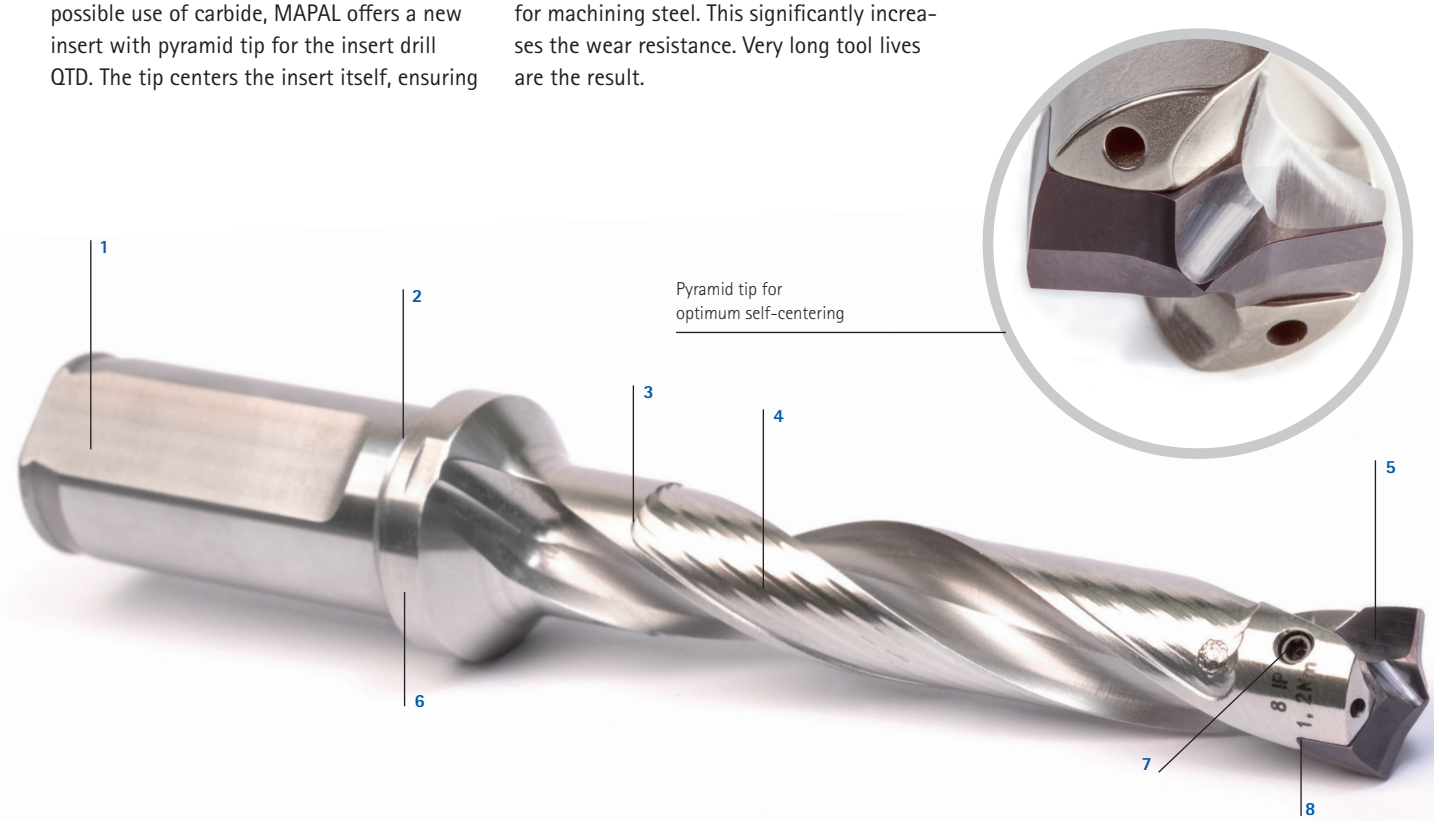
Your technology partner for cost-effective machining

QTD STEEL-PYRAMID

Stable insert holder, simple clamping system

QTD insert drill with pyramid tip

If steel is to be machined under unstable machining conditions with the lowest possible use of carbide, MAPAL offers a new insert with pyramid tip for the insert drill QTD. The tip centers the insert itself, ensuring safe entry into the bore. In addition, the coating of the new insert is specially tailored for machining steel. This significantly increases the wear resistance. Very long tool lives are the result.



