



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.

New England Region- 1-800-243-9637

sales@lindquiststeels.com

Southeast & Mid Atlantic Region-

1-800-845-7052,

sales-sc@lindquiststeels.com

Mid-West Region- 1-866-489-6417

sales-tn@lindquiststeels.com



NOMINAL 45 HRC

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