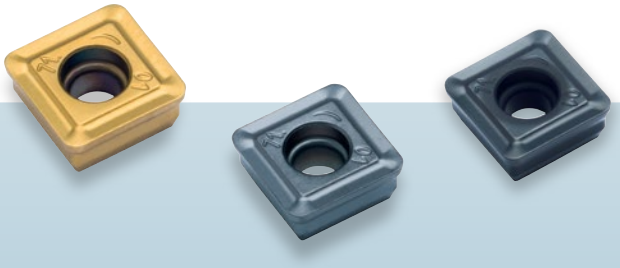
Galtona®

TOOLS & INSERTS FOR DRILLING

Catalogue



Galtona

TOOLS & INSERTS FOR DRILLING

Catalogue

Our Product Portfolio

MILLING

TURNING

GROOVING

DRILLING

MULTICUT

The Origin of Galtona O.K.

We are proud to present Galtona UK as one of the pioneers in Metalworking Excellence.

Explore the realm of exceptional metal-working prowess with Galtona UK, which has been a trailblazer in the industry for decades.

As an esteemed manufacturer, specializing in precision machining solutions, Galtona UK presents an extreme array of cutting-edge tools especially designed and built to suit diverse turning, milling, threading, and drilling needs.

Our collaborative approach is unique. We closely work with our clients to embark on a journey of 'co-creation' by fashioning bespoke solutions for addressing the intricate demands of aviation, aerospace, automotive, energy, and general engineering sectors.

In the vanguard of innovation, we're not just engineers; we're digital architects. Our expertise extends to sculpting digital process solutions that redefine efficiency standards.

Embodying a profound commitment, Galtona UK promotes a sustainable and visionary energy landscape. Join us in our mission to illuminate the path towards tomorrow.

Inserts and tools for indexable drilling in 3xD, 4xD and 5xD

Presentation:

▲ Ø 14.0 mm to Ø 44.0 mm

Your benefits:

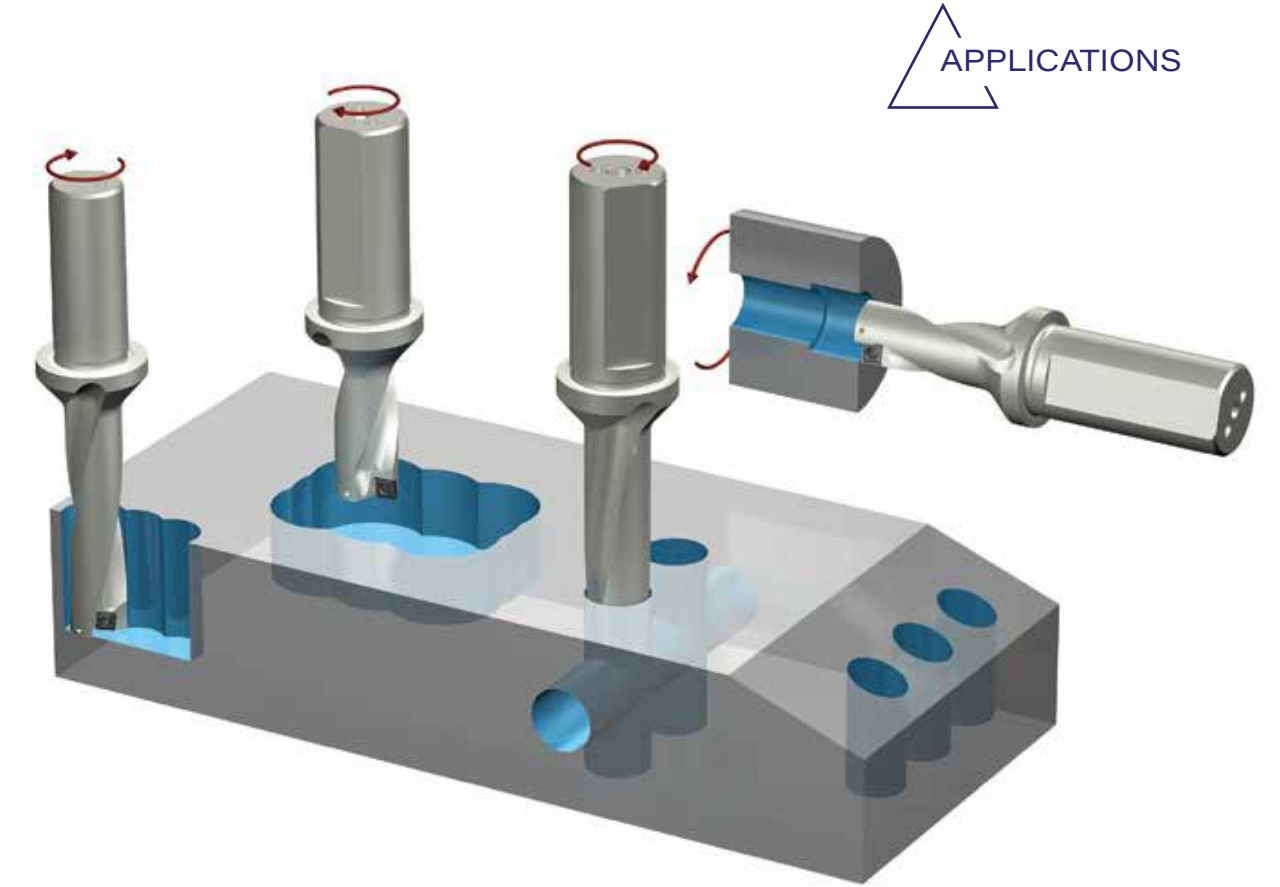
Performance booster suitable for extreme machining:

- ▲ drilling through stacks,
- ▲ drilling into edges,
- ▲ drilling into corner angles,
- ▲ drilling into weld seams or ridged surfaces

Costs savings:

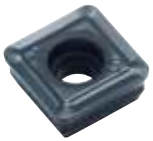
- ▲ Achieves an increase in cutting data and feed rates of up to 20 %
- ▲ Optimum dimensional accuracy in the most difficult drilling conditions
- ▲ A single tool combines key features such as real accuracy, top performance parameters and deep drilling depths.
- ▲ Cost reductions in stocking and ease of handling due to identical internal and external indexable inserts

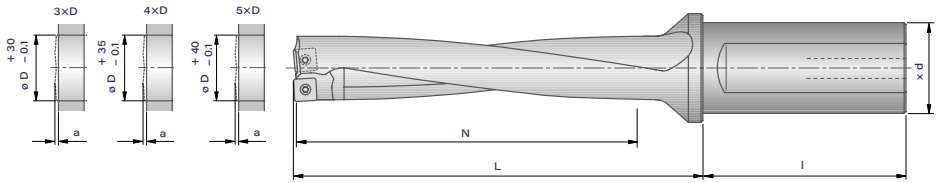
APPLICATIONS



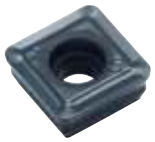
Available range 3xD:
∅14.0 mm – ∅19.5 mm

Tools	∅ [mm]	Designation	∅ d×l [mm]	N [mm]	L [mm]	Material number
	14.0	IDCD.3D.1400.R.20.05	20x50	42	55	MM12547000
	14.5	IDCD.3D.1450.R.20.05	20x50	45	59	MM12547014
	15.0	IDCD.3D.1500.R.20.05	20x50	45	59	MM12547020
	15.5	IDCD.3D.1550.R.20.05	20x50	48	64	MM12547027
	16.0	IDCD.3D.1600.R.20.05	20x50	48	64	MM12547037
	16.5	IDCD.3D.1650.R.20.05	20x50	51	68	MM12547045

Insert	Designation	Chipbreaker	Material number	Available
	SOLT 050204-HCD GTPP425 VV	...-HCD	P	MM12421657
	SOLT 050204-CCD GTPK415	...-CCD	K	MM12421662
	SOLT 050204-SCD GTPP440	...-SCD	M	MM12421661
	SOLT 050204-HCD GTPP440	...-HCD	S	MM12421660

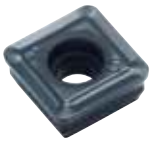


Tools	Ø [mm]	Designation	Ø d×l [mm]	N [mm]	L [mm]	Material number
	17.0	IDCD.3D.1700.R.20.06	20x50	51	68	MM1254922
	17.5	IDCD.3D.1750.R.25.06	25x56	51	71	MM1254974
	18.0	IDCD.3D.1800.R.25.06	25x56	54	71	MM1254983
	18.5	IDCD.3D.1850.R.25.06	25x56	55.5	75	MM1254904
	19.0	IDCD.3D.1900.R.25.06	25x56	57	75	MM1254909
	19.5	IDCD.3D.1950.R.25.06	25x56	60	78	MM1254914

