

HOLEMAKING



HOLEMAKING



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Guide to Icons



➤ External Coolant



➤ Internal Coolant



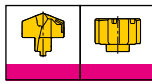
➤ Through Hole



➤ Blind Hole



➤ Tube Page



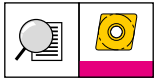
➤ Head Page



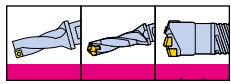
➤ Pad Page



➤ Cartridge Page



➤ Insert Page



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➤ Assembly Page



➤ Technical Data Page



➤ Cutting Condition Page



Reaming Tools

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Recommended Cutting Conditions

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Technical Data

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Tailor-made Order Form

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Tool Selection Guide

Drilling tools

Series			Indexable drill				
			<i>TOPDRILL</i>		<i>TDRILL</i>		<i>TOPCAP</i>
			TOP 2/3/4/5	TOP-CA	TDR 2/3/4/5	TDR-CA	TCAP
							
Pages			D18-D29	D30-D33	D34-D46	D47-D49	D51-D53
DC(mm)			Ø12.0-Ø50.0	Ø51.0-Ø80.0	Ø12.5-Ø50.0	Ø51.0-Ø80.0	Ø8.0-Ø32.0
Drilling depth(L/D)			2, 3, 4, 5 x Dc	2, 3, 4 x Dc	2, 3, 4, 5 x Dc	2.5, 3.5 x Dc	2.25, 3 x Dc
Hole tolerance			IT 11-13	IT 12-13	IT 12-13	IT 12-13	IT 10-12
Application	General drilling		●	●	●	●	●
	Cross hole drilling		●	●	●	●	
	Irregular surface drilling		○	○	○	○	●
	Interrupted drilling		○	○	○	○	
	Chamfering						
Coolant supply			Internal	Internal	Internal	Internal	Internal

Tool Selection Guide

Drilling tools

Head changeable drill					
 3ED	 TCD...A0	 TCD	 TCD-M	 TCD...A0 3/5/8D	 TCD-MRS/TCDM
					
D55-D57	D58	D59-D67	D68	D70	D71-D74
Ø12.0-Ø25.9	Ø4.0-Ø5.9	Ø6.0-Ø25.9	M8-M24 (ISO)	Ø6.0-Ø9.9	Ø6.0-Ø20.9
3, 5, 8 x Dc	3, 5 x Dc	1.5, 3, 5, 8, 12 x Dc		3, 5, 8 x Dc	2, 3, 4 x Dc
IT 9-10	IT 9-10	IT 9-10	IT 9-10	IT 9-10	IT 9-10
●	●	●	●	●	●
○	●	●		●	●
			●		
Internal	Internal	Internal	Internal	Internal	Internal

● Recommended, ○ Suitable

Tool Selection Guide

Drilling tools

Series			Head changeable drill			Solid carbide drill
			<i>WINGUN</i>	<i>MODURDRILL</i>	<i>SPADERUSH</i>	<i>SOLID3DRILL</i>
			TCDGN	TNDH-TP/ MDB	LCD	3HD
						
Pages			D125-D126	D75-D79	D80-D82	D83-D88
DC(mm)			Ø10.0-Ø25.9	Ø26.0-Ø50.0	Ø20.0-Ø41.0	Ø4.0-Ø12.0
Drilling depth(L/D)			16, 20 x Dc	3, 5 x Dc	3, 5, 8 x Dc	3, 5, 8, 12 x Dc
Hole tolerance			IT 9-10	IT 10-12	IT 9-10	IT 8-10
Application	General drilling		•	•	•	•
	Cross hole drilling		•	•	•	•
	Irregular surface drilling					
	Interrupted drilling					
	Chamfering					
Coolant supply			Internal	Internal	Internal	Internal

Tool Selection Guide

Drilling tools

Solid carbide drill				
H ² DRILL				
NHD-PE/PI	NHD-KI	SHO 10/15/20	SHO-M	CDF
				
D89-D100	D101-D102	D104	D105	D106
Ø3.0-Ø12.0	Ø3.0-Ø12.0	Ø4.0-Ø10.0	M4-M10 (ISO)	Ø3.0-Ø12.7
3, 5 x Dc	3, 5 x Dc	10, 15, 20 x Dc		
IT 8-10	IT 8-10	IT 8-10	IT 8-10	IT 8-10
●	●	●	●	●
●	●	○		
			●	
External / Internal	Internal	Internal	Internal	External

● Recommended, ○ Suitable

Tool Selection Guide

Reaming tools

Series				Indexable reamer		Solid reamer	
				<i>XM-REAM</i>	<i>TM-REAM</i>	<i>TB-REAM</i>	<i>TS-REAM</i>
				XR-S0	TM	TB	TS
							
Pages				D112-D113	D115	D118-D119	D122-D123
DC(mm)				Ø8.000-Ø12.999	Ø11.501-Ø32.000	Ø8.000-Ø32.000	Ø3.000-Ø12.000
Reaming depth(L/D)				3, 5 x Dc	3, 5, 8 x Dc	5-9 x Dc	7.5-10 x Dc
Hole tolerance				IT 7 ★	IT 7 ★	IT 6 ★★	IT 7
Application		Through	Blind				
	General reaming			●	●	●	●
	Cross hole reaming					●	●
	Irregular surface reaming					●	●
	Interrupted reaming			●	●	●	●
Coolant supply				Internal	Internal	Internal	Internal

★ Up to IT 6 tolerance ★★ Up to IT 5 tolerance

Tool Selection Guide

Deep drilling tools

Series		Indexable deep drill head				
						
		TRGD/TRGD3 /TRGDL	TBTA3	TBTA5	TBTA7	TBTA9
						
Pages		D127-D133	D134-D139	D140-D143	D144-D146	D147-D149
DC(mm)		Ø10.0-Ø36.0	Ø38.00-Ø106.99	Ø107.00-Ø168.99	Ø169.00-Ø232.99	Ø233.00-Ø293.99
Drilling depth(L/D)		10-25 x Dc	100 x Dc	100 x Dc	100 x Dc	100 x Dc
Hole tolerance		IT 10-11	IT 10	IT 10	IT 10	IT 10
Surface finish			3µm	3µm	3µm	3µm
Single tube	Outer four thread		●	●	●	●
	Inner single thread		●	●	●★	●
Double tube	Outer four thread		●	●		

★ In case of inner single thread connection TBTA7 series can cover up to dia. 245.99mm

Series		Indexable deep drill & boring head			Brazed deep drill head	
						
		TBTA-FB	TBTA-TR	TBTA-R	BTA-SE/DE	BTS-SE
						
Pages		D150-D155	D162-D165	D156-D161	D166-D168	D169
DC(mm)		Ø25.00-Ø89.00	Ø16.00-Ø40.00	Ø25.00-Ø110.99	Ø12.60-Ø65.00	Ø8.00-Ø20.00
Drilling depth(L/D)		100 x Dc	100 x Dc	100 x Dc	100 x Dc	100 x Dc
Hole tolerance		IT 10	IT 10	IT 7 - IT 9	IT 9	IT 9
Surface finish		3µm	3µm	1-2µm	2µm	2µm
Single tube	Outer four thread	●	●	●	●	●★
	Inner single thread	●	●	●		
Double tube	Outer four thread	●	●		●	

★ Two start thread: Diameter 12.60 to 15.59mm

● Recommended

Tool Selection Guide

Drill inserts

Series			TOPDRILL	TDRILL	DRILLSPEED	
			SOMT	SPMG / SPGG	3ED-P+	3ED-F
						
Pages			D180-D181	D182-D183	D184-D186	D187
Size			04/05/06/07/08 09/11/13/15	05/06/07/09 11/12/14	Ø12.0-Ø25.9	Ø12.0-Ø25.9
Chip former			DP, DK, DL, DA	DG, DK, DA	P+	F
Grades			TT9080, TT9300 TT8020, TT6080, K10	TT9030, TT8020 TT7400, TT6030, K10	TT5130	TT5130
Application	General drilling		●	●	●	●
	Cross hole drilling		●	●	●	●
	Irregular surface drilling		○	○	○	○
	Interrupted drilling		○	○		
	Chamfering					

Tool Selection Guide

Drill inserts

WINDRILL		DRILLRUSH			
TCD-P	TCD-P/M/K/N	TCD-P+	TCD-F	AOMT	CRNG
					
D188	D189-D195	D196-D200	D201-D202	D203	D203
Ø4.0-Ø5.9	Ø6.0-Ø25.9	Ø6.0-Ø25.9	Ø6.0-Ø25.9	03,04,06-C30/C45	08-45CD
P	P/M/K/N	P+	F	-	-
TT9080	TT9080 UF10	TT9080	TT9080	TT9080	TT9080
●	●	●	●		
●	●	●	●		
○	○	○	○		
				●	●

● Recommended, ○ Suitable

Tool Selection Guide

Drill inserts

Series			MODURDRILL		SPADERUSH	
			TCD-P-CO+	SPGX...DW	LCD-P	LCD-P+
						
Pages			D204	D204	D205-D206	D207
Size			Ø15.9-Ø25.9	06/07/09/11/14	Ø20.0-Ø41.0	Ø20.0-Ø34.5
Chip former			P-CO+	DW	P	P+
Grades			TT9080	TT9080	TT9080	TT9080
Application	General drilling		●	●	●	●
	Cross hole drilling		●	●	●	●
	Irregular surface drilling		○	○	○	○
	Interrupted drilling					
	Chamfering					

Tool Selection Guide

Drill inserts

SPADE RUSH	T CHAMFER	TOP CAP	T DEEP	
LCD-F	XCGT-C	XCGT-TA XCMT	NPHT NPMT	NPMX TPMX
				
D208-D209	D210	D211-D212	D213 -D215	D216
Ø20.0-Ø41.0	06/09	04/05/06/07/08 10/13/17	06/07/08/09 /11/13	08/14/17/24/28
F	C30/C45/C60	TA/GV/TC	R(L)-G... /R(L)-HF...	R-B/R-G
TT9080	TT9080	TT9080, TT8020, TT9030, K10	TT9030, TT9130, TT8125, TT6130, TT5030	TT9030, TT9130, TT8125, TT7200, TT6130, TT6020, TT5100, TT5030
●		●	●	●
●			○	○
○				
	●			

● Recommended, ○ Suitable

Tool Selection Guide

Drill inserts

			TDDEEP			
Series			TOGT	ZSGT	LOGT	TPMX XPMT
						
Pages			D218	D217	D217	D219
Size			07/08/09/10/11 /12/13/14	06	06	14/16/17/24
Chip former			RS/GF	RS	RS	LG/-45
Grades			TT9030	TT9130	TT9130, TT8125	TT9030, TT9130, TT6020, TT5100
Application	General drilling		●	●	●	●
	Cross hole drilling					○
	Irregular surface drilling					
	Interrupted drilling					
	Chamfering					

Tool Selection Guide

Reamer heads & blades

				<i>XM-REAM</i>	<i>TM-REAM</i>	<i>TB-REAM</i>
Series				XR 	TM 	TB 
Pages				D114	D116 - D117	D121
Size				Ø8.000-Ø12.000	Ø11.50-Ø32.000	1/2/3/4
Chip former				AS/BL	AS/BL	A06/B06/B12
Grades				TT9030	TT9030	TT5030, TT5050
Application		Through	Blind			
	General reaming			●	●	●
	Cross hole reaming					
	Irregular surface reaming					
	Interrupted reaming					

● Recommended, ○ Suitable

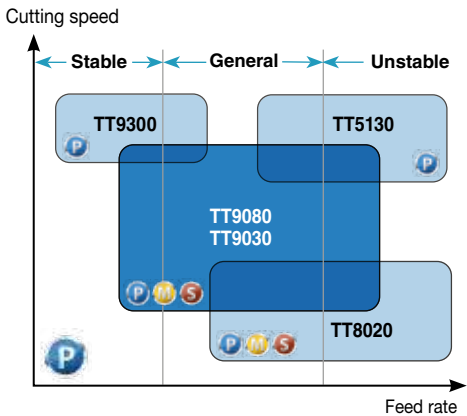
Grades

Holemaking grades

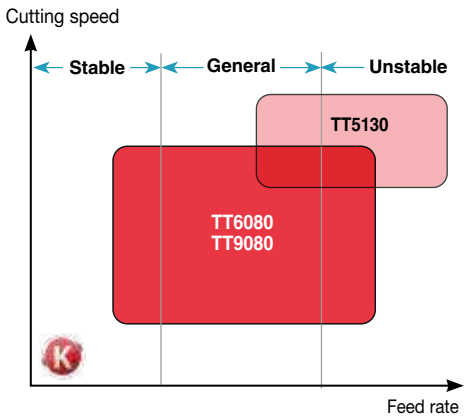
Grades	ISO	Characteristics & applications
TT6080 PVD carbide	K05 – K25 H05 – H25	• General machining for gray and ductile cast iron • Finish and medium machining of hardened steel
TT9300 CVD carbide	P10 – P25	• High speed drilling of carbon & alloy steel
TT5130 PVD carbide	P20 – P40 K20 – K40	• High speed drilling of carbon & alloy steel
TT9080 PVD carbide	P20 – P40 M20 – M40 S20 – S40	• General machining of steel • General machining of stainless steel • General machining of heat-resistant alloy
TT9030 PVD carbide	P20 – P40 M20 – M40 S20 – S40	• General machining of steel • General machining of stainless steel • General machining of heat-resistant alloy
TT8020 PVD carbide	P30 – P50 M30 – M50 S30 – S50	• Interrupted and rough machining of steel • Interrupted and rough machining of stainless steel • Low speed and interrupted machining of heat-resistant alloy
K10 Uncoated	K05 – K15 N05 – N15 S05 – S15	• General machining of cast iron • General machining of aluminum alloys and non-ferrous materials • General machining of heat-resistant alloy
UF1A/UF10 Uncoated	N10 – N25 S10 – S30	• General machining of aluminum alloys and non-ferrous materials • General machining of heat-resistant alloy

Selection guide for holemaking grades

For steel



For cast iron



Drilling Tools

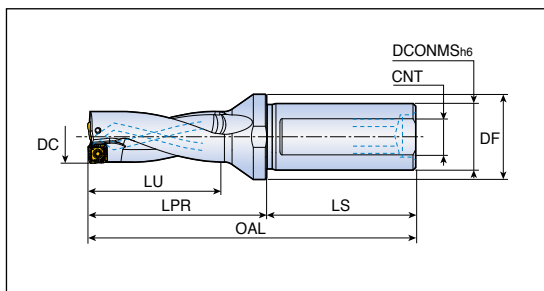


TOP 2...-T2

Indexable drill holders



- Drilling depth: 2x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TOP 2120-20T2-04	12.0	20	25	24	44	50	M13X1.0	SOMT 04...DP
2125-20T2-04	12.5	20	25	26	46	50	M13X1.0	D180
2130-20T2-04	13.0	20	25	26	46	50	M13X1.0	
2135-20T2-04	13.5	20	25	28	46	50	M13X1.0	SOMT 05...DP/DL/DK/DA D180-D181
2140-20T2-05	14.0	20	25	28	46	50	M13X1.0	
2145-20T2-05	14.5	20	25	30	49	50	M13X1.0	
2150-20T2-05	15.0	20	25	30	49	50	M13X1.0	
2155-20T2-05	15.5	20	25	32	52	50	M13X1.0	
2160-20T2-05	16.0	20	25	32	52	50	M13X1.0	SOMT 06...DP/DL/DK/DA D180-D181
2165-25T2-06	16.5	25	32	34	54	56	M16X1.5	
2170-25T2-06	17.0	25	32	34	54	56	M16X1.5	
2175-25T2-06	17.5	25	32	36	57	56	M16X1.5	
2180-25T2-06	18.0	25	32	36	57	56	M16X1.5	
2185-25T2-06	18.5	25	32	38	59	56	M16X1.5	SOMT 07...DP/DL/DK/DA D180-D181
2190-25T2-06	19.0	25	32	38	59	56	M16X1.5	
2195-25T2-07	19.5	25	32	40	63	56	M16X1.5	
2200-25T2-07	20.0	25	32	40	63	56	M16X1.5	
2205-25T2-07	20.5	25	32	42	65	56	M16X1.5	
2210-25T2-07	21.0	25	32	42	65	56	M16X1.5	SOMT 08...DP/DL/DK/DA D180-D181
2215-25T2-07	21.5	25	32	44	67	56	M16X1.5	
2220-25T2-07	22.0	25	32	44	67	56	M16X1.5	
2225-25T2-08	22.5	25	32	46	68	56	M16X1.5	
2230-25T2-08	23.0	25	32	46	68	56	M16X1.5	
2230-32T2-08	23.0	32	40	46	68	60	M22X2.0	
2235-25T2-08	23.5	25	32	48	70	56	M16X1.5	
2235-32T2-08	23.5	32	40	48	70	60	M22X2.0	
2240-25T2-08	24.0	25	32	48	70	56	M16X1.5	
2240-32T2-08	24.0	32	40	48	70	60	M22X2.0	
2245-25T2-08	24.5	25	32	50	72	56	M16X1.5	D180-D181
2245-32T2-08	24.5	32	40	50	72	60	M22X2.0	
2250-25T2-08	25.0	25	32	50	72	56	M16X1.5	
2250-32T2-08	25.0	32	40	50	72	60	M22X2.0	
2255-25T2-08	25.5	25	32	52	73	56	M16X1.5	
2255-32T2-08	25.5	32	40	52	73	60	M22X2.0	
2260-25T2-08	26.0	25	32	52	73	56	M16X1.5	D180-D181
2260-32T2-08	26.0	32	40	52	73	60	M22X2.0	

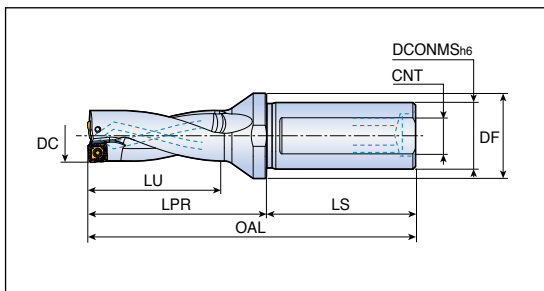


► OAL: LPR + LS

Indexable drill holders



- Drilling depth: 2x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TOP 2265-32T2-09	26.5	32	40	54	77	60	M22X2.0	SOMT 09...DP/DL/DK/DA D180-D181
2270-25T2-09	27.0	25	40	54	77	56	M16X1.5	
2270-32T2-09	27.0	32	40	54	77	60	M22X2.0	
2275-32T2-09	27.5	32	40	56	79	60	M22X2.0	
2280-25T2-09	28.0	25	40	56	79	56	M16X1.5	
2280-32T2-09	28.0	32	40	56	79	60	M22X2.0	
2285-32T2-09	28.5	32	40	58	81	60	M22X2.0	
2290-25T2-09	29.0	25	40	58	81	56	M16X1.5	
2290-32T2-09	29.0	32	40	58	81	60	M22X2.0	
2295-32T2-09	29.5	32	40	60	83	60	M22X2.0	
2300-32T2-09	30.0	32	40	60	83	60	M22X2.0	SOMT 11...DP/DL/DK/DA D180-D181
2305-32T2-09	30.5	32	40	62	85	60	M22X2.0	
2310-32T2-09	31.0	32	40	62	85	60	M22X2.0	
2320-32T2-11	32.0	32	40	64	87	60	M22X2.0	
2320-40T2-11	32.0	40	50	64	87	70	M30X2.0	
2330-32T2-11	33.0	32	40	66	89	60	M22X2.0	
2330-40T2-11	33.0	40	50	66	89	70	M30X2.0	
2340-32T2-11	34.0	32	40	68	91	60	M22X2.0	
2340-40T2-11	34.0	40	50	68	91	70	M30X2.0	
2350-32T2-11	35.0	32	40	70	93	60	M22X2.0	SOMT 13...DP/DL/DK/DA D180-D181
2350-40T2-11	35.0	40	50	70	93	70	M30X2.0	
2360-32T2-11	36.0	32	40	72	95	60	M22X2.0	
2360-40T2-11	36.0	40	50	72	95	70	M30X2.0	
2370-32T2-13	37.0	32	50	74	102	60	M22X2.0	
2370-40T2-13	37.0	40	50	74	102	70	M30X2.0	
2380-32T2-13	38.0	32	50	76	104	60	M22X2.0	
2380-40T2-13	38.0	40	50	76	104	70	M30X2.0	
2390-32T2-13	39.0	32	50	78	106	60	M22X2.0	
2390-40T2-13	39.0	40	50	78	106	70	M30X2.0	
2400-32T2-13	40.0	32	50	80	108	60	M22X2.0	
2400-40T2-13	40.0	40	50	80	108	70	M30X2.0	
2410-40T2-13	41.0	40	50	82	110	70	M30X2.0	
2420-40T2-13	42.0	40	50	84	112	70	M30X2.0	
2430-40T2-13	43.0	40	50	86	114	70	M30X2.0	



► OAL: LPR+LS

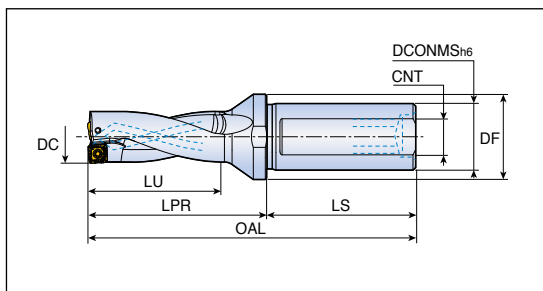
TOP 2...-T2



Indexable drill holders



- Drilling depth: 2x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TOP 2440-40T2-15	44.0	40	60	88	123	70	M30X2.0	SOMT 15...DP/DL/DK/DA D180-D181
2450-40T2-15	45.0	40	60	90	125	70	M30X2.0	
2460-40T2-15	46.0	40	60	92	127	70	M30X2.0	
2470-40T2-15	47.0	40	60	94	129	70	M30X2.0	
2480-40T2-15	48.0	40	60	96	131	70	M30X2.0	
2490-40T2-15	49.0	40	60	98	133	70	M30X2.0	
2500-40T2-15	50.0	40	60	100	135	70	M30X2.0	

► OAL: LPR+LS

Spare parts

Designation	Screw	Wrench	Plug*	
TOP 2120 - 2135	TS 18041/HG	TD 6P	SL 20M	
TOP 2140 - 2160	TS 20043/HG-P	TD 6P	SL 20M	
TOP 2165 - 2220	TS 22052/HG-P	TD 7P	SL 25M	
TOP 2225 - 2260	SO 25065I	TD 7	SL 25M / SL 32M	
TOP 2265 - 2360	TS 35088I	TD 10	SL 25M / SL 32M / SL 40M	
TOP 2370 - 2430	TS 40093I	TD 15	SL 32M / SL 40M	
TOP 2440 - 2550	TS 50115I	TD 20	SL 40M	

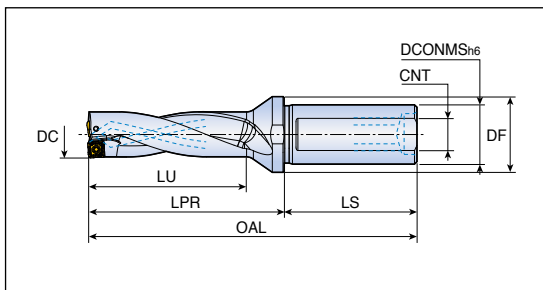


- * Notice: Cooling hole plug for lathe should be ordered separately
Order example) Plug for shank diameter 25.0mm: SL 25M

Indexable drill holders



- Drilling depth: 3x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TOP 3120-20T2-04	12.0	20	25	36	56	50	M13X1.0	SOMT 04...DP
3125-20T2-04	12.5	20	25	39	59	50	M13X1.0	D180
3130-20T2-04	13.0	20	25	39	59	50	M13X1.0	
3135-20T2-04	13.5	20	25	42	60	50	M13X1.0	
3140-20T2-05	14.0	20	25	42	60	50	M13X1.0	
3145-20T2-05	14.5	20	25	45	64	50	M13X1.0	D180-D181
3150-20T2-05	15.0	20	25	45	64	50	M13X1.0	
3155-20T2-05	15.5	20	25	48	68	50	M13X1.0	
3160-20T2-05	16.0	20	25	48	68	50	M13X1.0	
3165-25T2-06	16.5	25	32	51	71	56	M16X1.5	D180-D181
3167-25T2-06 *	16.7	25	32	51	71	56	M16X1.5	
3170-25T2-06	17.0	25	32	51	71	56	M16X1.5	
3175-25T2-06	17.5	25	32	54	75	56	M16X1.5	
3180-25T2-06	18.0	25	32	54	75	56	M16X1.5	D180-D181
3185-25T2-06	18.5	25	32	57	78	56	M16X1.5	
3190-25T2-06	19.0	25	32	57	78	56	M16X1.5	
3195-25T2-07	19.5	25	32	60	83	56	M16X1.5	
3200-25T2-07	20.0	25	32	60	83	56	M16X1.5	D180-D181
3205-25T2-07	20.5	25	32	63	86	56	M16X1.5	
3210-25T2-07	21.0	25	32	63	86	56	M16X1.5	
3215-25T2-07	21.5	25	32	66	89	56	M16X1.5	
3220-25T2-07	22.0	25	32	66	89	56	M16X1.5	D180-D181
3222-25T2-07 *	22.2	25	32	66	89	56	M16X1.5	
3225-25T2-08	22.5	25	32	69	91	56	M16X1.5	
3230-25T2-08	23.0	25	32	69	91	56	M16X1.5	
3230-32T2-08	23.0	32	40	69	91	60	M22X2.0	D180-D181
3235-25T2-08	23.5	25	32	72	94	56	M16X1.5	
3235-32T2-08	23.5	32	40	72	94	60	M22X2.0	
3240-25T2-08	24.0	25	32	72	94	56	M16X1.5	
3240-32T2-08	24.0	32	40	72	94	60	M22X2.0	D180-D181
3245-25T2-08	24.5	25	32	75	97	56	M16X1.5	
3245-32T2-08	24.5	32	40	75	97	60	M22X2.0	
3250-25T2-08	25.0	25	32	75	97	56	M16X1.5	
3250-32T2-08	25.0	32	40	75	97	60	M22X2.0	
3254-25T2-08 *	25.4	25	32	75	97	56	M16X1.5	



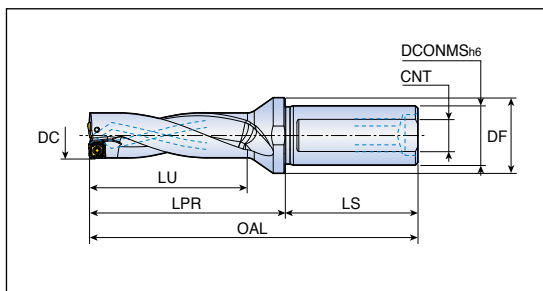
- *: Inch sized hole
- OAL: LPR+LS

TOP 3...-T2

Indexable drill holders



- Drilling depth: 3x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TOP 3255-25T2-08	25.5	25	32	78	99	56	M16X1.5	SOMT 08...DP/DL/DK/DA D180-D181
3255-32T2-08	25.5	32	40	78	99	60	M22X2.0	
3260-25T2-08	26.0	25	32	78	99	56	M16X1.5	
3260-32T2-08	26.0	32	32	78	99	60	M22X2.0	
3265-25T2-09	26.5	25	40	81	104	56	M16X1.5	SOMT 09...DP/DL/DK/DA D180-D181
3265-32T2-09	26.5	32	40	81	104	60	M22X2.0	
3270-25T2-09	27.0	25	40	81	104	56	M16X1.5	
3270-32T2-09	27.0	32	40	81	104	60	M22X2.0	
3275-25T2-09	27.5	25	40	84	107	56	M16X1.5	
3275-32T2-09	27.5	32	40	84	107	60	M22X2.0	
3280-25T2-09	28.0	25	40	84	107	56	M16X1.5	
3280-32T2-09	28.0	32	40	84	107	60	M22X2.0	
3285-25T2-09	28.5	25	40	87	110	56	M16X1.5	
3285-32T2-09	28.5	32	40	87	110	60	M22X2.0	
3290-25T2-09	29.0	25	40	87	110	56	M16X1.5	
3290-32T2-09	29.0	32	40	87	110	60	M22X2.0	
3295-32T2-09	29.5	32	40	90	113	60	M22X2.0	
3300-32T2-09	30.0	32	40	90	113	60	M22X2.0	
3305-32T2-09	30.5	32	40	93	116	60	M22X2.0	
3310-32T2-09	31.0	32	40	93	116	60	M22X2.0	
3320-32T2-11	32.0	32	40	96	119	60	M22X2.0	SOMT 11...DP/DL/DK/DA D180-D181
3320-40T2-11	32.0	40	50	96	119	70	M30X2.0	
3330-32T2-11	33.0	32	40	99	122	60	M22X2.0	
3330-40T2-11	33.0	40	50	99	122	70	M30X2.0	
3340-32T2-11	34.0	32	40	102	125	60	M22X2.0	
3340-40T2-11	34.0	40	50	102	125	70	M30X2.0	
3350-32T2-11	35.0	32	40	105	128	60	M22X2.0	
3350-40T2-11	35.0	40	50	105	128	70	M30X2.0	
3360-32T2-11	36.0	32	40	108	131	60	M22X2.0	
3360-40T2-11	36.0	40	50	108	131	70	M30X2.0	
3370-32T2-13	37.0	32	50	111	139	60	M22X2.0	
3370-40T2-13	37.0	40	50	111	139	70	M30X2.0	
3380-32T2-13	38.0	32	50	114	142	60	M22X2.0	SOMT 13...DP/DL/DK/DA D180-D181
3380-40T2-13	38.0	40	50	114	142	70	M30X2.0	
3390-32T2-13	39.0	32	50	117	145	60	M22X2.0	

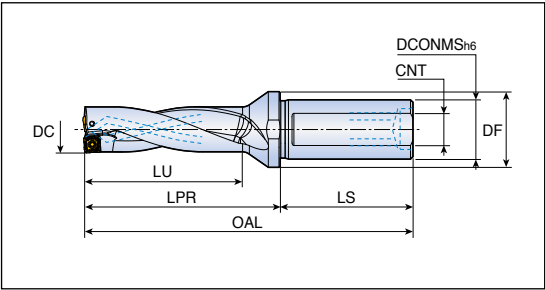


► OAL: LPR + LS

Indexable drill holders



- Drilling depth: 3xdiameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TOP 3390-40T2-13	39.0	40	50	117	145	70	M30X2.0	SOMT 13...DP/DL/DK/DA  D180-D181
3400-32T2-13	40.0	32	50	120	148	60	M22X2.0	
3400-40T2-13	40.0	40	50	120	148	70	M30X2.0	
3410-40T2-13	41.0	40	50	123	151	70	M30X2.0	
3420-40T2-13	42.0	40	50	126	154	70	M30X2.0	
3430-40T2-13	43.0	40	50	129	157	70	M30X2.0	SOMT 15...DP/DL/DK/DA  D180-D181
3440-40T2-15	44.0	40	60	132	167	70	M30X2.0	
3450-40T2-15	45.0	40	60	135	170	70	M30X2.0	
3460-40T2-15	46.0	40	60	138	173	70	M30X2.0	
3470-40T2-15	47.0	40	60	141	176	70	M30X2.0	
3480-40T2-15	48.0	40	60	144	179	70	M30X2.0	
3490-40T2-15	49.0	40	60	147	182	70	M30X2.0	
3500-40T2-15	50.0	40	60	150	185	70	M30X2.0	

► OAL: LPR+LS

Spare parts

Designation	Screw	Wrench	Plug*	
				
TOP 3120 - 3135	TS 18041/HG	TD 6P	SL 20M	
TOP 3140 - 3160	TS 200431/HG-P	TD 6P	SL 20M	
TOP 3165 - 3220	TS 220521/HG-P	TD 7P	SL 25M	
TOP 3225 - 3260	SO 250651	TD 7	SL 25M / SL 32M	
TOP 3265 - 3360	TS 350881	TD 10	SL 25M / SL 32M / SL 40M	
TOP 3370 - 3430	TS 400931	TD 15	SL 32M / SL 40M	
TOP 3440 - 3500	TS 501151	TD 20	SL 40M	

► * Notice: Cooling hole plug for lathe should be ordered separately
Order example) Plug for shank diameter 25.0mm: SL 25M

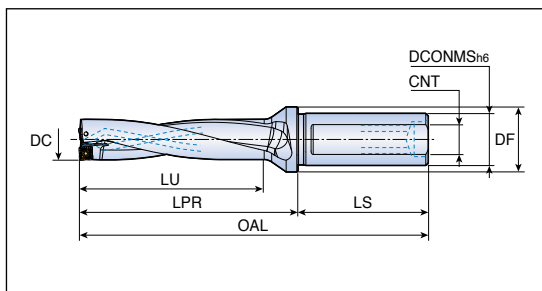


TOP 4...-T2

Indexable drill holders



- Drilling depth: 4x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TOP 4120-20T2-04	12.0	20	25	48	68	50	M13X1.0	SOMT 04...DP
4125-20T2-04	12.5	20	25	52	72	50	M13X1.0	D180
4130-20T2-04	13.0	20	25	52	72	50	M13X1.0	
4135-20T2-04	13.5	20	25	56	74	50	M13X1.0	
4140-20T2-05	14.0	20	25	56	74	50	M13X1.0	SOMT 05...DP/DL/DK/DA
4145-20T2-05	14.5	20	25	60	79	50	M13X1.0	D180-D181
4150-20T2-05	15.0	20	25	60	79	50	M13X1.0	
4155-20T2-05	15.5	20	25	64	84	50	M13X1.0	
4160-20T2-05	16.0	20	25	64	84	50	M13X1.0	
4165-25T2-06	16.5	25	32	68	88	56	M16X1.5	SOMT 06...DP/DL/DK/DA
4170-25T2-06	17.0	25	32	68	88	56	M16X1.5	D180-D181
4175-25T2-06	17.5	25	32	72	93	56	M16X1.5	
4180-25T2-06	18.0	25	32	72	93	56	M16X1.5	
4185-25T2-06	18.5	25	32	76	97	56	M16X1.5	
4190-25T2-06	19.0	25	32	76	97	56	M16X1.5	
4195-25T2-07	19.5	25	32	80	103	56	M16X1.5	SOMT 07...DP/DL/DK/DA
4200-25T2-07	20.0	25	32	80	103	56	M16X1.5	D180-D181
4205-25T2-07	20.5	25	32	84	107	56	M16X1.5	
4210-25T2-07	21.0	25	32	84	107	56	M16X1.5	
4215-25T2-07	21.5	25	32	88	111	56	M16X1.5	
4220-25T2-07	22.0	25	32	88	111	56	M16X1.5	
4225-25T2-08	22.5	25	32	92	114	56	M16X1.5	SOMT 08...DP/DL/DK/DA
4230-25T2-08	23.0	25	32	92	114	56	M16X1.5	D180-D181
4230-32T2-08	23.0	32	40	92	114	60	M22X2.0	
4235-25T2-08	23.5	25	32	96	118	56	M16X1.5	
4235-32T2-08	23.5	32	40	96	118	60	M22X2.0	
4240-25T2-08	24.0	25	32	96	118	56	M16X1.5	
4240-32T2-08	24.0	32	40	96	118	60	M22X2.0	
4245-25T2-08	24.5	25	32	100	122	56	M16X1.5	
4245-32T2-08	24.5	32	40	100	122	60	M22X2.0	
4250-25T2-08	25.0	25	32	100	122	56	M16X1.5	
4250-32T2-08	25.0	32	40	100	122	60	M22X2.0	
4254-25T2-08 *	25.4	25	32	100	122	56	M16X1.5	
4255-25T2-08	25.5	25	32	104	125	56	M16X1.5	
4255-32T2-08	25.5	32	40	104	125	60	M22X2.0	

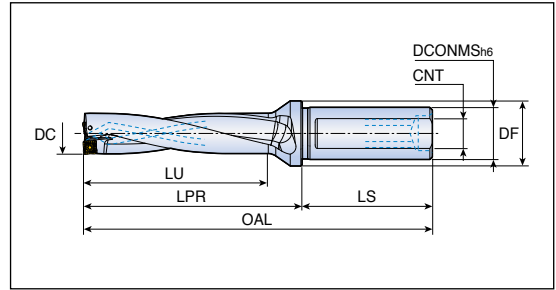


- *: Inch sized hole
- OAL: LPR+LS

Indexable drill holders



- Drilling depth: 4x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TOP 4260-25T2-08	26.0	25	32	104	125	56	M16X1.5	SOMT 08...DP/DL/DK/DA D180-D181
4260-32T2-08	26.0	32	40	104	125	60	M22X2.0	
4265-25T2-09	26.5	25	40	108	131	56	M16X1.5	
4265-32T2-09	26.5	32	40	108	131	60	M22X2.0	
4270-25T2-09	27.0	25	40	108	131	56	M16X1.5	
4270-32T2-09	27.0	32	40	108	131	60	M22X2.0	
4275-25T2-09	27.5	25	40	112	135	56	M16X1.5	
4275-32T2-09	27.5	32	40	112	135	60	M22X2.0	
4280-25T2-09	28.0	25	40	112	135	56	M16X1.5	
4280-32T2-09	28.0	32	40	112	135	60	M22X2.0	
4285-25T2-09	28.5	25	40	116	139	56	M16X1.5	
4285-32T2-09	28.5	32	40	116	139	60	M22X2.0	
4286-32T2-09 *	28.6	32	40	116	139	60	M22X2.0	SOMT 11...DP/DL/DK/DA D180-D181
4290-25T2-09	29.0	25	40	116	139	56	M16X1.5	
4290-32T2-09	29.0	32	40	116	139	60	M22X2.0	
4295-32T2-09	29.5	32	40	120	143	60	M22X2.0	
4300-32T2-09	30.0	32	40	120	143	60	M22X2.0	
4305-32T2-09	30.5	32	40	124	147	60	M22X2.0	
4310-32T2-09	31.0	32	40	124	147	60	M22X2.0	
4318-32T2-11 *	31.8	32	40	128	151	60	M22X2.0	
4320-32T2-11	32.0	32	40	128	151	60	M22X2.0	
4320-40T2-11	32.0	40	50	128	151	70	M30X2.0	
4330-32T2-11	33.0	32	40	132	155	60	M22X2.0	SOMT 13...DP/DL/DK/DA D180-D181
4330-40T2-11	33.0	40	50	132	155	70	M30X2.0	
4340-32T2-11	34.0	32	40	136	159	60	M22X2.0	
4340-40T2-11	34.0	40	50	136	159	70	M30X2.0	
4349-40T2-11 *	34.9	40	50	140	163	70	M30X2.0	
4350-32T2-11	35.0	32	40	140	163	60	M22X2.0	
4350-40T2-11	35.0	40	50	140	163	70	M30X2.0	
4360-32T2-11	36.0	32	40	144	167	60	M22X2.0	
4360-40T2-11	36.0	40	50	144	167	70	M30X2.0	
4370-32T2-13	37.0	32	50	148	176	60	M22X2.0	
4370-40T2-13	37.0	40	50	148	176	70	M30X2.0	
4371-40T2-13 *	37.1	40	50	148	176	70	M30X2.0	



- *: Inch sized hole
- OAL: LPR + LS

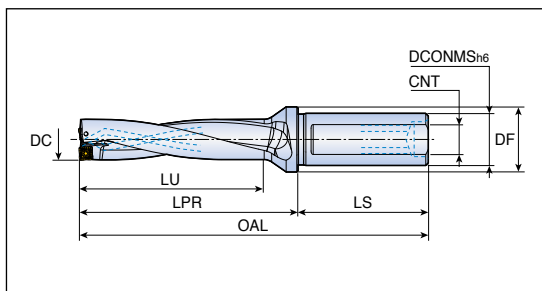
TOP 4...-T2



Indexable drill holders



- Drilling depth: 4x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TOP 4380-32T2-13	38.0	32	50	152	180	60	M22X2.0	SOMT 13...DP/DL/DK/DA D180-D181
4380-40T2-13	38.0	40	50	152	180	70	M30X2.0	
4381-40T2-13 *	38.1	40	50	152	180	70	M30X2.0	
4390-32T2-13	39.0	32	50	156	184	60	M22X2.0	
4390-40T2-13	39.0	40	50	156	184	70	M30X2.0	
4400-32T2-13	40.0	32	50	160	188	60	M22X2.0	
4400-40T2-13	40.0	40	50	160	188	70	M30X2.0	
4410-40T2-13	41.0	40	50	164	192	70	M30X2.0	
4413-40T2-13 *	41.3	40	50	164	192	70	M30X2.0	
4420-40T2-13	42.0	40	50	168	196	70	M30X2.0	
4429-40T2-13 *	42.9	40	50	172	200	70	M30X2.0	SOMT 15...DP/DL/DK/DA D180-D181
4430-40T2-13	43.0	40	50	172	200	70	M30X2.0	
4440-40T2-15	44.0	40	60	176	211	70	M30X2.0	
4445-40T2-15 *	44.5	40	60	180	215	70	M30X2.0	
4450-40T2-15	45.0	40	60	180	215	70	M30X2.0	
4460-40T2-15	46.0	40	60	184	219	70	M30X2.0	
4470-40T2-15	47.0	40	60	188	223	70	M30X2.0	
4476-40T2-15 *	47.6	40	60	192	227	70	M30X2.0	
4480-40T2-15	48.0	40	60	192	227	70	M30X2.0	
4490-40T2-15	49.0	40	60	196	231	70	M30X2.0	
4500-40T2-15	50.0	40	60	200	235	70	M30X2.0	
4508-40T2-15 *	50.8	40	60	204	239	70	M30X2.0	

► * Marked items are for inch sized hole

► OAL = LPR+LS

Spare parts

Designation	Screw 	Wrench 	Plug* 	
TOP 4120 - 4135	TS 18041/HG	TD 6P	SL 20M	
TOP 4140 - 4160	TS 20043I/HG-P	TD 6P	SL 20M	
TOP 4165 - 4220	TS 22052I/HG-P	TD 7P	SL 25M	
TOP 4225 - 4260	SO 25065I	TD 7	SL 25M / SL 32M	
TOP 4265 - 4360	TS 35088I	TD 10	SL 25M / SL 32M / SL 40M	
TOP 4370 - 4430	TS 40093I	TD 15	SL 32M / SL 40M	
TOP 4440 - 4508	TS 50115I	TD 20	SL 40M	

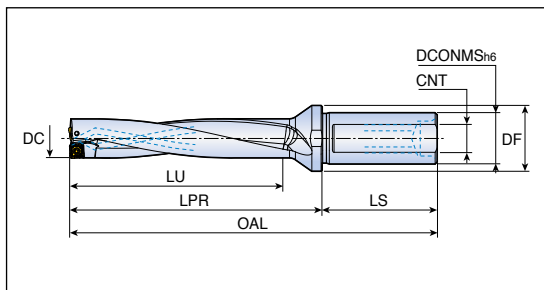


► * Notice: Cooling hole plug for lathe should be ordered separately
Order example) Plug for shank diameter 25.0mm: SL 25M

