



DRY CUTTING PROFILE MACHINING



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// Advantages

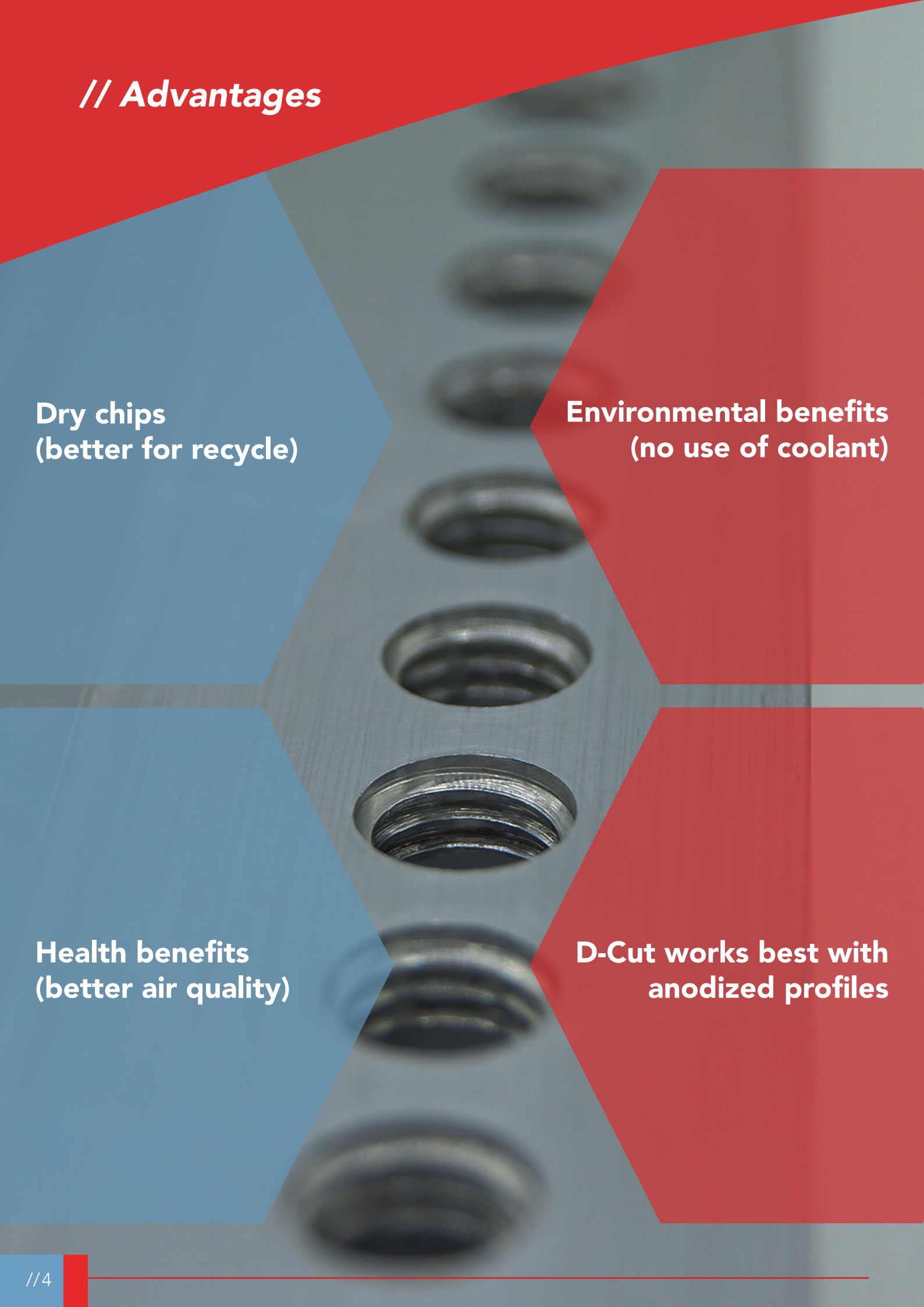
No use of coolant

**Better surface quality
(burr-free machining)**

**Tool life up to 5
times higher**

**Washing of the profiles
is not needed anymore**

// Advantages



**Dry chips
(better for recycle)**

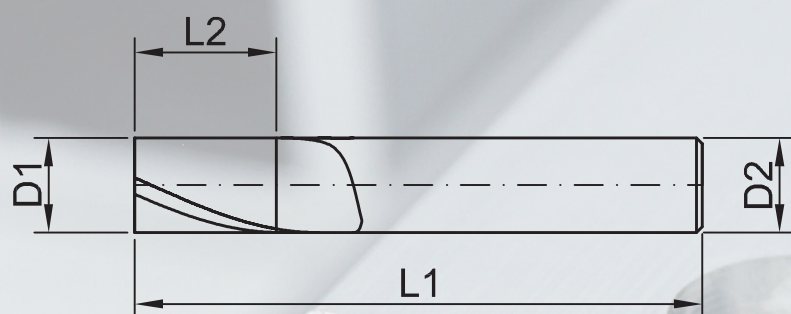
**Environmental benefits
(no use of coolant)**

