



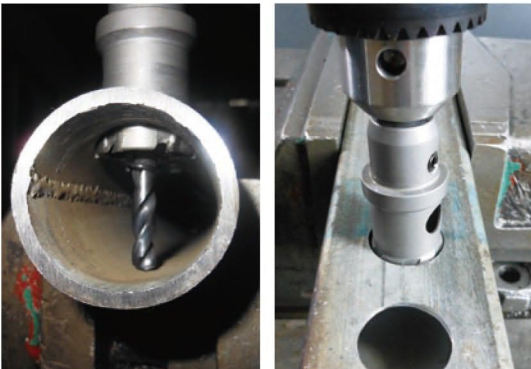
Effective knifing	25mm
Applicable electrical equipment	Electric hand drill, impact drill (rotary type), magnetic base drilling machine and bench drill

Applicable materials

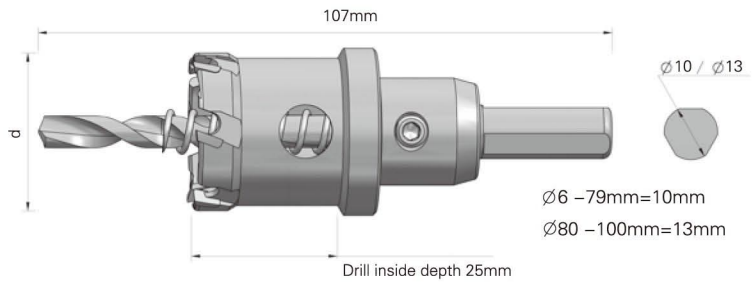
I-steel	Steel plate	Tubular product	Stainless steel	Aluminum
<1400N	-	-	<900N	-
<10mm	<10mm	-	<10mm	<5mm
✓	✓	✓	✓	✓

Brass/Tin	Plastic/Organic glass	Cast iron	Laminated material
-	-	-	-
<10mm	<10mm	<10mm	<10mm
✓	✓	✓	✓

Processing diagram



Overall dimension MCT Series



Introduction

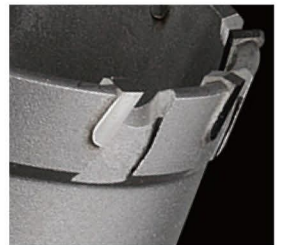
● Chip groove

Adopt the arc spiral chip groove to smoothly discharge the iron chips, reduce the built-up edge, and effectively prevent from stoppage and tipping caused by blocking the iron chips between the cutting blade and the processed material; the iron chips can be quickly discharged by the chip groove even if the thick steel plate is processed.



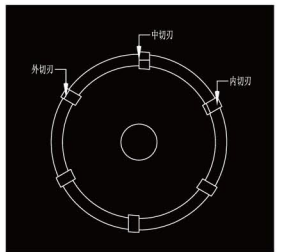
● Hard high-intensity alloy blade

Due to the peculiar drill, the hard high-intensity high-sharpness alloy blade is adopted and still maintains excellent chipping resistance and abrasion resistance and agile cutting force under bad operating environment. The alloy blade is combined with vibration-resistance teeth to achieve smooth and steady drilling and greatly improve the service life.



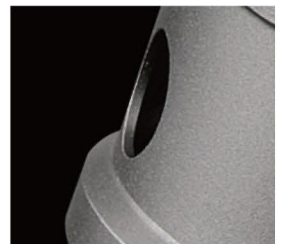
● Geometric design of special blade

The special blade adopts the three-layer combination design of an external cutting blade, a middle cutting blade and an internal cutting blade and is applied to layering and component cutting, and the hole inside is provided with the cutting blade to reduce the cutting resistance and smoothly discharge the chips, at the same time, the cutting blade is specially grinded such that the cutting blade isn't easily tipped to prolong the service life of the drill.



