CNC TOOLING

Core Drills – THIN WALLED

CNC Machines

size (mm - in)	part no.	rpm	feed rate
12.70 mm - 1/2	DDS127P	5000	40 mm/min
19.05 mm - 3/4	DDS191P	3000	40 mm/min
25.40 mm - 1	DDS254P	2500	50 mm/min
28.60 mm - 1 1/8	DDS286P	2300	60 mm/min
32.00 mm - 1 1/4	DDS32P	2200	60 mm/min
35.00 mm - 1 3/8	DDS35P	2000	60 mm/min
38.00 mm - 1 1/2	DDS38P	1800	60 mm/min
50.80 mm - 2	DDS508P	1500	40 mm/min
76.20 mm - 3	DDS762P	1000	40 mm/min

Finger Bits

CNC Machines

size: dia. x L • segments		part number
20 x 40	**• 5**	DRS20
20 x 45	**• 5**	DRS20L
22 x 50	**• 5**	DRS201L
24 x 45	**• 5**	DRS24
20 x 40	**• 6**	DRS25
25 x 40	**• 6**	DRS23I
TIP x 20	**• 2**	DRS20P
25 x 63	**• 5**	DRS21G
25 x 42	**• 5**	DRS6GD
20 x 50	**• plated**	BD519D

FINGER BIT OPERATING PARAMETERS (DRS20 – DRS20L – DRS25)

1. RPM= 6500: At higher rpm the load on the spindle (amp) reduces and the bit cuts better.
2. Feed Rate: New bits = 250-300 mm/min on most materials. After 2 sinks, adjust feed rate to:
   Giallo Venziano= 500 mm/min (20 inches/min) • Ubatuba= 450 mm/min (18 inches/min)
   Absolute Black= 400 mm/min (16 inches/min) • Tropic Brown= 350 mm/min (14 inches/min)
3. Amp Reading: Bavelloni= 33-35 • Intermac (old)= 14-16 • Intermac (new)= 6-8 • Brembana= 50
   Breton= 50 • Park Industries= 8 • Northwood= 8

DIAMOND TOOL DRESSING PROCEDURE

1. Soak dressing stick or block in coolant or water.
2. Turn off coolant (water) supply to diamond tool.
3. Turn on diamond tool and allow to reach full-speed.
4. Turn off diamond tool.
5. Apply dressing stick to coasting diamond tool or in the case of core drills, lower bit into dressing block with enough pressure to slowly bring to a stop.
6. Repeat if necessary.

DRESSING STICKS

3/8"X2"X8" Aluminum Oxide

grit	part number
150	954-02T
320	949-02T