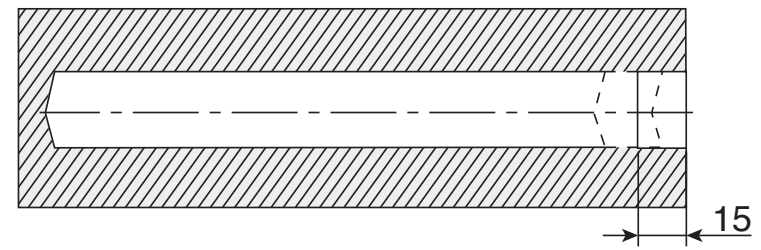


# Drilling process on machining centers and lathe machines

1. Make a pilot hole  $D_{+0.10}^{-0.03}$  with 15 mm depth.

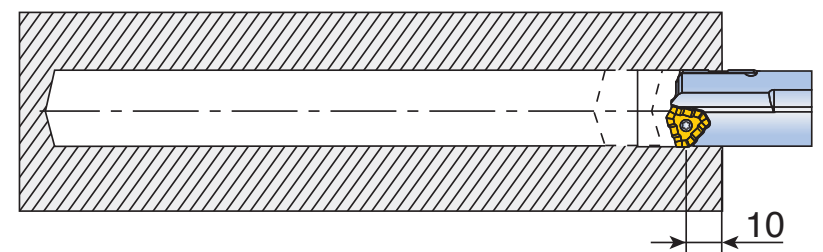


2. Insert then set the TRGD drill into the pilot hole (10 mm depth).

$V_c=5-10$  m/min

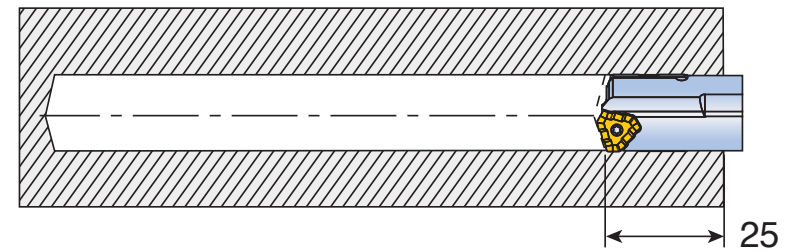
$f=0.5-1.0$  mm/rev

Activate coolant system and increase cutting speed up to 100%.

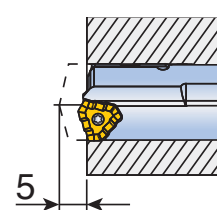


3. Initial cutting at a 25 mm depth with 80% feed rate.

To the end of the hole, increase feed rate up to 100%.



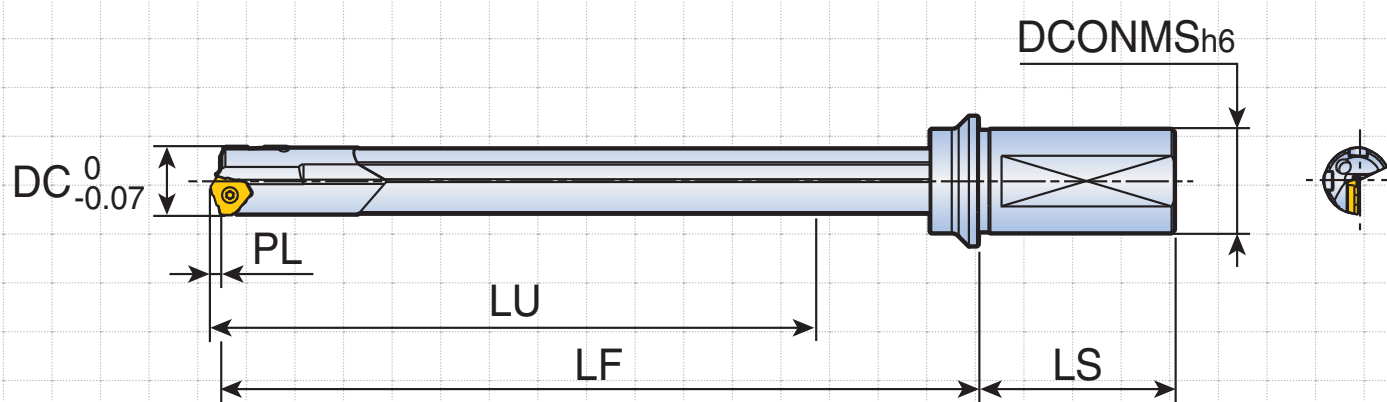
4. In case of through hole, drill the full hole to a depth of +5 mm.



5. Retract with slow rotation (5-10 m/min).

## Tailor-made Order Form

### Deep hole drilling order form



Sketch of drilling application

• Note: It may be necessary to change several of the parameters that you indicated based on our experience with your application.

Tool			
Quantity			
Nominal diameter and tolerance			
- Please fill in dimensions on the sketch above.			
Driver			
Code No			
- For standard drivers, please use codes from next pages and for special drivers, please attach sketch and specifications.			
Workpiece (If possible, please attach a drawing)			
Material description (DIN material number or any other standard)			
Hardness and properties			
Hole type	<input type="checkbox"/> Blind hole <input type="checkbox"/> Through hole <input type="checkbox"/> Drilling into pre-hole		
	<input type="checkbox"/> Angled entry <input type="checkbox"/> Drilling into solid <input type="checkbox"/> Boring		
	<input type="checkbox"/> Angled exit		
Drilling depth	mm		
Hole tolerance			
Application	Workpiece	<input type="checkbox"/> Stationary	<input type="checkbox"/> Rotating
	Tool	<input type="checkbox"/> Stationary	<input type="checkbox"/> Rotating
Machine			
Machine type			
Power		kW	
Cutting data	Cutting speed ( $V_c$ )	m/min	
	Revolutions	<b>Nmin :</b> RPM	<b>Nmax :</b> RPM
	Feed	<b>Fmin :</b> mm/rev	<b>Fmin :</b> mm/rev
	Feed rate (VF)	mm/min	
Coolant	Coolant type	<input type="checkbox"/> Oil	<input type="checkbox"/> Soluble oil <input type="checkbox"/> Other
	Coolant pressure	Bar	
	Coolant volume	liter/min	