



Practical Test on Toolox44 – Chiron DRILLING-TAPPING 2011



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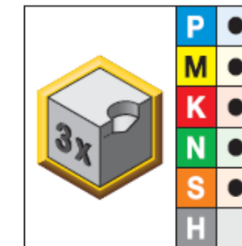


Solid Carbide Drill, 3 x D, 5 x D, 8 x D

Go Drill
 B041A05000CPG
 KC7325
 Ø 1,6 - Ø 12,7



Diameter = 5 mm
 Vc = 50 m/min
 n = 3200 U/min
 fz = 0,07 mm
 f/rev. = 0,15 mm
 cooling = internal emulsion



Application:

- Workpiece
 -drilling blind hole

Test plate Toolox44
 depth 12,0 mm

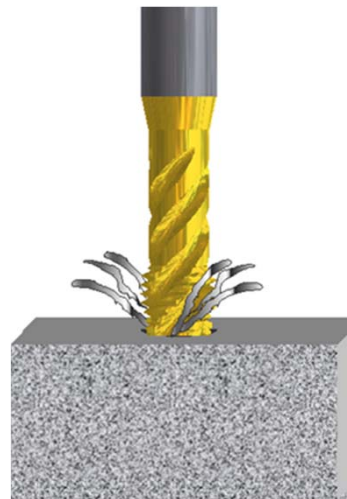
Result:

After 130holes or 1,5m TL only 0,03mm flank wear

Solid Carbide Tap

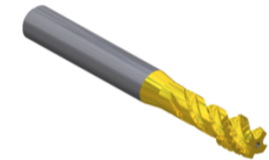


KC7542



SC-Tap
T331M060X100R6H
KC7542
M3 - M20

Diameter = M6
Vc = 35 m/min
n = 1857 U/min
f/rev. = 1,00 mm
vf = 1857 mm/min



T331

RHSF

3P chamfer

Application:

- Workpiece
- drilling blind hole
- tapping blind hole

Test plate Toolox44
depth 12 mm
M 6 depth 8mm

Result:

After 76holes or 0,9m TL only 0,02mm flank wear