

EXPERT MACHINING ADVICE ON DRILLING TOOLOX® 44



International Mold Steel High Performance Mold & Tool Steel Solutions

Drilling Toolox® 44 Tool Steel 3 Easy Steps

NOTE: Mechanical feed is highly recommended

Step #1

Use COBALT Drills when doing a few holes. Use OSG Exocarb Max Oil Drill when doing many holes.

Step #2

Make sure the lead in angle of your drills is flatter than a normal drill. 112 to 118 degrees is preferred.

Step #3

Make sure your speeds and feeds are much lower than normal drilling practices. With a .257" Dia. OSG Max Oil we were able to drill 260 holes 1-1/8" deep. We ran at 1174 RPM, 6.9 IPM, 80 SFM, .006 FPR.

OR

Send IMS a detailed print outlining where the drilled holes are suppose to be and we will send you a block squared up 6 sides to tight tolerances with all the holes you require already in the steel.

If your blocks require gun drilled holes we can do that as well. We have the capacity to handle just about any pre-machining that you require.

Call us: 800-625-6653

Or

Email us: saledesk@imsteel.com



NORMAL 45 HRC

A new quenched and Tempered steel designed to have high impact and low Residual stresses and Therefore good dimensional stability

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