

TREPPANNING

DRILLS



Trepanning drills are ideal for drilling larger hole diameters in situations where machine power is restricted, as they consume less power compared to conventional drilling methods. Instead of machining the entire hole, only a peripheral ring is created. Consequently, this method is for through-hole applications.

As brocas de furação são ideais para perfurar diâmetros grandes em situações em que a potência da máquina é restrita, pois consomem menos energia em comparação com os métodos de perfuração convencionais. Na vez de maquinar todo o furo, é criado apenas um anel periférico. Consequentemente, este método é indicado para aplicações de furos passantes.

Las brocas de trepanación son ideales para perforar diámetros grandes en situaciones donde la potencia de la máquina está restringida, ya que consumen menos energía en comparación con los métodos de perforación convencionales. En lugar de mecanizar todo el agujero, solo se crea un anillo periférico. En consecuencia, este método es para aplicaciones de agujeros pasantes.

PND > page 420

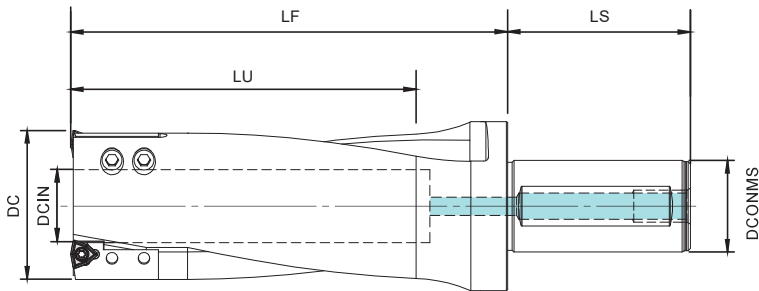
- > From DC 40,0mm to 110,0mm

De DC 40,0mm a 110,0mm | Desde DC 40,0mm hasta 110,0mm

- > Available in 2D

Disponível em 2D | Disponible en 2D





DCONMS	LS	BP / SP
32	70	PT - 1/4
40	80	PT - 1/4
50	100	PT - 1/4

Order code Código	Reference Referência Referencia	Dimensions Dimensões Dimensiones (mm)					Cartridge	Insert	Insert Screw	Torx key	Stock
		DC	DCIN	DCONMS	LU	LF					
184067500	PND 04032-2D	40,0	10,0	32	100	140	PNC 040055-I/O	WCKX 050308	P0300701	XT08	☐
184067600	PND 04540-2D	45,0	15,0	40	100	130	PNC 040055-I/O	WCKX 050308	P0300701	XT08	☐
184067700	PND 05040-2D	50,0	21,0	40	120	150	PNC 040055-I/O	WCKX 050308	P0300701	XT08	☐
184067800	PND 05540-2D	55,0	26,0	40	120	150	PNC 040055-I/O	WCKX 050308	P0300701	XT08	☐
184067900	PND 06040-2D	60,0	24,5	40	150	190	PNC 060110-I/O	WCKX 06T308	P0350903	XT15	☐
184068000	PND 06540-2D	65,0	30,5	40	150	190	PNC 060110-I/O	WCKX 06T308	P0350903	XT15	☐
184068100	PND 07040-2D	70,0	35,5	40	170	210	PNC 060110-I/O	WCKX 06T308	P0350903	XT15	☐
184068200	PND 07540-2D	75,0	40,5	40	170	210	PNC 060110-I/O	WCKX 06T308	P0350903	XT15	☐
184068300	PND 08040-2D	80,0	45,5	40	190	230	PNC 060110-I/O	WCKX 06T308	P0350903	XT15	☐
184068400	PND 08550-2D	85,0	50,5	50	190	230	PNC 060110-I/O	WCKX 06T308	P0350903	XT15	☐
184068500	PND 09050-2D	90,0	55,0	50	210	250	PNC 060110-I/O	WCKX 06T308	P0350903	XT15	☐
184068600	PND 09550-2D	95,0	60,0	50	210	250	PNC 060110-I/O	WCKX 06T308	P0350903	XT15	☐
184068700	PND 10050-2D	100,0	66,0	50	250	290	PNC 060110-I/O	WCKX 06T308	P0350903	XT15	☐
184068800	PND 11050-2D	110,0	76,0	50	250	290	PNC 060110-I/O	WCKX 06T308	P0350903	XT15	☐

