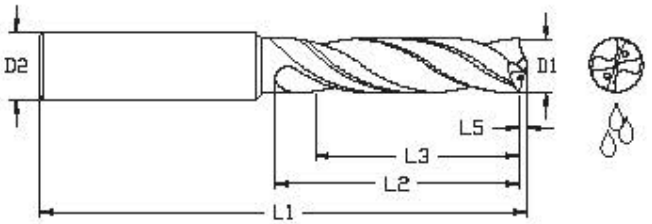
# Cyclone Series CDACR




**Features:**

- 2 Flutes.
- Lower Thrust Point Geometry.
- Enhanced Double Margin Design.
- Coolant Fed.

**Benefits:**

- Reduced cutting forces allowing for heavier feed rates.
- Improved performance in Non-Ferrous materials.
- Back margin location allows for quicker engagement in hole.
- Improved hole finishes.
- Improved location when drilling through cross holes.
- Higher heat resistance means higher speed and feed capabilities.

**CDA vs. CXD Style HP Drills:**

The CDA provides a deeper flute depth than the CXD style drill for increased chip evacuation. Also, The CDA's point relief and edge protection is maximized for machining in non-ferrous materials.

| | | Diameter | | | | Shank | OAL | | Flute Length | | Relief Length | | Point Length | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | D1 (m7) | | | | D2 (h6) | L1 | | L2 (max) | | L3 (Ref) | | L5 | |
| Tool No. | EDP | Inch | Letter/Wire | mm | Decimal | mm | Inch | mm | Inch | mm | Inch | mm | Inch | mm |
| CDACRM0300 | 07300 | | | 3.00 | .1181 | 6 | | 66 | | 28 | | 23 | | 0.46 |
| CDACR1200 | 07301 | | #31 | | .1200 | 6 | 2.60 | | 1.102 | | 0.905 | | 0.018 | |
| CDACRM0310 | 07302 | | | 3.10 | .1220 | 6 | | 66 | | 28 | | 23 | | 0.48 |
| CDACR1250 | 07303 | 1/8 | | | .1250 | 6 | 2.60 | | 1.102 | | 0.905 | | 0.019 | |
| CDACRM0320 | 07304 | | | 3.20 | .1260 | 6 | | 66 | | 28 | | 23 | | 0.49 |
| CDACR1285 | 07305 | | #30 | | .1285 | 6 | 2.60 | | 1.102 | | 0.905 | | 0.020 | |
| CDACRM0330 | 07306 | | | 3.30 | .1299 | 6 | | 66 | | 28 | | 23 | | 0.51 |
| CDACRM0340 | 07307 | | | 3.40 | .1339 | 6 | | 66 | | 28 | | 23 | | 0.52 |
| CDACR1360 | 07308 | | #29 | | .1360 | 6 | 2.60 | | 1.102 | | 0.905 | | 0.021 | |
| CDACRM0350 | 07309 | | | 3.50 | .1378 | 6 | | 66 | | 28 | | 23 | | 0.54 |
| CDACR1406 | 07310 | 9/64 | | | .1406 | 6 | 2.60 | | 1.102 | | 0.905 | | 0.022 | |
| CDACRM0360 | 07311 | | | 3.60 | .1417 | 6 | | 66 | | 28 | | 23 | | 0.55 |
| CDACR1440 | 07312 | | #27 | | .1440 | 6 | 2.60 | | 1.102 | | 0.905 | | 0.022 | |
| CDACRM0370 | 07313 | | | 3.70 | .1457 | 6 | | 66 | | 28 | | 23 | | 0.57 |
| CDACR1470 | 07314 | | #26 | | .1470 | 6 | 2.60 | | 1.102 | | 0.905 | | 0.023 | |
| CDACR1495 | 07315 | | #25 | | .1495 | 6 | 2.91 | | 1.417 | | 1.141 | | 0.023 | |
| CDACRM0380 | 07316 | | | 3.80 | .1496 | 6 | | 74 | | 36 | | 29 | | 0.58 |
| CDACR1520 | 07317 | | #24 | | .1520 | 6 | 2.91 | | 1.417 | | 1.141 | | 0.023 | |
| CDACRM0390 | 07318 | | | 3.90 | .1535 | 6 | | 74 | | 36 | | 29 | | 0.60 |
| CDACR1562 | 07319 | 5/32 | | | .1562 | 6 | 2.91 | | 1.417 | | 1.141 | | 0.024 | |
| CDACRM0400 | 07320 | | | 4.00 | .1575 | 6 | | 74 | | 36 | | 29 | | 0.61 |
| CDACR1590 | 07321 | | #21 | | .1590 | 6 | 2.91 | | 1.417 | | 1.141 | | 0.024 | |
| CDACR1610 | 07322 | | #20 | | .1610 | 6 | 2.91 | | 1.417 | | 1.141 | | 0.025 | |
| CDACRM0410 | 07323 | | | 4.10 | .1614 | 6 | | 74 | | 36 | | 29 | | 0.63 |
| CDACRM0420 | 07324 | | | 4.20 | .1654 | 6 | | 74 | | 36 | | 29 | | 0.64 |
| CDACR1660 | 07325 | | #19 | | .1660 | 6 | 2.91 | | 1.417 | | 1.141 | | 0.025 | |
| CDACRM0430 | 07326 | | | 4.30 | .1693 | 6 | | 74 | | 36 | | 29 | | 0.66 |
| CDACR1719 | 07327 | 11/64 | | | .1719 | 6 | 2.91 | | 1.417 | | 1.141 | | 0.026 | |

| Inch | |
|---|---|
| D1 | Tolerance (m7) |
| .0000 - .1181 | +.00008/+.00047 |
| .1182 - .2362 | +.00016/+.00063 |
| .2363 - .3937 | +.00024/+.00083 |
| .3938 - .5000 | +.00027/+.00098 |

| Inch | |
|---|---|
| D2 | Tolerance (h6) |
| .0000 - .1181 | +0/-.00024 |
| .1182 - .2362 | +0/-.00031 |
| .2363 - .3937 | +0/-.00035 |
| .3938 - .5000 | +0/-.00043 |

| Metric (mm) | |
|---|---|
| D1 | Tolerance (m7) |
| 0 - 3.0 | +.002/+.012 |
| 3.01 - 6.0 | +.004/+.016 |
| 6.01 - 10.0 | +.006/+.021 |
| 10.01 - 12.7 | +.007/+.025 |

| Metric (mm) | |
|---|---|
| D2 | Tolerance (h6) |
| 0 - 3.0 | +0/-.006 |
| 3.01 - 6.0 | +0/-.008 |
| 6.01 - 10.0 | +0/-.009 |
| 10.01 - 12.7 | +0/-.011 |

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