One tool for five materials

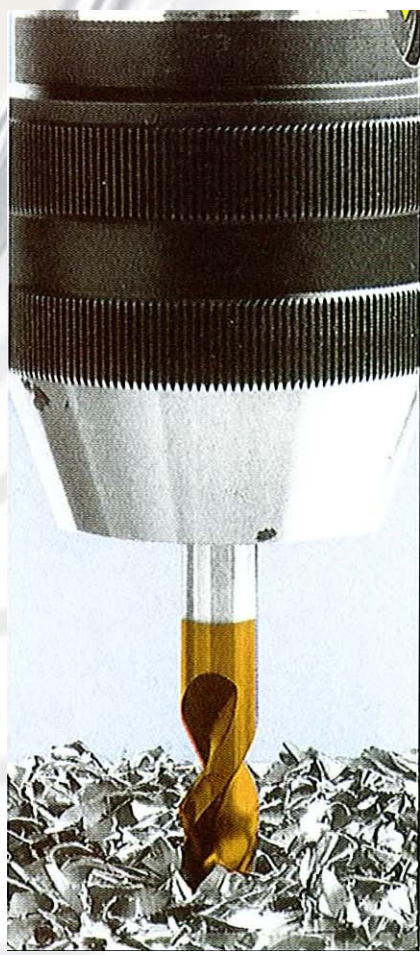
HSS-CO High performace ILIX Record Evolution VA coated twist drills especially developed for high performance drilling of **Stainless Steels.**

Appication Area: General Steel, Stainless Steel, Cast Iron,
Aluminum incl. Al-Si Alloyed and Copper

6134TN
DIN 1897
Short length

6229TN
DIN 338
Regular length

Product Advantages:
Tool material HSS-Co for extra wear resistance, toughness and hot hardness.
TIN coated surface for optimal chip removal.
Special point geometry for high capacity metal removal.
Self centering point
Unified shank to DIN 6535 HA for better tool stability



Customer Advantages:
Drilling depth to 3 – 7 x dia no pecks.
Universal application in 5 different material groups.
Higth penetration rates for shorter cycles and faster production.
Good tool security.

No more changes made to remainded of citting data.

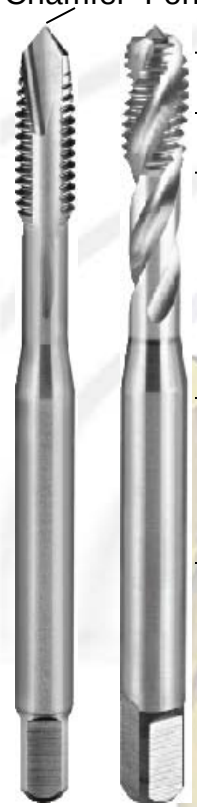
Cutting data:

Steel:	Vc = 50 m/min, feed row 12
Stainless steel:	Vc = 20 m/min, feed row 8
Aluminum a. Al-Si alloyed:	Vc = 80 m/min, feed row 12
Cast iron:	Vc = 45 m/min, feed row 10
Copper:	Vc = 60 m/min, feed row 5

One tool for five materials

HSS-CO ILIX Machine-Taps Type VA especially developed for high performance taping of **Stainless Steels.**

Appication Area: General Steel, Stainless Steel, Cast Iron, Aluminum incl. Al-Si Alloyed and Copper



Chamfer Form B / Through hole

Chamfer Form C / Blind hole

Optimised metal cutting geometry

Back taper thread

35 degs. Right hand helix

Tool material HSS-CO

6646 6661
DIN 371
and DIN 376

Product advantages

Tool material HSS-Co for extra wear resistance, toughness and hot hardness.
Processor optimised metal cutting to achieve a high performance.
Right hand helix 35 degs. for a better chip control at the blind hole

Customer atvantages

Short cycel time.
High cutting speed.
Long live time .
Thread true to gauge.
Ensure high efficiency.

Cutting data:

Steel:	Vc = 16 m/min,
Stainless steel:	Vc = 5 m/min,
Aluminum a. Al-Si alloyed:	Vc = 20 m/min,
Cast iron:	Vc = 20 m/min,
Copper:	Vc = 16 m/min,