

FREE TEST MACHINING

TEST WORK SHEET

Call 01744 889726
for more information
about this service

IWATA GP DRILLS for Soft to Medium Steels (<40 HRC)

TEST: To drill 1 mm diameter holes by 4 mm deep

Material	S50C Carbon Steel
Size	
Set-up	'Clock-in' drills with 2 μ m dial indicator, concentricity to be better than 5 μ m.

Drill 1 mm diameter with

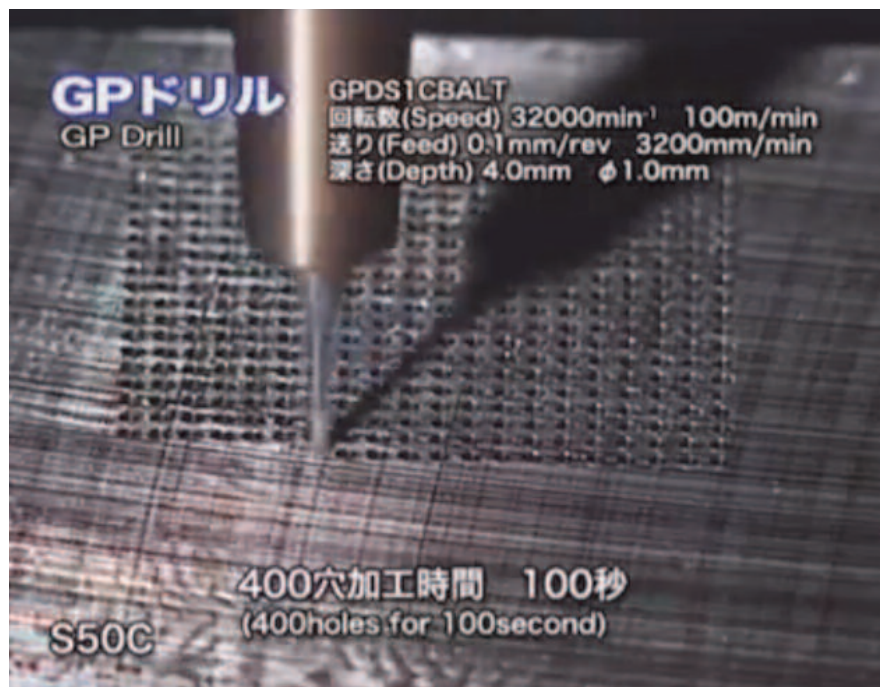
IWATA GP DRILL (GPDS1CBALT)

Speed	32,000 rpm
Feed	3,200 mm/min (0.1 mm/rev)

Coolant	Air blow, water based coolant or oil mist
Time	0.25 seconds per hole

RAINFORD PRECISION GUARANTEE

We are confident that our tools will offer you improvements in tool life and machining capability and would like to give you the opportunity to try our tools with no risk. **We will guarantee to refund any money paid if you are not completely satisfied with the tool's performance.**



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www.precisiondrills.co.uk

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