



TUNGSTEN CARBIDE TIPPED HOLE CUTTER

MANUAL

Classification

● HC-35L

Drilling depth: 35mm thick
 Effective length (L): 50mm deep
 Specifications: From 12mm to 50mm

● HC-50L

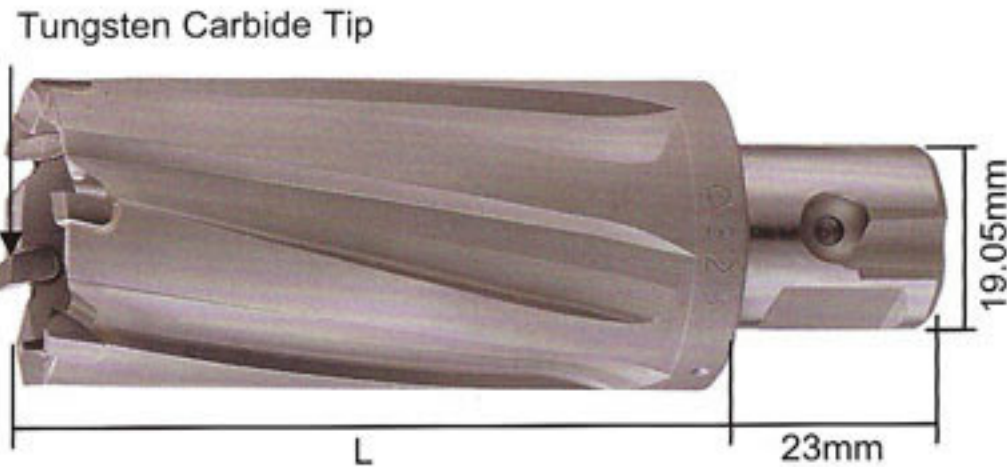
Drilling depth: 50mm thick
 Effective length (L): 70mm deep
 Specifications: From 14mm to 70mm

● HC-85L

Drilling depth: 85mm thick
 Effective length (L): 100mm deep
 Specifications: From 18mm to 100mm

● HC-110L

Drilling depth: 110mm thick
 Effective length (L): 120mm deep
 Specifications: From 18mm to 100mm



Main applications

Tungsten Carbide Tipped Hole Cutters are designed particularly for drilling on various steel materials used on the I-bean steel, channel iron, steel plates, tool steel, cutting of overlapping holes, shipping building, etc.

They are suitable for all kinds of magnetic drilling machines.

Features

- Three times faster than regular drills
- The pilot pin ejects the slug when cutting is finished.
- The special teeth arrangement makes cutting smooth.
- Can be run at higher speeds and higher feed rates.

Using notice

For your safety please wear goggles.

Before using, install pilot pin into TCT Hole Cutter

Before cutting, make sure all parts to be locked surely.

For extending Hole Cutter longer life please use a coolant spray.

During perforating operation, the remaining core is very hot. Don't touch it right away.

For quality improvement please refer to RPM list.

Suggestible R.P.M.

Diameter ϕ mm	Steel	Stainless Steel	Iron
$\phi 14$ mm — $\phi 16$ mm	1000—600	800—550	1200—800
$\phi 17$ mm — $\phi 20$ mm	800—480	640—400	960—640
$\phi 21$ mm — $\phi 24$ mm	670—400	530—330	800—531
$\phi 25$ mm — $\phi 30$ mm	540—320	420—270	640—430
$\phi 31$ mm — $\phi 35$ mm	460—280	370—230	550—370
$\phi 36$ mm — $\phi 40$ mm	400—240	320—200	480—320
$\phi 41$ mm — $\phi 45$ mm	360—220	290—180	430—290
$\phi 46$ mm — $\phi 50$ mm	320—190	260—160	390—260
$\phi 51$ mm — $\phi 60$ mm	290—160	230—130	350—210
$\phi 61$ mm — $\phi 70$ mm	250—140	200—110	300—180
$\phi 71$ mm — $\phi 80$ mm	210—120	170—100	260—160
$\phi 81$ mm — $\phi 90$ mm	190—105	150—90	230—140
$\phi 91$ mm — $\phi 100$ mm	170—95	135—80	200—120

Flat surface

WARNING

Hex. socket screw must come directly on the flat surface without dimple(see arrow on the sketch) for "side lock" type cutter holders.