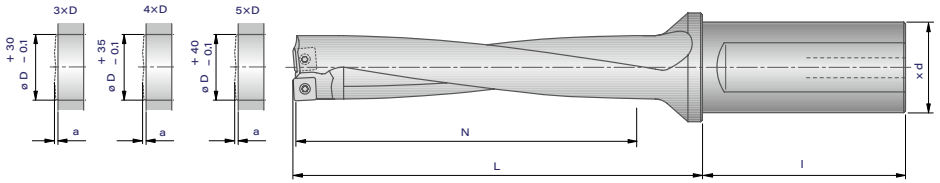
Insert	Designation	Chipbreaker	Material number	Available
	SOLT 06T206-HCD GTPP425	...-HCD	P	MM12421690
	SOLT 06T206-CCD GTPK415	...-CCD	K	MM12421699
	SOLT 06T206-SCD GTPP440	...-SCD	M	MM12421695
	SOLT 06T206-HCD GTPP440	...-HCD	S	MM12421693

Available range 3xD:
∅20.0 mm – ∅28.0 mm

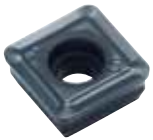
Tools	∅ [mm]	Designation	∅ d×l [mm]	N [mm]	L [mm]	Material number
	20.0	IDCD.3D.2000.R.25.07	25x56	60	78	MM12553501
	20.5	IDCD.3D.2050.R.25.07	25x56	61.5	82	MM12553502
	21.0	IDCD.3D.2100.R.25.07	25x56	66	85	MM12553503
	21.5	IDCD.3D.2150.R.25.07	25x56	66	85	MM12553504
	22.0	IDCD.3D.2200.R.25.07	25x56	66	85	MM12553506
	22.5	IDCD.3D.2250.R.25.07	25x56	69	89	MM12553507
	23.0	IDCD.3D.2300.R.25.07	25x56	69	89	MM12553508



Insert	Designation	Chipbreaker	Material number	Available
	SOLT 070308-HCD GTPP425	...-HCD	P	MM12421701
	SOLT 070308-CCD GTPK415	...-CCD	K	MM12421711
	SOLT 070308-SCD GTPP440	...-SCD	M	MM12421704
	SOLT 070308-HCD GTPP440	...-HCD	S	MM12421702

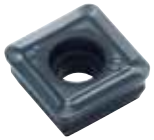


Tools	Ø [mm]	Designation	Ø d×l [mm]	N [mm]	L [mm]	Material number
	23.5	IDCD.3D.2350.R.32.08	32x60	72	92	MM12553510
	24.0	IDCD.3D.2400.R.32.08	32x60	72	92	MM12553511
	24.5	IDCD.3D.2450.R.32.08	32x60	75	96	MM12553512
	25.0	IDCD.3D.2500.R.32.08	32x60	78	96	MM12553513
	25.5	IDCD.3D.2550.R.32.08	32x60	78	99	MM12553515
	26.0	IDCD.3D.2600.R.32.08	32x60	81	99	MM12553516
	26.5	IDCD.3D.2650.R.32.08	32x60	81	103	MM12553517
	27.0	IDCD.3D.2700.R.32.08	32x60	81	103	MM12553519
	27.5	IDCD.3D.2750.R.32.08	32x60	84	106	MM12553520
	28.0	IDCD.3D.2800.R.32.08	32x60	84	106	MM12553521

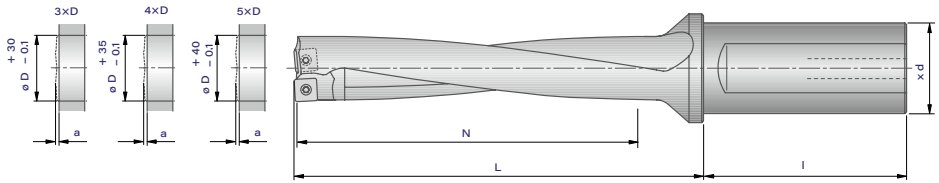
Insert	Designation	Chipbreaker	Material number	Available
	SOLT 080308-HCD GTPP425	...-HCD	P	MM12421717
	SOLT 080308-CCD GTPK415	...-CCD	K	MM12421752
	SOLT 080308-SCD GTPP440	...-SCD	M	MM12421750
	SOLT 080308-HCD GTPP440	...-HCD	S	MM12421720

Available range 3xD:
∅28.5 mm – ∅38.0 mm

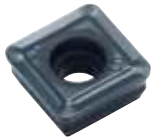
Tools	∅ [mm]	Designation	∅ d×l [mm]	N [mm]	L [mm]	Material number
	28.5	IDCD.3D.2850.R.32.10	32x60	87	110	MM12553522
	29.0	IDCD.3D.2900.R.32.10	32x60	87	110	MM12553523
	29.5	IDCD.3D.2950.R.32.10	32x60	90	113	MM12553524
	30.0	IDCD.3D.3000.R.32.10	32x60	90	113	MM12553525
	30.5	IDCD.3D.3050.R.40.10	40x68	93	117	MM12553534
	31.0	IDCD.3D.3100.R.40.10	40x68	93	117	MM12553535
	31.5	IDCD.3D.3150.R.40.10	40x68	96	120	MM12553536
	32.0	IDCD.3D.3200.R.40.10	40x68	96	120	MM12553537
	32.5	IDCD.3D.3250.R.40.10	40x68	99	124	MM12553538
	33.0	IDCD.3D.3300.R.40.10	40x68	99	124	MM12553539



Insert	Designation	Chipbreaker	Material number	Available
	SOLT 10T308-HCD GTPP425	...-HCD	P	MM12421756
	SOLT 10T308-CCD GTPK415	...-CCD	K	MM12421772
	SOLT 10T308-SCD GTPP440	...-SCD	M	MM12421771
	SOLT 10T308-HCD GTPP440	...-HCD	S	MM12421757

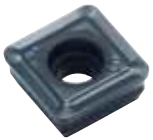


Tools	Ø [mm]	Designation	Ø d×l [mm]	N [mm]	L [mm]	Material number
	33.5	IDCD.3D.3350.R.40.11	40x68	102	127	MM12555817
	34.0	IDCD.3D.3400.R.40.11	40x68	102	127	MM12555823
	34.5	IDCD.3D.3450.R.40.11	40x68	102	131	MM12555824
	35.0	IDCD.3D.3500.R.40.11	40x68	105	131	MM12555825
	35.5	IDCD.3D.3550.R.40.11	40x68	105	134	MM12555827
	36.0	IDCD.3D.3600.R.40.11	40x68	108	134	MM12555828
	36.5	IDCD.3D.3650.R.40.11	40x68	108	138	MM12555829
	37.0	IDCD.3D.3700.R.40.11	40x68	111	138	MM12555830
	37.5	IDCD.3D.3750.R.40.11	40x68	111	141	MM12555831
	38.0	IDCD.3D.3800.R.40.11	40x68	114	141	MM12555832

Insert	Designation	Chipbreaker	Material number	Available
	SOLT 110408-HCD GTPP425	...-HCD	P	MM12421773
	SOLT 110408-CCD GTPK415	...-CCD	K	MM12421777
	SOLT 110408-SCD GTPP440	...-SCD	M	MM12421776
	SOLT 110408-HCD GTPP440	...-HCD	S	MM12421775

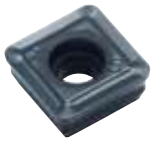
Available range 3xD:
∅38.5 mm – ∅44.0 mm

Tools	∅ [mm]	Designation	∅ d×l [mm]	N [mm]	L [mm]	Material number
	38.5	IDCD.3D.3850.R.40.13	40x68	117	145	MM12555833
	39.0	IDCD.3D.3900.R.40.13	40x68	117	145	MM12555835
	39.5	IDCD.3D.3950.R.40.13	40x68	120	148	MM12555836
	40.0	IDCD.3D.4000.R.40.13	40x68	120	148	MM12555837
	40.5	IDCD.3D.4050.R.40.13	40x68	123	152	MM12555838
	41.0	IDCD.3D.4100.R.40.13	40x68	123	152	MM12555839
	41.5	IDCD.3D.4150.R.40.13	40x68	126	155	MM12555840
	42.0	IDCD.3D.4200.R.40.13	40x68	126	155	MM12555842
	42.5	IDCD.3D.4250.R.40.13	40x68	129	159	MM12555843
	43.0	IDCD.3D.4300.R.40.13	40x68	129	159	MM12555844
	43.5	IDCD.3D.4350.R.40.13	40x68	132	162	MM12555845
	44.0	IDCD.3D.4400.R.40.13	40x68	132	162	MM12555847

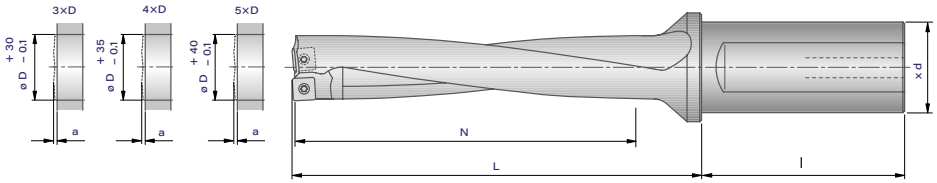
Insert	Designation	Chipbreaker	Material number	Available
	SOLT 130508-HCD GTPP425	...-HCD	P	MM12421779
	SOLT 130508-CCD GTPK415	...-CCD	K	MM12421783
	SOLT 130508-SCD GTPP440	...-SCD	M	MM12421782
	SOLT 130508-HCD GTPP440	...-HCD	S	MM12421780

