

Modular Drills

Application Data • Victory™ TOP DRILL M1™

Cautions**Coolant**

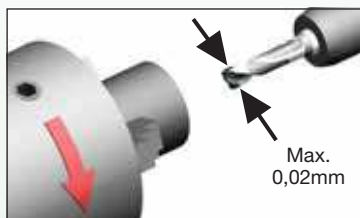
1) Internal coolant is recommended.



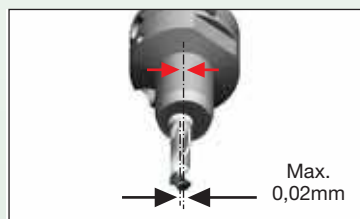
2) In case of external coolant, cutting depth must be 3 x D or less.

3) Dry cutting is not recommended.
Limited applicability in cast iron materials,
MQL strongly recommended.**Usage Precautions****Core deviation**

1) For Turning Machines

Set deviation amount under 0,02mm
between workpiece and drill.

2) For Machining Centres

Do not use any arbour with a damaged attachment surface.
Centre of arbour deviation must be within 0,02mm.

Application Recommendation	Workpiece Shape
Flat Face Recommended	
Stacked Plates Recommended	
Inclined Surface >3° Not Recommended	
Half Cylindrical Not Recommended	
Hole Expansion Not Recommended	
Concave Surface Not Recommended	
Pipe Material Not Recommended	
Cored Hole Not Recommended	