

SOLID CARBIDE REPLACEABLE HEAD DRILLS

HYDRA DRILL

Solid Carbide Replaceable Head Drilling



FEATURES:

- The Hydra Drill is manufactured for EASY head changes for 3X and 5X depth of cut
- The HSS high wear resistant body will accommodate multiple head sizes, maintaining its structural integrity- even after numerous head changes!
- Special 140° split point TiAlN coated solid carbide head ensures optimum chip flow and longer tool life.
- Coolant hole provides optimized coolant direction for chip evacuation

HYDRA DRILL BODIES

Carbide Head Series #	OAL	Drill Depth	Shank Dia	Body Length	Shank Length	Hydra Drill Body Part Number	Price Each
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3X BODY DIA

55	4.527	2.008	0.75	2.527	2.000	HD-55-MDB-PTD	\$174.64
59	4.921	2.126	0.75	2.921	2.000	HD-59-MDB-PTD	\$179.93
63	5.118	2.283	0.75	3.118	2.000	HD-63-MDB-PTD	\$185.22
67	5.315	2.401	0.75	3.315	2.000	HD-67-MDB-PTD	\$190.51
71	5.512	2.559	0.75	3.512	2.000	HD-71-MDB-PTD	\$195.80
75	6.102	2.677	1.00	3.852	2.250	HD-75-MDB-PTD	\$201.10
79	6.102	2.834	1.00	3.852	2.250	HD-79-MDB-PTD	\$206.39
83	6.102	2.953	1.00	3.852	2.250	HD-83-MDB-PTD	\$211.68
87	6.299	3.110	1.00	4.049	2.250	HD-87-MDB-PTD	\$216.97

5X BODY DIA

55	5.708	3.150	0.75	3.708	2.000	HD-55-LDB-PTD	\$211.68
59	6.102	3.346	0.75	4.102	2.000	HD-59-LDB-PTD	\$216.97
63	6.496	3.582	0.75	4.496	2.000	HD-63-LDB-PTD	\$222.26
67	6.694	3.789	0.75	4.693	2.000	HD-67-LDB-PTD	\$227.56
71	6.890	4.015	0.75	4.890	2.000	HD-71-LDB-PTD	\$232.85
75	7.480	4.212	1.00	5.230	2.250	HD-75-LDB-PTD	\$238.14
79	7.677	4.449	1.00	5.427	2.250	HD-79-LDB-PTD	\$243.43
83	7.677	4.645	1.00	5.427	2.250	HD-83-LDB-PTD	\$248.72
87	7.874	4.882	1.00	5.624	2.250	HD-87-LDB-PTD	\$254.02

Drilling Effectively With Hydra Drills:

Holders: Toolholders and collets must provide good concentricity between the drill and the machine spindle. Using a positive back stop to prevent the tool from backing up into the holder is recommended. Static runout in the tool assembly must be accurately checked and maintained.

Workpiece: A secure and rigid workpiece to minimize deflection is needed, particularly on through-hole applications.

Speeds: Hydra Drills are run at substantially higher speeds than high speed steel drills.

Feeds: The feed rates for Hydra Drills are normally comparable to that of high speed steel drills. It is important not to underfeed the drill, which will cause it to dwell and dull. This is particularly true in work hardening materials.

Note: Reducing feed rate to .004-.006IPR is recommended when drilling through cross holes, interruptions at exit and/or entrance or exit on an angular surface.

Drilling With Coolants:

For maximum chip ejection and tool performance, coolant must be used with the Hydra Drill. Emulsion coolant mix of 6-8% is recommended for most applications. Use a higher 10% mix for high strength steel, stainless steels and tougher drilling applications.

When using coolant fed drills, a coolant pressure of 150PSI or higher is recommended. Internal coolant holes deliver lubrication on cutting edges for increased productivity and longer tool life.

SOLID CARBIDE INDEXABLE DRILL TIPS

For Drill Series #	Cutting Dia	Replaceable Head Part Number	Price Each
55	35/64	HD-55-35/64-PTD	\$59.85
	14.00	HD-55-M1400-PTD	\$59.85
	9/16	HD-55-9/16-PTD	\$59.85
	14.50	HD-55-M1450-PTD	\$59.85
59	37/64	HD-59-37/64-PTD	\$61.85
	15.00	HD-59-M1500-PTD	\$61.85
	19/32	HD-59-19/32-PTD	\$61.85
	39/64	HD-59-39/64-PTD	\$61.85
	15.50	HD-59-M1550-PTD	\$61.85
63	5/8	HD-63-5/8-PTD	\$63.84
	16.00	HD-63-M1600-PTD	\$63.84
	41/64	HD-63-41/64-PTD	\$63.84
	16.30	HD-63-M1630-PTD	\$63.84
67	16.50	HD-63-M1650-PTD	\$63.84
	21/32	HD-67-21/32-PTD	\$65.84
	17.00	HD-67-M1700-PTD	\$65.84
	43/64	HD-67-43/64-PTD	\$65.84
71	11/16	HD-67-11/16-PTD	\$65.84
	17.50	HD-67-M1750-PTD	\$65.84
	17.60	HD-71-M1760-PTD	\$66.83
45/64	HD-71-45/64-PTD	\$66.83	

For Drill Series #	Cutting Dia	Replaceable Head Part Number	Price Each
71	18.00	HD-71-M1800-PTD	\$66.83
	23/32	HD-71-23/32-PTD	\$66.83
	18.50	HD-71-M1850-PTD	\$66.83
75	47/64	HD-75-47/64-PTD	\$69.83
	19.00	HD-75-M1900-PTD	\$69.83
	3/4	HD-75-3/4-PTD	\$69.83
	49/64	HD-75-49/64-PTD	\$69.83
	19.50	HD-75-M1950-PTD	\$69.83
79	25/32	HD-79-25/32-PTD	\$71.82
	20.00	HD-79-M2000-PTD	\$71.82
	51/64	HD-79-51/64-PTD	\$71.82
83	13/16	HD-83-13/16-PTD	\$73.82
	21.00	HD-83-M2100-PTD	\$73.82
	53/64	HD-83-53/64-PTD	\$73.82
	27/32	HD-83-27/32-PTD	\$73.82
87	21.50	HD-83-M2150-PTD	\$73.82
	55/64	HD-87-55/64-PTD	\$76.81
	22.00	HD-87-M2200-PTD	\$76.81
	7/8	HD-87-7/8-PTD	\$76.81
	57/64	HD-87-57/64-PTD	\$76.81
22.50	HD-87-M2250-PTD	\$76.81	

Replacement Screws

For Drill Series #	Part Number	Price Each
55	SC-10093-PTD	\$2.98
59	SC-10093-PTD	\$2.98
63	SC-10094-PTD	\$2.98
67	SC-10094-PTD	\$2.98
71	SC-10094-PTD	\$2.98
75	SC-10095-PTD	\$2.98
79	SC-10095-PTD	\$2.98
83	SC-10095-PTD	\$2.98
87	SC-10096-PTD	\$2.98

Screw Drivers

For Drill Series #	Part Number	Price Each
55	TX-10097-PTD	\$9.07
59	TX-10097-PTD	\$9.07
63	TX-10098-PTD	\$11.98
67	TX-10098-PTD	\$11.98
71	TX-10098-PTD	\$11.98
75	TX-10099-PTD	\$11.98
79	TX-10099-PTD	\$11.98
83	TX-10099-PTD	\$11.98

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