Available range 4xD:
∅14.0 mm – ∅19.5 mm

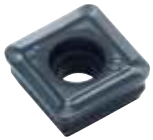
Tools	∅ [mm]	Designation	∅ d×l [mm]	N [mm]	L [mm]	Material number
	14.0	IDCD.4D.1400.R.20.05	20x50	56	69	MM12556124
	14.5	IDCD.4D.1450.R.20.05	20x50	60	74	MM12556129
	15.0	IDCD.4D.1500.R.20.05	20x50	60	74	MM12556136
	15.5	IDCD.4D.1550.R.20.05	20x50	64	80	
	16.0	IDCD.4D.1600.R.20.05	20x50	64	80	MM12556145
	16.5	IDCD.4D.1650.R.20.05	20x50	68	85	MM12556151



Insert	Designation	Chipbreaker	Material number	Available
	SOLT 050204-HCD GTPP425	...-HCD	P	MM12421657
	SOLT 050204-CCD GTPK415	...-CCD	K	MM12421662
	SOLT 050204-SCD GTPP440	...-SCD	M	MM12421661
	SOLT 050204-HCD GTPP440	...-HCD	S	MM12421660

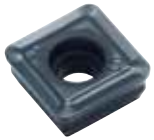


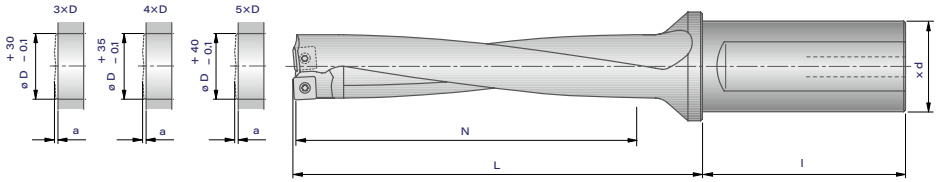
Tools	Ø [mm]	Designation	Ø d×l [mm]	N [mm]	L [mm]	Material number
	17.0	IDCD.4D.1700.R.20.06	20x50	68	85	MM12556158
	17.5	IDCD.4D.1750.R.25.06	25x56	72	89	MM12556162
	18.0	IDCD.4D.1800.R.25.06	25x56	72	89	MM12556166
	18.5	IDCD.4D.1850.R.25.06	25x56	76	94	MM12556169
	19.0	IDCD.4D.1900.R.25.06	25x56	76	94	MM12556170
	19.5	IDCD.4D.1950.R.25.06	25x56	80	98	MM12556212

Insert	Designation	Chipbreaker	Material number	Available
	SOLT 06T206-HCD GTPP425	...-HCD	P	MM12421690
	SOLT 06T206-CCD GTPK415	...-CCD	K	MM12421699
	SOLT 06T206-SCD GTPP440	...-SCD	M	MM12421695
	SOLT 06T206-HCD GTPP440	...-HCD	S	MM12421693

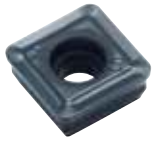
Available range 4xD:
∅20.0 mm – ∅28.0 mm

Tools	∅ [mm]	Designation	∅ d×l [mm]	N [mm]	L [mm]	Material number
	20.0	IDCD.4D.2000.R.25.07	25x56	80	98	MM12556817
	20.5	IDCD.4D.2050.R.25.07	25x56	84	103	MM12556819
	21.0	IDCD.4D.2100.R.25.07	25x56	84	103	MM12556823
	21.5	IDCD.4D.2150.R.25.07	25x56	88	107	MM12556824
	22.0	IDCD.4D.2200.R.25.07	25x56	88	107	MM12556825
	22.5	IDCD.4D.2250.R.25.07	25x56	92	112	MM12556826
	23.0	IDCD.4D.2300.R.25.07	25x56	92	112	MM12556828

Insert	Designation	Chipbreaker	Material number	Available
	SOLT 070308-HCD GTPP425	...-HCD	P	MM12421701
	SOLT 070308-CCD GTPK415	...-CCD	K	MM12421711
	SOLT 070308-SCD GTPP440	...-SCD	M	MM12421704
	SOLT 070308-HCD GTPP440	...-HCD	S	MM12421702



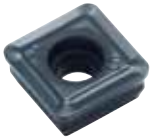
Tools	Ø [mm]	Designation	Ø dxl [mm]	N [mm]	L [mm]	Material number
	23.5	IDCD.4D.2350.R.32.08	32x60	96	116	MM12556830
	24.0	IDCD.4D.2400.R.32.08	32x60	96	116	MM12556833
	24.5	IDCD.4D.2450.R.32.08	32x60	100	121	MM12556835
	25.0	IDCD.4D.2500.R.32.08	32x60	100	121	MM12556837
	25.5	IDCD.4D.2550.R.32.08	32x60	104	125	MM12556839
	26.0	IDCD.4D.2600.R.32.08	32x60	104	125	MM12556841
	26.5	IDCD.4D.2650.R.32.08	32x60	108	130	MM12556845
	27.0	IDCD.4D.2700.R.32.08	32x60	108	130	MM12556846
	27.5	IDCD.4D.2750.R.32.08	32x60	112	134	MM12556847
	28.0	IDCD.4D.2800.R.32.08	32x60	112	134	MM12556848

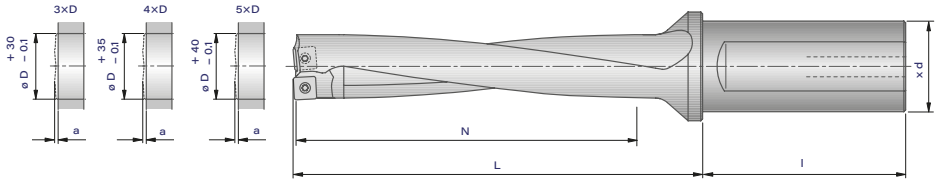
Insert	Designation	Chipbreaker	Material number	Available
	SOLT 080308-HCD GTPP425	...-HCD	P	12421717
	SOLT 080308-CCD GTPK415	...-CCD	K	12421752
	SOLT 080308-SCD GTPP440	...-SCD	M	12421750
	SOLT 080308-HCD GTPP440	...-HCD	S	12421720

Available range 4xD:

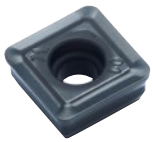
∅28.5 mm ∅38.0 mm

Tools	∅ [mm]	Designation	∅ dxl [mm]	N [mm]	L [mm]	Material number
	28.5	IDCD.4D.2850.R.32.10	32x60	116	139	MM12556883
	29.0	IDCD.4D.2900.R.32.10	32x60	116	139	MM12556884
	29.5	IDCD.4D.2950.R.32.10	32x60	120	143	MM12556887
	30.0	IDCD.4D.3000.R.32.10	32x60	120	143	MM12556889
	30.5	IDCD.4D.3050.R.40.10	40x68	124	148	MM12556892
	31.0	IDCD.4D.3100.R.40.10	40x68	124	148	MM12556895
	31.5	IDCD.4D.3150.R.40.10	40x68	128	152	MM12556898
	32.0	IDCD.4D.3200.R.40.10	40x68	128	152	MM12556902
	32.5	IDCD.4D.3250.R.40.10	40x68	132	157	MM12556904
	33.0	IDCD.4D.3300.R.40.10	40x68	132	157	MM12556905

Insert	Designation	Chipbreaker	Material number	Available
	SOLT 10T308-HCD GTPP425	...-HCD	P	MM12421756
	SOLT 10T308-CCD GTPK415	...-CCD	K	MM12421772
	SOLT 10T308-SCD GTPP440	...-SCD	M	MM12421771
	SOLT 10T308-HCD GTPP440	...-HCD	S	MM12421757



Tools	∅ [mm]	Designation	∅ d×l [mm]	N [mm]	L [mm]	Material number
	33.5	IDCD.4D.3350.R.40.11	40x68	136	161	MM12556934
	34.0	IDCD.4D.3400.R.40.11	40x68	136	161	MM12556935
	34.5	IDCD.4D.3450.R.40.11	40x68	140	166	MM12556942
	35.0	IDCD.4D.3500.R.40.11	40x68	140	166	MM12556945
	35.5	IDCD.4D.3550.R.40.11	40x68	144	170	MM12556946
	36.0	IDCD.4D.3600.R.40.11	40x68	144	170	MM12556947
	36.5	IDCD.4D.3650.R.40.11	40x68	148	175	MM12557457
	37.0	IDCD.4D.3700.R.40.11	40x68	148	175	MM12557458
	37.5	IDCD.4D.3750.R.40.11	40x68	152	179	MM12557459
	38.0	IDCD.4D.3800.R.40.11	40x68	152	179	MM12557460

Insert	Designation	Chipbreaker	Material number	Available
	SOLT 110408-HCD GTPP425	...-HCD	P	MM12421773
	SOLT 110408-CCD GTPK415	...-CCD	K	MM12421777
	SOLT 110408-SCD GTPP440	...-SCD	M	MM12421776
	SOLT 110408-HCD GTPP440	...-HCD	S	MM12421775