Indexable drill holders



- Drilling depth: 5xdiameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TOP 5120-20T2-04	12.0	20	25	60	80	50	M13X1.0	SOMT 04...DP
5125-20T2-04	12.5	20	25	65	85	50	M13X1.0	D180
5130-20T2-04	13.0	20	25	65	85	50	M13X1.0	
5135-20T2-04	13.5	20	25	70	88	50	M13X1.0	SOMT 05...DP/DL/DK/DA D180-D181
5140-20T2-05	14.0	20	25	70	88	50	M13X1.0	
5145-20T2-05	14.5	20	25	75	94	50	M13X1.0	
5150-20T2-05	15.0	20	25	75	94	50	M13X1.0	
5155-20T2-05	15.5	20	25	80	100	50	M13X1.0	
5160-20T2-05	16.0	20	25	80	100	50	M13X1.0	
5165-25T2-06	16.5	25	32	85	105	56	M16X1.5	SOMT 06...DP/DL/DK/DA D180-D181
5170-25T2-06	17.0	25	32	85	105	56	M16X1.5	
5175-25T2-06	17.5	25	32	90	111	56	M16X1.5	
5180-25T2-06	18.0	25	32	90	111	56	M16X1.5	
5185-25T2-06	18.5	25	32	95	116	56	M16X1.5	
5190-25T2-06	19.0	25	32	95	116	56	M16X1.5	
5195-25T2-07	19.5	25	32	100	123	56	M16X1.5	SOMT 07...DP/DL/DK/DA D180-D181
5200-25T2-07	20.0	25	32	100	123	56	M16X1.5	
5205-25T2-07	20.5	25	32	105	128	56	M16X1.5	
5210-25T2-07	21.0	25	32	105	128	56	M16X1.5	
5215-25T2-07	21.5	25	32	110	133	56	M16X1.5	
5220-25T2-07	22.0	25	32	110	133	56	M16X1.5	
5222-25T2-07 *	22.2	25	32	110	133	56	M16X1.5	SOMT 08...DP/DL/DK/DA D180-D181
5225-25T2-08	22.5	25	32	115	137	56	M16X1.5	
5230-25T2-08	23.0	25	32	115	137	56	M16X1.5	
5230-32T2-08	23.0	32	40	115	137	60	M22X2.0	
5235-25T2-08	23.5	25	32	120	142	56	M16X1.5	
5235-32T2-08	23.5	32	40	120	142	60	M22X2.0	
5240-25T2-08	24.0	25	32	120	142	56	M16X1.5	
5240-32T2-08	24.0	32	40	120	142	60	M22X2.0	
5245-25T2-08	24.5	25	32	125	147	56	M16X1.5	
5245-32T2-08	24.5	32	40	125	147	60	M22X2.0	
5250-25T2-08	25.0	25	32	125	147	56	M16X1.5	
5250-32T2-08	25.0	32	40	125	147	60	M22X2.0	
5255-25T2-08	25.5	25	32	130	151	56	M16X1.5	
5255-32T2-08	25.5	32	40	130	151	60	M22X2.0	



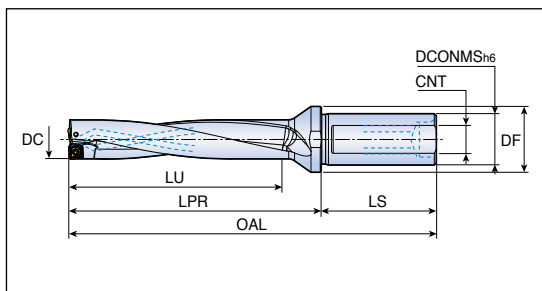
- *: Inch sized hole
- OAL: LPR+LS

TOP 5...-T2

Indexable drill holders



- Drilling depth: 5x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TOP 5260-25T2-08	26.0	25	32	130	151	56	M16X1.5	SOMT 08...DP/DL/DK/DA
5260-32T2-08	26.0	32	40	130	151	60	M22X2.0	D180-D181
5265-32T2-09	26.5	32	40	135	158	60	M22X2.0	SOMT 09...DP/DL/DK/DA
5270-25T2-09	27.0	25	40	135	158	56	M16X1.5	D180-D181
5270-32T2-09	27.0	32	40	135	158	60	M22X2.0	
5275-32T2-09	27.5	32	40	140	163	60	M22X2.0	
5280-25T2-09	28.0	25	40	140	163	56	M16X1.5	
5280-32T2-09	28.0	32	40	140	163	60	M22X2.0	
5282-32T2-09 *	28.2	32	40	140	163	60	M22X2.0	
5285-32T2-09	28.5	32	40	145	168	60	M22X2.0	
5290-25T2-09	29.0	25	40	145	168	56	M16X1.5	
5290-32T2-09	29.0	32	40	145	168	60	M22X2.0	
5295-32T2-09	29.5	32	40	150	173	60	M22X2.0	
5300-32T2-09	30.0	32	40	150	173	60	M22X2.0	
5305-32T2-09	30.5	32	40	155	178	60	M22X2.0	
5310-32T2-09	31.0	32	40	155	178	60	M22X2.0	
5320-32T2-11	32.0	32	40	160	183	60	M22X2.0	SOMT 11...DP/DL/DK/DA
5320-40T2-11	32.0	40	50	160	183	70	M30X2.0	D180-D181
5330-32T2-11	33.0	32	40	165	188	60	M22X2.0	
5330-40T2-11	33.0	40	50	165	188	70	M30X2.0	
5340-32T2-11	34.0	32	40	170	193	60	M22X2.0	
5340-40T2-11	34.0	40	50	170	193	70	M30X2.0	
5350-32T2-11	35.0	32	40	175	198	60	M22X2.0	
5350-40T2-11	35.0	40	50	175	198	70	M30X2.0	
5360-32T2-11	36.0	32	40	180	203	60	M22X2.0	
5360-40T2-11	36.0	40	50	180	203	70	M30X2.0	
5370-32T2-13	37.0	32	50	185	213	60	M22X2.0	SOMT 13...DP/DL/DK/DA
5370-40T2-13	37.0	40	50	185	213	70	M30X2.0	D180-D181
5380-32T2-13	38.0	32	50	190	218	60	M22X2.0	
5380-40T2-13	38.0	40	50	190	218	70	M30X2.0	
5390-32T2-13	39.0	32	50	195	223	60	M22X2.0	
5390-40T2-13	39.0	40	50	195	223	70	M30X2.0	
5400-32T2-13	40.0	32	50	200	228	60	M22X2.0	
5400-40T2-13	40.0	40	50	200	228	70	M30X2.0	

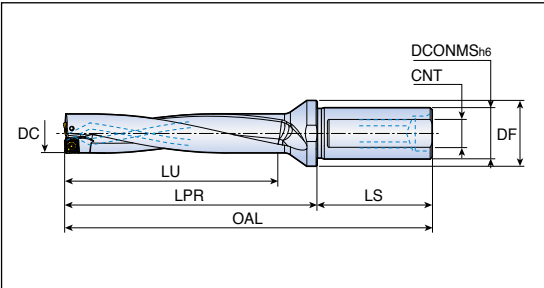


- *: Inch sized hole
- OAL: LPR+LS

Indexable drill holders



- Drilling depth: 5xdiameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TOP 5410 - 40T2-13	41.0	40	50	205	233	70	M30X2.0	SOMT 13...DP/DL/DK/DA
5420 - 40T2-13	42.0	40	50	210	238	70	M30X2.0	D180-D181
5430 - 40T2-13	43.0	40	50	215	243	70	M30X2.0	
5440 - 40T2-15	44.0	40	60	220	255	70	M30X2.0	SOMT 15...DP/DL/DK/DA
5450 - 40T2-15	45.0	40	60	225	260	70	M30X2.0	D180-D181
5460 - 40T2-15	46.0	40	60	230	265	70	M30X2.0	
5470 - 40T2-15	47.0	40	60	235	270	70	M30X2.0	
5480 - 40T2-15	48.0	40	60	240	275	70	M30X2.0	
5490 - 40T2-15	49.0	40	60	245	280	70	M30X2.0	
5500 - 40T2-15	50.0	40	60	250	285	70	M30X2.0	

► OAL: LPR+LS

Spare parts

Designation	Screw	Wrench	Plug*	
TOP 5120 - 5135	TS 18041I/HG	TD 6P	SL 20M	
TOP 5140 - 5160	TS 20043I/HG-P	TD 6P	SL 20M	
TOP 5165 - 5220	TS 22052I/HG-P	TD 7P	SL 25M	
TOP 5225 - 5260	SO 25065I	TD 7	SL 25M / SL 32M	
TOP 5265 - 5360	TS 35088I	TD 10	SL 25M / SL 32M / SL 40M	
TOP 5370 - 5430	TS 40093I	TD 15	SL 32M / SL 40M	
TOP 5440 - 5500	TS 50115I	TD 20	SL 40M	



► * Notice: Cooling hole plug for lathe should be ordered separately
Order example) Plug for shank diameter 25.0mm: SL 25M

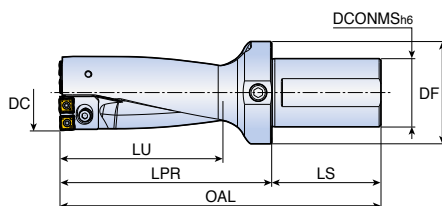
TOP 20...CA



Indexable drill holders for cartridge



- Drilling depth: 2x diameter



Designation	Dimension (mm)							Setting Plate	Insert
	DC	DCONMS	DF	OAL	LU	LPR	LS		
TOP 2051-55-50T2-09CA	51	50	64	223	110	143	80	-	SOMT 09...
	52	50	64	223	110	143	80	TOP-0901	DP/DL/DK/DA
	53	50	64	223	110	143	80	TOP-0902	D180-D181
	54	50	64	223	110	143	80	TOP-0903	
	55	50	64	223	110	143	80	TOP-0904	
TOP 2056-60-50T2-11CA	56	50	64	236	120	156	80	-	SOMT 11...
	57	50	64	236	120	156	80	TOP-0901	DP/DL/DK/DA
	58	50	64	236	120	156	80	TOP-0902	D180-D181
	59	50	64	236	120	156	80	TOP-0903	
	60	50	64	236	120	156	80	TOP-0904	
TOP 2061-65-50T2-11CA	61	50	69	249	130	169	80	-	SOMT 11...
	62	50	69	249	130	169	80	TOP-0901	DP/DL/DK/DA
	63	50	69	249	130	169	80	TOP-0902	D180-D181
	64	50	69	249	130	169	80	TOP-0903	
	65	50	69	249	130	169	80	TOP-0904	
TOP 2066-70-50T2-11CA	66	50	69	262	140	182	80	-	SOMT 11...
	67	50	69	262	140	182	80	TOP-0901	DP/DL/DK/DA
	68	50	69	262	140	182	80	TOP-0902	D180-D181
	69	50	69	262	140	182	80	TOP-0903	
	70	50	69	262	140	182	80	TOP-0904	
TOP 2071-75-50T2-13CA	71	50	74	275	150	195	80	-	SOMT 13...
	72	50	74	275	150	195	80	TOP-0901	DP/DL/DK/DA
	73	50	74	275	150	195	80	TOP-0902	D180-D181
	74	50	74	275	150	195	80	TOP-0903	
	75	50	74	275	150	195	80	TOP-0904	
TOP 2076-80-50T2-13CA	76	50	74	288	160	208	80	-	SOMT 13...
	77	50	74	288	160	208	80	TOP-0901	DP/DL/DK/DA
	78	50	74	288	160	208	80	TOP-0902	D180-D181
	79	50	74	288	160	208	80	TOP-0903	
	80	50	74	288	160	208	80	TOP-0904	



► OAL: LPR+LS

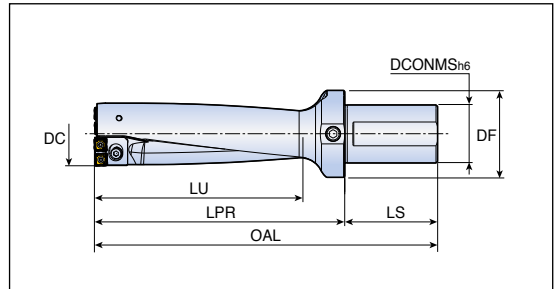
TOP 30...CA



Indexable drill holders for cartridge



- Drilling depth: 3x diameter



Designation	Dimension (mm)							Setting Plate	Insert
	DC	DCONMS	DF	OAL	LU	LPR	LS		
TOP 3051-55-50T2-09CA	51	50	64	278	165	198	80	-	SOMT 09... DP/DL/DK/DA
	52	50	64	278	165	198	80	TOP-0901	D180-D181
	53	50	64	278	165	198	80	TOP-0902	
	54	50	64	278	165	198	80	TOP-0903	
	55	50	64	278	165	198	80	TOP-0904	
TOP 3056-60-50T2-11CA	56	50	64	296	180	216	80	-	SOMT 11... DP/DL/DK/DA
	57	50	64	296	180	216	80	TOP-0901	D180-D181
	58	50	64	296	180	216	80	TOP-0902	
	59	50	64	296	180	216	80	TOP-0903	
	60	50	64	296	180	216	80	TOP-0904	
TOP 3061-65-50T2-11CA	61	50	69	314	195	234	80	-	SOMT 11... DP/DL/DK/DA
	62	50	69	314	195	234	80	TOP-0901	D180-D181
	63	50	69	314	195	234	80	TOP-0902	
	64	50	69	314	195	234	80	TOP-0903	
	65	50	69	314	195	234	80	TOP-0904	
TOP 3066-70-50T2-11CA	66	50	69	332	210	252	80	-	SOMT 11... DP/DL/DK/DA
	67	50	69	332	210	252	80	TOP-0901	D180-D181
	68	50	69	332	210	252	80	TOP-0902	
	69	50	69	332	210	252	80	TOP-0903	
	70	50	69	332	210	252	80	TOP-0904	
TOP 3071-75-50T2-13CA	71	50	74	350	225	270	80	-	SOMT 13... DP/DL/DK/DA
	72	50	74	350	225	270	80	TOP-0901	D180-D181
	73	50	74	350	225	270	80	TOP-0902	
	74	50	74	350	225	270	80	TOP-0903	
	75	50	74	350	225	270	80	TOP-0904	
TOP 3076-80-50T2-13CA	76	50	74	368	240	288	80	-	SOMT 13... DP/DL/DK/DA
	77	50	74	368	240	288	80	TOP-0901	D180-D181
	78	50	74	368	240	288	80	TOP-0902	
	79	50	74	368	240	288	80	TOP-0903	
	80	50	74	368	240	288	80	TOP-0904	



► OAL: LPR+LS

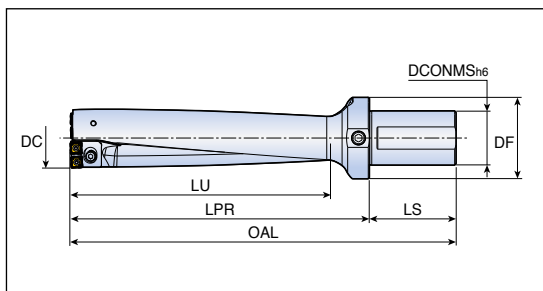
TOP 40...CA



Indexable drill holders for cartridge



- Drilling depth: 4xdiameter



Designation	Dimension (mm)							Setting Plate	Insert
	DC	DCONMS	DF	OAL	LU	LPR	LS		
TOP 4051-55-50T2-09CA	51	50	64	333	220	253	80	-	SOMT 09...
	52	50	64	333	220	253	80	TOP-0901	DP/DL/DK/DA
	53	50	64	333	220	253	80	TOP-0902	D180-D181
	54	50	64	333	220	253	80	TOP-0903	
	55	50	64	333	220	253	80	TOP-0904	
TOP 4056-60-50T2-11CA	56	50	64	356	240	276	80	-	SOMT 11...
	57	50	64	356	240	276	80	TOP-0901	DP/DL/DK/DA
	58	50	64	356	240	276	80	TOP-0902	D180-D181
	59	50	64	356	240	276	80	TOP-0903	
	60	50	64	356	240	276	80	TOP-0904	
TOP 4061-65-50T2-11CA	61	50	69	379	260	299	80	-	SOMT 11...
	62	50	69	379	260	299	80	TOP-0901	DP/DL/DK/DA
	63	50	69	379	260	299	80	TOP-0902	D180-D181
	64	50	69	379	260	299	80	TOP-0903	
	65	50	69	379	260	299	80	TOP-0904	
TOP 4066-70-50T2-11CA	66	50	69	402	280	322	80	-	SOMT 11...
	67	50	69	402	280	322	80	TOP-0901	DP/DL/DK/DA
	68	50	69	402	280	322	80	TOP-0902	D180-D181
	69	50	69	402	280	322	80	TOP-0903	
	70	50	69	402	280	322	80	TOP-0904	
TOP 4071-75-50T2-13CA	71	50	74	425	300	345	80	-	SOMT 13...
	72	50	74	425	300	345	80	TOP-0901	DP/DL/DK/DA
	73	50	74	425	300	345	80	TOP-0902	D180-D181
	74	50	74	425	300	345	80	TOP-0903	
	75	50	74	425	300	345	80	TOP-0904	
TOP 4076-80-50T2-13CA	76	50	74	448	320	368	80	-	SOMT 13...
	77	50	74	448	320	368	80	TOP-0901	DP/DL/DK/DA
	78	50	74	448	320	368	80	TOP-0902	D180-D181
	79	50	74	448	320	368	80	TOP-0903	
	80	50	74	448	320	368	80	TOP-0904	



► OAL: LPR+LS

Indexable drill holders for cartridge

Spare parts

Designation	Screw	Cartridge for peripheral	Cartridge for center
TOP ..51-55-50T2-09CA	TS 35088I	TOP 09CA-P1	TOP 09CA-C1
TOP ..56-60-50T2-11CA	TS 35088I	TOP 11CA-P1	TOP 11CA-C1
TOP ..61-65-50T2-11CA	TS 35088I	TOP 11CA-P2	TOP 11CA-C2
TOP ..66-70-50T2-11CA	TS 35088I	TOP 11CA-P3	TOP 11CA-C3
TOP ..71-75-50T2-13CA	TS 40093I	TOP 13CA-P1	TOP 13CA-C1
TOP ..76-80-50T2-13CA	TS 40093I	TOP 13CA-P2	TOP 13CA-C2

Spare parts for cartridge

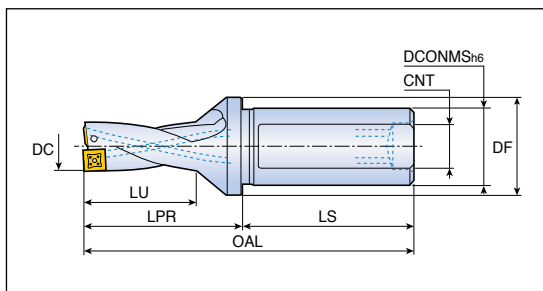
Designation	Cartridge clamping screw	Washer	Setting plate screw
TOP 09CA-P1	SH M4x0.7x16	MW 4.3x8	TS 20043I/HG-P
TOP 09CA-C1	SH M4x0.7x16	MW 4.3x8	-
TOP 11CA-P1	SH M5x0.8x16	MW 5.5x10	TS 20043I/HG-P
TOP 11CA-C1	SH M5x0.8x16	MW 5.5x10	-
TOP 11CA-P2	SH M5x0.8x16	MW 5.5x10	TS 20043I/HG-P
TOP 11CA-C2	SH M5x0.8x16	MW 5.5x10	-
TOP 11CA-P3	SH M5x0.8x16	MW 5.5x10	TS 20043I/HG-P
TOP 11CA-C3	SH M5x0.8x16	MW 5.5x10	-
TOP 13CA-P1	SH M6x1.0x20	MW 6.4x12	TS 20043I/HG-P
TOP 13CA-C1	SH M6x1.0x20	MW 6.4x12	-
TOP 13CA-P2	SH M6x1.0x20	MW 6.4x12	TS 20043I/HG-P
TOP 13CA-C2	SH M6x1.0x20	MW 6.4x12	-

TDR 2...-T2

Indexable drill holders



- Drilling depth: 2x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TDR 2125-20T2-05	12.5	20	25	26	44	50	M13X1.0	SPMG 05...
2130-20T2-05	13.0	20	25	26	44	50	M13X1.0	DG/DK
2135-20T2-05	13.5	20	25	28	46	50	M13X1.0	SPGG 05..DA
2140-20T2-05	14.0	20	25	28	46	50	M13X1.0	D182-D183
2145-20T2-05	14.5	20	25	30	49	50	M13X1.0	
2150-20T2-05	15.0	20	25	30	49	50	M13X1.0	
2155-25T2-06	15.5	25	32	32	52	56	M16X1.5	SPMG 06...
2160-25T2-06	16.0	25	32	32	52	56	M16X1.5	DG/DK
2165-25T2-06	16.5	25	32	34	54	56	M16X1.5	SPGG 06..DA
2170-25T2-06	17.0	25	32	34	54	56	M16X1.5	D182-D183
2175-25T2-06	17.5	25	32	36	57	56	M16X1.5	
2180-25T2-06	18.0	25	32	36	57	56	M16X1.5	
2185-25T2-06	18.5	25	32	38	59	56	M16X1.5	
2190-25T2-06	19.0	25	32	38	59	56	M16X1.5	
2195-25T2-06	19.5	25	32	40	63	56	M16X1.5	
2200-25T2-06	20.0	25	32	40	63	56	M16X1.5	
2205-25T2-06	20.5	25	32	42	65	56	M16X1.5	
2210-25T2-06	21.0	25	32	42	65	56	M16X1.5	
2215-25T2-06	21.5	25	32	44	67	56	M16X1.5	
2220-25T2-07	22.0	25	32	44	67	56	M16X1.5	SPMG 07...
2225-25T2-07	22.5	25	32	46	71	56	M16X1.5	DG/DK
2225-32T2-07	22.5	32	40	46	71	60	M22X2.0	SPGG 07..DA
2230-25T2-07	23.0	25	32	46	71	56	M16X1.5	D182-D183
2230-32T2-07	23.0	32	40	46	71	60	M22X2.0	
2235-25T2-07	23.5	25	32	48	74	56	M16X1.5	
2235-32T2-07	23.5	32	40	48	74	60	M22X2.0	
2240-25T2-07	24.0	25	32	48	74	56	M16X1.5	
2240-32T2-07	24.0	32	40	48	74	60	M22X2.0	
2245-25T2-07	24.5	25	32	50	77	56	M16X1.5	
2245-32T2-07	24.5	32	40	50	77	60	M22X2.0	
2250-25T2-07	25.0	25	32	50	77	56	M16X1.5	
2250-32T2-07	25.0	32	40	50	77	60	M22X2.0	
2255-25T2-07	25.5	25	32	52	79	56	M16X1.5	
2255-32T2-07	25.5	32	40	52	79	60	M22X2.0	
2260-25T2-07	26.0	25	32	52	79	56	M16X1.5	



► OAL: LPR+LS

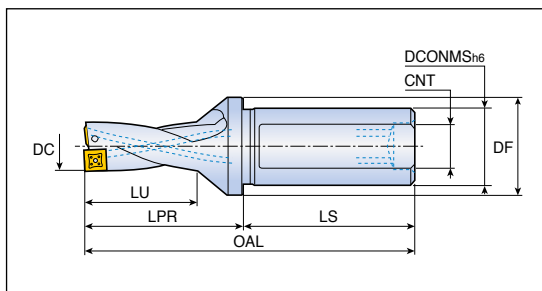
TDR 2...-T2



Indexable drill holders



- Drilling depth: 2x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TDR 2260-32T2-07	26.0	32	40	52	79	60	M22X2.0	SPMG 07... DG/DK SPGG 07..DA D182-D183
2265-25T2-07	26.5	25	32	54	81	56	M16X1.5	
2265-32T2-07	26.5	32	40	54	81	60	M22X2.0	
2270-25T2-07	27.0	25	32	54	81	56	M16X1.5	
2270-32T2-07	27.0	32	40	54	81	60	M22X2.0	
2275-25T2-07	27.5	25	32	56	84	56	Rc 1/8	
2275-32T2-07	27.5	32	40	56	84	60	Rc 1/4	
2280-25T2-09	28.0	25	40	56	84	56	Rc 1/8	SPMG 09... DG/DK SPGG 09..DA D182-D183
2280-32T2-09	28.0	32	40	56	84	60	Rc 1/4	
2285-25T2-09	28.5	25	40	58	86	56	Rc 1/8	
2285-32T2-09	28.5	32	40	58	86	60	Rc 1/4	
2290-25T2-09	29.0	25	40	58	86	56	Rc 1/8	
2290-32T2-09	29.0	32	40	58	86	60	Rc 1/4	
2295-32T2-09	29.5	32	40	60	91	60	Rc 1/4	
2295-40T2-09	29.5	40	50	60	91	70	Rc 1/4	
2300-32T2-09	30.0	32	40	60	91	60	Rc 1/4	
2300-40T2-09	30.0	40	50	60	91	70	Rc 1/4	
2305-32T2-09	30.5	32	40	62	94	60	Rc 1/4	
2305-40T2-09	30.5	40	50	62	94	70	Rc 1/4	
2310-32T2-09	31.0	32	40	62	94	60	Rc 1/4	
2310-40T2-09	31.0	40	50	62	94	70	Rc 1/4	
2315-32T2-09	31.5	32	40	64	96	60	Rc 1/4	
2315-40T2-09	31.5	40	50	64	96	70	Rc 1/4	
2320-32T2-09	32.0	32	40	64	96	60	Rc 1/4	
2320-40T2-09	32.0	40	50	64	96	70	Rc 1/4	
2325-32T2-09	32.5	32	40	66	99	60	Rc 1/4	SPMG 11... DG/DK SPGG 11..DA D182-D183
2325-40T2-09	32.5	40	50	66	99	70	Rc 1/4	
2330-32T2-09	33.0	32	40	66	99	60	Rc 1/4	
2330-40T2-09	33.0	40	50	66	99	70	Rc 1/4	
2340-32T2-11	34.0	32	50	68	101	60	Rc 1/4	
2340-40T2-11	34.0	40	55	68	101	70	Rc 1/4	
2350-32T2-11	35.0	32	50	70	104	60	Rc 1/4	
2350-40T2-11	35.0	40	55	70	104	70	Rc 1/4	
2360-32T2-11	36.0	32	50	72	107	60	Rc 1/4	
2360-40T2-11	36.0	40	55	72	107	70	Rc 1/4	



► OAL: LPR+LS

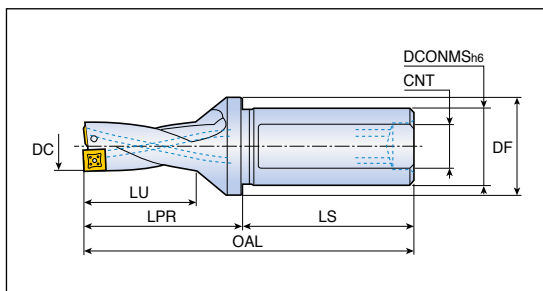
TDR 2...-T2



Indexable drill holders



- Drilling depth: 2x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TDR 2370-32T2-11	37.0	32	50	74	110	60	Rc 1/4	SPMG 11... DG/DK SPGG 11..DA D182-D183
2370-40T2-11	37.0	40	55	74	110	70	Rc 1/4	
2380-32T2-11	38.0	32	50	76	113	60	Rc 1/4	
2380-40T2-11	38.0	40	55	76	113	70	Rc 1/4	
2390-32T2-11	39.0	32	50	78	115	60	Rc 1/4	
2390-40T2-11	39.0	40	55	78	115	70	Rc 1/4	
2400-32T2-11	40.0	32	50	80	118	60	Rc 1/4	
2400-40T2-11	40.0	40	55	80	118	70	Rc 1/4	
2410-40T2-11	41.0	40	55	82	121	70	Rc 1/4	
2420-40T2-14	42.0	40	60	84	123	70	Rc 1/4	SPMG 14... DG/DK SPGG 14..DA D182-D183
2430-40T2-14	43.0	40	60	86	126	70	Rc 1/4	
2440-40T2-14	44.0	40	60	88	128	70	Rc 1/4	
2450-40T2-14	45.0	40	60	90	132	70	Rc 1/4	
2460-40T2-14	46.0	40	60	92	135	70	Rc 1/4	
2470-40T2-14	47.0	40	60	94	137	70	Rc 1/4	
2480-40T2-14	48.0	40	60	96	140	70	Rc 1/4	
2490-40T2-14	49.0	40	60	98	142	70	Rc 1/4	
2500-40T2-14	50.0	40	60	100	145	70	Rc 1/4	

► OAL: LPR+LS

Spare parts

Designation	Screw	Wrench	Plug*	
TDR 2125 - 2150	TS 20043I/HG-P	TD 6P	SL 20 M	
TDR 2155 - 2215	TS 22052I/HG	TD 7	SL 25 M	
TDR 2220 - 2270	TS 25064I	TD 8	SL 25 M / SL 32 M	
TDR 2275	TS 25064I	TD 8	-	
TDR 2280 - 2330	TS 35088I	TD 10	-	
TDR 2340 - 2390	TS 40093I	TD 15	-	
TDR 2400 - 2410	TS 40093I	TD 15	-	
TDR 2420 - 2500	SO 50090I	TD 20	-	



- * Notice: Cooling hole plug for lathe should be ordered separately
Order example) Plug for shank diameter 25.0mm: SL 25M

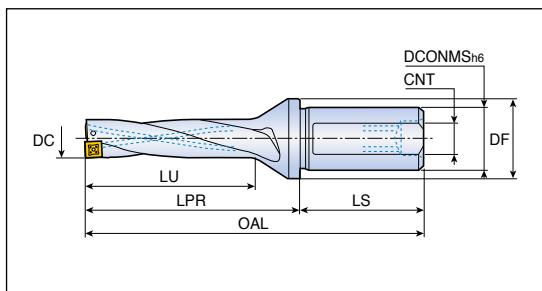
TDR 3...-T2



Indexable drill holders



- Drilling depth: 3xdiameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TDR 3125-20T2-05	12.5	20	25	39	57	50	M13X1.0	SPMG 05... DG/DK SPGG 05..DA D182-D183
3130-20T2-05	13.0	20	25	39	57	50	M13X1.0	
3135-20T2-05	13.5	20	25	42	60	50	M13X1.0	
3140-20T2-05	14.0	20	25	42	60	50	M13X1.0	
3145-20T2-05	14.5	20	25	45	64	50	M13X1.0	
3150-20T2-05	15.0	20	25	45	64	50	M13X1.0	SPMG 06... DG/DK SPGG 06..DA D182-D183
3155-25T2-06	15.5	25	32	48	68	56	M16X1.5	
3160-25T2-06	16.0	25	32	48	68	56	M16X1.5	
3165-25T2-06	16.5	25	32	51	71	56	M16X1.5	
3170-25T2-06	17.0	25	32	51	71	56	M16X1.5	
3175-25T2-06	17.5	25	32	54	75	56	M16X1.5	
3180-25T2-06	18.0	25	32	54	75	56	M16X1.5	
3185-25T2-06	18.5	25	32	57	78	56	M16X1.5	
3190-25T2-06	19.0	25	32	57	78	56	M16X1.5	
3195-25T2-06	19.5	25	32	60	83	56	M16X1.5	
3200-25T2-06 *	20.0	25	32	60	83	56	M16X1.5	
3205-25T2-06	20.5	25	32	63	86	56	M16X1.5	
3209-25T2-06 *	20.9	25	32	63	86	56	M16X1.5	
3210-25T2-06	21.0	25	32	63	86	56	M16X1.5	
3215-25T2-06	21.5	25	32	66	89	56	M16X1.5	SPMG 07... DG/DK SPGG 07..DA D182-D183
3220-25T2-07	22.0	25	32	66	89	56	M16X1.5	
3225-25T2-07	22.5	25	32	69	94	56	M16X1.5	
3225-32T2-07	22.5	32	40	69	94	60	M22X2.0	
3230-25T2-07	23.0	25	32	69	94	56	M16X1.5	
3230-32T2-07	23.0	32	40	69	94	60	M22X2.0	
3235-25T2-07	23.5	25	32	72	98	56	M16X1.5	
3235-32T2-07	23.5	32	40	72	98	60	M22X2.0	
3239-25T2-07 *	23.9	25	32	72	98	56	M16X1.5	
3239-32T2-07 *	23.9	32	45	72	98	60	M22X2.0	
3240-25T2-07	24.0	25	32	72	98	56	M16X1.5	
3240-32T2-07	24.0	32	40	72	98	60	M22X2.0	
3245-25T2-07	24.5	25	32	75	102	56	M16X1.5	
3245-32T2-07	24.5	32	40	75	102	60	M22X2.0	
3250-25T2-07	25.0	25	32	75	102	56	M16X1.5	
3250-32T2-07	25.0	32	40	75	102	60	M22X2.0	



- *: Pre-thread hole making
- OAL: LPR+LS

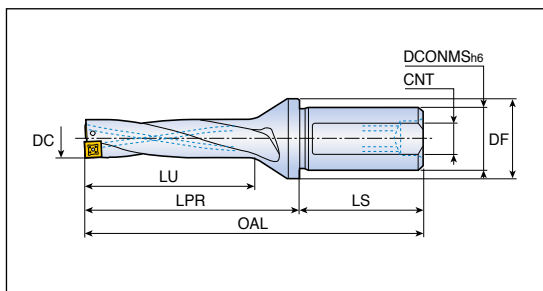
TDR 3...-T2



Indexable drill holders



- Drilling depth: 3x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TDR 3255-25T2-07	25.5	25	32	78	105	56	M16X1.5	SPMG 07... DG/DK SPGG 07..DA D182-D183
3255-32T2-07	25.5	32	40	78	105	60	M22X2.0	
3260-25T2-07	26.0	25	32	78	105	56	M16X1.5	
3260-32T2-07	26.0	32	40	78	105	60	M22X2.0	
3264-25T2-07 *	26.4	25	45	81	108	56	M16X1.5	
3264-32T2-07 *	26.4	32	45	81	108	60	M22X2.0	
3265-25T2-07	26.5	25	32	81	108	56	M16X1.5	
3265-32T2-07	26.5	32	40	81	108	60	M22X2.0	
3270-25T2-07	27.0	25	32	81	108	56	M16X1.5	
3270-32T2-07	27.0	32	40	81	108	60	M22X2.0	
3275-25T2-07	27.5	25	32	84	112	56	Rc 1/8	
3275-32T2-07	27.5	32	40	84	112	60	Rc 1/4	
3280-25T2-09	28.0	25	40	84	112	56	Rc 1/8	SPMG 09... DG/DK SPGG 09..DA D182-D183
3280-32T2-09	28.0	32	40	84	112	60	Rc 1/4	
3285-25T2-09	28.5	25	40	87	115	56	Rc 1/8	
3285-32T2-09	28.5	32	40	87	115	56	Rc 1/4	
3290-25T2-09	29.0	25	40	87	115	56	Rc 1/8	
3290-32T2-09	29.0	32	40	87	115	60	Rc 1/4	
3294-32T2-09 *	29.4	32	55	90	121	60	Rc 1/4	
3294-40T2-09 *	29.4	40	55	90	121	70	Rc 1/4	
3295-32T2-09	29.5	32	40	90	121	60	Rc 1/4	
3295-40T2-09	29.5	40	50	90	121	70	Rc 1/4	
3300-32T2-09	30.0	32	40	90	121	60	Rc 1/4	
3300-40T2-09	30.0	40	50	90	121	70	Rc 1/4	
3305-32T2-09	30.5	32	40	93	125	60	Rc 1/4	
3305-40T2-09	30.5	40	50	93	125	70	Rc 1/4	
3310-32T2-09	31.0	32	40	93	125	60	Rc 1/4	
3310-40T2-09	31.0	40	50	93	125	70	Rc 1/4	
3315-32T2-09	31.5	32	40	96	128	60	Rc 1/4	
3315-40T2-09	31.5	40	50	96	128	70	Rc 1/4	
3320-32T2-09	32.0	32	40	96	128	60	Rc 1/4	
3320-40T2-09	32.0	40	50	96	128	70	Rc 1/4	



- *: Pre-thread hole making
- OAL: LPR + LS

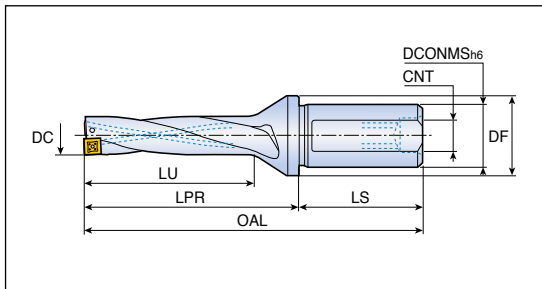
TDR 3...-T2



Indexable drill holders



- Drilling depth: $3 \times \text{diameter}$

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- ▶ *: Pre-thread hole making
- ▶ OAL: LPR+LS

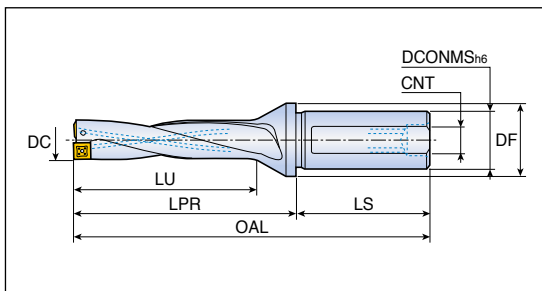
TDR 3...-T2



Indexable drill holders



- Drilling depth: 3xdiameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TDR 3420-40T2-14	42.0	40	60	126	165	70	Rc 1/4	SPMG 14...
3430-40T2-14	43.0	40	60	129	169	70	Rc 1/4	DG/DK
3440-40T2-14	44.0	40	60	132	172	70	Rc 1/4	SPGG 14..DA
3450-40T2-14	45.0	40	60	135	177	70	Rc 1/4	 D182-D183
3460-40T2-14	46.0	40	60	138	181	70	Rc 1/4	
3470-40T2-14	47.0	40	60	141	184	70	Rc 1/4	
3480-40T2-14	48.0	40	60	144	188	70	Rc 1/4	
3490-40T2-14	49.0	40	60	147	191	70	Rc 1/4	
3500-40T2-14	50.0	40	60	150	195	70	Rc 1/4	

► OAL: LPR+LS

Spare parts

Designation	Screw	Wrench	Plug*	
				
TDR 3125 - 3150	TS 20043I/HG-P	TD 6P	SL 20 M	
TDR 3155 - 3215	TS 22052I/HG	TD 7	SL 25 M	
TDR 3220 - 3270	TS 25064I	TD 8	SL 25 M / SL 32 M	
TDR 3275	TS 25064I	TD 8	-	
TDR 3280 - 3330	TS 35088I	TD 10	-	
TDR 3340 - 3390	TS 40093I	TD 15	-	
TDR 3400 - 3410	TS 40093I	TD 15	-	
TDR 3420 - 3500	SO 50090I	TD 20	-	



- * Notice: Cooling hole plug for lathe should be ordered separately
Order example) Plug for shank diameter 25.0mm : SL 25M

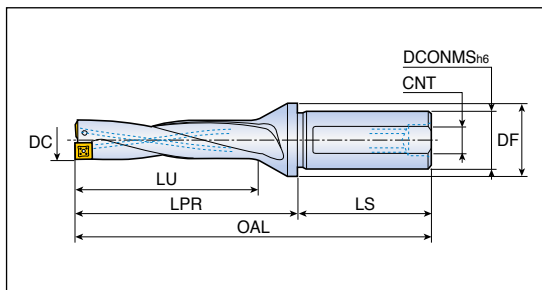
TDR 4...-T2



Indexable drill holders



- Drilling depth: 4xdiameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TDR 4125-20T2-05	12.5	20	25	52	70	50	M13X1.0	SPMG 05... DG/DK SPGG 05..DA D182-D183
4130-20T2-05	13.0	20	25	52	70	50	M13X1.0	
4135-20T2-05	13.5	20	25	56	74	50	M13X1.0	
4140-20T2-05	14.0	20	25	56	74	50	M13X1.0	
4145-20T2-05	14.5	20	25	60	79	50	M13X1.0	
4150-20T2-05	15.0	20	25	60	79	50	M13X1.0	
4155-25T2-06	15.5	25	32	64	84	56	M16X1.5	
4160-25T2-06	16.0	25	32	64	84	56	M16X1.5	
4165-25T2-06	16.5	25	32	68	88	56	M16X1.5	
4170-25T2-06	17.0	25	32	68	88	56	M16X1.5	
4175-25T2-06	17.5	25	32	72	93	56	M16X1.5	SPMG 06... DG/DK SPGG 06..DA D182-D183
4180-25T2-06	18.0	25	32	72	93	56	M16X1.5	
4185-25T2-06	18.5	25	32	76	97	56	M16X1.5	
4190-25T2-06	19.0	25	32	76	97	56	M16X1.5	
4195-25T2-06	19.5	25	32	80	103	56	M16X1.5	
4200-25T2-06	20.0	25	32	80	103	56	M16X1.5	
4205-25T2-06	20.5	25	32	84	107	56	M16X1.5	
4210-25T2-06	21.0	25	32	84	107	56	M16X1.5	
4215-25T2-06	21.5	25	32	88	111	56	M16X1.5	
4220-25T2-07	22.0	25	32	88	111	56	M16X1.5	SPMG 07... DG/DK SPGG 07..DA D182-D183
4225-25T2-07	22.5	25	32	92	117	56	M16X1.5	
4225-32T2-07	22.5	32	40	92	117	60	M22X2.0	
4230-25T2-07	23.0	25	32	92	117	56	M16X1.5	
4230-32T2-07	23.0	32	40	92	117	60	M22X2.0	
4235-25T2-07	23.5	25	32	96	122	56	M16X1.5	
4235-32T2-07	23.5	32	40	96	122	60	M22X2.0	
4240-25T2-07	24.0	25	32	96	122	56	M16X1.5	
4240-32T2-07	24.0	32	40	96	122	60	M22X2.0	
4245-25T2-07	24.5	25	32	100	127	56	M16X1.5	
4245-32T2-07	24.5	32	40	100	127	60	M22X2.0	SPMG 07... DG/DK SPGG 07..DA D182-D183
4250-25T2-07	25.0	25	32	100	127	56	M16X1.5	
4250-32T2-07	25.0	32	40	100	127	60	M22X2.0	
4255-25T2-07	25.5	25	32	104	131	56	M16X1.5	
4255-32T2-07	25.5	32	40	104	131	60	M22X2.0	
4260-25T2-07	26.0	25	32	104	131	56	M16X1.5	



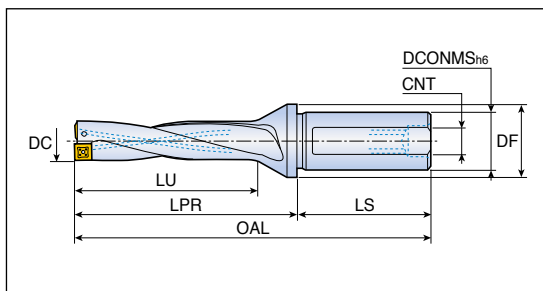
► OAL: LPR+LS

TDR 4...-T2

Indexable drill holders



- Drilling depth: 4x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TDR 4260-32T2-07	26.0	32	40	104	131	60	M22X2.0	SPMG 07... DG/DK SPGG 07..DA D182-D183
4265-25T2-07	26.5	25	32	108	135	56	M16X1.5	
4265-32T2-07	26.5	32	40	108	135	60	M22X2.0	
4270-25T2-07	27.0	25	32	108	135	56	M16X1.5	
4270-32T2-07	27.0	32	40	108	135	60	M22X2.0	
4275-25T2-07	27.5	25	32	112	140	56	Rc 1/8	
4275-32T2-07	27.5	32	40	112	140	60	Rc 1/4	
4280-25T2-09	28.0	25	40	112	140	56	Rc 1/8	
4280-32T2-09	28.0	32	40	112	140	60	Rc 1/4	
4285-25T2-09	28.5	25	40	116	144	56	Rc 1/8	
4285-32T2-09	28.5	32	40	116	144	60	Rc 1/4	SPMG 09... DG/DK SPGG 09..DA D182-D183
4290-25T2-09	29.0	25	40	116	144	56	Rc 1/8	
4290-32T2-09	29.0	32	40	116	144	60	Rc 1/4	
4295-32T2-09	29.5	32	40	120	151	60	Rc 1/4	
4295-40T2-09	29.5	40	50	120	151	70	Rc 1/4	
4300-32T2-09	30.0	32	40	120	151	60	Rc 1/4	
4300-40T2-09	30.0	40	50	120	151	70	Rc 1/4	
4305-32T2-09	30.5	32	40	124	156	60	Rc 1/4	
4305-40T2-09	30.5	40	50	124	156	70	Rc 1/4	
4310-32T2-09	31.0	32	40	124	156	60	Rc 1/4	
4310-40T2-09	31.0	40	50	124	156	70	Rc 1/4	SPMG 11... DG/DK SPGG 11..DA D182-D183
4315-32T2-09	31.5	32	40	128	160	60	Rc 1/4	
4315-40T2-09	31.5	40	50	128	160	70	Rc 1/4	
4320-32T2-09	32.0	32	40	128	160	60	Rc 1/4	
4320-40T2-09	32.0	40	50	128	160	70	Rc 1/4	
4325-32T2-09	32.5	32	40	132	165	60	Rc 1/4	
4325-40T2-09	32.5	40	50	132	165	70	Rc 1/4	
4330-32T2-09	33.0	32	40	132	165	60	Rc 1/4	
4330-40T2-09	33.0	40	50	132	165	70	Rc 1/4	
4340-32T2-11	34.0	32	50	136	169	60	Rc 1/4	
4340-40T2-11	34.0	40	55	136	169	70	Rc 1/4	SPMG 11... DG/DK SPGG 11..DA D182-D183
4350-32T2-11	35.0	32	50	140	174	60	Rc 1/4	
4350-40T2-11	35.0	40	55	140	174	70	Rc 1/4	
4360-32T2-11	36.0	32	50	144	179	60	Rc 1/4	
4360-40T2-11	36.0	40	55	144	179	70	Rc 1/4	



