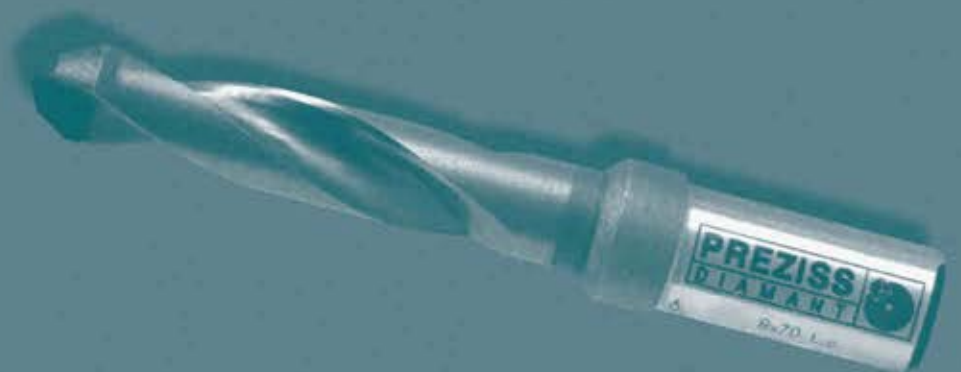




## DRILL BITS

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**PCD DRILL BITS**

*Drilling is probably the most widely performed operation on a worldwide scale. It is also very important in the wood industry and specially in furniture manufacturing, which produces a large amount of drilled parts.*

*In these operations it is very important to have a tool that is very durable, producing a precise and smooth finish on both delicate and abrasive materials.*

*PREZISS DIAMANT offers drill bits with polycrystalline diamond tips. These we set out in the following pages.*

**RECOMMENDATIONS FOR BEST PRACTICE**

*The application of the required feed speed (Vf) depends directly on the RPM n (min) that will be averaged according to the following table.*

*Other factors will be important depending on the drill bit diameter and the working material.*

Recommended feed rate	
n (min <sup>1</sup> )	Vf (m/min <sup>1</sup> )
3.000	1 - 2
4.500	1,5 - 2,5
6.000	2 - 3,5
9.000	2,5 - 5,5

For through hole drilling on delicate coated boards, badly glued boards or low quality boards.

It is advisable to reduce the feed speed rate in the exit area to avoid breakout. (Fig 1).

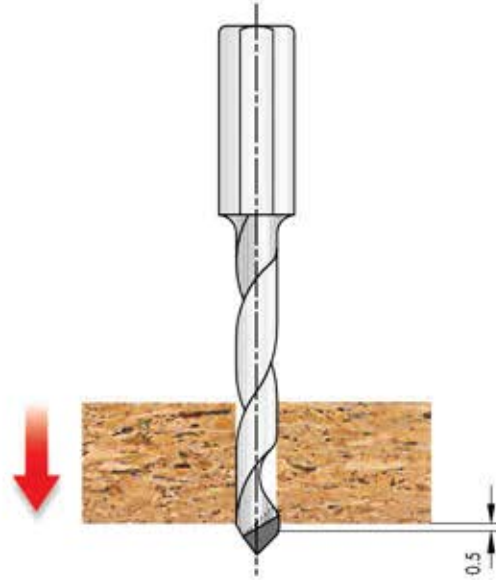


Fig 1

Special sizes and operations, for example: countersink drill bits and double diameter drill bits, (Fig 2), drill bits with reduced tip for drilling pilot holes (Fig 3), etc... Prices on request.