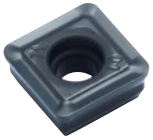
Available range 4xD:
∅38.5 mm – ∅44.0 mm

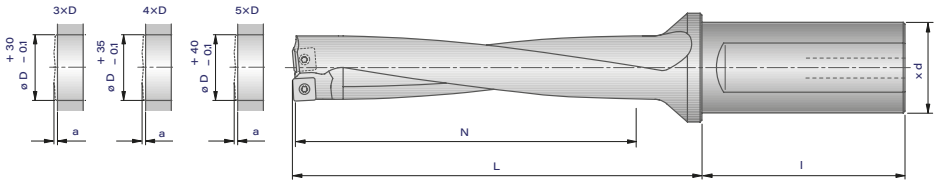
Tools	∅ [mm]	Designation	∅ d×l [mm]	N [mm]	L [mm]	Material number
	38.5	IDCD.4D.3850.R.40.13	40x68	156	184	MM12557462
	39.0	IDCD.4D.3900.R.40.13	40x68	156	184	MM12557464
	39.5	IDCD.4D.3950.R.40.13	40x68	160	188	MM12557467
	40.0	IDCD.4D.4000.R.40.13	40x68	160	188	MM12557470
	40.5	IDCD.4D.4050.R.40.13	40x68	164	193	MM12557472
	41.0	IDCD.4D.4100.R.40.13	40x68	164	193	MM12557473
	41.5	IDCD.4D.4150.R.40.13	40x68	168	197	MM12557475
	42.0	IDCD.4D.4200.R.40.13	40x68	168	197	MM12557476
	42.5	IDCD.4D.4250.R.40.13	40x68	172	202	MM12557477
	43.0	IDCD.4D.4300.R.40.13	40x68	172	202	MM12557478
	43.5	IDCD.4D.4350.R.40.13	40x68	176	206	MM12557480
	44.0	IDCD.4D.4400.R.40.13	40x68	176	206	MM12557492

Insert	Designation	Chipbreaker	Material number	Available
	SOLT 130508-HCD GTPP425	...-HCD	P	MM12421779
	SOLT 130508-CCD GTPK415	...-CCD	K	MM12421783
	SOLT 130508-SCD GTPP440	...-SCD	M	MM12421782
	SOLT 130508-HCD GTPP440	...-HCD	S	MM12421780

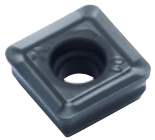
Available range 5xD:
∅14.0 mm – ∅19.5 mm

Tools	∅ [mm]	Designation	∅ d×l [mm]	N [mm]	L [mm]	Material number
	14.0	IDCD.5D.1400.R.20.05	20x50	70	83	MM12568585
	14.5	IDCD.5D.1450.R.20.05	20x50	75	89	MM12568588
	15.0	IDCD.5D.1500.R.20.05	20x50	75	89	MM12568591
	15.5	IDCD.5D.1550.R.20.05	20x50	80	96	MM12568594
	16.0	IDCD.5D.1600.R.20.05	20x50	80	96	MM12568596
	16.5	IDCD.5D.1650.R.20.05	20x50	85	102	MM12568599

Insert	Designation	Chipbreaker	Material number	Available
	SOLT 050204-HCD GTPP425	...-HCD	P	MM12421657
	SOLT 050204-CCD GTPK415	...-CCD	K	MM12421662
	SOLT 050204-SCD GTPP440	...-SCD	M	MM12421661
	SOLT 050204-HCD GTPP440	...-HCD	S	MM12421660

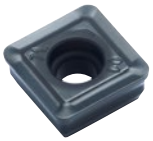


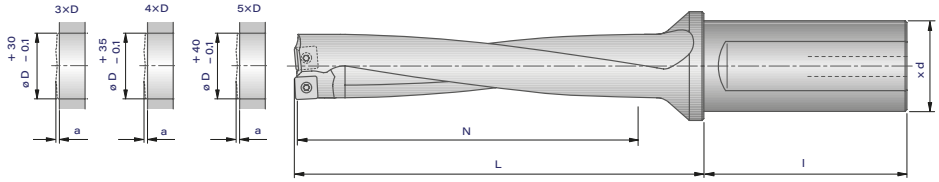
Tools	Ø [mm]	Designation	Ø d×l [mm]	N [mm]	L [mm]	Material number
	17.0	IDCD.5D.1700.R.20.06	20x50	85	102	MM12568601
	17.5	IDCD.5D.1750.R.25.06	25x56	90	107	MM12568603
	18.0	IDCD.5D.1800.R.25.06	25x56	90	107	MM12568605
	18.5	IDCD.5D.1850.R.25.06	25x56	95	113	MM12568608
	19.0	IDCD.5D.1900.R.25.06	25x56	95	113	MM12568614
	19.5	IDCD.5D.1950.R.25.06	25x56	100	118	MM12568616

Insert	Designation	Chipbreaker	Material number	Available
	SOLT 06T206-HCD GTPP425	...-HCD	P	MM12421690
	SOLT 06T206-CCD GTPK415	...-CCD	K	MM12421699
	SOLT 06T206-SCD GTPP440	...-SCD	M	MM12421695
	SOLT 06T206-HCD GTPP440	...-HCD	S	MM12421693

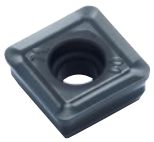
Available range 5xD:
∅20.0 mm ∅28.0 mm

Tools	∅ [mm]	Designation	∅ d×l [mm]	N [mm]	L [mm]	Material number
	20.0	IDCD.5D.2000.R.25.07	25x56	100	118	MM12568649
	20.5	IDCD.5D.2050.R.25.07	25x56	105	124	MM12568716
	21.0	IDCD.5D.2100.R.25.07	25x56	105	124	MM12568738
	21.5	IDCD.5D.2150.R.25.07	25x56	110	129	MM12568741
	22.0	IDCD.5D.2200.R.25.07	25x56	110	129	MM12568747
	22.5	IDCD.5D.2250.R.25.07	25x56	115	135	MM12568749
	23.0	IDCD.5D.2300.R.25.07	25x56	115	135	MM12568753

Insert	Designation	Chipbreaker	Material number	Available
	SOLT 070308-HCD GTPP425	...-HCD	P	MM12421701
	SOLT 070308-CCD GTPK415	...-CCD	K	MM12421711
	SOLT 070308-SCD GTPP440	...-SCD	M	MM12421704
	SOLT 070308-HCD GTPP440	...-HCD	S	MM12421702

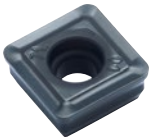


Tools	Ø [mm]	Designation	Ø d×l [mm]	N [mm]	L [mm]	Material number
	23.5	IDCD.5D.2350.R.32.08	32x60	120	140	MM12568771
	24.0	IDCD.5D.2400.R.32.08	32x60	125	140	MM12568772
	24.5	IDCD.5D.2450.R.32.08	32x60	125	146	MM12568775
	25.0	IDCD.5D.2500.R.32.08	32x60	130	146	MM12568776
	25.5	IDCD.5D.2550.R.32.08	32x60	130	151	MM12568777
	26.0	IDCD.5D.2600.R.32.08	32x60	135	151	MM12568778
	26.5	IDCD.5D.2650.R.32.08	32x60	135	157	MM12568779
	27.0	IDCD.5D.2700.R.32.08	32x60	135	157	MM12568780
	27.5	IDCD.5D.2750.R.32.08	32x60	140	162	MM12568781
	28.0	IDCD.5D.2800.R.32.08	32x60	140	162	MM12568782

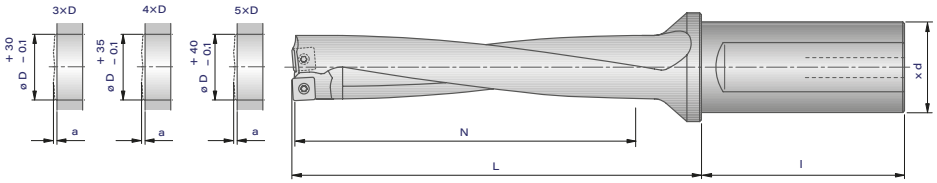
Insert	Designation	Chipbreaker	Material number	Available
	SOLT 080308-HCD GTPP425	...-HCD	P	MM12421717
	SOLT 080308-CCD GTPK415	...-CCD	K	MM12421752
	SOLT 080308-SCD GTPP440	...-SCD	M	MM12421750
	SOLT 080308-HCD GTPP440	...-HCD	S	MM12421720

Available range 5xD:
∅28.5 mm – ∅38.0 mm

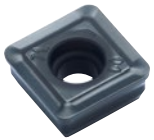
Tools	∅ [mm]	Designation	∅ d×l [mm]	N [mm]	L [mm]	Material number
	28.5	IDCD.5D.2850.R.32.10	32x60	145	168	MM12568783
	29.0	IDCD.5D.2900.R.32.10	32x60	145	168	MM12568784
	29.5	IDCD.5D.2950.R.32.10	32x60	150	173	MM12568786
	30.0	IDCD.5D.3000.R.32.10	32x60	150	173	MM12568787
	30.5	IDCD.5D.3050.R.40.10	40x68	155	179	MM12568788
	31.0	IDCD.5D.3100.R.40.10	40x68	155	179	MM12568789
	31.5	IDCD.5D.3150.R.40.10	40x68	160	184	MM12568790
	32.0	IDCD.5D.3200.R.40.10	40x68	160	184	MM12568793
	32.5	IDCD.5D.3250.R.40.10	40x68	165	190	MM12568795
	33.0	IDCD.5D.3300.R.40.10	40x68	165	190	MM12568797



