The world's first replaceable tip drill with two cutting edges.

NEW

THE TOOL

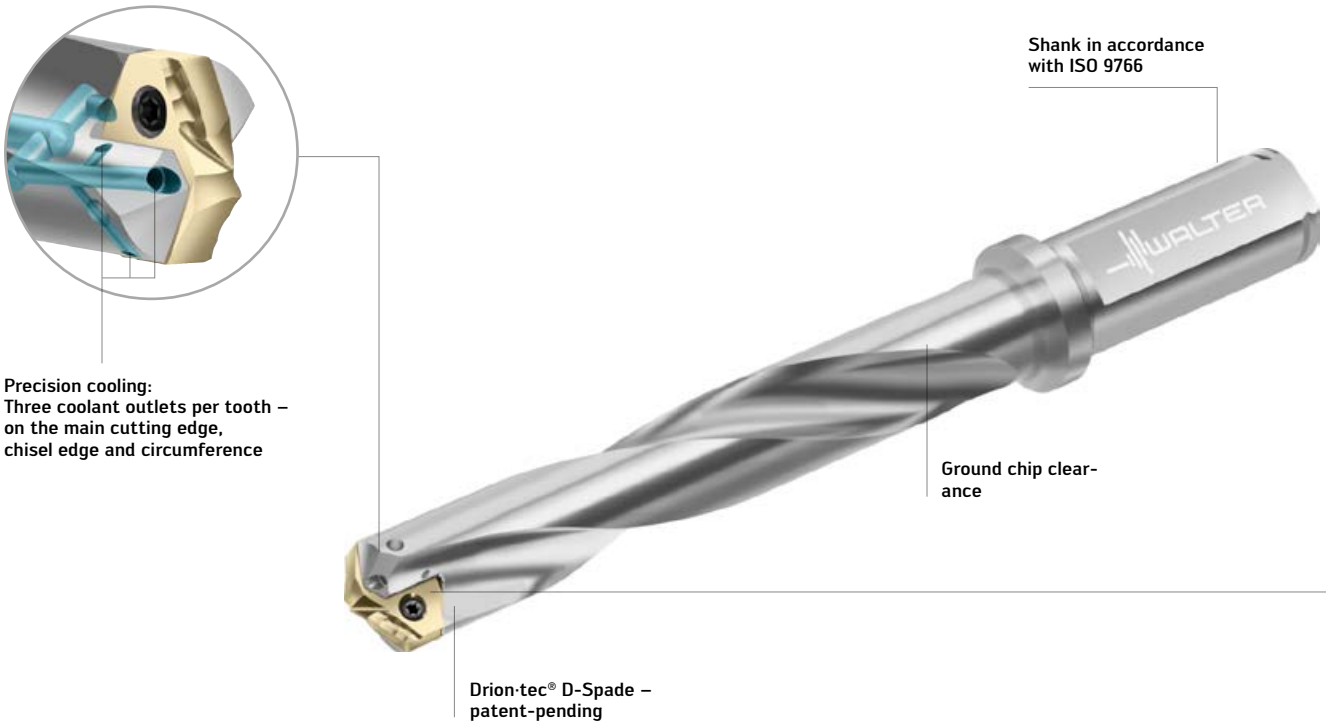
- Drion·tec® D-Spade D5142 double-sided replaceable tip drill
- Drilling depths: 3 and 5 × D_C
- Easy handling due to radial clamping screws
- Three coolant channels per tooth for maximum cooling
- Ground chip clearance for quick and reliable chip removal
- DS42 double-sided replaceable tip (symmetrical)
- Four margins for excellent surface quality
- F58 geometry
- Dia. 12–25.70 mm

THE GRADE

- WPP25: Fine-grained substrate and HIPIMS AlTiN coating for high wear resistance
- Gold-colored top layer for the best wear detection

THE APPLICATION

- Drilling blind holes and through holes from solid
- Suitable for stack drilling (laminate drilling)
- Primary application: ISO P
- Secondary application: ISO K and ISO N

