

50 YEARS

NACHI

NACHI EUROPE GmbH

OUR SYNERGY
YOUR PERFORMANCE

AQUA DRILL EX OIL-HOLE LONG

HIGH-EFFICIENT DEEP HOLE DRILL



CELEBRATE THE POLE POSITION



**NEW
AQUA EX
COATING**

Deep-Hole Drills
Aquadrill EX Oil-hole long
Reliable and Durable
in Largest Drill Depths

High-Efficient Deep Hole Drill

AQUA Drills EX Oil Hole Long



AQDEXOH

AQDEX AQDEXR AQDEXOH10D AQDEXOH15D AQDEXOH20D AQDEXOH25D AQDEXOH30D

- 30D Non step drilling possible
- High efficient & long tool life in both Wet & MQL
- Low cutting force point geometry provides long tool life on stainless steel deep hole drilling

Improved sharpness and stability

Point geometry which reduces the cutting force and improves the chip evacuation

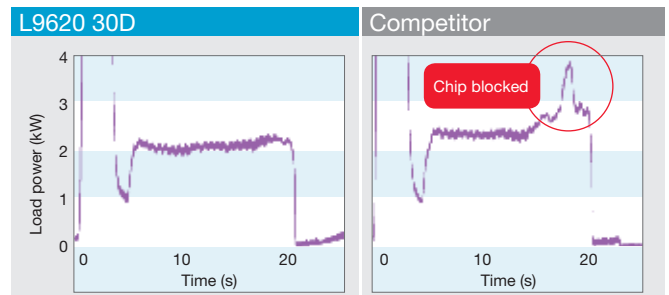
Double margin supports the guide and realizes stable deep drilling



Guide pad located on the vertical direction against the cutting edge lead the drill stable

30D Non step drilling

No chip block



Cutting Condition

Tool:	5.0mm 30D type	Cutting fluid:	Water soluble (internal coolant)
Speed:	120 m/min	Cutting depth:	150 mm (30D)
Feed:	1150 mm/min	Guide hole:	5.03mm, 10mm depth
Work material:	C50 (180HB)		

Stable deep hole drilling in stainless steels

Divided in small chips



Cutting Condition

Tool:	5.0mm 20D type	Cutting fluid:	Water soluble (internal coolant)
Cutting speed:	75 m/min	Cutting depth:	100 mm blind hole
Feed:	450 mm/min (0.1 mm/rev)	Guide hole:	5.03mm, 10mm depth
Work material:	1.4301 (SUS304)		

AQUA EX Oil-Hole Pilot

AQDEXOHPLT

Ideal guide hole drill for AQUA EX Oil-Hole long
Improved concentricity and realize stable deep hole drilling

AQUA EX Coating

Improved heat and wear resistance

Anti-oxidation test

After 1 hour in 1100°C

AQUA EX Coat
50% oxidized

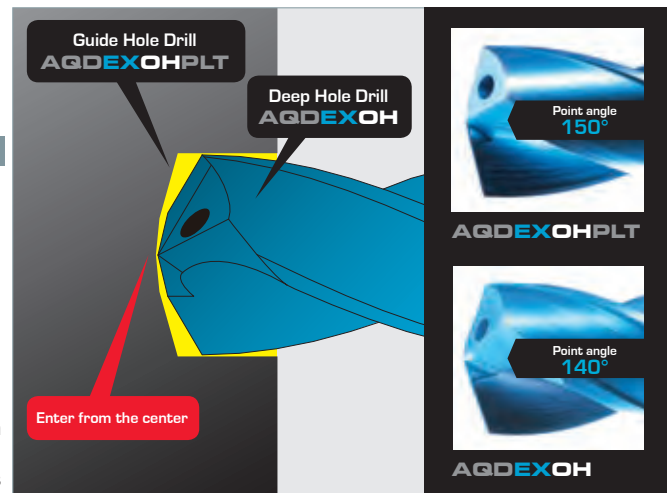
Competitor (1200°C catalog condition)
Complete oxidation

Anti-adhesion layer

TiAlCrX Anti-oxidant & wear resistant multi-layer


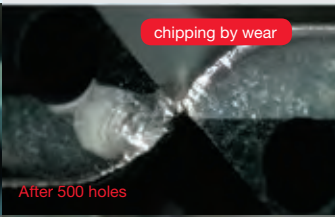


High strength carbide material

- Anti-adhesion layer and smoothed surface makes easy chip evacuation
- Al rich layer realize high anti-oxidant (1100°C)
- Multi-layered avoids crack propagation. Compressive stress moderates hardened film (3300HV) which increases the wear resistance.



