

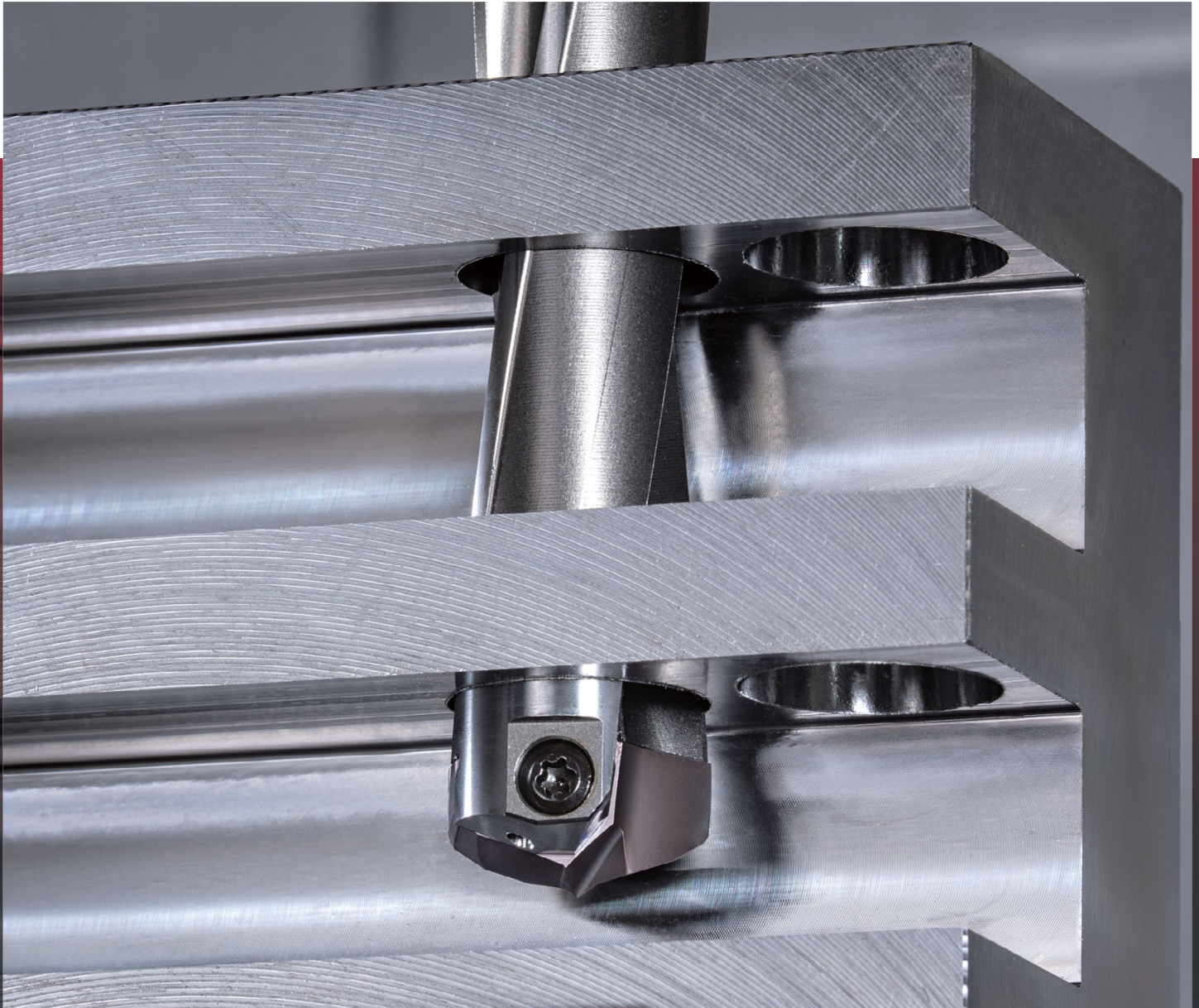


Exchangeable head drill

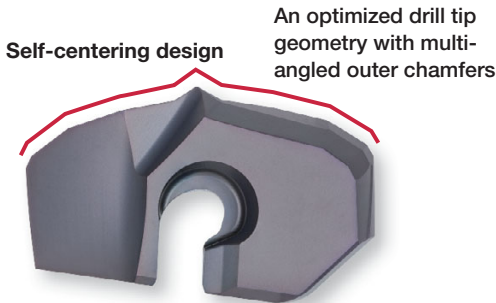
# DRILL **F**ORCE MEISTER

Tungaloy Report No. 509S5-US

## Introducing self-centering SMC heads for drilling long depths without pre-hole



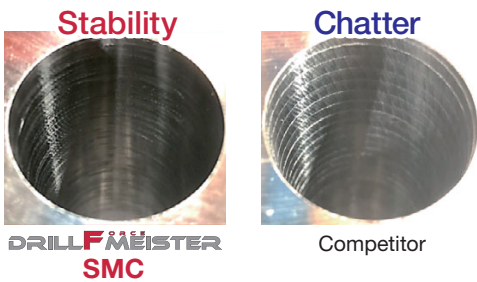
## SMC - High precision drilling



- Pre-drilling is unnecessary
- Outstanding **drilling stability**
- Sophisticated geometry prevents cutting edge fracture and burr formation on the workpiece

