

DrillLine



DRILLFORCE MEISTER

www.tungaloy.com/it

Tungaloy Report No. 87S1-I

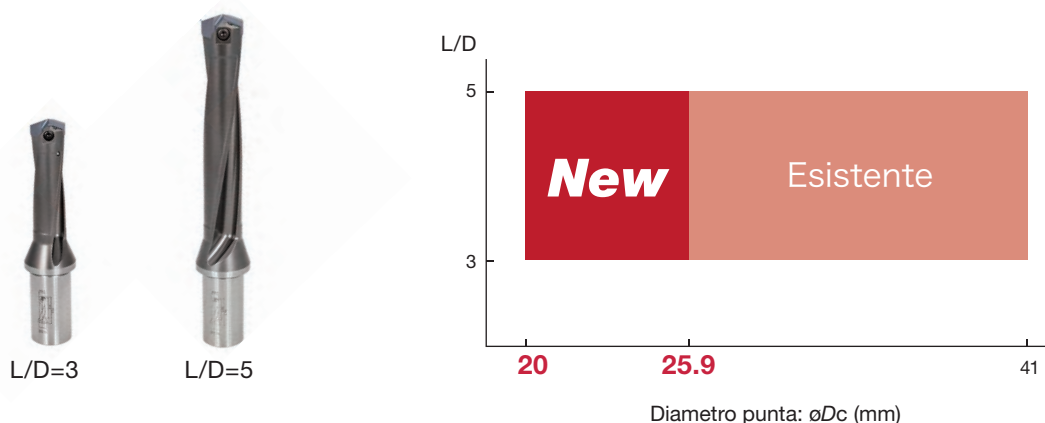
Espansione gamma dei diametri della linea
DrillForceMeister - **ø20 - 25.9 mm**



INDUSTRY 4.0
FEED the SPEED!

Espansione gamma da $\varnothing 20$ a $\varnothing 25.9$ mm

Le nuove cuspidi sono rivestite con il grado PVD AH725, resistente all'usura e applicabile in una vasta gamma di materiali.



Sistema di bloccaggio esclusivo

Facile, veloce e allo stesso tempo rigido ed affidabile garantisce un'eccellente qualità del foro e una durata elevata.

L'ampia area di contatto tra cuspidi e sede garantisce un bloccaggio affidabile in grado di contrastare le forze radiali che si innescano durante il taglio.



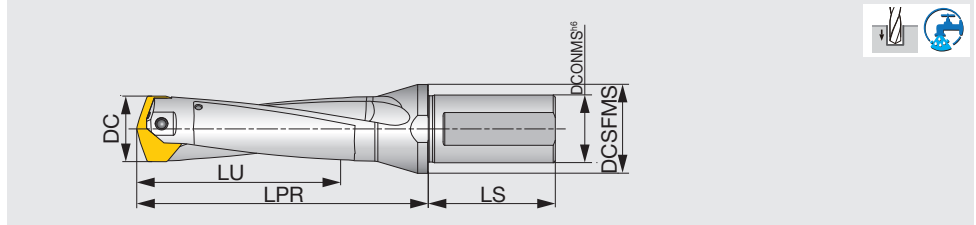
Esempi tipici di lavorazioni sbilanciate

Uscita inclinata	Ingresso inclinato	Superficie sottile	Fori incrociati

TIS L/D=3

Punta a cuspidi intercambiabile

New



Denominazione	DC	DCONMS	DCSFMS	LU	LPR	LS	Dimensione sede	Cuspide
TIS200F25-3	20 - 20.9	25	32	63.1	92.1	56	20	SMP20*
TIS210F25-3	21 - 21.9	25	32	66.3	95.1	56	21	SMP21*
TIS220F25-3	22 - 22.9	25	32	69.4	98.4	56	22	SMP22*
TIS230F25-3	23 - 23.9	25	32	72.6	101.4	56	23	SMP23*
TIS240F32-3	24 - 24.9	32	40	75.7	110.7	60	24	SMP24*
TIS250F32-3	25 - 25.9	32	40	78.9	113.7	60	25	SMP25*