► OAL: LPR + LS

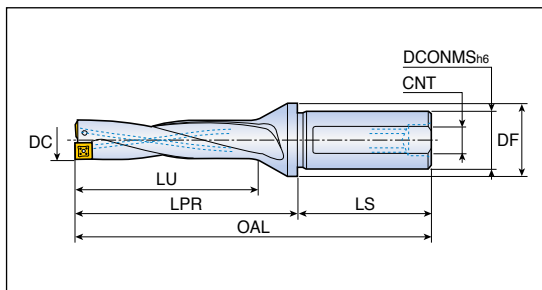
TDR 4...-T2



Indexable drill holders



- Drilling depth: 4xdiameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TDR 4370-32T2-11	37.0	32	50	148	184	60	Rc 1/4	SPMG 11... DG/DK SPGG 11..DA D182-D183
4370-40T2-11	37.0	40	55	148	184	70	Rc 1/4	
4380-32T2-11	38.0	32	50	152	189	60	Rc 1/4	
4380-40T2-11	38.0	40	55	152	189	70	Rc 1/4	
4390-32T2-11	39.0	32	50	156	193	60	Rc 1/4	
4390-40T2-11	39.0	40	55	156	193	70	Rc 1/4	
4400-32T2-11	40.0	32	50	160	198	60	Rc 1/4	
4400-40T2-11	40.0	40	55	160	198	70	Rc 1/4	
4410-40T2-11	41.0	40	55	164	203	70	Rc 1/4	
4420-40T2-14	42.0	40	60	168	207	70	Rc 1/4	SPMG 14... DG/DK SPGG 14..DA D182-D183
4430-40T2-14	43.0	40	60	172	212	70	Rc 1/4	
4440-40T2-14	44.0	40	60	176	216	70	Rc 1/4	
4450-40T2-14	45.0	40	60	180	222	70	Rc 1/4	
4460-40T2-14	46.0	40	60	184	227	70	Rc 1/4	
4470-40T2-14	47.0	40	60	188	231	70	Rc 1/4	
4480-40T2-14	48.0	40	60	192	236	70	Rc 1/4	
4490-40T2-14	49.0	40	60	196	240	70	Rc 1/4	
4500-40T2-14	50.0	40	60	200	245	70	Rc 1/4	

► OAL = LPR+LS

Spare parts

Designation	Screw	Wrench	Plug*	
TDR 4125 - 4150	TS 20043I/HG-P	TD 6P	SL 20 M	
TDR 4155 - 4215	TS 22052I/HG	TD 7	SL 25 M	
TDR 4220 - 4270	TS 25064I	TD 8	SL 25 M / SL 32 M	
TDR 4275	TS 25064I	TD 8	-	
TDR 4280 - 4330	TS 35088I	TD 10	-	
TDR 4340 - 4390	TS 40093I	TD 15	-	
TDR 4400 - 4410	TS 40093I	TD 15	-	
TDR 4420 - 4500	SO 50090I	TD 20	-	



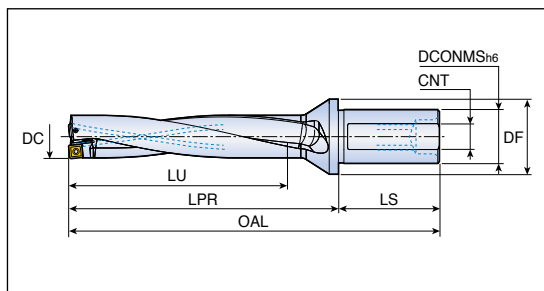
► * Notice: Cooling hole plug for lathe should be ordered separately
Order example) Plug for shank diameter 25.0mm: SL 25M

TDR 5...-T2

Indexable drill holders



- Drilling depth: 5x diameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TDR 5125-20T2-05	12.5	20	25	65	83	50	M13X1.0	SPMG 05...
5130-20T2-05	13.0	20	25	65	83	50	M13X1.0	DG/DK
5135-20T2-05	13.5	20	25	70	88	50	M13X1.0	SPGG 05..DA
5140-20T2-05	14.0	20	25	70	88	50	M13X1.0	 D182-D183
5145-20T2-05	14.5	20	25	75	94	50	M13X1.0	
5150-20T2-05	15.0	20	25	75	94	50	M13X1.0	
5155-25T2-06	15.5	25	32	80	100	56	M16X1.5	SPMG 06...
5160-25T2-06	16.0	25	32	80	100	56	M16X1.5	DG/DK
5165-25T2-06	16.5	25	32	85	105	56	M16X1.5	SPGG 06..DA
5170-25T2-06	17.0	25	32	85	105	56	M16X1.5	 D182-D183
5175-25T2-06	17.5	25	32	90	111	56	M16X1.5	
5180-25T2-06	18.0	25	32	90	111	56	M16X1.5	
5185-25T2-06	18.5	25	32	95	116	56	M16X1.5	
5190-25T2-06	19.0	25	32	95	116	56	M16X1.5	
5195-25T2-06	19.5	25	32	100	123	56	M16X1.5	
5200-25T2-06	20.0	25	32	100	123	56	M16X1.5	
5205-25T2-06	20.5	25	32	105	128	56	M16X1.5	
5210-25T2-06	21.0	25	32	105	128	56	M16X1.5	
5215-25T2-06	21.5	25	32	110	133	56	M16X1.5	
5220-25T2-07	22.0	25	32	110	133	56	M22X2.0	SPMG 07...
5225-32T2-07	22.5	32	40	115	140	60	M22X2.0	DG/DK
5230-32T2-07	23.0	32	40	115	140	60	M22X2.0	SPGG 07..DA
5235-32T2-07	23.5	32	40	120	146	60	M22X2.0	 D182-D183
5240-32T2-07	24.0	32	40	120	146	60	M22X2.0	
5245-32T2-07	24.5	32	40	125	152	60	M22X2.0	
5250-32T2-07	25.0	32	40	125	152	60	M22X2.0	
5255-32T2-07	25.5	32	40	130	157	60	M22X2.0	
5260-32T2-07	26.0	32	40	130	157	60	M22X2.0	
5265-32T2-07	26.5	32	40	135	162	60	M22X2.0	
5270-32T2-07	27.0	32	40	135	162	60	M22X2.0	
5275-32T2-07	27.5	32	40	140	168	60	Rc 1/4	



► OAL: LPR+LS

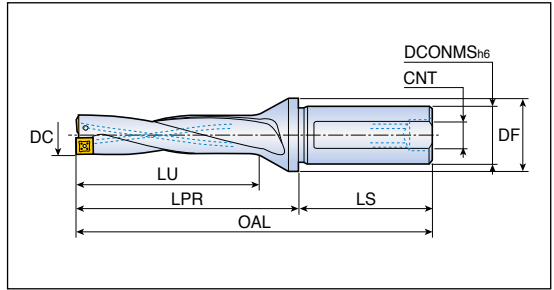
TDR 5...-T2



Indexable drill holders



- Drilling depth: 5xdiameter

[illegible]

► OAL: LPR+LS

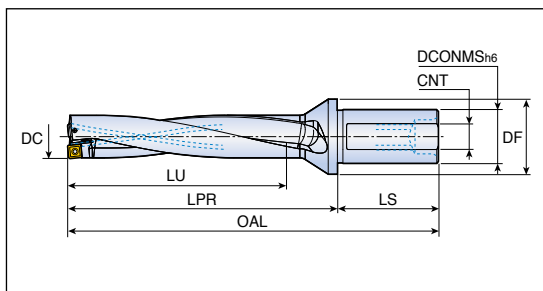
TDR 5...-T2



Indexable drill holders



- Drilling depth: 5xdiameter



Designation	Dimension (mm)							Insert
	DC	DCONMS	DF	LU	LPR	LS	CNT	
TDR 5420-40T2-14	42.0	40	60	210	249	70	Rc 1/4	SPMG 14...
5430-40T2-14	43.0	40	60	215	255	70	Rc 1/4	DG/DK
5440-40T2-14	44.0	40	60	220	260	70	Rc 1/4	SPGG 14..DA
5450-40T2-14	45.0	40	60	225	267	70	Rc 1/4	D182-D183
5460-40T2-14	46.0	40	60	230	273	70	Rc 1/4	
5470-40T2-14	47.0	40	60	235	278	70	Rc 1/4	
5480-40T2-14	48.0	40	60	240	284	70	Rc 1/4	
5490-40T2-14	49.0	40	60	245	289	70	Rc 1/4	
5500-40T2-14	50.0	40	60	250	295	70	Rc 1/4	

► OAL: LPR+LS

Spare parts

Designation	Screw	Wrench	Plug*	
TDR 5125 - 5150	TS 20043I/HG-P	TD 6P	SL 20 M	
TDR 5155 - 5215	TS 22052I/HG	TD 7	SL 25 M	
TDR 5220 - 5270	TS 25064I	TD 8	SL 25 M / SL 32 M	
TDR 5275	TS 25064I	TD 8	-	
TDR 5280 - 5330	TS 35088I	TD 10	-	
TDR 5340 - 5390	TS 40093I	TD 15	-	
TDR 5400 - 5410	TS 40093I	TD 15	-	
TDR 5420 - 5500	SO 50090I	TD 20	-	



- * Notice: Cooling hole plug for lathe should be ordered separately
Order example) Plug for shank diameter 25.0mm: SL 25M

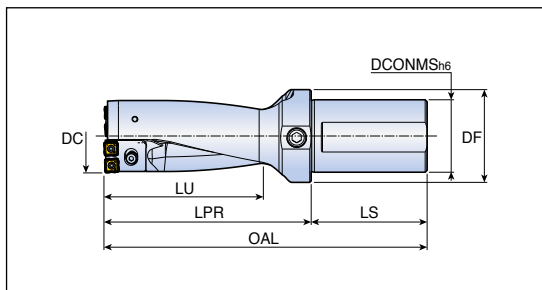
TDR 25...CA-T



Indexable cartridge drill holders



- Drilling depth: 2.5x diameter



Designation	Dimension (mm)						Setting plate	Insert
	DC	DCONMS	DF	LU	LPR	LS		
TDR 2551-53-50T2-07CA-T	51	50	64	133	170	80	-	SPMG 07...
	52	50	64	133	170	80	TDP-0701	DG/DK
	53	50	64	133	170	80	TDP-0702	SPGG 07..DA
								D182-D183
2554-56-50T2-07CA-T	54	50	64	140	180	80	-	SPMG 07...
	55	50	64	140	180	80	TDP-0701	DG/DK
	56	50	64	140	180	80	TDP-0702	SPGG 07..DA
								D182-D183
2557-62-50T2-09CA-T	57	50	64	155	201	80	-	SPMG 09...
	58	50	64	155	201	80	TDP-0901	DG/DK
	59	50	64	155	201	80	TDP-0902	SPGG 09..DA
	60	50	64	155	201	80	TDP-0903	D182-D183
	61	50	64	155	201	80	TDP-0904	
	62	50	64	155	201	80	TDP-0905	
2563-66-50T2-09CA-T	63	50	69	165	215	80	-	SPMG 09...
	64	50	69	165	215	80	TDP-0901	DG/DK
	65	50	69	165	215	80	TDP-0902	SPGG 09..DA
	66	50	69	165	215	80	TDP-0903	D182-D183
2567-73-50T2-11CA-T	67	50	69	183	240	80	-	SPMG 11...
	68	50	69	183	240	80	TDP-1101	DG/DK
	69	50	69	183	240	80	TDP-1102	SPGG 11..DA
	70	50	69	183	240	80	TDP-1103	D182-D183
	71	50	69	183	240	80	TDP-1104	
	72	50	69	183	240	80	TDP-1105	
	73	50	69	183	240	80	TDP-1106	
2574-80-50T2-12CA-T	74	50	74	200	250	80	-	SPMG 12...DG
	75	50	74	200	250	80	TDP-1101	D182
	76	50	74	200	250	80	TDP-1102	
	77	50	74	200	250	80	TDP-1103	
	78	50	74	200	250	80	TDP-1104	
	79	50	74	200	250	80	TDP-1105	
	80	50	74	200	250	80	TDP-1106	



► OAL: LPR+LS

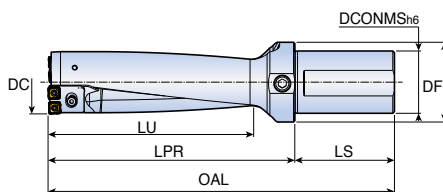
TDR 35...CA-T



Indexable cartridge drill holders



- Drilling depth: $3.5 \times \text{diameter}$



Designation	Dimension (mm)						Setting plate	Insert
	DC	DCONMS	DF	LU	LPR	LS		
TDR 3551-53-50T2-07CA-T	51	50	64	186	223	80	-	SPMG 07... DG/DK SPGG 07..DA
	52	50	75	186	223	80	TDP-0701	
	53	50	75	186	223	80	TDP-0702	 D182-D183
3554-56-50T2-07CA-T	54	50	75	196	236	80	-	SPMG 07... DG/DK SPGG 07..DA
	55	50	75	196	236	80	TDP-0701	
	56	50	75	196	236	80	TDP-0702	 D182-D183
3557-62-50T2-09CA-T	57	50	75	217	263	80	-	SPMG 09... DG/DK SPGG 09..DA
	58	50	75	217	263	80	TDP-0901	
	59	50	75	217	263	80	TDP-0902	
	60	50	75	217	263	80	TDP-0903	 D182-D183
	61	50	75	217	263	80	TDP-0904	
	62	50	75	217	263	80	TDP-0905	
3563-66-50T2-09CA-T	63	50	75	231	281	80	-	SPMG 09... DG/DK SPGG 09..DA
	64	50	75	231	281	80	TDP-0901	
	65	50	75	231	281	80	TDP-0902	
	66	50	75	231	281	80	TDP-0903	 D182-D183
3567-73-50T2-11CA-T	67	50	75	256	313	80	-	SPMG 11... DG/DK SPGG 11..DA
	68	50	75	256	313	80	TDP-1101	
	69	50	75	256	313	80	TDP-1102	
	70	50	75	256	313	80	TDP-1103	
	71	50	75	256	313	80	TDP-1104	
	72	50	75	256	313	80	TDP-1105	
	73	50	75	256	313	80	TDP-1106	 D182-D183



► OAL: LPR+LS

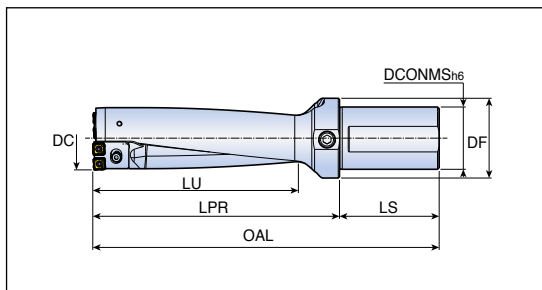
TDR 35...CA-T



Indexable cartridge drill holders



- Drilling depth: 3.5xdiameter



Designation	Dimension (mm)						Setting plate	Insert
	DC	DCONMS	DF	LU	LPR	LS		
TDR 3574-80-50T2-12CA-T	74	50	75	280	330	80	-	SPMG 12...DG D182
	75	50	75	280	330	80	TDP-1101	
	76	50	75	280	330	80	TDP-1102	
	77	50	75	280	330	80	TDP-1103	
	78	50	75	280	330	80	TDP-1104	
	79	50	75	280	330	80	TDP-1105	
	80	50	75	280	330	80	TDP-1106	

► OAL: LPR+LS

Spare parts

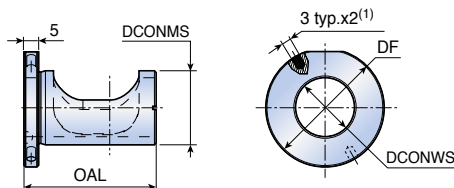
Designation	Screw	Cartridge for peripheral	Cartridge for center
TDR.. 51-53...	TS 25064I	TDR 07CA-P1-T	TDR 07CA-C1-T
TDR.. 54-56...	TS 25064I	TDR 07CA-P2-T	TDR 07CA-C2-T
TDR.. 57-62...	TS 35088I	TDR 09CA-P1-T	TDR 09CA-C1-T
TDR.. 63-66...	TS 35088I	TDR 09CA-P2-T	TDR 09CA-C2-T
TDR.. 67-73...	TS 40093I	TDR 11CA-P1-T	TDR 11CA-C1-T
TDR.. 74-80...	TS 40093I	TDR 12CA-P2-T	TDR 12CA-C2-T

Spare parts for cartridges

Designation	Cartridge clamping screw	Washer	Setting plate screw
TDR 07CA-P1-T	SH M4x0.7x16	MW 4.3x8	TS 20043I/HG-P
TDR 07CA-C1-T	SH M4x0.7x16	MW 4.3x8	-
TDR 07CA-P2-T	SH M4x0.7x16	MW 4.3x8	TS 20043I/HG-P
TDR 07CA-C2-T	SH M4x0.7x16	MW 4.3x8	-
TDR 09CA-P1-T	SH M5x0.8x16	MW 5.5x10	SO 30055I
TDR 09CA-C1-T	SH M5x0.8x16	MW 5.5x10	-
TDR 09CA-P2-T	SH M5x0.8x16	MW 5.5x10	SO 30055I
TDR 09CA-C2-T	SH M5x0.8x16	MW 5.5x10	-
TDR 11CA-P1-T	SH M6x1.0x20	MW 6.4x12	SO 30055I
TDR 11CA-C1-T	SH M6x1.0x20	MW 6.4x12	-
TDR 12CA-P2-T	SH M6x1.0x20	MW 6.4x12	SO 30055I
TDR 12CA-C2-T	SH M6x1.0x20	MW 6.4x12	-



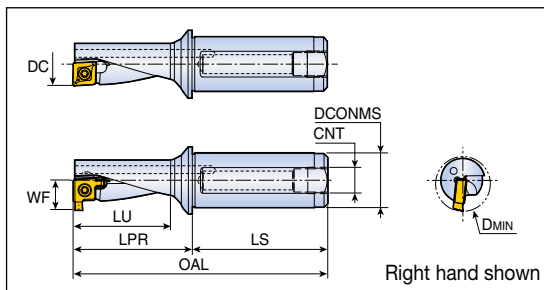
TDRILL

[illegible]

► ⁽¹⁾ Holes for inserting a pin are used to facilitate radial adjustment of the sleeve (Pin is not supplied)

TOPCAP

-



- ▶ OAL: LPR+LS
- ▶ Grooving insert is available for right handed type

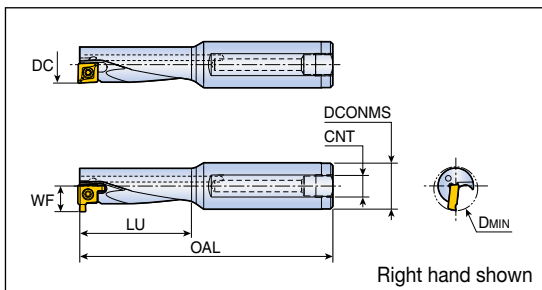
Designation	Screw	Wrench		
TCAP 08	TS 18034/HG-P	T 6P	-	
TCAP 10	TS 20038/HG-P	T 6P	-	
TCAP 12	TS 22052/HG-P	T 7P	-	
TCAP 14	TS 25064/HG-P	T 8P	-	
TCAP 16	TS 30100/HG-P	-	TD 9P	
TCAP 20	TS 35088/HG-P	-	TD10P	
TCAP 25	TS 45A100/HG	-	TD 20	
TCAP 32	TS 45A100/HG	-	TD 20	



TOPCAP

[illegible]

-



- ▶ OA: LPR+LS
- ▶ Grooving insert is available for right handed type

Designation	Screw	Wrench		
TCAP 08	TS 18034I/HG-P	T 6P	-	
TCAP 10	TS 20038I/HG-P	T 6P	-	
TCAP 12	TS 22052I/HG-P	T 7P	-	
TCAP 14	TS 25064I/HG-P	T 8P	-	
TCAP 16	TS 30100I/HG-P	-	TD 9P	
TCAP 20	TS 35088I/HG-P	-	TD10P	
TCAP 25	TS 45A100I/HG	-	TD 20	
TCAP 32	TS 45A100I/HG	-	TD 20	



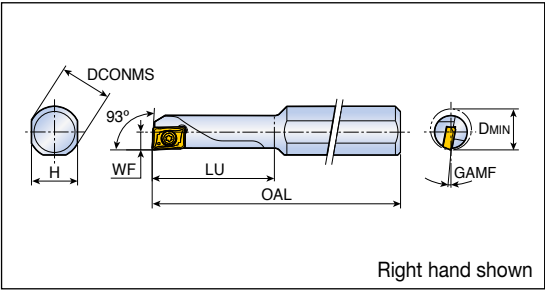
S...SXUCR/L



Boring bars with TOP-CAP inserts



- For boring
- External coolant



Designation	Dimension (mm)							Insert
	DCONMS	H	OAL	LU	WF	DMIN	GAMF	
S10H SXUCR/L 04-06 ⁽¹⁾	10	9	100	21	3.0	6	9°	XCMT 04...R/L TC  D212
S10J SXUCR/L 04-07 ⁽¹⁾	10	9	110	24.5	3.5	7	5°	
S10J SXUCR/L 04-08 ⁽¹⁾	10	9	110	28	4.0	8	2°	XCMT 05...TC  D212
S10K SXUCR/L 05-10	10	9	125	35	5.0	10	2°	

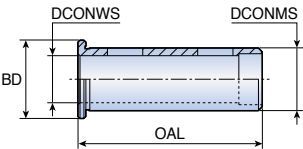
► ⁽¹⁾ Right hand Insert should be used in right hand boring bar

Spare parts

Designation	Screw	Wrench		
S10H SXUCR/L 04-06	TS 18034I/HG-P	T 6P		
S10J SXUCR/L 04-07	TS 18034I/HG-P	T 6P		
S10J SXUCR/L 04-08	TS 18034I/HG-P	T 6P		
S10K SXUCR/L 05-10	TS 20038I/HG-P	T 6P		



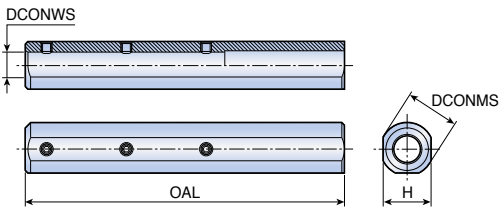
Sleeves for clamping unit



Designation	Dimension (mm)				Toolholders
	DCONMS	DCONWS	BD	OAL	
TSL 16-12	16	12	20	47	TCAP 10R/L...
25-20	25	20	32	55	TCAP 16R/L...

TBSL

Sleeves for boring bar



Designation	Dimension (mm)			
	DCONMS	DCONWS	OAL	H
TBSL 20-10-120	20	10	120	18

Spare parts

Designation	Screw	Wrench		
TBSL 20-10-120	 SS M4x0.7x4	 L-W 2		

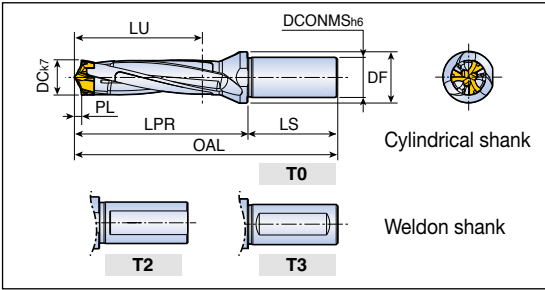
3ED...T...-3D



Head changeable 3 flute drill holder



- Drilling depth: 3xdiameter



Designation	Dimension (mm)								Clamping key
	DC	DCONMS	DF	LU	LPR	LS	PL	SSC	
3ED 120-124-16T3/T0-3D	12.0-12.4	16	20	40.0	60.7	48	2.74	12	K 3ED D12-D13
125-129-16T3/T0-3D	12.5-12.9	16	20	41.5	62.5	48	2.76	12	
130-134-16T3/T0-3D	13.0-13.4	16	20	43.0	64.8	48	2.91	13	
135-139-16T3/T0-3D	13.5-13.9	16	20	44.5	66.6	48	2.93	13	
140-144-16T3/T0-3D	14.0-14.4	16	20	46.0	68.9	48	3.17	14	K 3ED D14-D15
145-149-16T3/T0-3D	14.5-14.9	16	20	47.5	70.7	48	3.19	14	
150-159-20T3/T0-3D	15.0-15.9	20	25	49.0	73.9	50	3.31	15	
160-169-20T3/T0-3D	16.0-16.9	20	25	52.0	79.0	50	3.70	16	
170-179-20T3/T0-3D	17.0-17.9	20	25	55.0	84.0	50	3.88	17	K 3ED D16-D17
180-189-25T2/T0-3D	18.0-18.9	25	32	58.0	90.1	56	4.07	18	
190-199-25T2/T0-3D	19.0-19.9	25	32	61.0	94.7	56	4.26	19	
200-209-25T2/T0-3D	20.0-20.9	25	32	64.0	99.3	56	4.44	20	
210-219-25T2/T0-3D	21.0-21.9	25	32	67.0	103.8	56	4.62	21	K 3ED D18-D19
220-229-25T2/T0-3D	22.0-22.9	25	32	70.0	108.4	56	4.78	22	
230-239-32T2/T0-3D	23.0-23.9	32	42	73.0	112.8	60	5.02	23	
240-249-32T2/T0-3D	24.0-24.9	32	42	76.0	117.4	60	5.18	24	
250-259-32T2/T0-3D	25.0-25.9	32	42	79.0	122.0	60	5.29	25	K 3ED D20-D21



- OAL: LPR+LS
- SSC: Seat size code

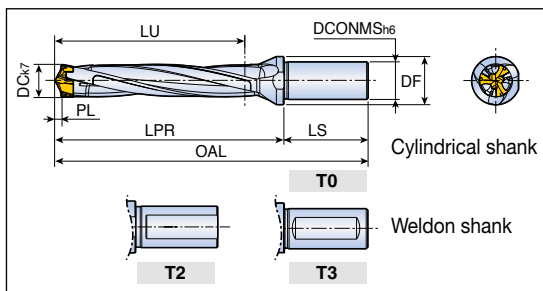
3ED...T...-5D



Head changeable 3 flute drill holder



- Drilling depth: 5xdiameter

[illegible]

- ▶ OAL: LPR+LS
- ▶ SSC: Seat size code

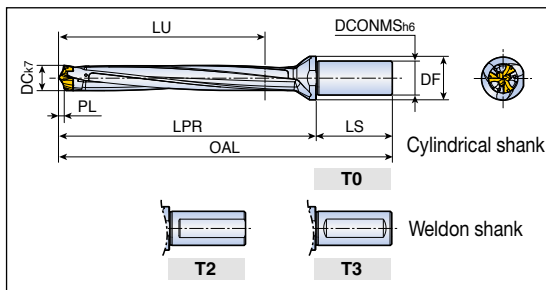
3ED...T...-8D



Head changeable 3 flute drill holder



- Drilling depth: 8xdiameter



Designation	Dimension (mm)								Clamping key
	DC	DCONMS	DF	LU	LPR	LS	PL	SSC	
3ED 120-124-16T3/T0-8D	12.0-12.4	16	20	100	120.7	48	2.74	12	K 3ED D12-D13
125-129-16T3/T0-8D	12.5-12.9	16	20	104	125.0	48	2.76	12	
130-134-16T3/T0-8D	13.0-13.4	16	20	108	129.8	48	2.91	13	
135-139-16T3/T0-8D	13.5-13.9	16	20	112	134.1	48	2.93	13	
140-144-16T3/T0-8D	14.0-14.4	16	20	116	138.9	48	3.17	14	K 3ED D14-D15
145-149-16T3/T0-8D	14.5-14.9	16	20	120	143.2	48	3.19	14	
150-159-20T3/T0-8D	15.0-15.9	20	25	124	148.9	50	3.31	15	
160-169-20T3/T0-8D	16.0-16.9	20	25	132	159.0	50	3.70	16	
170-179-20T3/T0-8D	17.0-17.9	20	25	140	169.0	50	3.88	17	K 3ED D16-D17
180-189-25T2/T0-8D	18.0-18.9	25	32	148	180.1	56	4.07	18	
190-199-25T2/T0-8D	19.0-19.9	25	32	156	189.7	56	4.26	19	
200-209-25T2/T0-8D	20.0-20.9	25	32	164	199.3	56	4.44	20	
210-219-25T2/T0-8D	21.0-21.9	25	32	172	208.8	56	4.62	21	K 3ED D18-D19
220-229-25T2/T0-8D	22.0-22.9	25	32	180	218.4	56	4.78	22	
230-239-32T2/T0-8D	23.0-23.9	32	42	188	227.8	60	5.02	23	
240-249-32T2/T0-8D	24.0-24.9	32	42	196	237.4	60	5.18	24	
250-259-32T2/T0-8D	25.0-25.9	32	42	204	247.0	60	5.29	25	K 3ED D20-D21



- OAL: LPR+LS
- SSC: Seat size code

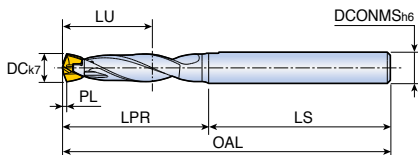
TCD...-3D



Head changeable drill holders - Cylindrical type shank



- Drilling depth: 3xdiameter



Designation	Dimension (mm)							Clamping key
	DC	DCONMS	LU	LPR	LS	PL	SSC	
TCD 040-044-06A0-3D	4.0-4.4	6	13	22.7	35	0.62	4	K TCD D040-D049
045-049-06A0-3D	4.5-4.9	6	14	24.7	35	0.66	4.5	
050-054-06A0-3D	5.0-5.4	6	16	26.3	35	0.73	5	K TCD D050-D059
055-059-06A0-3D	5.5-5.9	6	17	28.2	35	0.81	5.5	



- OAL: LPR+LS
- SSC: Seat size code

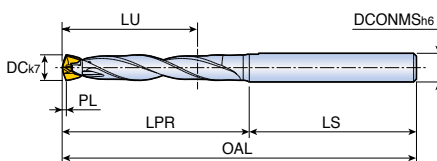
TCD...-5D



Head changeable drill holders - Cylindrical type shank



- Drilling depth: 5xdiameter



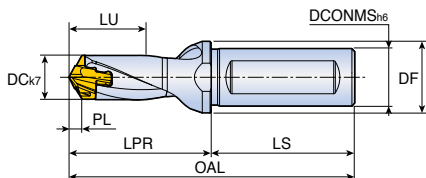
Designation	Dimension (mm)							Clamping key
	DC	DCONMS	LU	LPR	LS	PL	SSC	
TCD 040-044-06A0-5D	4.0-4.4	6	21	30.7	35	0.62	4	K TCD D040-D049
045-049-06A0-5D	4.5-4.9	6	23	33.7	35	0.66	4.5	
050-054-06A0-5D	5.0-5.4	6	26	36.3	35	0.73	5	K TCD D050-D059
055-059-06A0-5D	5.5-5.9	6	28	39.2	35	0.81	5.5	



- OAL: LPR+LS
- SSC: Seat size code

DRILL RUSH

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- A schematic diagram of a water pump assembly. It features a vertical shaft with a propeller-like impeller at the top. The shaft is connected to a horizontal pump head. The pump head has a central outlet pipe pointing downwards. The entire assembly is shown within a rectangular frame.



		
D189-D202	D109	D242

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- TaeguTec**
Member IMC Group

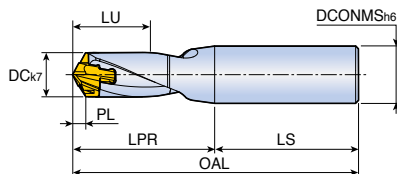
TCD...S0-1.5D



Head changeable drill holders - Cylindrical type shank



- Drilling depth: 1.5x diameter



Designation	Dimension (mm)							Clamping key
	DC	DCONMS	LU	LPR	LS	PL	SSC	
TCD 060-064-12S0-1.5D	6.0-6.4	12	10	23.0	45	0.96	6	K TCD D060-D099
065-069-12S0-1.5D	6.5-6.9	12	11	24.1	45	1.18	6.5	
070-074-12S0-1.5D	7.0-7.4	12	12	25.1	45	1.01	7	
075-079-12S0-1.5D	7.5-7.9	12	12	25.9	45	1.10	7	
080-089-12S0-1.5D	8.0-8.9	12	13	27.4	45	1.20	8	
090-099-12S0-1.5D	9.0-9.9	12	15	29.3	45	1.35	9	K TCD D100-D199
100-109-16S0-1.5D	10.0-10.9	16	17	31.2	48	1.50	10	
110-119-16S0-1.5D	11.0-11.9	16	19	33.1	48	1.67	11	
120-129-16S0-1.5D	12.0-12.9	16	20	35.0	48	1.82	12	
130-139-16S0-1.5D	13.0-13.9	16	22	37.1	48	1.96	13	
140-149-16S0-1.5D	14.0-14.9	16	23	41.1	48	2.12	14	K TCD D200-D269
150-159-20S0-1.5D	15.0-15.9	20	25	46.2	50	2.27	15	
160-169-20S0-1.5D	16.0-16.9	20	26	49.3	50	2.42	16	
170-179-20S0-1.5D	17.0-17.9	20	29	52.4	50	2.59	17	
180-189-25S0-1.5D	18.0-18.9	25	30	55.5	56	2.73	18	
190-199-25S0-1.5D	19.0-19.9	25	32	58.5	56	2.88	19	
200-209-25S0-1.5D	20.0-20.9	25	33	61.6	56	3.02	20	
210-219-25S0-1.5D	21.0-21.9	25	35	64.7	56	3.18	21	
220-229-25S0-1.5D	22.0-22.9	25	36	67.8	56	3.24	22	
230-239-32S0-1.5D	23.0-23.9	32	38	70.8	60	3.46	23	
240-249-32S0-1.5D	24.0-24.9	32	40	73.9	60	3.62	24	
250-259-32S0-1.5D	25.0-25.9	32	42	77.0	60	3.80	25	



- OAL: LPR+LS
- SSC: Seat size code

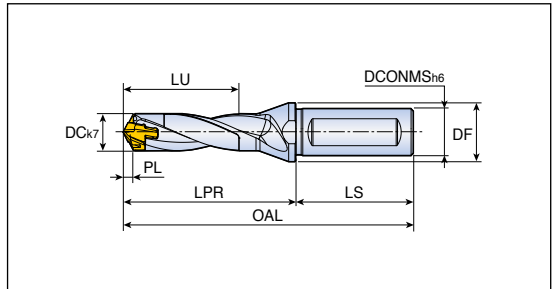
D189-D202

D242

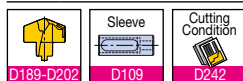
Head changeable drill holders - Weldon type shank



- Drilling depth: 3xdiameter



Designation	Dimension (mm)								Clamping key
	DC	DCONMS	DF	LU	LPR	LS	PL	SSC	
TCD 060-064-12T3-3D	6.0-6.4	12	16	19	32.0	45	0.96	6	K TCD D060-D099
065-069-12T3-3D	6.5-6.9	12	16	21	33.8	45	1.18	6.5	
070-074-12T3-3D	7.0-7.4	12	16	22	35.6	45	1.01	7	
075-079-12T3-3D	7.5-7.9	12	16	24	37.1	45	1.10	7	
080-084-12T3-3D	8.0-8.4	12	16	25	39.4	45	1.20	8	
085-089-12T3-3D	8.5-8.9	12	16	27	40.9	45	1.29	8	
090-094-12T3-3D	9.0-9.4	12	16	28	42.8	45	1.35	9	
095-099-12T3-3D	9.5-9.9	12	16	30	44.3	45	1.44	9	
100-104-16T3-3D	10.0-10.4	16	20	32	46.2	48	1.50	10	K TCD D100-D199
105-109-16T3-3D	10.5-10.9	16	20	34	47.7	48	1.59	10	
110-114-16T3-3D	11.0-11.4	16	20	35	49.6	48	1.67	11	
115-119-16T3-3D	11.5-11.9	16	20	37	51.1	48	1.76	11	
120-124-16T3-3D	12.0-12.4	16	20	38	53.0	48	1.82	12	
125-129-16T3-3D	12.5-12.9	16	20	39	54.5	48	1.91	12	
130-134-16T3-3D	13.0-13.4	16	20	41	56.6	48	1.96	13	
135-139-16T3-3D	13.5-13.9	16	20	43	58.1	48	2.05	13	
140-144-16T3-3D	14.0-14.4	16	20	44	62.2	48	2.12	14	
145-149-16T3-3D	14.5-14.9	16	20	46	63.7	48	2.21	14	
150-159-20T3-3D	15.0-15.9	20	25	47	68.7	50	2.27	15	K TCD D200-D269
160-169-20T3-3D	16.0-16.9	20	25	50	73.3	50	2.42	16	
170-179-20T3-3D	17.0-17.9	20	25	54	77.9	50	2.59	17	
180-189-25T2-3D	18.0-18.9	25	32	57	82.5	56	2.73	18	
190-199-25T2-3D	19.0-19.9	25	32	60	87.0	56	2.88	19	
200-209-25T2-3D	20.0-20.9	25	32	63	91.6	56	3.02	20	
210-219-25T2-3D	21.0-21.9	25	32	66	96.2	56	3.18	21	
220-229-25T2-3D	22.0-22.9	25	32	69	100.8	56	3.24	22	
230-239-32T2-3D	23.0-23.9	32	42	72	105.3	60	3.46	23	
240-249-32T2-3D	24.0-24.9	32	42	76	109.9	60	3.62	24	
250-259-32T2-3D	25.0-25.9	32	42	79	114.5	60	3.80	25	



- OAL: LPR+LS
- SSC: Seat size code

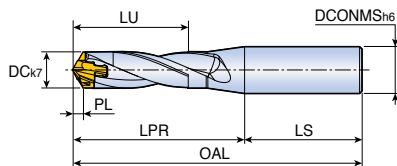
TCD...S0-3D



Head changeable drill holders - Cylindrical type shank



- Drilling depth: 3x diameter



Designation	Dimension (mm)							Clamping key
	DC	DCONMS	LU	LPR	LS	PL	SSC	
TCD 060-064-12S0-3D	6.0-6.4	12	19	32.0	45	0.96	6	K TCD D060-D099
065-069-12S0-3D	6.5-6.9	12	21	33.8	45	1.18	6.5	
070-074-12S0-3D	7.0-7.4	12	22	35.6	45	1.01	7	
075-079-12S0-3D	7.5-7.9	12	24	37.1	45	1.10	7	
080-084-12S0-3D	8.0-8.4	12	25	39.4	45	1.20	8	
085-089-12S0-3D	8.5-8.9	12	27	40.9	45	1.29	8	
090-094-12S0-3D	9.0-9.4	12	28	42.8	45	1.35	9	
095-099-12S0-3D	9.5-9.9	12	30	44.3	45	1.44	9	
100-104-16S0-3D	10.0-10.4	16	32	46.2	48	1.50	10	K TCD D100-D199
105-109-16S0-3D	10.5-10.9	16	34	47.7	48	1.59	10	
110-114-16S0-3D	11.0-11.4	16	35	49.6	48	1.67	11	
115-119-16S0-3D	11.5-11.9	16	37	51.1	48	1.76	11	
120-124-16S0-3D	12.0-12.4	16	38	53.0	48	1.82	12	
125-129-16S0-3D	12.5-12.9	16	39	54.5	48	1.91	12	
130-134-16S0-3D	13.0-13.4	16	41	56.6	48	1.96	13	
135-139-16S0-3D	13.5-13.9	16	43	58.1	48	2.05	13	
140-144-16S0-3D	14.0-14.4	16	44	62.1	48	2.12	14	
145-149-16S0-3D	14.5-14.9	16	46	63.7	48	2.21	14	
150-159-20S0-3D	15.0-15.9	20	47	68.7	50	2.27	15	K TCD D200-D269
160-169-20S0-3D	16.0-16.9	20	50	73.3	50	2.42	16	
170-179-20S0-3D	17.0-17.9	20	54	77.9	50	2.59	17	
180-189-25S0-3D	18.0-18.9	25	57	82.5	56	2.73	18	
190-199-25S0-3D	19.0-19.9	25	60	87.0	56	2.88	19	
200-209-25S0-3D	20.0-20.9	25	63	91.6	56	3.02	20	
210-219-25S0-3D	21.0-21.9	25	66	96.2	56	3.18	21	
220-229-25S0-3D	22.0-22.9	25	69	100.8	56	3.24	22	
230-239-32S0-3D	23.0-23.9	32	72	105.3	60	3.46	23	
240-249-32S0-3D	24.0-24.9	32	76	109.9	60	3.62	24	
250-259-32S0-3D	25.0-25.9	32	79	114.5	60	3.80	25	

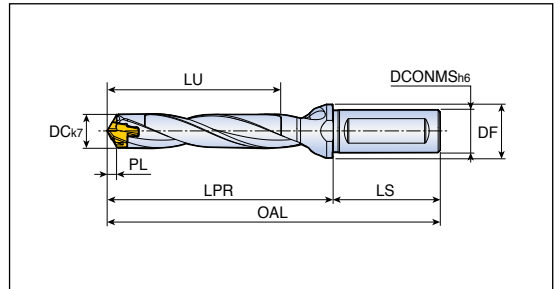


- OAL: LPR+LS
- SSC: Seat size code

Head changeable drill holders - Weldon type shank



- Drilling depth: 5xdiameter



Designation	Dimension (mm)								Clamping key
	DC	DCONMS	DF	LU	LPR	LS	PL	SSC	
TCD 060-064-12T3-5D	6.0-6.4	12	16	31	44.0	45	0.96	6	K TCD D060-D099
065-069-12T3-5D	6.5-6.9	12	16	34	46.8	45	1.18	6.5	
070-074-12T3-5D	7.0-7.4	12	16	36	49.6	45	1.01	7	
075-079-12T3-5D	7.5-7.9	12	16	39	52.1	45	1.10	7	
080-084-12T3-5D	8.0-8.4	12	16	41	55.4	45	1.20	8	
085-089-12T3-5D	8.5-8.9	12	16	44	57.9	45	1.29	8	
090-094-12T3-5D	9.0-9.4	12	16	46	60.8	45	1.35	9	
095-099-12T3-5D	9.5-9.9	12	16	49	63.3	45	1.44	9	
100-104-16T3-5D	10.0-10.4	16	20	52	66.2	48	1.50	10	K TCD D100-D199
105-109-16T3-5D	10.5-10.9	16	20	55	68.7	48	1.59	10	
110-114-16T3-5D	11.0-11.4	16	20	57	71.6	48	1.67	11	
115-119-16T3-5D	11.5-11.9	16	20	60	74.1	48	1.76	11	
120-124-16T3-5D	12.0-12.4	16	20	62	77.0	48	1.82	12	
125-129-16T3-5D	12.5-12.9	16	20	64	79.5	48	1.91	12	
130-134-16T3-5D	13.0-13.4	16	20	67	82.6	48	1.96	13	
135-139-16T3-5D	13.5-13.9	16	20	70	85.1	48	2.05	13	
140-144-16T3-5D	14.0-14.4	16	20	72	90.2	48	2.12	14	
145-149-16T3-5D	14.5-14.9	16	20	75	92.7	48	2.21	14	
150-159-20T3-5D	15.0-15.9	20	25	77	98.7	50	2.27	15	K TCD D200-D269
160-169-20T3-5D	16.0-16.9	20	25	82	105.3	50	2.42	16	
170-179-20T3-5D	17.0-17.9	20	25	88	111.9	50	2.59	17	
180-189-25T2-5D	18.0-18.9	25	32	93	118.5	56	2.73	18	
190-199-25T2-5D	19.0-19.9	25	32	98	125.0	56	2.88	19	
200-209-25T2-5D	20.0-20.9	25	32	103	131.6	56	3.02	20	
210-219-25T2-5D	21.0-21.9	25	32	108	138.2	56	3.18	21	
220-229-25T2-5D	22.0-22.9	25	32	113	144.8	56	3.24	22	
230-239-32T2-5D	23.0-23.9	32	42	118	151.3	60	3.46	23	
240-249-32T2-5D	24.0-24.9	32	42	124	157.9	60	3.62	24	
250-259-32T2-5D	25.0-25.9	32	42	129	164.5	60	3.80	25	



- OAL: LPR+LS
- SSC: Seat size code

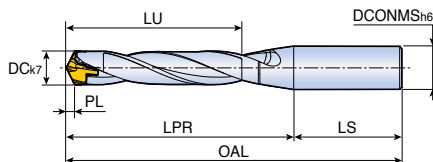
TCD...S0-5D



Head changeable drill holders - Cylindrical type shank



- Drilling depth: 5x diameter



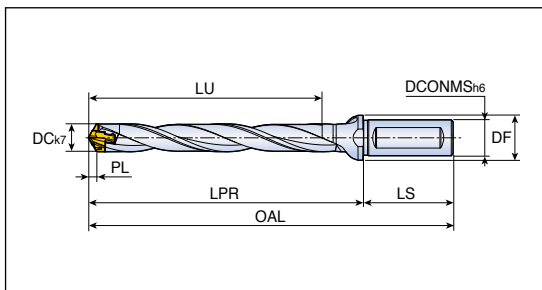
Designation	Dimension (mm)							Clamping key
	DC	DCONMS	LU	LPR	LS	PL	SSC	
TCD 060-064-12S0-5D	6.0-6.4	12	31	44.0	45	0.96	6	K TCD D060-D099
065-069-12S0-5D	6.5-6.9	12	34	46.8	45	1.18	6.5	
070-074-12S0-5D	7.0-7.4	12	36	49.6	45	1.01	7	
075-079-12S0-5D	7.5-7.9	12	39	52.1	45	1.10	7	
080-084-12S0-5D	8.0-8.4	12	41	55.4	45	1.20	8	
085-089-12S0-5D	8.5-8.9	12	44	57.9	45	1.29	8	
090-094-12S0-5D	9.0-9.4	12	46	60.8	45	1.35	9	
095-099-12S0-5D	9.5-9.9	12	49	63.3	45	1.44	9	
100-104-16S0-5D	10.0-10.4	16	52	66.2	48	1.50	10	K TCD D100-D199
105-109-16S0-5D	10.5-10.9	16	55	68.7	48	1.59	10	
110-114-16S0-5D	11.0-11.4	16	57	71.6	48	1.67	11	
115-119-16S0-5D	11.5-11.9	16	60	74.1	48	1.76	11	
120-124-16S0-5D	12.0-12.4	16	62	77.0	48	1.82	12	
125-129-16S0-5D	12.5-12.9	16	64	79.5	48	1.91	12	
130-134-16S0-5D	13.0-13.4	16	67	82.6	48	1.96	13	
135-139-16S0-5D	13.5-13.9	16	70	85.1	48	2.05	13	
140-144-16S0-5D	14.0-14.4	16	72	90.2	48	2.12	14	
145-149-16S0-5D	14.5-14.9	16	75	92.7	48	2.21	14	
150-159-20S0-5D	15.0-15.9	20	77	98.7	50	2.27	15	K TCD D200-D269
160-169-20S0-5D	16.0-16.9	20	82	105.3	50	2.42	16	
170-179-20S0-5D	17.0-17.9	20	88	111.9	50	2.59	17	
180-189-25S0-5D	18.0-18.9	25	93	118.5	56	2.73	18	
190-199-25S0-5D	19.0-19.9	25	98	125.0	56	2.88	19	
200-209-25S0-5D	20.0-20.9	25	103	131.6	56	3.02	20	
210-219-25S0-5D	21.0-21.9	25	108	138.2	56	3.18	21	
220-229-25S0-5D	22.0-22.9	25	113	144.8	56	3.24	22	
230-239-32S0-5D	23.0-23.9	32	118	151.3	60	3.46	23	
240-249-32S0-5D	24.0-24.9	32	124	157.9	60	3.62	24	
250-259-32S0-5D	25.0-25.9	32	129	164.5	60	3.80	25	



- OAL: LPR+LS
- SSC: Seat size code

DRILL RUSH

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- A schematic diagram of a water pump. It features a vertical shaft passing through a horizontal impeller. The impeller has four curved blades. The entire assembly is housed within a rectangular frame.