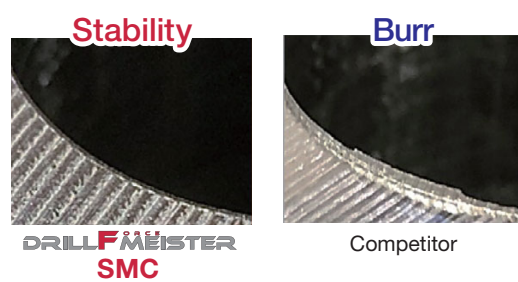
### Cutting performance

#### Hole quality



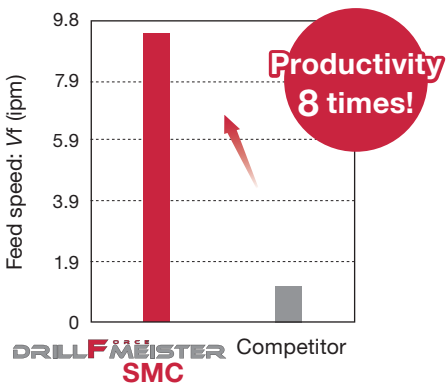
<b>P</b>	Tool	: $\phi 1.024"$ , L/D = 8
	Workpiece material	: Alloy steel
	Cutting speed	: $V_c = 328$ sfm
	Feed	: $f = 0.012$ ipr

#### Burr formation



<b>P</b>	Tool	: $\phi 1.024"$ , L/D = 8
	Workpiece material	: Low carbon steel
	Cutting speed	: $V_c = 328$ sfm
	Feed	: $f = 0.012$ ipr

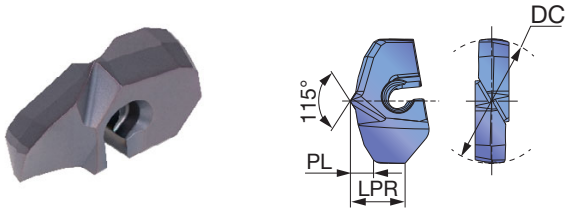
#### Stable long-overhang drilling with no need for pre-drilling



<b>K</b>	Tool	: TIS260F32-8
	Drill head	: SMC260
	Grade	: AH9130
	Workpiece material	: FCD600
	Cutting speed	: $V_c = 262$ sfm
	Feed	: $f = 0.010$ ipr
	Hole depth	: $H = 5.906"$
	Hole type	: Through holes
	Coolant	: Wet



## SMC High precision drilling



Tool diameter (in)	Head diameter tolerance
ø1.024 - ø1.299	+0.001 / 0

Tool diameter (mm)	Head diameter tolerance
ø26 - ø33	+0.025 / 0

<b>P</b>	Steel	★		
<b>M</b>	Stainless			
<b>K</b>	Cast iron	★		
<b>N</b>	Non-ferrous	☆		
<b>S</b>	Superalloys			
<b>H</b>	Hard materials	☆		

★ : First choice  
☆ : Second choice

Designation	DC (in)	DC (mm)	LPR (mm)	Coated		PL (mm)	Pocket size	Body
				AH9130				
SMC260	1.024	26	13.78	●		6.26	26	TIS260F32-*
SMC265	1.043	26.5	13.73	●		6.35	26	TIS260F32-*
SMC267	1.051	26.7	13.71	●		6.39	26	TIS260F32-*
SMC270	1.063	27	13.73	●		6.43	27	TIS270F32-*
SMC275	1.083	27.5	13.69	●		6.52	27	TIS270F32-*
SMC280	1.102	28	14.15	●		6.48	28	TIS280F32-*
SMC290	1.142	29	14.24	●		6.62	29	TIS290F32-*
SMC300	1.181	30	16.78	●		6.67	30	TIS300F32-*
SMC310	1.22	31	16.66	●		6.84	31	TIS310F32-*
SMC315	1.24	31.5	16.62	●		6.93	31	TIS310F32-*
SMC320	1.26	32	17.34	●		6.94	32	TIS320F40-*
SMC330	1.299	33	17.2	●		7.1	33	TIS330F40-*

● : New product  
Package quantity = 1 pc

## STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Cutting speed Vc (sfm)	Feed: f (ipr)
			ø1.024 - ø1.299
<b>P</b>	Low carbon steel 1015, 1020, etc.	262 - 459	0.008 - 0.02
	Carbon steel and alloy steel 1055, 4140, etc.	262 - 427	0.008 - 0.02
	Prehardened steel NAK80, PX5, etc.	164 - 328	0.008 - 0.02
<b>K</b>	Grey cast iron Class 25, Class 30, etc.	262 - 591	0.01 - 0.022
	Ductile cast iron 60-40-18, 80-55-06, etc.	262 - 459	0.01 - 0.022
<b>N</b>	Non ferrous materials	328 - 656	0.016 - 0.024
<b>H</b>	Hard materials	66 - 197	0.004 - 0.008

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