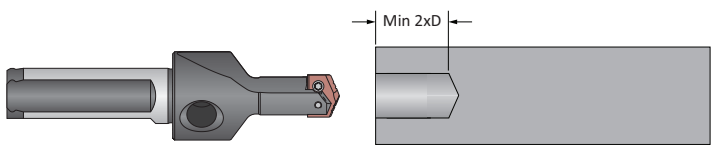
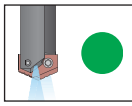
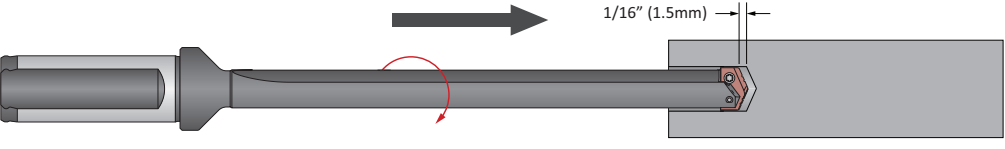
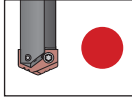

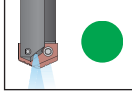
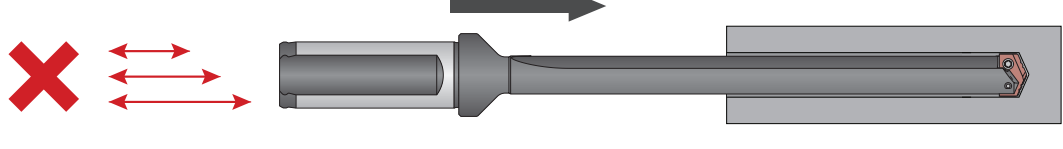
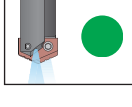
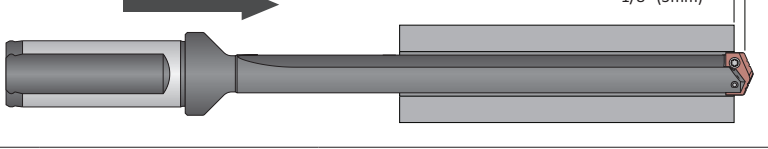
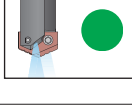

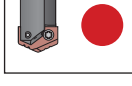


T-A® Deep Hole Drilling Guidelines

For Lengths Greater Than 9xD (including Extended, Long, XL, 3XL, and Special Length)

<p>1. Pilot Hole 100 % RPM 100% IPR (mm/rev)</p>	<p>Establish the pilot hole using the same diameter short drill to a depth of 2xD minimum. Utilize a pilot drill with the same or larger included point angle.</p>	 <p>Coolant ON</p> 
<p>2. Feed-in 50 RPM max 12 IPM (300 mm/min)</p>	<p>Feed the longer drill within 1/16" (1.5mm) short of the established pilot hole bottom at a maximum of 50 RPM and 12 IPM (300 mm/min) feed rate.</p>	 <p>Coolant OFF</p> 
<p>3. Deep Hole Transition Drilling 50 % RPM 75% IPR (mm/rev)</p>	<p>Drill additional 1xD past the bottom of the pilot hole at 50% reduction of recommended speed and 25% reduction of recommended feed. Minimum of 1 second dwell is required to meet full speed before feeding.</p>	 <p>Coolant ON</p> 
<p>4. Deep Hole Drilling - Blind 100% RPM 100% IPR (mm/rev)</p>	<p>Drill to full depth at recommended speed and feed for longer drill according to Allied speed and feed charts. No peck cycle recommended.</p>	 <p>Coolant ON</p> 
<p>5. Deep Hole Drilling - at Breakout 50% RPM 75% IPR (mm/rev)</p>	<p>For through holes only: Reduce speed by 50% and feed by 25% prior to breakout. Do not breakout more than 1/8" (3mm) past the full diameter of the drill.</p>	 <p>Coolant ON</p> 
<p>6. Drill Retract 50 RPM max</p>	<p>Reduce speed to a maximum of 50 RPM before retracting from the hole.</p>	 <p>Coolant OFF</p> 

⚠ WARNING Tool failure can cause serious injury. To prevent:

- When using holders without support bushing, use a short T-A® holder to establish an initial hole that is a minimum of 2 diameters deep.
- Do not rotate tool holder more than 50 RPM unless it is engaged with the workpiece or fixture.

Visit www.alliedmachine.com/DeepHoleGuidelines for the most up-to-date information and procedures. Factory technical assistance is available for your specific applications through our Application Engineering Team.