

AG DRILL SERIES

HSCO PARABOLIC TiAlN COATED
DEEP HOLE DRILL SERIES



AG SUS Drills - Technical Information

Features

- 4-facet 135° self-centering point for stable and precise positioning
- Made from Nachi's next generation fine melted HSCO substrate for superior tool performance
- Composite multi-layer AG Coating (TiAlN)
- Precision Ground End mill style shank for accurate and precise drilling

Work Materials

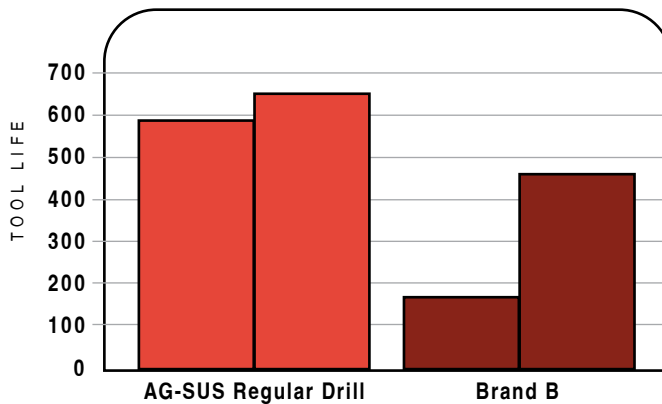
- Stainless Steel
- Cast Irons
- Hi-temp alloys
- Structural Steels
- Carbon Steels
- Alloy Steels

Performance



CUTTING CONDITION

Drill Dia.: 6mm
Material: S42020 (SUS420J2)
Hole Depth: 20mm through
Speed: 78 SFM (1.275 rpm)
Feed: 190mm/min (7.48 IPM)
Pecking: Non
Coolant: Emulsion



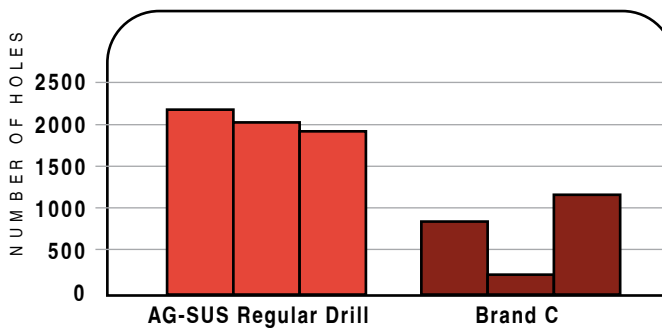
CHIP SHAPE
NACHI AG-SUS DRILL VS. COMPETITOR
FOR STAINLESS STEEL



AG-SUS DRILL

CUTTING CONDITION

Drill Dia.: 1mm (0.039")
Material: S304 (175 HB)
Hole Depth: 5mm blind
Speed: 49 SFM (4.775 rpm)
Feed: 100mm/min (3.94 IPM)
Pecking: 1mm
Coolant: Emulsion



COMPETITOR

AG Power Long Drills - Technical Information

AG Power Long Deep Hole Series HSCo Parabolic Style TiAlN Coated Drills

Features

New Style Parabolic Drills

- Flute geometry and coating enables non pecking deep hole drilling up to 20XD
- AG Coating (TiAlN) and HSS-Co material increases tool life
- Available in 10D / 15D / 20D lengths in Metric & Fractional sizes (USA Stock)

Work Materials

APPLICABLE MATERIAL

- Carbon Steel
- Alloy Steel
- Tool Steel
- Die Steel
- Cast Iron
- Stabilized Steel (under 35HRC)

UNSUITABLE MATERIAL

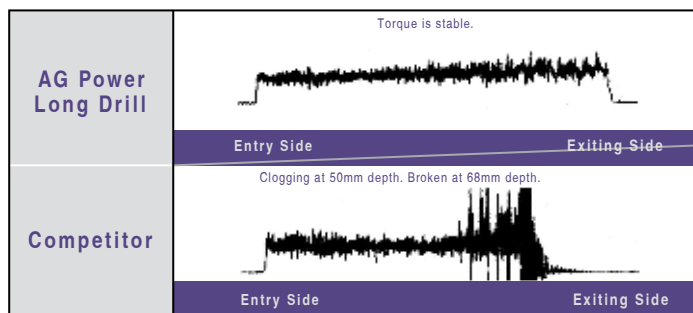
- Soft Steel
- Aluminum
- Copper Alloy
- Hardened Steel (over 40HRC)

