

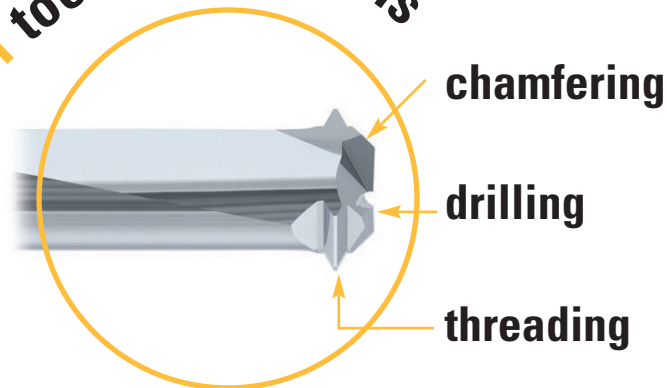
Tungsten carbide and diamond precision tools

NEW

DRILLING THREAD WHIRLER



1 tool, 3 operations



DIXI 1740 M 0.80 - M 10.00

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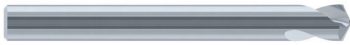
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**Classical method
with 3 tools**

1. Centering, chamfering 90°



2. Drilling

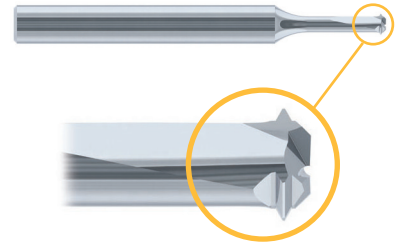


3. Threading

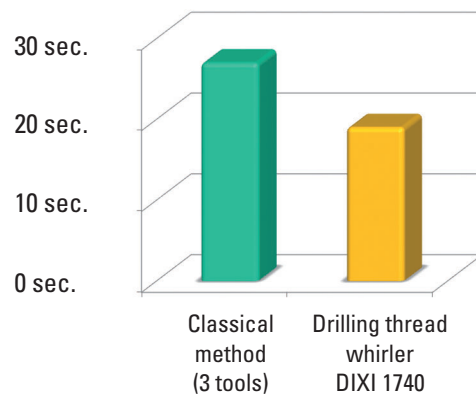


**New method
with drilling thread whirler**

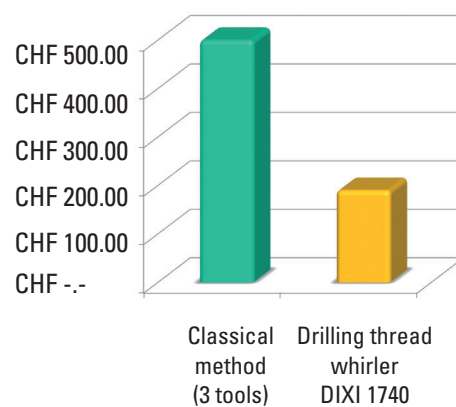
1 tool, 3 operations



1 TOOL = IMPROVED CYCLE TIME, POSITIVE IMPACT ON PRODUCTIVITY AND IMPROVED MANUFACTURING TERMS



1 TOOL = REDUCTING OF TOOLING COSTS AND SIMPLIFIED STOCK MANAGEMENT



* Current prices:
tool holder and collet CHF 180.-.

Cutting examples

Dimension	M 1.00 x 0.25	M 3.00 x 0.50	M 8.00 x 1.25
Material	Titanium GR5	Cast iron GG25	Titanium GR5
Z	1	2	3
Depth (mm)	2	4.5	10
n (rev/min)	30'000	11'000	3'200
Vc (m/min)	72	112	65
Fz (mm)	0.006	0.08	0.06
Vf (mm/min)	168	1'760	573
Cyclus time	19 sec.	10 sec.	58 sec.
With finishing pass when up-milling*	yes	no	yes

