



Flexible Products Drilling

Jinzhou SR129FP

Flexible Product Drill Bit Series

SR129FP Design & Advantages

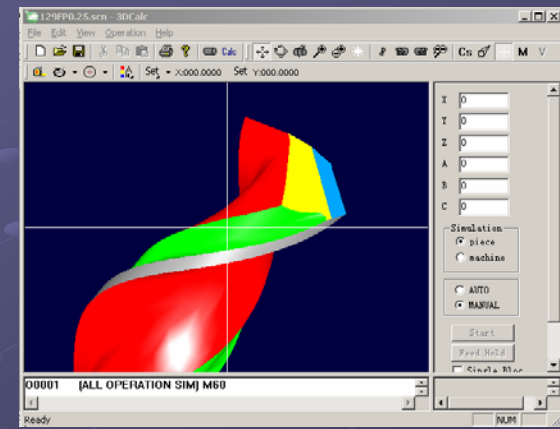
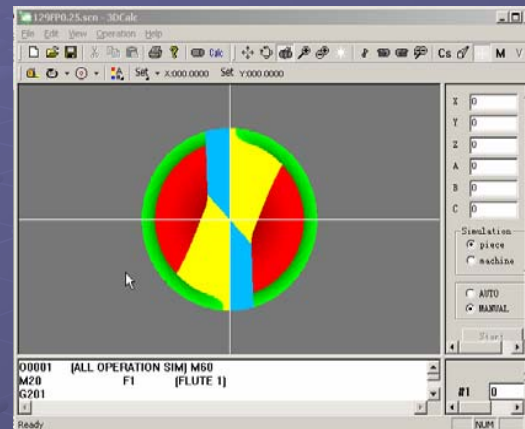
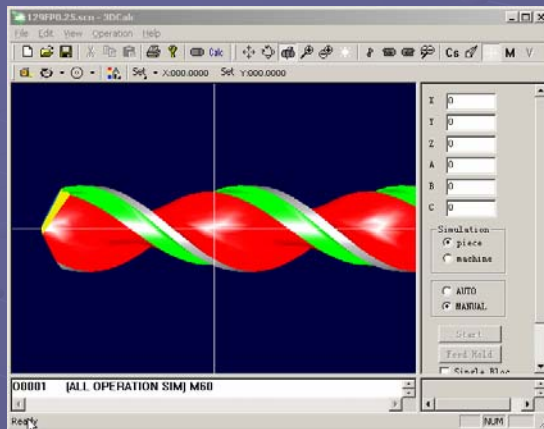
● Design Characteristics

- Thin Web
- Large Flute Volume
- High Helix Angle

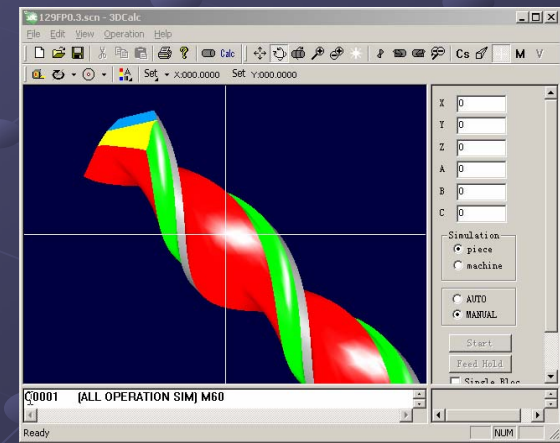
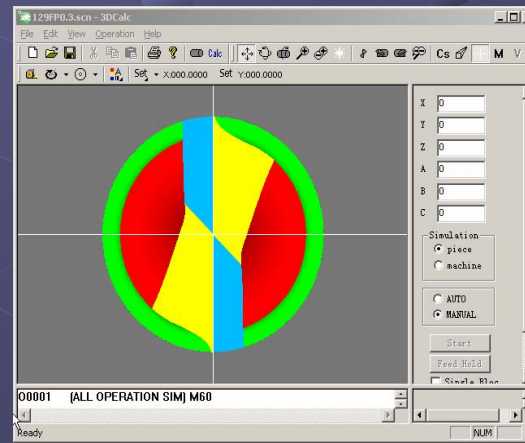
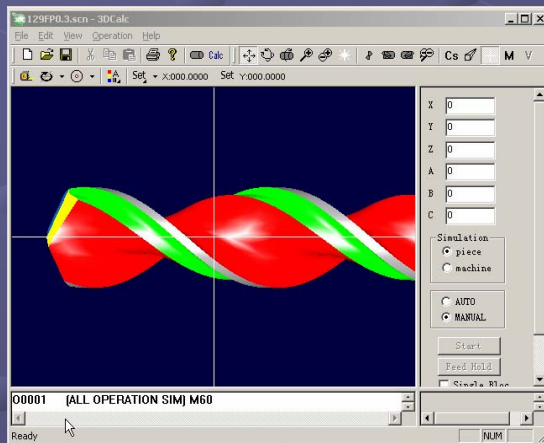
● Design Advantages