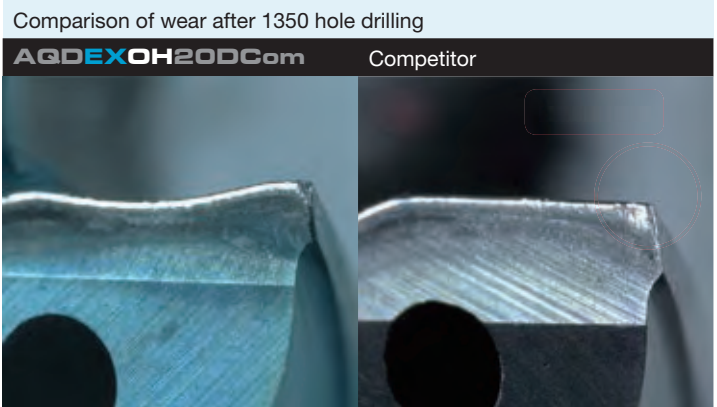
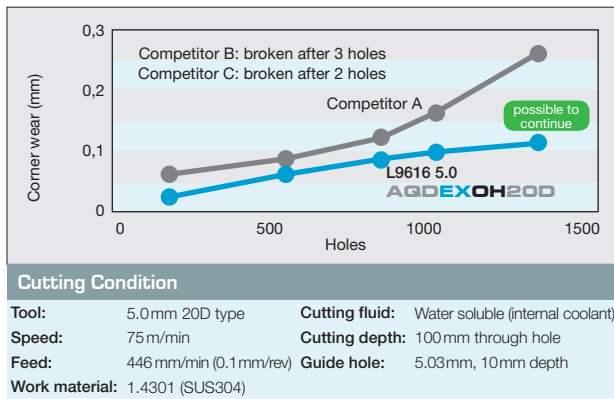
30D Non-step drilling on C50

High efficient & long tool life in both wet & MQL

	AGDEXOH30D	Competitor	Cutting conditions	
Wet			Tool: 5.0mm 30D type	Cutting fluid: Water soluble (internal coolant)
	After 700 holes	After 500 holes	Speed: 120m/min	Cutting depth: 150mm through hole
MQL			Feed: 1150 mm/min (0.15mm/rev)	Guide hole: 5.03mm, 10mm depth
	After 700 holes	After 700 holes	Work material: C50	
			Tool: 5.0mm 30D type	Cutting fluid: MQL
			Speed: 80m/min	Cutting depth: 150mm through hole
			Feed: 760 mm/min (0.15mm/rev)	Guide hole: 5.03mm, 10mm depth
			Work material: C50	

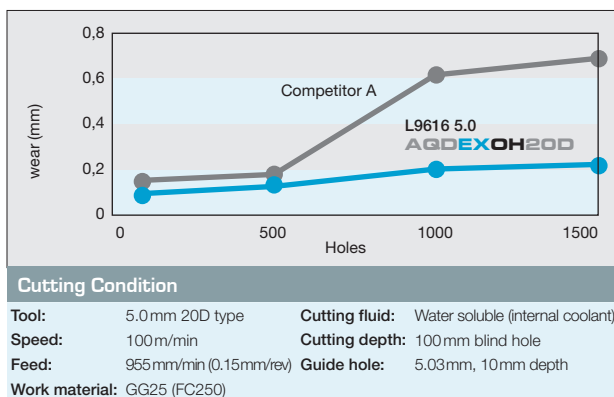
Wet drilling on stainless steel 304 (1.4301)

stable and long tool life even on stainless steel



GG25(FC250) Cast Iron Wet drilling

High wear resistance with long tool life

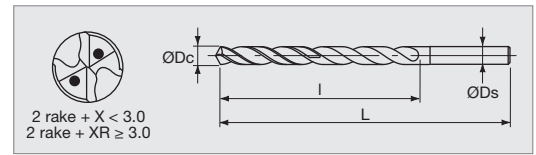


Applicable working materials

Structural Steels	Carbon Steels	Pre-Hardened Steels Alloy Steels	Hardened Steels Mold Steels	Hardened Steels		Stainless Steels		Ti Alloys Ni Alloys	Cast Iron	Aluminium Alloys	Copper Alloys
ST37-2(SS400)	C45/C50	42CrMo4 SCR/NAK	30-40HRC	40-50HRC	50-65HRC	1.4301/1.4401 SUS304/SUS316	1.4021/1.4028 SUS420		GG/GGG	Al/ADC	Cu
■	■	■	○			■	■		■		

AQDEXOH10D

AQUA Drills EX Oil-Hole Long 10D



LIST9612				Unit: mm
Dc	l	L	Ds	
1.0	13	61	3	
1.1	14	63	3	
1.2	16	63	3	
1.3	17	63	3	
1.4	18	63	3	
1.5	20	63	3	
1.6	21	70	3	
1.7	22	70	3	
1.8	23	70	3	
1.9	25	70	3	
2.0	26	70	3	
2.1	27	80	3	
2.2	29	80	3	
2.3	30	80	3	
2.4	31	80	3	
2.5	33	80	3	
2.6	34	89	3	
2.7	35	89	3	
2.8	36	89	3	
2.9	38	89	3	
3.0	39	89	3	
3.1	46	96	4	
3.2	46	96	4	
3.3	46	96	4	
3.4	46	96	4	
3.5	46	96	4	
3.6	52	102	4	
3.7	52	102	4	
3.8	52	102	4	
3.9	52	102	4	

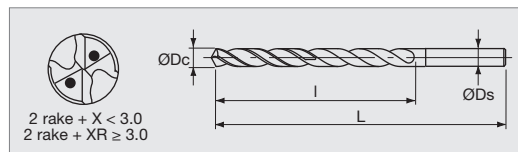
LIST9612				Unit: mm
Dc	l	L	Ds	
4.0	52	102	4	
4.1	59	109	5	
4.2	59	109	5	
4.3	59	109	5	
4.4	59	109	5	
4.5	59	109	5	
4.6	65	115	5	
4.7	65	115	5	
4.8	65	115	5	
4.9	65	115	5	
5.0	65	115	5	
5.1	72	122	6	
5.2	72	122	6	
5.3	72	122	6	
5.4	72	122	6	
5.5	72	122	6	
5.6	78	128	6	
5.7	78	128	6	
5.8	78	128	6	
5.9	78	128	6	
6.0	78	128	6	
6.1	85	135	7	
6.2	85	135	7	
6.3	85	135	7	
6.4	85	135	7	
6.5	85	135	7	
6.6	91	141	7	
6.7	91	141	7	
6.8	91	141	7	
6.9	91	141	7	

