



## PREMIUM BELGIUM SHANK DIAMOND DRILL



- Core drills are used to create precise holes in both monolithic and laminated glass
- Superior performance and long-lasting life
- Provide extra clean cutting
- Don't require dressing
- Drills are manufactured with water-pressure release slots in the diamond crown
- Suitable for semi-auto, auto, and horizontal and vertical CNC drilling machines
- Adaptors able to convert Belgium shank to Habit shank

These Diamond Drills don't blow out the back face of the glass when used in CNC machines for single sided drilling

Property	Value
Brand	NFK
Product code	45-000P
Length	95mm
Body material	Stainless steel
Diameter	From 6mm to 70 mm
Suitable for glass thickness	From 3mm to 25mm
FEED mm/min	60-90
Fitting	1/2 Gas
Glass Type	Monolithic, Laminated



## USAGE INSTRUCTIONS FOR MACHINE OPERATORS

When selecting new diamond drills please identify if they are the same design as the photo above. If they are, please take note of the following.

These drills have been engineered differently from all other diamond drills. They cut very freely and fast, and do not need dressing between holes as they have been designed to self-dress.

Due to the thin wall and free-cutting design, the holes should be clean and not break out on the back side of the glass, if used correctly.

These drills must be pre-conditioned by drilling 20 holes at the above recommended speeds, and with a feed rate of 0.5 mm/second. Once this step has been completed, using the above speed chart, these drills can safely operate at a feed rate of 1.0 to 1.5 mm/second.

Feed rates in this product sheet are achievable but to the detriment of drill life.

Please NOTE: DO NOT DRESS THESE DRILLS, BEFORE OR DURING THE DRILL LIFE.

## Performance characteristics

Diameter	Minimum R.P.M.	Maximum R.P.M.
6mm	6000	7000
7mm	5000	6000
8mm	4000	5000
9mm	4000	5000
10mm	3500	4500
11mm	3000	4000
12mm	3000	3500
13mm	2700	3600
14mm	2700	3300
15mm	2400	3000
16mm	2100	2700
17mm	2200	2800
18mm	2000	2600
19mm	2000	2400
20mm	1800	2200

Diameter	Minimum R.P.M.	Maximum R.P.M.
21mm	1800	2200
22mm	1600	2000
23mm	1600	2000
24-26mm	1400	1800
27mm	1400	1600
28-29mm	1200	1600
30-31mm	1200	1500
32-34mm	1100	1400
35-36mm	1000	1300
37-38mm	1000	1200
39mm	900	1200
40mm	950	1150
41mm	900	1150
42mm	900	1100
43mm	850	1100

Diameter	Minimum R.P.M.	Maximum R.P.M.
44mm	850	1050
45-47mm	800	1000
48-50mm	750	950
52mm	700	900
55mm	650	850
60mm	600	750
65mm	550	700
70mm	500	650
75mm	500	600
80mm	450	550