

TUNGALOY® INDEXABLE DRILLS & INSERTS

TUNGSIX-DRILL

Using WWMU 6 Cornered Inserts

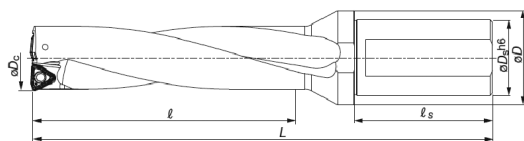
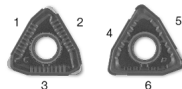
The Most Economical Drilling Solution In The Industry!



- Features double sided 6 cornered insert for drilling with superior performance
- One insert type for both inboard and outboard insert pockets
- Coolant thru design
- Twisted coolant holes improve coolant flow and chip evacuation
- Ideal for plane/slant surface, cross hole, plunging, boring and round surfaces
- Drill can be offset to drill larger diameter hole than drill diameter



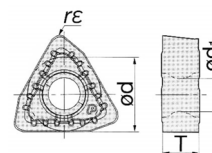
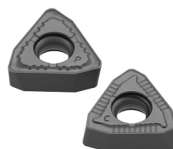
Central Peripheral



L/D	Dia Dc	Shank Ds	D	LOC l	Shank Len ls	OAL L	offset	Part Number	Drill Price	Uses Insert	Screw	Wrench
2xD	0.812	1.000	1.457	1.625	2.205	4.665	0.031	TO-6712015	\$442.10	WWMU05X205R-D	CSPB-2.2	IP-7D
	0.875	1.000	1.457	1.750	2.205	4.831	0.020	TO-6712016	\$466.30	WWMU05X205R-D	CSPB-2.2	IP-7D
	0.937	1.000	1.457	1.875	2.205	4.994	0.047	TO-6712017	\$466.30	WWMU060306R-D	CSPB-2.5	IP-8D
	1.000	1.000	1.457	2.000	2.205	5.161	0.026	TO-6712018	\$525.50	WWMU060306R-D	CSPB-2.5	IP-8D
	1.062	1.250	1.575	2.125	2.342	5.465	0.012	TO-6712019	\$525.50	WWMU060306R-D	CSPB-2.5	IP-8D
3xD	0.812	1.000	1.457	2.438	2.205	5.516	0.031	TO-6712021	\$466.30	WWMU05X205R-D	CSPB-2.2	IP-7D
	0.875	1.000	1.457	2.625	2.205	5.665	0.020	TO-6712022	\$489.20	WWMU05X205R-D	CSPB-2.2	IP-7D
	0.937	1.000	1.457	2.813	2.205	5.894	0.047	TO-6712023	\$489.20	WWMU060306R-D	CSPB-2.5	IP-8D
	1.000	1.000	1.457	3.000	2.205	6.122	0.028	TO-6712024	\$554.40	WWMU060306R-D	CSPB-2.5	IP-8D
	1.062	1.250	1.575	3.186	2.342	6.488	0.012	TO-6712025	\$554.40	WWMU060306R-D	CSPB-2.5	IP-8D

INSERTS FOR TUNGSIX-DRILL

- **AH6030 Grade:** Ideal for Steels, Stainless & Super Alloys
- Smooth insert surface prevents chip adhesion and improves chip control
- New PVD coating prevents fracture caused by chip welding.
- Exclusive carbide substrate with high fracture resistance



Designation	d	T	d1	re	Grade	Part Number	Price EA
WWMU05X205R-DS	0.228	0.094	0.098	0.020	AH6030	TO-6712012	\$13.50
WWMU060306R-DS	0.264	0.114	0.118	0.024	AH6030	TO-6712013	\$14.50

SPEEDS & FEEDS FOR TUNGSIX-DRILL

TUNGSIX-DRILL



ISO	Workpiece Material	Chip breaker	Grade	Cutting Speed Vc (sfm)	Feed: f (ipr) L/D=2,3 Dia: 0.787-1.063
P	Low carbon Steels (C,0.3) 70,1025 etc.	DS	AH6030	525-820	.0015-.004
	Carbon Steels (C>.3) 1045C,1055 etc.	DS	AH6030	260-820	.0015-.005
	Loy Alloy Steels SCM415 etc	DS	AH6030	525-820	.0015-.005
	Alloy steels 4140 etc	DS	AH6030	260-660	.002-.005
M	Stainless steels (Austenitic) 304,316 etc.	DS	AH6030	330-660	.0015-.004
	Stainless steels (Martensitic and ferritic) 430,416 etc.	DS	AH6030	330-660	.0015-.004
	Stainless steels (Precipitation Hardening) S17400 etc.	DS	AH6030	260-400	.0015-.003
K	Gray Cast Irons no. 250b etc.	DS	AH6030	260-660	.002-.005
	Ductile Cast Irons 700etc.	DS	AH6030	260-500	.002-.005
N	Aluminum Alloy	DS	AH6030	660-1310	.004-.007
S	High Temp Alloy Inconel 718 etc	DS	AH6030	60-200	.0015-.007
	Titanium Alloy Ti-6Al-4V etc	DS	AH6030	130-400	.0015-.007
H	Hardened Steel Over 40HRC	DS	AH6030	130-260	.0015-.007

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