MXC SERIES

PRECISION CUTTING TOOLS
Member IMC Group

		P1		P2		P3		P5		M2		K1	
Length	Diameter	P1 SFM	P1 IPR	P2 SFM	P2 IPR	P3 SFM	P3 IPR	P5 SFM	P5 IPR	M2 SFM	M2 IPR	K1 SFM	K1 IPR
3xD	0.039	361	0.0012	279	0.0007	230	0.0007	197	0.0007	197	0.0007	361	0.0012
	0.059	361	0.0018	279	0.0010	230	0.0010	197	0.0010	197	0.0010	361	0.0018
	0.079	361	0.0024	279	0.0013	230	0.0013	197	0.0013	197	0.0013	361	0.0031
	0.098	361	0.0030	279	0.0016	230	0.0016	197	0.0016	197	0.0016	361	0.0033
	0.114	361	0.0035	279	0.0019	230	0.0019	197	0.0019	197	0.0019	361	0.0035
5xD	0.039	361	0.0012	279	0.0007	230	0.0007	197	0.0007	197	0.0007	361	0.0012
	0.059	361	0.0018	279	0.0010	230	0.0010	197	0.0010	197	0.0010	361	0.0018
	0.079	361	0.0024	279	0.0013	230	0.0013	197	0.0013	197	0.0013	361	0.0031
	0.098	361	0.0030	279	0.0016	230	0.0016	197	0.0016	197	0.0016	361	0.0033
	0.114	361	0.0035	279	0.0019	230	0.0019	197	0.0019	197	0.0019	361	0.0035
8xD	0.039	328	0.0012	262	0.0012	213	0.0010	197	0.0010	197	0.0007	361	0.0012
	0.059	328	0.0016	262	0.0016	213	0.0012	197	0.0012	197	0.0010	361	0.0018
	0.079	328	0.0024	262	0.0024	213	0.0016	197	0.0016	197	0.0013	361	0.0031
	0.098	328	0.0031	262	0.0031	213	0.0024	197	0.0024	197	0.0016	361	0.0033
	0.114	328	0.0035	262	0.0035	213	0.0029	197	0.0029	197	0.0019	361	0.0035
12xD	0.039	328	0.0012	262	0.0012	213	0.0010	197	0.0010	197	0.0007	361	0.0012
	0.059	328	0.0016	262	0.0016	213	0.0012	197	0.0012	197	0.0010	361	0.0018
	0.079	328	0.0024	262	0.0024	213	0.0016	197	0.0016	197	0.0013	361	0.0031
	0.098	328	0.0031	262	0.0031	213	0.0024	197	0.0024	197	0.0016	361	0.0033
	0.114	328	0.0035	262	0.0035	213	0.0029	197	0.0029	197	0.0019	361	0.0035

TIPS & TRICKS FOR DRILLING

Using a G73 peck cycle helps chip evacuation in deep hole drilling & materials which have a poor chip formation
If there are scratches on the outside of the chip, increase coolant pressure and or reduce feedrate
TIR, SFM, & tool alignment with material are the most important factors in deep hole drilling
Use high pressure coolant when deep hole drilling
Lower coolant pressure can help surface finish in 3xD & 5xD holes in P1 & P2 materials
Slow the feedrate to 50% when breaking through the material

RECOMMENDED COOLANT PRESSURES

1 mm - 480 psi | 2 mm - 540 psi | 2.9 mm - 600 psi