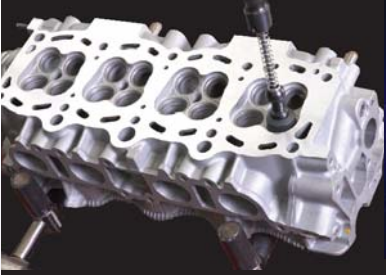




INTRODUCING THE ALL NEW SOLID CARBIDE V-DRILL

FOR TITANIUM AND STAINLESS STEEL



Variable rake

High performance point

Rake chamfer

Variable helix

THE HIGH-PERFORMANCE V-DRILL IMPROVES CUTTING TIME AND FINISH, GENERATING STRAIGHTER ROUNDER HOLES.

APPLICABLE FOR AUTOMOTIVE, AEROSPACE AND GENERAL USE.

V-DRILL SPEED AND FEED RATES

Material Group	Speed SFM	Feed Rate (I.P.R.)				
		1/16"	1/8"	1/4"	1/2"	3/4"
Aluminum/ Aluminum Alloys	300-600	.0013	.004	.008	.013	.016
Aluminum Alloyed Si > 10%	150-400	.0013	.003	.007	.011	.013
Soft Cast Irons	200-300	.0015	.004	.006	.011	.013
Medium Cast Irons	125-225	.0015	.004	.006	.009	.011
Malleable Cast Irons	65-200	.0010	.003	.005	.008	.011
Brass	200-300	.0012	.003	.004	.005	.007
Bronze	150-250	.0012	.003	.004	.005	.007
Coppers/ Copper Alloys	150-300	.0015	.004	.007	.011	.013
Magnesium	300-600	.0015	.004	.008	.013	.016
Nickel Alloys	75-200	.0015	.004	.006	.010	.013
Free Machining Stainless Steels	100-150	.0015	.004	.006	.009	.013
Work Hardening Stainless Steels	50-100	.0010	.003	.005	.007	.011
Low Carbon Steels	150-300	.0015	.003	.005	.008	.013
Medium Carbon Steels	100-200	.0015	.003	.004	.007	.011
High Tensile (35-40 Rc) Steels	75-150	.0015	.003	.004	.005	.006
High Tensile (40-45 Rc) Steels	50-100	.0012	.002	.003	.004	.005
High Tensile (45 Rc+) Steels	25-75	.0010	.0008	.002	.003	.004
Tool Steels	40-100	.0015	.0016	.004	.006	.009
Soft Titanium	80-125	.0015	.003	.005	.007	.011
Titanium Alloys Hard Titanium	40-100	.0012	.002	.003	.006	.009



www.mastercuttool.com

965 F. Harbor Lake Dr.
 Safety Harbor, FL 34695 USA.
 Phone (727) 726-5336
 Fax (727) 725-2532
 Email sales@mastercuttool.com

PROUDLY DISTRIBUTED BY: