



ACE Spot Drill >>

Spotting
Countersink
Chamfering

Accuracy! Coolant! Efficiency!

High rigidity, HPC high performance cutting, ultra-long tool life.

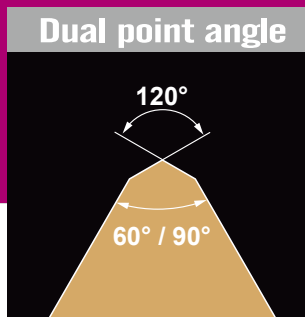


Features

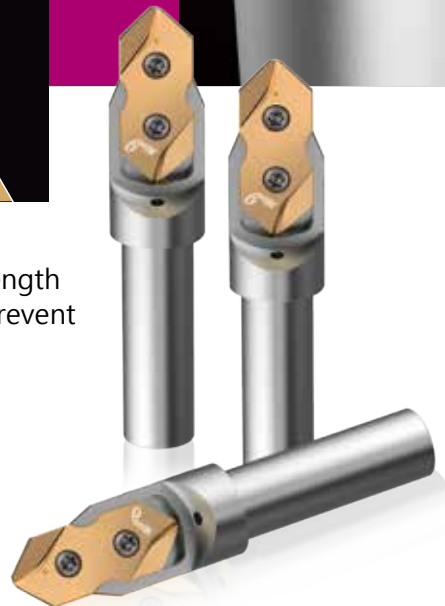
- ▶ 3 angles : 60° / 90° / 120°
- ▶ 3 different sizes of insert and holder, larger size is available on request.
- ▶ 2-flutes edged is symmetric, it reduces the lateral force.
 - High rigidity, HPC high performance cutting, ultra-long tool life.
 - Dual clamping screwed design ensures the vibration free during the cutting.
 - Each insert has 2 cutting edges
 - Holder with internal coolant.
 - Ultra long tool life.
 - Good for use on CNC lathe, Swiss type machine, small machine and weak clamping situation.



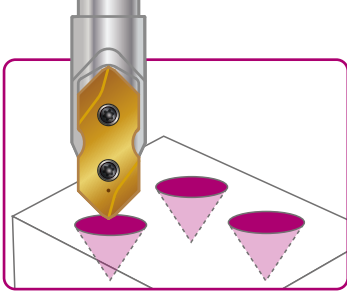
• It is symmetric.



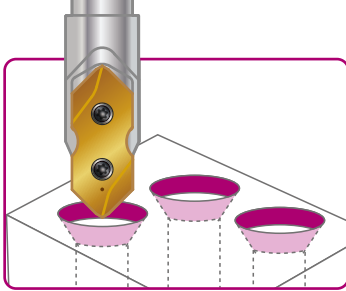
• The double point angles ensure strength at the centre to prevent fracturing.



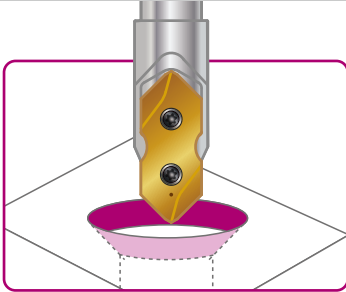
Spotting



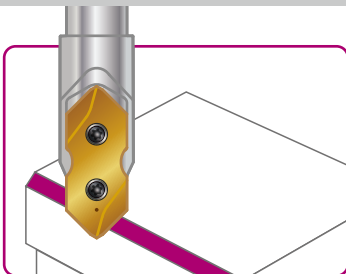
Countersink



Contour Chamfering



Chamfering



► Can drill with minimum quantity lubrication (MQL).

Coolant

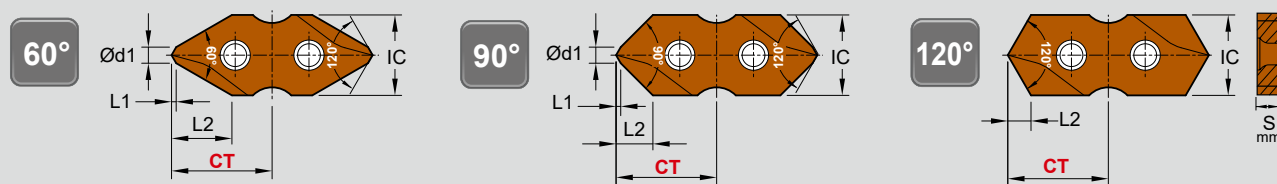


► **Internal Coolant**
 • Optimized coolant design for better balancing.

► **Dual clamping screwed design**
 • ensures the vibration free during the cutting.

► **Excellent repeatability.**
 No need tool length re-setting by insert type.
 Ultra long tool life.

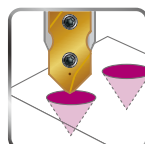
ACE Spot Drill Spotting & Countersink



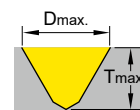
► Inserts >>

NC2057: • Universal grade for alloy steel and cast iron.
• Each insert has 2 cutting edges.

XP9000: • High positive geometry and sharp edge produces excellent surface finish.
• For non-ferrous material such as aluminum, titanium, brass, copper and long cutting chip metal.
• Each insert has 2 cutting edges.

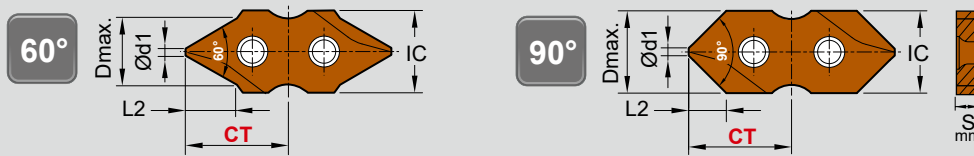


For Spotting & Countersink >>



IC	Angle ±0.5	Code	Parts No.	Coating	Grade	Ød1	L1	L2	Dmax.	Tmax.	S	CT ±0.025	
08	60°	06A121	S9MT0802-060	NC2057	P35	1.6	0.46	6.0	8	6.0	2.4	10	
		06A122		XP9000									-
	90°	06A131	S9MT0802-090	NC2057									AL(L)
		06A132		XP9000									-
	120°	06A141	S9MT0802-120	NC2057									AL(L)
		06A142		XP9000									-
10	60°	06A221	S9MT1003-060	NC2057	P35	2	0.58	7.5	10	7.5	3.0	12.50	
		06A222		XP9000									-
	90°	06A231	S9MT1003-090	NC2057									AL(L)
		06A232		XP9000									-
	120°	06A241	S9MT1003-120	NC2057									AL(L)
		06A242		XP9000									-
12	60°	06A321	S9MT1203-060	NC2057	P35	2.4	0.69	9.0	12	9.0	3.0	15	
		06A322		XP9000									-
	90°	06A331	S9MT1203-090	NC2057									AL(L)
		06A332		XP9000									-
	120°	06A341	S9MT1203-120	NC2057									AL(L)
		06A342		XP9000									-

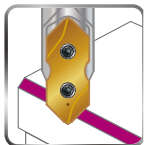
ACE Spot Drill Chamfering



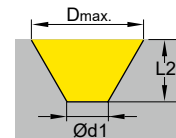
► Inserts >>

- NC2055:**
- ALDURA coating, reduces heat and tool wear.
 - For hardened steel up to 56 HRC.
 - Each insert has 2 cutting edges.

- XP9000:**
- High positive geometry and sharp edge produces excellent surface finish.
 - For non-ferrous material such as aluminum, titanium, brass, copper and long cutting chip metal.
 - Each insert has 2 cutting edges.



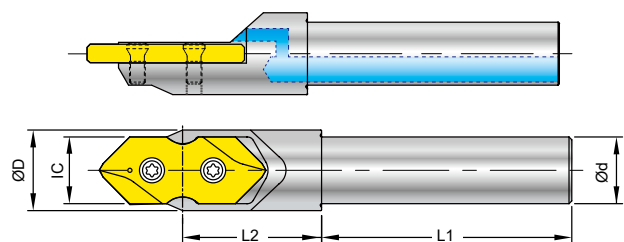
For Chamfering >>



IC	Angle ±0.5	Code	Parts No.	Coating	Grade	Ød1	L2	Dmax.	S	CT ±0.025
08	60°	06A123	S9MT0802-D060	NC2055	P35	0.5	5	6.27	2.4	10
		06A124		XP9000						
	90°	06A133	S9MT0802-D090	NC2055	P35					
		06A134		XP9000						

► Cylindrical Shank >>

- Made of hardened high alloy steel, 58 HRC.
- Internal coolant.



IC	Code	Order No.	Ød	L1	L2	ØD	Screw	Key
08	6A0101	00-99688-SI08-08	8	36	19	10.5	*NS-20045 / 0.6Nm	NK-T6
10	6A0201	00-99688-SI10-10	10	40	22.5	13	*NS-25060 / 0.9Nm	NK-T7
12	6A0301	00-99688-SI12-12	12	45	25	15.5	NS-30072 / 2.0Nm	NK-T9

*Torque screwdriver is recommended.

► Larger size insert is on request.