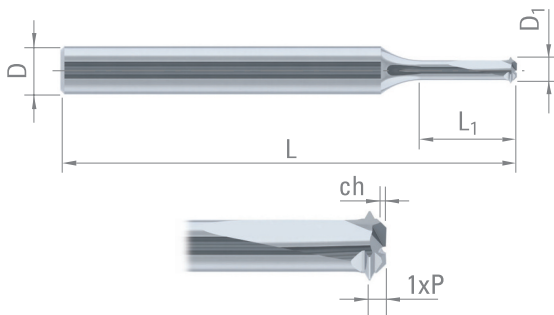
* see next page for machining method

DIXI 1740



DRILLING THREAD WHIRLER

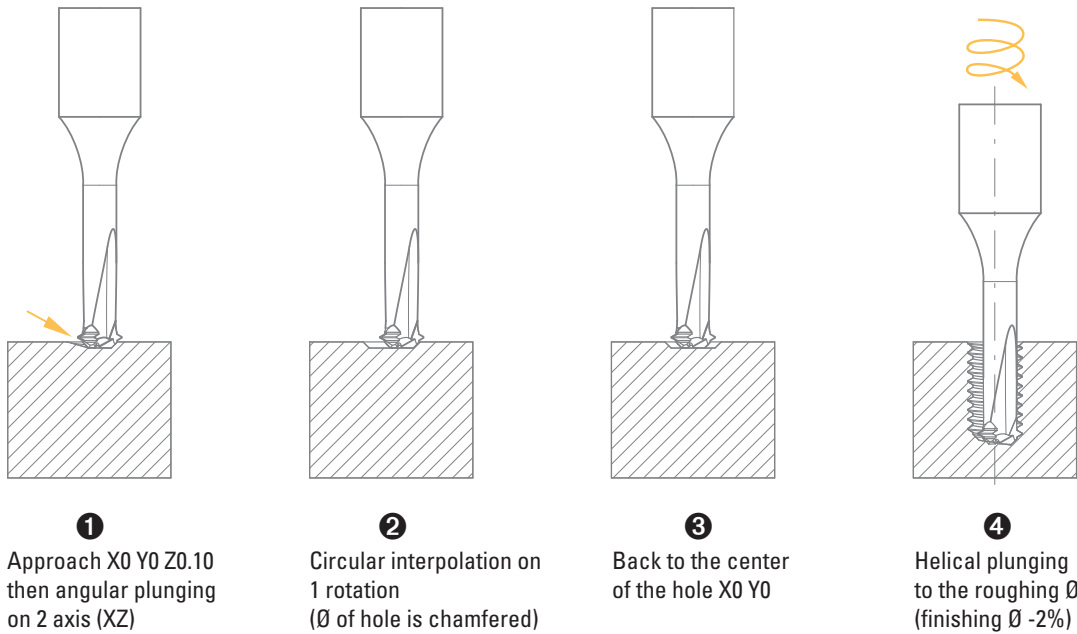
Z = 1-3



Steel < 600Mpa	Steel > 600Mpa	High alloyed steel	DUPLEX stainless steel	Cast iron
Refractory alloy	Titanium, titanium alloy	Cu alloy Silver Gold	Cu alloy difficult to machine	Al
Graphite	Plastic			

Nominal Ø	Pitch	D ₁	ch	L ₁	D _{h6}	L	Z	CARBIDE	CUTINOX
M 0.80	0.20	0.60	0.10	2.4	3	38	1	<input type="checkbox"/>	<input checked="" type="checkbox"/>
M 0.90	0.225	0.66	0.12	2.7	3	38	1	<input type="checkbox"/>	<input checked="" type="checkbox"/>
M 1.00	0.25	0.73	0.15	3.0	3	38	1	<input type="checkbox"/>	<input checked="" type="checkbox"/>
M 1.20	0.25	0.92	0.15	3.6	3	38	1	<input type="checkbox"/>	<input checked="" type="checkbox"/>
M 1.40	0.30	1.05	0.19	4.2	3	38	1	<input type="checkbox"/>	<input checked="" type="checkbox"/>
M 1.60	0.35	1.21	0.22	4.8	3	38	1	<input type="checkbox"/>	<input checked="" type="checkbox"/>
M 2.00	0.40	1.55	0.25	6.0	3	38	2	<input type="checkbox"/>	<input checked="" type="checkbox"/>
M 2.50	0.45	2.00	0.29	7.5	3	38	2	<input type="checkbox"/>	<input checked="" type="checkbox"/>
M 3.00	0.50	2.44	0.33	9.0	6	57	2	<input type="checkbox"/>	<input checked="" type="checkbox"/>
M 4.00	0.70	3.20	0.45	12.0	6	57	2	<input type="checkbox"/>	<input checked="" type="checkbox"/>
M 5.00	0.80	4.00	0.53	15.0	6	57	2	<input type="checkbox"/>	<input checked="" type="checkbox"/>
M 6.00	1.00	4.85	0.65	18.0	6	57	3	<input type="checkbox"/>	<input checked="" type="checkbox"/>
M 8.00	1.25	6.50	0.80	24.0	8	75	3	<input type="checkbox"/>	<input checked="" type="checkbox"/>
M 10.00	1.50	7.90	1.00	30.0	8	75	3	<input type="checkbox"/>	<input checked="" type="checkbox"/>

Example for easy to machine materials (brass, aluminium, lead alloyed steel, etc...).



Example for difficult to machine materials (titanium, stainless steel).

