



# Drills

Smart program  
for drilling glass



**ALTIFORT**  
BOART

# Drilling bore holes. Our smart program for the glass industry.

Drills, FC161 und FC158:

FC158, soft bond



FC161, hard bond





## Available standards and advised working parameters

### Available specifications:

- FC161: hard bond for high feed rate, high lifetime
- FC158: soft bond for high cutting ability and improved holes quality

### Available diameters (D):

- D 3 mm to D 100 mm, decimal diameters available upon request

### Standard lengths (L):

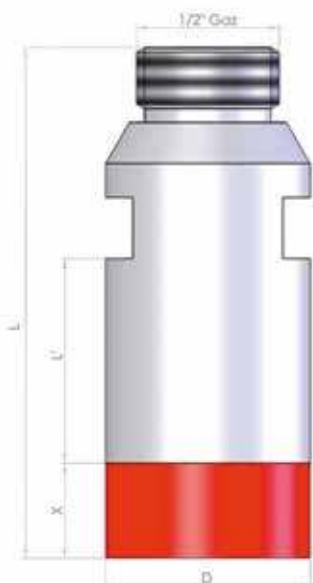
- L75: for Benteler, Schraml, Busetti, Knopp ...
- L95: for Forvet, Bottero ...

### Standard height of diamond (X):

- X: 5 mm for diameter D 4 mm and below
- X: 10 mm for diameter D 5 mm and above

### Standard fitting:

- R1/2" GAZ



### Standard working length (L1)

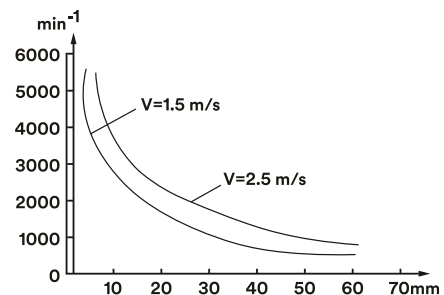
External diameter	Total length L75m	Total length L95m
D 3 mm to D 8 mm	L1 = 15 mm	L1 = 35 mm
D 9 mm to D 100 mm	L1 = 30 mm	L1 = 50 mm

### Advised working parameters

#### Peripheral speed:

Optimum peripheral speed is between 1.5 and 2.5 m/s

D in mm	Speed RPM
3-5	9000
6-10	4500
11-20	2500
21-25	2000
26-35	1250
36-50	1000
51-100	600
101-150	300



#### Feed rate:

Drills performances depend on feed rate. The optimum feed rate is between 30-60 mm/min or 0.5-1.0 mm/s

With a low feed rate, diamond dulls and the layer loses cutting ability. With a higher feed rate, diamonds are exposed out of the bond.

At optimum speed, the specific pressure is reached and allows self-dressing effect which helps to minimize the tools wear.

#### Water pressure

D (mm)	Pressure (bar)
2-5	5-3
6-10	3-2
11-20	2-1
21-40	1-0.5
41-120	0.5-0.2

# Our drilling solutions for the glass industry.



## Drills

### Straight drills, our smart program

- Available for automated NC process and manual machines
- Extended lifetime and stable performances



## Spider Reamers TR 120 D

### When countersinking glass is not an issue anymore

- Your only solution for wide and/or deep chamfers
- Extremely high quality
- Patented – unique Altifort Boart technology



## Combis

### Drilling and chamfering glass

- Extended lifetime and constant performances
- The best in class quality for chamfered holes



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