Insert	Designation	Chipbreaker	Material number	Available
	SOLT 10T308-HCD GTPP425	...-HCD	P	MM12421756
	SOLT 10T308-CCD GTPK415	...-CCD	K	MM12421772
	SOLT 10T308-SCD GTPP440	...-SCD	M	MM12421771
	SOLT 10T308-HCD GTPP440	...-HCD	S	MM12421757

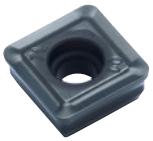


Tools	Ø [mm]	Designation	Ø d×l [mm]	N [mm]	L [mm]	Material number
	33.5	IDCD.5D.3350.R.40.11	40x68	170	195	MM12568830
	34.0	IDCD.5D.3400.R.40.11	40x68	170	195	MM12568831
	34.5	IDCD.5D.3450.R.40.11	40x68	175	201	MM12568832
	35.0	IDCD.5D.3500.R.40.11	40x68	175	206	MM12568833
	35.5	IDCD.5D.3550.R.40.11	40x68	180	206	MM12568834
	36.0	IDCD.5D.3600.R.40.11	40x68	180	212	MM12568835
	36.5	IDCD.5D.3650.R.40.11	40x68	185	212	MM12568836
	37.0	IDCD.5D.3700.R.40.11	40x68	185	212	MM12568837
	37.5	IDCD.5D.3750.R.40.11	40x68	190	217	MM12568838
	38.0	IDCD.5D.3800.R.40.11	40x68	190	217	MM12568839

Insert	Designation	Chipbreaker	Material number	Available
	SOLT 110408-HCD GTPP425	...-HCD	P	MM12421773
	SOLT 110408-CCD GTPK415	...-CCD	K	MM12421777
	SOLT 110408-SCD GTPP440	...-SCD	M	MM12421776
	SOLT 110408-HCD GTPP440	...-HCD	S	MM12421775

Available range 5xD:
∅38.5 mm – ∅44.0 mm

Tools	∅ [mm]	Designation	∅ dxl [mm]	N [mm]	L [mm]	Material number
	38.5	IDCD.5D.3850.R.40.13	40x68	195	223	MM12568848
	39.0	IDCD.5D.3900.R.40.13	40x68	195	223	MM12568853
	39.5	IDCD.5D.3950.R.40.13	40x68	200	228	MM12568856
	40.0	IDCD.5D.4000.R.40.13	40x68	200	228	MM12568857
	40.5	IDCD.5D.4050.R.40.13	40x68	205	234	MM12568859
	41.0	IDCD.5D.4100.R.40.13	40x68	205	234	MM12568861
	41.5	IDCD.5D.4150.R.40.13	40x68	210	239	MM12568863
	42.0	IDCD.5D.4200.R.40.13	40x68	210	239	MM12568868
	42.5	IDCD.5D.4250.R.40.13	40x68	215	245	MM12568875
	43.0	IDCD.5D.4300.R.40.13	40x68	215	245	MM12568879
	43.5	IDCD.5D.4350.R.40.13	40x68	220	250	MM12568880
	44.0	IDCD.5D.4400.R.40.13	40x68	220	250	MM12568882



Insert	Designation	Chipbreaker	Material number	Available
	SOLT 130508-HCD GTPP425	...-HCD	P	MM12421779
	SOLT 130508-CCD GTPK415	...-CCD	K	MM12421783
	SOLT 130508-SCD GTPP440	...-SCD	M	MM12421782
	SOLT 130508-HCD GTPP440	...-HCD	S	MM12421780

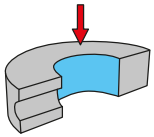
Technical information

Guideline values for solid drilling					Cutting speed v_c (m/min)								
						 GTPP425 (M/Min)			 GTPP440 (M/Min)			 GTPK415 (M/Min)		
Material group	Strength Rm (N/mm²)	Hardness HB	Material	Material example, material code/DIN	Geometry	min	opt.	max	min	opt.	max	min	opt.	max
P 1.0	≤ 500		non-alloy steels	1.0037 (S235JR) 1.0715 (11SMn30) 1.0044 (S2575JR)	_HCD	200	260	320	–	–	–	–	–	–
P 2.0	500-900		non-alloy / low alloy steels	1.0050 (E295) 1.0535 (C55) 1.7131 (16MnCr5)	_HCD	250	270	300	–	–	–	–		
P 2.1	< 500		lead alloys	1.0718 (11SMnPb30)	_HCD	200	260	320	–	–	–	–	–	–
P 3.0	> 900		low alloy steels: heat resistant structural, heat treated, nitride and tools steels	1.7225 (42CrMo4) 1.1221 (C60E)	_HCD	140	180	220	–	–	–	–		
P 4.0	> 900		high alloy steels	1.2341 (6CrMo15-5) 1.2601 (X165CrMoV12)	_HCD	120	160	200	–	–	–	–	–	–
P 4.1			HSS		_HCD	50	70	90	–	–	–	–		
S 5.0		250	special alloys: Inconel, Hastelloy, Nimonic, stc.	2.4668 (NiuCr19Fe19Nb5Mo3) 2.4631 (Nimonic 80A)	_HCD	–	–	–	20	40	60	–	–	–
S 5.1	400		titanium, titanium alloys	3.7115 (TiAl5Sn2.5)	_HCD	–	–	–	40	60	60	–		
M 6.0	≤ 600		stainless steels	1.4306 (X2CrNi19-11) 1.4401 (X5CrNiMo17-12-2)	_SCD	–	–	–	140	180	220	–	–	–
M 6.1	< 900		stainless steels	1.4511 (X3CrNb17) 1.4571 (X10CrNiMoTi17-12-2)	_SCD	–	–	–	120	160	200	–		
M 7.0	> 900		stainless / fireproof steels	1.4713 (X10CrAlSi7) 1.4862 (X8NiCrSi38-18)	_SCD	–	–	–	120	160	200	–	–	–
K 8.0		180	gray cast iron	0.6025 (EN-GJL-250) 0.6035 (EN-GJL-350)	_CCD	–	–	–	–	–	–	160	240	
K 8.1		250	alloy gray cast iron	0.6660 (GGL-NiCr20 2)	_CCD	–	–	–	–	–	–	100	140	180
K 9.0	≤ 600	130	spheroidal graphite cast iron, ferritic	0.7040 (EN-GJS-400-15)	_CCD	–	–	–	–	–	–	120	160	
K 9.1		230	spheroidal graphite cast iron, ferritic/perlitic	0.7050 (EN-GJS-500-7) 0.7055 (GJS-55) 0.8055 (GTW-55)	_CCD	–	–	–	–	–	–	100	140	180
K 10.0	> 600	250	spheroidal graphite cast iron, perlitic malleable iron	0.7060 (EN-GJS-600-3) 0.8165 (GTS-65)	_CCD	–	–	–	–	–	–	90	120	
K 10.1		200	alloyed spheroidal graphite cast iron	0.7661 (EN-GJSA-XNiCr20-2)	_CCD	–	–	–	–	–	–	90	120	150
K 10.2		300	vermicular cast iron	EN-GJV Ti < 0,2 EN-GJV Ti > 0,2	_CCD	–	–	–	–	–	–	70	100	

Cutting values shown are relating to the basic recommendations for cutting materials given.

