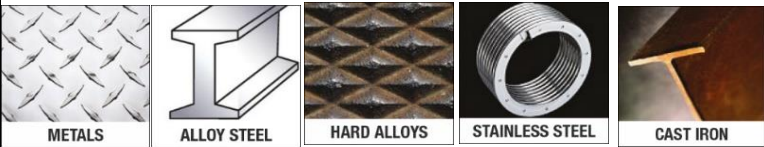
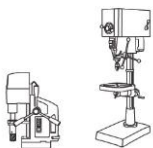


FAMILY CLASSIFICATION	03790
DESCRIPTION	TUNGSTEN CARBIDE TIPPED CORE DRILLS WITH WELDON SHANK FOR MAGNETIC DRILLING MACHINES - CUTTING DEPTH 35 mm
PRODUCT IMAGE	
KIND OF STEEL	C45
COMPOSITION %	C 0,42-0,50 - Si ≤ 0,40 - Mn 0,50-0,80 - P ≤ 0,045 - S ≤ 0,045 - Cr ≤ 0,40 Ni ≤ 0,40 - Mo ≤ 0,10 - Cr+Mo+Ni ≤ 0,63 C=Carbon - Si=Silicon - Mn=Manganese - P=Phosphorus - S=Sulfur - Cr=Chrome - Mo=Molybdenum Ni=Nickel - Cu=Copper - Ti=Titanium - Al=Aluminium
KIND OF TEETH	TUNGSTEN CARBIDE H.M. ISO K20=Vickers 1710
TOOTH WELDING	BRAZE TEC 5600 ISO 3677
LENGTHS	TOTAL = 65 mm - CUTTING DEPTH = 35 mm
HARDENING TEMPERATURE	1120°
HARDNESS OF THE TIPS	78 HRC
CORE DRILL EXECUTION	Body with lateral helicoidal grooves for the evacuation of chips
PIN - EXTRACTOR	L. 35 mm (Ø 6,34x90mm) for core drills Ø 14-16 mm L. 35 mm (Ø 7,98x90mm) for core drills Ø 17-90 mm
SHANK	WELDON 19 mm (3/4") - 31,75 mm (1-1/4")
MANUFACTURING PROCESS	FULLY GROUND FROM THE SOLID, with CAO System, that grants quality control and product homogeneity. The flute is made by grinding lathe (fine sand disc), for a smoother and brighter surface.
TOOTHING SHARPENING	DOUBLE GEOMETRY CBN FOR A PERFECT CENTERING
SURFACE TREATMENT	SAND-BLASTING (anti-rust)
WORK PIECE MATERIALS	HARD METALS - HARD ALLOY STEEL - STAINLESS STEEL - HARD CAST IRON - METALLS WITH RESISTANCE $R \leq 1400 \text{ N/mm}^2$ 
REFERENCE TOOL	Magnetic drilling machines with Weldon shank, alternatively it is possible to use a drill press with a specific chuck (spindle) from morse taper to weldon. 
RECOMMENDATIONS	DRY CUTTING - USE REFRIGERANT OIL if required
SPECIAL FEATURES	DRILLING CAPACITY TWICE UPPER RESPECT TO THE TCT HOLE SAWS
PACKAGE	IN PLASTIC TUBE 14,00 - 90,00 mm = 1 pc.



TECHNICAL SPECIFICATIONS

METAL TOOLS

FAMILY CLASSIFICATION		03790				
CUTTING SPEED CONVERSION TABLE - ROUND/MINUTE - DIAMETER						
diameter ø		MATERIALE				
mm	inches	LIGHT ALLOYS	ALLOY STEEL	CAST IRON	STAINLESS STEEL	HARD ALLOYS
14	35/64	800	700	240	200	220
15	19/32	530	610	200	180	200
16	5/8	530	610	200	180	200
17	43/64	530	610	200	180	200
18	23/32	380	530	180	160	180
19	3/4	380	530	180	160	180
20	25/32	380	530	180	160	180
21	53/64	290	460	160	140	150
22	7/8	290	460	160	140	150
21	53/64	290	460	160	140	150
24	15/16	250	400	140	120	130
25	1"	250	400	140	120	130
26	1"1/32	250	400	140	120	130
27	1"1/16	200	340	120	100	110
28	1"7/64	200	340	120	100	110
29	1"9/64	200	340	120	100	110
30	1"1/8	200	340	120	100	110
31	1"7/32	185	300	110	80	90
32	1"1/4	185	300	110	80	90
33	1"19/64	185	300	110	80	90
34	1"11/32	185	300	110	80	90
35	1"3/8	170	270	100	60	70
36	1"27/64	170	270	100	60	70
37	1"29/64	170	270	100	60	70
38	1"1/2	170	270	100	60	70
39	1"17/32	170	270	100	60	70
40	1"9/16	170	270	100	60	70
41	1"5/8	130	240	80	40	50
42	1"21/32	130	240	80	40	50
43	1"11/16	130	240	80	40	50
44	1"3/4	130	240	80	40	50
45	1"3/4	130	240	80	40	50
46	1"13/16	100	180	60	20	30
47	1"27/32	100	180	60	20	30
48	1"7/8	100	180	60	20	30
49	1"59/64	100	180	60	20	30
50	1"31/32	100	180	60	20	30
51	2"	80	140	50	20	30
52	2"3/64	80	140	50	20	30
53	2"3/32	80	140	50	20	30
54	2"1/8	80	140	50	20	30



TECHNICAL SPECIFICATIONS

METAL TOOLS

FAMILY CLASSIFICATION		03790				
CUTTING SPEED CONVERSION TABLE - ROUND/MINUTE - DIAMETER						
diameter Ø		MATERIALE				
mm	inches	LIGHT ALLOYS	ALLOY STEEL	CAST IRON	STAINLESS STEEL	HARD ALLOYS
55	2"11/64	80	140	50	20	20
56	2"13/64	60	110	40	20	20
57	2"1/4	60	110	40	20	20
58	2"9/32	60	110	40	20	20
59	2"21/64	60	110	40	20	20
60	2"3/8	60	110	40	20	20
62	2"7/16	40	80	30	20	20
65	2"9/16	40	80	30	20	20
68	2"11/16	40	80	30	20	20
70	2"3/4	40	80	30	20	20
75	2"61/64	30	40	20	20	20
80	3"5/32	30	40	20	20	20
85	3"11/32	20	30	20	20	20
90	3"9/16	20	30	20	20	20