● Depoling hole

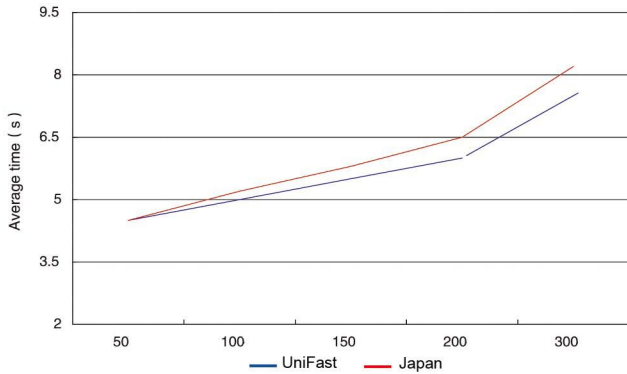
The cutter side is provided with a depoling hole to conveniently remove the cylindrical material core in the hole.



Comparison diagram of cutting efficiency

Size : $\Phi 35 \times 25$ Material thickness : 2mm Power : 1.5KW

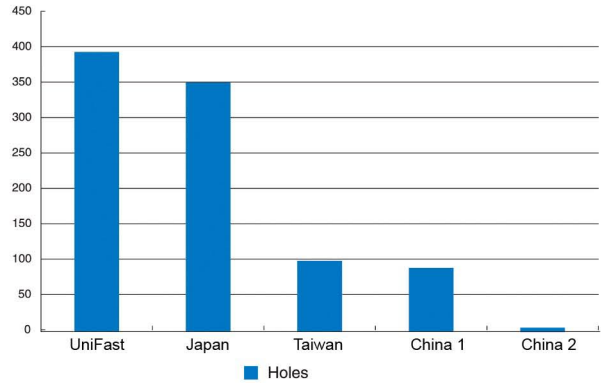
Use equipment: Bench drill Processed materials: 304 Stainless steel



Comparison diagram of service life

Size : $\Phi 35 \times 25$ Material thickness : 2mm Power : 1.5KW

Use equipment: Bench drill Processed materials: 304 Stainless steel



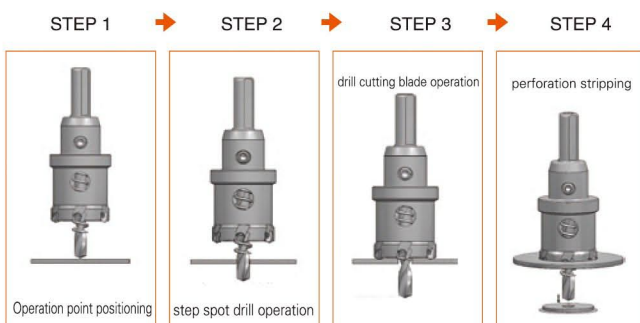
Recommend cutting parameter table

Size extent (mm)	Processed materials					
	aluminum (r/min)	copper (r/min)	plain steel (r/min)	stainless steel (r/min)	alloy steel (r/min)	non-metallic material (r/min)
≤20	1500~1800	800~1000	700~1000	700~800	700~900	1500~1800
21~30	1500~1800	800~1000	700~800	400~600	600~700	1500~1800
31~40	1500~1800	800~1000	500~600	350~450	450~500	1500~1800
41~50	800~1000	600~800	400~500	250~400	300~400	1000~1500
51~60	600~850	400~600	300~400	200~300	200~300	800~1000
61~79	400~600	200~400	150~200	150~200	150~200	500~800
≥80	200~400	100~200	100~150	100~150	100~150	500~800

Processing diagram for drilling square tube and circular tube



Drilling diagram



Operation cautions

■ The spot drill avoids to strike the blade in drilling. The overlarge impact force enables the blade to be tipped, thereby affecting the drilling effect.



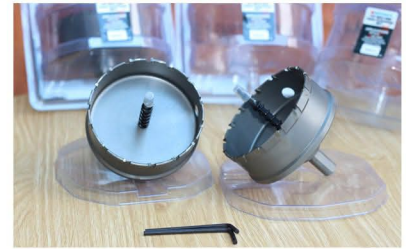
1. Before use, inspect the completeness of the drill;
2. When the drill is installed into the electric drill, three planes corresponding to the shank shall be clamped;
3. During drilling, retain perpendicularity between the drill and the workpiece;
4. During start of drilling, adopt the lower feeding force;
5. After positioning, adopt the intermediate feeding force;
6. During operation, the revolving speed of the drill shall be not too low to avoid the cutting blade to be tipped due to locking;
7. There is no overlarge force to drill the workpiece by the spot drill, in order to prevent the cutting blade of the drill and the workpiece from fierce impact;
8. After the workpiece is drilled by the drill, the workpiece shall be withdrawn when the drill is rotated.
9. During continuous drilling, cool the cutting blade by the cutting fluid.



