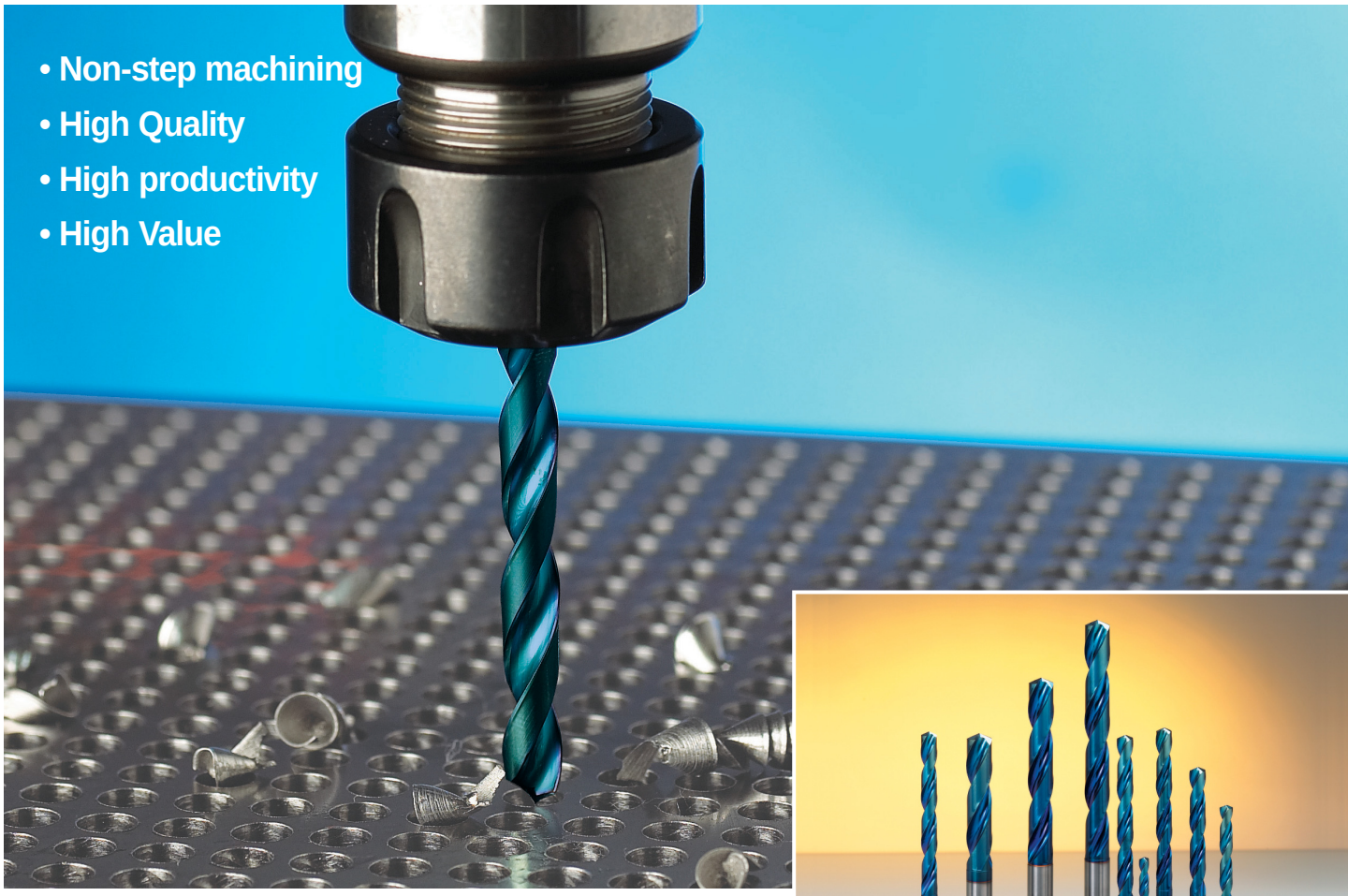
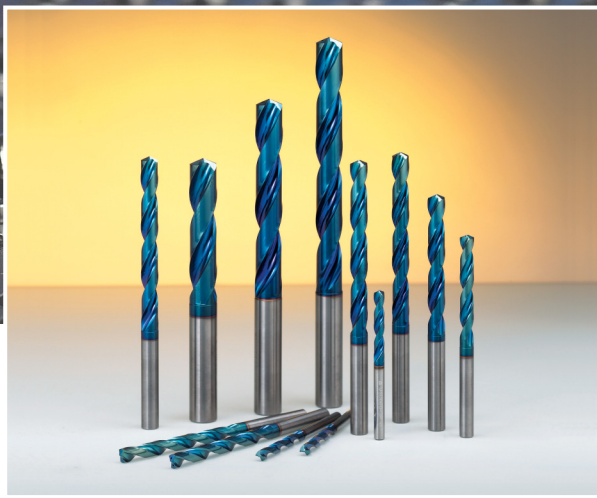
Excellent Chip Evacuation !

