



**LINDQUIST STEELS, INC.**  
TOOL STEEL SPECIALISTS

## 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.

### Another option is:

You may also send Lindquist Steels a detailed print outlining where the drilled holes are to be placed and we can provide you with a block squared up 6 sides to tight tolerances and all the holes you require in the steel.

For more information or questions please contact the Lindquist Steels location nearest you.

### Lindquist Steels, Inc.

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NOMINAL 45 HRC

A new quenched and tempered steel designed to have high impact and low residual stresses and therefore good dimensional stability.