Expansion of Indexable carbide guide pads - Double chamfer & FH3125 grade
Deep Hole Drilling Tools

Long tool life and high performance are now possible with new combination of double chamfer & FH3125 grade

**For higher wear resistance**
- High wear-resistant grade

**First recommendation**
- Suitable for various workpiece materials
- Long tool life due to unique substrate and coating

**Fracture resistance priority**
- High fracture resistance
- First choice when using water-soluble coolant

**Advantages:**
- Promotes smooth entry into the bore
- Reduces the risk of guide pad rupture for extended tool life

**CUTTING PERFORMANCE**

**Drill** : TRLG20.01X1200-U04
**Workpiece material** : SNCM439H
**Cutting speed** : \( V_c = 100 \text{ m/min} \)
**Feed** : \( f = 0.15 \text{ mm/rev} \)
**Coolant** : Wet

Double chamfer significantly improved fracture resistance and has increased tool life by 2 times more than single chamfer.
ACCELERATED MACHINING

CARBIDE GUIDE PADS LINE UP

GP04, 05, 06, 07, 08, 10, 12, 14, 18

Guide pad grade and the timing for replacement

Guide pads are subject to wear, like inserts
- The guide pad has two sides.
- Each guide pad can be used on two sides. When the first corner wears out to 70% of the width, reverse the guide pad to use the second side.
- Replace with a new guide pad when the second side wears out.

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