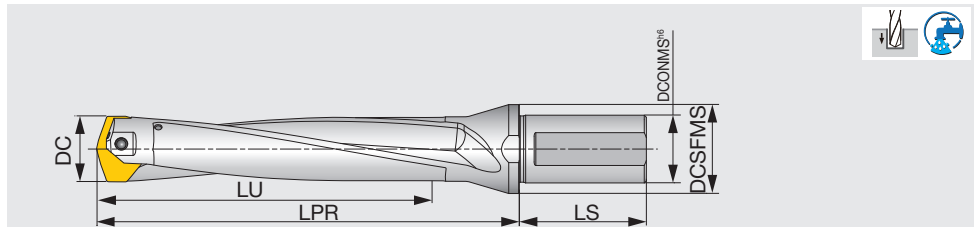
Diametro punta	Tolleranza diametro foro*
ø20 - ø25.9	+0.05 / 0

* Valore indicativo.

TIS L/D=5

Punta a cuspidi intercambiabile

New



Denominazione	DC	DCONMS	DCSFMS	LU	LPR	LS	Dimensione sede	Cuspide
TIS200F25-5	20 - 20.9	25	32	103.1	132.1	56	20	SMP20*
TIS210F25-5	21 - 21.9	25	32	108.3	137.1	56	21	SMP21*
TIS220F25-5	22 - 22.9	25	32	113.4	142.4	56	22	SMP22*
TIS230F25-5	23 - 23.9	25	32	118.6	147.4	56	23	SMP23*
TIS240F32-5	24 - 24.9	32	40	123.7	158.7	60	24	SMP24*
TIS250F32-5	25 - 25.9	32	40	128.9	163.7	60	25	SMP25*

Diametro punta	Tolleranza diametro foro*
ø20 - ø25.9	+0.08 / 0

* Valore indicativo.

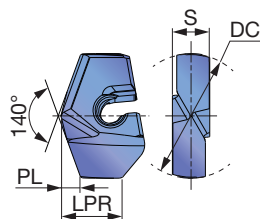
PARTI DI RICAMBIO



Denominazione	Vite di fissaggio	Chiave	
		Stelo Torx	Manico
TIS200F25-*	TS40178D25	BLDT20/S7	H-TB2W
TIS210F25-*	TS40178D25	BLDT20/S7	H-TB2W
TIS220F25-*	TS40198D28	BLDT20/S7	H-TB2W
TIS230F25-*	TS40198D28	BLDT20/S7	H-TB2W
TIS240F32-*	TS40210D3	BLDT20/S7	H-TB2W
TIS250F32-*	TS40210D3	BLDT20/S7	H-TB2W

SMP

New



Diametro punta	Tolleranza diametro cuspidi
ø20 - ø25.9	-0.006 / -0.026

P	Acciai	★
M	Acciai inossidabili	★
K	Ghisa	★
N	Non ferrosi	☆
S	Superleghe	★
H	Materiali duri	★