- Improved Debris Evacuation
- Reduced Hole Wall Friction
- Minimized Burr Generation

SR129FP Drawings



- 0.20mm / .0079" Diameter

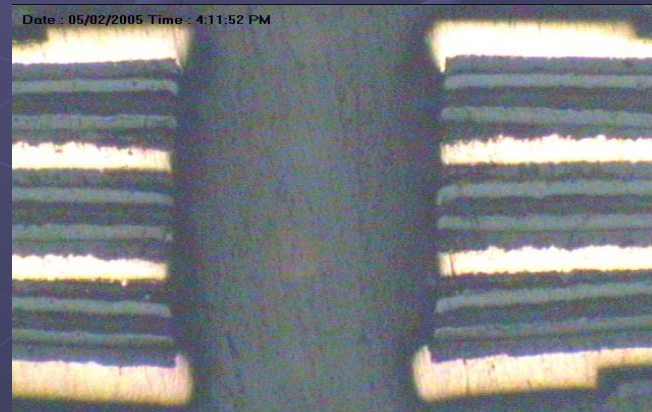
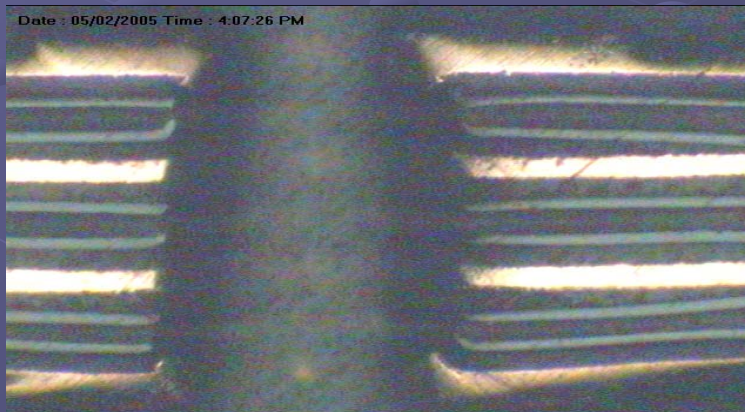


- 0.25mm / .0098" Diameter

SR129FP Optimized Parameters

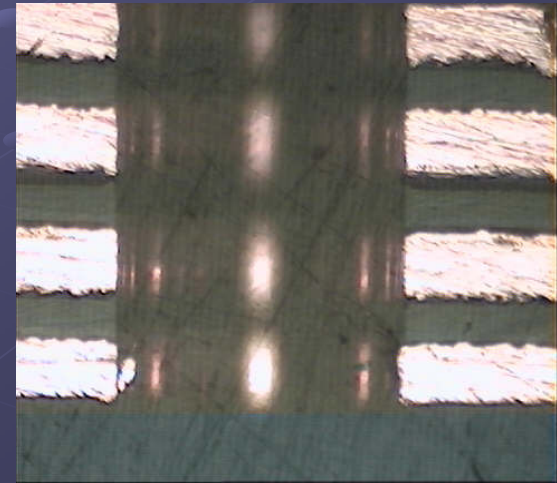
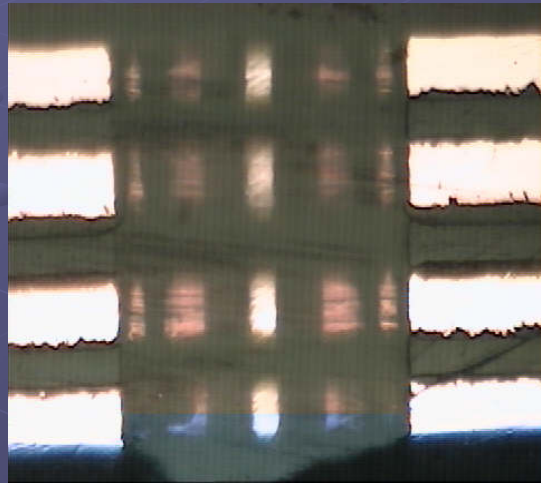
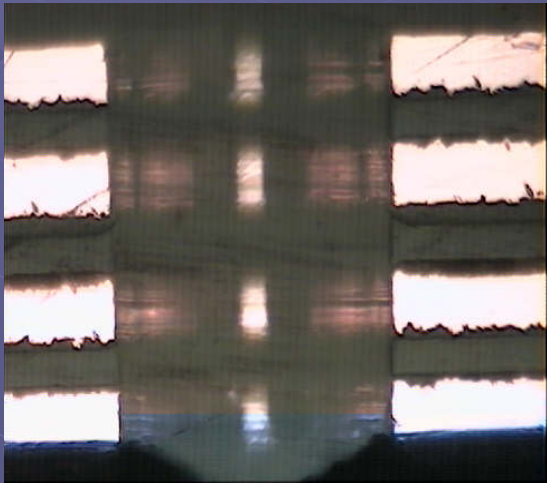
Size (mm)	Diameter (inch)	Surface Speed (sfm)	Chip Load (mils/rev)	Speed (krpm)	Infeed Rate (ipm)	Retract Rate (ipm)	Max Hits
0.20	0.0079	258	0.38	125	47	472	500
0.25	0.0098	309	0.49	120	59	591	800
0.30	0.0118	309	0.66	100	66	709	1000
0.35	0.0138	307	0.83	85	71	709	1000
0.40	0.0157	309	0.94	75	71	709	1200