Performance



AG POWER LONG DRILL VS. STANDARD DRILL

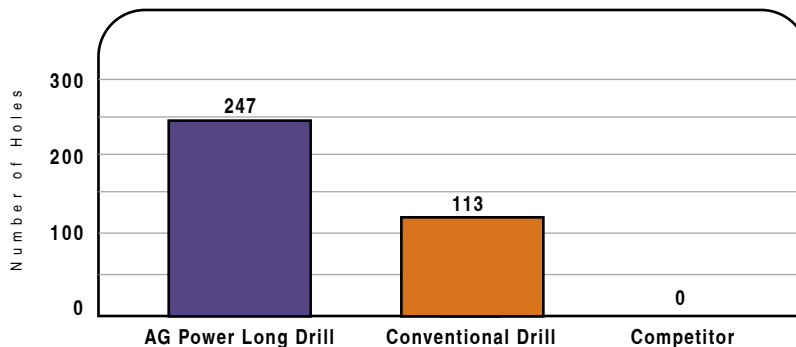
Stable torque



CUTTING CONDITION

Drill : 6mm (0.236in)
Material : 1050 (217HB) S50C
Hole Depth : 102mm (4.01in : 17D) through
Speed : 1590rpm (98 SFM)
Feed : 0.1mm/rev (6.26 IPM)
non-pecking drilling
Fluid : Emulsion

Long tool life



AG-SUS DRILLS-JOBBER LENGTH / METRIC SIZES

List No.6594P

High Performance (7xD)

FM HSCO AG COATED



Range 2.0 to 20.0

This drill meets stable drilling by AG coat, and is very suitable for drilling of Stainless Steel.

(Unit) : mm

Size	Decimal Equivalent	Flute Length	Overall Length	Shank Diameter
1.0	0.0394	12	50	3
1.1	0.0433	14	50	3
1.2	0.0472	16	50	3
1.3	0.0512	16	50	3
1.4	0.0551	18	50	3
1.5	0.0591	18	50	3
1.6	0.0630	20	56	3
1.7	0.0669	20	56	3
1.8	0.0709	22	56	3
1.9	0.0748	22	56	3
2.0	0.0787	24	56	3
2.1	0.0827	24	56	3
2.2	0.0866	25	56	3
2.3	0.0906	25	56	3
2.4	0.0945	30	61	3
2.5	0.0984	30	61	3
2.6	0.1024	30	61	3
2.7	0.1063	33	64	3
2.8	0.1102	33	64	3
2.9	0.1142	33	64	3
3.0	0.1181	33	64	3
3.1	0.1220	36	71	4
3.2	0.1260	36	71	4
3.3	0.1299	36	71	4
3.4	0.1339	39	71	4
3.5	0.1378	39	71	4
3.6	0.1417	39	71	4
3.7	0.1457	39	71	4
3.8	0.1496	43	75	4
3.9	0.1535	43	75	4
4.0	0.1575	43	75	4
4.1	0.1614	43	85	6
4.2	0.1654	43	85	6
4.3	0.1693	47	89	6
4.4	0.1732	47	89	6
4.5	0.1772	47	89	6
4.6	0.1811	47	89	6
4.7	0.1850	47	89	6
4.8	0.1890	52	94	6
4.9	0.1929	52	94	6
5.0	0.1969	52	94	6
5.1	0.2008	52	94	6
5.2	0.2047	52	94	6
5.3	0.2087	52	94	6
5.4	0.2126	57	99	6