LIST9612				Unit: mm
Dc	l	L	Ds	
7.0	91	141	7	
7.1	98	148	8	
7.2	98	148	8	
7.3	98	148	8	
7.4	98	148	8	
7.5	98	148	8	
7.6	104	154	8	
7.7	104	154	8	
7.8	104	154	8	
7.9	104	154	8	
8.0	104	154	8	
8.1	111	161	9	
8.2	111	161	9	
8.3	111	161	9	
8.4	111	161	9	
8.5	111	161	9	
8.6	117	167	9	
8.7	117	167	9	
8.8	117	167	9	
8.9	117	167	9	
9.0	117	167	9	
9.1	124	174	10	
9.2	124	174	10	
9.3	124	174	10	
9.4	124	174	10	
9.5	124	174	10	
9.6	130	180	10	
9.7	130	180	10	
9.8	130	180	10	
9.9	130	180	10	

LIST9612				Unit: mm
Dc	l	L	Ds	
10.0	130	180	10	
10.1	137	197	11	
10.2	137	197	11	
10.3	137	197	11	
10.4	137	197	11	
10.5	137	197	11	
10.6	143	203	11	
10.7	143	203	11	
10.8	143	203	11	
10.9	143	203	11	
11.0	143	203	11	
11.1	150	210	12	
11.2	150	210	12	
11.3	150	210	12	
11.4	150	210	12	
11.5	150	210	12	
11.6	156	216	12	
11.7	156	216	12	
11.8	156	216	12	
11.9	156	216	12	
12.0	156	216	12	

AQDEXOH15D

AQUA Drills EX Oil-Hole Long 15D



LIST9614				Unit: mm
Dc	l	L	Ds	
1.0	18	66	3	
1.1	20	71	3	
1.2	22	71	3	
1.3	23	71	3	
1.4	25	71	3	
1.5	27	71	3	
1.6	29	80	3	
1.7	31	80	3	
1.8	32	80	3	
1.9	34	80	3	
2.0	36	80	3	
2.1	38	93	3	
2.2	40	93	3	
2.3	41	93	3	
2.4	43	93	3	
2.5	45	93	3	
2.6	47	104	3	
2.7	49	104	3	
2.8	50	104	3	
2.9	52	104	3	
3.0	54	104	3	
3.1	63	113	4	
3.2	63	113	4	
3.3	63	113	4	
3.4	63	113	4	
3.5	63	113	4	
3.6	72	122	4	
3.7	72	122	4	
3.8	72	122	4	
3.9	72	122	4	

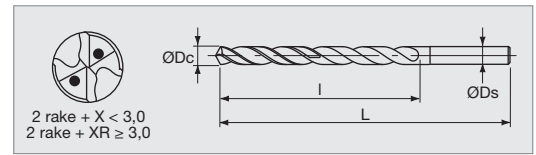
LIST9614				Unit: mm
Dc	l	L	Ds	
4.0	72	122	4	
4.1	81	131	5	
4.2	81	131	5	
4.3	81	131	5	
4.4	81	131	5	
4.5	81	131	5	
4.6	90	140	5	
4.7	90	140	5	
4.8	90	140	5	
4.9	90	140	5	
5.0	90	140	5	
5.1	99	149	6	
5.2	99	149	6	
5.3	99	149	6	
5.4	99	149	6	
5.5	99	149	6	
5.6	108	158	6	
5.7	108	158	6	
5.8	108	158	6	
5.9	108	158	6	
6.0	108	158	6	
6.1	117	167	7	
6.2	117	167	7	
6.3	117	167	7	
6.4	117	167	7	
6.5	117	167	7	
6.6	126	176	7	
6.7	126	176	7	
6.8	126	176	7	
6.9	126	176	7	

LIST9614				Unit: mm
Dc	l	L	Ds	
7.0	126	176	7	
7.1	135	185	8	
7.2	135	185	8	
7.3	135	185	8	
7.4	135	185	8	
7.5	135	185	8	
7.6	144	194	8	
7.7	144	194	8	
7.8	144	194	8	
7.9	144	194	8	
8.0	144	194	8	
8.1	153	203	9	
8.2	153	203	9	
8.3	153	203	9	
8.4	153	203	9	
8.5	153	203	9	
8.6	162	212	9	
8.7	162	212	9	
8.8	162	212	9	
8.9	162	212	9	
9.0	162	212	9	
9.1	171	221	10	
9.2	171	221	10	
9.3	171	221	10	
9.4	171	221	10	
9.5	171	221	10	
9.6	180	230	10	
9.7	180	230	10	
9.8	180	230	10	
9.9	180	230	10	

LIST9614				Unit: mm
Dc	l	L	Ds	
10.0	180	230	10	
10.1	189	249	11	
10.2	189	249	11	
10.3	189	249	11	
10.4	189	249	11	
10.5	189	249	11	
10.6	198	258	11	
10.7	198	258	11	
10.8	198	258	11	
10.9	198	258	11	
11.0	198	258	11	
11.1	207	267	12	
11.2	207	267	12	
11.3	207	267	12	
11.4	207	267	12	
11.5	207	267	12	
11.6	216	276	12	
11.7	216	276	12	
11.8	216	276	12	
11.9	216	276	12	
12.0	216	276	12	

