378"	-	3.500	43.00	80.00	4.00
SF50825	0.1417"	-	3.600	43.00	80.00	4.00
SF50830	0.1457"	-	3.700	43.00	80.00	4.00
SF50835	0.1496"	-	3.800	49.00	87.00	4.00
SF50840	0.1535"	-	3.900	49.00	87.00	4.00
SF50845	0.1575"	5/32"	3.975	49.00	87.00	4.00
SF50850	0.1590"	#70	4.039	49.00	87.00	5.00
SF50855	0.1614"	-	4.100	49.00	87.00	5.00
SF50860	0.1654"	-	4.200	49.00	87.00	5.00
SF50865	0.1693"	-	4.300	49.00	87.00	5.00
SF50870	0.1719"	11/64"	4.366	49.00	87.00	5.00
SF50875	0.1732"	-	4.400	49.00	87.00	5.00
SF50880	0.1772"	-	4.500	49.00	87.00	5.00
SF50885	0.1811"	-	4.600	49.00	87.00	5.00
SF50890	0.1850"	-	4.700	49.00	87.00	5.00
SF50895	0.1895"	3/16"	4.763	56.00	94.00	5.00
SF50900	0.1930"	-	4.800	56.00	94.00	5.00
SF50905	0.1969"	-	4.900	56.00	94.00	5.00
SF50910	0.2008"	-	5.100	56.00	94.00	6.00
SF50915	0.2031"	13/64"	5.159	56.00	94.00	6.00
SF50920	0.2047"	-	5.200	56.00	94.00	6.00
SF50925	0.2087"	-	5.300	56.00	94.00	6.00
SF50930	0.2126"	-	5.400	56.00	94.00	6.00
SF50935	0.2130"	#9	5.410	56.00	94.00	6.00
SF50940	0.2165"	-	5.500	56.00	94.00	6.00

Applicable Working Material

Aluminum	Steel	Cast Iron	Stainless Steel	Titanium	Brass	Copper	Aluminum	Steel	Cast Iron	Stainless Steel	Titanium	Brass	Copper	Aluminum	Steel	Cast Iron	Stainless Steel	Titanium	Brass	Copper
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