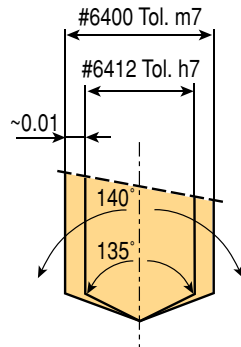


Technical Bulletin: Operation of Exclusive Line Micro Drills

Pilot drilling

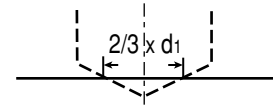
For applications using Series 6412 solid carbide micro-precision drills to drilling depths of 15xD we recommend a pilot hole 1xD up to 2xD depth.

For this pilot hole, the Series 6400 solid carbide micro-precision drill (4xD) is optimally suited. Its 140° point angle and its m7 diameter tolerance are perfectly adapted.



Note: Series 6408 and 6412 are coolant fed. Minimum recommended coolant pressure is 250 - 400 psi.

Spot Drilling



In order to achieve full performance with Series 6408 solid carbide micro-precision drills at 8xD drilling depth, we recommend spot drilling.

The ExclusiveLine Series 6400 solid carbide micro-precision drill (up to 4xD) can be applied for this purpose. The spot drill diameter should be approximately $\frac{2}{3}xD$.

Coolant Fed Carbide Micro-Drills:

Series **6408** - 8xD, 135° 4-facet point angle

Series **6412** - 15xD, 135° 4-facet point angle

Solid Carbide Micro-Drills:

Series **6400** - 4xD, 140° 4-facet point angle

Series **6401** - 7xD, 140° 4-facet point angle