AQDEXOH20D

AQUA Drills EX Oil-Hole Long 20D



LIST9616				Unit: mm
Dc	l	L	Ds	
1.0	23	71	3	
1.1	25	78	3	
1.2	28	78	3	
1.3	30	78	3	
1.4	32	78	3	
1.5	35	78	3	
1.6	37	90	3	
1.7	39	90	3	
1.8	41	90	3	
1.9	44	90	3	
2.0	46	90	3	
2.1	48	105	3	
2.2	51	105	3	
2.3	53	105	3	
2.4	55	105	3	
2.5	58	105	3	
2.6	60	119	3	
2.7	62	119	3	
2.8	64	119	3	
2.9	67	119	3	
3.0	69	119	3	
3.1	81	131	4	
3.2	81	131	4	
3.3	81	131	4	
3.4	81	131	4	
3.5	81	131	4	
3.6	92	142	4	
3.7	92	142	4	
3.8	92	142	4	
3.9	92	142	4	

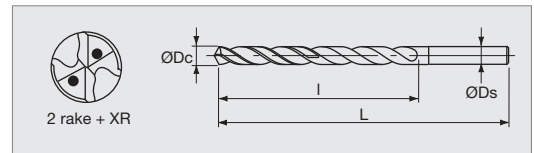
LIST9616				Unit: mm
Dc	l	L	Ds	
4.0	92	142	4	
4.1	104	154	5	
4.2	104	154	5	
4.3	104	154	5	
4.4	104	154	5	
4.5	104	154	5	
4.6	115	165	5	
4.7	115	165	5	
4.8	115	165	5	
4.9	115	165	5	
5.0	115	165	5	
5.1	127	177	6	
5.2	127	177	6	
5.3	127	177	6	
5.4	127	177	6	
5.5	127	177	6	
5.6	138	188	6	
5.7	138	188	6	
5.8	138	188	6	
5.9	138	188	6	
6.0	138	188	6	
6.1	150	200	7	
6.2	150	200	7	
6.3	150	200	7	
6.4	150	200	7	
6.5	150	200	7	
6.6	161	211	7	
6.7	161	211	7	
6.8	161	211	7	
6.9	161	211	7	

LIST9616				Unit: mm
Dc	l	L	Ds	
7.0	161	211	7	
7.1	173	223	8	
7.2	173	223	8	
7.3	173	223	8	
7.4	173	223	8	
7.5	173	223	8	
7.6	184	234	8	
7.7	184	234	8	
7.8	184	234	8	
7.9	184	234	8	
8.0	184	234	8	
8.1	196	246	9	
8.2	196	246	9	
8.3	196	246	9	
8.4	196	246	9	
8.5	196	246	9	
8.6	207	257	9	
8.7	207	257	9	
8.8	207	257	9	
8.9	207	257	9	
9.0	207	257	9	
9.1	219	269	10	
9.2	219	269	10	
9.3	219	269	10	
9.4	219	269	10	
9.5	219	269	10	
9.6	230	280	10	
9.7	230	280	10	
9.8	230	280	10	
9.9	230	280	10	

LIST9616				Unit: mm
Dc	l	L	Ds	
10.0	230	280	10	

AQDEXOH25D

AQUA Drills EX Oil-Hole Long 25D



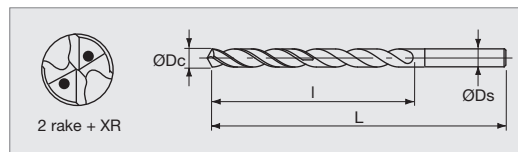
LIST9618				Unit: mm
Dc	l	L	Ds	
3.0	84	134	3	
3.1	98	148	4	
3.2	98	148	4	
3.3	98	148	4	
3.4	98	148	4	
3.5	98	148	4	
3.6	112	162	4	
3.7	112	162	4	
3.8	112	162	4	
3.9	112	162	4	
4.0	112	162	4	
4.1	126	176	5	
4.2	126	176	5	
4.3	126	176	5	
4.4	126	176	5	
4.5	126	176	5	
4.6	140	190	5	
4.7	140	190	5	
4.8	140	190	5	
4.9	140	190	5	

LIST9618				Unit: mm
Dc	l	L	Ds	
5.0	140	190	5	
5.1	154	204	6	
5.2	154	204	6	
5.3	154	204	6	
5.4	154	204	6	
5.5	154	204	6	
5.6	168	218	6	
5.7	168	218	6	
5.8	168	218	6	
5.9	168	218	6	
6.0	168	218	6	
6.1	182	232	7	
6.2	182	232	7	
6.3	182	232	7	
6.4	182	232	7	
6.5	182	232	7	
6.6	196	246	7	
6.7	196	246	7	
6.8	196	246	7	
6.9	196	246	7	

LIST9618				Unit: mm
Dc	l	L	Ds	
7.0	196	246	7	
7.1	210	260	8	
7.2	210	260	8	
7.3	210	260	8	
7.4	210	260	8	
7.5	210	260	8	
7.6	224	274	8	
7.7	224	274	8	
7.8	224	274	8	
7.9	224	274	8	
8.0	224	274	8	

