NEW TBX COBALT DRILL BITS – 4 FACET POINT

A concentration of technology....

A Tivoly Exclusive

OV, 07/2012
NEW TBX COBALT DRILL BITS – 4 FACET POINT – leading edge technology

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NEW TBX COBALT DRILL BITS – 4 FACET POINT

Drilling Innovation - a continuous process

- User driven process
  - Consultation
  - Understanding applications
  - Defining needs
  - Prioritisation

Our close contacts with industry enable us to define the broad range of users requirements very precisely and respond with targeted product solutions.

- Industrial Market – Driver of research & development
  - Problem analysis
  - Research & Development
  - Defining solutions
  - Manufacturing

Tivoly’s is a major supplier of hand held drilling products to the aerospace industry. We develop customer specific product solutions for high volume industrial production and within tight production cost constraints.
**NEW TBX COBALT DRILL BITS – 4 FACET POINT**

**Stainless Steel – an application with specific requirements**

New Generation Drill bit TBX-4F designed for drilling austenitic stainless steels (type 304L & 316L)

Stainless represents 24% of steel drilling applications

Austentitic Stainless steels represent 84% of stainless drilling applications

<table>
<thead>
<tr>
<th>Stainless Steel types</th>
<th>Composition</th>
<th>Features</th>
<th>Applications</th>
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</thead>
<tbody>
<tr>
<td>FERRITIC</td>
<td>Chromium (12-30%)</td>
<td>TB Corrosion resistant</td>
<td>Interior Decor Pumps</td>
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<td></td>
<td></td>
<td>Poor heat and cold resistance</td>
<td></td>
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<tr>
<td>MARTENSITIC</td>
<td>Chromium (12-18%)</td>
<td>Mechanical properties GradeB</td>
<td>(18-0) Cutlery</td>
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<tr>
<td></td>
<td>Carbone (0,05-1,2%)</td>
<td>Corrosion resistance B</td>
<td></td>
</tr>
<tr>
<td>AUSTENTITIC</td>
<td>Chrome (16-35%)</td>
<td>Ductility (Hot/cold) TB</td>
<td>18/8(304) Food industries, Decorative, exterior protective surfaces, vats &amp; tubes(316L) Biomedical</td>
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<tr>
<td></td>
<td>Nickel (7-26%)</td>
<td>Weldability B</td>
<td></td>
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<tr>
<td></td>
<td>Carbone (0,1%)</td>
<td>Low surface roughness</td>
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With a production quantity of 600k pieces per annum, TBX represents the second most important drill bit category stocked and sold by our distributors.
NEW TBX COBALT DRILL BITS – 4 FACET POINT
A range positioned to achieve optimum performance

New TBX 4F drill bits are at the very heart of the drilling range

With the TZX and the NEW TBX-4F Tivoly offers a core range of metal drill bits with genuine added value. These innovations reinforce the Tivoly Distributor’s position as a true specialist, providing the necessary technical and commercial tools guaranteed to ensure sales growth.
NEW TBX COBALT DRILL BITS – 4 FACET POINT
Demanding High Performance

Drilling in stainless steel grades 304L & 316

Drilling in stainless steel poses a number of serious challenges for cutting tools

**Strength and Flexibility**: greater cutting force/speed is required to avoid the creation of a long continuous steel chip and produce smaller fragments. The cutting edges are therefore exposed to greater abrasion forces.

**Low thermal conductivity**: heat dissipates slowly from the workpiece and from the cutting chips. The drill bit is subjected to excess heat leading to more rapid deterioration and wear.

Current drill bits available in the market all suffer from excessively rapid wear as well as requiring significant additional drilling effort to obtain a relatively clean and precise hole.

Key objective for the TIVOLY TBX development team - design a drill bit to overcome these major end user obstacles focussing on the following aspects of performance:

- Product Life
- User comfort & ease of drilling
- Productivity
- Hole accuracy
NEW TBX COBALT DRILL BITS – 4F
A new generation of tip design

4 Facet Point Project Plan « a concentration of technology »

SCOPE

• User needs (hand held and stationary drilling)
• Production capacity (600k pieces)
• Design vs Cost

TIVOLY R&D Centre CRAOC – development output:

A drill bit which combines several flat main cutting angles (Tivoly exclusive) relief and draft angles leading to a thinner web and combined with a highly resistant cobalt base material

- Geometric Stability
- Stronger tip
- Wear distribution across relief angle
- Chip breaking

- Easier drilling
- Increased bit life
- Improved cutting conditions
- Increased productivity
- Greater control of diametrical accuracy
- Wider application ‘window’
NEW TBX COBALT DRILL BITS – 4F
A world manufacturing exclusive

Over the last 3 years TIVOLY has made major investments in exclusive automated technology at its Albertville manufacturing site in France. Developments include:

- grinding for main cutting angles, for draft and relief angles and for web thickness reduction without additional tool modification
- manufacturing capacity and efficiency requirements for volume drill bit production

Tivoly is the first worldwide manufacturer to offer a range of HSS drill bits with a four facet tip grind to the maintenance distribution sector.
NEW TBX COBALT DRILL BITS – 4F

New levels of technical performance

A winning combination

- New 4 face « flat » tip grind
- Blade drill bit protective coating
- Cobalt metal bit body HSCOB

Drilling life with lubricant d= 6 mm – 304L
Vc = 12 m/mn – N = 637 tr/mn – f = 0.10 – vf = 63.70 mm/mn

Drilling footprint / barb4left

SP drill bit

TBX 4F bit

Hole geometry without lubricant d= 6 mm – 304L
Vc = 8 m/mn – N = 426 tr/mn – f = 0.1 – vf = 42.46 mm/mn

Measurement of drilling force with lubricant d= 6 mm – 304L
Vc = 12 m/mn – N = 637 tr/mn – f = 0.10 – vf = 63.70 mm/mn

TIVOLY ‘BLADE’ COATING

Multiple layers TiAlN + TiCN

3300 HV hardness – resists abrasion and creates an anti-friction barrier prolonging tool life and performance. Surface heat treatment of 700° creates a thermal anti rust protection on the working part of the bit. A friction coefficient of 0.4 helps to reduce the effects of adhesion between bit and workpiece and allows easier drilling.
NEW TBX COBALT DRILL BITS – TBX4F
A new level of environmental performance

TBX 4F, The first 4 face « flat grind » tip drill bit made specifically for professional users in metalworking, locksmithing, general mechanical and maintenance tasks has been designed and manufactured in France to be as environmentally friendly as possible.

TIVOLY manufacturing

- uses recyclable materials
- minimises amount of material removal
- recycles manufacturing waste
- maintains lower energy consumption

As well as benefiting from the TBX 4F « Blade » coated bit drilling performance the ENDUSER assists Tivoly’s efforts towards sustainable development

- Operator saves time and effort
- Reduced power consumption (esp cordless)
- Increased tool life
- Increased battery life
- Increased equipment life