★ : Prima scelta
☆ : In alternativa

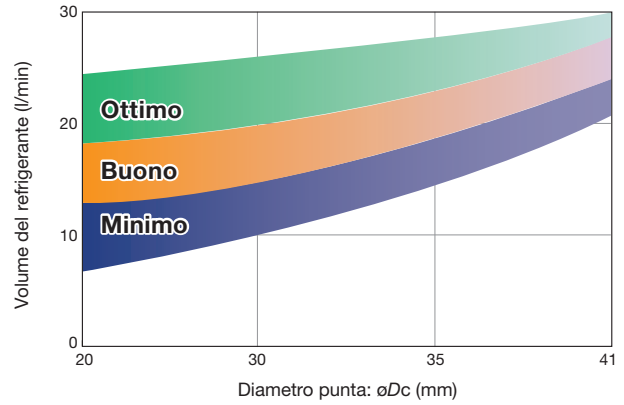
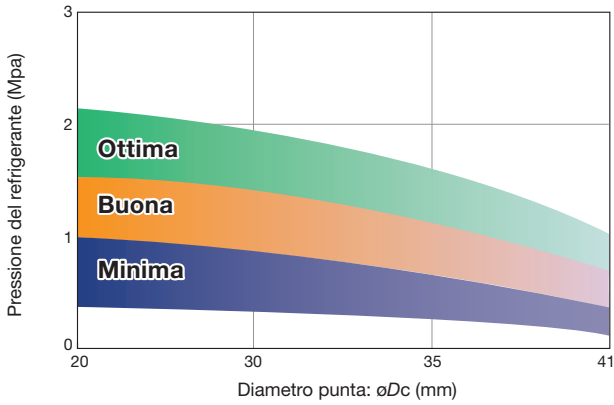
Denominazione	DC	S	Rivestito								LPR	PL	Dimensione sede	Corpo punta
			AH725											
SMP200	20	5.7	●								9.7	3.11	20	TIS200F25-*
SMP205	20.5	5.7	●								9.7	3.2	20	TIS200F25-*
SMP210	21	5.7	●								9.7	3.29	21	TIS210F25-*
SMP215	21.5	5.7	●								9.7	3.38	21	TIS210F25-*
SMP220	22	6.2	●								10.5	3.42	22	TIS220F25-*
SMP223	22.3	6.2	●								10.5	3.47	22	TIS220F25-*
SMP225	22.5	6.2	●								10.5	3.51	22	TIS220F25-*
SMP230	23	6.2	●								10.5	3.6	23	TIS230F25-*
SMP235	23.5	6.2	●								10.5	3.69	23	TIS230F25-*
SMP240	24	6.7	●								10.8	3.73	24	TIS240F32-*
SMP245	24.5	6.7	●								10.8	3.82	24	TIS240F32-*
SMP247	24.7	6.7	●								10.8	3.86	24	TIS240F32-*
SMP250	25	6.7	●								10.8	3.91	25	TIS250F32-*
SMP255	25.5	6.7	●								10.8	4	25	TIS250F32-*

● : Standard stock

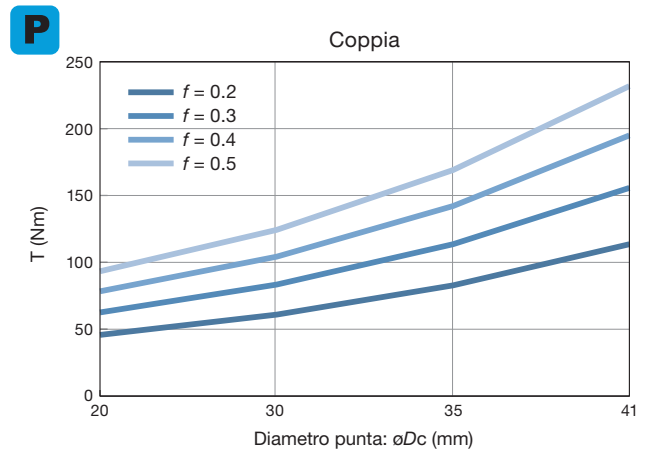
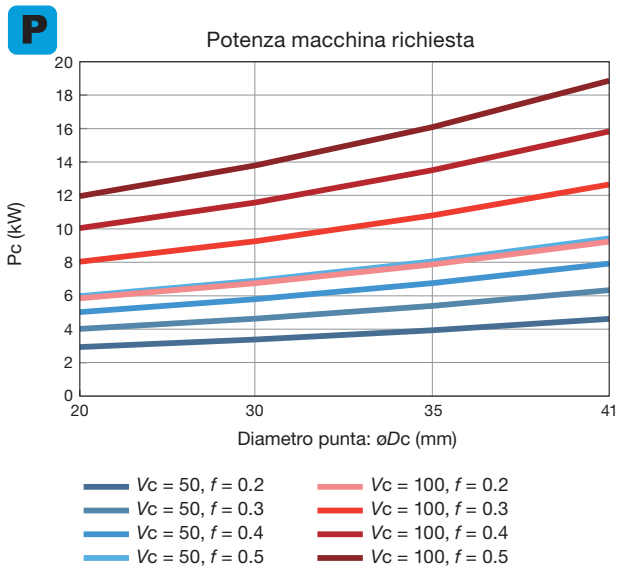
PARAMETRI DI TAGLIO CONSIGLIATI