AQDEXOH30D

AQUA Drills EX Oil-Hole Long 30D



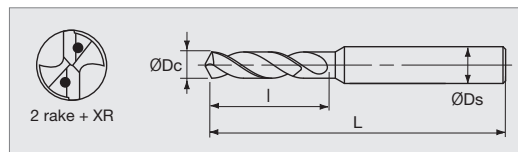
LIST9620				Unit: mm
Dc	l	L	Ds	
3.0	99	149	3	
3.1	116	166	4	
3.2	116	166	4	
3.3	116	166	4	
3.4	116	166	4	
3.5	116	166	4	
3.6	132	182	4	
3.7	132	182	4	
3.8	132	182	4	
3.9	132	182	4	
4.0	132	182	4	
4.1	149	199	5	
4.2	149	199	5	
4.3	149	199	5	
4.4	149	199	5	
4.5	149	199	5	
4.6	165	215	5	
4.7	165	215	5	
4.8	165	215	5	
4.9	165	215	5	

LIST9620				Unit: mm
Dc	l	L	Ds	
5.0	165	215	5	
5.1	182	232	6	
5.2	182	232	6	
5.3	182	232	6	
5.4	182	232	6	
5.5	182	232	6	
5.6	198	248	6	
5.7	198	248	6	
5.8	198	248	6	
5.9	198	248	6	
6.0	198	248	6	
6.1	215	265	7	
6.2	215	265	7	
6.3	215	265	7	
6.4	215	265	7	
6.5	215	265	7	
6.6	231	281	7	
6.7	231	281	7	
6.8	231	281	7	
6.9	231	281	7	

LIST9620				Unit: mm
Dc	l	L	Ds	
7.0	231	281	7	
7.1	248	298	8	
7.2	248	298	8	
7.3	248	298	8	
7.4	248	298	8	
7.5	248	298	8	
7.6	264	314	8	
7.7	264	314	8	
7.8	264	314	8	
7.9	264	314	8	
8.0	264	314	8	

AQUA Drills EX Oil-Hole Pilot

- AQUA Drills EX Oil-Hole Pilot for guide hole drilling
- Improves concentricity and realizes stable deep hole drilling



LIST9622				Unit: mm
Dc	l	L	Ds	
1.015	3.3	54	3	
1.115	3.6	56	3	
1.215	3.9	56	3	
1.315	4.2	56	3	
1.415	4.6	56	3	
1.515	4.9	56	3	
1.615	5.2	60	3	
1.715	5.5	60	3	
1.815	5.8	60	3	
1.915	6.2	60	3	
2.015	9	60	3	
2.115	11	63	3	
2.215	11	63	3	
2.315	11	63	3	
2.415	12	63	3	
2.515	12	63	3	
2.615	12	68	3	
2.715	14	68	3	
2.815	14	68	3	
2.915	14	68	3	
3.03	14	68	3	
3.13	15	72	4	
3.23	15	72	4	
3.33	15	72	4	
3.43	16	72	4	
3.53	16	72	4	
3.63	16	72	4	
3.73	18	72	4	
3.83	18	72	4	
3.93	18	72	4	

LIST9622				Unit: mm
Dc	l	L	Ds	
4.03	18	72	4	
4.13	19	80	5	
4.23	19	80	5	
4.33	19	80	5	
4.43	21	80	5	
4.53	21	80	5	
4.63	21	80	5	
4.73	22	80	5	
4.83	22	80	5	
4.93	22	80	5	
5.03	23	80	5	
5.13	24	82	6	
5.23	24	82	6	
5.33	24	82	6	
5.43	25	82	6	
5.53	25	82	6	
5.63	25	82	6	
5.73	27	82	6	
5.83	27	82	6	
5.93	27	82	6	
6.03	27	82	6	
6.13	28	88	7	
6.23	28	88	7	
6.33	28	88	7	
6.43	30	88	7	
6.53	30	88	7	
6.63	30	88	7	
6.73	31	88	7	
6.83	31	88	7	
6.93	31	88	7	

LIST9622				Unit: mm
Dc	l	L	Ds	
7.03	32	88	7	
7.13	33	94	8	
7.23	33	94	8	
7.33	33	94	8	
7.43	34	94	8	
7.53	34	94	8	
7.63	34	94	8	
7.73	36	94	8	
7.83	36	94	8	
7.93	36	94	8	
8.03	36	94	8	
8.13	37	100	9	
8.23	37	100	9	
8.33	37	100	9	
8.43	39	100	9	
8.53	39	100	9	
8.63	39	100	9	
8.73	40	100	9	
8.83	40	100	9	
8.93	40	100	9	
9.03	41	100	9	
9.13	42	106	10	
9.23	42	106	10	
9.33	42	106	10	
9.43	43	106	10	
9.53	43	106	10	
9.63	43	106	10	
9.73	45	106	10	
9.83	45	106	10	
9.93	45	106	10	

LIST9622				Unit: mm
Dc	l	L	Ds	
10.03	45	106	10	
10.13	46	116	11	
10.23	46	116	11	
10.33	46	116	11	
10.43	48	116	11	
10.53	48	116	11	
10.63	48	116	11	
10.73	49	116	11	
10.83	49	116	11	
10.93	49	116	11	
11.03	49	116	11	
11.13	50	122	12	
11.23	51	122	12	
11.33	51	122	12	
11.43	52	122	12	
11.53	52	122	12	
11.63	52	122	12	
11.73	54	122	12	
11.83	54	122	12	
11.93	54	122	12	
12.03	54	122	12	