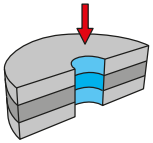
Feed f (mm/rev)						
Ø 14 – 16.5 f (mm/rev)	Ø 17 – 19.5 f (mm/rev)	Ø 20 – 23 f (mm/rev)	Ø 23.5 – 28 f (mm/rev)	Ø 28.5 – 33 f (mm/rev)	Ø 33.5 – 38 f (mm/rev)	Ø 38.5 – 44 f (mm/rev)
0.04 – 0.1	0.08 – 0.1	0.06 – 0.12	0.06 – 0.12	0.06 – 0.12	0.06 – 0.12	0.06 – 0.12
0.04 – 0.14	0.1 – 0.15	0.11 – 0.16	0.11 – 0.16	0.11 – 0.13	0.11 – 0.16	0.11 – 0.16
0.06 – 0.16	0.1 – 0.16	0.13 – 0.18	0.13 – 0.2	0.15 – 0.2	0.15 – 0.2	0.15 – 0.2
0.06 – 0.16	0.11 – 0.16	0.13 – 0.22	0.14 – 0.22	0.14 – 0.22	0.14 – 0.22	0.14 – 0.22
0.06 – 0.15	0.1 – 0.15	0.12 – 0.22	0.14 – 0.22	0.14 – 0.22	0.14 – 0.22	0.14 – 0.22
0.04 – 0.1	0.04 – 0.1	0.05 – 0.1	0.06 – 0.12	0.07 – 0.13	0.07 – 0.14	0.08 – 0.15
0.04 – 0.08	0.04 – 0.08	0.05 – 0.9	0.06 – 0.10	0.07 – 0.11	0.07 – 0.11	0.08 – 0.12
0.04 – 0.1	0.04 – 0.1	0.05 – 0.1	0.06 – 0.12	0.07 – 0.13	0.07 – 0.14	0.08 – 0.15
0.06 – 0.12	0.08 – 0.12	0.1 – 0.18	0.12 – 0.18	0.1 – 0.18	0.1 – 0.18	0.1 – 0.18
0.06 – 0.12	0.08 – 0.12	0.1 – 0.18	0.12 – 0.18	0.12 – 0.18	0.12 –0.18	0.12 – 0.18
0.06 – 0.1	0.06 – 0.16	0.09 – 0.16	0.1 – 0.16	0.1 – 0.16	0.1 – 0.16	0.1 – 0.16
0.08 – 0.18	0.1 – 0.18	0.14 – 0.25	0.18 – 0.3	0.2 – 0.3	0.2 – 0.3	0.2 – 0.3
0.08 – 0.16	0.1 – 0.16	0.12 – 0.23	0.16 – 0.28	0.18 – 0.28	0.18 – 0.28	0.18 – 0.28
0.08 – 0.18	0.12 – 0.18	0.14 – 0.25	0.18 – 0.3	0.2 – 0.3	0.2 – 0.3	0.2 – 0.3
0.08 – 0.18	0.12 – 0.18	0.14 – 0.25	0.18 – 0.3	0.2 – 0.3	0.2 – 0.3	0.2 – 0.3
0.08 – 0.18	0.12 – 0.18	0.14 – 0.25	0.18 – 0.3	0.2 – 0.3	0.2– 0.3	0.2 – 0.3
0.08 – 0.16	0.1 – 0.16	0.12 – 0.23	0.16 – 0.28	0.18 – 0.28	0.18 – 0.28	0.18 – 0.28
0.08 – 0.15	0.09 – 0.15	0.11 – 0.22	0.15 – 0.27	0.17 – 0.27	0.17 – 0.27	0.17 – 0.27

Applications



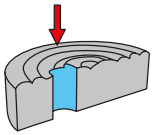
Producing a transverse through hole

Reduce the feed when the drill enters the transverse hole. With transverse bores you should drill from both sides if possible.
Reduce feed rate between 30 and 60% (depending on the proportion of hole to transverse hole).



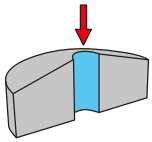
Stack drilling

When stack drilling ensure that there is either no gap or the maximum gap possible. Good work piece clamping is required.



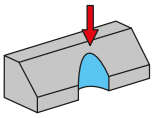
Drilling on an uneven surface

Depending on the surface quality, reduce the feed rate when drilling.



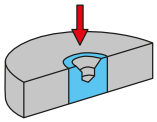
Drilling of a convex surface

When the drill enters the convex work piece surface, the central insert cuts first.



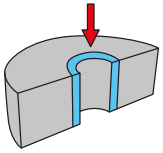
Drilling on inclined surfaces

When the drill enters or exits at an angle to the work piece surface, reduce the feed rate by 30 to 60%.



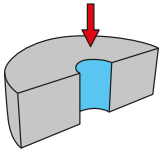
Spot drilling in a central hole

When spot drilling in a bead or central hole, reduce the feed rate by up to 50%.



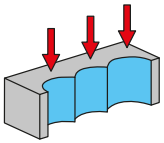
Reboring

Possible.



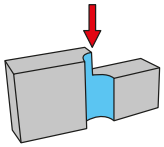
Drilling into solid material

Possible.



Chain drilling

It is important to ensure a symmetrical distribution. Reduce the feed rate to 50% in case of cut interruption. Use tough insert types and a corner radius for optimal results.

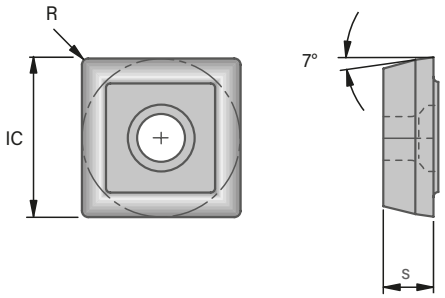


Drilling on a stepped surface

Due to the undefined drilling surface, pre-machining is required (face countersinking, face milling).

SOLT inserts

Geometry:



Grades and materials:

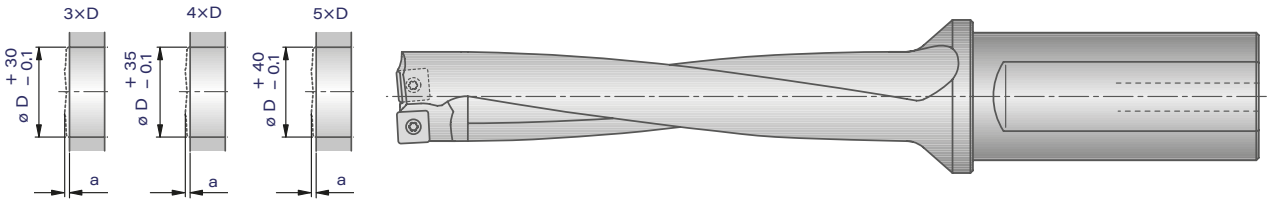
Material group		Grade
P	Steel	GTPP425
M	Stainless steel	GTPP440
K	Cast iron	GTPK415
S	Super alloys	GTPP440

Spare parts screws:

Insert	Clamping screw description	Material	Key size	IC [mm]	s [mm]	R [mm]
SOLT 050204	S/M2x4,3-6IP	MM12633706	T06IP	5.0	2.1	0.4
SOLT 06T206	S/M2,2x5,5-6IP	MM12633715	T06IP	5.8	2.5	0.6
SOLT 070308	S/M2,5x6,3-8IP	MM12633722	T08IP	6.9	3.0	0.8
SOLT 080308	S3070-8IP	MM12633723	T08IP	8.4	3.5	0.8
SOLT 10T308	S3575-15IP	MM12633726	T15IP	10.3	4.0	0.8
SOLT 110408	S3585-15IP	MM12633729	T15IP	11.1	4.4	0.8
SOLT 130508	S45100-20IP	MM12633734	T20IP	13.3	5.0	0.8

Indexable insert drill

Geometry:



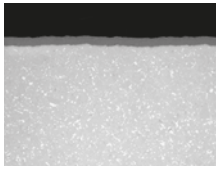
∅ [mm]		Radius [mm]	a [mm]
14.0	IC5.0 Ø14.0- Ø16.50	R0.4	1.5
14.5			
15.0			
15.5			
16.0			
16.5			
17.0	IC5.8 Ø16.60- Ø19.50	R0.6	1.7
17.5			
18.0			
18.5			
19.0			
19.5			
20.0	IC6.9 Ø19.60- Ø23.00	R0.8	1.9
20.5			
21.0			
21.5			
22.0			
22.5			
23.0			

∅ [mm]		Radius [mm]	a [mm]
23.5	IC8.4 Ø23.10- Ø28.00	R0.8	2.3
24.0			
24.5			
25.0			
25.5			
26.0	IC8.4 Ø23.10- Ø28.00	R0.8	2.3
26.5			
27.0			
27.5			
28.0			
28.5	IC10.3 Ø28.10- Ø33.00	R0.8	2.7
29.0			
29.5			
30.0			
30.5			
31.0			
31.5			
32.0			
32.5			
33.0			

∅ [mm]		Radius [mm]	a [mm]
33.5	IC11.1 Ø33.10- Ø38.00	R0.8	2.9
34.0			
34.5			
35.0			
35.5			
36.0	IC11.1 Ø33.10- Ø38.00	R0.8	2.9
36.5			
37.0			
37.5			
38.0			
38.5	IC13.3 Ø38.10- Ø44.00	R0.8	3.1
39.0			
39.5			
40.0			
40.5			
41.0			
41.5			
42.0			
42.5			
43.0			
43.5			
44.0			

Grade overview

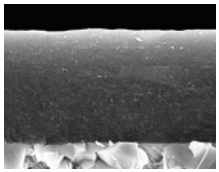
GTPP425 **HC-P25 I HC-M25**



Specification:
Composition: Co 9.0%; mixed carbides 4.0%; WC balance | Grain size: fine/medium | Hardness: HV_{30} 1510 | Coating specification: PVD TiAlN/TiN

Recommended application:
Particularly suitable for the machining of steels.

