

Vischer & Bolli  
OSG GROUP COMPANY



High efficiency modular drill

# MagicDrill DRA 12D



Excellent hole accuracy with a low cutting force design

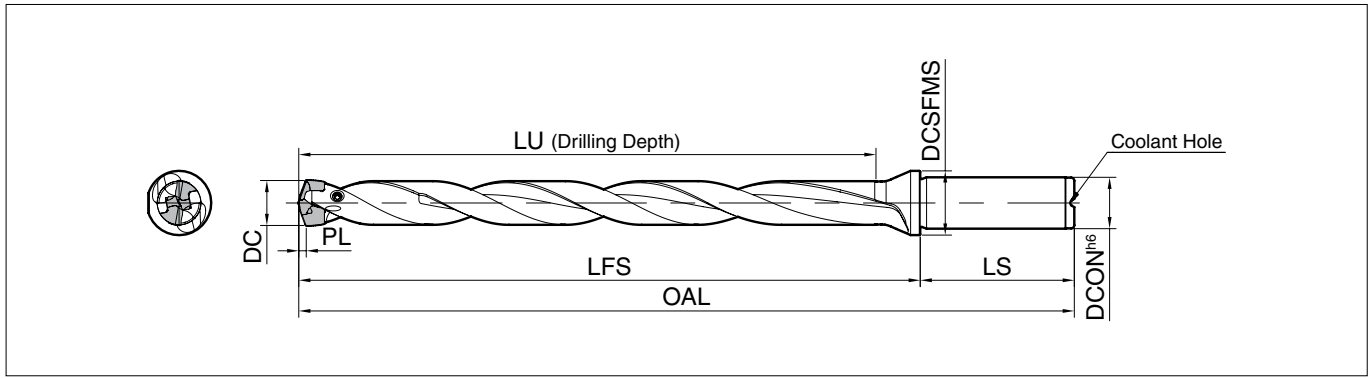
Optimal web thickness reduces deflection

Fine chip breaking and smooth deep hole cutting

Easy insert replacement



## SF-DRA (Drilling depth: 12x DC)




## Toolholder dimensions

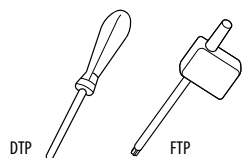
Description	Availability	Dimension (mm)								Spare parts		Applicable inserts
		Applicable insert dia. DC		DCON (h6)	OAL	LFS	LU	LS	DCS-FMS	Clamp screw	Wrench	
		min.	max.									
SF16- DRA120M-12 DRA125M-12 DRA130M-12 DRA135M-12 DRA140M-12 DRA145M-12	●	12.00	12.49	16	216	168	150.0	48	20	HS-2534TRP	FTP-5	DA1200M-...~DA1240M-...
	●	12.50	12.99		223	175	156.0					DA1250M-...~DA1290M-...
	●	13.00	13.49		229	181	162.0					DA1300M-...~DA1340M-...
	●	13.50	13.99		236	188	168.0					DA1350M-...~DA1390M-...
	●	14.00	14.49		242	194	174.0					DA1400M-...~DA1440M-...
	●	14.50	14.99		249	201	180.0					DA1450M-...~DA1490M-...
SF20- DRA150M-12 DRA160M-12 DRA170M-12	●	15.00	15.99	20	265	215	192.0	50	25	HS-3048TRP	DTP-6	DA1500M-...~DA1590M-...
	●	16.00	16.99		279	229	204.0					DA1600M-...~DA1690M-...
	●	17.00	17.99		292	242	216.0					DA1700M-...~DA1790M-...
SF25- DRA180M-12 DRA190M-12 DRA200M-12 DRA210M-12 DRA220M-12 DRA230M-12 DRA240M-12 DRA250M-12	●	18.00	18.99	25	312	256	228.0	56	32	HS-4067TRP	DTP-7	DA1800M-...~DA1890M-...
	●	19.00	19.99		325	269	240.0					DA1900M-...~DA1990M-...
	●	20.00	20.99		338	282	252.0					DA2000M-...~DA2090M-...
	●	21.00	21.99		351	295	264.0					DA2100M-...~DA2150M-...
	●	22.00	22.99		365	309	276.0					DA2200M-...~DA2250M-...
	●	23.00	23.99		378	322	288.0					DA2300M-...~DA2350M-...
	●	24.00	24.99		391	335	300.0					DA2400M-...~DA2450M-...
	●	25.00	25.50		404	348	312.0					DA2500M-...~DA2550M-...

For recommended cutting conditions please refer to MacigDrill DRA brochure

● : Available

## Spare parts

Clamp Screw	Description
	HS-2524TRP
	HS-2534TRP
	HS-3048TRP
	HS-4067TRP

Wrench	Description	Tightening torque (N-m)
	FTP-5	0.5
	DTP-6	0.8
	DTP-7	1.2