Standard drilling condition

Wet Condition

AQDEXOH 10D 15D 20D

Work material	SS400 S50C FC250 Structural steels Carbon steels		SCM440 NAK HPM Alloy steels		SKD61 NAK HPM Mold steels Hardened Steels		Hardened steels		FCD400 Ductile cast iron		SUS304 SUS316 Stainless steel		Nickel Alloys Titanium Alloys	
	~200HB		20~30HRC		30~40HRC								30~40HRC	
mm	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min
1.0	14300	310	12700	250	11150	170	6350	65	11150		7950	80	3150	30
1.5	9550	310	8500	250	7400	170	4250	65	7400		5300	80	2100	30
2.0	7150	310	6350	250	5550	170	3200	65	5550		4000	80	1600	30
2.5	7000	470	6350	360	5700	280	3200	95	5700		3800	140	1650	50
2.9	6050	470	5500	360	4950	280	2750	95	4950		3300	140	1400	50
3.0	11500	1140	7600	570	6700	500			6700	600	6700	440		
4.0	8600	1140	5700	570	5000	500			5000	600	5000	440		
5.0	7600	1260	5100	640	4500	560			4500	670	4500	490		
6.0	6400	1260	4200	640	3700	560			3700	670	3700	490		
7.0	5500	1260	3600	640	3200	560			3200	670	3200	490		
8.0	4800	1260	3200	640	2800	560			2800	670	2800	490		
9.0	4200	1190	2800	610	2500	540			2500	650	2500	470		
10.0	3800	1100	2500	590	2200	510			2200	620	2200	450		
11.0	3500	1030	2300	560	2000	490			2000	600	2000	420		
12.0	3200	960	2100	540	1900	470			1900	580	1900	400		

AQDEXOH 25D 30D

Work material	SS400 S50C FC250 Structural steels Carbon steels		SCM440 NAK HPM Alloy steels		SKD61 NAK HPM Mold steels Hardened Steels		FCD400 Ductile cast iron		SUS304 SUS316 Stainless steel	
	~200HB		20~30HRC		30~40HRC					
mm	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min
3.0	11500	1030	7600	530	6700	460	6700	560	6700	400
4.0	8600	1030	5700	530	5000	460	5000	560	5000	400
5.0	7600	1150	5100	590	4500	510	4500	620	4500	450
6.0	6400	1150	4200	590	3700	510	3700	620	3700	450
7.0	5500	1150	3600	590	3200	510	3200	620	3200	450
8.0	4800	1150	3200	590	2800	510	2800	620	2800	450
9.0	4200	1070	2800	560	2500	490	2500	600	2500	420
10.0	3800	1000	2500	540	2200	470	2200	580	2200	400

Warnings on using the drilling condition tables

- Adjust drilling condition according to the rigidity of machine or work clamp state.
- The table values condition are for drilling with water-soluble cutting fluid.
- Reduce RPM and feed speeds by 30% for non-water-soluble cutting fluid.
- Use the internal lubricating oil hole.
- 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.
- In step feed, return to the entrance hole.
- Step feed interval is about 0.5-1xD.
- Recommend pre-drilling of guide holes. Depth is 2-3xD.
- Recommend the AQDEXOHPLT for guide drilling.
Recommend the diameter that is 0.03mm larger than the deep hole drill.

ML Condition

AQDEXOH 10D 15D 20D

Work material	SS400 S50C FC250 Structural steels Carbon steels ~200 HB		SCM440 NAK HPM Alloy steels Pre-Hardened steels 20~30 HRC		SKD61 NAK HPM Mold steels Hardened Steels 30~40HRC		FCD400 Ductile cast iron	
	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min
3.0	7600	750	6700	500	5700	430	5700	520
4.0	5700	750	5000	500	4300	430	4300	520
5.0	5100	840	4450	560	3800	480	3800	570
6.0	4200	840	3700	560	3200	480	3200	570
7.0	3600	840	3200	560	2700	480	2700	570
8.0	3200	840	2800	560	2400	480	2400	570
9.0	2800	790	2500	540	2100	460	2100	550
10.0	2550	740	2200	510	1900	440	1900	540
11.0	2300	690	2000	490	1700	420	1700	520
12.0	2100	640	1900	470	1600	400	1600	500

AQDEXOH 25D 30D

Work material	SS400 S50C FC250 Structural steels Carbon steels ~200 HB		SCM440 NAK HPM Alloy steels Pre-Hardened steels 20~30 HRC		SKD61 NAK HPM Mold steels Hardened Steels 30~40HRC		FCD400 Ductile cast iron	
	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min
3.0	7700	690	6700	460	5700	400	5700	480
4.0	5700	690	5000	460	4300	400	4300	480
5.0	5100	750	4450	510	3800	440	3800	540
6.0	4200	750	3700	510	3200	440	3200	540
7.0	3600	750	3200	510	2700	440	2700	540
8.0	3200	750	2800	510	2400	440	2400	540
9.0	2800	730	2500	490	2100	420	2100	520
10.0	2550	690	2200	470	1900	400	1900	500

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.
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.

For holes deeper than 20D in stainless steels, recommend in step feed.

4. In step feed, return to the entrance hole.

5. Step feed interval is about 0.5~1×D.

6. Recommend pre-drilling of guide holes. Depth is 2~3×D.

7. Recommend the AQDEXOHPLT for guide drilling.

Recommend the diameter that is 0.03mm larger than the deep hole drill.

