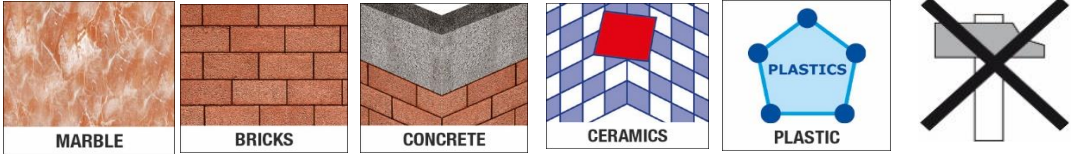


FAMILY CLASSIFICATION	00640
DESCRIPTION	CARBIDE TIPPED WALL SOCKET HOLE CUTTER WITH PILOT DRILL AND THREADED SHANK INCLUDED - ROTARY USE ONLY
PRODUCT IMAGE	
KIND OF STEEL	C45 - EN 10083-2
STEEL COMPOSITION %	C 0,42-0,50 - Si ≤ 0,40 - Mn 0,50-0,80 - P ≤ 0.045 - S ≤ 0,045 - Cr ≤ 0,40 Ni ≤ 0,40 - Mo ≤ 0,10 - 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=Aluminum
HARD METAL OF THE TEETH	YG6 - K10 cemented carbide
CARBIDE TEETH COMPOSITION %	WC 94% - Co 6% WC=Tungsten carbide Co= Cobalt DENSITY = 14,80 (g/cm ³) HRA=89,5 1700 N/mm ²
HARDENING TEMP.	1100°
Shank HARDNESS	43 - 45 HRC
Shank SHAPE	TRIANGULAR - 3 sided 
PILOT DRILL	Ø 6x70 mm for Ø 16÷50mm - Ø 8x80 mm for Ø 55÷150 mm
MANUFACTURING PROCESS	Hot forged body, fully rectified. The carbide teeth are welded to the body with high frequency voltage
SURFACE TREATMENT	Natural steel - ground from the solid - smooth RED color finish with black color shank
APPLICATION	Rotary use on masonry, tiles, for passage holes; floor holes; holes to install armored doors, junction boxes, holes for pipes
USE BY ROTATION	MARBLE - LIGHT STONES - BRICKS - CONCRETE MASONRY - CERAMIC - LAMINATED PLASTIC 
REFERENCE POWER TOOL	Power drilling machines after disabling the percussion function; HIGH speed and good pressure
PACKAGE	IN SINGLE PLASTIC BOX with HANGER 16,00 - 150,00 mm = 1 pc.

FAMILY CLASSIFICATION 00640

TABLE OF CUTTING SPEED - ROUNDS/MINUTE - DRILL DIAMETER

diameter Ø		WORK-PIECE MATERIALS		
		CONCRETE MASONRY	MARBLE CERAMIC	STONE
16	5/8	2.800	2.500	1.800
22	7/8	2.500	2.100	1.600
25	1	2.200	1.900	1.400
27	1"1/16	2.000	1.700	1.250
30	1"3/16	1.800	1.400	1.000
35	1"3/8	1.600	1.100	800
38	1"1/2	1.500	1.000	750
40	1"9/16	1.400	900	650
45	1"3/4	1.250	800	600
50	2"	1.100	750	500
55	2"11/64	1.000	700	470
60	2"3/8	900	650	450
65	2"9/16	850	600	420
70	2"3/4	800	550	400
80	3"5/32	720	500	370
85	3"11/32	680	450	340
90	3"9/16	650	420	320
95	3"3/4	600	400	320
100	3"15/16	580	380	300
110	4"21/64	500	350	280
125	5"	420	300	250
150	6"	380	250	200

FORMULA	CAPTION
$R.P.M. = \frac{V_c \times 1000}{\pi \times \varnothing}$	RPM = Rounds per minute Vc = Peripheral speed π = 3,1416 $\varnothing$ = Drill diameter

PERSONAL SECURITY WARNINGS



Always use safety glasses



In case of loud noise wear ear protection



Always wear protective gloves



Always wear protective mask