Deep Hole Drilling Guidelines

T-A Pro | 10xD, 12xD, 15xD Holders

1. Pilot Hole
100% RPM
100% IPR (mm/rev)

Establish the pilot hole using the same diameter short drill to a depth of 2xD minimum. Utilize a pilot drill with the same or larger included point angle.

Coolant ON

2. Feed-in
50 RPM max
12 IPM (300 mm/min)

Feed the longer drill within 1/16“ (1.5mm) short of the established pilot hole bottom at a maximum of 50 RPM and 12 IPM (300 mm/min) feed rate.

Coolant OFF

3. Deep Hole Transition Drilling
50 % RPM
75% IPR (mm/rev)

Drill additional 1xD past the bottom of the pilot hole at 50% reduction of recommended speed and 25% reduction of recommended feed. Minimum of one second dwell is required to meet full speed before feeding.

Coolant ON

4. Deep Hole Drilling - Blind
100% RPM
100% IPR (mm/rev)

Drill to full depth at recommended speed and feed for longer drill according to Allied speed and feed charts. No peck cycle recommended.

Coolant ON

5. Deep Hole Drilling - at Breakout
50% RPM
75% IPR (mm/rev)

For through holes only: Reduce speed by 50% and feed by 25% prior to breakout. Do not break out more than 1/8“ (3mm) past the full diameter of the drill.

Coolant ON

6. Drill Retract
50 RPM max

Reduce speed to a maximum of 50 RPM before retracting from the hole.

Coolant OFF

**WARNING** Tool failure can cause serious injury. To prevent:

- When using holders without support bushing, use a short T-A Pro holder to establish an initial hole that is a minimum of 2 diameters deep.
- Do not rotate tool holders more than 50 RPM unless it is engaged with the workpiece or fixture.

Visit www.alliedmachine.com/DeepHoleGuidelines for the most up-to-date information and procedures.

Factory technical assistance is available for your specific applications through our Application Engineering department. ext: 7611 | email: appeng@alliedmachine.com