NEW WHIRLING TOOLS
WITH COMPLETE PROFILE

DIXI polytool

FOR THREADS WITHOUT BURRS

DIXI 1737

From S0.50 to M3.00

DIXI 1737 C-TOP
DIXI 1737 DRYCUT

VIDEO 1737

swiss made since 1946

MADE SWISS

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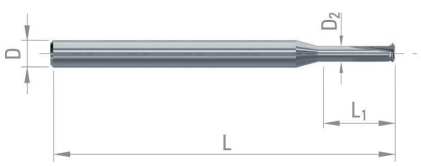
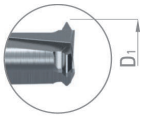
DIXI 1737

Z = 3

WHIRLING TOOL
COMPLETE PROFILE





Steel + Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Titanium, titanium alloy	
Refractory alloy	Alliage Cu Argent Or	Cu alloy difficult to machine	Al	Plastic	

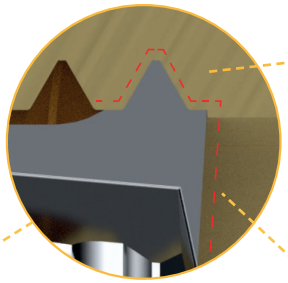
D nom.	Pitch	Drill. Ø	D_1	L_1	D_2	D_{h5}	L	CARBIDE	C-TOP	DRYCUT*
S0.50	0.125	0.38 - 0.40	0.37	0.85	0.22	3	38	378072	378089	378351
S0.60	0.15	0.46 - 0.49	0.44	1.25	0.26	3	38	378073	378090	378352
S0.70	0.175	0.54 - 0.57	0.52	1.80	0.31	3	38	378074	378091	378353
S0.80	0.20	0.61 - 0.64	0.59	2.30	0.35	3	38	378075	378092	378354
S0.90	0.225	0.69 - 0.73	0.67	2.50	0.40	3	38	378076	378093	378355
S1.00	0.25	0.76 - 0.80	0.74	2.80	0.44	3	38	378077	378094	378356
S1.20	0.25	0.96 - 1.00	0.94	3.40	0.64	3	38	378078	378095	378357
S1.40	0.30	1.12 - 1.16	1.08	4.00	0.72	3	38	378079	378096	378358

D nom.	Pitch	Drill. Ø	D_1	L_1	D_2	D_{h5}	L	CARBIDE	C-TOP	DRYCUT*
M1.00	0.25	0.73 - 0.77	0.71	2.80	0.37	3	38	378080	378097	378359
M1.20	0.25	0.93 - 0.97	0.91	3.40	0.57	3	38	378081	378098	378360
M1.40	0.30	1.08 - 1.12	1.05	4.00	0.64	3	38	378082	378099	378361
M1.60	0.35	1.23 - 1.28	1.19	4.50	0.72	3	38	378083	378100	378362
M1.80	0.35	1.43 - 1.48	1.39	5.10	0.91	3	38	378084	378101	378363
M2.00	0.40	1.57 - 1.62	1.53	5.60	0.99	3	38	378085	378102	378364
M2.20	0.45	1.72 - 1.78	1.67	6.20	1.06	3	38	378086	378103	378365
M2.50	0.45	2.02 - 2.08	1.97	7.00	1.36	3	38	378087	378104	378366
M3.00	0.50	2.46 - 2.53	2.40	8.40	1.72	3	38	378088	378105	378367

*For non-ferrous materials

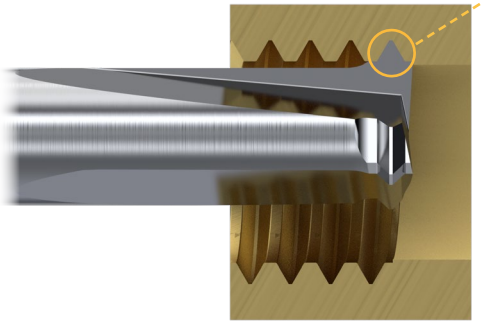
APPLICATION EXAMPLE

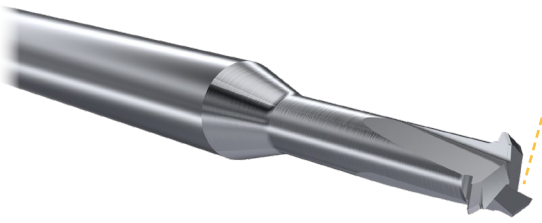
Material : Titanium grade 5
Thread : M1.00x0.25, depth = 2.25mm
n = 30'000 (Vc = 67 m/min)
Vf = 180 mm/min (fz = 0.002 mm/dts)
Lubrication : cutting oil
Machine : 3 axis machining centre



Complete profile

- ⊕ No burrs
- ⊕ Reduced cutting forces in comparison to two profiles





Front cutting

- ⊕ Correction of misalignments