

($\varnothing D$ - Tolerance: m7)

SumiDrill Power Series SDP Type (DIN)

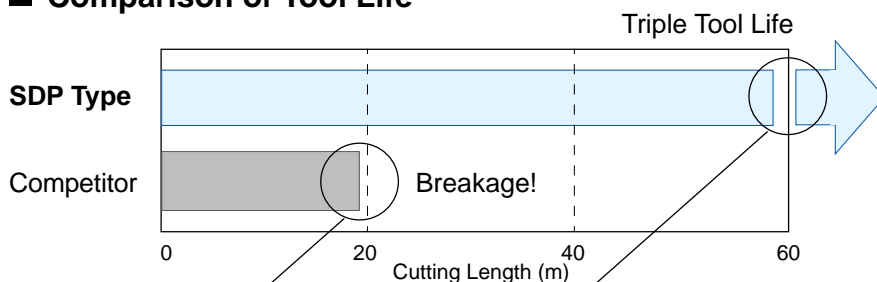
Maximum Feed Rate Result

Feed Rate (mm/rev)	0,30	0,40	0,50	0,55	0,60	0,65	0,70	0,75	0,80
SDP Type	OK	OK	OK	OK	OK	OK	OK	OK	OK
Competitor	OK	Breakage!							

Internal test conditions

Drill: $\varnothing 4$, L/D=5
Work Material: Carbon Steel (C50)
Cutting Data: $v_c=80\text{m/rev}$, $a_p=18\text{mm}$

Comparison of Tool Life



Drill: $\varnothing 8$, L/D=5
Work Material: Carbon Steel (C50)
Cutting Data: $v_c=80\text{m/min}$, $f=0,15\text{mm/rev}$, $a_p=38\text{mm}$, Through hole, Internal coolant

Competitor

SDP Type

Cut volume: 950cm^3

Cut volume: 3800cm^3



500 Holes

Work: C50, Drill Dia: 8mm, L/D=5

2000 Holes

SDP Type



Competitor



Excellent Hole Accuracy

	Hole Accuracy	Chip Shape
SDP Type	<p>Stable hole size</p> <p>Enlarge (mm)</p> <p>Number of holes</p> <p>Entrance Bottom</p>	<p>Compact cutting chips</p>
Competitor	<p>Unstable</p> <p>Enlarge (mm)</p> <p>Number of holes</p> <p>Entrance Bottom</p> <p>Breakage!</p>	<p>Longer cutting chips</p>

Drill: $\varnothing 8$, L/D=5
Workpiece: Carbon Steel (C50)
Cutting Data: $v_c=80\text{m/min}$, $f=0,25\text{mm/rev}$, $a_p=24\text{mm}$, Blind-hole, Internal coolant