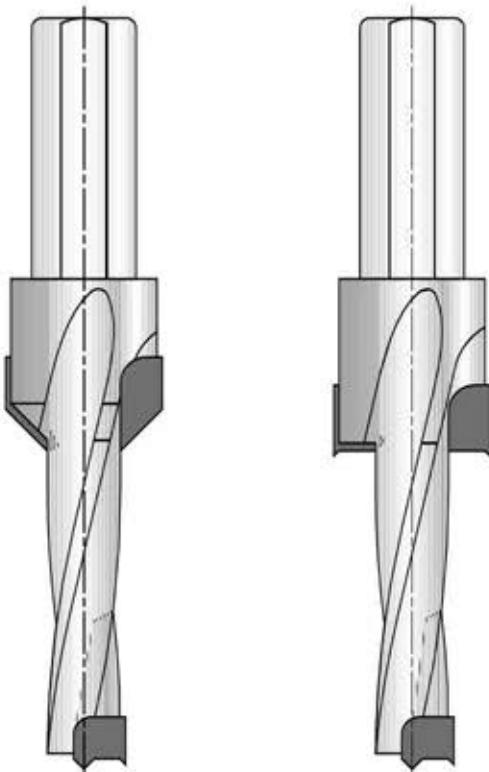


Fig 2

ØD	A
mm	mm
15	0,3
25	0,6
35	0,9

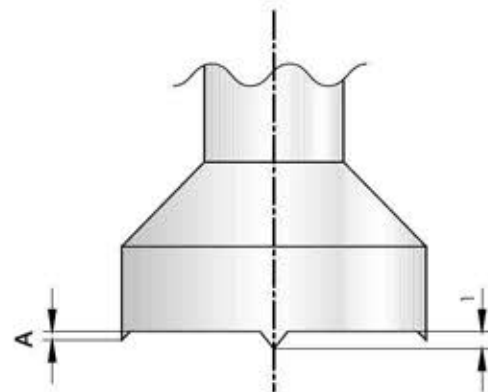


Fig 3

**PCD LIP AND SPUR DRILL BIT / "BLIND HOLE"**

L.T.: 57 mm

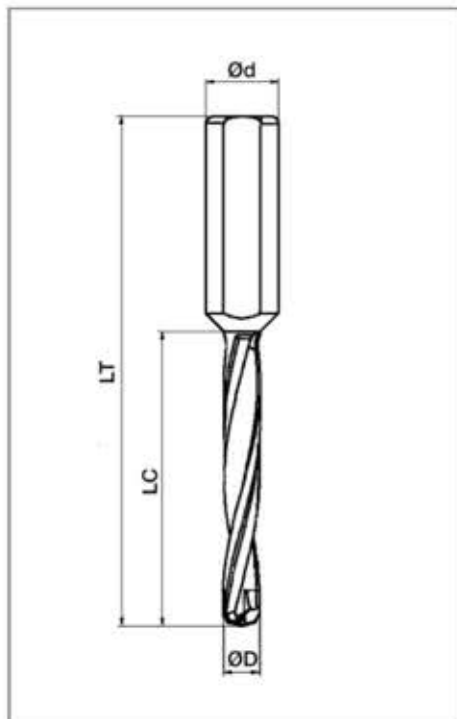


ØD mm	L.T. mm	L.C. mm	Z =	Shank mm	PRODUCT CODE
5	57	30	2	10x27 R	6005001
5	57	30	2	10x27 L	6005002
6	57	30	2	10x27 R	6005003
6	57	30	2	10x27 L	6005004
8	57	30	2	10x27 R	6005005
8	57	30	2	10x27 L	6005006
10	57	30	2	10x27 R	6005007
10	57	30	2	10x27 L	6005008
12	57	30	2	10x27 R	6005009
12	57	30	2	10x27 L	6005010

*Solid carbide body for CNC.*

ØD mm	L.T. mm	L.C. mm	Z =	Shank mm	PRODUCT CODE
5	57	30	2	10x27 R	6005020
5	57	30	2	10x27 L	6005021
6	57	30	2	10x27 R	6005022
6	57	30	2	10x27 L	6005023
8	57	30	2	10x27 R	6005024
8	57	30	2	10x27 L	6005025
10	57	30	2	10x27 R	6005026
10	57	30	2	10x27 L	6005027
12	57	30	2	10x27 R	6005028
12	57	30	2	10x27 L	6005029

*Steel body with adjusting screw.*



**APPLICATION**

- Lip and spur drill bit for drilling veneered covered melamine and paper faced boards and abrasive laminates in multiboards in point to point machines with a perfect finish.
- Longer lasting than TCT tips.

**DESCRIPTION**

- Spiral bit with 2 PCD cutting wings and two channels for swarf extraction.
- Hard TCT body that gives the drill bit great rigidity and stability, achieving a better finish and greater feed speed.
- Cut geometry: C - Blind hole.
- Round shank with flat, and height adjusting screw.