 Stock item | Produto de stock | Itens de stock

☐ Available under request | Disponível sobre consulta | Disponible bajo consulta

CUTTING PARAMETERS AND ADJUSTMENTS

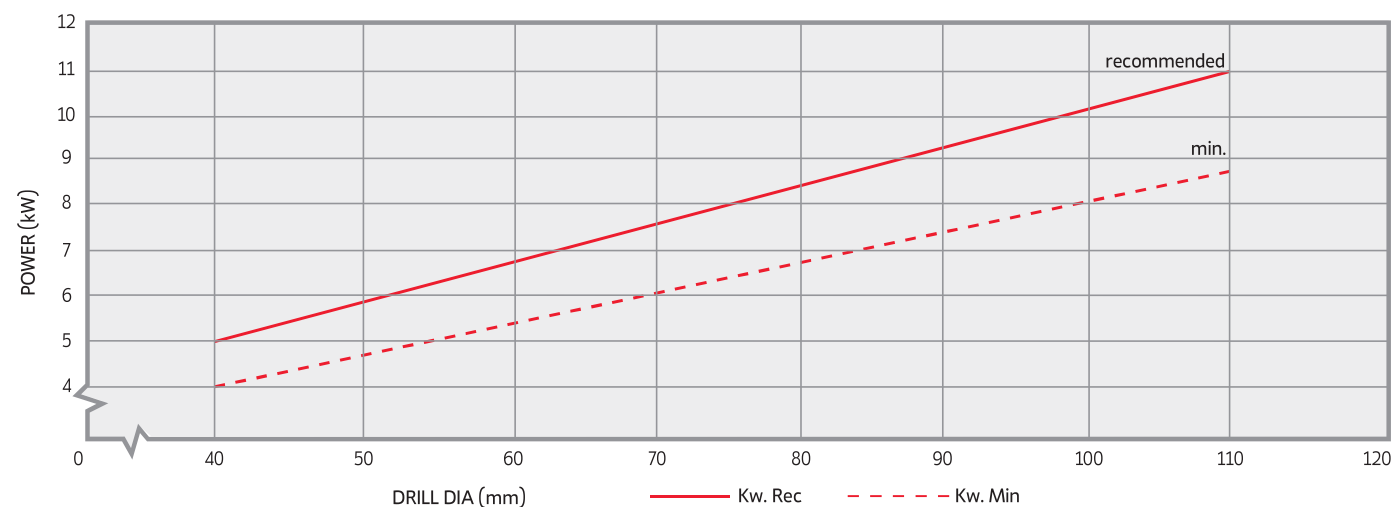
Parâmetros de corte e ajustes | Condiciones de corte y ajustes

B

RECOMMENDED SPEEDS AND FEEDS

ISO	Material Group Grupo Materiais Grupo Materiales	DC (mm)	Fn (mm/r)	Vc (m/min)
P	Unalloyed steel (-0,25%)	60-110	0,07-0,20	130-345
	Low-alloy steel (0,25%-)	60-110	0,10-0,20	100-210
	Low-alloy steel	60-110	0,10-0,20	90-200
	Steel casting	60-110	0,06-0,18	120-280
M	Stainless steel	60-110	0,10-0,20	100-240
K	Grey cast iron	60-110	0,14-0,26	105-280
	Cast iron with nodular cast	60-110	0,14-0,20	110-195
N	Aluminium forging alloys	60-110	0,12-0,22	250-400
	Copper and copper alloys	60-110	0,12-0,22	180-350

POWER REQUIREMENTS



• The cutting fluid quantity is measured at the cutting edge of the drill

COOLANT APPLICATION CHART