Size	Decimal Equivalent	Flute Length	Overall Length	Shank Diameter
5.5	0.2165	57	99	6
5.6	0.2205	57	99	6
5.7	0.2244	57	99	6
5.8	0.2283	57	99	6
5.9	0.2323	57	99	6
6.0	0.2362	57	99	6
6.1	0.2402	63	107	8
6.2	0.2441	63	107	8
6.3	0.2480	63	107	8
6.4	0.2520	63	107	8
6.5	0.2559	63	107	8
6.6	0.2598	63	107	8
6.7	0.2638	63	107	8
6.8	0.2677	69	113	8
6.9	0.2717	69	113	8
7.0	0.2756	69	113	8
7.1	0.2795	69	113	8
7.2	0.2835	69	113	8
7.3	0.2874	69	113	8
7.4	0.2913	69	113	8
7.5	0.2953	69	113	8
7.6	0.2992	75	119	8
7.7	0.3031	75	119	8
7.8	0.3071	75	119	8
7.9	0.3110	75	119	8
8.0	0.3150	75	119	8
8.1	0.3189	75	125	10
8.2	0.3228	75	125	10
8.3	0.3268	75	125	10
8.4	0.3307	75	125	10
8.5	0.3346	75	125	10
8.6	0.3386	81	131	10
8.7	0.3425	81	131	10
8.8	0.3465	81	131	10
8.9	0.3504	81	131	10
9.0	0.3543	81	131	10
9.1	0.3583	81	131	10
9.2	0.3622	81	131	10
9.3	0.3661	81	131	10
9.4	0.3701	81	131	10
9.5	0.3740	81	131	10
9.6	0.3780	87	137	10
9.7	0.3819	87	137	10
9.8	0.3858	87	137	10
9.9	0.3898	87	137	10

Size	Decimal Equivalent	Flute Length	Overall Length	Shank Diameter
10.0	0.3937	87	137	10
10.1	0.3976	87	144	12
10.2	0.4016	87	144	12
10.3	0.4055	87	144	12
10.4	0.4094	87	144	12
10.5	0.4134	87	144	12
10.6	0.4173	87	144	12
10.7	0.4213	94	151	12
10.8	0.4252	94	151	12
10.9	0.4291	94	151	12
11.0	0.4331	94	151	12
11.1	0.4370	94	151	12
11.2	0.4409	94	151	12
11.3	0.4449	94	151	12
11.4	0.4488	94	151	12
11.5	0.4528	94	151	12
11.6	0.4567	94	151	12
11.7	0.4606	94	151	12
11.8	0.4646	94	151	12
11.9	0.4685	101	158	12
12.0	0.4724	101	158	12
12.1	0.4764	101	158	12
12.2	0.4803	101	158	12
12.3	0.4843	101	158	12
12.4	0.4882	101	158	12
12.5	0.4921	101	158	12
12.6	0.4961	101	158	12
12.7	0.5000	101	158	12
12.8	0.5039	101	158	12
12.9	0.5079	101	158	12
13.0	0.5118	101	158	12
13.5	0.5315	108	168	16
14.0	0.5512	108	168	16
14.5	0.5709	114	173	16
15.0	0.5906	114	180	20
15.5	0.6102	120	185	20
16.0	0.6299	120	185	20
16.5	0.6496	125	189	20
17.0	0.6693	125	189	20
17.5	0.6890	130	194	20
18.0	0.7087	130	194	20
18.5	0.7283	135	198	20
19.0	0.7480	135	206	25
19.5	0.7677	140	210	25
20.0	0.7874	140	210	25

1 per tube

AG-SUS DRILLS-JOBBER LENGTH / FRACTIONAL SIZES

List No.6595P High Performance (7xD)

FM HSCO AG COATED



Range 3/32 to 3/4

This drill meets stable drilling by AG coat, and is very suitable for drilling of Stainless Steel.