K-BLUE Coating (TiAlN)

MACH-Drill





Safety instruction

- Do not touch the edge with bare hand.
- Wear safety glasses or face cover.
- Make appropriate tool substitution when chattering, flame and noise.

Excellent Chip Evacuation !

MACH-Drill

INTRO

Optimal design chip pocket

- Wide and deep chip pocket minimize the friction during operation.
- Scratch free (protecting workpiece)
- Excellent chip evacuation

Curvilinear edge

- Curvilinear edge decreases cutting force by dispersing cutting load.
- Excellent wear resistance and shock resistance

Ultra micro grain substrate and K-Blue coating

- 0.6µm of tungsten carbide substrate.
- Enhanced toughness and wear resistance.
- K-Blue, TiAlN coating film guarantees excellent shock resistance.
- Good lubrication of K-blue coating.
- Non-step operation of 3D~7D, high speed machining.

3D, 5D, 7D standardization

- For your easy choice for drill, we standardize the aspect ratio of the mach drill
- For example, diameter Ø10mm and depth 30mm and without hole, take MSD100-3P!

MSD; Solid type & MSDH; Inner oil-hole type

- MSD's solid type and MSDH's inner oil-hole type.

Low cutting resistance type edge

- Low cutting resistance type edges guarantees better surface finish and chip breaking.
- Self centering

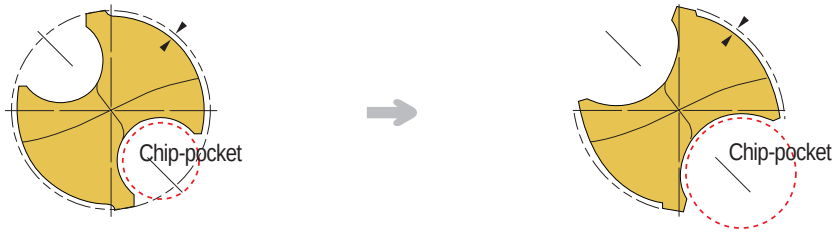
Rigid neck of drill

- rigid neck prevents breakage of neck.

Excellent Chip Evacuation !

MACH-Drill

Wide chip-pocket



Conventional Drill | Mach Drill

Optimal Chip-pocket Design

1. Wide chip pocket area.
- 140% wider chip pocket than VSD, Better chip evacuation.

2. Torsion rigidity increasing.
- Special rigidity enhancing design for weakened flute by enhanced chip pocket area.

3. Better lubrication.
- K-Blue's lubrication shows chipping resistance and reduces friction during chip evacuation.

4. Post treatment for better chip evacuation
- Outer edge design for better chip evacuation.

Specification Line-up

Line-up as per aspect ratio

MSD□□□-7P

MSD□□□-5P

MSD□□□-3P

Line-up as per aspect ratio

➔ Various choice as aspect ratio.
- ex) Solid, Ø10.2mm, 50mm hole machining = 50 ÷ 10.2 ≒ 5 ➔ MSD102-5P

Excellent Chip Evacuation !

MACH-Drill

Line-up as per coolant type

MSD Type

MSDH Type

- **MSD Type for solid type**
- **MSDH Type for inner oil-hole type**
  - ➔ Wider choice for coolant type.