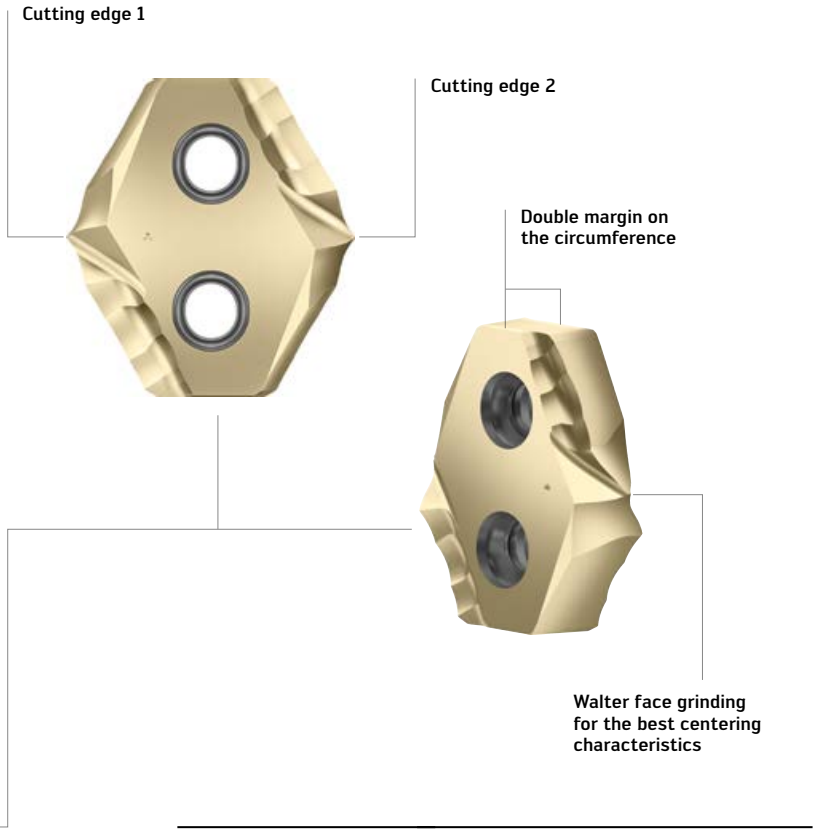


Drion·tec® replaceable tip drill

Fig.: D5142-05-18.00F20-G

THE TECHNOLOGY

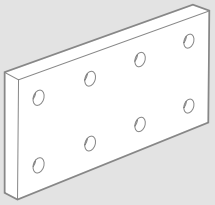
- Symmetrical Drion·tec® D-Spade design with two cutting edges per replaceable tip
- The flank face of the first cutting edge forms the pocket support surface of the second cutting edge
- Secure clamping due to two radial screws



Double-sided replaceable tip **Fig.: DS42-F58-18.00G WPP25**

APPLICATION EXAMPLE

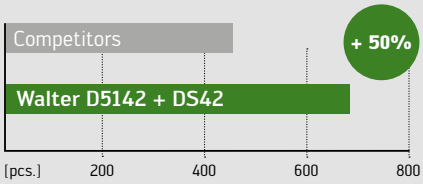
Connecting plate - holemaking: ø 17.5



Material:	S355
Strength:	520 N/mm²
Tool:	D5142-03-17.00F20-F
Indexable insert:	DS42-17.50F-F58 WPP25

Cutting data:	Competitors	**Walter D5142 + DS42**
v_c (m/min)	265	125
n (min^{-1})	4820	2274
f_n (mm)	0,07	**0,18**
v_f	313	**409**
Drilling depth (mm)	15	15
Cooling	Internal coolant	Internal coolant
Adaptors	SK50 Weldon ø 20 mm	SK50 Weldon ø 20 mm
Tool life quantity (pcs.)	448	**672**

Comparison:
Tool life quantity (per cutting edge)



POTENTIAL BENEFITS

- Maximum cost-efficiency due to two cutting edges per replaceable tip
- Excellent surfaces due to double margins on the circumference (within IT8)
- Precise holes due to the best centering characteristics
- Maximum process reliability due to optimum cooling effect and chip removal
- High level of stability due to two radial clamping screws