

NEW TREND

WATCHMAKING ENGRAVING

ENGRAVING TOOLS

2/3 GRINDING

DIXI 7027

- **Sharp cutting edge**
- **Multiple purpose geometry**
- **DINAC coating for an optimal wear resistance**



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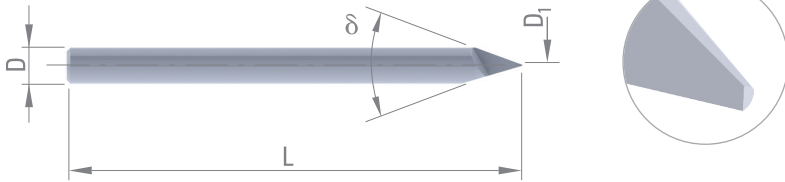
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www.dixipolytool.com

ENGRAVING TOOLS



Steel +Pb	Low alloyed steel	High alloyed steel	DUPLEX stainless steel	Titanium, titanium alloy
Cu alloy Silver Gold	Cu alloy difficult to machine	Alu	Plastic	

δ	D_{h5}	L	$D_{1 \pm 0.008}$	CARBIDE	DINAC
35°	3	38	0.05	326662	326682
			0.07	326663	326683
			0.08	326664	326684
			0.10	326665	326685
40°	3	38	0.05	326666	326686
			0.07	326667	326687
			0.08	326668	326688
			0.10	326669	326689
50°	3	38	0.15	326670	326690
			0.05	326671	326691
			0.07	326672	326692
			0.08	326673	326693
60°	3	38	0.10	326674	326694
			0.15	326675	326695
			0.05	326676	326696
			0.06	326677	326697
			0.07	326678	326698
60°	3	38	0.08	326679	326699
			0.10	326680	326700
			0.15	326681	326701

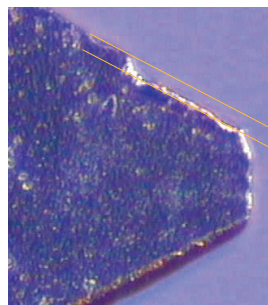
Application example

DIXI 7027 60° Ø 0.05 mm DINAC

Cutting conditions

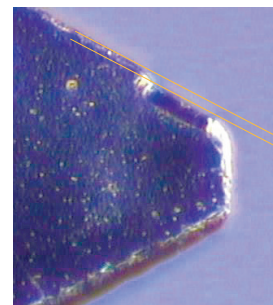
Material: stainless steel DIN 1.4435
 $n = 25'000$ rev/min
 $V_f = 75$ mm/min
 V_f diving = 15 mm/min
 $a_p = 0.05$ mm

Universal grade 40 min. machining



0.025 mm

Optimized grade 40 min. machining



0.01 mm