



# Practical Test on Toolox44 – Chiron DRILLING-TAPPING 2011



Herbert Amon  
October-2011

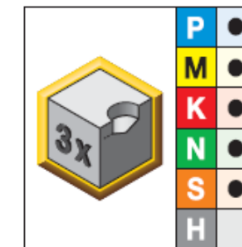


## Solid Carbide Drill, 3 x D, 5 x D, 8 x D

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:

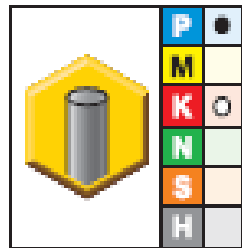
- Workpiece  
 -drilling blind hole

Test plate Toolox44  
 depth 12,0 mm

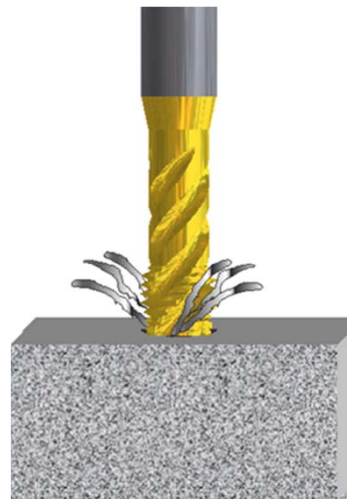
### Result:

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

## Solid Carbide Tap

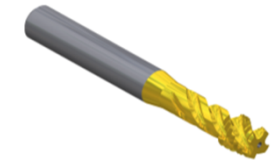


KC7542



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