

DR187-2023

KW07.2023

Positive Result „Krato-tec™ - Supreme DC180“



Tool:

Designation : **DC180-03-12.000A1**
Diameter : **12,0mm**
Coating : **WJ30EZ**
Drilling Depth : **12mm**

Work piece:

Designation : **Input shaft**
Material : **20MnCrS5**
"Material value" : **200 HB**
Hole Type : **Throughhole**

Machine:

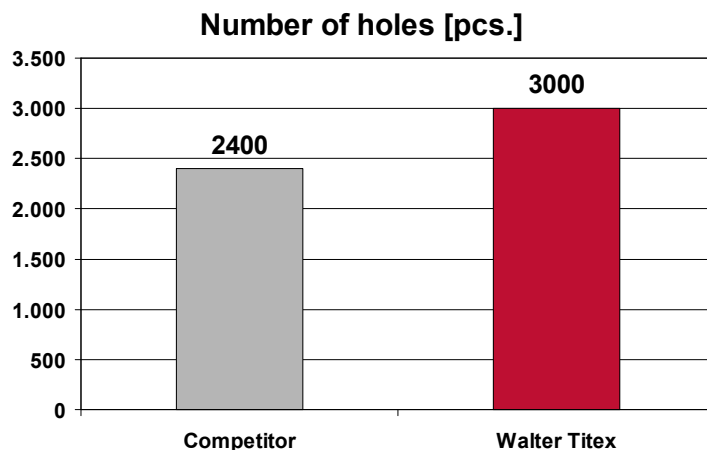
Type : **Machining center**
Designation : **LG Mazak - Vertical**
Adaption : **BT40**

Cutting data:

			Competitor	Walter Titex
			„B224A12000HPX KCP15B “	„DC180-03-12.000A1- WJ30EZ “
v_c	[m/min]	:	83	83
n	[min ⁻¹]	:	2202	2202
f	[mm/rev.]	:	0,2	0,2
v_f	[mm/min]	:	440	440
T	No. of holes	:	2400	3000

Customer benefits:

- Higher Tool Life
- Process reliability
- Increased Productivity
- Cost Reduction



DR190-2023

KW 28.2023

Positive Result „Krato-tec™ - Supreme DC183“



Tool:

Designation : **DC183-08-11.113A1**
Diameter : **11,113mm**
Coating : **WJ30EY**
Drilling Depth : **70mm**

Work piece:

Designation : **Cylinder head**
Material : **G-AlSi9Cu3**
"Material value" : **80 HB**
Hole Type : **Through hole**

Machine:

Type : **Machinig center**
Designation : **Enshu GE480H**
Adaption : **MAS-BT40**



Cutting data:

Competitor „SC Drill“

Walter Titex

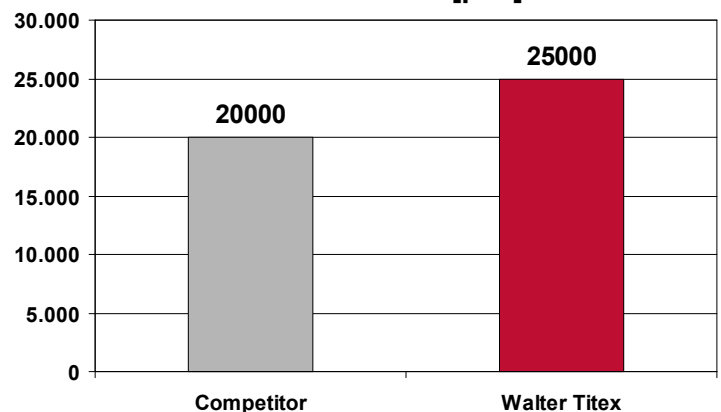
„DC183-08-11.113A1- WJ30EY“

v_c	[m/min]	:	245	243
n	[min ⁻¹]	:	6963	6960
f	[mm/rev.]	:	0,46	0,696
v_f	[mm/min]	:	3203	4844
T	No. of holes	:	20000	25000

Customer benefits:

- Increased tool life
- Reduce machining time
- Saved CO2 emissions
- Improved quality

Number of Holes [pcs]



DR191-2023

KW 23.2023

Positive Result „Krato-tec™ - Supreme DC183“



Tool:

Designation : **DC183-05-14.288A1**
Diameter : **14,288mm**
Coating : **WJ30EZ**
Drilling Depth : **28mm**

