



Exchangeable head drill

DRILLMEISTER

Tungaloy Report No. 412S8-US

DrillLine



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New sleeve dedicated to Swiss type machines for easy setup with DrillMeister tools

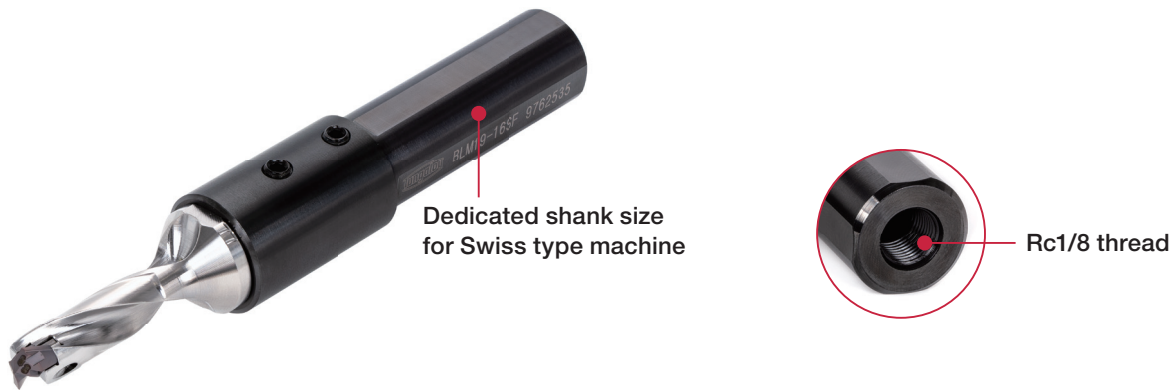




New sleeve dedicated to Swiss type machines for easy setup with DrillMeister tools

Dedicated design for Swiss type machines

- Allows standard TID-F bodies (flange type) to be used without additional machining
- Easy tool change in the machine with side lock system
- Tool can be replaced with minimal misalignment
- Internal lubrication enables high-efficiency machining



Line up overview

Drill diameter (in)	Drill body designation	Shank diameter of sleeve (in)						
		ø0.630	ø0.750	ø0.787	ø0.866	ø0.984	ø1.000	ø1.260
ø0.236 - ø0.390	TID***F12...	○	○	○	○	○	○	○
ø0.394 - ø0.587	TID***F16...		○	○	○	○	○	○
ø0.591 - ø0.705	TID***F20...					○	○	○

