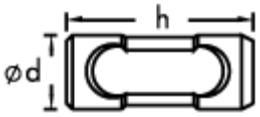
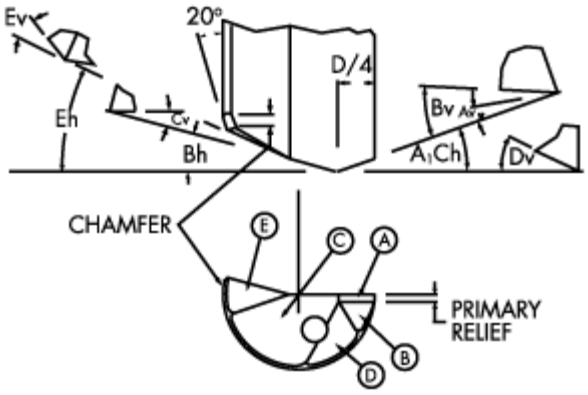
Drivers

Driver Styles		Ref	Tip Diameter	Ød	h	Overall Length
	VT1	CA	Ø5.0 - 11.73	Ø16	40	Flute Length + 50.0
	VT2	CB	Ø11.74 - 21.18	Ø25	50	Flute Length + 65.0
	VT3	CC	Ø21.19 - 40.50	Ø35	60	Flute Length + 80.0

Cutting Data

Material	Surface Speed Metres	Feed / Rev Ø6.0	Feed / Rev Ø8.0	Feed / Rev Ø10.0	Feed / Rev Ø15.0	Feed / Rev Ø20.0	Feed / Rev Ø30.0
High Temp Alloys	18	0.010	0.012	0.015	0.020	0.025	0.030
Stainless Steel Alloys	30	0.015	0.020	0.025	0.035	0.040	0.040
High Carbon Steel	38	0.015	0.020	0.030	0.040	0.050	0.050
Medium Carbon Steel	45	0.020	0.030	0.040	0.050	0.060	0.060
Low Carbon Steel	55	0.020	0.030	0.040	0.060	0.075	0.075
Cast Iron	35	0.040	0.060	0.100	0.130	0.150	0.180
Free Cuttin Alluminium	75	0.040	0.060	0.100	0.130	0.150	0.180



Clamping Method				
Face	**Horiz**	**Vert**	**Horiz**	**Vert**
A	+20°	+15°	+22°	+13°
B	+19.5°	+20°	+21.5°	+18°
C	-15°	+15°	-13°	+16°
D	0°	+25°	0°	+25°
E	-18°	-14°	-20°	-12°
Good surface finish required on faces A, C and Chamfer.				

DRILL DIA.	PRIMARY RELIEF	CHAMFER AT 20°
Ø5-Ø12	0.4 - 0.6	0.4 - 0.6
Ø12-Ø25	0.6 - 0.8	0.6 - 0.8
Ø25-Ø40	0.8 - 1.2	0.8 - 1.2