Line-up as per workpiece

- **Line-up as per workpiece** (ex : MSD102-5 **P** ⇒ steel)
  - ➔ **P** : steel **M** : stainless **K** : brass, aluminum

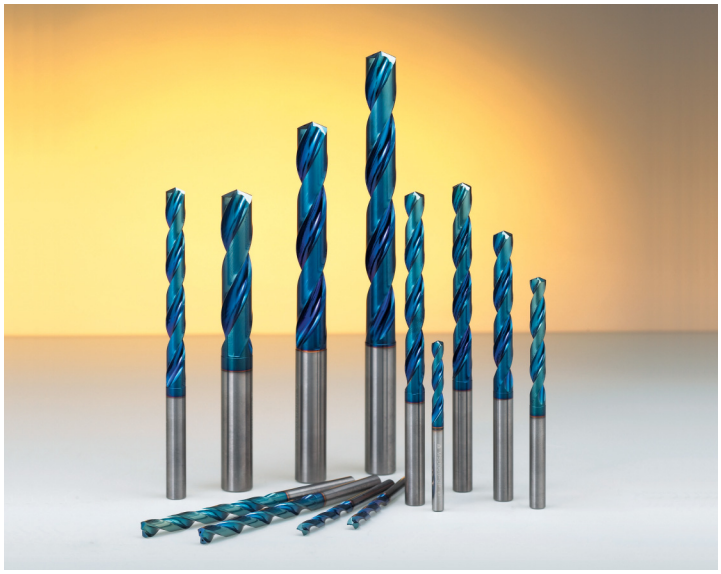
* Note : M and K are under developing

MSD□□□-7P

MSD□□□-5P

MSD□□□-3P

Low cutting resistance type edge



Low cutting resistance type edge

- Uniformity of edge treatment
  - ➔ equalized quality.
- Protecting workpiece
  - ➔ Low cutting resistance type edge operate well in medium-finish machining. Workpiece protecting and Good surface finish.
- Better chip breaking
  - ➔ Based on cutting process study, guarantees better chip breaking at high and low speed.

Excellent Chip Evacuation !

MACH-Drill

K-Blue Coating

K-Blue Coating

1. Decrease of Macro particle.
   ➔ Chipping free from macro particle.

2. Better hardness and toughness.
   ➔ covering wide cutting speed and feed rate range.

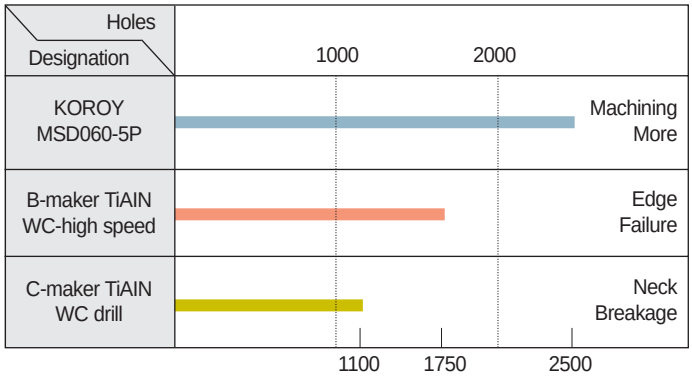
3. Special coating layer at most-outer edge.
   ➔ Special coating film with better lubrication guarantees adhesion resistance.

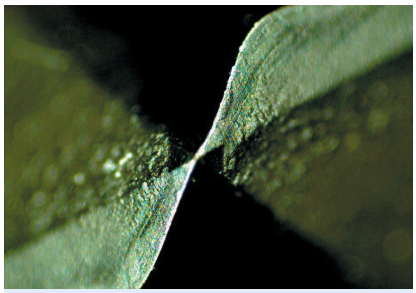
4. Pre treatment before coating process.
   ➔ Higher adherency of coating layer by pre treatment.

Mach- drill machining example

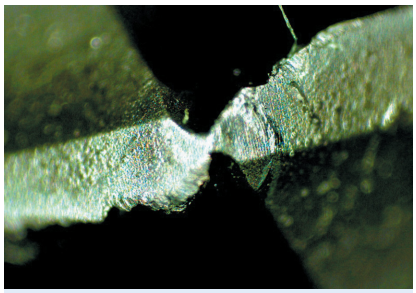
Cutting condition

- Designation : MSD060-5P
- Workpiece : SCM440,
  AISI4140, 42CrMo4 (HRC20)
- V : 100m/min 330 sfm
- f : 0.15mm/rev 0.006 ipr
- Coolant : Wet
- Tool life criteria : 0.2mm flank wear
  (25 mm, 1 inch plate drilling)





MSD060-5P
after 1750 hole machining



B-maker TiAlN coating, high speed drill
after 1750 hole machining

Excellent Chip Evacuation !