Work piece:

Designation : **Breake disc**
Material : **Variver 1 (GGV ; GJV ; GJL)**
"N/mm²" : **450**
Hole Type : **Blindhole**

Machine:

Type : **Machinig center**
Designation : **Chiron FZ 15 W**
Adaption : **SK40 / Whistle Notch**

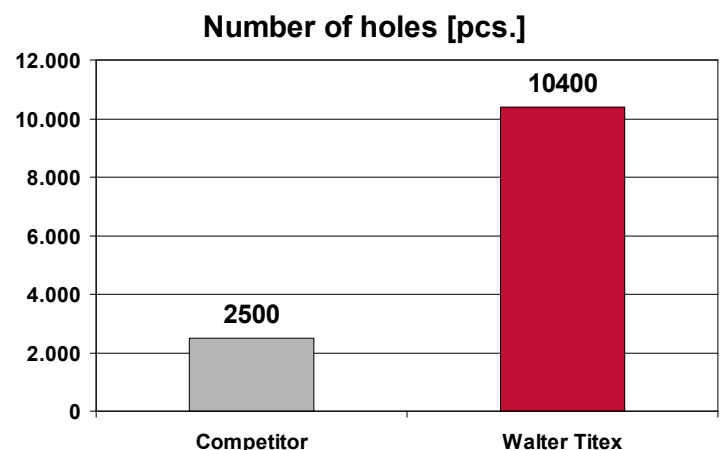


Cutting data:

			Competitor „VHM Bohrer“	Walter Titex „DC183-05-14.288A1- WJ30EZ“
v_c	[m/min]	:	115	115
n	[min ⁻¹]	:	2550	2550
f	[mm/rev.]	:	0,5	0,5
v_f	[mm/min]	:	1260	1260
T	No. of holes	:	2500	10400

Customer benefits:

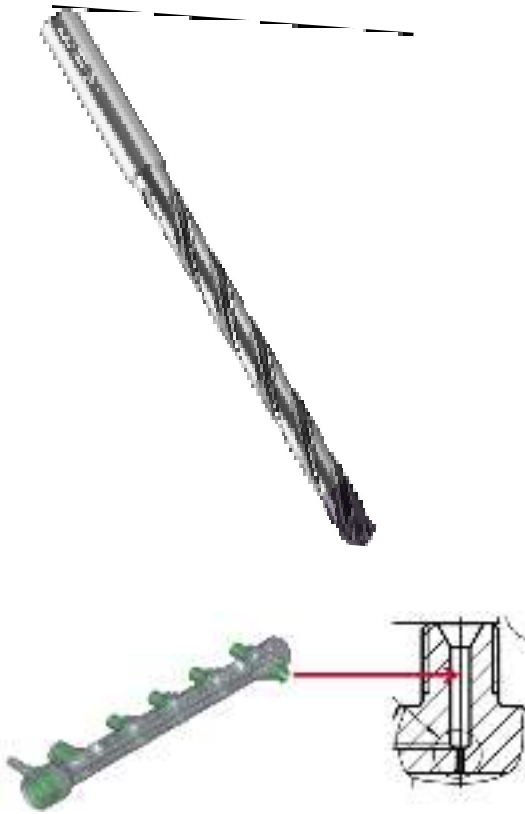
- 4 times higher toollife
- Increased Productivity
- Secure Process
- Customer satisfaction achieved



DR193-2023

KW 32.2023

Positive Result „Krato-tec™ - Supreme DC183“



Tool:

Designation : **DC183-08-03.000A1**
Diameter : **3,0mm**
Coating : **WJ30EY**
Drilling Depth : **17mm**

Work piece:

Designation : **Common fuel rail**
Material : **38MnVS6**
"N/mm²" : **900**
Hole Type : **Blindhole**

Machine:

Type : **Machinig center**
Designation : **Chiron DZ15KW**
Adaption : **HSK63-A**

Cutting data:

			Competitor	Walter Titex
			„DC150-08-03.000A1-WJ30TA“	„DC183-08-03.000A1-WJ30EY “
v_c	[m/min]	:	70	100
n	[min ⁻¹]	:	7430	10600
f	[mm/rev.]	:	0,06	0,1
v_f	[mm/min]	:	446	1060
T	No. of holes	:	700-1500 unstable	1500 stable Process

Customer benefits:

- Reproducible result
- Stable and Secured Process
- Increased Productivity
- Improved quality

