





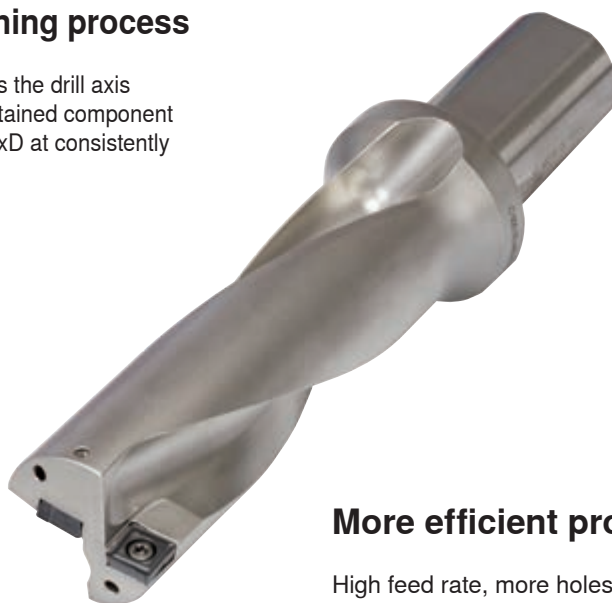
MaxiDrill 900

The new tooling concept for the entire application spectrum in the diameter range 14 mm to 63 mm and lengths up to 5xD. Both the peripheral and the central cutting edges are designed to have the same geometry, size, and grade which simplifies usage, avoids mixing up the inserts and increases productivity. The new grade CTPP430 is suitable for a wide range of drilling applications and is characterised by high wear resistance combined with excellent toughness in numerous applications. Suitable for drilling at high speeds and with interrupted cuts, drilling through cast skin and in difficult situations, drilling of convex or inclined surfaces. The materials that can be machined range from steel to

stainless steel, cast iron, non-ferrous metals and difficult to machine materials.

Higher stability of machining process

The radial force compensation prevents the drill axis from running off-centre, precisely maintained component tolerances when drilling depths up to 5xD at consistently high quality.



More efficient production

High feed rate, more holes possible. Optimal chip evacuation through asymmetric chip pocket design.

Easier to use

Same inserts, the peripheral and central cutting edge are in the same grade.

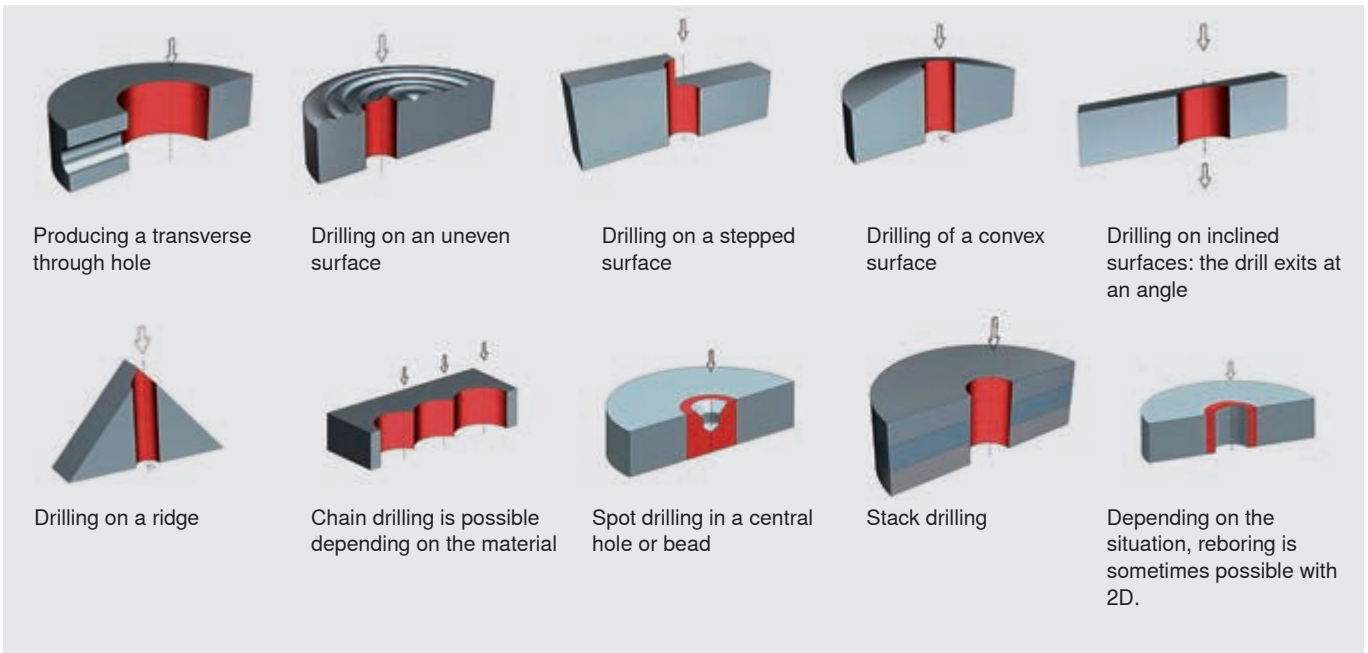


New tools

Insert	Diameter [mm]	Length of drill
SONT 04	14,0 – 15,5	2xD
SONT 05	16,0 – 17,5	2xD
SONT 06	18,0 – 20,5	2xD
SONT 07	21,0 – 23,0	2xD
SONT 08	24,0 – 27,0	2xD
SONT 09	28,0 – 32,0	2xD
SONT 10	33,0 – 36,0	2xD
SONT 12	37,0 – 41,0	2xD
SONT 13	42,0 – 46,0	2xD
SONT 15	47,0 – 54,0	2xD
SONT 17	55,0 – 63,0	2xD



Application



Universal application is possible

Wide application range combined with the most recent technology

Extended product range

New tools for drilling depths of $2xD$ in the diameter range 14 – 63 mm



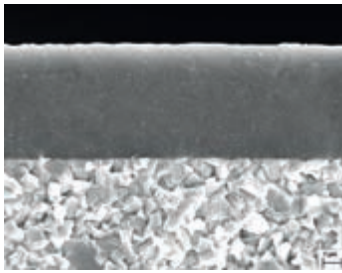


Chip grooves

MaxiDrill 900

CTPP430
SILVERSTAR™

HC-P30 | HC-M25 | HC-S25



Specification:

Composition: Co 9.0%; others 0.75%; WC balance | Grain size: 0.85 μm | Hardness: HV₃₀ 1590 | Coating specification: PVD TiAlN

Recommended application:

The universal high-performance grade for steel, austenitic steel and heat-resistant alloys.

Introduction

Tools and inserts for drilling

Chip groove	Material	Machining situation and stability				Machining type
		○	○	◐	◑	F / M / R
 $\gamma = 10^\circ$ 	Steel Stainless Heat-resistant	X	X			 M

- MasterGuide:**
- Steel
 - Stainless
 - Cast iron
 - Non-ferrous metals
 - Heat-resistant
 - Hard materials

- Main application
- Extended application

Machining situation and stability:

- excellent
- good
- acceptable
- difficult

Machining type:

- F** Fine machining
- M** Medium machining
- R** Rough machining