

DRILLING

The experience of **SISTEMI** is being always available to its customers in choosing the right tool for the desired processing. In this regard, a wide range of factors must be taken into consideration. Here is a summary list:

- 1) In addition to the traditional drilling bits with brazed carbide tips sometimes it is important to evaluate the use of **solid carbide drills** (Art. L116/L117/L118/L129/L134/L135) **that can ensure performance benefits**, longer life, higher number of resharpening times and higher resistance to breakage of tool body;
- 2) Choosing the drill bit according to the working material by properly setting RPM and feed speed as indicated in the following tables help to optimize the process;
- 3) To reduce the time of assembly and align the drills, **we recommend using our quick change drill chucks** (Art. L030 ÷ L060);
- 4) **Regular cleaning and maintenance** of the drills and adaptors **improve the performance and life of tools**, reducing the risk of breakage and increasing the quality of the worked pieces;
- 5) To improve the chips flow, the boring bits are coated with a **PTFE-based heat treatment** (Polytetrafluoroethylene) in black for Right Rotation and orange for Left Rotation.



How to choose the right Boring Bits

Types of material Items	Softwood (Cider, Poplar, Pine, etc.)	Hardwood (Ash, Walnut, Beech, Oak, Teak, etc.)	Pressed Wood (Plywood, Blockboard)	Chipboard	Laminated Wood (Veneered, melamine coated panels, HPL, etc.)	MDF	Trespa®
L101/L102/L103/L104 - Page 5.07, 5.08	XX	XX	XX	XX	X	XX	
L105/L106/L107/L108 - Page 5.08	XX	XX	XX	XX	X	XX	
L109/L110 - Page 5.09	XX	XX	XX	XX	X	XX	
L112/L113 - Page 5.10	XX	XX	XXX	XXX	XXX	XXX	
L114/L115/L116/L117 - Page 5.11	XX	XX	XXX	XXX	XXX	XXX	X
L118 - Page 5.12	X	X	X	X	X	XX	XXX
L132/L133 - Page 5.15	XXX	XXX	XXX	XXX	XXX	XXX	XX
L134/L135 - Page 5.15	XXX	XXX	XXX	XXX	XXX	XXX	XX
L120 - Page 5.12	XX	XX	XX	XX	XX	XX	X
L121/L122/L123/L124 - Page 5.07, 5.13	XX	XX	XX	XX	X	XX	
L125/L126/L127 - Page 5.13	XX	XX	XX	XX	X	XX	
L129 - Page 5.14	XXX	XXX	XXX	XXX	XX	XXX	X
L140/L141/L142 - Page 5.16	XX	XX	XXX	XXX	XX	XX	
L143/L144/L150/L151 - Page 5.17	XX	XX	XXX	XXX	X	XX	
L155 - Page 5.17	XXX	XXX	XXX	XXX	XXX	XXX	XX
L160/L170 - Page 5.18	XX	XX	XXX	XXX	XX	XX	

X = Satisfactory - **XX** = Good - **XXX** = Excellent

Technical data and images are just an indication.
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