

## Economical machining with Quadro 15 PLUS®

Sphinx Tools Ltd. is your partner for innovative machining solutions. We provide the perfect tool for every application, along with excellent after-sales service. All Sphinx products are developed and produced entirely in Switzerland.



# 4 in 1

The perfect drill for drilling and reaming steel and cast iron

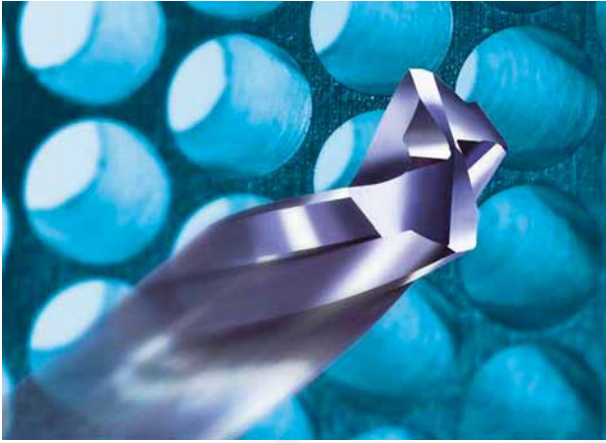
Sphinx Tools Ltd. is adding a new model to its Quadro Plus® series: the **Quadro 15 PLUS®**, a high-performance drill developed using the latest technology.

The perfect tool for machining steel and cast iron. The special construction allows extremely high feed rates to be achieved. Sustained high performance is guaranteed by a special combination of a new type of geometry and coating.

Holes in the tolerance class H6 to H7 can be produced with virtually the same surface qualities as in reaming.

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## Product advantages:

- Maximum productivity thanks to ultra-fast cutting speeds and feeds.
- Special tip geometry for low cutting forces.
- Solid carbide material (ultra-fine grain carbide) for increased wear resistance and high degree of toughness.
- Balzers coating for high wear resistance and optimum chip evacuation.
- Hole quality: H6 to H7 with Ra 0.8 (N6).
- Structural dimensions according to Sphinx, special dimensions producible at any time.

## Useable in:

- Steel
- Cast iron (grey cast, nodular cast, vermicular cast)
- Non-ferrous metals

# Maximum productivity with excellent hole quality: Quadro 15 PLUS

<b>Working exaÜles: Quadro 15 Plus® Art. 52150: Ø 4.00 mm to 20.00 mm</b>					
Tool description	Catalog article	Catalog article	Catalog article	Catalog article	Catalog article
Coating	Futura Nano Top	Futura Nano Top	Futura Nano Top	Futura Nano Top	Futura Nano Top
Diameter (mm)	10	9,50	10	6	4
Hole depth (mm)	48	45	50	30	24
Hole	Blind hole	Blind hole	Trough hole	Blind hole	Blind hole
Material group	Plain carbon steel <1000 N/mm <sup>2</sup>	Steel >1000 N/mm <sup>2</sup>	Cast iron	Tool steel	
Material number	1.1191	1.7321	0.7050	1.2316	Vanadis 6
DIN	CK45	20MoCr4	GGG-50	X38CrMo16	Superclean
Machine type	CNC	CNC	CNC	CNC	CNC
Coolant	Emulsion internal coolant	Emulsion internal coolant	Emulsion internal coolant	Emulsion internal coolant	Emulsion internal coolant
v <sub>c</sub> (m/min)	170	90	200	60	40
f (mm/rev.)	0,30	0,20	0,50	0,10	0,03

Available from stock: Diameter range 4.0 – 20.0 mm.

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