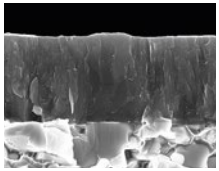
GTPP440 **HC-M40 I HC-P40**



Specification:
Composition: Co 9.0%; mixed carbides 0.7%; others 0.7%; WC balance |
Grain size: submicron | Hardness: HV_{30} 1590 | Coating specification: PVD TiAlN

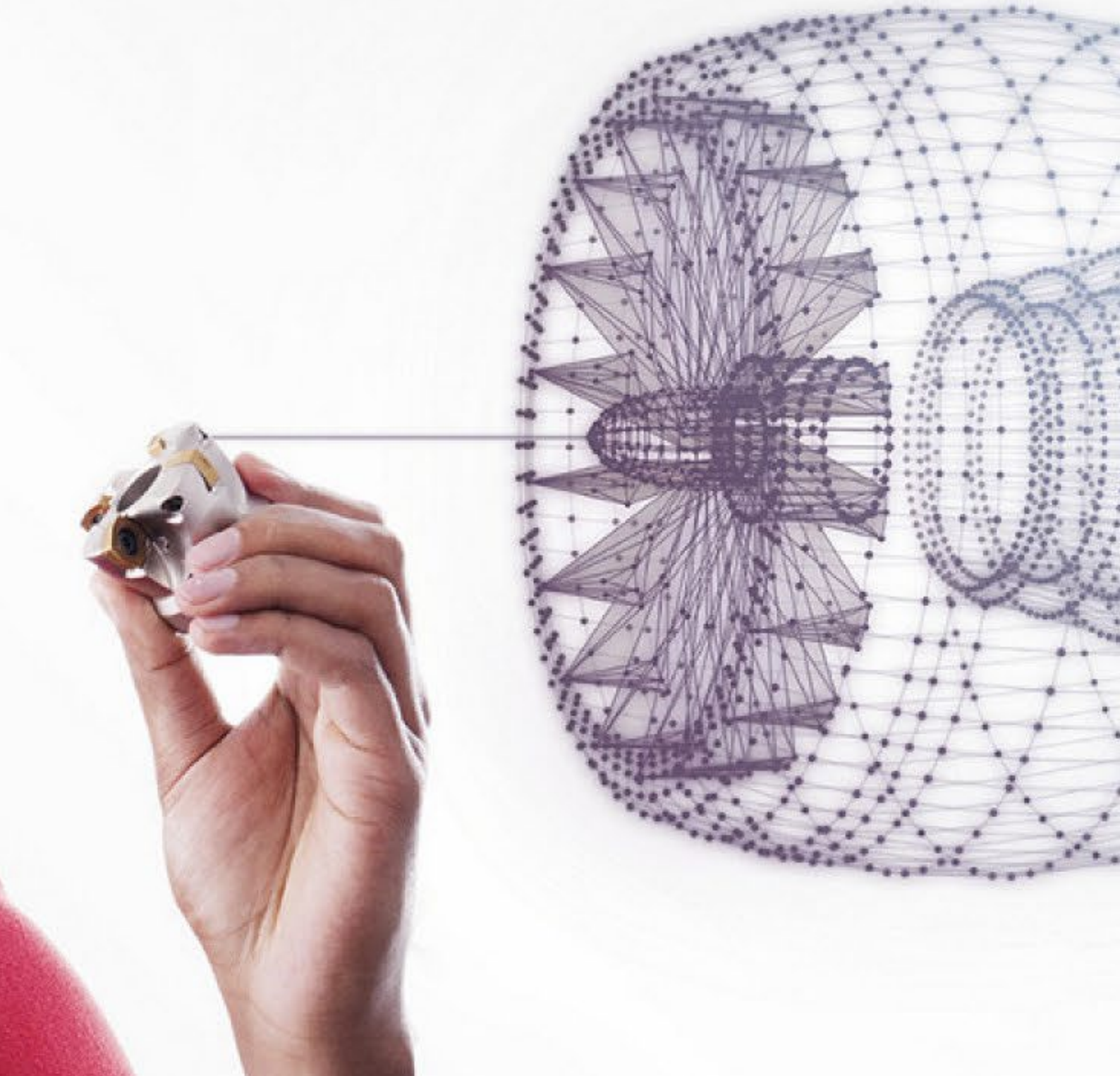
Recommended application:
The first choice for the machining of austenitic steels as well as heat-resistant alloys.

GTPK415 **HC-K15**



Specification:
Composition: Co 6.0%; WC balance; mixed carbides 2.0% ; Grain size: fine |
Hardness: HV_{30}1630

Recommended application:
Suitable for cast iron machining.



GALTONA designation system: Insert

Insert shape

A	85°	
B	82°	
K	55°	
H	120°	
L	90°	
O	135°	
P	108°	
C	80°	
D	55°	
E	75°	
M	86°	
V	35°	
R		
S	90°	
T	60°	
W	80°	
X Z	Special shapes	

Clearance angle

	α
A	3°
B	5°
C	7°
D	15°
E	20°
F	25°
G	30°
N	0°
P	11°
O	Special version

Tolerances

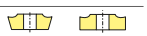
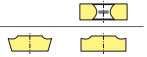
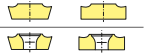
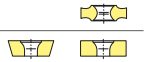
	d [± mm]	m [± mm]	s [± mm]	d=6.35/9.52	d=12.7	d=15.8/19.05
A	0.025	0.005	0.025	●	●	●
C	0.025	0.013	0.025	●	●	●
E	0.025	0.025	0.025	●	●	●
F	0.013	0.005	0.025	●	●	●
G	0.025	0.025	0.13	●	●	●
H	0.013	0.013	0.025	●	●	●
	0.05	0.005	0.025	●		
J	0.08	0.005	0.025		●	
	0.10	0.005	0.025			●
	0.05	0.013	0.025	●		
K	0.08	0.013	0.02		●	
	0.10	0.013	0.02			●
	0.05	0.08	0.13	●		
M	0.08	0.13	0.13		●	
	0.10	0.15	0.13			●
	0.05	0.08	0.025	●		
N	0.08	0.13	0.025		●	
	0.10	0.15	0.025			●
	0.08	0.13	0.13	●		
U	0.13	0.20	0.13		●	
	0.18	0.27	0.13			●

