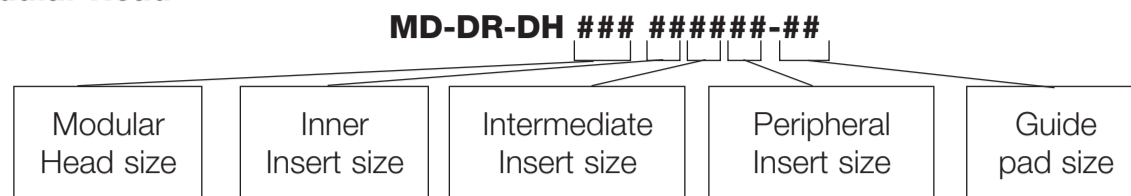
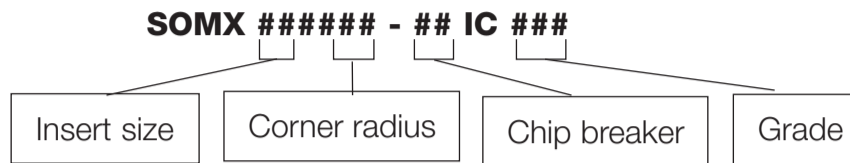


Description Code Key

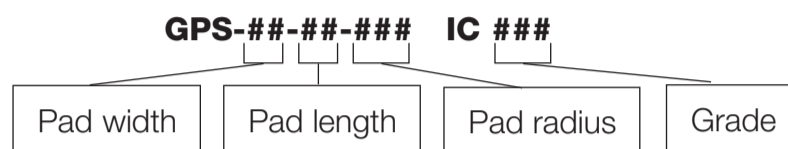
Modular Head



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	Material	Condition	Tensile Strength Rm [N/mm ²]	Hardness HB	Material No.	V _c [m/min]	Feed Vs. Drill Diameter		
							33<ØD<40 (mm)		
							f [mm/rev]		
P	Non-alloy steel and cast steel, free cutting steel	< 0.25 %C	Annealed	420	125	1	100-150	0.10-0.25	
		≥ 0.25 %C	Annealed	650	190	2			
		≥ 0.55 %C	< 0.55 %C	Quenched and tempered	850	250	3	80-150	0.15-0.30
			≥ 0.55 %C	Annealed	750	220	4		
				Quenched and tempered	1000	300	5		
	Low alloy and cast steel (less than 5% of alloying elements)	Quenched and tempered	Annealed	600	200	6	70-120	0.15-0.30	
			1000	300	8				
			1200	350	9				
	High alloyed steel, cast steel and tool steel	Annealed	680	200	10	80-150	0.10-0.25		
		Quenched and tempered	1100	325	11	70-120	0.10-0.25		
	K	Grey cast iron (GG)	Ferritic / pearlitic		180	15	180-300	0.18-0.35	
Pearlitic / martensitic				260	16				
Nodular cast iron (GGG)		Ferritic		160	17	150-250	0.15-0.30		
		Pearlitic		250	18				
Malleable cast iron		Ferritic		130	19	150-250	0.15-0.35		
		Pearlitic		230	20				

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