D189-202



- It is recommended to make the pilot hole with a 1.5D holder
- OAL: LPR+LS
- SSC: Seat size code

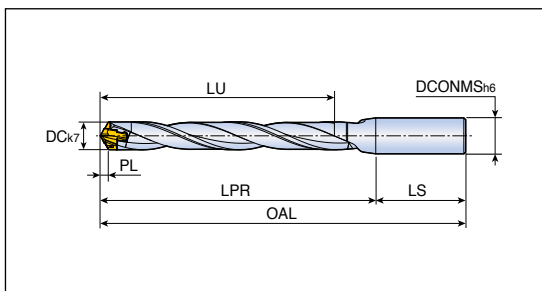
TCD...S0-8D



Head changeable drill holders - Cylindrical type shank



- Drilling depth: 8x diameter



Designation	Dimension (mm)							Clamping key
	DC	DCONMS	LU	LPR	LS	PL	SSC	
TCD 060-064-12S0-8D	6.0-6.4	12	49	62.0	45	0.96	6	K TCD D060-D099
065-069-12S0-8D	6.5-6.9	12	53	66.3	45	1.18	6.5	
070-074-12S0-8D	7.0-7.4	12	57	70.6	45	1.01	7	
075-079-12S0-8D	7.5-7.9	12	61	74.6	45	1.10	7	
080-084-12S0-8D	8.0-8.4	12	65	79.4	45	1.20	8	
085-089-12S0-8D	8.5-8.9	12	69	83.4	45	1.29	8	
090-094-12S0-8D	9.0-9.4	12	73	87.8	45	1.35	9	
095-099-12S0-8D	9.5-9.9	12	77	91.8	45	1.44	9	
100-104-16S0-8D	10.0-10.4	16	82	96.2	48	1.50	10	K TCD D100-D199
105-109-16S0-8D	10.5-10.9	16	86	100.2	48	1.59	10	
110-114-16S0-8D	11.0-11.4	16	90	104.6	48	1.67	11	
115-119-16S0-8D	11.5-11.9	16	94	108.6	48	1.76	11	
120-124-16S0-8D	12.0-12.4	16	98	113.0	48	1.82	12	
125-129-16S0-8D	12.5-12.9	16	102	117.0	48	1.91	12	
130-134-16S0-8D	13.0-13.4	16	106	121.6	48	1.96	13	
135-139-16S0-8D	13.5-13.9	16	110	125.6	48	2.05	13	
140-144-16S0-8D	14.0-14.4	16	114	132.2	48	2.12	14	
145-149-16S0-8D	14.5-14.9	16	118	136.2	48	2.21	14	
150-159-20S0-8D	15.0-15.9	20	122	143.7	50	2.27	15	K TCD D200-D269
160-169-20S0-8D	16.0-16.9	20	130	153.3	50	2.42	16	
170-179-20S0-8D	17.0-17.9	20	139	162.9	50	2.59	17	
180-189-25S0-8D	18.0-18.9	25	147	172.5	56	2.73	18	
190-199-25S0-8D	19.0-19.9	25	155	182.0	56	2.88	19	
200-209-25S0-8D	20.0-20.9	25	163	191.6	56	3.02	20	
210-219-25S0-8D	21.0-21.9	25	171	201.2	56	3.18	21	
220-229-25S0-8D	22.0-22.9	25	179	210.8	56	3.24	22	
230-239-32S0-8D	23.0-23.9	32	187	220.3	60	3.46	23	
240-249-32S0-8D	24.0-24.9	32	196	229.9	60	3.62	24	
250-259-32S0-8D	25.0-25.9	32	204	239.5	60	3.80	25	



- It is recommended to make the pilot hole with a 1.5D holder
- OAL: LPR+LS
- SSC: Seat size code

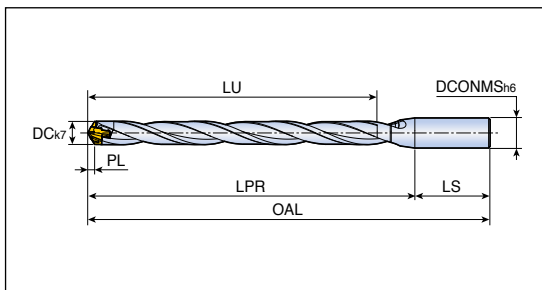
TCD...S0-12D



Head changeable drill holders - Cylindrical type shank



- Drilling depth: 12xdiameter

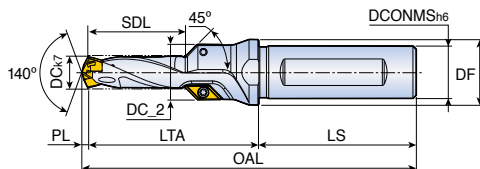


Designation	Dimension (mm)							Clamping key
	DC	DCONMS	LU	LPR	LS	PL	SSC	
TCD 080-084-12S0-12D	8.0-8.4	12	97	111.4	45	1.20	8	K TCD D060-D099
085-089-12S0-12D	8.5-8.9	12	103	117.4	45	1.29	8	
090-094-12S0-12D	9.0-9.4	12	109	123.8	45	1.35	9	
095-099-12S0-12D	9.5-9.9	12	115	129.8	45	1.44	9	
100-104-16S0-12D	10.0-10.4	16	122	136.2	48	1.50	10	K TCD D100-D199
105-109-16S0-12D	10.5-10.9	16	128	142.2	48	1.59	10	
110-114-16S0-12D	11.0-11.4	16	134	148.6	48	1.67	11	
115-119-16S0-12D	11.5-11.9	16	140	154.6	48	1.76	11	
120-124-16S0-12D	12.0-12.4	16	146	161.0	48	1.82	12	
125-129-16S0-12D	12.5-12.9	16	152	167.0	48	1.91	12	
130-134-16S0-12D	13.0-13.4	16	158	173.6	48	1.96	13	
135-139-16S0-12D	13.5-13.9	16	164	179.6	48	2.05	13	
140-144-16S0-12D	14.0-14.4	16	170	188.2	48	2.12	14	
145-149-16S0-12D	14.5-14.9	16	176	194.2	48	2.21	14	
150-159-20S0-12D	15.0-15.9	20	182	203.7	50	2.27	15	
160-169-20S0-12D	16.0-16.9	20	194	217.3	50	2.42	16	
170-179-20S0-12D	17.0-17.9	20	207	230.9	50	2.59	17	K TCD D200-D269
180-189-25S0-12D	18.0-18.9	25	219	244.5	56	2.73	18	
190-199-25S0-12D	19.0-19.9	25	221	258.0	56	2.88	19	
200-209-25S0-12D	20.0-20.9	25	243	271.6	56	3.02	20	
210-219-25S0-12D	21.0-21.9	25	255	285.2	56	3.18	21	
220-229-25S0-12D	22.0-22.9	25	267	298.8	56	3.24	22	
230-239-32S0-12D	23.0-23.9	32	289	312.3	60	3.46	23	
240-249-32S0-12D	24.0-24.9	32	292	325.9	60	3.62	24	
250-259-32S0-12D	25.0-25.9	32	304	339.5	60	3.80	25	



- It is recommended to make the pilot hole with a 1.5D holder
- OAL: LPR+LS
- SSC: Seat size code

Head changeable drill holders for pre-thread hole



Designation	ISO thread	DC	Dimension (mm)							Drill dia. range	Insert
			SDL	LTA	LS	DC_2	DCONMS	DF	PL		
TCD 068x21x12T3-M8	M8	6.8	21	43.77	45	13.5	12	16	1.23	6.5-6.9	AOMT 06...-C45 D203
085x26x12T3-M10	M10	8.5	26	48.71	45	15.5	12	16	1.29	8.5-8.9	
102x30x16T3-M12	M12	10.2	30	52.46	48	17.0	16	20	1.54	10.0-10.4	
120x35x16T3-M14	M14	12.0	35	59.18	48	19.0	16	20	1.82	12.0-12.4	
140x39x20T3-M16	M16	14.0	39	66.88	50	21.0	20	25	2.12	14.0-14.4	
175x42x20T3-M20	M20	17.5	42	69.32	50	24.5	20	27	2.68	17.0-17.9	
210x48x25T2-M24	M24	21.0	48	76.82	56	28.0	25	32	3.18	21.0-21.9	

► OAL: LTA+LS+PL

Spare parts

Designation	Screw	Wrench	Clamping key	
TCD 068	TS 22046I	TD 7	K TCD D060-D099	
TCD 085	TS 22046I	TD 7	K TCD D060-D099	
TCD 102 - 175	TS 22046I	TD 7	K TCD D100-D199	
TCD 210	TS 22046I	TD 7	K TCD D200-D269	



Plug for coolant supply in a stationary machines

TaeguTec supplies special plugs with an internal thread for coolant connections used on lathes that can be pressed into the cavity on the back end of the shank.

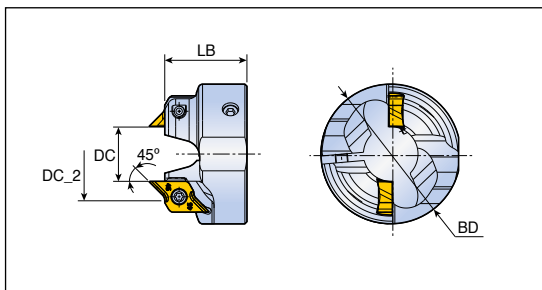
Description	Shank diameter	Internal thread
PL-TCD-12	12	G 1/16
PL-TCD-16	16	G 1/16
PL-TCD-20	20	G 1/8
PL-TCD-25	25	G 1/8
PL-TCD-32	32	G 1/8



CFR D...-A45



Chamfering ring tools



Designation	Dimension (mm)				Chamfer size	Chamfer insert
	DC	DC_2	BD	LB		
CFR D100-A45	9.8	16.56	34	20	2.5	CRNG 08...-45CD D203
D105-A45	10.3	17.06	34	20	2.5	
D110-A45	10.8	17.56	34	20	2.5	
D115-A45	11.3	18.06	34	20	2.5	
D120-A45	11.8	18.56	34	20	2.5	
D125-A45	12.3	19.06	34	20	2.5	
D130-A45	12.8	19.56	34	20	2.5	
D135-A45	13.3	20.06	34	20	2.5	
D140-A45	13.8	20.56	38	22	2.5	
D145-A45	14.3	21.06	38	22	2.5	
D150-A45	14.6	21.36	38	22	2.5	
D160-A45	15.6	22.36	42	23	2.5	
D170-A45	16.6	23.36	42	23	2.5	
D180-A45	17.6	24.36	42	23	2.5	
D190-A45	18.6	25.36	42	24	2.5	
D200-A45	19.6	26.36	42	24	2.5	
D210-A45	20.6	27.36	47	24	2.5	
D220-A45	21.6	28.36	47	24	2.5	
D230-A45	22.6	29.36	47	24	2.5	
D240-A45	23.6	30.36	47	24	2.5	
D250-A45	24.6	31.36	47	24	2.5	

Spare parts

Designation	Insert screw	Wrench	Clamping screw	L-wrench
CFR D100 - D135	SO 25065I	TD 7	SH M3x0.5x10 ⁽¹⁾	L-W2.5
CFR D140 - D150	SO 25065I	TD 7	SH M4x0.7x12 ⁽²⁾	L-W3
CFR D160 - D250	SO 25065I	TD 7	SH M5x0.8x16 ⁽³⁾	L-W4

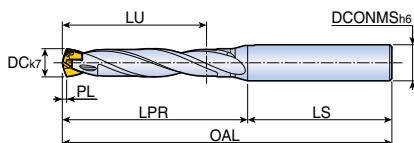


► ⁽¹⁾ Clamping torque: 2-3 [N·m] ⁽²⁾ Clamping torque: 3.5-4.5 [N·m] ⁽³⁾ Clamping torque: 5-6 [N·m]

D272-275

DRILL RUSH

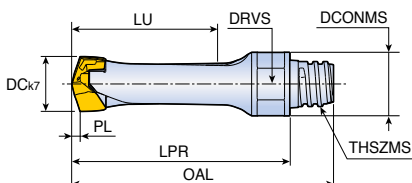
-
- A diagram of a water pump. A blue propeller is shown at the bottom of a vertical shaft. Water is being drawn up from below the propeller, forming a column that rises above the propeller. The water column is depicted with blue lines and a small globe-like shape at its base, representing the water being lifted.



Cutting Condition

- ▶ OAL: LPR+LS
- ▶ SSC: Seat size code

-
- A schematic diagram of a water pump. It features a central vertical shaft with a propeller at the bottom. The propeller is shown in a cross-section view, with blades extending outwards. The shaft is connected to a motor or drive mechanism at the top. The entire assembly is housed within a rectangular frame. Below the propeller, there is a discharge pipe or outlet. The diagram is labeled with 'a)' in the top left corner.



D189-202



- ▶ SSC: Seat size code
- ▶ Matched with MAXI-RUSH holder

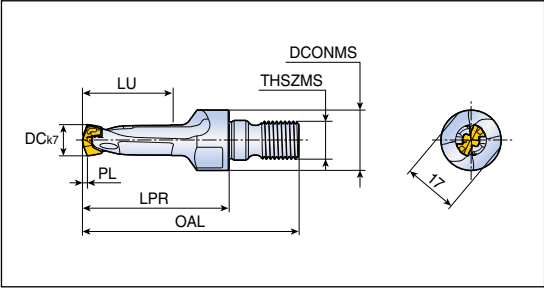
TCDM...-M12-2D



Head changeable drill holder with T-FLEXTEC type shank



- Drilling depth: 2xdiameter



Designation	Dimension (mm)								Clamping key
	DC	DCONMS	LU	LPR	PL	OAL	THSZMS	SSC	
TCDM 100-104-M12-2D	10.0-10.4	19	28.7	46.2	1.5	68.2	M12	10	K TCD D100-D199
105-109-M12-2D	10.5-10.9	19	29.7	47.2	1.6	69.2	M12	10	
110-114-M12-2D	11.0-11.4	19	31.1	48.6	1.7	70.6	M12	11	
115-119-M12-2D	11.5-11.9	19	32.1	49.6	1.8	71.6	M12	11	
120-124-M12-2D	12.0-12.4	19	33.5	51.0	1.8	73.0	M12	12	
125-129-M12-2D	12.5-12.9	19	34.5	52.0	1.9	74.0	M12	12	
130-134-M12-2D	13.0-13.4	19	36.1	53.6	2.0	75.6	M12	13	
135-139-M12-2D	13.5-13.9	19	37.1	54.6	2.1	76.6	M12	13	
140-144-M12-2D	14.0-14.4	19	38.7	56.2	2.1	78.2	M12	14	
145-149-M12-2D	14.5-14.9	19	39.7	57.2	2.2	79.2	M12	14	
150-159-M12-2D	15.0-15.9	19	41.2	58.7	2.3	80.7	M12	15	



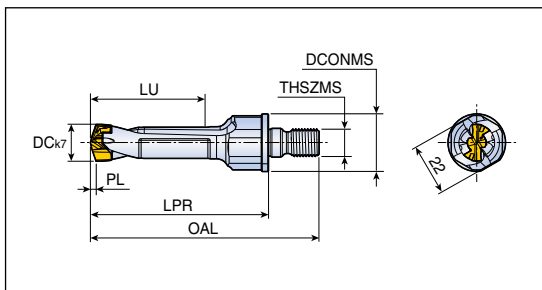
D189-D202



D242

- ▶ SSC: Seat size code
- ▶ Matched with T-FLEXTEC holder

-
- A schematic diagram of a water pump. It features a vertical shaft with a propeller-like impeller at the bottom. A horizontal pipe extends from the side of the pump housing, representing the discharge line. The pump is shown in a cross-sectional view within a rectangular frame.



D189-D20



- ▶ SSC: Seat size code
- ▶ Matched with T-FLEXTEC holder

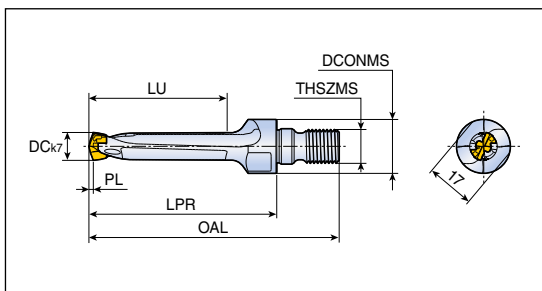
TCDM...-M12-4D



Head changeable drill holder with T-FLEXTEC type shank



- Drilling depth: 4x diameter



Designation	Dimension (mm)								Clamping key
	DC	DCONMS	LU	LPR	PL	OAL	THSZMS	SSC	
TCDM 100-104-M12-4D	10.0-10.4	19	48.7	66.2	1.5	88.2	M12	10	K TCD D100-D199
105-109-M12-4D	10.5-10.9	19	50.7	68.2	1.6	90.2	M12	10	
110-114-M12-4D	11.0-11.4	19	53.1	70.6	1.7	92.6	M12	11	
115-119-M12-4D	11.5-11.9	19	55.1	72.6	1.8	94.6	M12	11	
120-124-M12-4D	12.0-12.4	19	57.5	75.0	1.8	97.0	M12	12	
125-129-M12-4D	12.5-12.9	19	59.5	77.0	1.9	99.0	M12	12	
130-134-M12-4D	13.0-13.4	19	62.1	79.6	2.0	101.6	M12	13	
135-139-M12-4D	13.5-13.9	19	64.1	81.6	2.1	103.6	M12	13	
140-144-M12-4D	14.0-14.4	19	66.7	84.2	2.1	106.2	M12	14	
145-149-M12-4D	14.5-14.9	19	68.7	86.2	2.2	108.2	M12	14	
150-159-M12-4D	15.0-15.9	19	71.2	88.7	2.3	110.7	M12	15	



D189-D202



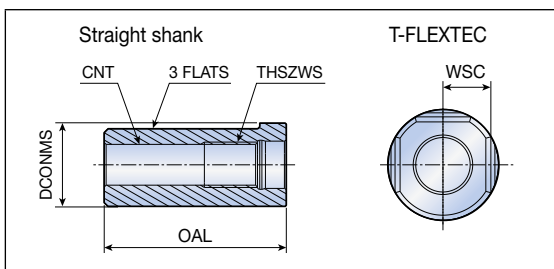
D242

- SSC: Seat size code
- Matched with T-FLEXTEC holder

TFLEX-TCD-M12



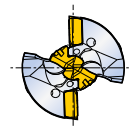
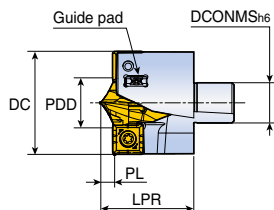
T-FLEXTEC shank



Designation	Dimension (mm)				CNT
	THSZWS	DCONMS	OAL	WSC	
TFLEX 160X36-TCD-M12	M12	16	36	7.5	UNF 5/16
190X36-TCD-M12	M12	19.05	36	8.5	UNF 5/16
200X36-TCD-M12	M12	20	36	8.5	G 1/8
220X48-TCD-M12	M12	22	48	9.5	G 1/8
250X54-TCD-M12	M12	25	54	11	G 1/8
254X54-TCD-M12	M12	25.4	54	11	G 1/8

TNDH-TP

Modular drill heads



Designation	Dimension (mm)					Clamping Key	Insert	
	DC	DCONMS	LPR	PL	PDD		Center	Outer
TNDH 2600-C26-TP	26	10.4	24.9	3.98	15.9	K TCD D15-D16 CO	TCD-159-P-CO+	SPGX 06...DW
2700-C26-TP	27	10.4	25.4	4.14	16.9	K TCD D15-D16 CO	TCD-169-P-CO+	D204
2800-C28-TP	28	11.2	26.9	4.29	17.9	K TCD D17-D19 CO	TCD-179-P-CO+	
2900-C28-TP	29	11.2	26.6	3.97	15.9	K TCD D15-D16 CO	TCD-159-P-CO+	SPGX 07...DW
3000-C30-TP	30	12.0	28.3	4.14	16.9	K TCD D15-D16 CO	TCD-169-P-CO+	D204
3100-C30-TP	31	12.0	28.5	4.30	17.9	K TCD D17-D19 CO	TCD-179-P-CO+	
3200-C32-TP	32	12.8	30.3	4.46	18.9	K TCD D17-D19 CO	TCD-189-P-CO+	SPGX 09...DW
3300-C32-TP	33	12.8	29.8	3.97	15.9	K TCD D15-D16 CO	TCD-159-P-CO+	
3400-C34-TP	34	13.6	31.6	4.14	16.9	K TCD D15-D16 CO	TCD-169-P-CO+	D204
3500-C34-TP	35	13.6	31.8	4.30	17.9	K TCD D17-D19 CO	TCD-179-P-CO+	
3600-C36-TP	36	14.4	33.5	4.46	18.9	K TCD D17-D19 CO	TCD-189-P-CO+	SPGX 11...DW
3700-C36-TP	37	14.4	33.3	4.14	16.9	K TCD D15-D16 CO	TCD-169-P-CO+	
3800-C38-TP	38	15.2	35.0	4.30	17.9	K TCD D17-D19 CO	TCD-179-P-CO+	D204
3900-C38-TP	39	15.2	35.2	4.46	18.9	K TCD D17-D19 CO	TCD-189-P-CO+	
4000-C40-TP	40	16.0	36.9	4.62	19.9	K TCD D17-D19 CO	TCD-199-P-CO+	
4100-C40-TP	41	16.0	37.1	4.78	20.9	K TCD D20-D21 CO	TCD-209-P-CO+	
4200-C42-TP	42	16.8	38.9	4.95	21.9	K TCD D20-D21 CO	TCD-219-P-CO+	
4300-C42-TP	43	16.8	38.9	5.11	22.9	K TCD D22-D23 CO	TCD-229-P-CO+	

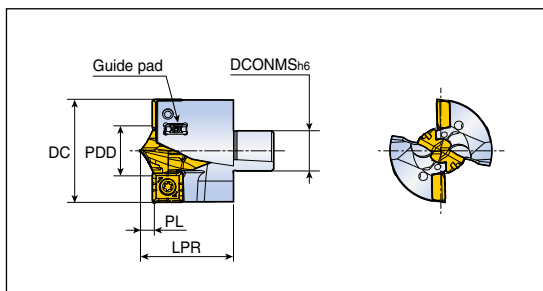
▶ DCONMS: Holder connection size

▶ Guide pad is sold separately from drill head

Spare parts

Designation	For double pitch screw		For SPGX		For Guide pad	
	Screw1	Wrench1	Screw2	Wrench2	Screw3	Wrench3
TNDH 2600-2800	TDPS 0512-T7	TD 7	TS 220521/HG	TD 7	TS 200431/HG-P	TD 6P
TNDH 2900-3200	TDPS 0512-T7	TD 7	TS 250641	TD 8	TS 200431/HG-P	TD 6P
TNDH 3300-3500	TDPS 0512-T7	TD 7	TS 350881	TD 10	TS 200431/HG-P	TD 6P
TNDH 3600	TDPS 0618-T8	TD 8	TS 350881	TD 10	TS 200431/HG-P	TD 6P
TNDH 3700-4300	TDPS 0618-T8	TD 8	TS 400931	TD 15	TS 200431/HG-P	TD 6P





- ▶ DCONMS: Holder connection size
- ▶ Guide pad is sold separately from drill head

Designation	For double pitch screw		For SPGX		For Guide pad	
	Screw1	Wrench1	Screw2	Wrench2	Screw3	Wrench3
TNDH 4400-4500	TDPS 0722-W3.0	F-W3.0	TS 40093I	TD 15	TS 20043I/HG-P	TD 6P
TNDH 4600-5000	TDPS 0722-W3.0	F-W3.0	SO 50090I	TD 20	TS 20043I/HG-P	TD 6P

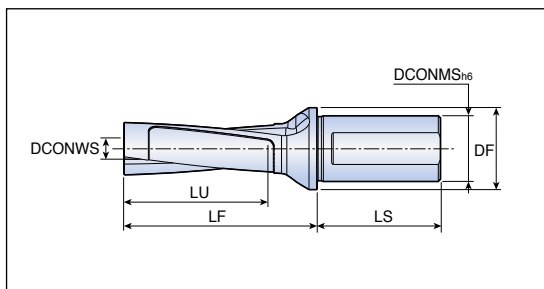


MDB...T2-3

Modular drill holders - Weldon type shank



- Drilling depth: 3xdiameter



Designation	Dimension (mm)						
	DC	DCONWS	DCONMS	DF	LU	LF	LS
MDB D26/27-081-32T2-C26-3	26-27	10.4	32	40	60	94.3	60
D28/29-087-32T2-C28-3	28-29	11.2	32	40	64	100.5	60
D30/31-093-32T2-C30-3	30-31	12.0	32	40	69	105.5	60
D32/33-099-32T2-C32-3	32-33	12.8	32	40	73	111.7	60
D34/35-105-40T2-C34-3	34-35	13.6	40	50	78	120.2	68
D36/37-111-40T2-C36-3	36-37	14.4	40	50	82	126.5	68
D38/39-117-40T2-C38-3	38-39	15.2	40	50	86	131.4	68
D40/41-123-40T2-C40-3	40-41	16.0	40	50	91	137.6	68
D42/43-129-40T2-C42-3	42-43	16.8	40	50	95	143.8	68
D44/45-135-40T2-C44-3	44-45	17.6	40	50	99	150.0	68
D46/47-141-50T2-C46-3	46-47	18.4	50	60	104	154.5	80
D48/50-150-50T2-C48-3	48-50	19.2	50	60	111	160.9	80

- DC: Cutting diameter range
- DCONWS: Modular head connection size
- Refer to the Modular head information on page **D75-D76**

Spare parts

Designation	Wrench	Wrench handle		
				
MDB D26/27-D34/35-3	BLD H-W2.5x210	SW6-T-SH		
MDB D36/37-D42/43-3	BLD H-W3.0x225	SW6-T-SH		
MDB D44/45-D48/50-3	BLD H-W4.0x255	SW6-T-SH		

- Wrench: Disassemble the modular head from the modular body (Insert from the rear shank)

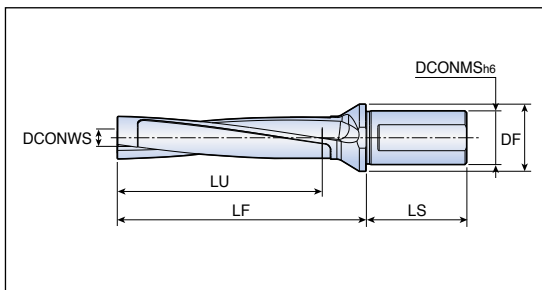


MDB...T2-5

Modular drill holders - Weldon type shank



- Drilling depth: 5x diameter



Designation	Dimension (mm)						
	DC	DCONWS	DCONMS	DF	LU	LF	LS
MDB D26/27-135-32T2-C26-5	26-27	10.4	32	40	114	148.3	60
D28/29-145-32T2-C28-5	28-29	11.2	32	40	122	158.5	60
D30/31-155-32T2-C30-5	30-31	12.0	32	40	131	167.5	60
D32/33-165-32T2-C32-5	32-33	12.8	32	40	139	177.7	60
D34/35-175-40T2-C34-5	34-35	13.6	40	50	148	190.2	68
D36/37-185-40T2-C36-5	36-37	14.4	40	50	156	200.5	68
D38/39-195-40T2-C38-5	38-39	15.2	40	50	164	209.4	68
D40/41-205-40T2-C40-5	40-41	16.0	40	50	173	219.6	68
D42/43-215-40T2-C42-5	42-43	16.8	40	50	181	229.8	68
D44/45-225-40T2-C44-5	44-45	17.6	40	50	189	240.0	68
D46/47-235-50T2-C46-5	46-47	18.4	50	60	198	248.5	80
D48/50-250-50T2-C48-5	48-50	19.2	50	60	211	258.9	80

- DC: Cutting diameter range
- DCONWS: Modular head connection size
- Refer to the Modular head information on page **D75-D76**

Spare parts

Designation	Wrench	Wrench handle		
MDB D26/27-D34/35-5	BLD H-W2.5x280	SW6-T-SH		
MDB D36/37-D42/43-5	BLD H-W3.0x310	SW6-T-SH		
MDB D44/45-D48/50-5	BLD H-W4.0x350	SW6-T-SH		

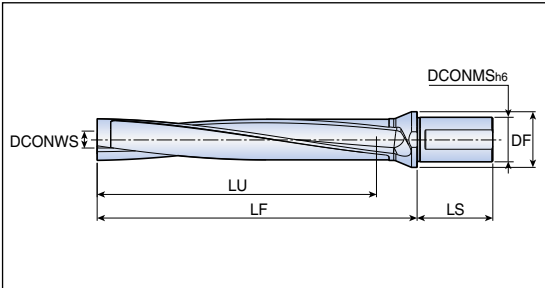
- Wrench: Disassemble the modular head from the modular body (Insert from the rear shank)



Modular drill holders - Weldon type shank



- Drilling depth: 7xdiameter



Designation	Dimension (mm)						
	DC	DCONWS	DCONMS	DF	LU	LF	LS
MDB D26/27-189-32T2-C26-7	26-27	10.4	32	40	168	202.3	60
D28/29-203-32T2-C28-7	28-29	11.2	32	40	180	216.5	60
D30/31-217-32T2-C30-7	30-31	12.0	32	40	193	229.5	60
D32/33-231-32T2-C32-7	32-33	12.8	32	40	205	243.7	60
D34/35-245-40T2-C34-7	34-35	13.6	40	50	218	260.2	68
D36/37-259-40T2-C36-7	36-37	14.4	40	50	230	274.5	68
D38/39-273-40T2-C38-7	38-39	15.2	40	50	242	287.4	68
D40/41-287-40T2-C40-7	40-41	16.0	40	50	255	301.6	68

- DC: Cutting diameter range
- DCONWS: Modular head connection size
- Refer to the Modular head information on page D75-D76

Spare parts

Designation	Wrench	Wrench handle		
MDB D26/27-7	BLD H-W2.5x280	SW6-T-SH		
MDB D28/29-D34/35-7	BLD H-W2.5x350	SW6-T-SH		
MDB D36/37-D40/41-7	BLD H-W3.0x400	SW6-T-SH		

- Wrench: Disassemble the modular head from the modular body (Insert from the rear shank)

Cutting Condition

D244

Technical Data

D276

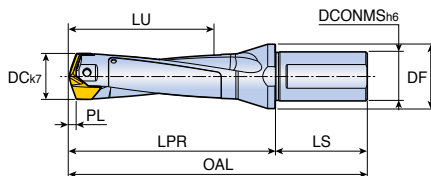
LCD...T2-3D



Head changeable drill holders - Weldon type shank



- Drilling depth: 3x diameter



Designation	Dimension (mm)							
	DC	DCONMS	DF	LU	LPR	LS	PL	SSC
LCD 200-209-25T2-3D	20.0-20.9	25	32	63	92.1	56	3.11	20
210-219-25T2-3D	21.0-21.9	25	32	66	95.3	56	3.29	21
220-229-25T2-3D	22.0-22.9	25	32	69	98.4	56	3.42	22
230-239-25T2-3D	23.0-23.9	25	32	73	101.6	56	3.60	23
240-249-32T2-3D	24.0-24.9	32	40	76	110.7	60	3.73	24
250-259-32T2-3D	25.0-25.9	32	40	79	113.9	60	3.91	25
260-269-32T2-3D	26.0-26.9	32	40	82	117.0	60	4.04	26
270-279-32T2-3D	27.0-27.9	32	40	85	120.2	60	4.22	27
280-289-32T2-3D	28.0-28.9	32	40	88	128.4	60	4.35	28
290-299-32T2-3D	29.0-29.9	32	40	92	131.5	60	4.53	29
300-309-32T2-3D	30.0-30.9	32	42	95	134.7	60	4.67	30
310-319-32T2-3D	31.0-31.9	32	42	98	137.9	60	4.85	31
320-329-40T2-3D	32.0-32.9	40	48	101	143.0	68	4.98	32
330-339-40T2-3D	33.0-33.9	40	48	104	146.2	68	5.16	33
340-349-40T2-3D	34.0-34.9	40	48	107	149.3	68	5.34	34
350-359-40T2-3D	35.0-35.9	40	48	110	152.4	68	5.44	35
360-369-40T2-3D	36.0-36.9	40	48	114	155.6	68	5.62	36
370-379-40T2-3D	37.0-37.9	40	48	117	158.8	68	5.80	37
380-389-40T2-3D	38.0-38.9	40	50	120	166.9	68	5.91	38
390-399-40T2-3D	39.0-39.9	40	50	123	170.1	68	6.09	39
400-410-40T2-3D	40.0-41.0	40	50	126	173.3	68	6.27	40

► OAL: LPR+LS ► SSC: Seat size code

Spare parts

Designation	Screw	Wrench	Wrench handle	
LCD 200-219-3D	TS 40178D25	BLD T20/S7	SW6-T-SH	
LCD 220-239-3D	TS 40198D28	BLD T20/S7	SW6-T-SH	
LCD 240-259-3D	TS 40210D3	BLD T20/S7	SW6-T-SH	
LCD 260-279-3D	TS 50230D3	BLD T20/S7	SW6-T-SH	
LCD 280-299-3D	TS 50250D35	BLD T25/S7	SW6-T-SH	
LCD 300-319-3D	TS 60265D4	BLD T25/S7	SW6-T-SH	
LCD 320-349-3D	TS 60285D42	BLD T25/S7	SW6-T-SH	
LCD 350-379-3D	TS 60320D5	BLD T25/S7	SW6-T-SH	
LCD 380-410-3D	TS 80340D6	BLD T25/S7	SW6-T-SH	



D205-D208

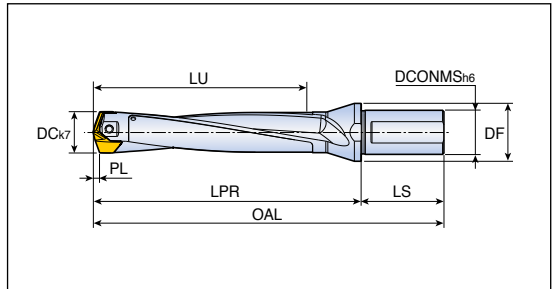


D246

Head changeable drill holders - Weldon type shank



- Drilling depth: 5xdiameter

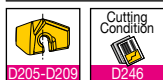


Designation	Dimension (mm)							
	DC	DCONMS	DF	LU	LPR	LS	PL	SSC
LCD 200-209-25T2-5D	20.0-20.9	25	32	103	132.1	56	3.11	20
210-219-25T2-5D	21.0-21.9	25	32	108	137.3	56	3.29	21
220-229-25T2-5D	22.0-22.9	25	32	113	142.4	56	3.42	22
230-239-25T2-5D	23.0-23.9	25	32	119	147.6	56	3.60	23
240-249-32T2-5D	24.0-24.9	32	40	124	158.7	60	3.73	24
250-259-32T2-5D	25.0-25.9	32	40	129	163.9	60	3.91	25
260-269-32T2-5D	26.0-26.9	32	40	134	169.0	60	4.04	26
270-279-32T2-5D	27.0-27.9	32	40	139	174.2	60	4.22	27
280-289-32T2-5D	28.0-28.9	32	40	144	184.4	60	4.35	28
290-299-32T2-5D	29.0-29.9	32	40	150	189.5	60	4.53	29
300-309-32T2-5D	30.0-30.9	32	42	155	194.7	60	4.67	30
310-319-32T2-5D	31.0-31.9	32	42	160	199.9	60	4.85	31
320-329-40T2-5D	32.0-32.9	40	48	165	207.0	68	4.98	32
330-339-40T2-5D	33.0-33.9	40	48	170	212.2	68	5.16	33
340-349-40T2-5D	34.0-34.9	40	48	175	217.3	68	5.34	34
350-359-40T2-5D	35.0-35.9	40	48	180	222.4	68	5.44	35
360-369-40T2-5D	36.0-36.9	40	48	186	227.6	68	5.62	36
370-379-40T2-5D	37.0-37.9	40	48	191	232.8	68	5.80	37
380-389-40T2-5D	38.0-38.9	40	50	196	242.9	68	5.91	38
390-399-40T2-5D	39.0-39.9	40	50	201	248.1	68	6.09	39
400-410-40T2-5D	40.0-41.0	40	50	206	253.3	68	6.27	40

► OAL: LPR+LS ► SSC: Seat size code

Spare parts

Designation	Screw	Wrench	Wrench handle	
LCD 200-219-5D	TS 40178D25	BLD T20/S7	SW6-T-SH	
LCD 220-239-5D	TS 40198D28	BLD T20/S7	SW6-T-SH	
LCD 240-259-5D	TS 40210D3	BLD T20/S7	SW6-T-SH	
LCD 260-279-5D	TS 50230D3	BLD T20/S7	SW6-T-SH	
LCD 280-299-5D	TS 50250D35	BLD T25/S7	SW6-T-SH	
LCD 300-319-5D	TS 60265D4	BLD T25/S7	SW6-T-SH	
LCD 320-349-5D	TS 60285D42	BLD T25/S7	SW6-T-SH	
LCD 350-379-5D	TS 60320D5	BLD T25/S7	SW6-T-SH	
LCD 380-410-5D	TS 80340D6	BLD T25/S7	SW6-T-SH	



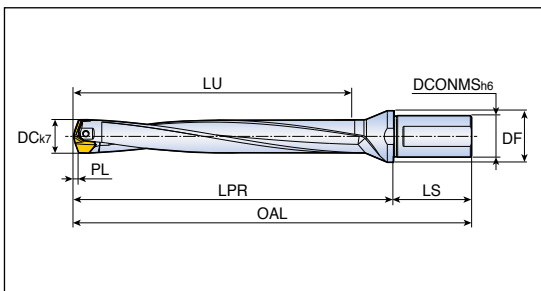
LCD...T2-8D



Head changeable drill holders - Weldon type shank



- Drilling depth: 8x diameter



Designation	Dimension (mm)							
	DC	DCONMS	DF	LU	LPR	LS	PL	SSC
LCD 200-209-25T2-8D	20.0-20.9	25	32	163.1	192.1	56	3.11	20
210-219-25T2-8D	21.0-21.9	25	32	171.3	200.1	56	3.29	21
220-229-25T2-8D	22.0-22.9	25	32	179.4	208.4	56	3.42	22
230-239-25T2-8D	23.0-23.9	25	32	187.6	216.4	56	3.60	23
240-249-32T2-8D	24.0-24.9	32	40	195.7	230.7	60	3.73	24
250-259-32T2-8D	25.0-25.9	32	40	203.9	238.7	60	3.91	25
260-269-32T2-8D	26.0-26.9	32	40	212.0	247.0	60	4.04	26
270-279-32T2-8D	27.0-27.9	32	40	220.2	255.0	60	4.22	27
280-289-32T2-8D	28.0-28.9	32	40	228.4	268.4	60	4.35	28
290-299-32T2-8D	29.0-29.9	32	40	236.5	276.4	60	4.53	29
300-309-32T2-8D	30.0-30.9	32	42	244.7	284.7	60	4.67	30
310-319-32T2-8D	31.0-31.9	32	42	252.9	292.7	60	4.85	31
320-329-40T2-8D	32.0-32.9	40	48	261.0	303.0	68	4.98	32
330-339-40T2-8D	33.0-33.9	40	48	269.2	311.0	68	5.16	33
340-349-40T2-8D	34.0-34.9	40	48	277.3	319.0	68	5.34	34
350-359-40T2-8D	35.0-35.9	40	48	285.4	327.4	68	5.44	35
360-369-40T2-8D	36.0-36.9	40	48	293.6	335.4	68	5.62	36
370-379-40T2-8D	37.0-37.9	40	48	301.8	343.4	68	5.80	37
380-389-40T2-8D	38.0-38.9	40	50	309.9	356.9	68	5.91	38
390-399-40T2-8D	39.0-39.9	40	50	318.1	364.9	68	6.09	39
400-410-40T2-8D	40.0-41.0	40	50	326.3	372.9	68	6.27	40