Rpm max.:  
3.000 - 9.000



**PCD LIP AND SPUR DRILL BIT / "BLIND HOLE"**

L.T.: 70 mm

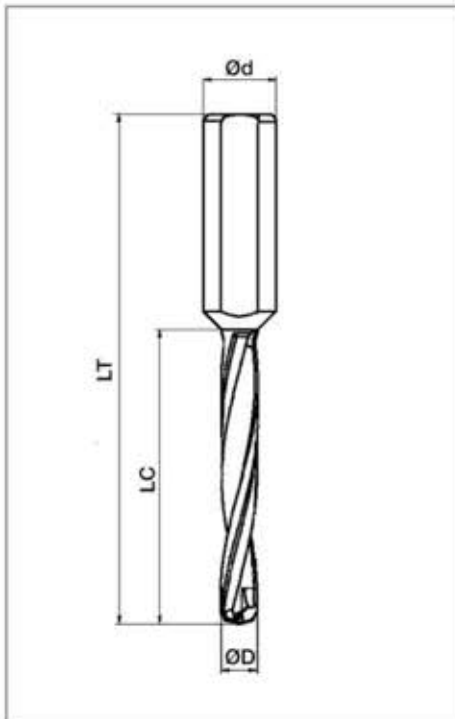


ØD mm	L.T. mm	L.C. mm	Z =	Shank mm		PRODUCT CODE
5	70	43	2	10x27	R	6006001
5	70	43	2	10x27	L	6006002
6	70	43	2	10x27	R	6006003
6	70	43	2	10x27	L	6006004
8	70	43	2	10x27	R	6006005
8	70	43	2	10x27	L	6006006
10	70	43	2	10x27	R	6006007
10	70	43	2	10x27	L	6006008
12	70	43	2	10x27	R	6006009
12	70	43	2	10x27	L	6006010

*Solid carbide body for CNC.*

ØD mm	L.T. mm	L.C. mm	Z =	Shank mm		PRODUCT CODE
5	70	43	2	10x27	R	6006020
5	70	43	2	10x27	L	6006021
6	70	43	2	10x27	R	6006022
6	70	43	2	10x27	L	6006023
8	70	43	2	10x27	R	6006024
8	70	43	2	10x27	L	6006025
10	70	43	2	10x27	R	6006026
10	70	43	2	10x27	L	6006027
12	70	43	2	10x27	R	6006028
12	70	43	2	10x27	L	6006029

*Steel body with adjusting screw.*



**APPLICATION**

- Lip and spur drill bit for drilling veneered covered melamine and paper faced boards and abrasive laminates in multiboards in point to point machines with a perfect finish.
- Longer lasting than TCT tips.

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- Hard TCT body that gives the drill bit great rigidity and stability, achieving a better finish and greater feed speed.
- Cut geometry: C - Blind hole.
- Round shank with flat, and height adjusting screw.



Rpm max.:  
3.000 - 9.000



**PCD DRILL BIT FOR DRILLING / "THROUGH HOLE"**

L.T.: 57 mm

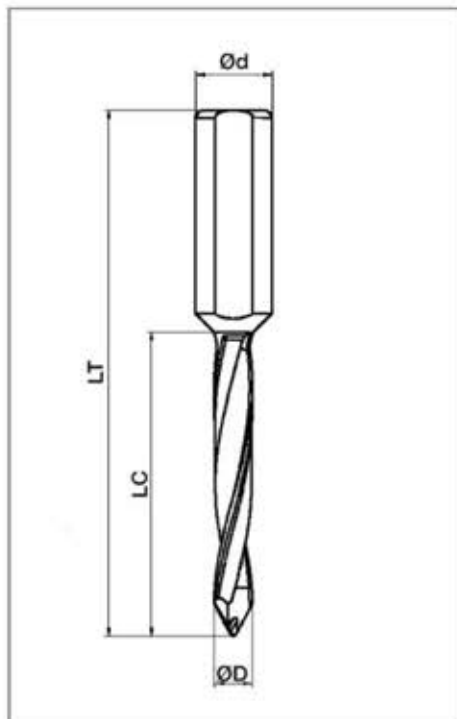


ØD mm	L.T. mm	L.C. mm	Z =	Shank mm	PRODUCT CODE
5	57	30	2	10x27 R	6007001
5	57	30	2	10x27 L	6007002
6	57	30	2	10x27 R	6007003
6	57	30	2	10x27 L	6007004
8	57	30	2	10x27 R	6007005
8	57	30	2	10x27 L	6007006
10	57	30	2	10x27 R	6007007
10	57	30	2	10x27 L	6007008
12	57	30	2	10x27 R	6007009
12	57	30	2	10x27 L	6007010

