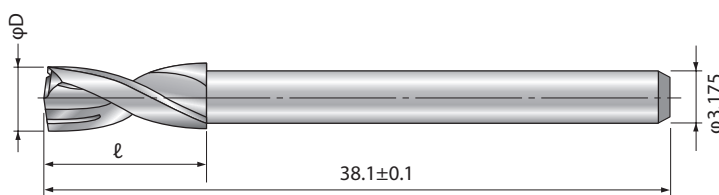
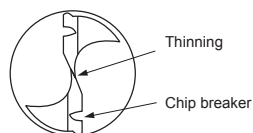


ID30C(Inverse drill) series



The UNION TOOL Inverse diameter drill is an innovative product that has both a chip-breaker to help prevent “bird-nesting” - that extends along the length of the flute - and a point design that incorporates web-thinning technology that greatly reduces the thrust load on the spindle. Additionally both these features remain present after repointing, helping to retain quality and performance throughout the drill's life.

ID30C SIZE : φ 3.20~ φ 6.50



Recommended models

φ D mm	ℓ mm	Part No.	φ D mm	ℓ mm	Part No.	φ D mm	ℓ mm	Part No.	φ D mm	ℓ mm	Part No.
3.20	12.0	112-8320	4.05	12.0	112-8405	4.90	12.0	112-8490	5.75	12.0	112-8575
3.25		112-8325	4.10		112-8410	4.95		112-8495	5.80		112-8580
3.30		112-8330	4.15		112-8415	5.00		112-8500	5.85		112-8585
3.35		112-8335	4.20		112-8420	5.05		112-8505	5.90		112-8590
3.40		112-8340	4.25		112-8425	5.10		112-8510	5.95		112-8595
3.45		112-8345	4.30		112-8430	5.15		112-8515	6.00		112-8600
3.50		112-8350	4.35		112-8435	5.20		112-8520	6.05		112-8605
3.55		112-8355	4.40		112-8440	5.25		112-8525	6.10		112-8610
3.60		112-8360	4.45		112-8445	5.30		112-8530	6.15		112-8615
3.65		112-8365	4.50		112-8450	5.35		112-8535	6.20		112-8620
3.70		112-8370	4.55		112-8455	5.40		112-8540	6.25		112-8625
3.75		112-8375	4.60		112-8460	5.45		112-8545	6.30		112-8630
3.80		112-8380	4.65		112-8465	5.50		112-8550	6.35		112-8635
3.85		112-8385	4.70		112-8470	5.55		112-8555	6.40		112-8640
3.90		112-8390	4.75		112-8475	5.60		112-8560	6.45		112-8645
3.95		112-8395	4.80		112-8480	5.65		112-8565	6.50		112-8650
4.00		112-8400	4.85		112-8485	5.70		112-8570			

* Model recommendation/specification may change as part of our policy to improve performance and quality.

Parameters

φ D	Spindle speed	1.6mm board thickness								
		FR-4 double-sided			FR-4 6~8 layers			FR-4 over 10 layers		
		Infeed rate	Chip load	Stack height	Infeed rate	Chip load	Stack height	Infeed rate	Chip load	Stack height
mm	k rpm	m/min	μ m/rev	-	m/min	μ m/rev	-	m/min	μ m/rev	-
3.2~3.95	25	0.8	30	3-4	0.8	30	3-4	0.8	30	1-2
4.0~4.95	20	0.6			0.6			0.6		
5.0~5.95	16		40		40	40				
6.0~6.50	15	0.5	35		0.5	35		0.5	35	

* ID drills that range from $\varphi 3.2$ to $\varphi 3.95$, do not have the chip breaker feature.

These are general parameters recommended for normal conditions. However they may vary depending on the material and machine/spindle rigidity.

Please refer to the "Technical database" contained on our web site for more detail technical support information. <http://www.usuniontool.com>