- OAL: LPR + LS
- SSC: Seat size code
- It is recommended to make the pilot hole with a 3D holder

Spare parts

Designation	Screw	Wrench	Wrench handle	
LCD 200-219-8D	TS 40178D25	BLD T20/S7	SW6-T-SH	
LCD 220-239-8D	TS 40198D28	BLD T20/S7	SW6-T-SH	
LCD 240-259-8D	TS 40210D3	BLD T20/S7	SW6-T-SH	
LCD 260-279-8D	TS 50230D3	BLD T20/S7	SW6-T-SH	
LCD 280-299-8D	TS 50250D35	BLD T25/S7	SW6-T-SH	
LCD 300-319-8D	TS 60265D4	BLD T25/S7	SW6-T-SH	
LCD 320-349-8D	TS 60285D42	BLD T25/S7	SW6-T-SH	
LCD 350-379-8D	TS 60320D5	BLD T25/S7	SW6-T-SH	
LCD 380-410-8D	TS 80340D6	BLD T25/S7	SW6-T-SH	

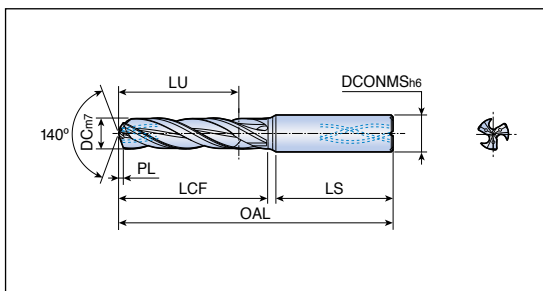


D205-209



D246

-



Cutting Condition



D248

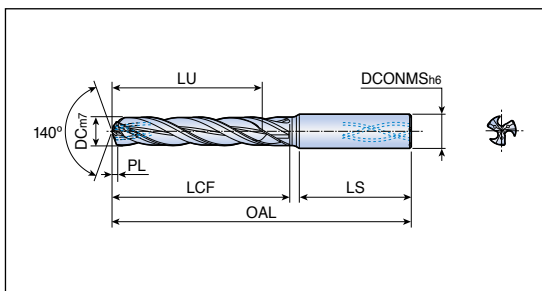


TaeguTec
Member IMC Group

3 flute solid carbide drills with oil holes



- Drilling depth: $5 \times \text{diameter}$

[illegible]

●: Standard items

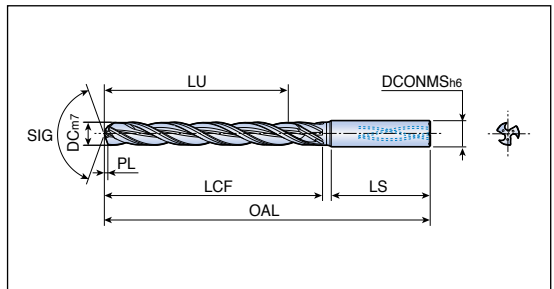
3HD...PI8



3 flute solid carbide drills with oil holes



- Drilling depth: $8 \times \text{diameter}$

[illegible]

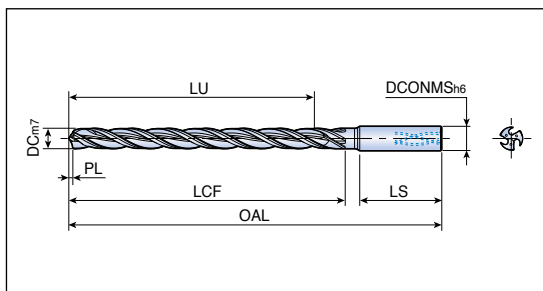
- ▶ Ø4.00-Ø8.00: SIG 140°
- ▶ Ø8.01-Ø12.00: SIG 130°

- : Standard items

3 flute solid carbide drill with oil holes



- Drilling depth: $12 \times \text{diameter}$

[illegible]

●: Standard items



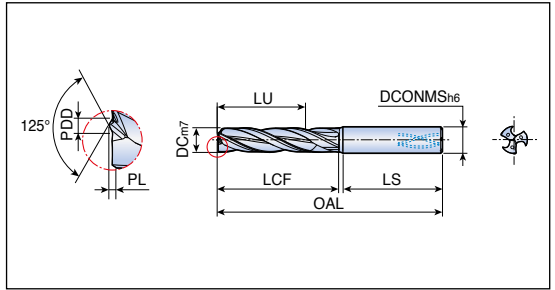
3HD...FI3



3 flute solid carbide drills for flat bottom holes



- Drilling depth: 3xdiameter

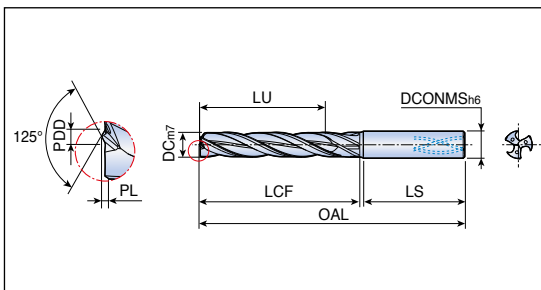
[illegible]

- : Standard items

3 flute solid carbide drills for flat bottom holes



- Drilling depth: $5 \times \text{diameter}$



Cutting Condition



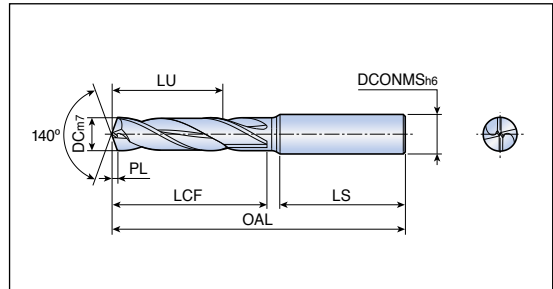
D248

●: Standard items

Solid carbide drills without oil holes



- Drilling depth: 3xdiameter



Designation	Dimension (mm)							Grade
	DC	DCONMS	OAL	LU	LCF	LS	PL	TT9030
NHD 030-014-06 PE3	3.0	6	62	14	21	34	0.5	●
031-014-06 PE3	3.1	6	62	14	21	34	0.5	●
032-014-06 PE3	3.2	6	62	14	21	34	0.5	●
033-014-06 PE3	3.3	6	62	14	21	34	0.5	●
034-014-06 PE3	3.4	6	62	14	21	34	0.5	●
035-014-06 PE3	3.5	6	62	14	21	34	0.6	●
036-014-06 PE3	3.6	6	62	14	21	34	0.6	●
037-014-06 PE3	3.7	6	62	14	21	34	0.6	●
038-017-06 PE3	3.8	6	66	17	25	35	0.6	●
039-017-06 PE3	3.9	6	66	17	25	35	0.6	●
040-017-06 PE3	4.0	6	66	17	25	35	0.6	●
041-017-06 PE3	4.1	6	66	17	25	35	0.7	●
042-017-06 PE3	4.2	6	66	17	25	35	0.7	●
043-017-06 PE3	4.3	6	66	17	25	35	0.7	●
044-017-06 PE3	4.4	6	66	17	25	35	0.7	●
045-017-06 PE3	4.5	6	66	17	25	35	0.7	●
046-017-06 PE3	4.6	6	66	17	25	35	0.7	●
047-017-06 PE3	4.7	6	66	17	25	35	0.8	●
048-020-06 PE3	4.8	6	66	20	29	36	0.8	●
049-020-06 PE3	4.9	6	66	20	29	36	0.8	●
050-020-06 PE3	5.0	6	66	20	29	36	0.8	●
051-020-06 PE3	5.1	6	66	20	29	36	0.8	●
052-020-06 PE3	5.2	6	66	20	29	36	0.8	●
053-020-06 PE3	5.3	6	66	20	29	36	0.8	●
054-020-06 PE3	5.4	6	66	20	29	36	0.8	●
055-020-06 PE3	5.5	6	66	20	29	36	0.9	●
056-020-06 PE3	5.6	6	66	20	29	36	0.9	●
057-020-06 PE3	5.7	6	66	20	29	36	0.9	●
058-020-06 PE3	5.8	6	66	20	29	36	0.9	●
059-020-06 PE3	5.9	6	66	20	29	36	0.9	●
060-020-06 PE3	6.0	6	66	20	29	36	0.9	●
061-024-08 PE3	6.1	8	79	24	35	36	1.0	●
062-024-08 PE3	6.2	8	79	24	35	36	1.0	●
063-024-08 PE3	6.3	8	79	24	35	36	1.0	●
064-024-08 PE3	6.4	8	79	24	35	36	1.0	●

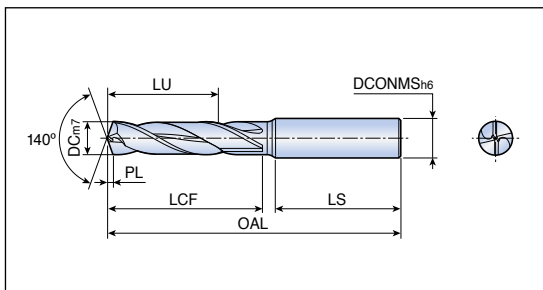
●: Standard items



Solid carbide drills without oil holes



- Drilling depth: 3x diameter



Designation	Dimension (mm)							Grade
	DC	DCONMS	OAL	LU	LCF	LS	PL	TT9030
NHD 065-024-08 PE3	6.5	8	79	24	35	36	1.0	●
066-024-08 PE3	6.6	8	79	24	35	36	1.0	●
067-024-08 PE3	6.7	8	79	24	35	36	1.1	●
068-024-08 PE3	6.8	8	79	24	35	36	1.1	●
069-024-08 PE3	6.9	8	79	24	35	36	1.1	●
070-024-08 PE3	7.0	8	79	24	35	36	1.1	●
071-029-08 PE3	7.1	8	79	29	42	36	1.1	●
072-029-08 PE3	7.2	8	79	29	42	36	1.1	●
073-029-08 PE3	7.3	8	79	29	42	36	1.1	●
074-029-08 PE3	7.4	8	79	29	42	36	1.2	●
075-029-08 PE3	7.5	8	79	29	42	36	1.2	●
076-029-08 PE3	7.6	8	79	29	42	36	1.2	●
077-029-08 PE3	7.7	8	79	29	42	36	1.2	●
078-029-08 PE3	7.8	8	79	29	42	36	1.2	●
079-029-08 PE3	7.9	8	79	29	42	36	1.3	●
080-029-08 PE3	8.0	8	79	29	42	36	1.3	●
081-035-10 PE3	8.1	10	89	35	48	40	1.3	●
082-035-10 PE3	8.2	10	89	35	48	40	1.3	●
083-035-10 PE3	8.3	10	89	35	48	40	1.3	●
084-035-10 PE3	8.4	10	89	35	48	40	1.3	●
085-035-10 PE3	8.5	10	89	35	48	40	1.3	●
086-035-10 PE3	8.6	10	89	35	48	40	1.4	●
087-035-10 PE3	8.7	10	89	35	48	40	1.4	●
088-035-10 PE3	8.8	10	89	35	48	40	1.4	●
089-035-10 PE3	8.9	10	89	35	48	40	1.4	●
090-035-10 PE3	9.0	10	89	35	48	40	1.4	●
091-035-10 PE3	9.1	10	89	35	48	40	1.4	●
092-035-10 PE3	9.2	10	89	35	48	40	1.4	●
093-035-10 PE3	9.3	10	89	35	48	40	1.5	●
094-035-10 PE3	9.4	10	89	35	48	40	1.5	●
095-035-10 PE3	9.5	10	89	35	48	40	1.5	●
096-035-10 PE3	9.6	10	89	35	48	40	1.5	●
097-035-10 PE3	9.7	10	89	35	48	40	1.5	●
098-035-10 PE3	9.8	10	89	35	48	40	1.6	●
099-035-10 PE3	9.9	10	89	35	48	40	1.6	●

- Standard items



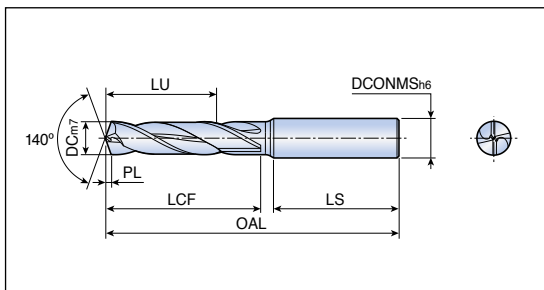
NHD...PE3



Solid carbide drills without oil holes



- Drilling depth: $3 \times \text{diameter}$

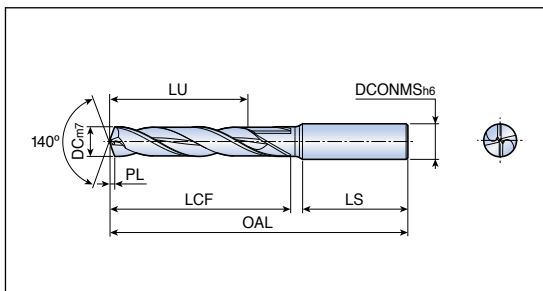
[illegible]

●: Standard items

Solid carbide drills without oil holes



- Drilling depth: 5x diameter



Designation	Dimension (mm)							Grade
	DC	DCONMS	OAL	LU	LCF	LS	PL	TT9030
NHD 030-023-06 PE5	3.0	6	66	23	29	34	0.5	●
031-023-06 PE5	3.1	6	66	23	29	34	0.5	●
032-023-06 PE5	3.2	6	66	23	29	34	0.5	●
033-023-06 PE5	3.3	6	66	23	29	34	0.5	●
034-023-06 PE5	3.4	6	66	23	29	34	0.5	●
035-023-06 PE5	3.5	6	66	23	29	34	0.6	●
036-023-06 PE5	3.6	6	66	23	29	34	0.6	●
037-023-06 PE5	3.7	6	66	23	29	34	0.6	●
038-029-06 PE5	3.8	6	74	29	37	35	0.6	●
039-029-06 PE5	3.9	6	74	29	37	35	0.6	●
040-029-06 PE5	4.0	6	74	29	37	35	0.6	●
041-029-06 PE5	4.1	6	74	29	37	35	0.7	●
042-029-06 PE5	4.2	6	74	29	37	35	0.7	●
043-029-06 PE5	4.3	6	74	29	37	35	0.7	●
044-029-06 PE5	4.4	6	74	29	37	35	0.7	●
045-029-06 PE5	4.5	6	74	29	37	35	0.7	●
046-029-06 PE5	4.6	6	74	29	37	35	0.7	●
047-029-06 PE5	4.7	6	74	29	37	35	0.8	●
048-035-06 PE5	4.8	6	82	35	45	36	0.8	●
049-035-06 PE5	4.9	6	82	35	45	36	0.8	●
050-035-06 PE5	5.0	6	82	35	45	36	0.8	●
051-035-06 PE5	5.1	6	82	35	45	36	0.8	●
052-035-06 PE5	5.2	6	82	35	45	36	0.8	●
053-035-06 PE5	5.3	6	82	35	45	36	0.8	●
054-035-06 PE5	5.4	6	82	35	45	36	0.8	●
055-035-06 PE5	5.5	6	82	35	45	36	0.9	●
056-035-06 PE5	5.6	6	82	35	45	36	0.9	●
057-035-06 PE5	5.7	6	82	35	45	36	0.9	●
058-035-06 PE5	5.8	6	82	35	45	36	0.9	●
059-035-06 PE5	5.9	6	82	35	45	36	0.9	●
060-035-06 PE5	6.0	6	82	35	45	36	0.9	●
061-043-08 PE5	6.1	8	91	43	54	36	1.0	●
062-043-08 PE5	6.2	8	91	43	54	36	1.0	●
063-043-08 PE5	6.3	8	91	43	54	36	1.0	●
064-043-08 PE5	6.4	8	91	43	54	36	1.0	●

- Standard items



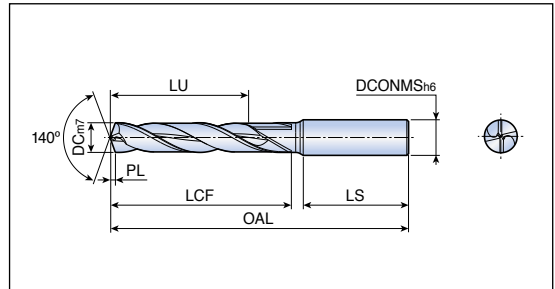
NHD...PE5



Solid carbide drills without oil holes



- Drilling depth: 5xdiameter



Designation	Dimension (mm)							Grade TT9030
	DC	DCONMS	OAL	LU	LCF	LS	PL	
NHD 065-043-08 PE5	6.5	8	91	43	54	36	1.0	●
066-043-08 PE5	6.6	8	91	43	54	36	1.0	●
067-043-08 PE5	6.7	8	91	43	54	36	1.1	●
068-043-08 PE5	6.8	8	91	43	54	36	1.1	●
069-043-08 PE5	6.9	8	91	43	54	36	1.1	●
070-043-08 PE5	7.0	8	91	43	54	36	1.1	●
071-043-08 PE5	7.1	8	91	43	54	36	1.1	●
072-043-08 PE5	7.2	8	91	43	54	36	1.1	●
073-043-08 PE5	7.3	8	91	43	54	36	1.1	●
074-043-08 PE5	7.4	8	91	43	54	36	1.2	●
075-043-08 PE5	7.5	8	91	43	54	36	1.2	●
076-043-08 PE5	7.6	8	91	43	54	36	1.2	●
077-043-08 PE5	7.7	8	91	43	54	36	1.2	●
078-043-08 PE5	7.8	8	91	43	54	36	1.2	●
079-043-08 PE5	7.9	8	91	43	54	36	1.3	●
080-043-08 PE5	8.0	8	91	43	54	36	1.3	●
081-049-10 PE5	8.1	10	103	49	62	40	1.3	●
082-049-10 PE5	8.2	10	103	49	62	40	1.3	●
083-049-10 PE5	8.3	10	103	49	62	40	1.3	●
084-049-10 PE5	8.4	10	103	49	62	40	1.3	●
085-049-10 PE5	8.5	10	103	49	62	40	1.3	●
086-049-10 PE5	8.6	10	103	49	62	40	1.4	●
087-049-10 PE5	8.7	10	103	49	62	40	1.4	●
088-049-10 PE5	8.8	10	103	49	62	40	1.4	●
089-049-10 PE5	8.9	10	103	49	62	40	1.4	●
090-049-10 PE5	9.0	10	103	49	62	40	1.4	●
091-049-10 PE5	9.1	10	103	49	62	40	1.4	●
092-049-10 PE5	9.2	10	103	49	62	40	1.4	●
093-049-10 PE5	9.3	10	103	49	62	40	1.5	●
094-049-10 PE5	9.4	10	103	49	62	40	1.5	●
095-049-10 PE5	9.5	10	103	49	62	40	1.5	●
096-049-10 PE5	9.6	10	103	49	62	40	1.5	●
097-049-10 PE5	9.7	10	103	49	62	40	1.5	●
098-049-10 PE5	9.8	10	103	49	62	40	1.6	●
099-049-10 PE5	9.9	10	103	49	62	40	1.6	●

●: Standard items



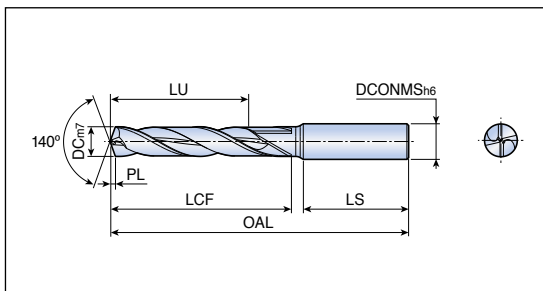
NHD...PE5



Solid carbide drills without oil holes



- Drilling depth: 5xdiameter

[illegible]

●: Standard items

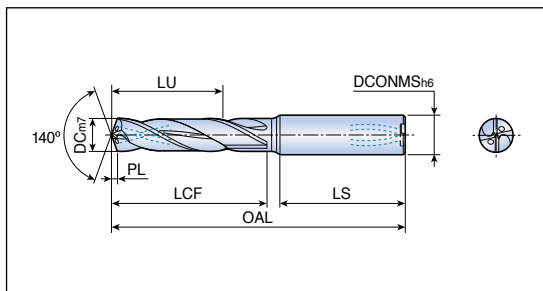
NHD...PI3



Solid carbide drills with oil holes



- Drilling depth: 3xdiameter



Designation	Dimension (mm)							Grade
	DC	DCONMS	OAL	LU	LCF	LS	PL	TT9030
NHD 030-014-06 PI3	3.0	6	62	14	21	34	0.5	●
031-014-06 PI3	3.1	6	62	14	21	34	0.5	●
032-014-06 PI3	3.2	6	62	14	21	34	0.5	●
033-014-06 PI3	3.3	6	62	14	21	34	0.5	●
034-014-06 PI3	3.4	6	62	14	21	34	0.5	●
035-014-06 PI3	3.5	6	62	14	21	34	0.6	●
036-014-06 PI3	3.6	6	62	14	21	34	0.6	●
037-014-06 PI3	3.7	6	62	14	21	34	0.6	●
038-017-06 PI3	3.8	6	66	17	25	35	0.6	●
039-017-06 PI3	3.9	6	66	17	25	35	0.6	●
040-017-06 PI3	4.0	6	66	17	25	35	0.6	●
041-017-06 PI3	4.1	6	66	17	25	35	0.7	●
042-017-06 PI3	4.2	6	66	17	25	35	0.7	●
043-017-06 PI3	4.3	6	66	17	25	35	0.7	●
044-017-06 PI3	4.4	6	66	17	25	35	0.7	●
045-017-06 PI3	4.5	6	66	17	25	35	0.7	●
046-017-06 PI3	4.6	6	66	17	25	35	0.7	●
047-017-06 PI3	4.7	6	66	17	25	35	0.8	●
048-020-06 PI3	4.8	6	66	20	29	36	0.8	●
049-020-06 PI3	4.9	6	66	20	29	36	0.8	●
050-020-06 PI3	5.0	6	66	20	29	36	0.8	●
051-020-06 PI3	5.1	6	66	20	29	36	0.8	●
052-020-06 PI3	5.2	6	66	20	29	36	0.8	●
053-020-06 PI3	5.3	6	66	20	29	36	0.8	●
054-020-06 PI3	5.4	6	66	20	29	36	0.8	●
055-020-06 PI3	5.5	6	66	20	29	36	0.9	●
056-020-06 PI3	5.6	6	66	20	29	36	0.9	●
057-020-06 PI3	5.7	6	66	20	29	36	0.9	●
058-020-06 PI3	5.8	6	66	20	29	36	0.9	●
059-020-06 PI3	5.9	6	66	20	29	36	0.9	●
060-020-06 PI3	6.0	6	66	20	29	36	0.9	●
061-024-08 PI3	6.1	8	79	24	35	36	1.0	●
062-024-08 PI3	6.2	8	79	24	35	36	1.0	●
063-024-08 PI3	6.3	8	79	24	35	36	1.0	●
064-024-08 PI3	6.4	8	79	24	35	36	1.0	●

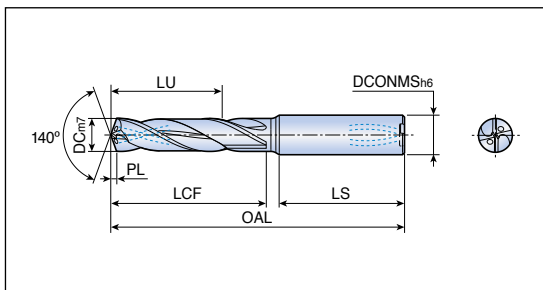
●: Standard items



Solid carbide drills with oil holes



- Drilling depth: 3x diameter



Designation	Dimension (mm)							Grade TT9030
	DC	DCONMS	OAL	LU	LCF	LS	PL	
NHD 065-024-08 PI3	6.5	8	79	24	35	36	1.0	●
066-024-08 PI3	6.6	8	79	24	35	36	1.0	●
067-024-08 PI3	6.7	8	79	24	35	36	1.1	●
068-024-08 PI3	6.8	8	79	24	35	36	1.1	●
069-024-08 PI3	6.9	8	79	24	35	36	1.1	●
070-024-08 PI3	7.0	8	79	24	35	36	1.1	●
071-029-08 PI3	7.1	8	79	29	42	36	1.1	●
072-029-08 PI3	7.2	8	79	29	42	36	1.1	●
073-029-08 PI3	7.3	8	79	29	42	36	1.1	●
074-029-08 PI3	7.4	8	79	29	42	36	1.2	●
075-029-08 PI3	7.5	8	79	29	42	36	1.2	●
076-029-08 PI3	7.6	8	79	29	42	36	1.2	●
077-029-08 PI3	7.7	8	79	29	42	36	1.2	●
078-029-08 PI3	7.8	8	79	29	42	36	1.2	●
079-029-08 PI3	7.9	8	79	29	42	36	1.3	●
080-029-08 PI3	8.0	8	79	29	42	36	1.3	●
081-035-10 PI3	8.1	10	89	35	48	40	1.3	●
082-035-10 PI3	8.2	10	89	35	48	40	1.3	●
083-035-10 PI3	8.3	10	89	35	48	40	1.3	●
084-035-10 PI3	8.4	10	89	35	48	40	1.3	●
085-035-10 PI3	8.5	10	89	35	48	40	1.3	●
086-035-10 PI3	8.6	10	89	35	48	40	1.4	●
087-035-10 PI3	8.7	10	89	35	48	40	1.4	●
088-035-10 PI3	8.8	10	89	35	48	40	1.4	●
089-035-10 PI3	8.9	10	89	35	48	40	1.4	●
090-035-10 PI3	9.0	10	89	35	48	40	1.4	●
091-035-10 PI3	9.1	10	89	35	48	40	1.4	●
092-035-10 PI3	9.2	10	89	35	48	40	1.4	●
093-035-10 PI3	9.3	10	89	35	48	40	1.5	●
094-035-10 PI3	9.4	10	89	35	48	40	1.5	●
095-035-10 PI3	9.5	10	89	35	48	40	1.5	●
096-035-10 PI3	9.6	10	89	35	48	40	1.5	●
097-035-10 PI3	9.7	10	89	35	48	40	1.5	●
098-035-10 PI3	9.8	10	89	35	48	40	1.6	●
099-035-10 PI3	9.9	10	89	35	48	40	1.6	●

- Standard items



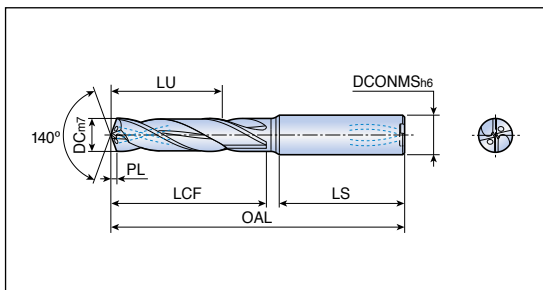
NHD...PI3



Solid carbide drills with oil holes



- Drilling depth: $3 \times \text{diameter}$

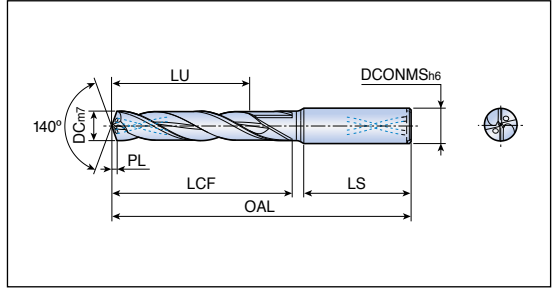
[illegible]

●: Standard items

Solid carbide drills with oil holes



- Drilling depth: 5x diameter



Designation	Dimension (mm)							Grade
	DC	DCONMS	OAL	LU	LCF	LS	PL	TT9030
NHD 030-023-06 PI5	3.0	6	66	23	29	34	0.5	●
031-023-06 PI5	3.1	6	66	23	29	34	0.5	●
032-023-06 PI5	3.2	6	66	23	29	34	0.5	●
033-023-06 PI5	3.3	6	66	23	29	34	0.5	●
034-023-06 PI5	3.4	6	66	23	29	34	0.5	●
035-023-06 PI5	3.5	6	66	23	29	34	0.6	●
036-023-06 PI5	3.6	6	66	23	29	34	0.6	●
037-023-06 PI5	3.7	6	66	23	29	34	0.6	●
038-029-06 PI5	3.8	6	74	29	37	35	0.6	●
039-029-06 PI5	3.9	6	74	29	37	35	0.6	●
040-029-06 PI5	4.0	6	74	29	37	35	0.6	●
041-029-06 PI5	4.1	6	74	29	37	35	0.7	●
042-029-06 PI5	4.2	6	74	29	37	35	0.7	●
043-029-06 PI5	4.3	6	74	29	37	35	0.7	●
044-029-06 PI5	4.4	6	74	29	37	35	0.7	●
045-029-06 PI5	4.5	6	74	29	37	35	0.7	●
046-029-06 PI5	4.6	6	74	29	37	35	0.7	●
047-029-06 PI5	4.7	6	74	29	37	35	0.8	●
048-035-06 PI5	4.8	6	82	35	45	36	0.8	●
049-035-06 PI5	4.9	6	82	35	45	36	0.8	●
050-035-06 PI5	5.0	6	82	35	45	36	0.8	●
051-035-06 PI5	5.1	6	82	35	45	36	0.8	●
052-035-06 PI5	5.2	6	82	35	45	36	0.8	●
053-035-06 PI5	5.3	6	82	35	45	36	0.8	●
054-035-06 PI5	5.4	6	82	35	45	36	0.8	●
055-035-06 PI5	5.5	6	82	35	45	36	0.9	●
056-035-06 PI5	5.6	6	82	35	45	36	0.9	●
057-035-06 PI5	5.7	6	82	35	45	36	0.9	●
058-035-06 PI5	5.8	6	82	35	45	36	0.9	●
059-035-06 PI5	5.9	6	82	35	45	36	0.9	●
060-035-06 PI5	6.0	6	82	35	45	36	0.9	●
061-043-08 PI5	6.1	8	91	43	54	36	1.0	●
062-043-08 PI5	6.2	8	91	43	54	36	1.0	●
063-043-08 PI5	6.3	8	91	43	54	36	1.0	●
064-043-08 PI5	6.4	8	91	43	54	36	1.0	●

- Standard items



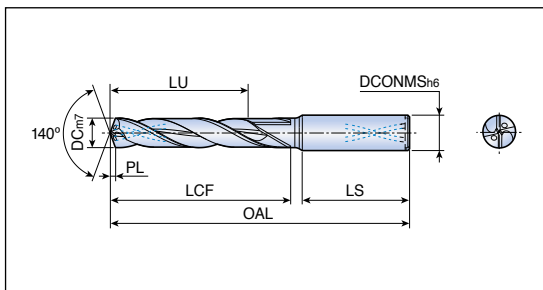
NHD...PI5



Solid carbide drills with oil holes



- Drilling depth: 5xdiameter



Designation	Dimension (mm)							Grade
	DC	DCONMS	OAL	LU	LCF	LS	PL	TT9030
NHD 065-043-08 PI5	6.5	8	91	43	54	36	1.0	●
066-043-08 PI5	6.6	8	91	43	54	36	1.0	●
067-043-08 PI5	6.7	8	91	43	54	36	1.1	●
068-043-08 PI5	6.8	8	91	43	54	36	1.1	●
069-043-08 PI5	6.9	8	91	43	54	36	1.1	●
070-043-08 PI5	7.0	8	91	43	54	36	1.1	●
071-043-08 PI5	7.1	8	91	43	54	36	1.1	●
072-043-08 PI5	7.2	8	91	43	54	36	1.1	●
073-043-08 PI5	7.3	8	91	43	54	36	1.1	●
074-043-08 PI5	7.4	8	91	43	54	36	1.2	●
075-043-08 PI5	7.5	8	91	43	54	36	1.2	●
076-043-08 PI5	7.6	8	91	43	54	36	1.2	●
077-043-08 PI5	7.7	8	91	43	54	36	1.2	●
078-043-08 PI5	7.8	8	91	43	54	36	1.2	●
079-043-08 PI5	7.9	8	91	43	54	36	1.3	●
080-043-08 PI5	8.0	8	91	43	54	36	1.3	●
081-049-10 PI5	8.1	10	103	49	62	40	1.3	●
082-049-10 PI5	8.2	10	103	49	62	40	1.3	●
083-049-10 PI5	8.3	10	103	49	62	40	1.3	●
084-049-10 PI5	8.4	10	103	49	62	40	1.3	●
085-049-10 PI5	8.5	10	103	49	62	40	1.3	●
086-049-10 PI5	8.6	10	103	49	62	40	1.4	●
087-049-10 PI5	8.7	10	103	49	62	40	1.4	●
088-049-10 PI5	8.8	10	103	49	62	40	1.4	●
089-049-10 PI5	8.9	10	103	49	62	40	1.4	●
090-049-10 PI5	9.0	10	103	49	62	40	1.4	●
091-049-10 PI5	9.1	10	103	49	62	40	1.4	●
092-049-10 PI5	9.2	10	103	49	62	40	1.4	●
093-049-10 PI5	9.3	10	103	49	62	40	1.5	●
094-049-10 PI5	9.4	10	103	49	62	40	1.5	●
095-049-10 PI5	9.5	10	103	49	62	40	1.5	●
096-049-10 PI5	9.6	10	103	49	62	40	1.5	●
097-049-10 PI5	9.7	10	103	49	62	40	1.5	●
098-049-10 PI5	9.8	10	103	49	62	40	1.6	●
099-049-10 PI5	9.9	10	103	49	62	40	1.6	●



- : Standard items

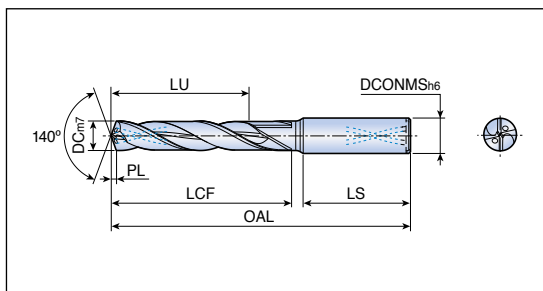
NHD...PI5



Solid carbide drills with oil holes



- Drilling depth: 5xdiameter

[illegible]

●: Standard items

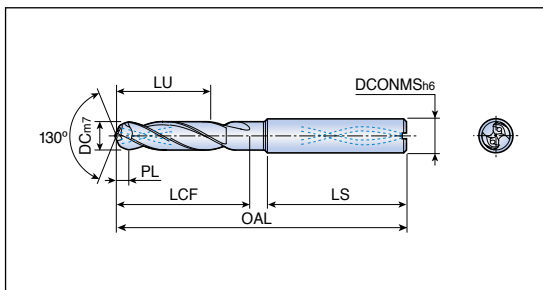
NHD...KI3



Solid carbide drills with oil holes for cast iron machining



• Drilling depth: 3x diameter



Designation	Dimension (mm)							Grade
	DC	DCONMS	OAL	LU	LCF	LS	PL	TT9030
NHD 030-014-06 KI3	3.0	6	62	14	20	34	1.4	●
033-014-06 KI3	3.3	6	62	14	20	34	1.6	●
035-014-06 KI3	3.5	6	62	14	20	34	1.7	●
040-017-06 KI3	4.0	6	66	17	24	35	1.9	●
041-017-06 KI3	4.1	6	66	17	24	35	2.0	●
042-017-06 KI3	4.2	6	66	17	24	35	2.0	●
045-017-06 KI3	4.5	6	66	17	24	35	2.2	●
046-017-06 KI3	4.6	6	66	17	24	35	2.2	●
050-020-06 KI3	5.0	6	66	20	27	36	2.4	●
051-020-06 KI3	5.1	6	66	20	27	36	2.5	●
052-020-06 KI3	5.2	6	66	20	27	36	2.5	●
055-020-06 KI3	5.5	6	66	20	27	36	2.6	●
060-020-06 KI3	6.0	6	66	20	27	36	2.9	●
061-024-08 KI3	6.1	8	79	24	34	36	2.9	●
065-024-08 KI3	6.5	8	79	24	34	36	3.1	●
067-024-08 KI3	6.7	8	79	24	34	36	3.2	●
068-024-08 KI3	6.8	8	79	24	34	36	3.3	●
070-024-08 KI3	7.0	8	79	24	34	36	3.4	●
075-029-08 KI3	7.5	8	79	29	40	36	3.6	●
080-029-08 KI3	8.0	8	79	29	40	36	3.8	●
081-035-10 KI3	8.1	10	89	35	45	40	3.9	●
085-035-10 KI3	8.5	10	89	35	45	40	4.1	●
087-035-10 KI3	8.7	10	89	35	45	40	4.2	●
089-035-10 KI3	8.9	10	89	35	45	40	4.3	●
090-035-10 KI3	9.0	10	89	35	45	40	4.3	●
095-035-10 KI3	9.5	10	89	35	45	40	4.6	●
100-035-10 KI3	10.0	10	89	35	45	40	4.8	●
103-040-12 KI3	10.3	12	102	40	53	45	4.9	●
105-040-12 KI3	10.5	12	102	40	53	45	5.0	●
110-040-12 KI3	11.0	12	102	40	53	45	5.3	●
115-040-12 KI3	11.5	12	102	40	53	45	5.5	●
120-040-12 KI3	12.0	12	102	40	53	45	5.8	●



●: Standard items

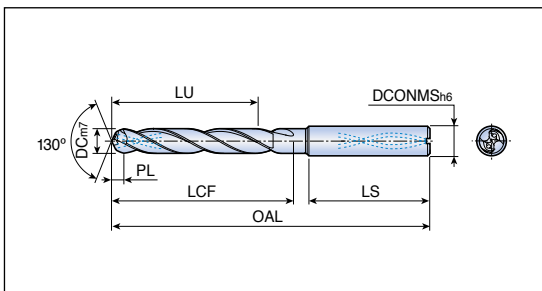
NHD...KI5



Solid carbide drills with oil holes for cast iron machining



- Drilling depth: 5x diameter



Designation	Dimension (mm)							Grade
	DC	DCONMS	OAL	LU	LCF	LS	PL	TT9030
NHD 030-023-06 KI5	3.0	6	66	23	27	34	1.4	●
033-023-06 KI5	3.3	6	66	23	27	34	1.6	●
035-023-06 KI5	3.5	6	66	23	27	34	1.7	●
040-029-06 KI5	4.0	6	74	29	34	35	1.9	●
042-029-06 KI5	4.2	6	74	29	34	35	2.0	●
045-029-06 KI5	4.5	6	74	29	35	35	2.2	●
046-029-06 KI5	4.6	6	74	29	35	35	2.2	●
050-035-06 KI5	5.0	6	82	35	43	36	2.4	●
052-035-06 KI5	5.2	6	82	35	43	36	2.5	●
055-035-06 KI5	5.5	6	82	35	43	36	2.6	●
060-035-06 KI5	6.0	6	82	35	43	36	2.9	●
065-043-08 KI5	6.5	8	91	43	52	36	3.1	●
067-043-08 KI5	6.7	8	91	43	52	36	3.2	●
068-043-08 KI5	6.8	8	91	43	52	36	3.3	●
070-043-08 KI5	7.0	8	91	43	52	36	3.4	●
075-043-08 KI5	7.5	8	91	43	52	36	3.6	●
080-043-08 KI5	8.0	8	91	43	52	36	3.8	●
081-049-10 KI5	8.1	10	103	49	59	40	3.9	●
085-049-10 KI5	8.5	10	103	49	59	40	4.1	●
087-049-10 KI5	8.7	10	103	49	59	40	4.2	●
089-049-10 KI5	8.9	10	103	49	59	40	4.3	●
090-049-10 KI5	9.0	10	103	49	59	40	4.3	●
095-049-10 KI5	9.5	10	103	49	59	40	4.6	●
100-049-10 KI5	10.0	10	103	49	59	40	4.8	●
103-056-12 KI5	10.3	12	118	56	69	45	4.9	●
105-056-12 KI5	10.5	12	118	56	69	45	5.0	●
110-056-12 KI5	11.0	12	118	56	69	45	5.3	●
115-056-12 KI5	11.5	12	118	56	69	45	5.5	●
120-056-12 KI5	12.0	12	118	56	69	45	5.8	●

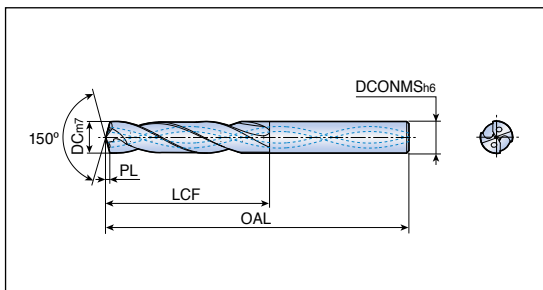


- Standard items

Solid pilot drills for solid long drill

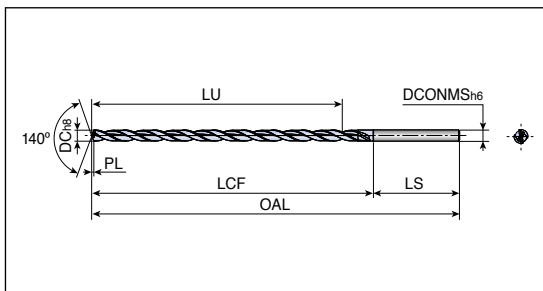


- M.Q.L drilling is available

[illegible]

●: Standard items

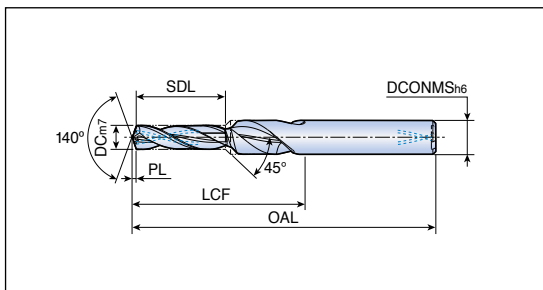
-
- A schematic diagram of a water pump. It features a vertical shaft passing through a horizontal impeller. The impeller has several curved blades. The entire assembly is housed within a rectangular frame that represents the pump casing.