ISO	Materiale da lavorare	Velocità di taglio Vc (m/min)	Avanzamento: f (mm/giro)
			øDc (mm)
P	Acciai a basso tenore di carbonio (C15, C20, ecc.)	80 - 140	0.2 - 0.5
	Acciai al carbonio e acciai legati (S55C / C55, SCM440 / 42CrMo4, ecc.)	80 - 130	0.2 - 0.5
	Acciai pre-tempra (NAK80, PX5, ecc.)	50 - 100	0.2 - 0.5
M	Acciai inossidabili (SUS304 / X5CrNi18-9, SUS316 / X5CrNiMo17-12-3, ecc.)	40 - 80	0.15 - 0.3
K	Ghisa grigia (FC250 / 250, FC300 / 300, ecc.)	80 - 180	0.25 - 0.55
	Ghisa sferoidale (400-15, 600-3, ecc.)	80 - 140	0.25 - 0.55
N	Materiali non ferrosi	100 - 200	0.4 - 0.6
S	Leghe resistenti al calore (Inconel718, ecc.)	30 - 60	0.1 - 0.2
	Leghe di titanio (Ti-6Al-4V, ecc.)	20 - 50	0.1 - 0.2
H	Materiali temprati	20 - 60	0.1 - 0.2

PRESSIONE E VOLUME DEL REFRIGERANTE CONSIGLIATI



POTENZA E COPPIA RICHIESTA



SOSTITUZIONE DELLA CUSPIDE

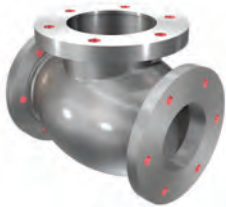
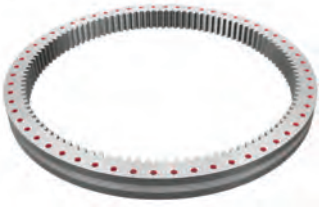
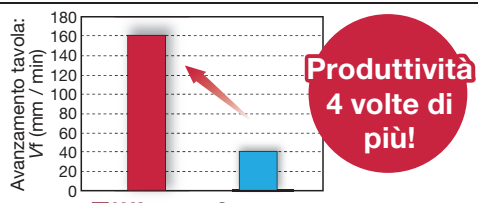
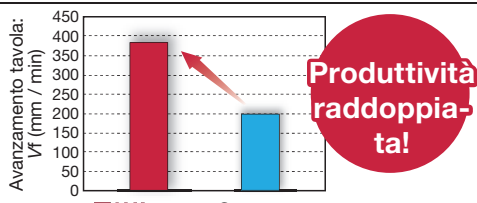
Allentare la vite, girandola 3-5 volte in senso antiorario



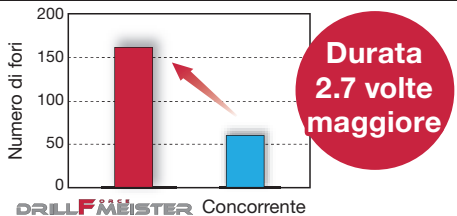
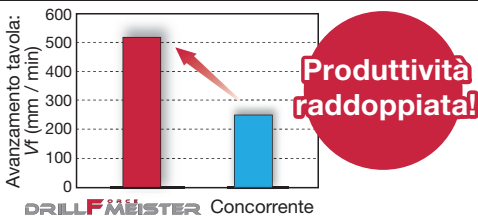
Non occorre rimuovere completamente la vite dalla sede per sostituire la cuspide



- Sostituire la vite quando non si allenta più facilmente

ESEMPI DI LAVORAZIONE

Pezzo		Valvola a saracinesca	Anello di rotazione	
Punta		TIS300F40-5	TIS330F40-5	
Cuspide		SMP300	SMP331	
Grado		AH725	AH725	
Materiale da lavorare		SUS304 / X5CrNi18-9	SCM440 / 42CrMo4	
		 M	 P	
Parametri di taglio	Velocità di taglio : V_c (mm/min)	60	100	
	Avanzamento : f (mm/giro)	0.25	0.4	
	Avanz. Tavola : V_f (mm)	160	380	
	Prof. foratura : H (mm)	120	150	
	Macchina	Centro di lavoro orizzontale	Centro di lavoro verticale	
Risultati				
	<p>Rispetto alla punta in HSS la produttività della DrillForceMeister è senza paragone.</p>		<p>Maggiore stabilità di lavorazione rispetto alla punta ad inserti.</p>	

