



## CD19 19 pce COBALT M35 STEEL DRILL SET

### ALWAYS USE CUTTING OIL TO MAXIMISE DRILL BIT LIFE

To ensure optimum performance always observe the appropriate (RPM) speed range applicable to the drill bit size and the recommended cutting speed for the work piece material.

$$\text{RPM} = \text{Cutting Speed (m/min)} \times \text{Bit Dia (mm)}$$

**A – Nimonic, High Tensile Steel 50-55Rc**

**B – Alloy > 80TT, Stainless (non magnetic), High Tensile Steel 40-50Rc, Monel, Titanium**

**C – 0.7% Carbon Steel, Alloy Steel 60-80TT, Stainless (magnetic), Nickel**

**D – 0.4-0.7% Carbon Steel, Alloy < 60TT**

Drill Bit Size (mm)	AñMin	A-Max	C-Min	C-Max	B-Min	B-Max	D-Min	D-Max
1.0	1000	1900	2800	4800	6700			
2.0	480	950	1400	2400	3350			
3.0	300	600	900	1200	2200			
4.0	240	480	700	1200	1650			
6.0	160	300	480	800	1100			
9.0	100	200	300	530	740			

$$\text{RPM} = \text{Cutting Speed (m/min)} \times \text{Bit Dia (mm)}$$

CD19 made to DIN338 with 4.5-5.0% Cobalt M35 Steel

**ALWAYS WEAR APPROVED EYE PROTECTION WHEN USING CUTTING TOOLS**