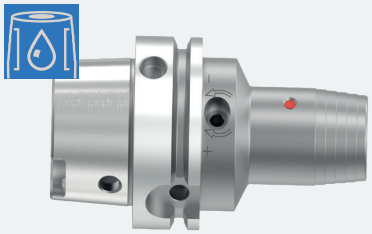
Tool features in detail

1 | Shank in accordance to ISO 9766
2 | Shank plan contact face
3 | Characteristic curve for maximum drilling depth
4 | Rear clearance for optimum chip removal
5 | Optimum power transmission through the embedded cutting insert
6 | Hardened steel holder with cylindrical shank
7 | Stable Torx Plus® clamping
8 | Prismatic insert seat for optimal centering of the insert

AT A GLANCE

- Useable in unstable machining conditions
- Universal application (steel, cast iron)
- Innovative point thinning
- Self-centering chisel edge
- Highest positional accuracy

Highest performance in combination with MAPAL chucks:



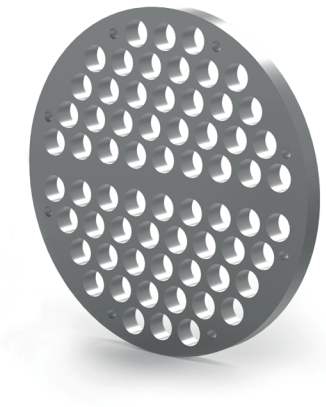
Mechanical chucks are used, these impress with their simple construction and the uncomplicated handling or hydraulic expansion chuck, which is characterized by their highest concentricity and clamping reliability at high speeds.

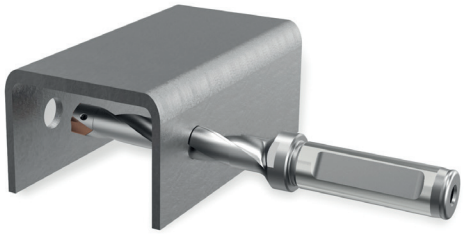
The chucks are available from stock for various machine interfaces, such as HSK, ISO taper, JIS-BT or CAT, available.

Practical test

Processing of sheet metal, heat exchangers / boiler plates, steel beams (T, U, ...).

Especially for machining with special demands on tool centring as well as for thin-walled components and unstable machining conditions.

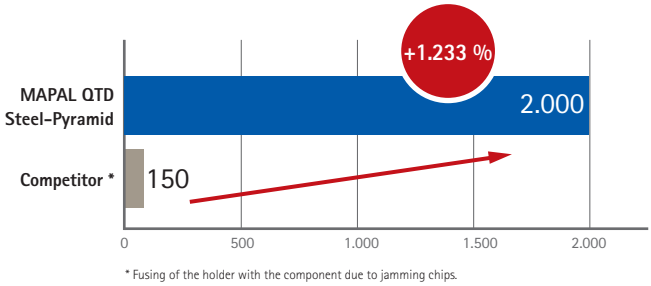




Machining data

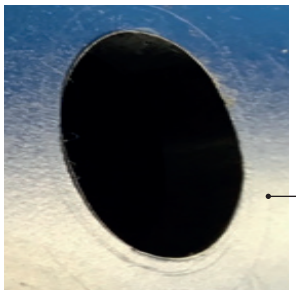
Tool:	ø 18 mm | 5xD
Chuck:	MillChuck
Cooling:	MMS internal cooling
l_B [mm]:	90
v_c [m/min]:	63
n [rpm]:	1.115
f_n [mm/U]:	0,3
v_f [mm/min]:	334

Number of bores

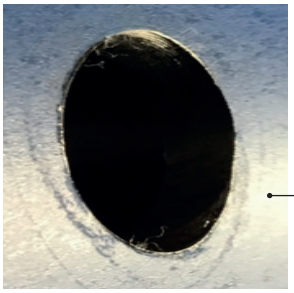


* Fusing of the holder with the component due to jamming chips.

Bore quality



MAPAL



Competitor

ADVANTAGES

- **Improved centering properties**
  through the pyramid tip
- **Flat point angle (160°)**
  for a burr-free bore exit
- **Long tool life**
  due to the tough substrate and robust geometry
- **Conservation of resources –**
  use of the carbide is limited to the cutting insert

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