Cutting Condition

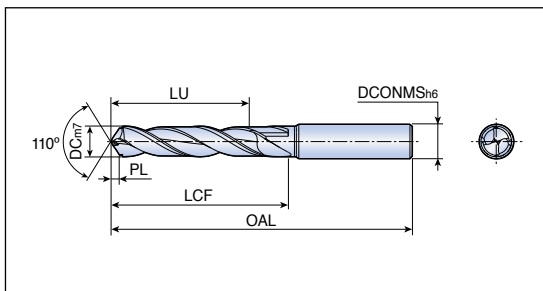
ADVANCECUTTING
TaeguTec

Solid carbide drills for pre-thread holes



Cutting Condition
D250

●: Standard items

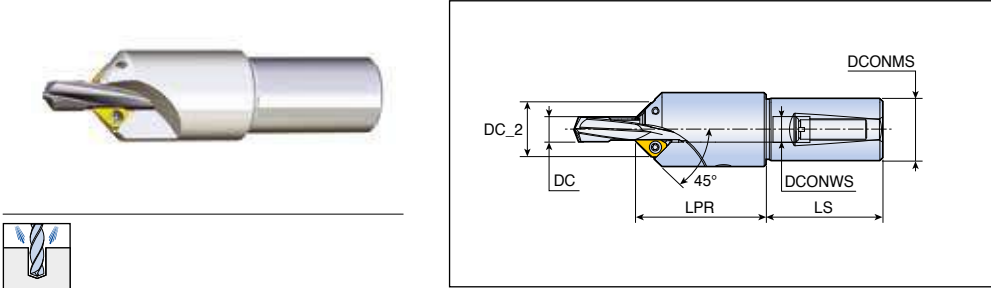


●: Standard items

T-CHAMFER...T1

TCHAMFER

Chamfering tools with solid carbide drill



Designation	DC	Dimension (mm)					Insert
		DCONWS	DC_2	DCONMS	LPR	LS	
T-CHAMFER 080-20T1-06	7.1-8.0	8	18.8	20	47.4	50	XCGT 06....C..  D210
090-20T1-06	8.1-9.0	9	19.8	20	47.4	50	
100-32T1-09	9.1-10.0	10	24.9	32	67.3	60	XCGT 09....C..  D210
110-32T1-09	10.1-11.0	11	25.9	32	67.3	60	
120-32T1-09	11.1-12.0	12	26.9	32	67.3	60	
130-32T1-09	12.1-13.0	13	27.9	32	67.3	60	
140-32T1-09	13.1-14.0	14	28.4	32	67.3	60	
150-32T1-09	14.1-15.0	15	29.4	32	67.3	60	
160-32T1-09	15.1-16.0	16	30.4	32	67.3	60	
170-32T1-09	16.1-17.0	17	31.4	32	67.3	60	
180-32T1-09	17.1-18.0	18	32.4	32	67.3	60	
190-32T1-09	18.1-19.0	19	33.4	32	75.0	60	
200-32T1-09	19.1-20.0	20	34.4	32	75.0	60	

Spare parts

Designation	Side screw	Back screw	L-wrench	Insert screw	Wrench
					
T-CHAMFER 080 - 090	SS M6x1x6	M6x1-SP	L-W 3	TS 25064I	TD 8
T-CHAMFER 100 - 200	SS M10x1.5x10	M10x1.5-SP	L-W 5	TS 40093I	TD 15

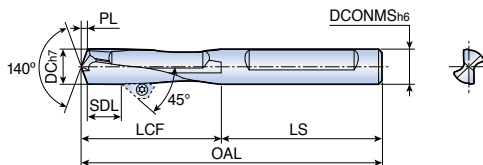
Assembly



D108

Solid carbide drills for T-CHAMFER

TCHAMFER



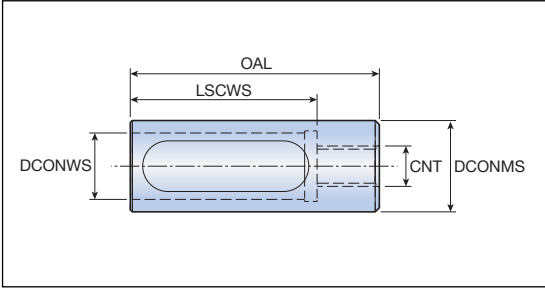
- 'SDL' is factored with a 45° insert positioned in insert pocket
- Solid carbide drill with internal coolant holes is available on request

● Standard items

► The maximum chamfer size is obtained when using the smallest drill diameter in the drilling range

TSL-NC

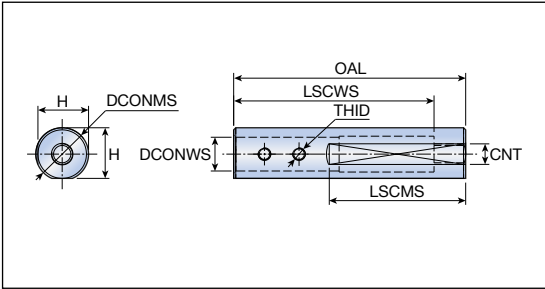
Drill sleeves for Swiss type automatic lathes (Fixed type, internal coolant)



Designation	Dimension (mm)				
	DCONMS	DCONWS	LSCWS	OAL	CNT
TSL-NC 19.05-12	19.05	12.0	45	60	Rc 1/8
19.05-16	19.05	16.0	45	60	Rc 1/8
20-12	20.0	12.0	45	60	Rc 1/8
20-16	20.0	16.0	45	60	Rc 1/8
22-16	22.0	16.0	45	60	Rc 1/8
25-20	25.0	20.0	45	60	Rc 1/8
25.4-20	25.4	20.0	45	60	Rc 1/8
32-25	32.0	25.0	45	60	Rc 1/8

TSL-SW

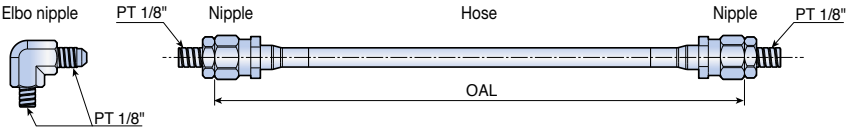
Drill sleeves for Swiss type automatic lathes (Adjustable type, internal coolant)



Designation	Dimension (mm)							
	DCONMS	DCONWS	LSCWS	LSCMS	OAL	H	THID	CNT
TSL-SW 22-12	22.0	12.0	95	65	110	21.0	M6	Rc 1/8
25-12	25.0	12.0	95	65	110	24.0	M8	Rc 1/8
25-16	25.0	16.0	95	65	110	24.0	M6	Rc 1/8
25.4-12	25.4	12.0	95	65	110	24.4	M8	Rc 1/8
25.4-16	25.4	16.0	95	65	110	24.4	M6	Rc 1/8
32-12	32.0	12.0	95	65	110	31.0	M8	Rc 1/8
32-16	32.0	16.0	95	65	110	31.0	M8	Rc 1/8
32-20	32.0	20.0	95	65	110	31.0	M8	Rc 1/8

Accessories

Hose set



* Hose set components: 1 hose, 2 nipples, 1 elbo nipple

Designation	Dimension (mm)	
	OAL (mm)	Max. pressure (bar)
S-TSL HOSE R1/8-220	220	100
R1/8-350	350	100

► Hose set is ordered separately

Spare parts

Designation	Mounting screw	Wrench		
				
TSL-SW 22-12	SS M6X1X5	L-W 3		
TSL-SW 25-12	SS M8X1.25X6	L-W 4		
TSL-SW 25-16	SS M6X1X5	L-W 3		
TSL-SW 25.4-12	SS M8X1.25X6	L-W 4		
TSL-SW 25.4-16	SS M6X1X5	L-W 3		
TSL-SW 32-12	SS M8X1.25X6	L-W 4		
TSL-SW 32-16	SS M8X1.25X6	L-W 4		
TSL-SW 32-20	SS M8X1.25X6	L-W 4		

Reaming Tools



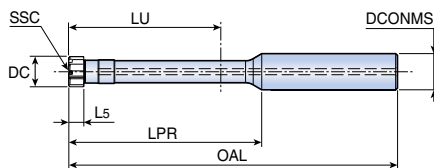
XR...-3B/5B-S0



Head changeable reamer holders for small diameter blind hole



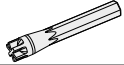
- Cylindrical shank



Designation	DC	SSC	Dimension (mm)					Overhang
			DCONMS	L5	OAL	LU	LPR	
XR-D08-3B-10S0	8.000-8.999	8	10	4.0	81.0	28.0	36.0	3XD
D09-3B-10S0	9.000-9.999	9	10	4.5	85.5	31.5	40.5	
D10-3B-12S0	10.000-10.999	10	12	5.0	89.0	35.0	44.0	
D11-3B-12S0	11.000-11.999	11	12	5.5	92.5	38.5	47.5	
D12-3B-12S0	12.000-12.999	12	12	6.0	96.0	42.0	51.0	
XR-D08-5B-10S0	8.000-8.999	8	10	4.0	97.0	44.0	52.0	5XD
D09-5B-10S0	9.000-9.999	9	10	4.5	103.5	49.5	58.5	
D10-5B-12S0	10.000-10.999	10	12	5.0	109.0	55.0	64.0	
D11-5B-12S0	11.000-11.999	11	12	5.5	114.5	60.5	69.5	
D12-5B-12S0	12.000-12.999	12	12	6.0	120.0	66.0	75.0	

- SSC: Seat size code
- Matched with XR...-AS reamer heads
- Reamer head is sold separately from reamer holder

Spare parts

Designation	Clamping key	Key handle
		
XR-D08	W XR D08-KEY	SW6-T-SH
XR-D09	W XR D08-KEY	SW6-T-SH
XR-D10	W XR D10-KEY	SW6-T-SH
XR-D11	W XR D10-KEY	SW6-T-SH
XR-D12	W XR D12-KEY	SW6-T-SH



- Clamping key & clamping screw are included

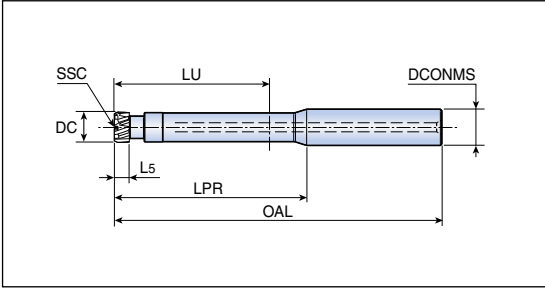
XR...-3T/5T-S0



Head changeable reamer holders for small diameter through hole



• Cylindrical shank



Designation	DC	SSC	Dimension (mm)					Overhang
			DCONMS	L5	OAL	LU	LPR	
XR- D08-3T-10S0	8.000-8.999	8	10	4.0	81.0	28.0	36.0	3XD
D09-3T-10S0	9.000-9.999	9	10	4.5	85.5	31.5	40.5	
D10-3T-12S0	10.000-10.999	10	12	5.0	89.0	35.0	44.0	
D11-3T-12S0	11.000-11.999	11	12	5.5	92.5	38.5	47.5	
D12-3T-12S0	12.000-12.999	12	12	6.0	95.0	42.0	50.0	
XR- D08-5T-10S0	8.000-8.999	8	10	4.0	97.0	44.0	52.0	5XD
D09-5T-10S0	9.000-9.999	9	10	4.5	103.5	49.5	58.5	
D10-5T-12S0	10.000-10.999	10	12	5.0	109.0	55.0	64.0	
D11-5T-12S0	11.000-11.999	11	12	5.5	114.5	60.5	69.5	
D12-5T-12S0	12.000-12.999	12	12	6.0	119.0	66.0	74.0	

- ▶ SSC: Seat size code
- ▶ Matched with XR...-BL reamer heads
- ▶ Reamer head is sold separately from reamer holder

Spare parts

Designation	Clamping key	Key handle
XR-D08	W XR D08-KEY	SW6-T-SH
XR-D09	W XR D08-KEY	SW6-T-SH
XR-D10	W XR D10-KEY	SW6-T-SH
XR-D11	W XR D10-KEY	SW6-T-SH
XR-D12	W XR D12-KEY	SW6-T-SH

D114

D263

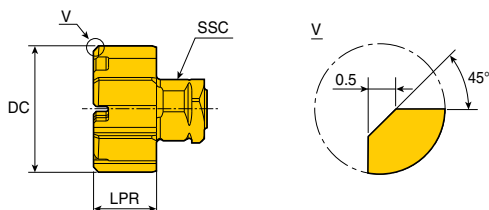
D278

▶ Clamping key & clamping screw are included

XR...-AS

XM-REAM

Head changeable reamer head



- Straight flute for blind hole
- For H7 hole tolerance

Head	Designation	Dimension (mm)		NOF	SSC	Flute type	Edge type	Grade
		DC	LPR					TT9030
	XR-08.000-AS	8.000	4.0	6	8	S	A	●
	09.000-AS	9.000	4.5	6	9	S	A	●
	10.000-AS	10.000	5.0	6	10	S	A	●
	11.000-AS	11.000	5.5	6	11	S	A	●
	12.000-AS	12.000	6.0	6	12	S	A	●



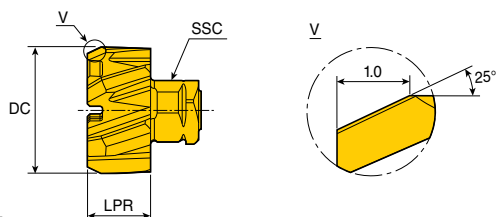
- NOF: Number of flutes
- SSC: Seat size code

●: Standard items

XR...-BL

XM-REAM

Head changeable reamer head



- Helical flute for through hole
- For H7 hole tolerance

Head	Designation	Dimension (mm)		NOF	SSC	Flute type	Edge type	Grade
		DC	LPR					TT9030
	XR-08.000-BL	8.000	4.0	6	8	L	B	●
	09.000-BL	9.000	4.5	6	9	L	B	●
	10.000-BL	10.000	5.0	6	10	L	B	●
	11.000-BL	11.000	5.5	6	11	L	B	●
	12.000-BL	12.000	6.0	6	12	L	B	●



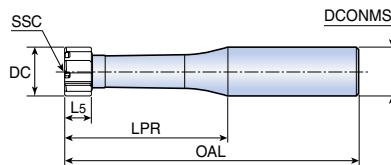
- NOF: Number of flutes
- SSC: Seat size code

●: Standard items

Head changeable reamer holders



- Cylindrical shank



Designation	DC	SSC	Dimension (mm)				Overhang
			DCONMS	L5	OAL	LPR	
TM - 3B5-16T0	11.501-13.500	B5	16	9.3	97.8	49.8	3XD
3B6-16T0	13.501-16.000	B6	16	9.4	105.4	57.4	
3B7-20T0	16.000-20.000	B7	20	10.6	120.6	70.6	
3B8-20T0	20.001-25.400	B8	20	12.8	137.8	87.8	
3B9-32T0	25.401-32.000	B9	32	12.8	167.1	107.1	
5B5-16T0	11.501-13.500	B5	16	9.3	125.0	77.0	5XD
5B6-16T0	13.501-16.000	B6	16	9.4	137.4	89.4	
5B7-20T0	16.000-20.000	B7	20	10.6	160.6	110.6	
5B8-20T0	20.001-25.400	B8	20	12.8	187.8	137.8	
5B9-32T0	25.401-32.000	B9	32	12.8	231.1	171.1	
8B5-16T0	11.501-13.500	B5	16	9.3	165.5	117.5	8XD
8B6-16T0	13.501-16.000	B6	16	9.4	185.4	137.4	
8B7-20T0	16.000-20.000	B7	20	10.6	220.6	170.6	
8B8-20T0	20.001-25.400	B8	20	12.8	262.8	212.8	
8B9-32T0	25.401-32.000	B9	32	12.8	327.1	267.1	

- SSC: Seat size code
- Reamer head is sold separately from reamer holder

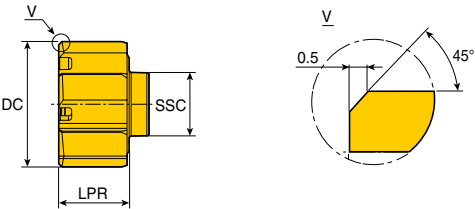
Spare parts

Designation	Clamping screw	Clamping key
TM...B5-16T0	TM-B5-SCR	TM-B5-KEY
TM...B6-16T0	TM-B6-SCR	TM-B6-KEY
TM...B7-20T0	TM-B7-SCR	TM-B7-KEY
TM...B8-20T0	TM-B8-SCR	TM-B8-KEY
TM...B9-32T0	TM-B9-SCR	TM-B9-KEY



- Clamping key & clamping screw are included

Head changeable reamer heads



- Straight flute for blind hole
- For H7 hole tolerance

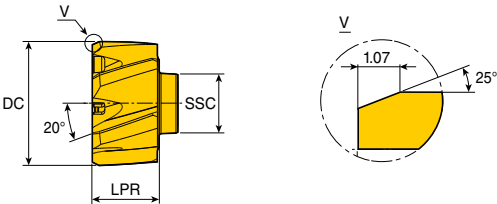
Head	Designation	Dimension (mm)		NOF	SSC	Flute type	Edge type	Grade TT9030
		DC	LPR					
	TM - 11.501-AS-B5	11.501	9.5	6	B5	S	A	●
	12.000-AS-B5	12.000	9.5	6	B5	S	A	●
	13.000-AS-B5	13.000	9.5	6	B5	S	A	●
	13.500-AS-B5	13.500	9.5	6	B5	S	A	●
	13.501-AS-B6	13.501	9.5	6	B6	S	A	●
	14.000-AS-B6	14.000	9.5	6	B6	S	A	●
	15.000-AS-B6	15.000	9.5	6	B6	S	A	●
	16.000-AS-B6	16.000	9.5	6	B6	S	A	●
	16.001-AS-B7	16.001	10.7	6	B7	S	A	●
	17.000-AS-B7	17.000	10.7	6	B7	S	A	●
	18.000-AS-B7	18.000	10.7	6	B7	S	A	●
	19.000-AS-B7	19.000	10.7	6	B7	S	A	●
	20.000-AS-B7	20.000	10.7	6	B7	S	A	●
	20.001-AS-B8	20.001	12.9	8	B8	S	A	●
	21.000-AS-B8	21.000	12.9	8	B8	S	A	●
	22.000-AS-B8	22.000	12.9	8	B8	S	A	●
	23.000-AS-B8	23.000	12.9	8	B8	S	A	●
	24.000-AS-B8	24.000	12.9	8	B8	S	A	●
	25.000-AS-B8	25.000	12.9	8	B8	S	A	●
	26.000-AS-B9	26.000	12.9	8	B9	S	A	●
	27.000-AS-B9	27.000	12.9	8	B9	S	A	●
	28.000-AS-B9	28.000	12.9	8	B9	S	A	●
	29.000-AS-B9	29.000	12.9	8	B9	S	A	●
	30.000-AS-B9	30.000	12.9	8	B9	S	A	●
	31.000-AS-B9	31.000	12.9	8	B9	S	A	●
	32.000-AS-B9	32.000	12.9	8	B9	S	A	●



- NOF: Number of flutes
- SSC: Seat size code

●: Standard items

Head changeable reamer heads



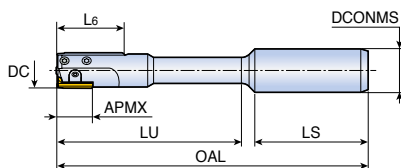
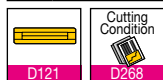
- Helical flute for through hole
- For H7 hole tolerance

Head	Designation	Dimension (mm)		NOF	SSC	Flute type	Edge type	Grade TT9030
		DC	LPR					
	TM - 11.501-BL-B5	11.501	9.5	6	B5	L	B	●
	12.000-BL-B5	12.000	9.5	6	B5	L	B	●
	13.000-BL-B5	13.000	9.5	6	B5	L	B	●
	13.500-BL-B5	13.500	9.5	6	B5	L	B	●
	13.501-BL-B6	13.501	9.5	6	B6	L	B	●
	14.000-BL-B6	14.000	9.5	6	B6	L	B	●
	15.000-BL-B6	15.000	9.5	6	B6	L	B	●
	16.000-BL-B6	16.000	9.5	6	B6	L	B	●
	16.001-BL-B7	16.001	10.7	6	B7	L	B	●
	17.000-BL-B7	17.000	10.7	6	B7	L	B	●
	18.000-BL-B7	18.000	10.7	6	B7	L	B	●
	19.000-BL-B7	19.000	10.7	6	B7	L	B	●
	20.000-BL-B7	20.000	10.7	6	B7	L	B	●
	20.001-BL-B8	20.001	12.9	8	B8	L	B	●
	21.000-BL-B8	21.000	12.9	8	B8	L	B	●
	22.000-BL-B8	22.000	12.9	8	B8	L	B	●
	23.000-BL-B8	23.000	12.9	8	B8	L	B	●
	24.000-BL-B8	24.000	12.9	8	B8	L	B	●
	25.000-BL-B8	25.000	12.9	8	B8	L	B	●
	26.000-BL-B9	26.000	12.9	8	B9	L	B	●
	27.000-BL-B9	27.000	12.9	8	B9	L	B	●
	28.000-BL-B9	28.000	12.9	8	B9	L	B	●
	29.000-BL-B9	29.000	12.9	8	B9	L	B	●
	30.000-BL-B9	30.000	12.9	8	B9	L	B	●
	31.000-BL-B9	31.000	12.9	8	B9	L	B	●
	32.000-BL-B9	32.000	12.9	8	B9	L	B	●



- NOF: Number of flutes
- SSC: Seat size code
- : Standard items

- For through hole

[illegible]

► SSC: Seat size code

► Available upon request

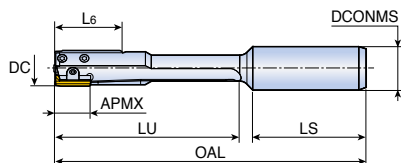
TB-B...-T0



Indexable reamer holders



- For blind hole

[illegible]

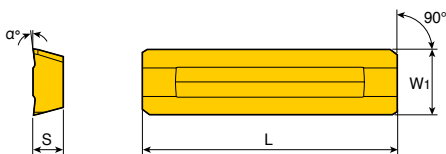
► SSC: Seat size code

► Available upon request

Spare parts

► SSC: Seat size code

Indexable blades



- 
- D118-119**

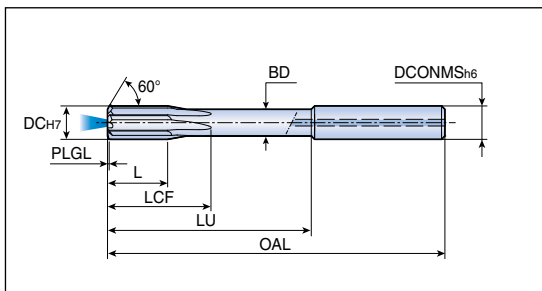
- Grades application ●: Standard items
 - TT5030: TiAlN coating for steel(P) and stainless steel(M) - TT5050: TiCN + TiN coating for cast iron(K)
 ► SSC: Seat size code

●: Standard items

Solid reamers for blind hole



- Straight flute - DIN1420

[illegible]

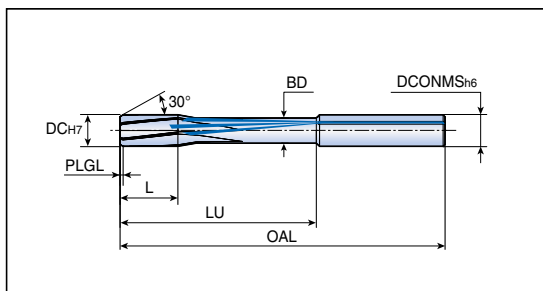
- ▶ Special diameters are available on request
- ▶ NOF: Number of flutes
- ▶ *: Ø3 reamer does not include a coolant hole

●: Standard items

Solid reamers for through hole



- Left flute - DIN1420

[illegible]

- ▶ Special diameters are available on request
- ▶ NOF: Number of flutes
- ▶ *: Ø3 reamer does not include a coolant hole

●: Standard items

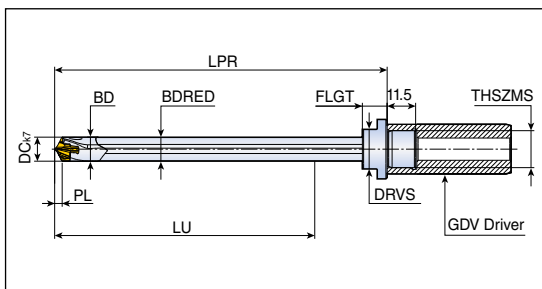
Deep Drilling Tools



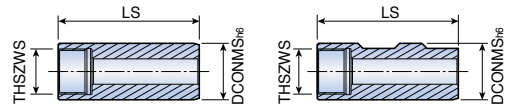
DRILL-RUSH head-changeable and modular shank gundrill holders



- Drilling depth: 16-20x diameter

[illegible]

- ▶ OAL: LPR+11.5
- ▶ Driver is sold separately from drill holder
- ▶ SSC: Seat size code



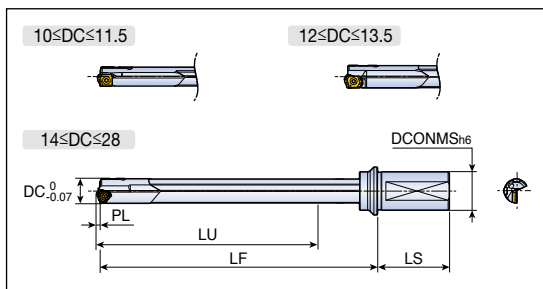
Weldon (W) Type

[illegible]

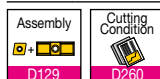
Standard gundrill holders



- Drilling depth: 10-25x diameter



Designation	Dimension (mm)						
	DC	LU	LF	LS	DCONMS	PL	L/D
TRGD 16.00xM25-10	16.0	172	209	56	25	2.2	10
16.50xM25-10	16.5	172	209	56	25	2.2	10
17.00xM25-10	17.0	182	220	56	25	2.2	10
18.00xM25-10	18.0	193	232	56	25	3.0	10
19.00xM25-10	19.0	203	243	56	25	3.0	10
20.00xM32-10	20.0	213	255	60	32	3.2	10
29.00xFM40-10	29.0	294.6	360	69	40	4.57	10
30.00xFM40-10	30.0	314.6	383	69	40	4.57	10
31.00xFM40-10	31.0	314.6	383	69	40	4.57	10
32.00xFM40-10	33.0	324.6	395	69	40	4.57	10
12.00XM20-15	12.0	196.8	225	50	20	1.8	15
12.50XM20-15	12.5	196.8	226	50	20	1.8	15
13.00XM25-15	13.0	211.8	245	56	25	1.8	15
13.50XM25-15	13.5	211.8	245	56	25	1.8	15
14.00XM25-15	14.0	227	261	56	25	2.0	15
14.50XM25-15	14.5	227	262	56	25	2.0	15
15.00XM25-15	15.0	242	278	56	25	2.0	15
16.00XM25-15	16.0	257	294	56	25	2.2	15
16.50XM25-15	16.5	257	294	56	25	2.2	15
17.00XM25-15	17.0	272	310	56	25	2.2	15
17.50XM25-15	17.5	272	310	56	25	2.2	15
18.00XM25-15	18.0	288	327	56	25	3.0	15
18.50XM25-15	18.5	288	327	56	25	3.0	15
19.00XM25-15	19.0	303	343	56	25	3.0	15
19.50XM25-15	19.5	303	343	56	25	3.0	15
20.00xM32-15	20.0	318	360	60	32	3.2	15
21.00xM32-15	21.0	333	376	60	32	3.2	15
22.00xM32-15	22.0	348	393	60	32	3.4	15
23.00xM32-15	23.0	363	409	60	32	3.4	15
24.00xM32-15	24.0	378	426	60	32	3.4	15
25.00xM32-15	25.0	394	442	60	32	3.6	15
26.00xM40-15	26.0	409	449	70	40	3.6	15
27.00xM40-15	27.0	424	465	70	40	3.6	15
28.00xM40-15	28.0	424	467	70	40	3.6	15



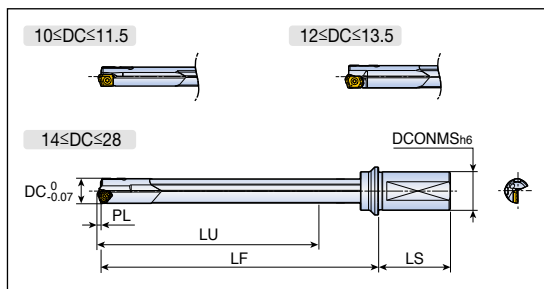
► Guide pad is sold separately from drill body

► Available upon request

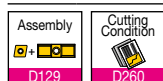
Standard gundrill holders



- Drilling depth: 10-25x diameter



Designation	Dimension (mm)						
	DC	LU	LF	LS	DCONMS	PL	L/D
TRGD 12.00XM20-20	12.0	261.8	290	50	20	1.8	20
12.50XM20-20	12.5	261.8	291	50	20	1.8	20
13.00XM25-20	13.0	281.8	315	56	25	1.8	20
13.50XM25-20	13.5	281.8	315	56	25	1.8	20
14.00xM25-20	14.0	302	336	56	25	2.0	20
14.50xM25-20	14.5	302	337	56	25	2.0	20
15.00xM25-20	15.0	322	358	56	25	2.0	20
29.00xFM40-20	29.0	584.6	650	69	40	4.57	20
30.00xFM40-20	30.0	624.6	693	69	40	4.57	20
31.00xFM40-20	31.0	624.6	693	69	40	4.57	20
32.00xFM40-20	32.0	644.6	715	69	40	4.57	20
10.00XM20-25	10.0	264.5	289.5	50	20	1.8	25
11.00XM20-25	11.0	301.7	329	50	20	1.8	25
11.50XM20-25	11.5	301.7	329	50	20	1.8	25
12.00XM20-25	12.0	326.8	355	50	20	1.8	25
12.50XM20-25	12.5	326.8	356	50	20	1.8	25
13.00XM25-25	13.0	351.8	385	56	25	1.8	25
13.50XM25-25	13.5	351.8	385	56	25	1.8	25
14.00xM25-25	14.0	377	411	56	25	2.0	25
14.50xM25-25	14.5	377	412	56	25	2.0	25
15.00xM25-25	15.0	402	438	56	25	2.0	25
16.00xM25-25	16.0	427	464	56	25	2.2	25
16.50xM25-25	16.5	427	464	56	25	2.2	25
17.00xM25-25	17.0	452	490	56	25	2.2	25
17.50xM25-25	17.5	452	490	56	25	2.2	25
18.00xM25-25	18.0	478	517	56	25	3.0	25
18.50xM25-25	18.5	478	517	56	25	3.0	25
19.00xM25-25	19.0	503	543	56	25	3.0	25
19.50xM25-25	19.5	503	543	56	25	3.0	25
20.00xM32-25	20.0	528	570	60	32	3.2	25
21.00xM32-25	21.0	553	596	60	32	3.2	25
22.00xM32-25	22.0	578	623	60	32	3.4	25
23.00xM32-25	23.0	603	649	60	32	3.4	25
24.00xM32-25	24.0	628	676	60	32	3.4	25
25.00xM32-25	25.0	654	702	60	32	3.6	25



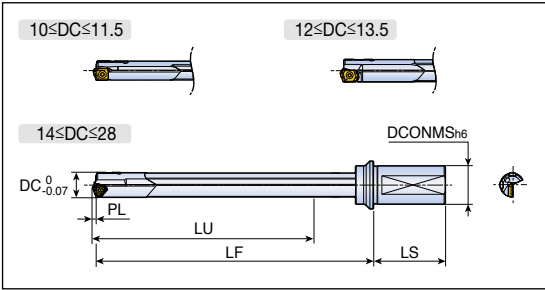
► Guide pad is sold separately from drill body

► Available upon request

Standard gundrill holders



- Drilling depth: 10-25x diameter



Designation	Dimension (mm)						
	DC	LU	LF	LS	DCONMS	PL	L/D
TRGD 26.00xM40-25	26.0	679	729	70	40	3.6	25
27.00xM40-25	27.0	704	755	70	40	3.6	25
28.00xM40-25	28.0	704	757	70	40	3.6	25

Insert & guide pad

Tool dia. (mm)	Insert			Guide pad		
	Insert	Screw	Wrench	Guide pad	Screw	Wrench
10.00-10.99	ZSGT 060204R-RS	SR-M2.5X0.35L3.8	T-7F	PAD-GP04-16-045-DC-SB	CSTB-2	T-6F
11.00-11.99	LOGT 060204R-RS	SR 10503833L040	T-7F	PAD-GP04-16-050-DC-SB	CSTB-2	T-6F
12.00-13.99				PAD-GP04-16-055-DC-SB	TS 200431/HG-P	IP-6F
12.00-13.99				PAD-GP04-16-055-DC-SC		
14.00-15.99	TOGT 070304 RS TT9030	CSTB2.5S*	T-8F	PAD-GP05-18-060-DC-SB PAD-GP05-18-060-DC-SC	SR 34-508	T-7F
16.00-18.00	TOGT 080305 RS TT9030	CSTB2.5S*	T-8F	PAD-GP05-18-075-DC-SB PAD-GP05-18-075-DC-SC	SR 34-508	T-7F
18.01-20.00	TOGT 090305 RS TT9030	CSTB2.5S*	T-8F	PAD-GP06-20-085-DC-SB PAD-GP06-20-085-DC-SC	SR 34-508	T-7F
20.01-21.00	TOGT 100305 RS TT9030	CSTB3S*	T-9F			
21.01-21.99	TOGT 100305 RS TT9030	CSTB3S*	T-9F	PAD-GP06-20-100-DC-SB PAD-GP06-20-100-DC-SC	SR 34-508	T-7F
22.00-25.00	TOGT 110405 RS TT9030	SR14-571/S	T-10/5			
25.01-28.00	TOGT 120405 RS TT9030	CSTB4S	T-15F	PAD-GP06-20-120-DC-SB PAD-GP06-20-120-DC-SC	SR 34-508	T-7F
28.01-29.99	TOGT 130408 RS	SR 16-212/L10	T-20/5	PAD-GP06-20-120-DC-SB PAD-GP06-20-120-DC-SC	SR 34-508	T-7F
30.00-32.00	TOGT 130408 RS	SR 16-212/L10	T-20/5	PAD-GP07-20-120-DC-SB PAD-GP07-20-120-DC-SC	CSTB-3S	T-9F

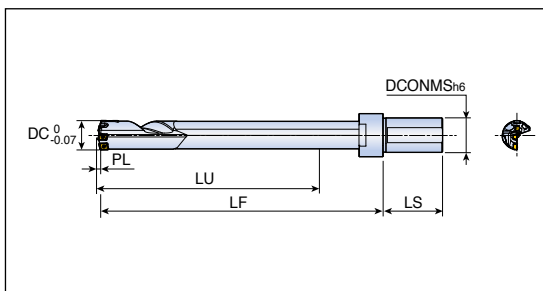


- Guide pad with "SB" is the first choice in general purpose machining
- "SC" is a excellent toughness grade used with water-soluble coolant
- Inserts and guide pads must be ordered separately

Standard gundrill holders



- Drilling depth: 10-15x diameter



Designation	Dimension (mm)						
	DC	LU	LF	LS	DCONMS	PL	L/D
TRGD3 29.00xFM40-10	29.0	293	360	69	40	2.6	10
30.00xFM40-10	30.0	313	383	69	40	2.9	10
31.00xFM40-10	31.0	313	383	69	40	2.9	10
32.00xFM40-10	32.0	323	395	69	40	3.0	10
33.00xFM40-10	33.0	333	406	69	40	3.1	10
34.00xFM40-10	34.0	343	418	69	40	3.0	10
35.00xFM40-10	35.0	353	428	69	40	3.1	10
36.00xFM40-10	36.0	363	441	69	40	3.1	10
29.00xFM40-15	29.0	438	505	69	40	2.6	15
30.00xFM40-15	30.0	468	538	69	40	2.9	15
31.00xFM40-15	31.0	468	538	69	40	2.9	15
32.00xFM40-15	32.0	483	555	69	40	3.0	15
33.00xFM40-15	33.0	498	571	69	40	3.1	15
34.00xFM40-15	34.0	513	588	69	40	3.0	15
35.00xFM40-15	35.0	528	603	69	40	3.1	15
36.00xFM40-15	36.0	543	621	69	40	3.1	15

► Guide pad is sold separately from drill body.

► Supply up to 40.0mm drill diameter

► Available upon request

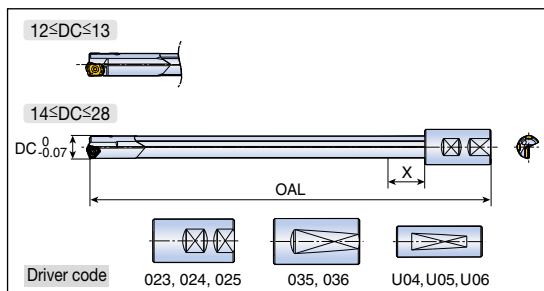
Insert & guide pad

Parts		Diameter (mm)			
		29.0-29.99	30.0-33.0	33.01-35.0	35.01-36.0
Insert	Peripheral insert	NPHT 060304R-G-P	NPHT 080404R-G-P	NPHT 080404R-G-P	NPHT 080404R-G-P
	Screw	CSTB2.2	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-7F	T-8F	T-8F	T-8F
	Inner insert	NPMT 060304R-G-I	NPMT 070404R-G-I	NPMT 070404R-G-I	NPMT 070404R-G-I
	Screw	CSTB2.2	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-7F	T-8F	T-8F	T-8F
	Center insert	NPMT 070408L-G-C	NPMT 070408L-G-C	NPMT 070408L-G-C	NPMT 080408L-L-C
	Screw	CSTB2.5	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-8F	T-8F	T-8F	T-8F
Pad	Guide pad	PAD-GP06-20-120-DC-SB	PAD-GP06-20-120-DC-SB	PAD-GP07-20-120-DC-SB	PAD-GP07-20-120-DC-SB
	Screw	PAD-GP06-20-120-DC-SC	PAD-GP06-20-120-DC-SC	PAD-GP07-20-120-DC-SC	PAD-GP07-20-120-DC-SC
	Wrench	T-7F	T-7F	T-9F	T-9F

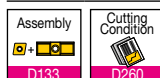


► Inserts and guide pads must be ordered separately

Standard gundrill holders

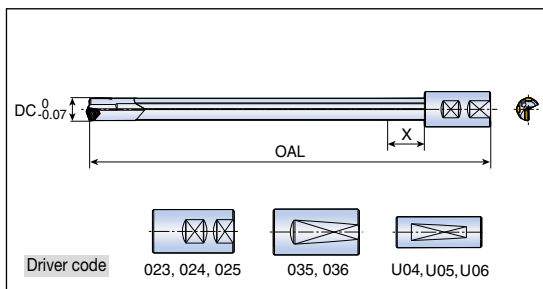
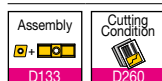


Designation	Driver code	Dimension (mm)		
		DC	OAL	X
TRGDL 12.00X800-XXX	U03 022	12	801.8	18
12.00X800-XXX		12	801.8	18
12.00X1000-XXX		12	1001.8	18
12.00X1000-XXX		12	1001.8	18
12.00X1650-XXX		12	1651.8	18
12.00X1650-XXX		12	1651.8	18
12.70X1219-XXX	U04	12.7	1220.8	19
12.70X1524-XXX		12.7	1525.8	19
13.00X800-XXX	U04 023	13	801.8	20
13.00X800-XXX		13	801.8	20
13.00X1000-XXX		13	1001.8	20
13.00X1000-XXX		13	1001.8	20
13.00X1650-XXX		13	1651.8	20
13.00X1650-XXX		13	1651.8	20
13.49X1219-XXX	U04	13.49	1220.8	20
13.49X1527-XXX		13.49	1528.8	20
14.00x800-XXX	U04 023	14	800	21
14.00x1000-XXX		14	1000	21
14.00x1650-XXX		14	1650	21
14.50x800-XXX		14.5	800	22
14.50x1000-XXX		14.5	1000	22
14.50x1650-XXX		14.5	1650	22
15.00x800-XXX	U04 023	15	800	23
15.00x1000-XXX		15	1000	23
15.00x1650-XXX		15	1650	23
16.00x800-XXX	U04 023 035	16	800	24
16.00x1000-XXX		16	1000	24
16.00x1500-XXX		16	1500	24
17.00x1000-XXX		17	1000	25
17.00x1500-XXX		17	1500	25
18.00x800-XXX		18	800	27
18.00x1000-XXX		18	1000	27
18.00x1500-XXX		18	1500	27
19.00x800-XXX		19	800	28
19.00x1000-XXX		19	1000	28
19.00x1500-XXX		19	1500	28



► Guide pad is sold separately from drill body

► Available upon request
► Select "XXX" driver code

[illegible]

- ▶ Available upon request
- ▶ Select "XXX" driver code

Insert & guide pad

Tool dia. (mm)	Insert			Guide pad		
	Insert	Screw	Wrench	Guide pad	Screw	Wrench
12.00-13.99	LOGT 060204R-RS	SR 10503833L040	T-7F	PAD-GP04-16-055-DC-SB PAD-GP04-16-055-DC-SC	TS 20043/HG-P	T-7F
14.00-15.99	TOGT 070304 RS TT9030	CSTB2.5S	T-8F	PAD-GP05-18-060-DC-SB PAD-GP05-18-060-DC-SC	SR 34-508	T-7F
16.00-18.00	TOGT 080305 RS TT9030	CSTB2.5S	T-8F	PAD-GP05-18-075-DC-SB PAD-GP05-18-075-DC-SC	SR 34-508	T-7F
18.01-20.00	TOGT 090305 RS TT9030	CSTB2.5S*	T-8F	PAD-GP06-20-085-DC-SB PAD-GP06-20-085-DC-SC	SR 34-508	T-7F
20.01-21.00	TOGT 100305 RS TT9030	CSTB3S*	T-9F			
21.01-21.99	TOGT 100305 RS TT9030	CSTB3S*	T-9F	PAD-GP06-20-100-DC-SB PAD-GP06-20-100-DC-SC	SR 34-508	T-7F
22.00-25.00	TOGT 110405 RS TT9030	SR14-571/S	T-10/5			
25.01-28.00	TOGT 120405 RS TT9030	CSTB4S	T-15F	PAD-GP07-20-120-DC-SB PAD-GP07-20-120-DC-SC	SR 34-508	T-7F



- ▶ Guide pad with "SB" is the first choice in general purpose machining
- "SC" is a excellent toughness grade used with water-soluble coolant
- ▶ Inserts and guide pads must be ordered separately

Driver for TRGDL Type

Driver	Driver code	Dimension (mm)	
		LS	DCONMS
	022	50	20.00
	023	56	25.00
	024	60	32.00
	025	70	40.00
	026	80	50.00
	035	56	25.00
	036	60	32.00
	U03	70	19.05
	U04	70	25.40
	U05	70	31.75
	U06	70	38.10

Single tube system



-
- Technical drawing of the DCONMS device. The left view is a side profile showing the device's dimensions: DC (height), LF (length of the main body), and OAL (overall length). The right view is an end view showing the circular face with four mounting points and a central feature.

Assembly  D137	Tube  D170-D171	Cutting Condition  D252
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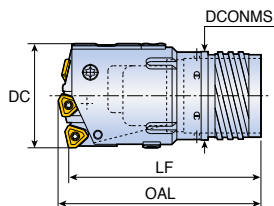
Single tube system



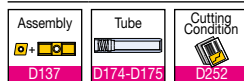
-
- Technical drawing of the DCONMS device. The top view shows a rectangular device with dimensions DC (depth), LF (length), and OAL (overall length). The side view shows the device's profile, which is circular, with DCONMS labeled above it.

