

FAMILY CLASSIFICATION	06420
DESCRIPTION	SPECIAL CARBIDE TIPPED GLASS DRILL BITS WITH 4 CUTTING EDGES HIGH PERFORMANCE
PRODUCT IMAGE	
KIND OF STEEL	C45 - EN 10083-2
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 TIP	YG8 - K20 + Tin cemented carbide
CARBIDE TIP COMPOSITION %	WC 92% - Co 8% WC=Tungsten carbide Co= Cobalt Tin= Titanium DENSITY = 14,70 (g/cm ³) HRA=88,5 2300 N/mm ²
SHARPENING	2 SHARP SPEAR-SHAPED CARBIDE TIPS WITH 4 CUTTING EDGES
HARDENING TEMP.	1100°
Shank HARDNESS	43 - 45 HRC
SHANK	CYLINDRICAL
MANUFACTURING PROCESS	The POSITIVE SHARPENING of the CARBIDE TIP is useful for drilling different materials, with the only use of rotation. Fast penetration. The 4 cutting edges guarantee concentric holes.
RECOMMANDATION	NEVER USE THE PERCUSSION 
SURFACE TREATMENT	Natural steel - ground - smooth golden finish
USE BY ROTATION ONLY	GLASS - CERAMIC - TILES - FIBREGLASS  USE ONLY WITH ROTATION
REFERENCE POWER TOOL	Power drilling machines after disabling the percussion function; MEDIUM-HIGH speed and good or light pressure.
PACKAGE	IN SINGLE PLASTIC WALLET 3,00 - 12,00 mm = 1 pc.

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TABLE OF CUTTING SPEED - ROUNDS/MINUTE - DRILL DIAMETER

diameter Ø		WORK-PIECE MATERIAL	
		GLASS	CERAMIC
3	1/8	700	1.000
4	5/32	700	1.000
5	3/16	700	1.000
6	15/64	600	800
8	5/16	550	750
10	25/64	350	550
12	15/32	250	400

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