

How-to

## Deep Hole Drilling — The Cutting View

Brought To You by SECO Tools | May 11, 2018

### Video Takeaways

- Use shrink fit or hydraulic chucks to hold your drills; this is the absolute best and keeps your run-out tight.
- You need a minimum of 30 Bar/435 PSI of coolant pressure.
- Create a pilot hole that's the exact same diameter of the long drill.
- Once you reach your final depth with the long drill, reduce your RPMs to 500 and feed out of the hole 4-5 times the feed rate used on the way in.

*To view the full offering of deep hole drilling products from SECO, visit [MSCdirect.com](https://www.mscdirect.com).*

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