DIAMETER	DECIMAL EQUIVALENT	FLUTE LENGTH	OVERALL LENGTH	SHANK DIAMETER
3/32	0.0938	1-1/8	2-3/8	1/8
7/64	0.1094	1-1/4	2-1/2	1/8
1/8	0.1250	1-3/8	2-5/8	1/8
9/64	0.1406	1-1/2	2-7/8	3/16
5/32	0.1563	1-3/4	3-1/8	3/16
11/64	0.1719	1-7/8	3-1/4	3/16
3/16	0.1875	2	3-3/8	3/16
13/64	0.2031	2-1/16	3-7/8	1/4
7/32	0.2188	2-1/16	3-7/8	1/4
15/64	0.2344	2-3/8	4-1/4	1/4
1/4	0.2500	2-3/8	4-1/4	1/4
17/64	0.2656	2-3/4	4-5/8	3/8
9/32	0.2813	2-3/4	4-5/8	3/8
19/64	0.2969	2-7/8	4-3/4	3/8
5/16	0.3125	2-7/8	4-3/4	3/8
21/64	0.3281	2-7/8	4-3/4	3/8
11/32	0.3438	3-1/4	5-1/8	3/8
23/64	0.3594	3-1/4	5-1/8	3/8
3/8	0.3750	3-1/4	5-1/8	3/8
25/64	0.3906	3-3/8	5-1/2	1/2
13/32	0.4063	3-3/8	5-1/2	1/2
27/64	0.4219	3-3/4	5-7/8	1/2
7/16	0.4375	3-3/4	5-7/8	1/2
29/64	0.4531	3-3/4	5-7/8	1/2
15/32	0.4688	4	6-1/4	1/2
31/64	0.4844	4	6-1/4	1/2
1/2	0.5000	4	6-1/4	1/2
17/32	0.5313	4-1/4	6-3/4	5/8
9/16	0.5625	4-1/2	7	5/8
37/64	0.5781	4-1/2	7	5/8
19/32	0.5938	4-3/4	7-1/4	3/4
5/8	0.6250	4-3/4	7-1/4	3/4
21/32	0.6563	5	7-1/2	3/4
11/16	0.6875	5-1/8	7-5/8	3/4
23/32	0.7188	5-3/8	7-3/4	7/8
3/4	0.7500	5-1/2	7-7/8	7/8

1 per tube

AG-POWER LONG DRILLS / METRIC SIZES / FRACTIONAL SIZES

List No.6540P Metric Sizes

HSS-Co AG COATED

List No.6541P Fractional



Series 1 Range 1.0 to 13.0

Series 2 Range 1.0 to 10.0

Series 3 Range 3.0 to 10.0



This drill meets non-step drilling of deep holes up to 20 times of a diameter, and is used for workpiece materials from raw materials to Mold Die Steels.
Note : Pre-hole should be drilled.

Series 1

(Unit) : mm

Size		Decimal Equivalent	Flute Length	Overall Length
Fractional L6541P	Metric L6540P			
	1.0	0.0394	33	56
	1.1	0.0433	37	60
	1.2	0.0472	41	65
	1.3	0.0512	41	65
	1.4	0.0551	45	70
	1.5	0.0591	45	70
	1.6	0.0630	50	76
	1.7	0.0669	50	76
	1.8	0.0709	53	80
	1.9	0.0748	53	80
	2.0	0.0787	56	85
	2.1	0.0827	56	85
	2.2	0.0866	59	90
	2.3	0.0906	59	90
	2.4	0.0945	62	95
	2.5	0.0984	62	95
	2.6	0.1024	62	95
	2.7	0.1063	66	100
	2.8	0.1102	66	100
	2.9	0.1142	66	100
	3.0	0.1181	66	100
	3.1	0.1220	69	106
1/8	3.175	0.1250	69	106
	3.2	0.1260	69	106
	3.3	0.1299	69	106
	3.4	0.1339	73	112
	3.5	0.1378	73	112
9/64	3.572	0.1406	73	112
	3.6	0.1417	73	112
	3.7	0.1457	73	112
	3.8	0.1496	78	119
	3.9	0.1535	78	119
5/32	3.969	0.1563	78	119
	4.0	0.1575	78	119
	4.1	0.1614	78	119
	4.2	0.1654	78	119
	4.3	0.1693	82	126
11/64	4.366	0.1719	82	126
	4.4	0.1732	82	126
	4.5	0.1772	82	126
	4.6	0.1811	82	126

