holemaking SOLUTIONS www.alliedmachine.com

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INDEXABLE CARBIDE DRILLING





Handle interruptions with ease

solutions for challenging applications

ALLIED MACHINE & ENGINEERING

Allied Machine offers a wide range of drilling, boring, reaming, burnishing, and threading tools to lower your **cost-per-hole**.

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4TEX[°] Drill | *FEATURES* & **ADVANTAGES**

- Superior chip evacuation provided by the 2 twisted coolant holes
- Improved hole size from the increased holder rigidity
- ✓ Longer tool life provided by the 4-sided insert design

CUTTING

EDGES

- Optimal chip formation with ISO-specific insert geometry/coating combinations
- ✓ Competitive cycle times due to single effective cutting when using light duty machines



STABLE & EFFICIENT

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- The 2 twisted coolant holes allow the core to remain intact, making the core thicker and stronger.
- The enlarged dual coolant outlets increase the coolant volume, which improves the chip evacuation and improves the hole size.
- The flute space of the internal cutting edge side (where chips get stuck most often) is 1.6x larger than typical IC drills.





180°

Periphery Insert



Periphery edge chip formation:







Center Edge

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Center edge chip formation:

AVAILABLE *LENGTHS*





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4TEX[®] Drill | *FEATURES* & **ADVANTAGES**



LONGER TOOL LIFE



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4TEX[®] Drill | INTERRUPTED CUTS

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(DON'T) PARDON THE INTERRUPTION

The 4TEX Drill is the premium solution when the cut is interrupted. The indexable carbide insert design provides multiple points of stability, so the entire cutting edge does not require engagement while still providing the hole quality required.





QUICK TROUBLESHOOTING

Starting on Angled Surfaces

- Reduce entry feed by 20 50%
- Use lower rake geometry if insert chipping occurs

Angled Bore Exit

- Reduce entry feed by 50% on breakout
- Use tough insert and stable corner radius

Starting on Convex Surfaces

- Reduce entry feed by 50%
- Use lower rake geometry if insert chipping occurs

Drilling Through a Cross Hole

- Reduce feed rate by 50% if necessary
- Use good coolant flow and monitor chip packing
- Use lower rake geometry if insert chipping occurs

Chain Drilling

- Use good coolant flow
- Reduce feed rate by 50% for interrupted cut
- Use lower rake geometry if insert chipping occurs

THE PROOF IS IN THE CHIPS







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Allied Machine offers expert engineering support. Whether you need a quote, a test, or an application solution, a highly skilled and trained engineer is standing by, ready to help. email: **engineering.eu@alliedmachine.com**

CORRECTION ALLIED MACHINE BENGINEERING WOHLHAUPTER

Holemaking Solutions for Today's Manufacturing

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