Designation system

BLM **254** - **16** **L** **F**

1 Shank diameter of sleeve (mm)	
254	ø25.4 mm (ø1.000")

2 Shank diameter of drill (mm)	
16	ø16 mm (ø0.630")

3 Length	
L	Long
S	Short

4 Shape of sleeve	
F	Flange
R	Round



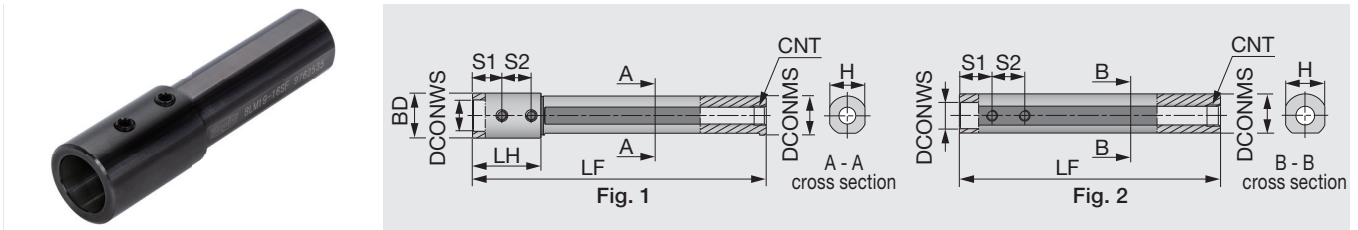
Flange



Round

BLM

Sleeve for exchangeable head drill



Designation	DCONMS	DCONWS	LF	LH	BD	H	S1	S2	CNT	Body	Fig.
BLM16-12LF	0.630	0.472	3.346	1.378	0.787	0.610	0.591	0.591	Rc1/8	TID***F12...	1
BLM19-12LF	0.750	0.472	5.512	1.378	0.906	0.728	0.591	0.591	Rc1/8	TID***F12...	1
BLM19-12SF	0.750	0.472	3.543	1.378	0.906	0.728	0.591	0.591	Rc1/8	TID***F12...	1
BLM19-16LF	0.750	0.630	5.512	1.378	0.906	0.728	0.591	0.591	Rc1/8	TID***F16...	1
BLM19-16SF	0.750	0.630	3.543	1.378	0.906	0.728	0.591	0.591	Rc1/8	TID***F16...	1
BLM20-12LR	0.787	0.472	4.724	-	-	0.748	0.591	0.591	Rc1/8	TID***F12...	2
BLM20-16LF	0.787	0.630	5.906	1.378	0.906	0.748	0.591	0.591	Rc1/8	TID***F16...	1
BLM22-12LR	0.866	0.472	4.724	-	-	0.846	0.591	0.591	Rc1/8	TID***F12...	2
BLM22-16LF	0.866	0.630	5.512	1.378	0.984	0.846	0.591	0.591	Rc1/8	TID***F16...	1
BLM25-12LR	0.984	0.472	4.528	-	-	0.945	0.591	0.591	Rc1/8	TID***F12...	2
BLM25-16LR	0.984	0.630	4.528	-	-	0.945	0.591	0.591	Rc1/8	TID***F16...	2
BLM25-20LF	0.984	0.787	5.906	1.378	1.102	0.945	0.591	0.591	Rc1/8	TID***F20...	1
BLM254-12LR	1.000	0.472	4.528	-	-	0.972	0.591	0.591	Rc1/8	TID***F12...	2
BLM254-12SR	1.000	0.472	2.953	-	-	0.972	0.591	0.591	Rc1/8	TID***F12...	2
BLM254-16LR	1.000	0.630	4.528	-	-	0.972	0.591	0.591	Rc1/8	TID***F16...	2
BLM254-16SR	1.000	0.630	2.953	-	-	0.972	0.591	0.591	Rc1/8	TID***F16...	2
BLM254-20LF	1.000	0.787	5.512	1.378	1.102	0.972	0.591	0.591	Rc1/8	TID***F20...	1
BLM32-12LR	1.260	0.472	4.724	-	-	1.240	0.591	0.591	Rc1/8	TID***F12...	2
BLM32-16LR	1.260	0.630	4.724	-	-	1.240	0.591	0.591	Rc1/8	TID***F16...	2
BLM32-20LR	1.260	0.787	4.724	-	-	1.240	0.591	0.591	Rc1/8	TID***F20...	2

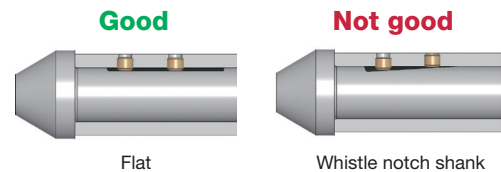
SPARE PARTS



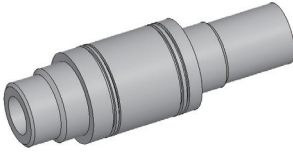
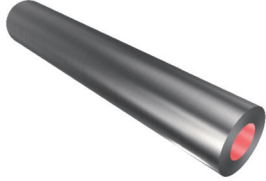
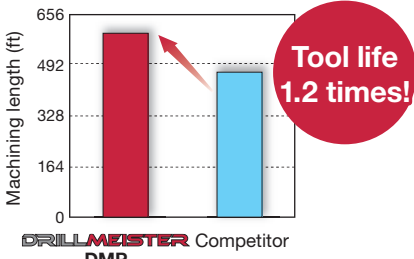
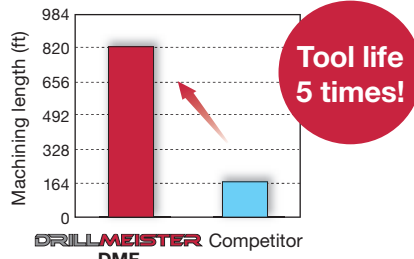
Designation	Clamping screw	Wrench
BLM16/19/20/22...	SR M5x4 FLAT	P-2.5
BLM25-12LR	SR M5x6 FLAT	P-2.5
BLM25-16LR, BLM25-20LF	SR M5x4 FLAT	P-2.5
BLM254-12LR, BLM254-12SR	SR M5x6 FLAT	P-2.5
BLM254-16LR, BLM254-16SR, BLM254-20LF	SR M5x4 FLAT	P-2.5
BLM32-12LR, BLM32-16LR	SR M5x6 FLAT	P-2.5
BLM32-20LR	SR M5x4 FLAT	P-2.5

Note for sleeve usage

- Please refer to the separate Tungaloy report and product catalog for cutting conditions
- Please refrain from using whistle notch and weldon type shanks from the viewpoint of clamping stability



PRACTICAL EXAMPLES

Workpiece type		Pump parts	Piston parts
Drill body		TID100F16-3	TID125F16-5
Head		DMP101	DMF126
Grade		AH725	AH9130
Workpiece material		430SS	1010
		 M	 P
Cutting conditions	Cutting speed : V_c (sfm)	259	164
	Feed : f (ipr)	0.006	0.008
	Feed speed : V_f (ipm)	14.685	9.953
	Drill diameter : DC (in)	0.398	0.496
	Hole depth : H (in)	0.705	1.969
	Coolant	Wet (External coolant)	Wet (Internal coolant)
Machine	Swiss lathe	Swiss lathe	
Results		 <p>Tool life 1.2 times!</p> <p>Machining stability improved by using a low cutting force of DMP head, achieving 20% longer tool life than existing products. In addition, tools can be exchanged inside the machine, leading to improved machine operating time.</p>	 <p>Tool life 5 times!</p> <p>DMF drill head in AH9130 showed 5 times better tool life than existing solid flat drill. Tool changing became much easier and quicker since it was done in the machine. In addition, tool stock management is improved by eliminating regrinding.</p>



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