

Strator

perfor
outils coupants
cutting tools

THE HSS ALTERNATIVE TO CARBIDE DRILLS

CUTTING CONDITIONS

Material Group	N/mm2	Vc (m/min)	Feed per reverse (mm/tr)		
			Ø 2-5	Ø 5-10	Ø 10-13
A Unalloyed or low alloyed steels	200-400	80-100	0.04-0.06	0.08-0.12	0.20-0.30
B Heat treatable steels	400-700	50-70	0.04-0.06	0.08-0.12	0.20-0.30
C Heat treatable steels	700-950	40-60	0.02-0.03	0.05-0.07	0.12-0.18
D Heat treatable steels	950-1200	30-50	0.01-0.04	0.04-0.09	0.09-0.18
F Ferritic stainless steels	400-650	40-50	0.02-0.04	0.07-0.09	0.15-0.21
G Martensitic stainless steels	730-1150	40-50	0.01-0.03	0.05-0.07	0.14-0.18
H Austenitic stainless steels	440-780	20-30	0.02-0.04	0.05-0.09	0.18-0.21
I Cast Iron	100-400	80-120	0.04-0.06	0.08-0.12	0.20-0.30
J SG Iron	370-800	50-70	0.02-0.04	0.05-0.09	0.18-0.21
L Cast aluminium, silicon < 10%	250-610	200-300	0.02-0.04	0.05-0.09	0.18-0.21

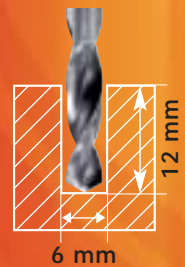
These recommendations should only be considered as a starting point.

This data is intended only as a guide, and is given without responsibility of the manufacturer or its agents.

APPLICATION EXAMPLE

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Ø : 6 mm
Profondeur : 12 mm
Vc : 90 m/min
N : 4770 RPM
f : 0.07 mm/tr
Vf : 477 mm/min
Emulsion: Soluble Oil 5%



Heat Treatable Steels



25 CrMo4
1.7218
1717CD 110

> Stopped at 500 Holes
> Drill's aspect is correct, good for 500 another holes.

TO ACHIEVE OPTIMUM RESULTS
USE HIGHER CUTTING SPEED

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NEW

NEW

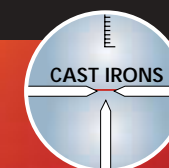


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THE HSS ALTERNATIVE TO CARBIDE DRILLS

TECHNICAL CHARACTERISTICS

HIGH PRODUCTIVITY

- > HIGHER SPEEDS
- > LONGER TOOL LIFE
- > BETTER HOLE SURFACE FINISH

HSS E5

DIN 1897

> High Rigidity

Extra short serie according to DIN 1897
Nuance HSS-E5 (AISI M35)



SHARPENING > Drilling Precision

DIN 1412 shape C

- A better quality of centering
- High stability
- Lower axial effort
- Provides better hole surface finish
- Greater precision of hole diameter



THE FLUTE > Chip Control

Flute NTA Type for a better chip removal

FUTURA®

COATING > Extended Lifetime

- High resistance to heat (< 900°C)
- Reduces friction
- Adapted to dry drilling
- For higher cutting conditions



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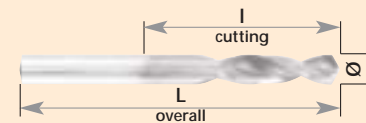


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THE RANGE

DIN 1897

7 14919 1



Ø mm	LENGTH	
	L overall	l cutting
2	38	12
2,1	38	12
2,2	40	13
2,25	40	13
2,3	40	13
2,4	43	14
2,5	43	14
2,6	43	14
2,7	46	16
2,75	46	16
2,8	46	16
2,9	46	16
3	46	16
3,1	49	18
3,2	49	18
3,25	49	18
3,3	49	18
3,4	52	20
3,5	52	20
3,6	52	20
3,7	52	20
3,75	52	20
3,8	55	22
3,9	55	22

Ø mm	LENGTH	
	L overall	l cutting
4	55	22
4,1	55	22
4,2	55	22
4,25	55	22
4,3	58	24
4,4	58	24
4,5	58	24
4,6	58	24
4,7	58	24
4,75	58	24
4,8	62	26
4,9	62	26
5	62	26
5,1	62	26
5,2	62	26
5,25	62	26
5,3	62	26
5,4	66	28
5,5	66	28
5,6	66	28
5,7	66	28
5,75	66	28
5,8	66	28
5,9	66	28

Ø mm	LENGTH	
	L overall	l cutting
6	66	28
6,1	70	31
6,2	70	31
6,3	70	31
6,4	70	31
6,5	70	31
6,6	70	31
6,7	70	31
6,8	74	34
6,9	74	34
7	74	34
7,2	74	34
7,5	74	34
7,8	79	37
8	79	37
8,5	84	40
9	84	40
9,5	84	40
10	89	43
10,2	89	43
10,5	89	43
11	95	47
11,5	95	47
12	102	51
12,5	102	51
13	102	51