Size		Decimal Equivalent	Flute Length	Overall Length
Fractional L6541P	Metric L6540P			
	4.7	0.1850	82	126
3/16	4.762	0.1875	87	132
	4.8	0.1890	87	132
	4.9	0.1929	87	132
	5.0	0.1969	87	132
	5.1	0.2008	87	132
13/64	5.159	0.2031	87	132
	5.2	0.2047	87	132
	5.3	0.2087	87	132
	5.4	0.2126	91	139
	5.5	0.2165	91	139
7/32	5.556	0.2187	91	139
	5.6	0.2205	91	139
	5.7	0.2244	91	139
	5.8	0.2283	91	139
	5.9	0.2323	91	139
	6.0	0.2362	91	139
1/4	6.35	0.2500	97	148
	6.5	0.2559	97	148
17/64	6.747	0.2656	102	156
	6.8	0.2677	102	156
	7.0	0.2756	102	156
9/32	7.144	0.2813	102	156
	7.5	0.2953	102	156
19/64	7.541	0.2969	109	165
5/16	7.933	0.3123	109	165
	8.0	0.3150	109	165
21/64	8.334	0.3281	109	165
	8.5	0.3346	109	165
11/32	8.731	0.3437	115	175
	9.0	0.3543	115	175
23/64	9.128	0.3594	115	175
	9.5	0.3740	115	175
3/8	9.525	0.3750	121	184
	10.0	0.3937	121	184
	10.5	0.4134	121	184
	11.0	0.4331	128	195
	11.5	0.4528	128	195
	12.0	0.4724	134	205
	12.5	0.4921	134	205
	13.0	0.5118	134	205

1 per tube

* Some Metric Sizes are Japan Stock item: Please allow 2-3 weeks for delivery

AG-POWER LONG DRILLS / METRIC SIZES / FRACTIONAL SIZES



Series 2

(Unit) : mm

Size		Decimal Equivalent	Flute Length	Overall Length
Fractional L6541P	Metric L6540P			
	1.0	0.0394	60	100
	1.1	0.0433	60	100
	1.2	0.0472	65	105
	1.3	0.0512	65	105
	1.4	0.0551	70	110
	1.5	0.0591	70	110
	1.6	0.0630	75	115
	1.7	0.0669	75	115
	1.8	0.0709	80	120
	1.9	0.0748	80	120
	2.0	0.0787	85	125
	2.1	0.0827	85	125
	2.2	0.0866	90	135
	2.3	0.0906	90	135
	2.4	0.0945	95	140
	2.5	0.0984	95	140
	2.6	0.1024	95	140
	2.7	0.1063	100	150
	2.8	0.1102	100	150
	2.9	0.1142	100	150
	3.0	0.1181	100	150
	3.1	0.1220	105	155
1/8	3.175	0.1250	105	155
	3.2	0.1260	105	155
	3.3	0.1299	105	155
	3.4	0.1339	115	165
	3.5	0.1378	115	165
9/64	3.572	0.1406	115	165
	3.6	0.1417	115	165
	3.7	0.1457	115	165
	3.8	0.1496	120	175
	3.9	0.1535	120	175
5/32	3.969	0.1563	120	175
	4.0	0.1575	120	175
	4.1	0.1614	120	175
	4.2	0.1654	120	175
	4.3	0.1693	125	185
11/64	4.366	0.1719	125	185