Assembly  D137	Tube  D172-D173	Cutting Condition  D252
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Double tube system



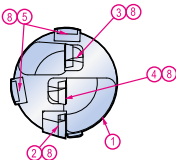
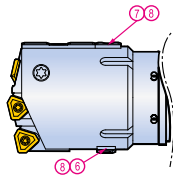
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TBTA3 Series



Assembly of TBTA3 series



1. Head shank

2. Outer cartridge

3. Inner cartridge

4. Center cartridge
5. Guide pad

6. Sub guide pad

7. Guide pad protector

8. Lock screw

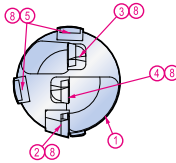
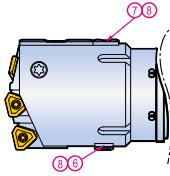
Parts		Diameter (mm)				
		38.00-39.99	40.00-44.99	45.00-47.99	48.00-51.99	52.00-54.99
Cartridge	Outer	PERC 05R	PERC 402-04	PERC 402-04	PERC 402-04	PERC 402-32
	Adjust screw	AS0003-5	AS0004-8	AS0004-8	AS0004-8	AS0005-10
	Wrench	H1.5	H2	H2	H2	H2.5
	Screw	LS1803RH	LS1803.5RH	LS1803.5RH	LS1803.5RH	LS1805RH
	Wrench	H2	H2.5	H2.5	H2.5	H3
	Inner	CENC 05R	CENC 05R	CENC 05R	CENC 402-04	CENC 402-04
	Screw	CSTB3	CSTB3	CSTB3	CSTB3.5	CSTB3.5
	Wrench	T-9D	T-9D	T-9D	T-15D	T-15D
	Center	CENC 05R	CENC 05R	CENC 402-04	CENC 402-04	CENC 402-04
	Screw	CSTB3	CSTB3	CSTB3.5	CSTB3.5	CSTB3.5
Insert	Wrench	T-9D	T-9D	T-15D	T-15D	T-15D
	Outer	NPMX 080308R-G	TPMX 140308R-G	TPMX 140308R-G	TPMX 140308R-G	TPMX 170408R-G
	Screw	CSTB2.2	CSTB2.5	CSTB2.5	CSTB2.5	CSTB3.5D
	Wrench	T-7D	T-8D	T-8D	T-8D	T-9D
	Inner	NPMX 080308R-G	NPMX 080308R-G	NPMX 080308R-G	TPMX 140308R-G	TPMX 140308R-G
	Screw	CSTB2.2	CSTB2.2	CSTB2.2	CSTB2.5	CSTB2.5
	Wrench	T-7D	T-7D	T-7D	T-8D	T-8D
	Center	NPMX 080308R-G	NPMX 080308R-G	TPMX 140308R-G	TPMX 140308R-G	TPMX 140308R-G
	Screw	CSTB2.2	CSTB2.2	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-7D	T-7D	T-8D	T-8D	T-8D
Pad	Guide pad	PAD-GP08-25-155-DC-SB	PAD-GP08-25-155-DC-SB	PAD-GP10-35-200-DC-SB	PAD-GP10-35-200-DC-SB	PAD-GP10-35-200-DC-SB
		PAD-GP08-25-155-DC-SC	PAD-GP08-25-155-DC-SC	PAD-GP10-35-200-DC-SC	PAD-GP10-35-200-DC-SC	PAD-GP10-35-200-DC-SC
	Screw	CSTB3S	CSTB3S	CSTB4S	CSTB4S	CSTB4S
	Wrench	T-9D	T-9D	T-15D	T-15D	T-15D
	Guide pad protector	PAD-P08	PAD-P08	PAD-P10	PAD-P10	PAD-P10
	Screw	CSTB3S	CSTB3S	CSTB4S	CSTB4S	CSTB4S
	Wrench	T-9D	T-9D	T-15D	T-15D	T-15D
	Sub guide pad	PAD-S08	PAD-S08	PAD-S08	PAD-S08	PAD-S08
	Screw	CSTB3S	CSTB3S	CSTB3S	CSTB3S	CSTB3S
	Wrench	T-9D	T-9D	T-9D	T-9D	T-9D

D216

D220

D224

Assembly of TBTA3 series



1. Head shank
2. Outer cartridge
3. Inner cartridge
4. Center cartridge
5. Guide pad
6. Sub guide pad
7. Guide pad protector
8. Lock screw

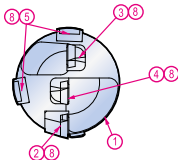
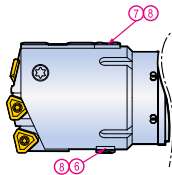
Parts		Diameter (mm)				
		55.00-57.99	58.00-59.99	60.00-63.99	64.00-67.99	68.00-77.99
Cartridge	Outer	PERC 402-32	PERC 402-32	PERC 402-32	PERC 402-43	PERC 402-32
	Adjust screw	AS0005-10	AS0005-10	AS0005-10	AS0005-15	AS0005-10
	Wrench	H2.5	H2.5	H2.5	H2.5	H2.5
	Screw	LS1805RH	LS1805RH	LS1805RH	LS1806RH	LS1805RH
	Wrench	H3	H3	H3	H4	H3
	Inner	CENC 402-04	CENC 402-32	CENC 402-32	CENC 402-32	CENC 402-43
	Screw	CSTB3.5	CSTA5	CSTA5	CSTA5	LS1206
	Wrench	T-15D	T-15D	T-15D	T-15D	H3
	Center	CENC 402-32	CENC 402-32	CENC 402-32	CENC 402-32	CENC 402-43
	Screw	CSTA5	CSTA5	CSTA5	CSTA5	LS1206
Insert	Wrench	T-15D	T-15D	T-15D	T-15D	H3
	Outer	TPMX 170408R-G	TPMX 170408R-G	TPMX 170408R-G	TPMX 240512R-G	TPMX 170408R-G
	Screw	CSTB3.5D	CSTB3.5D	CSTB3.5D	CSTB4M	CSTB3.5D
	Wrench	T-9D	T-9D	T-9D	T-15D	T-9D
	Inner	TPMX 140308R-G	TPMX 170408R-G	TPMX 170408R-G	TPMX 170408R-G	TPMX 240512R-G
	Screw	CSTB2.5	CSTB3.5D	CSTB3.5D	CSTB3.5D	CSTB4M
	Wrench	T-8D	T-9D	T-9D	T-9D	T-15D
	Center	TPMX 170408R-G	TPMX 170408R-G	TPMX 170408R-G	TPMX 170408R-G	TPMX 240512R-G
	Screw	CSTB3.5D	CSTB3.5D	CSTB3.5D	CSTB3.5D	CSTB4M
	Wrench	T-9D	T-9D	T-9D	T-9D	T-15D
Pad	Guide pad	PAD-GP10-35-200-DC-SB	PAD-GP10-35-200-DC-SB	PAD-GP14-40-250-DC-SB	PAD-GP14-40-250-DC-SB	PAD-GP14-40-250-DC-SB
		PAD-GP10-35-200-DC-SC	PAD-GP10-35-200-DC-SC	PAD-GP14-40-250-DC-SC	PAD-GP14-40-250-DC-SC	PAD-GP14-40-250-DC-SC
	Screw	CSTB4S	CSTB4S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T-15D	T-15D	T-15D	T-15D	T-15D
	Guide pad protector	PAD-P10	PAD-P10	PAD-P14	PAD-P14	PAD-P14
	Screw	CSTB4S	CSTB4S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T-15D	T-15D	T-15D	T-15D	T-15D
	Sub guide pad	PAD-S08	PAD-S08	PAD-S08	PAD-S10	PAD-S10
	Screw	CSTB3S	CSTB3S	CSTB3S	CSTB3S	CSTB3S
	Wrench	T-9D	T-9D	T-9D	T-9D	T-9D



TBTA3 Series



Assembly of TBTA3 series



1. Head shank

2. Outer cartridge

3. Inner cartridge

4. Center cartridge
5. Guide pad

6. Sub guide pad

7. Guide pad protector

8. Lock screw

Parts		Diameter (mm)			
		78.00-84.99	85.00-91.99	92.00-98.99	99.00-106.99
Cartridge	Outer	PERC 402-43	PERC 402-63	PERC 402-43	PERC 402-63
	Adjust screw	AS0005-15	AS0006-15	AS0005-15	AS0006-15
	Wrench	H2.5	H3	H2.5	H3
	Screw	LS1806RH	LS1806RH	LS1806RH	LS1806RH
	Wrench	H4	H4	H4	H4
	Inner	CENC 402-43	CENC 402-43	CENC 402-63	CENC 402-63
	Screw	LS1206	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3	H3
	Center	CENC 402-43	CENC 402-43	CENC 402-63	CENC 402-63
	Screw	LS1206	LS1206	LS1206	LS1206
Insert	Wrench	H3	H3	H3	H3
	Outer	TPMX 240512R-G	TPMX 280716R-G	TPMX 240512R-G	TPMX 280716R-G
	Screw	CSTB4M	CSTB5	CSTB4M	CSTB5
	Wrench	T-15D	T-20D	T-15D	T-20D
	Inner	TPMX 240512R-G	TPMX 240512R-G	TPMX 280716R-G	TPMX 280716R-G
	Screw	CSTB4M	CSTB4M	CSTB5	CSTB5
	Wrench	T-15D	T-15D	T-20D	T-20D
	Center	TPMX 240512R-G	TPMX 240512R-G	TPMX 280716R-G	TPMX 280716R-G
	Screw	CSTB4M	CSTB4M	CSTB5	CSTB5
	Wrench	T-15D	T-15D	T-20D	T-20D
Pad	Guide pad	PAD-GP14-40-250-DC-SB	PAD-GP14-40-250-DC-SB	PAD-GP14-40-250-DC-SB	PAD-GP18-40-300-DC-SB
		PAD-GP14-40-250-DC-SC	PAD-GP14-40-250-DC-SC	PAD-GP14-40-250-DC-SC	PAD-GP18-40-300-DC-SC
	Screw	CSTA5S	CSTA5S	CSTA5S	LS1206S
	Wrench	T-15D	T-15D	T-15D	H3
	Guide pad protector	PAD-P14	PAD-P14	PAD-P14	PAD-P18
	Screw	CSTA5S	CSTA5S	CSTA5SS	LS1206S
	Wrench	T-15D	T-15D	T-15D	H3
	Sub guide pad	PAD-S10	PAD-S10	PAD-S10	PAD-S14
	Screw	CSTB3S	CSTB3S	CSTB3S	CSTA5S
	Wrench	T-9D	T-9D	T-9D	T-15D

D216

D220

D224

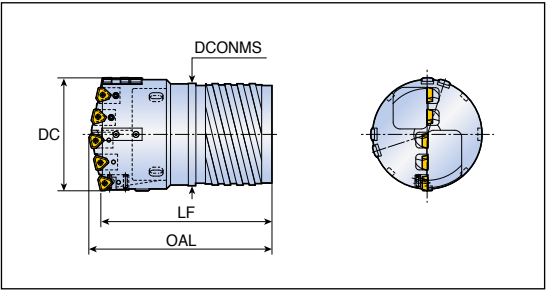
TBTA5...SE4



Single tube system



- Outer four start thread



Designation	DC	Dimension (mm)			Tube	
		LF	OAL	DCONMS	Part	Diameter (mm)
TBTA5- xxx.xxSE4-094	107.00-111.99	180	197	89	BTSl 094	94
xxx.xxSE4-106	112.00-123.99	205	221	101	BTSl 106	106
xxx.xxSE4-118	124.00-135.99	205	222	113	BTSl 118	118
xxx.xxSE4-130	136.00-147.99	205	223	125	BTSl 130	130
xxx.xxSE4-142	148.00-159.99	225	245	137	BTSl 142	142
xxx.xxSE4-154	160.00-168.99	225	246	149	BTSl 154	154

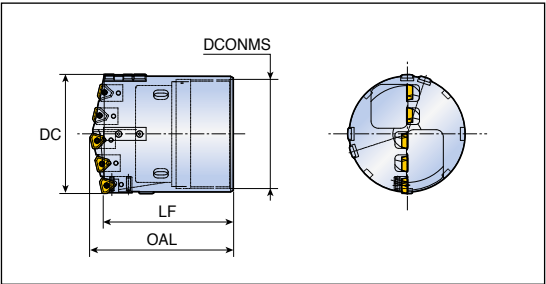
TBTA5...SI1



Single tube system



- Inner single start thread



Designation	DC	Dimension (mm)			Tube	
		LF	OAL	DCONMS	Part	Diameter (mm)
TBTA5- xxx.xxSI1-094	107.00-110.99	150	164	90	BTSE 094	94
xxx.xxSI1-106	111.00-122.99	150	165	102	BTSE 106	106
xxx.xxSI1-118	123.00-134.99	150	167	114	BTSE 118	118
xxx.xxSI1-130	135.00-148.99	150	168	126	BTSE 130	130
xxx.xxSI1-142	149.00-161.99	150	170	139	BTSE 142	142
xxx.xxSI1-154	162.00-168.99	190	211	151	BTSE 154	154

Assembly	Tube	Cutting Condition
 D142	 D171, D173	 D252

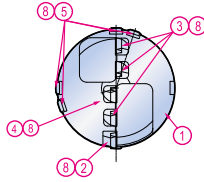
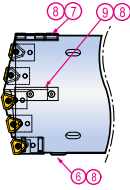
Double tube system



-
- Technical drawing of the DCONMS connector. The left view is a side profile showing the connector's dimensions: DC (height), LF (length of the main body), and OAL (overall length). The right view is a top-down perspective showing the circular connector face with four pins and a central feature.

Assembly  D142	Tube  D174	Cutting Condition  D252
--	---	--

Assembly of TBTA5 series



1. Head shank
2. Outer cartridge
3. Inner cartridge
4. Center cartridge
5. Guide pad
6. Sub guide pad
7. Guide pad protector
8. Lock screw
9. Filler

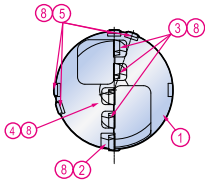
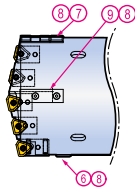
Parts		Diameter (mm)			
		107.00-117.99	118.00-135.99	136.00-144.99	145.00-150.99
Cartridge	Outer	PERC 402-43	PERC 402-43	PERC 402-43	PERC 402-43
	Adjust screw	AS0005-15	AS0005-15	AS0005-15	AS0005-15
	Wrench	H2.5	H2.5	H2.5	H2.5
	Screw	LS1806RH	LS1806RH	LS1806RH	LS1806RH
	Wrench	H4	H4	H4	H4
	Inner	CENC 402-32	CENC 402-43	CENC 402-43	CENC 402-43
	Screw	CSTA5	LS1206	LS1206	LS1206
	Wrench	T-15D	H3	H3	H3
	Center	CENC 402-43	CENC 402-43	CENC 402-63	CENC 402-63
	Screw	LS1206	LS1206	LS1206	LS1206
Insert	Wrench	H3	H3	H3	H3
	Outer	TPMX 240512R-G	TPMX 240512R-G	TPMX 240512R-G	TPMX 240512R-G
	Screw	CSTB4M	CSTB4M	CSTB4M	CSTB4M
	Wrench	T-15D	T-15D	T-15D	T-15D
	Inner	TPMX 170408R-G	TPMX 240512R-G	TPMX 240512R-G	TPMX 240512R-G
	Screw	CSTB3.5D	CSTB4M	CSTB4M	CSTB4M
	Wrench	T-9D	T-15D	T-15D	T-15D
	Center	TPMX 240512R-G	TPMX 240512R-G	TPMX 280716R-G	TPMX 280716R-G
Pad	Screw	CSTB4M	CSTB4M	CSTB5	CSTB5
	Wrench	T-15D	T-15D	T-20D	T-20D
	Guide pad	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB
		PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Guide pad protector	PAD-P18	PAD-P18	PAD-P18	PAD-P18
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Sub guide pad	PAD-S14	PAD-S14	PAD-S14	PAD-S14
	Screw	CSTA5S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T-15D	T-15D	T-15D	T-15D



TBTA5 Series



Assembly of TBTA5 series



1. Head shank

2. Outer cartridge

3. Inner cartridge

4. Center cartridge
5. Guide pad

6. Sub guide pad

7. Guide pad protector

8. Lock screw

9. Filler

Parts		Diameter (mm)		
		151.00-156.99	157.00-162.99	163.00-168.99
Cartridge	Outer	PERC 402-63	PERC 402-63	PERC 402-63
	Adjust screw	AS0006-15	AS0006-15	AS0006-15
	Wrench	H3	H3	H3
	Screw	LS1806RH	LS1806RH	LS1806RH
	Wrench	H4	H4	H4
	Inner	CENC 402-43	CENC 402-43	CENC 402-63
	Screw	LS1206	LS1206	LS1206
	Wrench	H3L	H3L	H3L
	Center	CENC 402-63	CENC 402-63	CENC 402-63
	Screw	LS1206S	LS1206S	LS1206S
Insert	Wrench	H3L	H3L	H3L
	Outer	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G
	Screw	CSTB5	CSTB5	CSTB5
	Wrench	T-20D	T-20D	T-20D
	Inner	TPMX 240512R-G	TPMX 240512R-G	TPMX 280716R-G
	Screw	CSTB4M	CSTB4M	CSTB5
	Wrench	T-15D	T-15D	T-20D
	Center	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G
Pad	Screw	CSTB5	CSTB5	CSTB5
	Wrench	T-20D	T-20D	T-20D
	Guide pad	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB
		PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC
	Screw	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3L
	Guide pad protector	PAD-P18	PAD-P18	PAD-P18
	Screw	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3
	Sub guide pad	PAD-S14	PAD-S14	PAD-S14
	Screw	CSTA5S	CSTA5S	CSTA5S
	Wrench	T-15D	T-15D	T-15D

D216

D220

D224

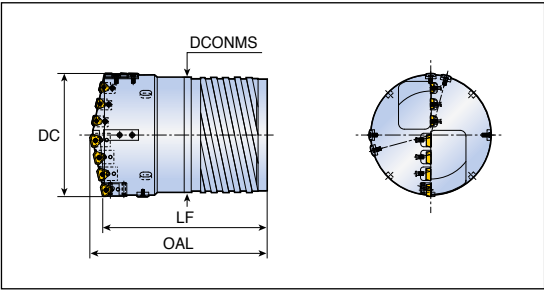
TBTA7...SE4



Single tube system



- Outer four start thread
- Double tube system also available on request



Designation	DC	Dimension (mm)			Tube	
		LF	OAL	DCONMS	Part	Diameter (mm)
TBTA7- xxx.xxSE4-154	169.00-171.99	225	246	149	BTSl 154	154
xxx.xxSE4-166	172.00-183.99	225	247	161	BTSl 166	166
xxx.xxSE4-178	184.00-195.99	245	267	173	BTSl 178	178
xxx.xxSE4-190	196.00-207.99	245	270	185	BTSl 190	190
xxx.xxSE4-202	208.00-219.99	245	271	197	BTSl 202	202
xxx.xxSE4-214	220.00-231.99	265	293	208	BTSl 214	214
xxx.xxSE4-226	232.00-232.99	265	293	220	BTSl 226	226

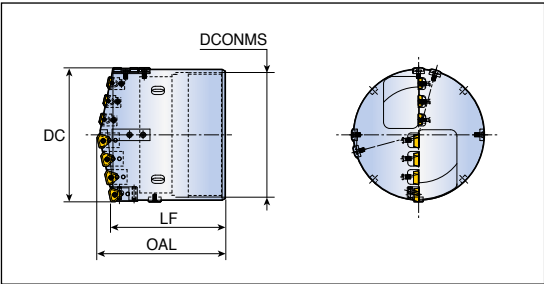
TBTA7...SI1



Single tube system



- Inner single start thread



Designation	DC	Dimension (mm)			Tube	
		LF	OAL	DCONMS	Part	Diameter (mm)
TBTA7- xxx.xxSI1-154	169.00-173.99	190	211	151	BTSE 154	154
xxx.xxSI1-166	174.00-185.99	190	213	163	BTSE 166	166
xxx.xxSI1-178	186.00-197.99	190	212	175	BTSE 178	178
xxx.xxSI1-190	198.00-209.99	190	215	187	BTSE 190	190
xxx.xxSI1-202	210.00-221.99	190	217	199	BTSE 202	202
xxx.xxSI1-214	222.00-232.99	190	218	211	BTSE 214	214

Assembly

S

Tube

D171, D173

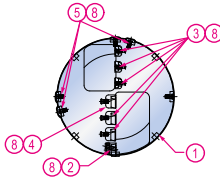
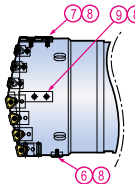
Cutting Condition

D252

TBTA7 Series



Assembly of TBTA7 series



1. Head shank

2. Outer cartridge

3. Inner cartridge

4. Center cartridge

5. Guide pad

6. Sub guide pad

7. Guide pad protector

8. Lock screw

9. Filler

Parts		Diameter (mm)			
		169.00-188.99	189.00-196.99	197.00-202.99	203.00-208.99
Cartridge	Outer	PERC 402-43	PERC 402-43	PERC 402-43	PERC 402-43
	Adjust screw	AS0005-15	AS0005-15	AS0005-15	AS0005-15
	Wrench	H2.5	H2.5	H2.5	H2.5
	Screw	LS1806RH	LS1806RH	LS1806RH	LS1806RH
	Wrench	H4	H4	H4	H4
	Inner	CENC 402-43	CENC 402-43	CENC 402-43	CENC 402-43
	Screw	LS1206	LS1206	LS1206	LS1206
	Wrench	H3L	H3L	H3L	H3L
	Center	CENC 402-43	CENC 402-63	CENC 402-63	CENC 402-63
	Screw	LS1206	LS1206S	LS1206S	LS1206S
Insert	Wrench	H3L	H3L	H3L	H3L
	Outer	TPMX 240512R-G	TPMX 240512R-G	TPMX 240512R-G	TPMX 240512R-G
	Screw	CSTB4M	CSTB4M	CSTB4M	CSTB4M
	Wrench	T-15D	T-15D	T-15D	T-15D
	Inner	TPMX 240512R-G	TPMX 240512R-G	TPMX 240512R-G	TPMX 240512R-G
	Screw	CSTB4M	CSTB4M	CSTB4M	CSTB4M
	Wrench	T-15D	T-15D	T-15D	T-15D
	Center	TPMX 240512R-G	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G
Pad	Screw	CSTB4M	CSTB5	CSTB5	CSTB5
	Wrench	T-15D	T-15D	T-15D	T-15D
	Guide pad	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB
		PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Guide pad protector	PAD-P18	PAD-P18	PAD-P18	PAD-P18
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Sub guide pad	PAD-S14	PAD-S14	PAD-S14	PAD-S14
	Screw	CSTA5S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T-15D	T-15D	T-15D	T-15D



D216



D220

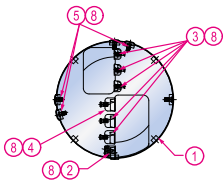
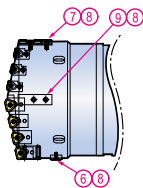


D224

TBTA7 Series



Assembly of TBTA7 series



1. Head shank

2. Outer cartridge

3. Inner cartridge

4. Center cartridge
5. Guide pad

6. Sub guide pad

7. Guide pad protector

8. Lock screw

9. Filler

Parts		Diameter (mm)			
		209.00-214.99	215.00-220.99	221.00-226.99	227.00-232.99
Cartridge	Outer	PERC 402-63	PERC 402-63	PERC 402-63	PERC 402-63
	Adjust screw	AS0006-15	AS0006-15	AS0006-15	AS0005-15
	Wrench	H3	H3	H3	H3
	Screw	L1806RH	L1806RH	L1806RH	LS1806RH
	Wrench	H4	H4	H4	H4
	Inner	CENC 402-43	CENC 402-43	CENC 402-43	CENC 402-63
	Screw	LS1206	LS1206	LS1206	LS1206
	Wrench	H3L	H3L	H3L	H3L
	Center	CENC 402-63	CENC 402-63	CENC 402-63	CENC 402-63
	Screw	LS1206S	LS1206	LS1206	LS1206S
Insert	Wrench	H3L	H3L	H3L	H3L
	Outer	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G
	Screw	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T-20D	T-20D	T-20D	T-20D
	Inner	TPMX 240512R-G	TPMX 240512R-G	TPMX 240512R-G	TPMX 280716R-G
	Screw	CSTB4M	CSTB4M	CSTB4M	CSTB5
	Wrench	T-15D	T-15D	T-15D	T-15D
Pad	Center	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G
	Screw	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T-20D	T-20D	T-20D	T-20D
	Guide pad	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB
		PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Guide pad protector	PAD-P18	PAD-P18	PAD-P18	PAD-P18
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Sub guide pad	PAD-S14	PAD-S14	PAD-S14	PAD-S14
	Screw	CSTA5S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T-15D	T-15D	T-15D	T-15D

D216

D220

D224

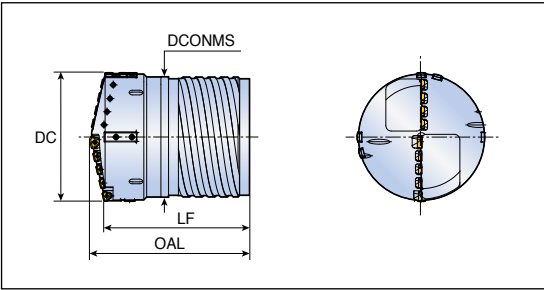
TBTA9...SE4



Single tube system



- Outer four start thread



Designation	DC	Dimension (mm)			Tube	
		LF	OAL	DCONMS	Part	Diameter (mm)
TBTA9 - xxx.xxSE4-226	233.00-243.99	265	294	220	BTSI 226	226
xxx.xxSE4-238	244.00-255.99	265	294	232	BTSI 238	238
xxx.xxSE4-250	256.00-267.99	290	322	244	BTSI 250	250
xxx.xxSE4-262	268.00-279.99	290	323	256	BTSI 262	262
xxx.xxSE4-274	280.00-291.99	290	325	268	BTSI 274	274

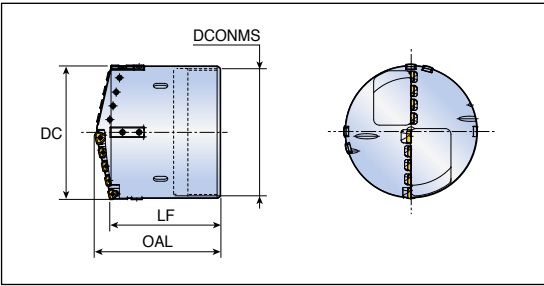
TBTA9...SI1



Single tube system



- Inner single start thread



Designation	DC	Dimension (mm)			Tube	
		LF	OAL	DCONMS	Part	Diameter (mm)
TBTA9 - xxx.xxSI1-214	233.00-233.99	190	217	211	BTSE 214	214
xxx.xxSI1-226	234.00-245.99	190	219	223	BTSE 226	226
xxx.xxSI1-238	246.00-257.99	190	221	235	BTSE 238	238
xxx.xxSI1-250	258.00-269.99	210	242	245	BTSE 250	250
xxx.xxSI1-262	270.00-281.99	210	244	259	BTSE 262	262
xxx.xxSI1-274	282.00-293.99	210	245	271	BTSE 274	274

Assembly

D148

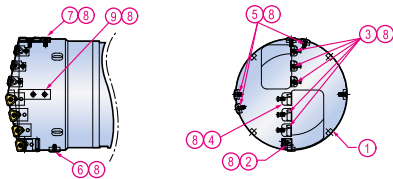
Tube

D171, D173

Cutting Condition

D252

Assembly of TBTA9 series



1. Head shank

2. Outer cartridge

3. Inner cartridge

4. Center cartridge
5. Guide pad

6. Sub guide pad

7. Guide pad protector

8. Lock screw

9. Filler

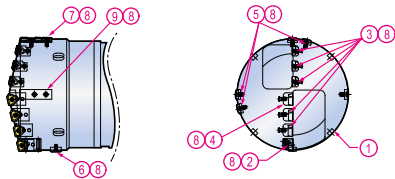
Parts		Diameter (mm)				
		233.00-247.99	248.00-253.99	254.00-258.99	259.00-264.99	265.00-271.99
Cartridge	Outer	PERC 402-43	PERC 402-63	PERC 402-63	PERC 402-63	PERC 402-63
	Adjust screw	AS0005-15	AS0006-15	AS0006-15	AS0006-15	AS0006-15
	Wrench	H2.5	H3	H3	H3	H3
	Screw	LS1806RH	L1806RH	L1806RH	L1806RH	L1806RH
	Wrench	H4	H4	H4	H4	H4
	Inner	CENC 402-43	CENC 402-43	CENC 402-43	CENC 402-43	CENC 402-43
	Screw	LS1206	LS1206	LS1206	LS1206	LS1206
	Wrench	H3L	H3L	H3L	H3L	H3L
	Center	CENC 402-63	CENC 402-63	CENC 402-63	CENC 402-63	CENC 402-63
	Screw	LS1206S	LS1206S	LS1206S	LS1206S	LS1206S
Insert	Wrench	H3L	H3L	H3L	H3L	H3L
	Outer	TPMX 240512R-G	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G
	Screw	CSTB4M	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T-15D	T-20D	T-20D	T-20D	T-20D
	Inner	TPMX 240512R-G	TPMX 240512R-G	TPMX 240512R-G	TPMX 240512R-G	TPMX 240512R-G
	Screw	CSTB4M	CSTB4M	CSTB4M	CSTB4M	CSTB4M
	Wrench	T-15D	T-15D	T-15D	T-15D	T-15D
	Center	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G
Pad	Screw	CSTB5	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T-20D	T-20D	T-20D	T-20D	T-20D
	Guide pad	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB
		PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC
	Screw	LS1206S	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3	H3
	Guide pad protector	PAD-P18	PAD-P18	PAD-P18	PAD-P18	PAD-P18
	Screw	LS1206S	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3	H3
	Sub guide pad	PAD-S14	PAD-S14	PAD-S14	PAD-S14	PAD-S14
	Screw	CSTA5S	CSTA5S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T-15D	T-15D	T-15D	T-15D	T-15D



TBTA9 Series



Assembly of TBTA9 series

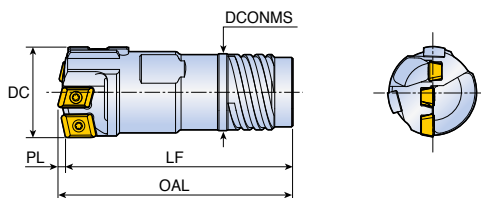


- 1. Head shank
- 2. Outer cartridge
- 3. Inner cartridge
- 4. Center cartridge
- 5. Guide pad
- 6. Sub guide pad
- 7. Guide pad protector
- 8. Lock screw
- 9. Filler

Parts		Diameter (mm)			
		272.00-275.99	276.00-284.99	285.00-289.99	290.00-293.99
Cartridge	Outer	PERC 402-63	PERC 402-63	PERC 402-63	PERC 402-63
	Adjust screw	AS0006-15	AS0006-15	AS0006-15	AS0006-15
	Wrench	H3	H3	H3	H3
	Screw	L1806RH	L1806RH	L1806RH	L1806RH
	Wrench	H4	H4	H4	H4
	Inner	CENC 402-63	CENC 402-63	CENC 402-63	CENC 402-63
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3L	H3L	H3L	H3L
	Center	CENC 402-63	CENC 402-63	CENC 402-63	CENC 402-63
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
Insert	Wrench	H3L	H3L	H3L	H3L
	Outer	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G
	Screw	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T-20D	T-20D	T-20D	T-20D
	Inner	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G
	Screw	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T-20D	T-20D	T-20D	T-20D
	Center	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G	TPMX 280716R-G
Pad	Screw	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T-20D	T-20D	T-20D	T-20D
	Guide pad	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB	PAD-GP18-40-300-DC-SB
		PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC	PAD-GP18-40-300-DC-SC
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Guide pad protector	PAD-P18	PAD-P18	PAD-P18	PAD-P18
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Sub guide pad	PAD-S14	PAD-S14	PAD-S14	PAD-S14
	Screw	CSTA5S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T-15D	T-15D	T-15D	T-15D



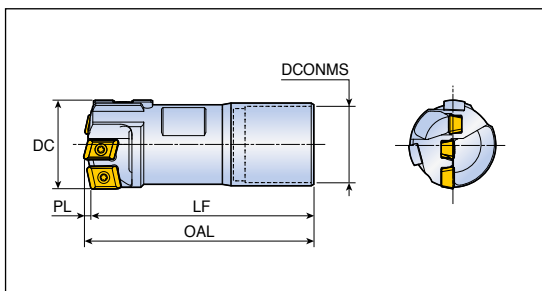
Single tube system



- | | | |
|--|--|--|
| <p>Assembly</p>  <p>D153</p> | <p>Tube</p>  <p>D170-D171</p> | <p>Cutting Condition</p>  <p>D254</p> |
|--|--|--|

ADVANCECUTTING
TaeguTec

Single tube system



- [illegible]

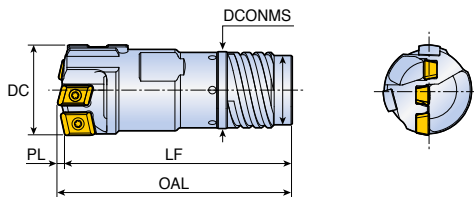
Assembly  D153	Tube  D172-D173	Cutting Condition  D254
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► Insert and guide pad are sold separately from drill body

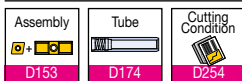
TBTA-FB...DE4



Double tube system



- Outer four start thread

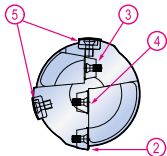
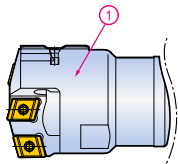
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► Insert and guide pad are sold separately from drill body

TBTA-FB Series



Assembly of TBTA-FB series



- 1. Head shank
- 2. Outer insert
- 3. Inner insert
- 4. Center insert
- 5. Guide pad

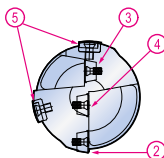
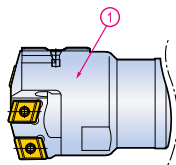
Parts		Diameter (mm)			
		25.00-28.00	28.01-29.99	30.00-35.00	35.01-38.00
Insert	PER	NPHT 060304R-G-P	NPHT 060304R-G-P	NPHT 080404R-G-P	NPHT 080404R-G-P
	Screw	CSTB2.2	CSTB2.2	SR 14-560-HG	SR 14-560-HG
	Wrench	T-7F	T-7F	T-8F	T-8F
	INT	NPMT 060304R-G-I	NPMT 060304R-G-I	NPMT 070404R-G-I	NPMT 070404R-G-I
	Screw	CSTB2.2	CSTB2.2	SR 14-560-HG	SR 14-560-HG
	Wrench	T-7F	T-7F	T-8F	T-8F
	CEN	NPMT 060308L-G-C	NPMT 070408L-G-C	NPMT 070408L-G-C	NPMT 080480L-G-C
	Screw	CSTB2.2	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG
Pad	Wrench	T-7F	T-8F	T-8F	T-8F
	PAD	PAD-GP06-20-120-DC-SB	PAD-GP06-20-120-DC-SB	PAD-GP07-20-120-DC-SB	PAD-GP07-20-120-DC-SB
		PAD-GP06-20-120-DC-SC	PAD-GP06-20-120-DC-SC	PAD-GP07-20-120-DC-SC	PAD-GP07-20-120-DC-SC
	Screw	CSTB2.2S	CSTB2.2S	CSTB3S	CSTB3S
	Wrench	T-7F	T-7F	T-9F	T-9F

Parts		Diameter (mm)			
		38.01-39.00	39.01-41.00	41.01-44.00	44.01-45.00
Insert	PER	NPHT 090404R-G-P	NPHT 090404R-G-P	NPHT 090404R-G-P	NPHT 090404R-G-P
	Screw	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG
	Wrench	T-8F	T-8F	T-8F	T-8F
	INT	NPMT 070404R-G-I	NPMT 070404R-G-I	NPMT 080404R-G-I	NPMT 080404R-G-I
	Screw	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG
	Wrench	T-8F	T-8F	T-8F	T-8F
	CEN	NPMT 080408L-G-C	NPMT 080408L-G-C	NPMT 080408L-G-C	NPMT 100408L-G-C
	Screw	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG
Pad	Wrench	T-8F	T-8F	T-8F	T-8F
	PAD	PAD-GP07-20-120-DC-SB	PAD-GP08-25-155-DC-SB	PAD-GP08-25-155-DC-SB	PAD-GP08-25-155-DC-SB
		PAD-GP07-20-120-DC-SC	PAD-GP08-25-155-DC-SC	PAD-GP08-25-155-DC-SC	PAD-GP08-25-155-DC-SC
	Screw	CSTB3S	CSTB3S	CSTB3S	CSTB3S
	Wrench	T-9F	T-9F	T-9F	T-9F



▶ Insert and guide pad are sold separately from drill body

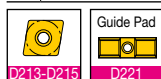
Assembly of TBTA-FB series



1. Head shank
2. Outer insert
3. Inner insert
4. Center insert
5. Guide pad

Parts		Diameter (mm)			
		45.01-47.00	47.01-51.00	51.01-54.00	54.01-57.00
Insert	PER	NPHT 090404R-G-P	NPHT 110404R-G-P	NPHT 110404R-G-P	NPHT 110404R-G-P
	Screw	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG
	Wrench	T-8F	T-8F	T-8F	T-8F
	INT	NPMT 080404R-G-I	NPMT 080404R-G-I	NPMT 100404R-G-I	NPMT 100404R-G-I
	Screw	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG
	Wrench	T-8F	T-8F	T-8F	T-8F
	CEN	NPMT 100408L-G-C	NPMT 100408L-G-C	NPMT 100408L-G-C	NPMT 130408L-G-C
	Screw	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG
Pad	Wrench	T-8F	T-8F	T-8F	T-8F
	PAD	PAD-GP10-30-200-DC-SB	PAD-GP10-30-200-DC-SB	PAD-GP10-30-200-DC-SB	PAD-GP10-30-200-DC-SB
		PAD-GP10-30-200-DC-SC	PAD-GP10-30-200-DC-SC	PAD-GP10-30-200-DC-SC	PAD-GP10-30-200-DC-SC
	Screw	CSTB3.5	CSTB3.5	CSTB3.5	CSTB3.5
	Wrench	T-15F	T-15F	T-15F	T-15F

Parts		Diameter (mm)		
		57.01-60.00	60.01-64.00	64.01-65.00
Insert	PER	NPHT 110404R-G-P	NPHT 130404R-G-P	NPHT 130404R-G-P
	Screw	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG
	Wrench	T-8F	T-8F	T-8F
	INT	NPMT 100404R-G-I	NPMT 100404R-G-I	NPMT 130404R-G-I
	Screw	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG
	Wrench	T-8F	T-8F	T-8F
	CEN	NPMT 130408L-G-C	NPMT 130408L-G-C	NPMT 130408L-G-C
	Screw	SR 14-560-HG	SR 14-560-HG	SR 14-560-HG
Pad	Wrench	T-8F	T-8F	T-8F
	PAD	PAD-GP12-35-250-DC-SB	PAD-GP12-35-250-DC-SB	PAD-GP12-35-250-DC-SB
		PAD-GP12-35-250-DC-SC	PAD-GP12-35-250-DC-SC	PAD-GP12-35-250-DC-SC
	Screw	CSTB3.5	CSTB3.5	CSTB3.5
	Wrench	T-15F	T-15F	T-15F

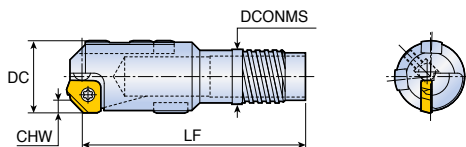


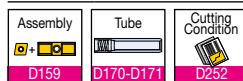
► Insert and guide pad are sold separately from drill body

1. Head shank
2. Outer insert
3. Inner insert 1
4. Inner insert 2
5. Inner insert 3
6. Center insert
7. Guide pad

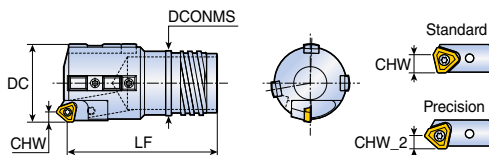
 **Guide Pad** ▶ Insert and guide pad are sold separately from drill body
D213-D215 **D221**

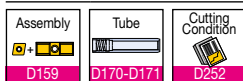
Single tube system





Single tube system





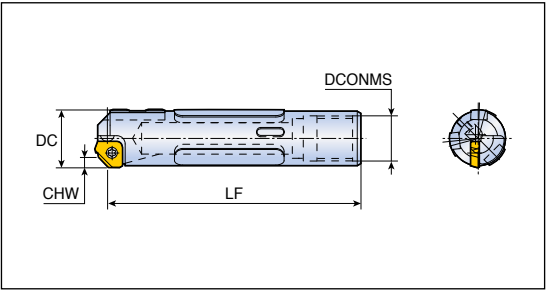
TBTA-R...SI1



Single tube system



- Inner single start thread



Designation	DC	CHW (mm)	Dimension (mm)		Tube	
			LF	DCONMS	Part	Diameter (mm)
TBTA-R- xxx.xxSI1-22	25.00-26.99	2.8	110.5	20	BTSE 022	22
xxx.xxSI1-24	27.00-29.99	2.8	110.5	22	BTSE 024	24
xxx.xxSI1-26	30.00-31.99	2.8	110.5	24	BTSE 026	26
xxx.xxSI1-28	32.00-33.99	2.8	110.5	26	BTSE 028	28
xxx.xxSI1-30	34.00-36.99	2.8	135.5	27	BTSE 030	30
xxx.xxSI1-33	37.00-39.99	2.8	135.5	30	BTSE 033	33

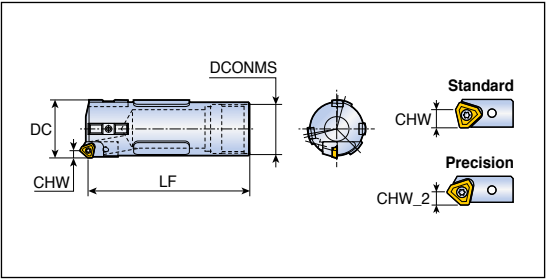
TBTA-R...SI1



Single tube system



- Inner single start thread



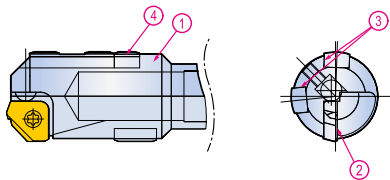
Designation	DC	CHW (mm)		Dimension (mm)		Tube	
		Standard	Precision	LF	DCONMS	Part	Diameter (mm)
TBTA-R- xxx.xxSI1-36	40.00-43.99	6.4	4	135	33	BTSE 036	36
xxx.xxSI1-39	44.00-46.99	6.4	4	135	37	BTSE 039	39
xxx.xxSI1-43	47.00-51.99	6.4	4	145	41	BTSE 043	43
xxx.xxSI1-47	52.00-56.99	7.2	4.8	145	44	BTSE 047	47
xxx.xxSI1-51	57.00-60.99	7.2	4.8	170	49	BTSE 051	51
xxx.xxSI1-56	61.00-67.99	7.2/10.4	4.8/6.4	170	53	BTSE 056	56
xxx.xxSI1-62	68.00-74.99	10.4	6.4	170	59	BTSE 062	62
xxx.xxSI1-68	75.00-80.99	10.4	6.4	205	65	BTSE 068	68
xxx.xxSI1-75	81.00-90.99	10.4	6.4	215	71	BTSE 075	75
xxx.xxSI1-82	91.00-98.99	10.4	6.4	225	79	BTSE 082	82
xxx.xxSI1-94	99.00-110.99	10.4	6.4	235	90	BTSE 094	94

Assembly	Tube	Cutting Condition
D159	D172-D173	D252

TBTA-R Series



Assembly of TBTA-R series



- 1. Head shank
- 2. Insert
- 3. Guide pad
- 4. Guide pad protector

Parts			Diameter (mm)			
			25.00-27.99	28.00-29.99	30.00-37.99	38.00-39.99
Close tolerance	Cartridge	Adjust ball	BALL5	BALL5	BALL5	BALL5
		Adjust screw	AS0005-5	AS0005-5	AS0005-5	AS0005-5
		Wrench	H2.5	H2.5	H2.5	H2.5
		Screw	-	-	-	-
	Wrench	-	-	-	-	
	Insert	Insert	XPMT 16002-45	XPMT 16002-45	XPMT 16002-45	XPMT 16002-45
		Screw	CSTANO3	CSTANO3	CSTANO3	CSTANO3
Wrench		T-9D	T-9D	T-9D	T-9D	
Normal tolerance	Cartridge	Outer	-	-	-	-
		Adjust screw	-	-	-	-
		Wrench	-	-	-	-
		Screw	-	-	-	-
		Wrench	-	-	-	-
	Insert	Insert	XPMT 16002-45	XPMT 16002-45	XPMT 16002-45	XPMT 16002-45
		Screw	CSTANO3	CSTANO3	CSTANO3	CSTANO3
		Wrench	T-9D	T-9D	T-9D	T-9D
Pad	Guide pad (A)	PAD-GP06-20-120-DC-SB	PAD-GP06-20-120-DC-SB	PAD-GP07-20-120-DC-SB	PAD-GP08-25-155-DC-SB	
		PAD-GP06-20-120-DC-SC	PAD-GP06-20-120-DC-SC	PAD-GP07-20-120-DC-SC	PAD-GP08-25-155-DC-SC	
	Screw	CSTB2.2S	CSTB2.2S	CSTB3S	CSTB3S	
	Wrench	T-9D	T-9D	T-9D	T-9D	
	Guide pad protector (B)	-	-	-	PAD-P08	
		-	-	-	CSTB3S	
	Wrench	-	-	-	T-9D	
	Resin guide pad (C)	PAD-R10	PAD-R10	PAD-R12	PAD-R15	
		LS0902, 5-6	LS0902, 5-6	LS0903-8	LS0904-10	
	Wrench	-	-	H2	H2.5	

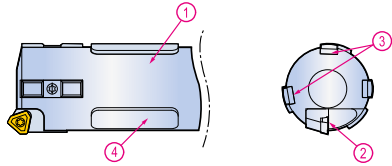


- A+B is for outer four start thread connection type
- A+C is for inner single start thread connection type