Standard drilling condition

Wet Condition

AQDEXOHPLT

Work material	SS400 S50C FC250 Structural steels Carbon steels		SCM440 NAK HPM Alloy steels		SKD61 NAK HPM Mold steels Hardened steels		Hardened Steels		FCD400 Ductile cast iron		SUS304 SUS316 Stainless steel		Nickel Alloys Titanium Alloys	
	~200HB		20~30HRC		30~40HRC								30~40HRC	
mm	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min
1.015	15700	400	14100	350	12550	250	9400	140	12550	320	9400	115	3150	30
1.515	10500	400	9450	350	8400	250	6300	140	8400	320	6300	115	2100	30
2.015	7900	400	7100	350	6300	250	4750	140	6300	320	4750	115	1550	30
2.515	7800	520	6950	470	6300	360	4400	200	6300	430	4400	165	1650	50
2.915	6850	520	6000	470	5450	360	3800	200	5450	430	3800	165	1400	50
3.03	10500	950	8400	760	6800	520	4200	270	8400	760	6800	550	2650	160
4.03	7900	950	6300	760	5100	520	3150	270	6300	760	5100	550	2000	160
5.03	6350	950	5050	760	4100	520	2550	270	5050	760	4100	550	1600	160
6.03	5300	900	4200	710	3400	480	2100	250	4200	710	3400	530	1300	150
7.03	4550	900	3600	710	2950	480	1800	250	3600	710	2950	530	1150	150
8.03	4000	900	3150	710	2600	480	1600	250	3150	710	2600	500	1000	150
9.03	3550	800	2800	640	2300	420	1400	230	2800	640	2300	500	900	145
10.03	3200	800	2550	640	2050	420	1250	230	2550	640	2050	450	800	145
11.03	2900	800	2300	640	1900	420	1150	230	2300	640	1900	450	720	145
12.03	2650	670	2100	530	1700	370	1050	200	2100	530	1700	410	650	130

Warnings on using the drilling condition tables

1. Adjust drilling condition according to the rigidity of machine or work clamp state.
2. Wet condition are for drilling with water soluble cutting fluid.
3. In non water soluble cutting fluid, reduce the rotation and feed by 20%.
4. Use on internal coolant.

ML Condition









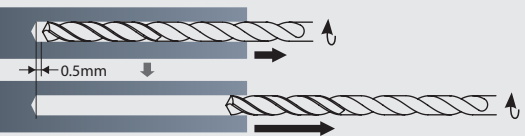
AQDEXOHPLT

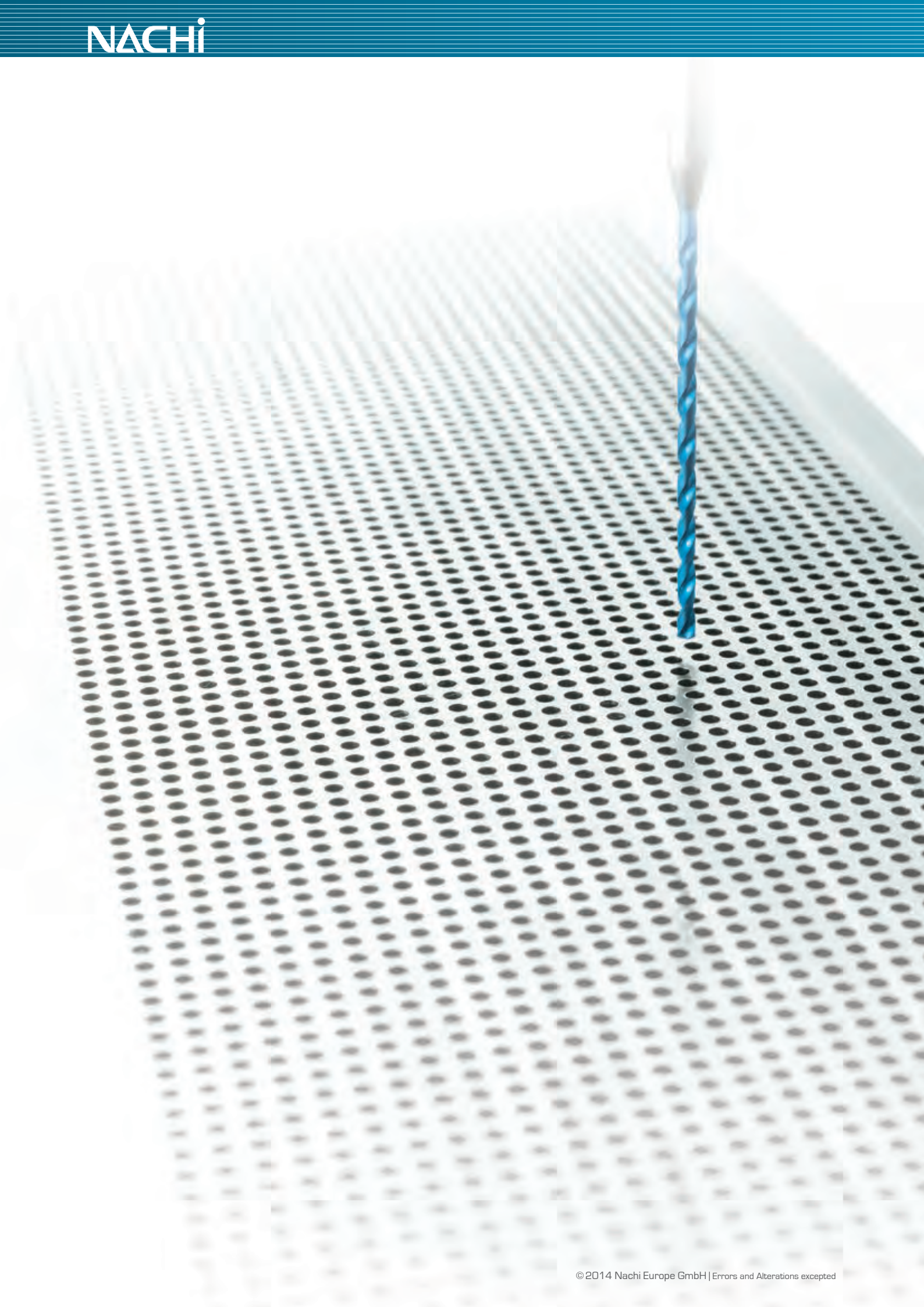
Work material	SS400 S50C FC250 Structural steels Carbon steels		SCM440 NAK HPM Alloy steels		SKD61 NAK HPM Mold steels Hardened steels		Hardened Steels		FCD400 Ductile cast iron	
	~200HB		20~30HRC		30~40HRC					
mm	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min	min ⁻¹	mm/min
3.03	6800	550	5800	470	5250	360	2600	150	5800	500
4.03	5100	550	4350	470	3950	360	2000	150	4350	500
5.03	4100	550	3500	470	3150	360	1600	150	3500	500
6.03	3400	520	2900	440	2650	330	1300	140	2900	470
7.03	2950	520	2500	440	2250	330	1150	140	2500	470
8.03	2600	520	2200	440	2000	330	1000	140	2200	470
9.03	2300	460	1950	400	1750	290	900	130	1950	420
10.03	2050	460	1750	400	1600	290	800	130	1750	420
11.03	1900	460	1600	400	1450	290	700	120	1600	420
12.03	1700	390	1450	330	1300	250	650	110	1450	350

