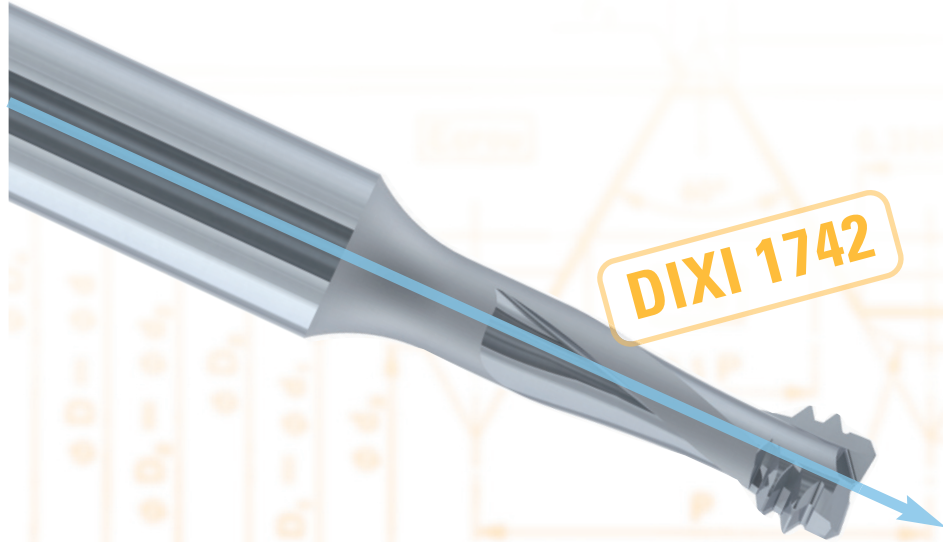


ENHANCE YOUR PRODUCTIVITY IN REDUCING THE NUMBER OF TOOLS



DRILLING THREAD WHIRLERS WITH THROUGH COOLANT



Dimensions in mm

| Ø = 4 | Ø ₁ = 4 | Ø ₂ = 4 | Ø ₃ = 4 | Ø ₄ = 4 | Ø ₅ = 4 | Ø ₆ = 4 | Ø ₇ = 4 | Ø ₈ = 4 | Ø ₉ = 4 |
|--------|--------------------|--------------------|--------------------|--------------------|--------------------|--------------------|--------------------|--------------------|--------------------|
| 1 0,20 | 0,080 | 0,200 | 0,222 | 0,250 | 0,275 | 0,300 | 0,325 | 0,350 | 0,375 |
| 1 0,25 | 0,090 | 0,250 | 0,264 | 0,292 | 0,320 | 0,350 | 0,375 | 0,400 | 0,425 |
| 1 0,30 | 0,100 | 0,300 | 0,304 | 0,332 | 0,360 | 0,390 | 0,420 | 0,450 | 0,475 |
| 1 0,35 | 0,110 | 0,350 | 0,354 | 0,382 | 0,410 | 0,440 | 0,470 | 0,500 | 0,525 |
| 1 0,40 | 0,120 | 0,400 | 0,404 | 0,432 | 0,460 | 0,490 | 0,520 | 0,550 | 0,575 |
| 1 0,45 | 0,130 | 0,450 | 0,454 | 0,482 | 0,510 | 0,540 | 0,570 | 0,600 | 0,625 |
| 1 0,50 | 0,140 | 0,500 | 0,504 | 0,532 | 0,560 | 0,590 | 0,620 | 0,650 | 0,675 |
| 1 0,55 | 0,150 | 0,550 | 0,554 | 0,582 | 0,610 | 0,640 | 0,670 | 0,700 | 0,725 |
| 1 0,60 | 0,160 | 0,600 | 0,604 | 0,632 | 0,660 | 0,690 | 0,720 | 0,750 | 0,775 |
| 1 0,65 | 0,170 | 0,650 | 0,654 | 0,682 | 0,710 | 0,740 | 0,770 | 0,800 | 0,825 |

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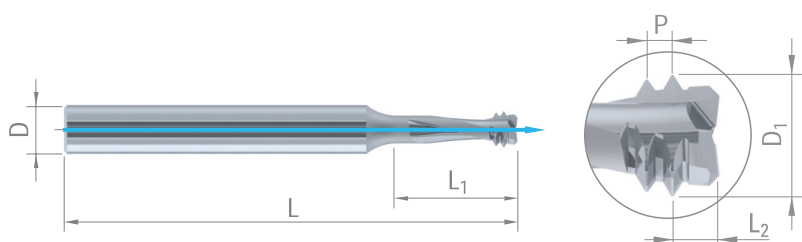
swiss
made