*Solid carbide body for CNC.*

ØD mm	L.T. mm	L.C. mm	Z =	Shank mm	PRODUCT CODE
5	57	30	2	10x27 R	6007020
5	57	30	2	10x27 L	6007021
6	57	30	2	10x27 R	6007022
6	57	30	2	10x27 L	6007023
8	57	30	2	10x27 R	6007024
8	57	30	2	10x27 L	6007025
10	57	30	2	10x27 R	6007026
10	57	30	2	10x27 L	6007027
12	57	30	2	10x27 R	6007028
12	57	30	2	10x27 L	6007029

*Steel body with adjusting screw.*



**APPLICATION**

- For through drillings on boards covered with veneer, melamine, paper, hard and abrasive laminates in multiboring point to point machines with perfect finish.
- Longer lasting than drill bits with TCT tip.

**DESCRIPTION**

- PCD twist drill with two cutting wings and two channels for chip evacuation.
- Drill tip with 60° with elevated angle of incidence achieving a perfect finish going out of the material.
- The cutting geometry favors the reduction of cutting pressure saving energy and consumption and increasing the tool performance.
- Carbide body in CNC.
- Steel body, with flat and height adjustment screw in the shank.



Rpm max.:  
3.000 - 9.000



**PCD DRILL BIT FOR DRILLING / "THROUGH HOLE"**

L.T.: 70 mm

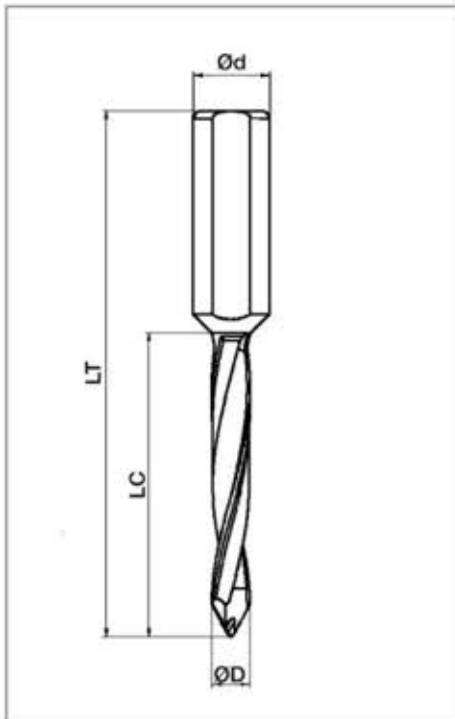


ØD mm	L.T. mm	L.C. mm	Z =	Shank mm		PRODUCT CODE
5	70	43	2	10x27	R	6008001
5	70	43	2	10x27	L	6008002
6	70	43	2	10x27	R	6008003
6	70	43	2	10x27	L	6008004
8	70	43	2	10x27	R	6008005
8	70	43	2	10x27	L	6008006
10	70	43	2	10x27	R	6008007
10	70	43	2	10x27	L	6008008
12	70	43	2	10x27	R	6008009
12	70	43	2	10x27	L	6008010

*Solid carbide body for CNC.*

ØD mm	L.T. mm	L.C. mm	Z =	Shank mm		PRODUCT CODE
5	70	43	2	10x27	R	6008020
5	70	43	2	10x27	L	6008021
6	70	43	2	10x27	R	6008022
6	70	43	2	10x27	L	6008023
8	70	43	2	10x27	R	6008024
8	70	43	2	10x27	L	6008025
10	70	43	2	10x27	R	6008026
10	70	43	2	10x27	L	6008027
12	70	43	2	10x27	R	6008028
12	70	43	2	10x27	L	6008029

*Steel body with adjusting screw.*



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Rpm max.:  
3.000 - 9.000