MACH-Drill

■ MSD (Solid Type)

MSD□□□-3P					MSD□□□-5P					MSD□□□-7P				
3D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)	5D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)	7D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)
025	●				025	●				025				
026	●				026					026				
027	●				027					027				
028	●	20	65	3	028		25	70	3	028		30	75	3
029	●				029					029				
030	●				030	●				030				
031	●				031					031				
032	●				032	●				032				
033	●				033					033				
034	●				034					034				
035	●	25	71	4	035	●	34	80	4	035		40	86	4
036	●				036					036				
037	●				037					037				
038	●				038					038				
039	●				039					039				
040	●				040	●				040				
041	●				041					041				
042	●				042	●				042				
043	●				043					043				
044	●				044					044				
045	●	30	77	5	045	●	43	90	5	045		50	97	5
046	●				046					046				
047	●				047					047				
048	●				048					048				
049	●				049					049				
050	●				050	●				050				
051	●				051					051				
052	●				052	●				052				
053	●				053					053				
054	●				054					054				
055	●	35	81	6	055	●	48	96	6	055		60	108	6
056	●				056					056				
057	●				057					057				
058	●				058	●				058				
059	●				059					059				
060	●				060	●				060				
061	●				061					061				
062	●				062	●				062				
063	●				063					063				
064	●				064					064				
065	●	40	84	7	065	●	56	105	7	065		70	120	7
066	●				066					066				
067	●				067					067				
068	●				068	●				068				
069	●				069					069				
070	●				070	●				070				
071	●				071					071				
072	●				072					072				
073	●				073					073				
074	●				074					074				
075	●	45	90	8	075	●	60	110	8	075		80	130	8
076	●				076					076				
077	●				077					077				
078	●				078					078				
079	●				079					079				
080	●				080	●				080				
081	●				081					081				
082	●	48	97	9	082	●	72	125	9	082		90	143	9
083	●				083	●				083				
084	●				084					084				

Excellent Chip Evacuation !

MACH-Drill

■ MSD (Solid Type)

MSD□□□-3P					MSD□□□-5P					MSD□□□-7P				
3D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)	5D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)	7D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)
085	●	48	97	9	085	●	72	125	9	085		90	143	9
086	●				086	●				086				
087	●				087	●				087				
088	●				088	●				088				
089	●				089	●				089				
090	●				090	●				090				
091	●	52	106	10	091		75	129	10	091		95	150	10
092	●				092					092				
093	●				093					093				
094	●				094					094				
095	●				095	●				095				
096	●				096					096				
097	●				097					097				
098	●				098	●				098				
099	●				099					099				
100	●				100	●				100				
101	●	56	111	11	101		83	140	11	101		105	160	11
102	●				102	●				102				
103	●				103	●				103				
104	●				104	●				104				
105	●				105	●				105				
106	●				106					106				
107	●				107					107				
108	●				108					108				
109	●				109	●				109				
110	●				110	●				110				
111	●	60	118	12	111		90	148	12	111		114	172	12
112	●				112					112				
113	●				113					113				
114	●				114					114				
115	●				115	●				115				
116	●				116					116				
117	●				117					117				
118	●				118	●				118				
119	●				119					119				
120	●				120	●				120				
121	●	65	125	13	121	●	98	158	13	121		124	184	13
122	●				122	●				122				
123	●				123	●				123				
124	●				124					124				
125	●				125	●				125				
126	●				126	●				126				
127	●				127					127				
128	●				128					128				
129	●				129					129				
130	●				130	●				130				
131		70	132	14	131		105	167	14	131		133	195	14
132					132					132				
133					133					133				
134					134					134				
135	●				135	●				135				
136					136					136				
137	●				137	●				137				
138					138	●				138				
139					139					139				
140	●				140	●				140				
141		75	139	15	141		108	172	15	141		138	202	15
142	●				142					142				
143					143	●				143				
144	●				144					144				

Excellent Chip Evacuation !