DIXI 1742

DRILLING THREAD WHIRLERS
WITH THROUGH COOLANT

Z = 2



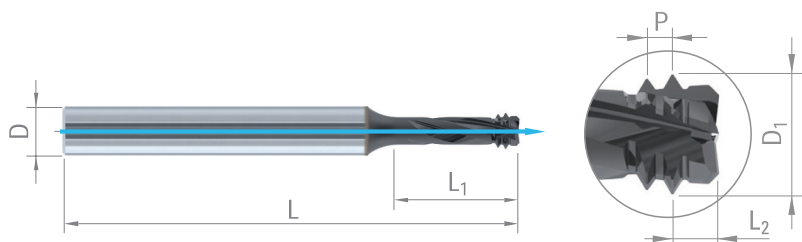
| | | | | |
|----------------------------|----------------------------------|----|----------|---------|
| Cu alloy Silver Gold | Cu alloy difficult to machine | Al | Graphite | Plastic |
|----------------------------|----------------------------------|----|----------|---------|

| D nom. | Pitch | D ₁ | L ₁ | L ₂ | D _{h5} | L | DAC |
|---------|-------|----------------|----------------|----------------|-----------------|-----|--------|
| M 5.00 | 0.80 | 4.00 | 12.5 | 1.50 | 8 | 60 | 303475 |
| M 6.00 | 1.00 | 4.80 | 15.0 | 1.85 | 8 | 60 | 303476 |
| M 8.00 | 1.25 | 6.40 | 20.0 | 2.30 | 8 | 75 | 303477 |
| M 10.00 | 1.50 | 7.80 | 25.0 | 2.75 | 8 | 75 | 303478 |
| M 12.00 | 1.75 | 9.50 | 30.0 | 3.10 | 10 | 100 | 308709 |

DIXI 1744

DRILLING THREAD WHIRLERS
WITH THROUGH COOLANT

Z = 4



| | | | | |
|------------------|--------------------------|--------------------|------------------------|-----------|
| Steel + Pb | Low alloyed steel | High alloyed steel | DUPLEX stainless steel | Cast iron |
| Refractory alloy | Titanium, titanium alloy | | | |

| D nom. | Pitch | D ₁ | L ₁ | L ₂ | D _{h5} | L | CUTINOX |
|---------|-------|----------------|----------------|----------------|-----------------|-----|---------|
| M 5.00 | 0.80 | 4.00 | 12.5 | 1.50 | 8 | 60 | 303479 |
| M 6.00 | 1.00 | 4.80 | 15.0 | 1.85 | 8 | 60 | 303480 |
| M 8.00 | 1.25 | 6.40 | 20.0 | 2.30 | 8 | 75 | 303481 |
| M 10.00 | 1.50 | 7.80 | 25.0 | 2.75 | 8 | 75 | 303482 |
| M 12.00 | 1.75 | 9.50 | 30.0 | 3.10 | 10 | 100 | 308710 |

DIXI 1742 Cutting conditions

| | |
|-------------------|---------------------------------------------|
| Tool | M10x1.50 Ø7.80 Z=2 DAC |
| Material | Aluminium 6082 (Wr N.3.2315) |
| Vc | 235 m/min n 9'590 rev/min |
| Fz | 0.25 mm/tooth |
| Vf | 4'795 mm/min (1'055 mm/min to axis) |
| Depth | 20 mm (2xØ) |
| Strategy | Plunging (roughing) + upmilling (finishing) |
| Tool life | >2'000 ISO 6H without tool correction |
| Cycle time | 22 seconds |

DIXI 1744 Cutting conditions

| | |
|-------------------|---------------------------------------------|
| Tool | M10x1.50 Ø7.80 Z=4 CUTINOX |
| Material | Stainless steel 316L (Wr N.1.4435) |
| Vc | 90 m/min n 3'673 rev/min |
| Fz | 0.15 mm/tooth |
| Vf | 2'292 mm/min (485 mm/min to axis) |
| Depth | 20 mm (2xØ) |
| Strategy | Plunging (roughing) + upmilling (finishing) |
| Tool life | >1'000 ISO 6H without tool correction |
| Cycle time | 33 seconds |