Size		Decimal Equivalent	Flute Length	Overall Length
Fractional L6541P	Metric L6540P			
	4.4	0.1732	125	185
	4.5	0.1772	125	185
	4.6	0.1811	125	185
	4.7	0.1850	125	185
3/16	4.762	0.1875	135	195
	4.8	0.1890	135	195
	4.9	0.1929	135	195
	5.0	0.1969	135	195
	5.1	0.2008	135	195
13/64	5.159	0.2031	135	195
	5.2	0.2047	135	195
	5.3	0.2087	135	195
	5.4	0.2126	140	205
	5.5	0.2165	140	205
7/32	5.556	0.2187	140	205
	5.6	0.2205	140	205
	5.7	0.2244	140	205
	5.8	0.2283	140	205
	5.9	0.2323	140	205
	6.0	0.2362	140	205
1/4	6.35	0.2500	150	215
	6.5	0.2559	150	215
17/64	6.747	0.2656	155	225
	6.8	0.2677	155	225
	7.0	0.2756	155	225
9/32	7.144	0.2813	155	225
	7.5	0.2953	155	225
19/64	7.541	0.2969	165	240
5/16	7.933	0.3123	165	240
	8.0	0.3150	165	240
21/64	8.334	0.3281	165	240
	8.5	0.3346	165	240
11/32	8.731	0.3437	175	250
	9.0	0.3543	175	250
23/64	9.128	0.3594	175	250
	9.5	0.3740	175	250
3/8	9.525	0.3750	185	265
	10.0	0.3937	185	265

1 per tube



Series 3

(Unit) : mm

Size		Decimal Equivalent	Flute Length	Overall Length
Fractional L6541P	Metric L6540P			
	3.0	0.1181	130	190
1/8	3.175	0.1250	135	200
	3.5	0.1378	145	210
9/64	3.572	0.1406	145	210
5/32	3.969	0.1563	150	220
	4.0	0.1575	150	220
11/64	4.366	0.1719	160	235
	4.5	0.1772	160	235
3/16	4.762	0.1875	170	245
	5.0	0.1969	170	245
	5.5	0.2165	180	260
7/32	5.556	0.2187	180	260

Size		Decimal Equivalent	Flute Length	Overall Length
Fractional L6541P	Metric L6540P			
	6.0	0.2362	180	260
1/4	6.35	0.2500	190	275
	6.5	0.2559	190	275
	7.0	0.2756	200	290
	7.5	0.2953	200	290
5/16	7.933	0.3123	210	305
	8.0	0.3150	210	305
	8.5	0.3346	210	305
	9.0	0.3543	220	320
	9.5	0.3740	220	320
	10.0	0.3937	235	340

1 per tube

* Some Metric Sizes are Japan Stock item: Please allow 2-3 weeks for delivery

AG DRILLS - STANDARD DRILLING CONDITION

AG-SUS Regular Drills List No. 6594P, 6595P

Workpiece Material			Austenitic Stainless Steels 304, 316		Austenitic Stainless Steels 304N		Martensitic Stainless Steels 420, 440		Ferritic Stainless Steels 405, 430		Low Carbon Steels	
Speed (SFM)			40 - 50 SFM		30 - 40 SFM		50 - 60 SFM		50 - 65 SFM		100 - 115 SFM	
Drill Diameter			40 - 50 SFM		30 - 40 SFM		50 - 60 SFM		50 - 65 SFM		100 - 115 SFM	
Fractional	Metric mm	Decimal	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)
—	1	0.0394	4,300	0.001	3,300	0.001	5,300	0.001	5,300	0.001	10,600	0.001
—	2	0.0787	2,100	0.003	1,700	0.002	2,650	0.002	2,650	0.001	5,300	0.003
3/32	2.381	0.0938	1,800	0.003	1,400	0.003	2,240	0.003	2,240	0.001	4,450	0.004
—	3	0.1181	1,400	0.004	1,100	0.004	1,770	0.004	1,750	0.001	3,500	0.005
1/8	3.175	0.1250	1,300	0.005	1,000	0.004	1,680	0.004	1,650	0.002	3,300	0.006
5/32	3.969	0.1563	1,100	0.006	850	0.005	1,340	0.004	1,340	0.002	2,650	0.007
3/16	4.763	0.1875	900	0.007	700	0.005	1,120	0.004	1,120	0.002	2,250	0.008
—	5	0.1969	850	0.007	670	0.006	1,050	0.004	1,060	0.002	2,100	0.008
1/4	6.35	0.2500	650	0.008	530	0.007	840	0.005	840	0.003	1,680	0.010
5/16	7.938	0.3125	550	0.009	420	0.008	670	0.007	650	0.003	1,350	0.012
—	8	0.3150	550	0.009	400	0.008	650	0.007	650	0.003	1,300	0.012
3/8	9.525	0.3750	450	0.010	350	0.009	560	0.008	560	0.004	1,100	0.012
—	10	0.3937	430	0.010	340	0.009	530	0.008	500	0.004	1,000	0.013
—	12	0.4724	360	0.011	280	0.010	440	0.009	450	0.005	850	0.014
1/2	12.7	0.5000	340	0.011	260	0.010	420	0.009	420	0.005	800	0.015
—	16	0.6299	270	0.014	210	0.012	330	0.011	330	0.007	650	0.017
3/4	19.05	0.7500	220	0.016	200	0.015	280	0.016	280	0.016	550	0.015
—	20	0.7874	210	0.016	170	0.014	260	0.012	250	0.008	500	0.020