Common Defects Using Standard Drills



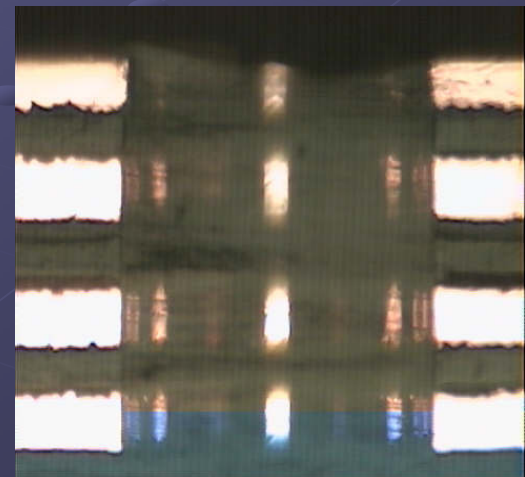
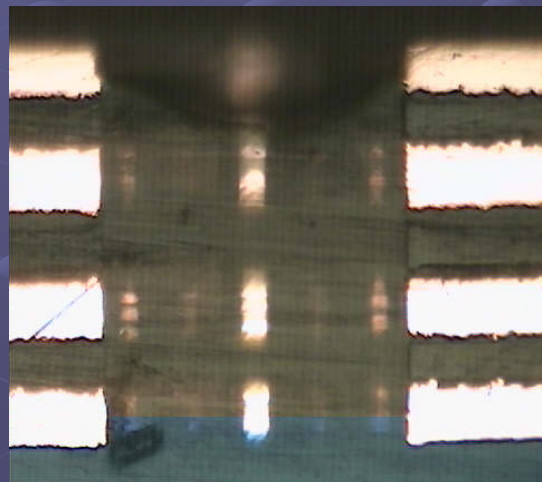
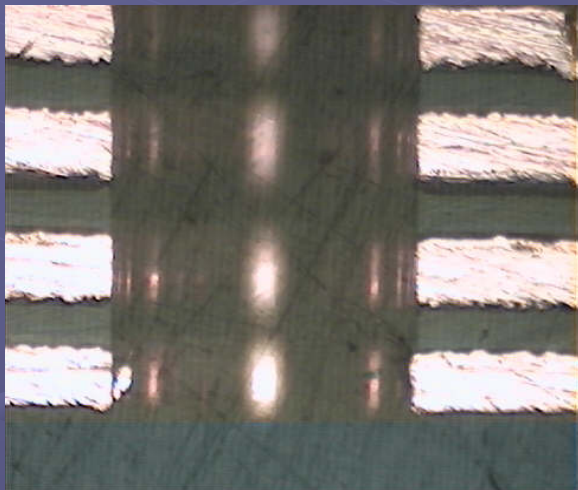
SR129FP Optimized Results

- 0.20mm / .0079" Diameter



SR129FP Optimized Results

- 0.25mm / .0079" Diameter



SR129FP Optimized Results

- 0.35mm / .0079" Diameter