Pezzo	Forcella	Piastra	
Punta	TIS320F40-5	TIS260F32-3	
Cuspide	SMP321	SMP260	
Grado	AH725	AH725	
	SCM440 / 42CrMo4	SN490B	
Materiale da lavorare	 M	 P	
Parametri di taglio	Velocità di taglio : V_c (m/min)	60	120
	Avanzamento : f (mm/giro)	0.15	0.35
	Avanz. Tavola : V_f (mm/min)	90	514
	Prof. foratura : H (mm)	43	22
	Macchina	Centro di lavoro orizzontale	Centro di lavoro verticale
Risultati	 <p>Durata 2.7 volte maggiore</p> <p>DRILLFORCEMEISTER Concorrente</p> <p>DrillForceMeister ha una vita utensile superiore rispetto alla punta concorrente.</p>	 <p>Produttività raddoppiata!</p> <p>DRILLFORCEMEISTER Concorrente</p> <p>DrillForceMeister è molto più produttiva della punta ad inserti.</p>	

Tungaloy Corporation (Head office)

11-1 Yoshima-Kogyodanchi
Iwaki-city, Fukushima 970-1144 Japan
Phone: +81-246-36-8501
Fax: +81-246-36-8542
www.tungaloy.co.jp

Tungaloy Italia S.r.l.

Via E. Andolfato 10
I-20126 Milano, Italy
Phone: +39-02-252012-1
Fax: +39-02-252012-65
www.tungaloy.com/it

Tungaloy America, Inc.

3726 N Ventura Drive
Arlington Heights, IL 60004, U.S.A.
Phone: +1-888-554-8394
Fax: +1-888-554-8392
www.tungaloy.com/us

Tungaloy Canada

432 Elgin St. Unit 3
Brantford, Ontario N3S 7P7, Canada
Phone: +1-519-758-5779
Fax: +1-519-758-5791
www.tungaloy.com/ca

Tungaloy de Mexico S.A.

C. Los Arellano 113,
Parque Industrial Siglo XXI
Aguascalientes, AGS, Mexico 20290
Phone: +52-449-929-5410
Fax: +52-449-929-5411
www.tungaloy.com/mx

Tungaloy do Brasil Ltda.

Avd. Independencia N4158 Residencial Flora
13280-000 Vinhedo, São Paulo, Brasil
Phone: +55-19-38262757
Fax: +55-19-38262757
www.tungaloy.com/br

Tungaloy Germany GmbH

An der Alten Ziegelei 1
D-40789 Monheim, Germany
Phone: +49-2173-90420-0
Fax: +49-2173-90420-19
www.tungaloy.com/de

Tungaloy France S.A.S.

ZA Courtaboeuf - Le Rio
1 rue de la Terre de feu
F-91952 Courtaboeuf Cedex, France
Phone: +33-1-6486-4300
Fax: +33-1-6907-7817
www.tungaloy.com/fr

Tungaloy Czech s.r.o.

Turanka 115
CZ-627 00 Brno, Czech Republic
Phone: +420-532 123 391
Fax: +420-532 123 392
www.tungaloy.com/cz

Tungaloy Ibérica S.L.

C/Miquel Servet, 43B, Nau 7
Pol. Ind. Bufalvent
ES-08243 Manresa (BCN), Spain
Phone: +34 93 113 1360
Fax: +34 93 876 2798
www.tungaloy.com/es

Tungaloy Scandinavia AB

Bultgatan 38
442 40 Kungälv, Sweden
Phone: +46-462119200
Fax: +46-462119207
www.tungaloy.com/se

Tungaloy Rus, LLC

Andropova avenue, h.18/7,
11 floor, office 3, 115432,
Moscow, Russia
Phone: +7-499-683-01-80
Fax: +7-499-683-01-81
www.tungaloy.com/ru

Tungaloy Polska Sp. z o.o.

