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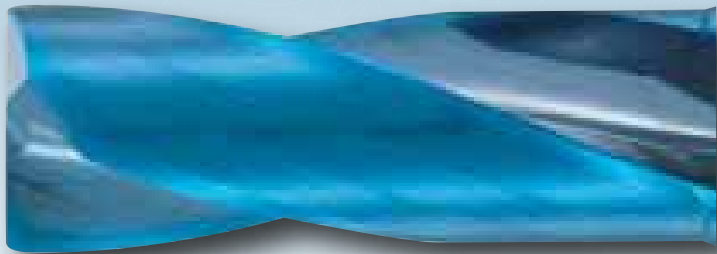
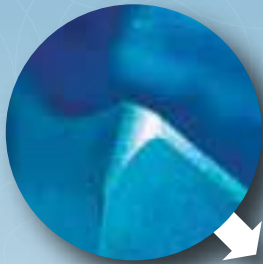
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AQDEXZ-R

AQUA Drills EX Flat with Radius

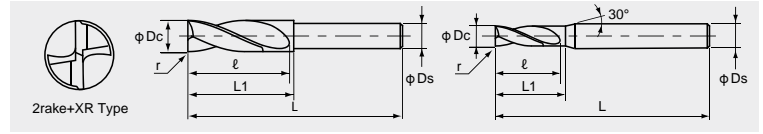
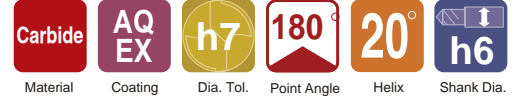
AQDEXZ-R: Designed for Processing Efficiency

List 9830



AQDEXZ-R

AQUA Drills EX Flat with Radius

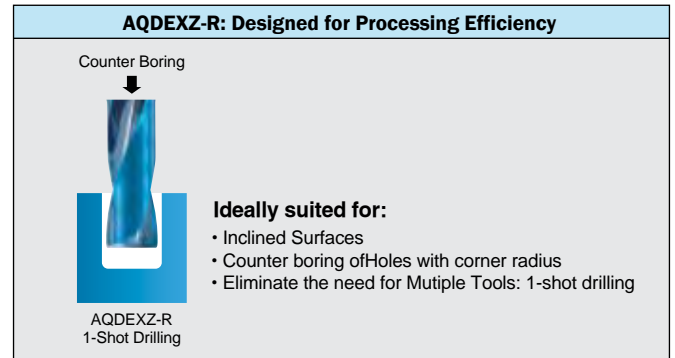
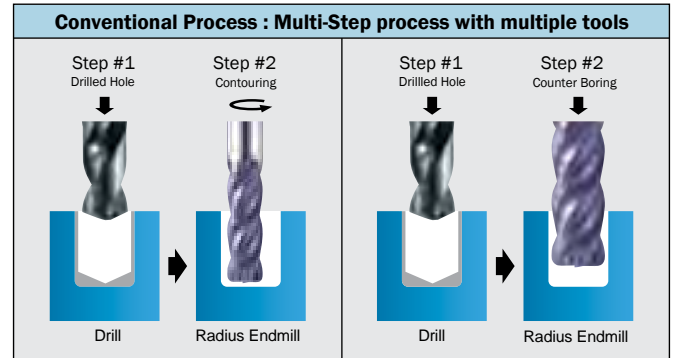


List 9830

EDP NO.	Size	Decimal	Radius	FL	OAL	L1	Shank Dia.	Stock
0732580	3.0	0.1181	0.3	14	50	14.4	6	●
0732597	3.3	0.1299	0.3	15	50	15.7	6	●
0732602	3.5	0.1378	0.3	16	50	16.3	6	●
0732619	4.0	0.1575	0.3	18	50	18.3	6	●
0732625	4.2	0.1654	0.3	19	60	20.4	6	●
0732631	4.5	0.1772	0.3	21	60	22.7	6	●
0732648	5.0	0.1969	0.3	23	60	23.1	6	●
0732654	5.3	0.2087	0.3	24	60	26.4	6	●
0732660	5.5	0.2165	0.3	25	60	27.6	6	●
0732677	6.0	0.2362	0.4	27	60	30	6	●
0732683	6.5	0.2559	0.4	30	70	33	6	●
0732690	6.8	0.2677	0.4	31	70	33	6	●
0732705	7.0	0.2756	0.4	32	70	33	6	●
0732711	7.5	0.2953	0.4	34	70	36	6	●
0732728	8.0	0.3150	0.4	36	70	39	8	●
0732734	8.5	0.3346	0.4	39	80	42	8	●
0732740	8.8	0.3465	0.4	40	80	42	8	●
0732757	9.0	0.3543	0.4	41	80	42	8	●
0732763	9.5	0.3740	0.4	43	80	45	8	●
0732770	10.0	0.3937	0.5	45	80	48	10	●
0732786	10.3	0.4055	0.5	46	90	49	10	●
0732792	10.5	0.4134	0.5	48	90	51	10	●
0732808	10.8	0.4252	0.5	49	90	51	10	●
0732814	11.0	0.4331	0.5	50	90	51	10	●
0732820	11.5	0.4528	0.5	52	90	54	10	●
0732837	12.0	0.4724	0.5	54	90	57	12	●

One Shot Drilling of Holes with Corner Radius

AQDEXZ-R For Multi-functional Machining



AQDEXZ-R Aqua Drill EX Flat Radius - Standard Drilling Conditions

List 9830 AQDEXZ-R

Work Material	Cast Irons/Carbon Steel		Alloy Steels/Pre-Hardened (20-30 HRC)		Mold Steels/Hardened Steels (30-40 HRC)		Hardened Steels (40-50 HRC)		Cast Irons		Stainless Steel (300-Series Stainless)		Cast Aluminum					
	Speed (SFM)		220-240 SFM		200-210 SFM		100-110 SFM		70-80SFM		200-210 SFM		515-525 SFM		260-400 SFM			
	Drilling Diameter		RPM		Feed (IPR)		RPM		Feed (IPR)		RPM		Feed (IPR)		RPM		Feed (IPR)	
Drill Dia. (mm/Inches)	Metric	Decimal	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)
	3	0.118	7,950	0.002	6,900	0.002	3,700	0.002	2,650	0.001	6,900	0.002	17,000	0.002	12,500	0.002	12,500	0.002
	4	0.157	5,950	0.003	5,150	0.003	2,800	0.002	2,000	0.002	5,150	0.002	12,500	0.003	9,550	0.003	9,550	0.003
	6	0.236	4,000	0.004	3,450	0.004	1,800	0.004	1,300	0.002	3,450	0.004	8,500	0.005	6,400	0.004	6,400	0.004
	8	0.315	3,000	0.006	2,600	0.005	1,400	0.005	1,000	0.003	2,600	0.005	6,350	0.006	4,750	0.005	4,750	0.005
	10	0.394	2,400	0.007	2,050	0.007	1,100	0.006	800	0.004	2,050	0.006	5,100	0.008	3,800	0.007	3,800	0.007
	12	0.472	2,000	0.008	1,700	0.008	950	0.007	650	0.005	1,700	0.007	4,250	0.009	3,200	0.008	3,200	0.008
	14	0.551	1,700	0.010	1,500	0.009	800	0.008	600	0.006	1,500	0.008	3,650	0.011	3,000	0.009	3,000	0.009
16	0.630	1,500	0.011	1,300	0.011	700	0.010	400	0.006	1,050	0.012	3,200	0.013	2,400	0.011	2,400	0.011	