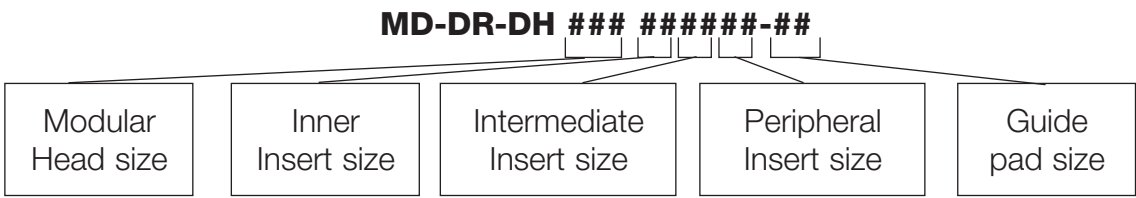
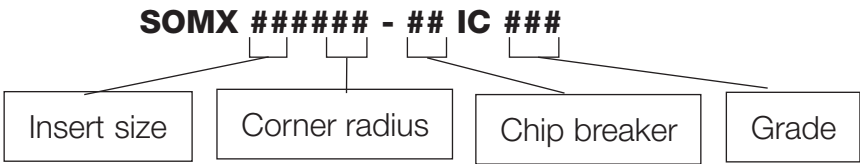


Description Code Key

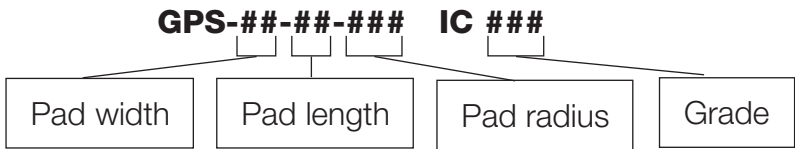
Modular Head








Inner/Intermediate/Peripheral Inserts



Guide Pads



Spare Parts

Designation					
MD-DR-DH-HEAD	SR 14-560-HG	T-8/53	SR 22052/HG-P	IP-7/51	GPS-06-20-120

MD-DR-DH Cutting Parameters

ISO				Tensile Strength [ksi]	Hardness HB	Material Group No.		Feed Vs. Drill Diameter
								1.299<ØD<1.575 (inch)
	Material		Condition				V _c [SFM]	f [ipr]
P	Non-alloy steel and cast steel, free cutting steel	<0.25% C	Annealed	61	125	1	330-495	.0039-.0098
		≥0.25% C	Annealed	94	190	2		
		<0.55% C	Quenched and tempered	123	250	3	265-495	.0059-.0117
		≥0.55% C	Annealed	109	220	4		
			Quenched and tempered	145	300	5		
	Low alloy and cast steel (less than 5% of alloying elements)		Annealed	87	200	6	230-400	.0059-.0117
			Quenched and tempered	135	275	7		
				145	300	8		
				174	350	9		
	High alloyed steel, cast steel and tool steel		Annealed	99	200	10	265-495	.0039-.0098
			Quenched and tempered	160	325	11	230-400	.0039-.0098
K	Gray cast iron (GG)	Ferritic / pearlitic		180	15	600-990	.007-.0136	
		Pearlitic / martensitic		260	16			
	Nodular cast iron (GGG)	Ferritic		160	17	495-825	.0059-.0117	
		Pearlitic		250	18			
	Malleable cast iron	Ferritic		130	19		.0059-.0136	
		Pearlitic		230	20			

*Reduce speed by 50% when using the MD-Extension