MACH-Drill

■ MSD (Solid Type)

MSD□□□-3P					MSD□□□-5P					MSD□□□-7P				
3D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)	5D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)	7D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)
145	●				145	●				145				
146					146	●				146				
147	●	75	139	15	147		108	172	15	147		138	202	15
148					148					148				
149					149					149				
150	●				150	●				150				
151					151					151				
152					152					152				
153					153					153				
154					154					154				
155	●	80	146	16	155	●	112	178	16	155		144	210	16
156					156					156				
157					157					157				
158					158					158				
159					159					159				
160	●				160	●				160				
161					161	●				161				
162					162					162				
163					163					163				
164					164					164				
165	●	85	151	17	165	●	120	186	17	165		153	220	17
166					166					166				
167					167					167				
168					168					168				
169					169	●				169				
170	●				170	●				170				
171					171					171				
172					172					172				
173					173					173				
174					174					174				
175	●	85	153	18	175	●	120	188	18	175		162	230	18
176					176					176				
177					177					177				
178					178					178				
179					179					179				
180	●				180	●				180				
181					181	●				181				
182					182					182				
183					183					183				
184					184					184				
185	●	88	157	19	185	●	124	193	19	185		171	240	19
186					186					186				
187					187					187				
188					188					188				
189					189					189				
190	●				190	●				190				
191					191					191				
192					192					192				
193					193					193				
194					194					194				
195	●	90	160	20	195	●	130	200	20	195		180	250	20
196					196					196				
197					197					197				
198					198					198				
199					199					199				
200	●				200	●				200				

Excellent Chip Evacuation !

MACH-Drill

■ MSDH (Oil Hole Type)

MSDH□□□-3P					MSDH□□□-5P					MSDH□□□-7P				
3D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)	5D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)	7D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)
025					025	●				025				
026					026					026				
027					027					027				
028		20	65	3	028		25	70	3	028		30	75	3
029					029					029				
030					030	●				030				
031					031					031				
032					032					032				
033					033					033				
034					034					034				
035		25	71	4	035	●	34	80	4	035		40	86	4
036					036					036				
037					037					037				
038					038					038				
039					039					039				
040					040	●				040				
041					041					041				
042					042					042				
043					043					043				
044					044					044				
045		30	77	5	045	●	43	90	5	045		50	97	5
046					046					046				
047					047					047				
048					048					048				
049					049					049				
050					050	●				050				
051					051					051				
052					052					052				
053					053					053				
054					054					054				
055		35	81	6	055	●	48	96	6	055		60	108	6
056					056					056				
057					057					057				
058					058					058				
059					059					059				
060					060	●				060				
061					061					061				
062					062					062				
063					063					063				
064					064					064				
065		40	84	7	065	●	56	105	7	065		70	120	7
066					066					066				
067					067					067				
068					068					068				
069					069					069				
070					070	●				070				
071					071					071				
072					072					072				
073					073					073				
074					074					074				
075		45	90	8	075	●	60	110	8	075		80	130	8
076					076					076				
077					077					077				
078					078					078				
079					079					079				
080					080	●				080				
081					081					081				
082		48	97	9	082		72	125	9	082		90	143	9
083					083					083				
084					084					084				

Excellent Chip Evacuation !

MACH-Drill

■ MSDH (Oil Hole Type)

