

# APX™ Deep Hole Drilling Guidelines

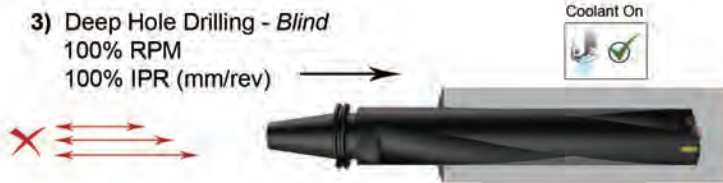
For use with APX™ Drills 8xD & greater (Depths to Diameter)



- Feed the longer drill within 1/16" (1,5 mm) short of the workpiece at a **maximum of 50 RPM** and 12 IPM (300 mm/min) feed rate



- Drill 3/4" deep at 75% recommended speed and 50% recommended feed to establish hole



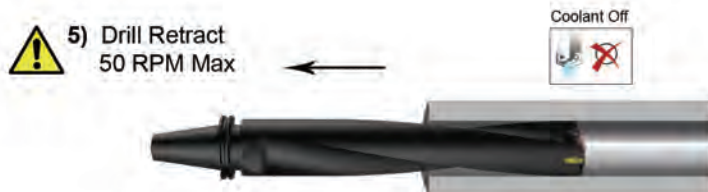
- Drill to full depth at recommended speed and feed for longer drills, according to Allied speed and feed charts

**No peck cycle recommended**



**\*For Through Holes Only\***

- Reduce speed by 50% prior to break out  
- Do not break out more than 1/8" (3 mm) past the full diameter of drill



Reduce speed to **maximum of 50 RPM** before retracting from hole

## ⚠ WARNING

Tool failure can cause serious injury. To prevent:

NEVER rotate these tool holders more than 50RPM without proper engagement with a workpiece or fixture. Failure to do so could result in tool failure and/or personal injury.

Visit [www.alliedmachine.com/deepholeguidelines.aspx](http://www.alliedmachine.com/deepholeguidelines.aspx) for the most up-to-date information and procedures. Factory technical assistance is also available for your specific applications.