



# ALLIED MACHINE & ENGINEERING CORP.

## Deep Hole Drilling Guidelines

Greater than 9 Depths to Diameter, including Extended, Long, XL, 3XL, and Specials

Deep Hole  
Standard Drills

Deep Hole  
Special Drills



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Made in the USA

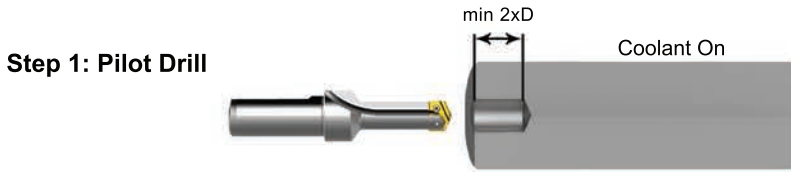
For the most up-to-date  
information and procedures, visit  
[www.alliedmachine.com](http://www.alliedmachine.com)

Literature Order Number: DHDFL

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# Deep Hole Drilling Guidelines

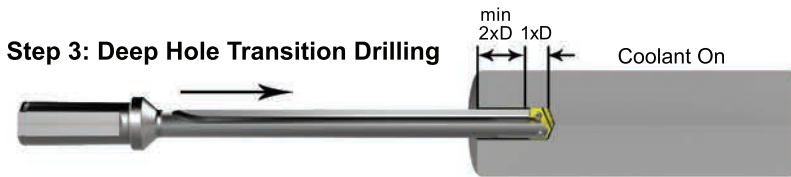
For use with all AMEC Drills greater than 9 Depths to Diameter, including Extended, Long, XL, 3XL, and Special Length.



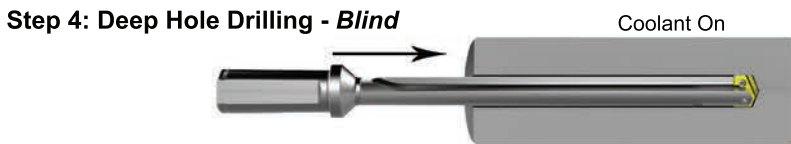
- Establish the pilot hole using the same diameter short drill to a depth of a 2xD minimum
- Utilize a pilot drill with the same or larger included point angle



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

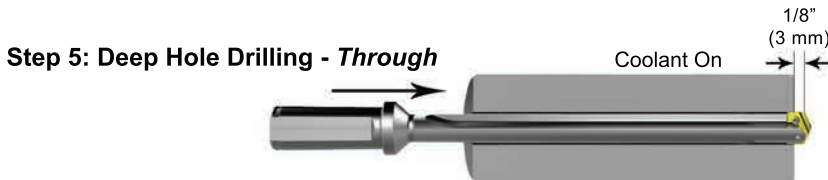


- Drill additional 1xD passed bottom of pilot hole at 50% reduction of recommended speed and 25% reduction of recommend feed
- Minimum of 1 second dwell is required to meet full speed before feeding



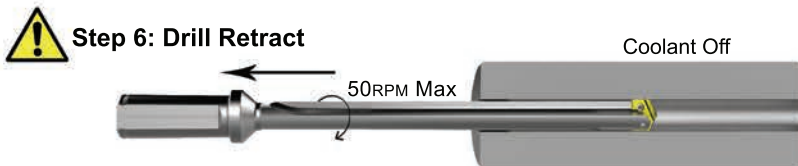
- Drill to full depth at recommended speed and feed for longer drills according to Allied speed and feed charts

***No peck cycle recommended***



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

- Reduce speed by 50% and feed by 25% 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 50RPM** before retracting from hole



**WARNING:** 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.