MSDH□□□-3P					MSDH□□□-5P					MSDH□□□-7P				
3D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)	5D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)	7D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)
085		48	97	9	085	●	72	125	9	085		90	143	9
086					086					086				
087					087					087				
088					088					088				
089					089					089				
090					090	●				090				
091		52	106	10	091		75	129	10	091		95	150	10
092					092					092				
093					093					093				
094					094					094				
095					095	●				095				
096					096					096				
097					097					097				
098					098					098				
099					099					099				
100					100	●				100				
101		56	111	11	101		83	140	11	101		105	160	11
102					102					102				
103					103					103				
104					104					104				
105					105	●				105				
106					106					106				
107					107					107				
108					108					108				
109					109					109				
110					110	●				110				
111		60	118	12	111		90	148	12	111		114	172	12
112					112					112				
113					113					113				
114					114					114				
115					115	●				115				
116					116					116				
117					117					117				
118					118					118				
119					119					119				
120					120	●				120				
121		65	125	13	121		98	158	13	121		124	184	13
122					122					122				
123					123					123				
124					124					124				
125					125	●				125				
126					126					126				
127					127					127				
128					128					128				
129					129					129				
130					130	●				130				
131		70	132	14	131		105	167	14	131		133	195	14
132					132					132				
133					133					133				
134					134					134				
135					135	●				135				
136					136					136				
137					137					137				
138					138					138				
139					139					139				
140					140	●				140				
141		75	139	15	141		108	172	15	141		138	202	15
142					142					142				
143					143					143				
144					144					144				

Excellent Chip Evacuation !

MACH-Drill

■ MSDH (Oil Hole Type)

MSD□□□-3P					MSD□□□-5P					MSD□□□-7P				
3D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)	5D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)	7D Diameter	stock	Flute Length	Total Length	Shank diameter (mm)
145		75	139	15	145	●	108	172	15	145		138	202	15
146					146					146				
147					147					147				
148					148					148				
149					149					149				
150					150	●				150				
151		80	146	16	151		112	178	16	151		144	210	16
152					152					152				
153					153					153				
154					154					154				
155					155	●				155				
156					156					156				
157					157					157				
158					158					158				
159					159					159				
160					160	●				160				
161		85	151	17	161		120	186	17	161		153	220	17
162					162					162				
163					163					163				
164					164					164				
165					165	●				165				
166					166					166				
167					167					167				
168					168					168				
169					169					169				
170					170	●				170				
171		85	153	18	171		120	188	18	171		162	230	18
172					172					172				
173					173					173				
174					174					174				
175					175	●				175				
176					176					176				
177					177					177				
178					178					178				
179					179					179				
180					180	●				180				
181		88	157	19	181		124	193	19	181		171	240	19
182					182					182				
183					183					183				
184					184					184				
185					185	●				185				
186					186					186				
187					187					187				
188					188					188				
189					189					189				
190					190	●				190				
191		90	160	20	191		130	200	20	191		180	250	20
192					192					192				
193					193					193				
194					194					194				
195					195	●				195				
196					196					196				
197					197					197				
198					198					198				
199					199					199				
200					200	●				200				

Excellent Chip Evacuation !

MACH-Drill

Cutting condition

Solid type (MSD□□□-□P)

