All deep hole drills must utilize a pilot hole.

Deep hole drills must never operate at full speed without support in the pilot hole.

Procedure:

- Machine a pilot hole with an m7 tolerated series 5514 RT 100 drill to a minimum pilot depth of 1 to 1.5 x D.
- Enter the pilot hole at a speed of approx. 300 RPM, and with a feed rate of approx. 19 - 20 IPM.
- Start high coolant pressure and increase RPM.
- Continuous drilling to complete hole depth without peck cycle.
- For through holes with oblique exit, reduce the feed rate v, to 40% approx. 1 mm prior to break-through.
- After reaching hole depth reduce machine spindle RPM and withdraw.

STOP

- Minimum of 250 PSI coolant pressure recommended -

<table>
<thead>
<tr>
<th>RPM =</th>
<th>SFM</th>
<th>( x ) 3.82</th>
<th>mm/rev. = ( \frac{IPR}{25.40} ) Liter</th>
<th>mm = in. ( x ) 25.40</th>
</tr>
</thead>
<tbody>
<tr>
<td>IPM =</td>
<td>IPR ( \times ) RPM</td>
<td>HOLE DEPTH ( \text{in.} \times 60 ) = Cut Time (seconds)</td>
<td>mm = in. ( \times ) 25.40</td>
<td></td>
</tr>
</tbody>
</table>

m/min. = SFM \( + \) 3.28 \( \times \) Bar | PSI \( + \) 14.50

RT 100 T Deep Hole Drilling Solutions

- 20xD Series 6511
- 25xD Series 6512
- 30xD Series 6513
- 40xD Series 6514