Ul. Irysowa 1, 55-040 Bielany
Wrocławskie, Poland
Phone: +48 607 907 237
www.tungaloy.com/pl

Tungaloy U.K. Ltd

Gallan Park, Watling Street,
Cannock, WS110XG, UK
Phone: +44 121 4000 231
Fax: +44 121 270 9694
www.tungaloy.com/uk

Tungaloy Hungary Kft

Erzsébet királyné útja 125
H-1142 Budapest, Hungary
Phone: +36 1 781-6846
Fax: +36 1 781-6866
www.tungaloy.com/hu

Tungaloy Turkey

Serifali Mah.bayraktar Bulvari Kule Sk. No:26
34775 Umraniye / Istanbul / Turkey
Phone: +90 216 540 04 67
Fax: +90 216 540 04 87
www.tungaloy.com/tr

Tungaloy Benelux b.v.

Tjalk 70
NL-2411 NZ Bodegraven, Netherlands
Phone: +31 172 630 420
Fax: +31 172 630 429
www.tungaloy.com/nl

Tungaloy Croatia

Ulica bana Josipa Jelačića 87,
10430, Samobor, Croatia
Phone: +385 1 3326 604
Fax: +385 1 3327 683
www.tungaloy.com/hr

Tungaloy Cutting Tool (Shanghai) Co.,Ltd.

Rm No 401 No.88 Zhabei
Jiangchang No.3 Rd
Shanghai 200436, China
Phone: +86-21-3632-1880
Fax: +86-21-3621-1918
www.tungaloy.com/cn

Tungaloy Cutting Tools (Taiwan) Co.,Ltd.

9F, No.293, Zhongyang Rd,
Xinzhuang Dist, New Taipei City,
24251 Taiwan
Phone: +886-2-8521-9986
Fax: +886-2-8521-8935
www.tungaloy.com/tw

Tungaloy Cutting Tools (Thailand) Co.,Ltd.

Interlink tower 4th Fl.
1858/5-7 Bangna-Trad Road
km.5 Bangna, Bangna, Bangkok 10260
Thailand
Phone: +66-2-751-5711
Fax: +66-2-751-5715
www.tungaloy.com/th

Tungaloy Singapore (Pte.), Ltd.

62 Ubi Road 1, #06-11 Oxley BizHub 2
Singapore 408734
Phone: +65-6391-1833
Fax: +65-6299-4557
www.tungaloy.com/sg

Tungaloy Vietnam

LE04.38, Lexington Residence
67 Mai Chi Tho St., Dist. 2,
Ho Chi Minh City, Vietnam
Phone: +84-2837406660
www.tungaloy.com/sg

Tungaloy India Pvt. Ltd.

Indiabulls Finance Centre,
Unit # 902-A, 9th Floor,
Tower 1, Senapati Bapat Marg,
Elphinstone Road (West),
Mumbai-400013, India
Phone: +91-22-6124-8804
Fax: +91-22-6124-8899
www.tungaloy.com/in

Tungaloy Korea Co., Ltd

#1312, Byucksan Digital Valley 5-cha
Beotkkot-ro 244, Geumcheon-gu
153-788 Seoul, Korea
Phone: +82-2-2621-6161
Fax: +82-2-6393-8952
www.tungaloy.com/kr

Tungaloy Malaysia Sdn Bhd

50 K-2, Kelana Mall, Jalan SS6/14
Kelana Jaya, 47301
Petaling Jaya, Selangor Darul Ehsan
Malaysia
Phone: +603-7805-3222
Fax: +603-7804-8563
www.tungaloy.com/my

Tungaloy Australia Pty Ltd

Unit 68 1470 Ferntree Gully Road
Knoxfield 3180 Victoria, Australia
Phone: +61-3-9755-8147
Fax: +61-3-9755-6070
www.tungaloy.com/au

PT. Tungaloy Indonesia

Kompleks Grand Wisata Block AA-10 No.3-5
Cibitung
Bekasi 17510, Indonesia
Phone: +62-21-8261-5808
Fax: +62-21-8261-5809
www.tungaloy.com/id



www.tungaloy.com/it

Seguici su:

facebook.com/tungaloyjapan
twitter.com/tungaloyjapan
youtube.com/tungaloycorporation



AS9100 Certified
78006
2015.11.04
ISO14001 Certified
EC97J1123
1997.11.26

Distribuito da:



FIND US ON THE CLOUD!
machingcloud.com