Work piece	V (m/min) (sfm)	L/D (□)	feed rate as per diameter (mm/rev) (ipr)					
			030~050	051~080	081~100	101~140	141~170	170~200
High carbon steel Low alloy steel (Under HB260)	80 (65~100) 265 (215~330)	3	0.08~0.12 0.0032-0.0048	0.10~0.15 0.0040-0.0060	0.12~0.17 0.0048-0.0068	0.15~0.22 0.0060-0.0088	0.20~0.25 0.0080-0.0100	0.23~0.28 0.0092-0.0112
		5	0.06~0.08 0.0024-0.0032	0.08~0.10 0.0032-0.0040	0.10~0.15 0.0040-0.0060	0.13~0.18 0.0052-0.0072	0.15~0.20 0.0060-0.0080	0.20~0.25 0.0080-0.0100
		7	0.05~0.07 0.0020-0.0028	0.07~0.09 0.0028-0.0036	0.09~0.03 0.0036-0.0012	0.12~0.16 0.0048-0.0064	0.14~0.18 0.0056-0.0072	0.18~0.23 0.0072-0.0092
High carbon steel High alloy steel (Under HB350)	70 (60~85) 230 (200~280)	3	0.08~0.12 0.0032-0.0048	0.10~0.15 0.0040-0.0060	0.12~0.17 0.0048-0.0068	0.15~0.22 0.0060-0.0088	0.20~0.25 0.0080-0.0100	0.23~0.28 0.0092-0.0112
		5	0.06~0.08 0.0024-0.0032	0.08~0.10 0.0032-0.0040	0.10~0.15 0.0040-0.0060	0.13~0.18 0.0052-0.0072	0.15~0.20 0.0060-0.0080	0.20~0.25 0.0080-0.0100
		7	0.05~0.07 0.0020-0.0028	0.07~0.09 0.0028-0.0036	0.09~0.03 0.0036-0.0012	0.12~0.16 0.0048-0.0064	0.14~0.18 0.0056-0.0072	0.18~0.23 0.0072-0.0092
Stainless steel (HB130~275)	35 (25~45) 115 (82~180)	3	0.08~0.12 0.0032-0.0048	0.10~0.15 0.0040-0.0060	0.12~0.17 0.0048-0.0068	0.15~0.22 0.0060-0.0088	0.20~0.25 0.0080-0.0100	0.23~0.28 0.0092-0.0112
		5	0.06~0.08 0.0024-0.0032	0.08~0.10 0.0032-0.0040	0.10~0.15 0.0040-0.0060	0.13~0.18 0.0052-0.0072	0.15~0.20 0.0060-0.0080	0.20~0.25 0.0080-0.0100
		7	0.05~0.07 0.0020-0.0028	0.07~0.09 0.0028-0.0036	0.09~0.03 0.0036-0.0012	0.12~0.16 0.0048-0.0064	0.14~0.18 0.0056-0.0072	0.18~0.23 0.0072-0.0092
Heat-resistant alloy (HB250~400)	40 (25~55) 130 (82~180)	3	0.08~0.12 0.0032-0.0048	0.10~0.15 0.0040-0.0060	0.12~0.17 0.0048-0.0068	0.15~0.22 0.0060-0.0088	0.20~0.25 0.0080-0.0100	0.23~0.28 0.0092-0.0112
		5	0.06~0.08 0.0024-0.0032	0.08~0.10 0.0032-0.0040	0.10~0.15 0.0040-0.0060	0.13~0.18 0.0052-0.0072	0.15~0.20 0.0060-0.0080	0.20~0.25 0.0080-0.0100
		7	0.05~0.07 0.0020-0.0028	0.07~0.09 0.0028-0.0036	0.09~0.03 0.0036-0.0012	0.12~0.16 0.0048-0.0064	0.14~0.18 0.0056-0.0072	0.18~0.23 0.0072-0.0092
Cast iron (HB150~300)	60 (55~65) 200 (180~215)	3	0.08~0.12 0.0032-0.0048	0.10~0.15 0.0040-0.0060	0.12~0.17 0.0048-0.0068	0.15~0.22 0.0060-0.0088	0.20~0.25 0.0080-0.0100	0.23~0.28 0.0092-0.0112
		5	0.06~0.08 0.0024-0.0032	0.08~0.10 0.0032-0.0040	0.10~0.15 0.0040-0.0060	0.13~0.18 0.0052-0.0072	0.15~0.20 0.0060-0.0080	0.20~0.25 0.0080-0.0100
		7	0.05~0.07 0.0020-0.0028	0.07~0.09 0.0028-0.0036	0.09~0.03 0.0036-0.0012	0.12~0.16 0.0048-0.0064	0.14~0.18 0.0056-0.0072	0.18~0.23 0.0072-0.0092

Inner oil-hole type (MSDH□□□-□P)