- 1) The above values apply when coolant is used in vertical machine & horizontal machine.
- 2) Adjust drilling condition when unusual vibration or different sound occurs.
- 3) Recommended feeds and speeds are starting points only. Actual performance will be determined by specific material, the condition of equipment being used and coolant.

Formulas: $RPM = \frac{SFM \times 3.82}{\text{Drill dia.}}$, Feed Rate (in/min) = RPM x IPR

AG-Power Long Drills List No. 6540P, 6541P

Workpiece Material			Structural Steels, Carbon Steels		Alloy Steels		Hardened Steels, (-40 HRc), Tool Steels		Stainless Steels 300-400 Series		Cast Irons	
Speed (SFM)			40 - 80 SFM		25 - 50 SFM		16 - 35 SFM		30 - 40 SFM		42 - 82 SFM	
Drill Diameter			40 - 80 SFM		25 - 50 SFM		16 - 35 SFM		30 - 40 SFM		42 - 82 SFM	
Fractional	Metric mm	Decimal	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)
—	1	0.0394	5,800	0.0007	3,300	0.0007	2,400	0.0005	2,900	0.0006	6,000	0.0008
—	2	0.0787	2,900	0.002	1,600	0.002	1,200	0.002	1,400	0.0015	3,000	0.002
—	3	0.1181	1,950	0.003	1,100	0.003	800	0.002	950	0.002	2,000	0.003
1/8	3.175	0.1250	1,800	0.003	1,000	0.003	750	0.002	900	0.002	1,800	0.003
3/16	4.763	0.1875	1,200	0.005	700	0.005	500	0.004	600	0.003	1,200	0.005
—	5	0.1969	1,100	0.005	650	0.005	480	0.004	550	0.004	1,200	0.006
—	6	0.2362	970	0.006	550	0.006	400	0.005	450	0.004	1,000	0.007
1/4	6.350	0.2500	900	0.006	500	0.006	350	0.005	450	0.004	950	0.008
9/32	7.144	0.2813	800	0.007	450	0.007	350	0.005	400	0.005	850	0.009
5/16	7.938	0.3125	700	0.008	400	0.008	300	0.006	350	0.006	800	0.010
—	8	0.3150	700	0.008	400	0.008	300	0.006	350	0.006	750	0.009
23/64	9	0.3594	650	0.009	350	0.009	250	0.007	300	0.007	700	0.010
—	10	0.3937	600	0.010	350	0.009	250	0.008	300	0.007	650	0.013
—	13	0.5118	550	0.009	300	0.009	200	0.008	250	0.008	600	0.011

- 1) Pilot Hole is required. It is recommended to use same diameter or up to 0.1mm larger than diameter of the long drill.
The depth of cut of the pilot hole is 1 to 2 times diameter of the drill diameter.
- 2) Above drilling table is applied to Series 1 & 2. In case of series 3 & 4, reduce the RPM and feed to 80% of table values.
- 3) Use pecking when drilling in Stainless Steel & Hardened Steels.
- 4) Recommended feeds and speeds are starting points only. Actual performance will be determined by specific material, the condition of equipment being used and coolant.

Formulas: $RPM = \frac{SFM \times 3.82}{\text{Drill dia.}}$, Feed Rate (in/min) = RPM x IPR

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