**Health benefits
(better air quality)**

**D-Cut works best with
anodized profiles**

// Milling Tools

Solide carbide milling tool for dry cutting



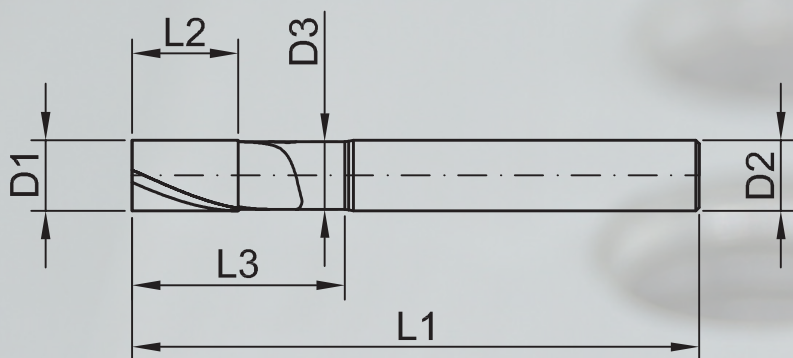
vc (m/min)
Cutting Speed
150-300

fz (mm)
Feed per tooth
0.07-0.25

Article Nr.	D1	D2	L1	L2	Z
109020	2	6	50	4	1
109030	3	6	50	4	1
109040	4	6	50	6	1
109050	5	6	50	7.5	1
109060	6	6	50	9	1
109070	7	8	50	10.5	1
109080	8	8	50	12	1
109090	9	10	60	13.5	1
109100	10	10	60	15	1
109110	11	12	73	16.5	1
109120	12	12	73	18	1
109130	13	14	75	19.5	1
109140	14	16	75	21	1
109150	15	16	82	22.5	1
109160	16	16	82	24	1
109170	17	18	84	25.5	1
109180	18	18	84	27	1

// Milling Tools

Solid carbide undercuted milling tool for dry cutting



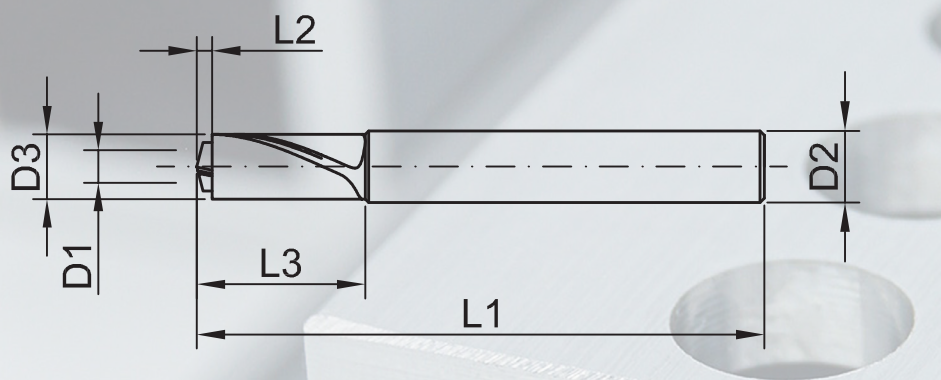
vc (m/min)
Cutting Speed
150-300

fz (mm)
Feed per tooth
0.07-0.25

ArticleNr.	D1	D2	D3	L1	L2	L3	Z
109020UC	2	6	2	50	4	10	1
109030UC	3	6	3	50	4	10	1
109040UC	4	6	4	50	6	12	1
109050UC	5	6	5	50	7.5	15	1
109060UC	6	6	6	50	9	17	1
109070UC	7	8	7	50	10.5	18	1
109080UC	8	8	7.5	50	12	18	1
109090UC	9	10	8.5	60	13.5	20	1
109100UC	10	10	9.5	60	15	20	1
109110UC	11	12	10.5	73	16.5	25	1
109120UC	12	12	11.5	73	18	25	1
109130UC	13	14	12.5	75	19.5	28	1
109140UC	14	16	13.5	75	21	30	1
109150UC	15	16	14.5	82	22.5	35	1
109160UC	16	16	15.5	82	24	35	1
109170UC	17	18	16.5	84	25.5	37	1
109180UC	18	18	17.5	84	27	37	1