Work piece	V (m/min) (sfm)	L/D (□)	feed rate as per diameter (mm/rev) (ipr)					
			030~050	051~080	081~100	101~140	141~170	170~200
High carbon steel Low alloy steel (Under HB260)	100 (85~120) 330 (280~400)	3	0.08~0.12 0.0032-0.0048	0.10~0.15 0.0040-0.0060	0.12~0.17 0.0048-0.0068	0.15~0.22 0.0060-0.0088	0.20~0.25 0.0080-0.0100	0.23~0.28 0.0092-0.0112
		5	0.06~0.08 0.0024-0.0032	0.08~0.10 0.0032-0.0040	0.10~0.15 0.0040-0.0060	0.13~0.18 0.0052-0.0072	0.15~0.20 0.0060-0.0080	0.20~0.25 0.0080-0.0100
		7	0.05~0.07 0.0020-0.0028	0.07~0.09 0.0028-0.0036	0.09~0.03 0.0036-0.0012	0.12~0.16 0.0048-0.0064	0.14~0.18 0.0056-0.0072	0.18~0.23 0.0072-0.0092
High carbon steel High alloy steel (Under HB350)	80 (70~85) 265 (230~280)	3	0.08~0.12 0.0032-0.0048	0.10~0.15 0.0040-0.0060	0.12~0.17 0.0048-0.0068	0.15~0.22 0.0060-0.0088	0.20~0.25 0.0080-0.0100	0.23~0.28 0.0092-0.0112
		5	0.06~0.08 0.0024-0.0032	0.08~0.10 0.0032-0.0040	0.10~0.15 0.0040-0.0060	0.13~0.18 0.0052-0.0072	0.15~0.20 0.0060-0.0080	0.20~0.25 0.0080-0.0100
		7	0.05~0.07 0.0020-0.0028	0.07~0.09 0.0028-0.0036	0.09~0.03 0.0036-0.0012	0.12~0.16 0.0048-0.0064	0.14~0.18 0.0056-0.0072	0.18~0.23 0.0072-0.0092
Stainless steel (HB130~275)	55 (45~65) 180 (150~215)	3	0.08~0.12 0.0032-0.0048	0.10~0.15 0.0040-0.0060	0.12~0.17 0.0048-0.0068	0.15~0.22 0.0060-0.0088	0.20~0.25 0.0080-0.0100	0.23~0.28 0.0092-0.0112
		5	0.06~0.08 0.0024-0.0032	0.08~0.10 0.0032-0.0040	0.10~0.15 0.0040-0.0060	0.13~0.18 0.0052-0.0072	0.15~0.20 0.0060-0.0080	0.20~0.25 0.0080-0.0100
		7	0.05~0.07 0.0020-0.0028	0.07~0.09 0.0028-0.0036	0.09~0.03 0.0036-0.0012	0.12~0.16 0.0048-0.0064	0.14~0.18 0.0056-0.0072	0.18~0.23 0.0072-0.0092
Heat-resistant alloy (HB250~400)	50 (45~60) 165 (150~200)	3	0.08~0.12 0.0032-0.0048	0.10~0.15 0.0040-0.0060	0.12~0.17 0.0048-0.0068	0.15~0.22 0.0060-0.0088	0.20~0.25 0.0080-0.0100	0.23~0.28 0.0092-0.0112
		5	0.06~0.08 0.0024-0.0032	0.08~0.10 0.0032-0.0040	0.10~0.15 0.0040-0.0060	0.13~0.18 0.0052-0.0072	0.15~0.20 0.0060-0.0080	0.20~0.25 0.0080-0.0100
		7	0.05~0.07 0.0020-0.0028	0.07~0.09 0.0028-0.0036	0.09~0.03 0.0036-0.0012	0.12~0.16 0.0048-0.0064	0.14~0.18 0.0056-0.0072	0.18~0.23 0.0072-0.0092
Cast iron (HB150~300)	75 (65~85) 250 (215~265)	3	0.08~0.12 0.0032-0.0048	0.10~0.15 0.0040-0.0060	0.12~0.17 0.0048-0.0068	0.15~0.22 0.0060-0.0088	0.20~0.25 0.0080-0.0100	0.23~0.28 0.0092-0.0112
		5	0.06~0.08 0.0024-0.0032	0.08~0.10 0.0032-0.0040	0.10~0.15 0.0040-0.0060	0.13~0.18 0.0052-0.0072	0.15~0.20 0.0060-0.0080	0.20~0.25 0.0080-0.0100
		7	0.05~0.07 0.0020-0.0028	0.07~0.09 0.0028-0.0036	0.09~0.03 0.0036-0.0012	0.12~0.16 0.0048-0.0064	0.14~0.18 0.0056-0.0072	0.18~0.23 0.0072-0.0092

1. Step feed at every 1.5D if you want longer tool life.
2. Keep variation under 0.02mm.
3. Do not touch cutting edge & chips with bare hands.
4. Do not change shape of drill.
5. Coolant pressure for inner hole type = 3~5Kg/cm^2, volume=2~5ℓ/min.
6. Note : $N=1000 \times V / \pi D$, $F=N \times f$
   (N: R.P.M., F: Table feed, D: Diameter, π=3.1416)

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