

NEW - 2009

Twister XD[®]

Coolant Extra Long Drills

2XDCEM

Developed to drill water lines in molds, the new 2XDCEM drill works exceptionally well in all deep hole drilling applications. With the 2XD drilling geometry, this drill provides productivity increases and reduced cycle time by eliminating the need for a peck drilling cycle.

Increases Productivity

Reduces Cycle Time

12X - 25X Diameter Deep

High Performance Deep Hole Drills

 **M.A. FORD[®]**
High Performance Cutting Tools

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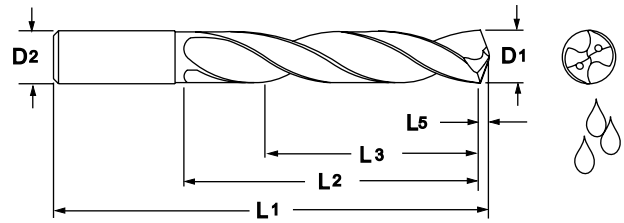
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Coolant Extra Long

Drills

- 30° Helix
- 142° Point
- ALtima[®] Coating



3mm dia. drill

82.5mm deep in
P20 Alloy Tool Steel

720mm/min.

6307 RPM

One pass/hole



Tool No.	EDP	Diameter		OAL	Flute Length			Point Length	Flute Length/ Diam. L2/D1
		D1 (h7)	D2 (h6)		L1	L2	L3 Ref.		
2XDCEM0300A	04300	3.00	3.0	125	75	60	0.46	25	
2XDCEM0320A	04304	3.20	4.0	163	100	80	0.50	31	
2XDCEM0330A	04306	3.30	4.0	163	100	80	0.51	30	
2XDCEM0340A	04308	3.40	4.0	163	100	80	0.53	29	
2XDCEM0360A	04310	3.60	4.0	163	100	80	0.56	28	
2XDCEM0380A	04312	3.80	4.0	163	100	80	0.59	26	
2XDCEM0390A	04314	3.90	4.0	163	100	80	0.60	26	
2XDCEM0400A	04316	4.00	4.0	163	100	80	0.62	25	
2XDCEM0420A	04318	4.20	5.0	163	105	84	0.65	25	
2XDCEM0430A	04320	4.30	5.0	163	105	84	0.67	24	
2XDCEM0440A	04322	4.40	5.0	163	105	84	0.68	24	
2XDCEM0460A	04324	4.60	5.0	163	105	84	0.71	23	
2XDCEM0480A	04328	4.80	5.0	163	105	84	0.74	22	
2XDCEM0490A	04330	4.90	5.0	163	105	84	0.76	21	
2XDCEM0500A	04332	5.00	5.0	163	105	84	0.77	21	
2XDCEM0520A	04334	5.20	6.0	163	110	88	0.81	21	
2XDCEM0540A	04336	5.40	6.0	163	110	88	0.84	20	
2XDCEM0560A	04338	5.60	6.0	163	110	88	0.87	20	
2XDCEM0580A	04340	5.80	6.0	163	110	88	0.90	19	
2XDCEM0600A	04342	6.00	6.0	163	110	88	0.93	18	
2XDCEM0620A	04344	6.20	8.0	163	110	88	0.96	18	
2XDCEM0630A	04346	6.30	8.0	163	110	88	0.98	17	
2XDCEM0680A	04350	6.80	8.0	163	110	88	1.05	16	
2XDCEM0700A	04352	7.00	8.0	163	110	88	1.08	16	
2XDCEM0760A	04354	7.60	8.0	163	120	96	1.18	16	
2XDCEM0780A	04356	7.80	8.0	163	120	96	1.21	15	
2XDCEM0800A	04360	8.00	8.0	163	120	96	1.24	15	
2XDCEM0820A	04362	8.20	10.0	180	135	108	1.27	16	
2XDCEM0850A	04364	8.50	10.0	180	135	108	1.32	16	
2XDCEM0870A	04366	8.70	10.0	180	135	108	1.35	16	
2XDCEM0900A	04368	9.00	10.0	180	135	108	1.39	15	
2XDCEM0940A	04370	9.40	10.0	195	150	120	1.46	16	
2XDCEM0980A	04374	9.80	10.0	195	150	120	1.52	15	
2XDCEM1000A	04376	10.00	10.0	195	150	120	1.55	15	
2XDCEM1030A	04378	10.30	12.0	210	160	128	1.60	16	
2XDCEM1050A	04380	10.50	12.0	210	160	128	1.63	15	
2XDCEM1080A	04382	10.80	12.0	210	160	128	1.67	15	
2XDCEM1100A	04384	11.00	12.0	210	160	128	1.70	15	
2XDCEM1150A	04388	11.50	12.0	210	160	128	1.78	14	
2XDCEM1180A	04390	11.80	12.0	210	160	128	1.83	14	
2XDCEM1200A	04392	12.00	12.0	210	160	128	1.86	13	



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