Warnings on using the drilling condition tables

1. Adjust drilling condition according to the rigidity of machine or work clamp state.
2. Use on internal coolant.

Recommended usage for Deep hole drill

<p>Guide hole drilling (AQDEXOHPLT)</p>  <p>AQDEXOHPLT</p> <p>For angled surface</p>  <p>AQDEXZ</p>  <p>AQDEXOHPLT</p>	<p>We recommend pre-drilling of guide holes. Depth is 2 to 3D. We recommend the AQDEXOHPLT for guide hole drilling. Select one with a diameter 0.03 mm larger than the deep hole drill when using AQDEXOHPLT. If the part is canted or misshapened, use the AQDEXZ to make a flat surface before use.</p>
<p>Deep hole drilling (Insert it in a guide hole)</p> 	<p>Penetrate into the guide hole at low speed until 2 to 3 mm from the bottom of the guide hole. (About, Rotation 500min⁻¹, Feed 1000 mm/min)</p>
<p>Deep hole drilling</p> 	<p>Start drilling at normal speed and feed</p>
<p>Deep hole drilling (Completion)</p> <p>Penetration on angled surface</p>  <p>Normal feed</p>  <p>Feed by 50%</p> 	<p>For through holes, drill at normal feed until penetration. Before penetrating through, lower the feed. To prevent drill from breaking.</p>
<p>Deep hole drilling (Back)</p>  <p>0.5mm</p>	<p>After drilling is completed and once the bit has passed through the bottom of the drill hole, decrease speed and pull the drill back through the hole. (About, Rotation 500min⁻¹, Feed 2000 mm/min)</p>



AQUA Drill EX Family

Selection Chart

List No.	Type	Cutting Fluid	Structural Steels	Carbon Steels	Pre-Hardened Steels Alloy Steels	Hardened Steels Mold Steels	Hardened Steels		Stainless Steels		Titanium Alloys Nickel Alloys	Cast Iron
			SS400	S45C S50C	SCR NAK	25 ~ 40 HRC	40 ~ 50 HRC	50 ~ 65 HRC	SUS304 SUS316	SUS420	FCD FC	
L9600	AQUA Drill EX Stub	Wet & Dry ¹	■	■	■	■	■		○ ²	○		○
L9602	AQUA Drill EX Regular		■	■	■	■	■		○ ²	○		○
L9604	AQUA Drill EX Oil Hole 3D	Wet & MQL	■	■	■	■	■		○ ²	○	○	■
L9606	AQUA Drill EX Oil Hole 5D		■	■	■	■	■		○ ²	○	○	■
L9608	AQUA Drill EX Oil Hole 8D		■	■	■	■	■		○ ²	○	○	■
L9826	AQUA Drill EX Oil Hole 3 Flutes 3D	Wet	■	■	■	■	■		○	○		○
L9820	AQUA Drill EX Oil Hole 3 Flutes 5D		■	■	■	■	■		○	○		○
L9544	AQUA Microdrill	Wet & Dry ¹	■	■	■	■	■		■ ²	■	○	○
L9546	AQUA 3Flute		■	■	■	■	■			○		○
L9548	AQUA Hard						■					○

¹ Use in Wet condition when drill size is under 1 mm

² Dry & MQL drilling not recommended

■ Excellent ○ Good

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