Insert thickness

Index	s [mm]
02	2.1
T2	2.5
03	3.0
T3	3.5
04	4.0
05	5.0

S	O	L	T	-	05	02	08	-	CCD

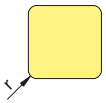
Form of top surface

A	
F	
G	
M	
N	
Q	
R	
T	
U	
W	
X	Special shapes

Insert size

Type	Index	[mm]
S	05	5.0
	06	5.8
	07	6.9
	08	8.4
	10	10.3
	11.1	11.6
	13	13.3

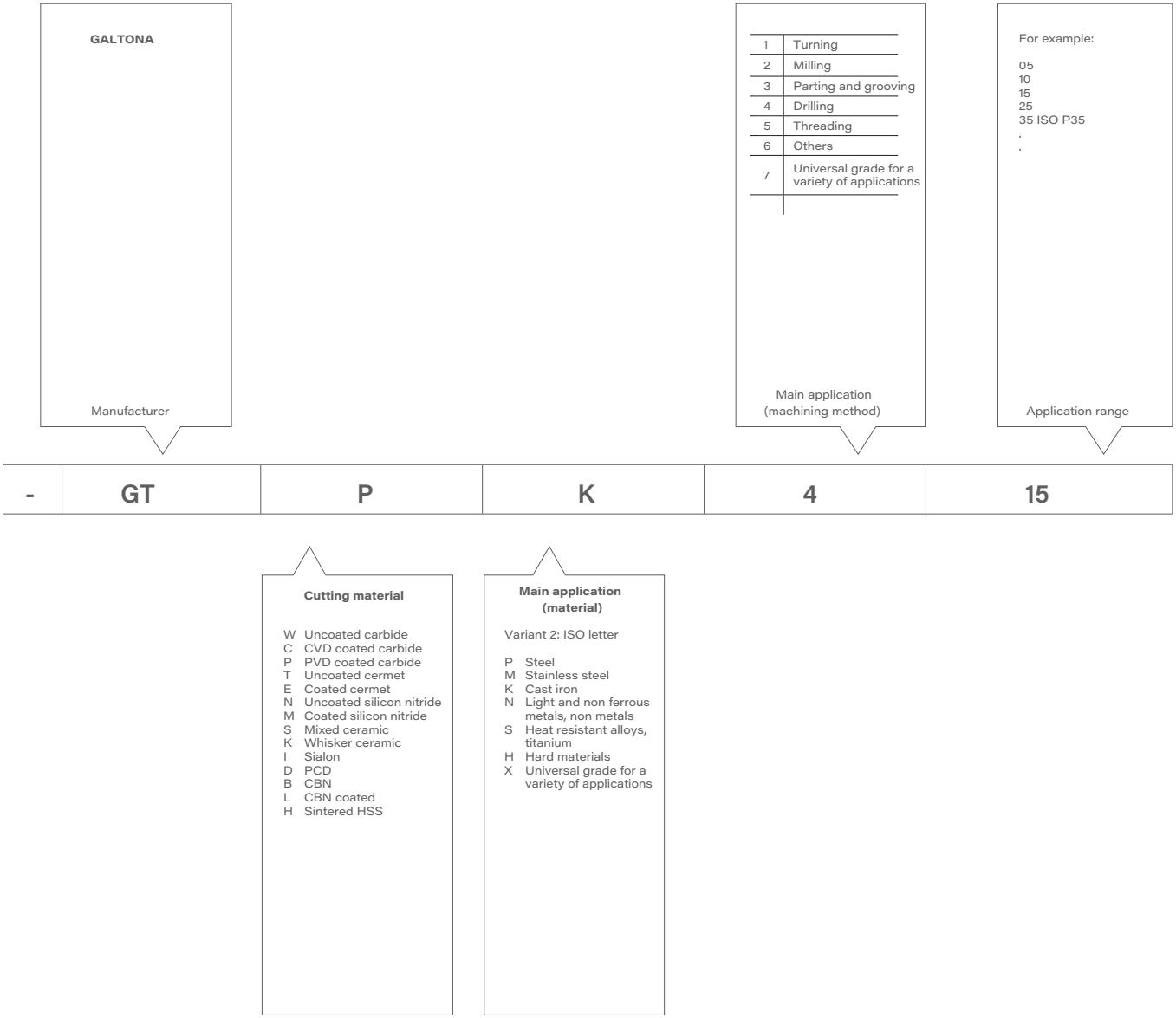
Corner radius



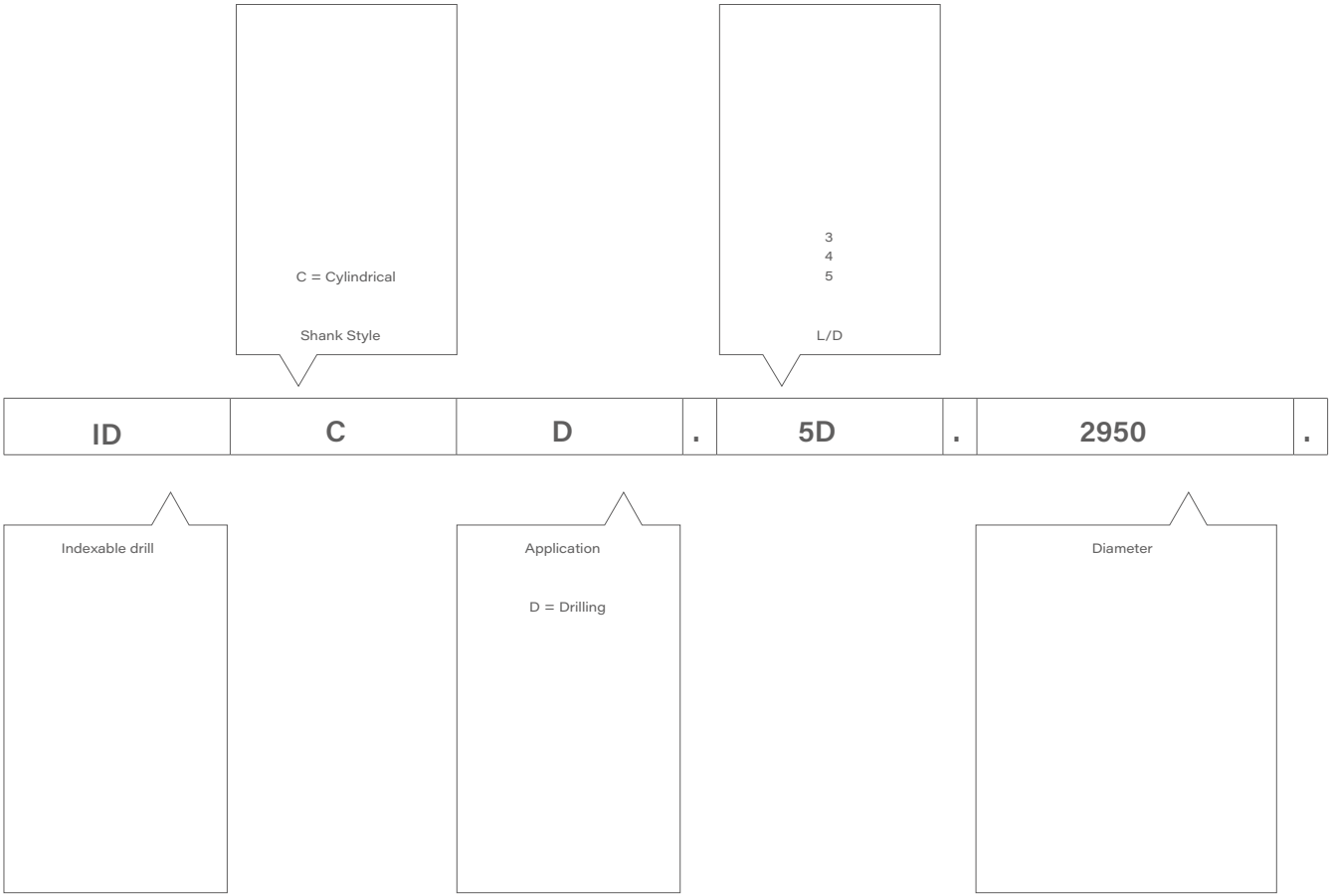
Index	r [mm]
05	0.4
06	0.6
07	0.8
08	0.8
10	0.8
12	0.8
13	0.8

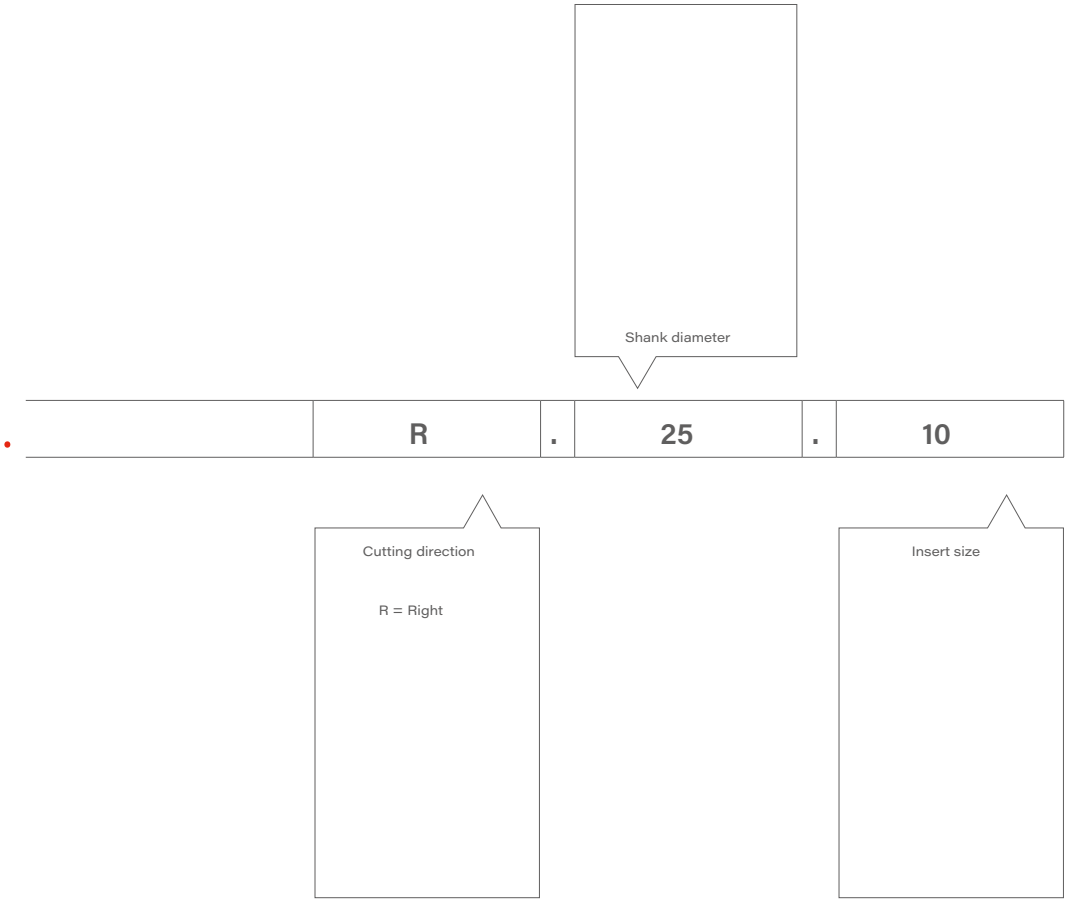
Chipformer

HCD	Steel machining
SCD	Stainless Steel machining
CCD	Cast Iron machining


GALTONA
Manufacturer
1 Turning
2 Milling
3 Parting and grooving
4 Drilling
5 Threading
6 Others
7 Universal grade for a variety of applications
Main application (machining method)
For example:
05
10
15
25
35 ISO P35
.
.
Application range
-
GT
P
K
4
15
Cutting material
W Uncoated carbide
C CVD coated carbide
P PVD coated carbide
T Uncoated cermet
E Coated cermet
N Uncoated silicon nitride
M Coated silicon nitride
S Mixed ceramic
K Whisker ceramic
I Sialon
D PCD
B CBN
L CBN coated
H Sintered HSS
Main application (material)
Variant 2: ISO letter
P Steel
M Stainless steel
K Cast iron
N Light and non ferrous metals, non metals
S Heat resistant alloys, titanium
H Hard materials
X Universal grade for a variety of applications

GALTONA Designation system: Tool holder




Shank diameter
R
.
25
.
10
Cutting direction
R = Right
Insert size

DESIGN AND
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