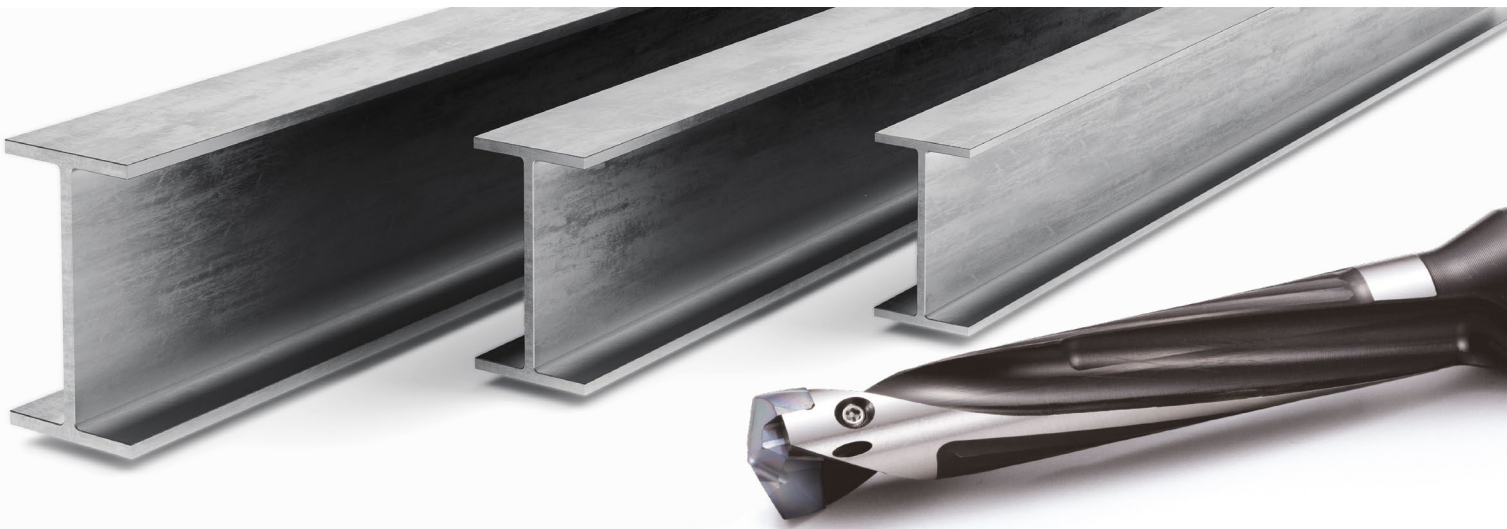


MagicDrill **DRA**



High efficient and reliable drilling in structural steel beam

Optimal web thickness limits deflection

Easy insert replacement

Fine chip breaking

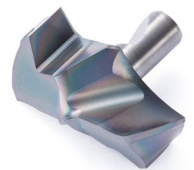
Insert sizes: DC = 7.94 mm - 33.00 mm

Toolholder L/D: 1.5D - 12D

1st choice
for general
machining
GM



For minimal
burr creation
FTP



Full lineup

Visit us on

LinkedIn

High efficient steel beam drilling

MagicDrill DRA

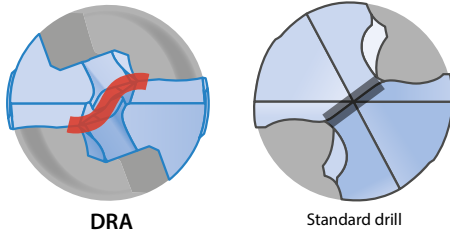
Excellent hole accuracy with a low cutting force design
Fine chip breaking and smooth deep hole cutting



1 Low cutting force design improves hole accuracy

Special chisel edge with S-curve reduces thrust force and controls vibration

Cutting edge image



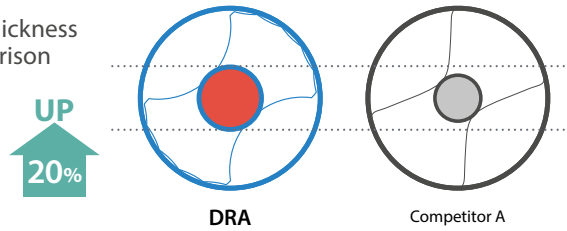
DRA

Standard drill

2 Optimal web thickness limits deflection

Improved hole accuracy by controlling drill deflection with a 20% thicker web compared with Competitor A

Web thickness comparison



DRA

Competitor A

DRA Toolholder $\varnothing 7.94$ mm - 25.50 mm

1.5D

3D

5D

8D

12D



(Straight shank)



(with flange)



Case Study

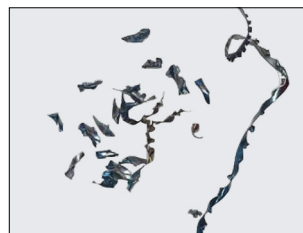
Structure part S390

$V_c = 50.2$ m/min ($n = 888$ min⁻¹),
 $f = 0.247$ mm/rev ($V_f = 220$ mm/min),

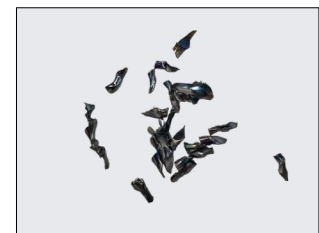
Drilling depth 40 mm, through-hole
Coolant = MQL

SF25-DRA180M-5
DA1800M-GM PR1535

Competitor K: $\varnothing 18-5D$



Competitor K



DRA

DRA produced finer chips and maintained stable machining and excellent surface finish with less cutting noise.

(User evaluation)