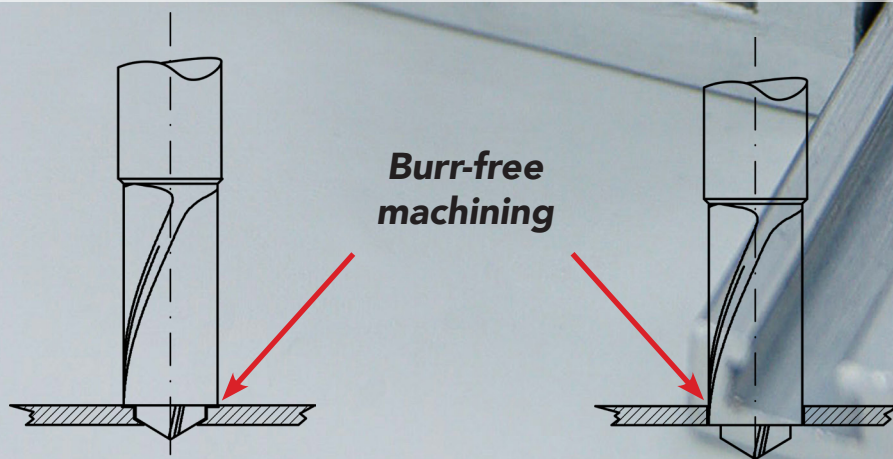
// Drilling Tools

Solid carbide stepdrill for burr free dry cutting



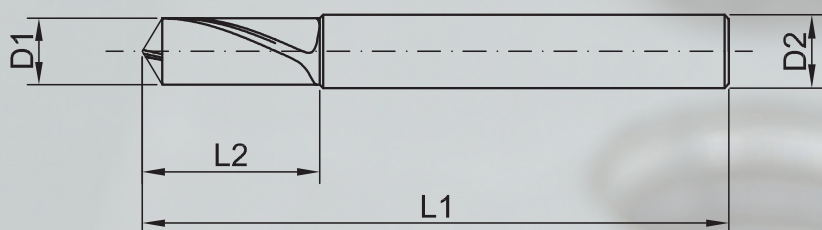
vc (m/min) Cutting Speed	fz (mm) Feed per tooth
300-400	0.07-0.3

Article Nr.	D1	D2	D3	L1	L2	L3
209020	1	6	2	50	2	10
209030	2	6	3	50	2	10
209040	3	6	4	60	2	12
209050	4	6	5	70	2	15
209060	5	6	6	70	2	17
209070	6	8	7	90	2	18
209080	7	8	8	100	2	18



// Drilling Tools

Solid carbide core drill for dry cutting



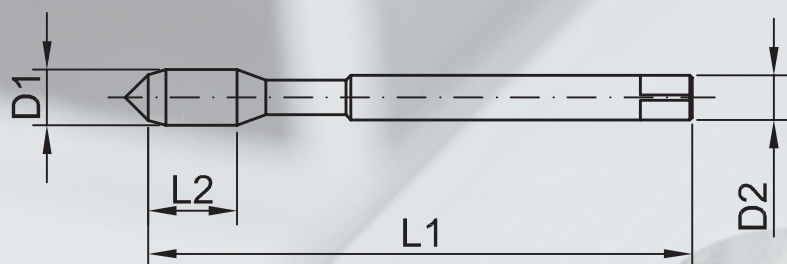
vc (m/min)
Cutting Speed
300-400

fz (mm)
Feed per tooth
0.07-0.3

Article Nr.	D1	D2	L1	L2	Gewinde
219025	2.5	6	50	10	M3
219033	3.3	6	50	10	M4
219042	4.2	6	60	12	M5
219050	5.0	6	70	15	M6
219068	6.8	8	70	17	M8
219085	8.5	10	90	18	M10
219102	10.2	12	100	18	M12

// Threading Tools

PM-HSS machine threading tool for dry cutting



vc (m/min)
Cutting Speed
25-35

Article Nr.	D1	D2	Core ϕ	L1	L2	□	P _{mm}
309030	M3	3.5	2.5	56	11	2.7	0.5
309040	M4	4.5	3.3	63	13	3.4	0.7
309050	M5	6	4.2	70	15	4.9	0.8
309060	M6	6	5.0	80	17	4.9	1
309080	M8	8	6.8	90	20	6.2	1.25
309100	M10	10	8.5	100	22	8	1.5
309120	M12	9	10.2	110	24	7	1.75



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