CODE	DIA.mm	DEPTH
MCT-12	Ø12	25mm
MCT-13	Ø13	25mm
MCT-14	Ø14	25mm
MCT-15	Ø15	25mm
MCT-16	Ø16	25mm
MCT-17	Ø17	25mm
MCT-18	Ø18	25mm
MCT-19	Ø19	25mm
MCT-20	Ø20	25mm
MCT-21	Ø21	25mm
MCT-22	Ø22	25mm
MCT-23	Ø23	25mm
MCT-24	Ø24	25mm
MCT-25	Ø25	25mm
MCT-26	Ø26	25mm
MCT-27	Ø27	25mm
MCT-28	Ø28	25mm
MCT-29	Ø29	25mm
MCT-30	Ø30	25mm
MCT-31	Ø31	25mm
MCT-32	Ø32	25mm
MCT-33	Ø33	25mm
MCT-34	Ø34	25mm
MCT-35	Ø35	25mm
MCT-36	Ø36	25mm
MCT-37	Ø37	25mm
MCT-38	Ø38	25mm
MCT-39	Ø39	25mm
MCT-40	Ø40	25mm



CODE	DIA.mm	DEPTH
MCT-43	Ø43	25mm
MCT-44	Ø44	25mm
MCT-45	Ø45	25mm
MCT-46	Ø46	25mm
MCT-47	Ø47	25mm
MCT-48	Ø48	25mm
MCT-49	Ø49	25mm
MCT-50	Ø50	25mm
MCT-51	Ø51	25mm
MCT-52	Ø52	25mm
MCT-53	Ø53	25mm
MCT-54	Ø54	25mm
MCT-55	Ø55	25mm
MCT-56	Ø56	25mm
MCT-57	Ø57	25mm
MCT-58	Ø58	25mm
MCT-59	Ø59	25mm
MCT-60	Ø60	25mm
MCT-61	Ø61	25mm
MCT-62	Ø62	25mm
MCT-63	Ø63	25mm
MCT-64	Ø64	25mm
MCT-65	Ø65	25mm
MCT-66	Ø66	25mm
MCT-67	Ø67	25mm
MCT-68	Ø68	25mm
MCT-69	Ø69	25mm
MCT-70	Ø70	25mm
MCT-71	Ø71	25mm



CODE	DIA.mm	DEPTH
MCT-72	Ø72	25mm
MCT-73	Ø73	25mm
MCT-74	Ø74	25mm
MCT-75	Ø75	25mm
MCT-76	Ø76	25mm
MCT-77	Ø77	25mm
MCT-78	Ø78	25mm
MCT-79	Ø79	25mm
MCT-80	Ø80	25mm
MCT-81	Ø81	25mm
MCT-82	Ø82	25mm
MCT-83	Ø83	25mm
MCT-84	Ø84	25mm
MCT-85	Ø85	25mm
MCT-86	Ø86	25mm
MCT-87	Ø87	25mm
MCT-88	Ø88	25mm
MCT-89	Ø89	25mm
MCT-90	Ø90	25mm
MCT-92	Ø92	25mm
MCT-95	Ø95	25mm
MCT-100	Ø100	25mm
MCT-105	Ø105	25mm
MCT-110	Ø110	25mm
MCT-114	Ø114	25mm
MCT-120	Ø120	25mm
MCT-130	Ø130	25mm
MCT-140	Ø140	25mm
MCT-150	Ø150	25mm

Unifast TCT hole-saws has extremely sharp and powerful Tungsten carbide tipped cutting edges. Its exceptional design allows to run at higher feed rates and speed, creating holes of remarkable quality and accuracy.

Recommended working depth is 25mm depends on application and the best in drilling Stainless Steel sheet metal, thick metal, iron, aluminum, copper, tin, brass, acrylic, FRP, PVC and even more in ceramic.

Attachment		
order number	Name	Size
2102017	Hexagon screw	M6
2106002	Spring	8.5*35
2501011	Spot drill	6*76

Remark: we shall prepare the spot drill to deal with difficult processing materials, purchased as needed.