TBTA-R Series



Assembly of TBTA-R series

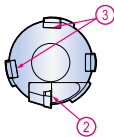
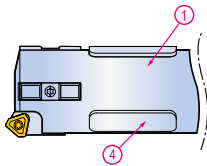


- 1. Head shank
- 2. Cartridge & lock screw
- 3. Guide pad
- 4. Resin guide pad & lock screw

Parts		Diameter (mm)			
		40.00-45.99	46.00-51.99	52.00-56.99	57.00-59.99
Close tolerance	Cartridge	Outer	PERC-P 04R	PERC-P 04R	PERC-P 32R
		Adjust screw	AS0004-8	AS0004-8	AS0005-10
		Wrench	H2	H2	H2.5
		Screw	LS1803.5RH	LS1803.5RH	LS1805RH
	Insert	Wrench	H2.5	H2.5	H3
		Insert	TPMX 1403LG	TPMX 1403LG	TPMX 1704LG
		Screw	CSTB2.5	CSTB2.5	CSTB3.5D
Normal tolerance	Cartridge	Wrench	T-8D	T-8D	T-8D
		Outer	PERC 402-04	PERC 402-04	PERC 402-32
		Adjust screw	AS0004-8	AS0004-8	AS0005-10
		Wrench	H2	H2	H2.5
	Insert	Screw	LS1803.5RH	LS1803.5RH	LS1805RH
		Wrench	H2.5	H2.5	H3
		Insert	TPMX 140308R-G	TPMX 140308R-G	TPMX 170408R-G
		Screw	CSTB2.5	CSTB2.5	CSTB3.5D
		Wrench	T-8D	T-8D	T-8D
Pad	Guide pad (A)	PAD-GP08-25-155-DC-SB	PAD-GP10-35-200-DC-SB	PAD-GP10-35-200-DC-SB	PAD-GP10-35-200-DC-SB
		PAD-GP08-25-155-DC-SC	PAD-GP10-35-200-DC-SC	PAD-GP10-35-200-DC-SC	PAD-GP10-35-200-DC-SC
		Screw	CSTB3S	CSTB4S	CSTB4S
	Guide pad protector (B)	Wrench	T-9D	T-15D	T-15D
		PAD-P08	PAD-P10	PAD-P10	PAD-P14
		Screw	CSTB3S	CSTB4S	CSTB4S
	Resin guide pad (C)	Wrench	T-9D	T-15D	T-15D
		PAD-R15	PAD-R15	PAD-R15	PAD-R20
		Screw	LS0904-10	LS0904-10	LS0905-12
		Wrench	H2.5	H2.5	H3



- ▶ A+B is for outer four start thread connection type
- ▶ A+C is for inner single start thread connection type



- 1. Head shank
- 2. Cartridge & lock screw
- 3. Guide pad
- 4. Resin guide pad & lock screw

Parts			Diameter (mm)		
			60.00-66.99	67.00-99.99	100.00-122.99
Close tolerance	Cartridge	Outer	PERC-P 32R	PERC-P 43R	PERC-P 43R
		Adjust screw	AS0005-10	AS0005-15	AS0005-15
		Wrench	H2.5	H2.5	H2.5
		Screw	LS1805RH	LS1806RH	LS1806RH
	Insert	Wrench	H3	H4	H4
		Insert	TPMX 1704LG	TPMX 2405LG	TPMX 2405LG
		Screw	CSTB3.5D	CSTB4M	CSTB4M
Normal tolerance	Cartridge	Wrench	T-8D	T-15D	T-15D
		Outer	PERC 402-32	PERC 402-43	PERC 402-43
		Adjust screw	AS0005-10	AS0005-15	AS0005-15
		Wrench	H2.5	H2.5	H2.5
	Insert	Screw	LS1805RH	LS1806RH	LS1806RH
		Wrench	H3	H4	H4
		Insert	TPMX 170408R-G	TPMX 240512R-G	TPMX 240512R-G
Pad	Guide pad (A)	Screw	CSTB3.5D	CSTB4M	CSTB4M
		Wrench	T-8D	T-15D	T-15D
		Guide pad (A)	PAD-GP14-40-250-DC-SB	PAD-GP14-40-250-DC-SB	PAD-GP18-40-300-DC-SB
			PAD-GP14-40-250-DC-SC	PAD-GP14-40-250-DC-SC	PAD-GP18-40-300-DC-SC
		Screw	CSTA5S	CSTA5S	LS1206S
		Wrench	T-15D	T-15D	H3
		Guide pad protector (B)	PAD-P14	PAD-P14	PAD-P18
	Resin guide pad (C)	Screw	CSTA5S	CSTA5S	LS1206S
		Wrench	T-15D	T-15D	H3
		Resin guide pad (C)	PAD-R20	PAD-R35	PAD-R35
		Screw	LS0905-12	LS0906-15	LS0906-15
		Wrench	H3	H4	H4

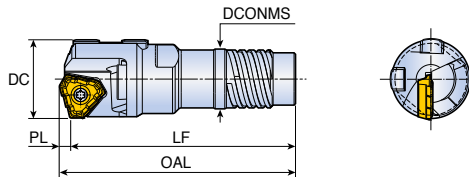


- ▶ A+B is for outer four start thread connection type
- ▶ A+C is for inner single start thread connection type

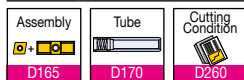
TBTA-TR...SE4



Single tube system



- Outer four start thread

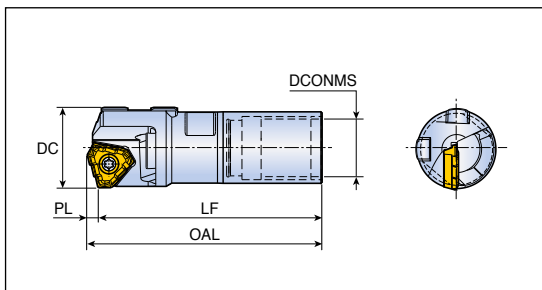
[illegible]

► Insert and guide pad are sold separately from drill body

Single tube system



- Inner single start thread

[illegible]

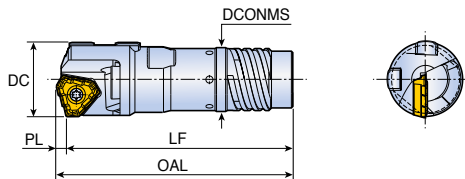
Assembly  D165	Tube  D172	Cutting Condition  D260
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► Insert and guide pad are sold separately from drill body

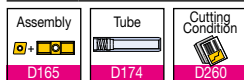
TBTA-TR...DE4



Double tube system



- Outer four start thread

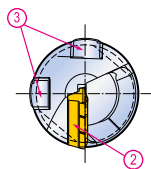
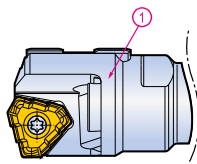
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► Insert and guide pad are sold separately from drill body.

TBTA-TR Series



Assembly of TBTA-TR series



1. Head shank
2. Insert
3. Guide pad

Parts		Diameter (mm)		
		16.00-18.00	18.01-20.00	20.01-21.00
Insert	Insert	TOGT 080305 RS	TOGT 090305 RS	TOGT 100305 RS
	Screw	CSTB2.5S	CSTB2.5S*	CSTB3S*
	Wrench	T-8F	T-8F	T-9F
Guide Pad	Guide Pad	PAD-GP06-20-075-DC-SB	PAD-GP06-20-085-DC-SB	PAD-GP06-20-085-DC-SB
		PAD-GP06-20-075-DC-SC	PAD-GP06-20-085-DC-SC	PAD-GP06-20-085-DC-SC
	Screw	CSTB2.2S	CSTB2.2S*	CSTB2.2S*
	Wrench	T-7F	T-7F	T-7F

Parts		Diameter (mm)		
		21.01-21.99	22.00-25.00	25.01-28.00
Insert	Insert	TOGT 100305 RS	TOGT 110405 RS	TOGT 120405 RS
	Screw	CSTB3S*	SR14-571/S	CSTB4S
	Wrench	T-9F	T-10/5	T-15F
Guide Pad	Guide Pad	PAD-GP06-20-100-DC-SB	PAD-GP06-20-100-DC-SB	PAD-GP06-20-120-DC-SB
		PAD-GP06-20-100-DC-SC	PAD-GP06-20-100-DC-SC	PAD-GP06-20-120-DC-SC
	Screw	CSTB2.2S*	CSTB2.2S*	CSTB2.2S*
	Wrench	T-7F	T-7F	T-7F

Parts		Diameter (mm)			
		28.01-29.99	30.00-32.00	32.01-39.00	39.01-40.00
Insert	Insert	TOGT 130408 RS	TOGT 130408 RS	TOGT 140510 RS	TOGT 140510 RS
	Screw	SR 16-212/L10	SR 16-212/L10	SR 16-212/L10	SR 16-212/L10
	Wrench	T-20/5	T-20/5	T-20/5	T-20/5
Guide Pad	Guide Pad	PAD-GP06-20-120-DC-SB	PAD-GP07-20-120-DC-SB	PAD-GP07-20-120-DC-SB	PAD-GP08-25-155-DC-SB
		PAD-GP06-20-120-DC-SC	PAD-GP07-20-120-DC-SC	PAD-GP07-20-120-DC-SC	PAD-GP08-25-155-DC-SC
	Screw	CSTB2.2	CSTB3S	CSTB3S	CSTB3S
	Wrench	T-7F	T-9F	T-9F	T-9F

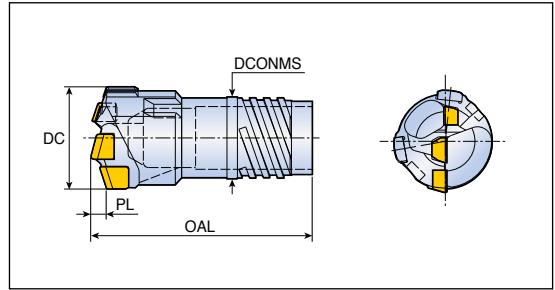


► Insert and guide pad are sold separately from drill body.

Single tube system

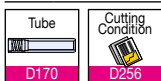


- Outer four start thread

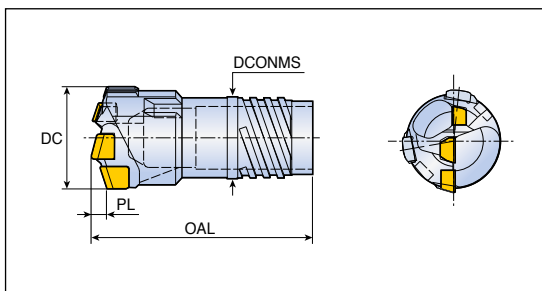


Designation	DC	Dimension (mm)			Tube	
		OAL	PL	DCONMS	Part	Diameter (mm)
BTA xxx.xx SE2-11*	12.60-13.10	43.0	1.1	9.6	BTSI011	11
xxx.xx SE2-11*	13.11-13.60	43.0	1.1	9.6	BTSI011	11
xxx.xx SE2-12*	13.61-14.10	43.0	1.2	10.6	BTSI012	12
xxx.xx SE2-12*	14.11-14.60	43.0	1.2	10.6	BTSI012	12
xxx.xx SE2-13*	14.61-15.10	43.0	1.3	11.6	BTSI013	13
xxx.xx SE2-13*	15.11-15.59	43.0	1.3	11.6	BTSI013	13
xxx.xx SE4-14	15.60-16.20	43.0	2.7	12.6	BTSI014	14
xxx.xx SE4-14	16.21-16.70	43.0	2.7	12.6	BTSI014	14
xxx.xx SE4-15	16.71-17.20	43.0	2.7	13.6	BTSI015	15
xxx.xx SE4-15	17.21-17.70	43.0	2.7	13.6	BTSI015	15
xxx.xx SE4-16	17.71-18.40	47.0	2.8	14.5	BTSI016	16
xxx.xx SE4-16	18.41-18.90	47.0	2.9	14.5	BTSI016	16
xxx.xx SE4-17	18.91-19.20	47.0	2.9	15.5	BTSI017	17
xxx.xx SE4-17	19.21-20.00	47.0	2.9	15.5	BTSI017	17
xxx.xx SE4-18	20.01-20.90	52.5	3.2	16.0	BTSI018	18
xxx.xx SE4-18	20.91-21.80	52.5	3.2	16.0	BTSI018	18
xxx.xx SE4-20	21.81-22.90	56.0	3.2	18.0	BTSI020	20
xxx.xx SE4-20	22.91-24.10	56.0	3.2	18.0	BTSI020	20
xxx.xx SE4-22	24.11-25.20	57.5	3.5	19.5	BTSI022	22
xxx.xx SE4-22	25.21-26.40	57.5	3.5	19.5	BTSI022	22
xxx.xx SE4-24	26.41-27.50	57.5	3.7	21.0	BTSI024	24
xxx.xx SE4-24	27.51-28.70	57.5	3.7	21.0	BTSI024	24
xxx.xx SE4-26	28.71-29.80	63.5	4.0	23.5	BTSI026	26
xxx.xx SE4-26	29.81-31.00	63.5	4.0	23.5	BTSI026	26
xxx.xx SE4-28	31.01-32.10	63.5	4.3	25.5	BTSI028	28
xxx.xx SE4-28	32.11-33.30	63.5	4.3	25.5	BTSI028	28
xxx.xx SE4-30	33.31-34.80	63.5	4.5	28.0	BTSI030	30
xxx.xx SE4-30	34.81-36.20	63.5	4.5	28.0	BTSI030	30
xxx.xx SE4-33	36.21-37.30	73.5	4.8	30.0	BTSI033	33
xxx.xx SE4-33	37.31-38.40	73.5	4.8	30.0	BTSI033	33
xxx.xx SE4-33	38.41-39.60	73.5	4.8	30.0	BTSI033	33
xxx.xx SE4-36	39.61-40.60	73.5	5.6	33.0	BTSI036	36
xxx.xx SE4-36	40.61-41.80	73.5	5.6	33.0	BTSI036	36
xxx.xx SE4-36	41.81-43.00	73.5	5.6	33.0	BTSI036	36
xxx.xx SE4-39	43.01-44.30	75.0	5.4	36.0	BTSI039	39

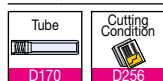
► *: 2 cutting edge head, 2 start thread



Single tube system



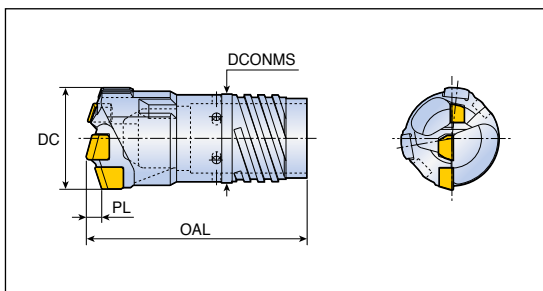
- [illegible]



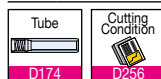
Double tube system



- Outer four start thread



Designation	DC	Dimension (mm)			Tube		
		OAL	PL	DCONMS	Outer tube	Inner tube	Diameter (mm)
BTA xxx.xx DE4-18	18.41-19.20	50.0	2.9	16.0	BTDO018	BTDI012	18.0
xxx.xx DE4-18	19.21-20.00	50.0	2.9	16.0	BTDO018	BTDI012	18.0
xxx.xx DE4-19.5	20.01-20.90	56.0	3.2	18.0	BTDO019.5	BTDI014	19.5
xxx.xx DE4-19.5	20.91-21.80	56.0	3.2	18.0	BTDO019.5	BTDI014	19.5
xxx.xx DE4-21.5	21.81-22.90	56.0	3.2	19.5	BTDO021.5	BTDI015	21.5
xxx.xx DE4-21.5	22.91-24.10	56.0	3.2	19.5	BTDO021.5	BTDI015	21.5
xxx.xx DE4-23.5	24.11-25.20	57.5	3.5	21.0	BTDO023.5	BTDI016	23.5
xxx.xx DE4-23.5	25.21-26.40	57.5	3.5	21.0	BTDO023.5	BTDI016	23.5
xxx.xx DE4-26	26.41-27.50	60.5	3.7	23.5	BTDO026	BTDI018	26.0
xxx.xx DE4-26	27.51-28.70	60.5	3.7	23.5	BTDO026	BTDI018	26.0
xxx.xx DE4-28	28.71-29.80	63.5	4.0	25.5	BTDO028	BTDI020	28.0
xxx.xx DE4-28	29.81-31.00	63.5	4.0	25.5	BTDO028	BTDI020	28.0
xxx.xx DE4-30.5	31.01-32.10	63.5	4.1	28.0	BTDO030.5	BTDI022	30.5
xxx.xx DE4-30.5	32.11-33.30	63.5	4.1	28.0	BTDO030.5	BTDI022	30.5
xxx.xx DE4-33	33.31-34.80	70.5	4.5	30.0	BTDO033.0	BTDI024	33.0
xxx.xx DE4-33	34.81-36.20	70.5	4.5	30.0	BTDO033.0	BTDI024	33.0
xxx.xx DE4-35.5	36.21-37.30	73.5	4.8	33.0	BTDO035.5	BTDI026	35.5
xxx.xx DE4-35.5	37.31-38.40	73.5	4.8	33.0	BTDO035.5	BTDI026	35.5
xxx.xx DE4-35.5	38.41-39.60	73.5	4.8	33.0	BTDO035.5	BTDI026	35.5
xxx.xx DE4-39	39.61-40.60	73.5	5.3	36.0	BTDO039	BTDI029	39.0
xxx.xx DE4-39	40.61-41.80	73.5	5.3	36.0	BTDO039	BTDI029	39.0
xxx.xx DE4-39	41.81-43.00	73.5	5.3	36.0	BTDO039	BTDI029	39.0
xxx.xx DE4-42.5	43.01-44.30	75.0	5.5	39.0	BTDO042.5	BTDI032	42.5
xxx.xx DE4-42.5	44.31-45.60	75.0	5.5	39.0	BTDO042.5	BTDI032	42.5
xxx.xx DE4-42.5	45.61-47.00	75.0	5.5	39.0	BTDO042.5	BTDI032	42.5
xxx.xx DE4-46.5	47.01-48.50	79.0	6.1	43.0	BTDO046.5	BTDI035	46.5
xxx.xx DE4-46.5	48.51-50.10	79.0	6.1	43.0	BTDO046.5	BTDI035	46.5
xxx.xx DE4-46.5	50.11-51.70	79.0	6.1	43.0	BTDO046.5	BTDI035	46.5
xxx.xx DE4-51	51.71-53.20	82.0	6.5	47.0	BTDO051	BTDI039	51.0
xxx.xx DE4-51	53.21-54.70	82.0	6.5	47.0	BTDO051	BTDI039	51.0
xxx.xx DE4-51	54.71-56.20	82.0	6.5	47.0	BTDO051	BTDI039	51.0
xxx.xx DE4-55.5	56.21-58.40	84.0	6.6	51.0	BTDO055.5	BTDI043A	55.5
xxx.xx DE4-55.5	58.41-60.60	84.0	6.6	51.0	BTDO055.5	BTDI043A	55.5
xxx.xx DE4-55.5	60.61-62.80	84.0	6.6	51.0	BTDO055.5	BTDI043A	55.5
xxx.xx DE4-55.5	62.81-65.00	84.0	6.6	51.0	BTDO055.5	BTDI043A	55.5



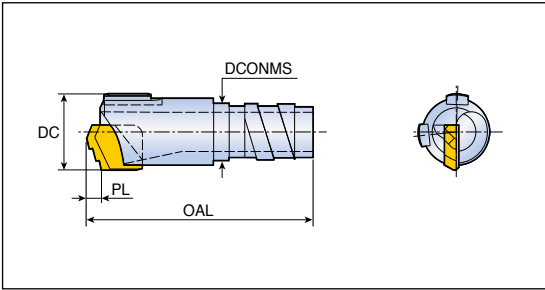
BTS...SE1



Single tube system



- Outer single start thread



Designation	DC	Dimension (mm)			Tube	
		OAL	PL	DCONMS	Part	Diameter (mm)
BTS xxx.xx SE1-7.1	8.00-8.99	34	2.0	6.0	BTSO071	7.1
xxx.xx SE1-8.3	9.00-9.99	34	2.0	7.2	BTSO083	8.3
xxx.xx SE1-9	10.00-10.99	34	2.2	7.6	BTSO090	9.0
xxx.xx SE1-10	11.00-11.99	34	2.2	8.6	BTSO100	10.0
xxx.xx SE1-11	12.00-13.49	34	2.3	9.1	BTSO110	11.0
xxx.xx SE1-12	13.50-14.79	34	2.4	10.8	BTSO120	12.0

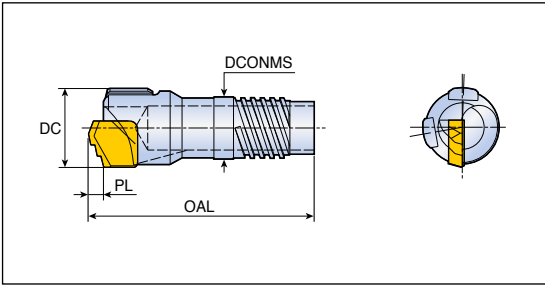
BTS...SE2/SE4



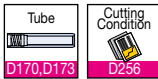
Single tube system



- Outer four start thread

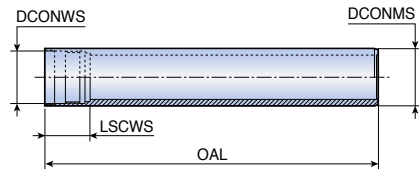


Designation	DC	Dimension (mm)			Tube	
		OAL	PL	DCONMS	Part	Diameter (mm)
BTS xxx.xx SE2-11*	12.60-13.60	40	2.3	9.6	BTSI011	11
xxx.xx SE2-12*	13.61-14.60	40	2.4	10.6	BTSI012	12
xxx.xx SE2-13*	14.61-15.59	40	3.0	11.6	BTSI013	13
xxx.xx SE4-14	15.60-16.70	40	2.4	12.6	BTSI014	14
xxx.xx SE4-15	16.71-17.70	40	3.0	13.6	BTSI015	15
xxx.xx SE4-16	17.71-18.90	40	3.3	14.5	BTSI016	16
xxx.xx SE4-17	18.91-20.00	40	3.3	15.5	BTSI017	17



► *: Designates outer two start thread

- Inner four start thread

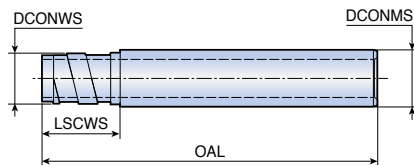
[illegible]

► Please indicate overall length (OAL) when ordering
► *: Indicates parts are inner two start thread

-
- The diagram illustrates a ship's hull cross-section. The total length of the hull is labeled OAL (Overall Length). The distance from the bow to the midship section is labeled DCONWS (Distance from Center of Gravity to the Waterline Section). The distance from the stern to the midship section is labeled DCONMS (Distance from Center of Gravity to the Waterline Section). The length of the waterline section is labeled LSCWS (Length of the Waterline Section). The diagram shows the hull's profile, including the bow, stern, and midship section, with the waterline section highlighted in blue.

[illegible]

► Please indicate overall length (OAL) when ordering

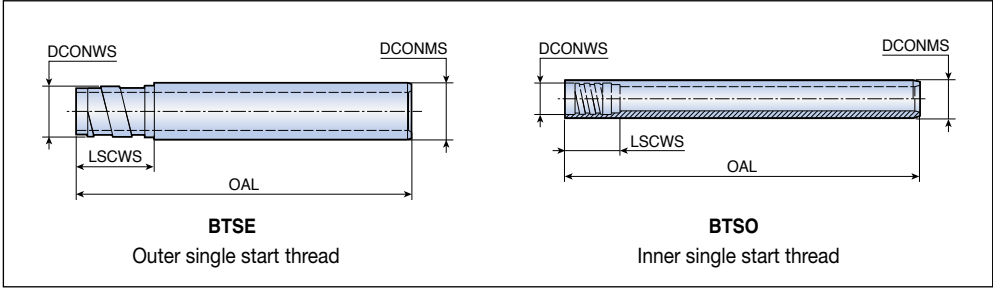


- Outer single start thread

[illegible]

► Please indicate overall length (OAL) when ordering

Single tube



Designation	DC	Dimension (mm)			
		DCONMS	DCONWS		LSCWS
BTSE 047	52.00-56.99	47.0	44	-	41
051	57.00-60.99	51.0	49	-	41
056	61.00-67.99	56.0	53	-	41
062	68.00-74.99	62.0	59	-	41
068	75.00-80.99	68.0	65	-	71
075	81.00-90.99	75.0	71	-	71
082	91.00-98.99	82.0	79	-	71
094	99.00-110.99	94.0	90	-	71
106	111.00-122.99	106.0	102	-	71
118	123.00-134.99	118.0	114	-	71
130	135.00-148.99	130.0	126	-	71
142	149.00-161.99	142.0	139	-	71
154	162.00-173.99	154.0	151	-	86
166	174.00-185.99	166.0	163	-	86
178	186.00-197.99	178.0	175	-	86
190	198.00-209.99	190.0	187	-	86
202	210.00-221.99	202.0	199	-	86
214	222.00-233.99	214.0	211	-	86
226	234.00-245.99	226.0	223	-	86
238	246.00-257.99	238.0	235	-	86
250	258.00-269.99	250.0	247	-	121
262	270.00-281.99	262.0	259	-	121
274	282.00-293.99	274.0	271	-	121
BTSO 071	8.00-8.99	7.1	-	6.0	13.5
083	9.00-9.99	8.3	-	7.2	13.5
090	10.00-10.99	9.0	-	7.6	13.5
100	11.00-11.99	10.0	-	8.6	13.5
110	12.00-13.49	11.0	-	9.1	13.5
120	13.50-14.79	12.0	-	10.8	13.5

► Please indicate overall length (OAL) when ordering

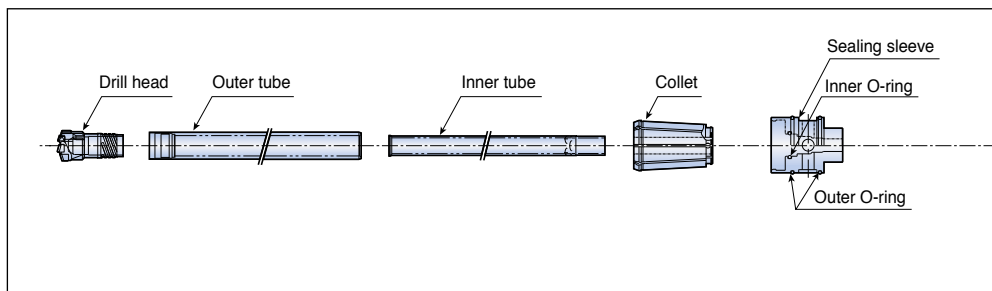
Outer tube

Inner tube

[illegible]

- For diameter range 18.40-65.00 (BTDO 055.5) the inner tube should be ordered 30mm longer than outer tube
- For diameter range 65.01-123.99 (BTDO 056-BTDO 106) the inner tube should be ordered 190mm longer than outer tube
- For diameter range 124.00-183.99 (BTDO 118-BTDO 166) the inner tube should be ordered 220mm longer than outer tube

Assembly of Double Tube System



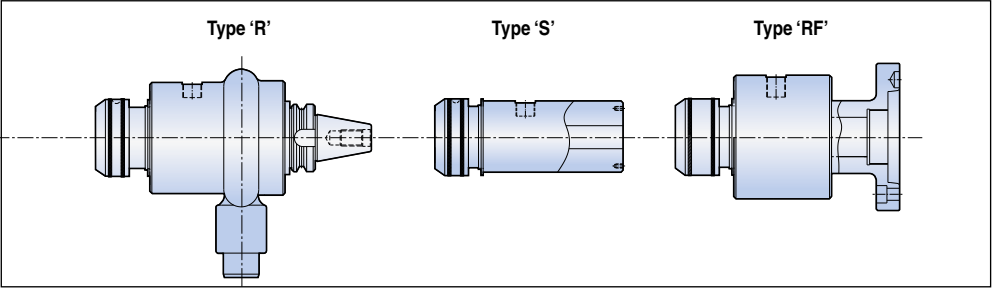
Designation		DC	Collet
BTDO 018	BTDI 012	18.40-19.20	COLLET 4-18
018	012	19.21-20.00	COLLET 4-18
019.5	014	20.01-20.90	COLLET 4-19.5
019.5	014	20.91-21.80	COLLET 4-19.5
021.5	015	21.81-22.90	COLLET 4-21.5
021.5	015	22.91-24.10	COLLET 4-21.5
023.5	016	24.11-25.20	COLLET 4-23.5
023.5	016	25.21-26.40	COLLET 4-23.5
026	018	26.41-27.50	COLLET 4-26
026	018	27.51-28.70	COLLET 4-26
028	020	28.71-29.80	COLLET 4-28
028	020	29.81-31.00	COLLET 4-28
030.5	022	31.01-32.10	COLLET 4-30.5
030.5	022	32.11-33.30	COLLET 4-30.5
033	024	33.31-34.80	COLLET 4-33
033	024	34.81-36.20	COLLET 4-33
035.5	026	36.21-37.30	COLLET 4-35.5
035.5	026	37.31-38.40	COLLET 4-35.5
035.5	026	38.41-39.60	COLLET 4-35.5
039	029	39.61-40.60	COLLET 4-39
039	029	40.61-41.80	COLLET 4-39
039	029	41.81-43.00	COLLET 4-39
042.5	032	43.01-44.30	COLLET 4-42.5
042.5	032	44.31-45.60	COLLET 4-42.5
042.5	032	45.61-47.00	COLLET 4-42.5
046.5	035	47.01-48.50	COLLET 4-46.5
046.5	035	48.51-50.10	COLLET 4-46.5
046.5	035	50.11-51.70	COLLET 4-46.5
051	039	51.71-53.20	COLLET 4-51
051	039	53.21-54.70	COLLET 4-51
051	039	54.71-56.20	COLLET 4-51
055.5	043A	56.21-58.40	COLLET 4-55.5
055.5	043A	58.41-60.60	COLLET 4-55.5
055.5	043A	60.61-62.80	COLLET 4-55.5
055.5	043A	62.81-65.00	COLLET 4-55.5

▶ Inner tube should be longer than outer tube. Please refer to page **D174** for details

Assembly of Double Tube System



Connector

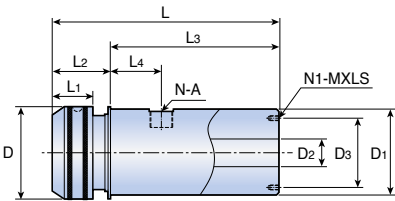


Sealing sleeve	Outer O-ring		Inner O-ring	Connector
SEALING SLEEVE 4R-18	OOR 25.24		IOR18	DTC-4S/4R/4RF
SEALING SLEEVE 4R-18			IOR18	
SEALING SLEEVE 4R-19.5			IOR19.5	
SEALING SLEEVE 4R-19.5			IOR19.5	
SEALING SLEEVE 4R-21.5			IOR21.5	
SEALING SLEEVE 4R-21.5			IOR21.5	
SEALING SLEEVE 4R-23.5			IOR23.5	
SEALING SLEEVE 4R-23.5			IOR23.5	
SEALING SLEEVE 4R-26			IOR26	
SEALING SLEEVE 4R-26			IOR26	
SEALING SLEEVE 4R-28			IOR28	
SEALING SLEEVE 4R-28			IOR28	
SEALING SLEEVE 4R-30.5			IOR30.5	
SEALING SLEEVE 4R-30.5			IOR30.5	
SEALING SLEEVE 4R-33	OOR65		IOR33	
SEALING SLEEVE 4R-33			IOR33	
SEALING SLEEVE 4R-35.5			IOR35.5	
SEALING SLEEVE 4R-35.5			IOR35.5	
SEALING SLEEVE 4R-35.5			IOR35.5	
SEALING SLEEVE 4R-35.5			IOR35.5	
SEALING SLEEVE 4R-39			IOR39	
SEALING SLEEVE 4R-39			IOR39	
SEALING SLEEVE 4R-39			IOR39	
SEALING SLEEVE 4R-42.5			IOR42.5	
SEALING SLEEVE 4R-42.5			IOR42.5	
SEALING SLEEVE 4R-42.5			IOR42.5	
SEALING SLEEVE 4R-46.5			IOR46.5	
SEALING SLEEVE 4R-46.5			IOR46.5	
SEALING SLEEVE 4R-46.5			IOR46.5	
SEALING SLEEVE 4R-51			IOR51	
SEALING SLEEVE 4R-51			IOR51	
SEALING SLEEVE 4R-51			IOR51	
SEALING SLEEVE 4R-55.5			IOR55.5	
SEALING SLEEVE 4R-55.5			IOR55.5	
SEALING SLEEVE 4R-55.5			IOR55.5	
SEALING SLEEVE 4R-55.5			IOR55.5	

DTC-S



'S' type connector

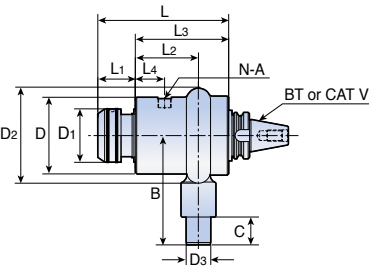


Designation	DC	D	D1	D2	D3	L	L1	L2	L3	L4	N-A	N1-MXLS
DTC 4S	18.4-65.0	115	100	45	80	310	50	60	250	68	2-PT3/4"	4-M8x15
5S	65.0-123.9	164	140	81	120	415	47	115	300		2-PT1"	6-M8x20

DTC-R

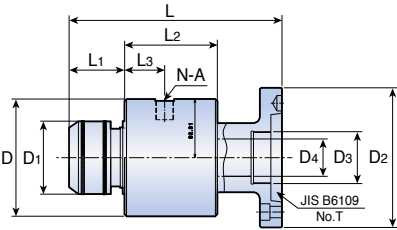


'R' type connector



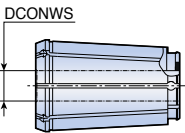
Designation	DC	D	D1	D2	D3	B	C	L	L1	L2	L3	L4	N-A
DTC 4R	18.4-65.0	165	115	206	53	186.5	60	319.7	59.2	152	228	75	2-PT1"
5R	65.0-123.9	225	164	312	100	310	100	382	62	201	320	95	2-PT1 1/4"
6R	124.0-183.9	350	244	445	152.4	412	120	487	75	250	412	118	4-PT1-1/4"

'RF' type connector

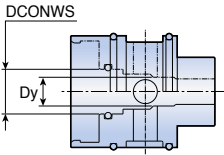


Designation	DC	D	D1	D2	D3	D4	L	L1	L2	L3	N-A
DTC 4RF	18.4-65.0	160	115	210	M62x2	46	291.5	64.5	150	75	2-PT1"

Collet / Sealing Sleeve



Collet



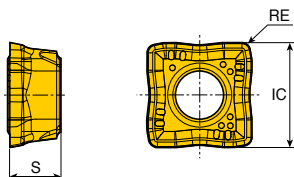
Sealing sleeve

Designation	DC	DCONWS	Designation	DC	DCONWS	Dy	Outer O-ring	Inner O-ring
COLLET 4-18	18.40-20.00	18.0	SEALING SLEEVE 4-18	18.40-20.00	18.0	10	OOR 65	IOR 18
4-19.5	20.01-21.80	19.5	4-19.5	20.01-21.80	19.5	12		IOR 19.5
4-21.5	21.81-24.10	21.5	4-21.5	21.81-24.10	21.5	13		IOR 21.5
4-23.5	24.11-26.40	23.5	4-23.5	24.11-26.40	23.5	14		IOR 23.5
4-26	26.41-28.70	26.0	4-26	26.41-28.70	26.0	16		IOR 26
4-28	28.71-31.00	28.0	4-28	28.71-31.00	28.0	18		IOR 28
4-30.5	31.01-33.30	30.5	4-30.5	31.01-33.30	30.5	20		IOR 30.5
4-33	33.31-36.20	33.0	4-33	33.31-36.20	33.0	22		IOR 33
4-35.5	36.21-39.60	35.5	4-35.5	36.21-39.60	35.5	24		IOR 35.5
4-39	39.61-43.00	39.0	4-39	39.61-43.00	39.0	27		IOR 39
4-42.5	43.01-47.00	42.5	4-42.5	43.01-47.00	42.5	30		IOR 42.5
4-46.5	47.01-51.70	46.5	4-46.5	47.01-51.70	46.5	32		IOR 46.5
4-51	51.71-56.20	51.0	4-51	51.71-56.20	51.0	36		IOR 51
4-55.5	56.21-65.00	55.5	4-55.5	56.21-65.00	55.5	40		IOR 55.5

[illegible]

SOMT...DP

Inserts for general purpose



Size	Dimension (mm)		
	IC	S	RE
04	4.4	2.38	0.4
05	4.9	2.38	0.4
06	5.7	2.38	0.4
07	6.8	2.80	0.6
08	7.9	3.97	0.6
09	9.2	3.97	0.8
11	11.0	3.97	0.8
13	12.8	4.40	0.8
15	15.0	4.80	1.0

Insert	Designation	Coated						Uncoated	
		TT9080	TT8020	TT9300	TT9030	TT6030	TT7400	K10	
	SOMT 040204 DP	●	●	●					
	050204 DP	●	●	●					
	060204 DP	●	●	●					
	070306 DP	●	●	●					
	08T306 DP	●	●	●					
	09T308 DP	●	●	●					
	11T308 DP	●	●	●					
	130408 DP	●	●	●					
	150510 DP	●	●	●					

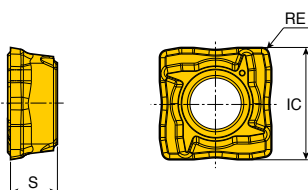


- ▶ TT9080: First choice for general purpose
- ▶ TT8020: For unstable condition
- ▶ TT9300: For high speed machining on a steel application (Peripheral **ONLY**)

●: Standard items

SOMT...DL

Inserts for low carbon steel



Size	Dimension (mm)		
	IC	S	RE
05	4.9	2.38	0.4
06	5.7	2.38	0.4
07	6.8	2.80	0.6
08	7.9	3.97	0.6
09	9.2	3.97	0.8
11	11.0	3.97	0.8
13	12.8	4.40	0.8
15	15.0	4.80	1.0

Insert	Designation	Coated						Uncoated	
		TT9080	TT9030	TT8020	TT6030	TT9300	TT7400	K10	
	SOMT 050204 DL	●							
	060204 DL	●							
	070306 DL	●							
	08T306 DL	●							
	09T308 DL	●							
	11T308 DL	●							
	130408 DL	●							
	150510 DL	●							



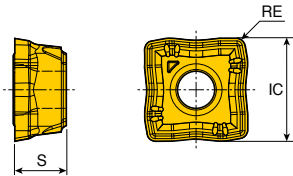
- ▶ TT9080: First choice for general purpose

●: Standard items

SOMT...DK



Inserts for cast iron



Size	Dimension (mm)		
	IC	S	RE
05	4.9	2.38	0.4
06	5.7	2.38	0.4
07	6.8	2.80	0.6
08	7.9	3.97	0.6
09	9.2	3.97	0.8
11	11.0	3.97	0.8
13	12.8	4.40	0.8
15	15.0	4.80	1.0

Insert	Designation	Coated							Uncoated		
		TT9080	TT8020	TT9300	TT9030	TT6030	TT6080	TT7400		K10	
	SOMT 050204 DK						●				
	060204 DK						●				
	070306 DK						●				
	08T306 DK						●				
	09T308 DK						●				
	11T308 DK						●				
	130408 DK						●				
	150510 DK						●				

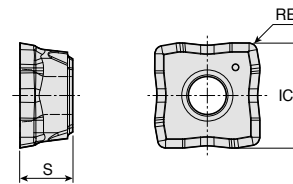


●: Standard items

SOMT...DA



Inserts for aluminum alloy



Size	Dimension (mm)		
	IC	S	RE
05	4.9	2.38	0.4
06	5.7	2.38	0.4
07	6.8	2.80	0.6
08	7.9	3.97	0.6
09	9.2	3.97	0.8
11	11.0	3.97	0.8
13	12.8	4.40	0.8
15	15.0	4.80	1.0

Insert	Designation	Coated							Uncoated		
		TT9080	TT8020	TT9300	TT9030	TT6030	TT6080	TT7400		K10	
	SOMT 050204 DA									●	
	060204 DA									●	
	070306 DA									●	
	08T306 DA									●	
	09T308 DA									●	
	11T308 DA									●	
	130408 DA									●	
	150510 DA									●	

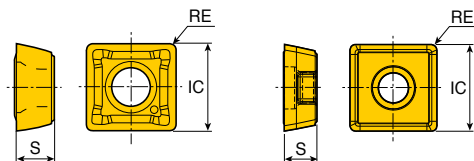


●: Standard items

SPMG...DG



Inserts for general purpose



SPMG 120408 DG

Size	Dimension (mm)		
	IC	S	RE
05	5.00	2.38	0.4
06	6.00	2.38	0.4
07	7.94	3.97	0.8
09	9.80	4.30	0.8
11	11.50	4.80	0.8
12	12.70	4.76	0.8
14	14.30	5.20	1.2

Insert	Designation	Coated						Uncoated	
		TT9080	TT9030	TT8020	TT6030	TT9300	TT7400	K10	
	SPMG 050204 DG		●	●		●			
	060204 DG		●	●		●			
	07T308 DG		●	●		●			
	090408 DG		●	●		●			
	110408 DG		●	●		●			
	120408 DG		●						
	140512 DG		●	●		●			



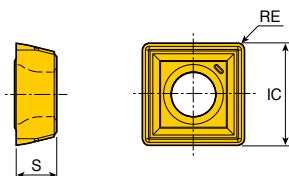
- ▶ TT9030: First choice for general purpose
- ▶ TT8020: For unstable condition
- ▶ TT7400: For high speed machining on a steel application (Peripheral **ONLY**)

●: Standard items

SPMG...DK



Inserts for cast iron



Size	Dimension (mm)		
	IC	S	RE
05	5.00	2.38	0.4
06	6.00	2.38	0.4
07	7.94	3.97	0.8
09	9.80	4.30	0.8
11	11.50	4.80	0.8
14	14.30	5.20	1.2

Insert	Designation	Coated						Uncoated	
		TT9080	TT9030	TT8020	TT6030	TT9300	TT7400	K10	
	SPMG 050204 DK				●				
	060204 DK				●				
	07T308 DK				●				
	090408 DK				●				
	110408 DK				●				
	140512 DK				●				

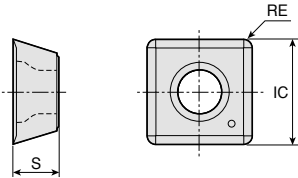


●: Standard items

SPGG...DA



Inserts for aluminum alloy

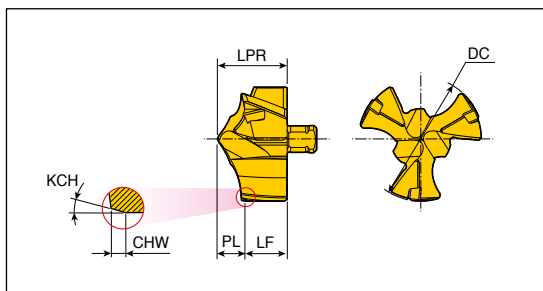


Size	Dimension (mm)		
	IC	S	RE
05	5.00	2.38	0.4
06	6.00	2.38	0.4
07	7.94	3.97	0.8
09	9.80	4.30	0.8
11	11.50	4.80	0.8
14	14.30	5.20	1.2

Insert	Designation	Coated						Uncoated	
		TT9080	TT9030	TT8020	TT6030	TT9300	TT7400	K10	
	SPGG 050204 DA							●	
	060204 DA							●	
	07T308 DA							●	
	090408 DA							●	
	110408 DA							●	
	140512 DA							●	



●: Standard items



Designation	Dimension (mm)							Grade
	DC	LPR	PL	LF	CHW	KCH	SSC	TT5130
3ED- 120-P+	12.0	6.7	2.74	3.96	0.4	15	12	●
121-P+	12.1	6.7	2.74	3.96	0.4	15	12	●
122-P+	12.2	6.7	2.74	3.96	0.4	15	12	●
123-P+	12.3	6.7	2.74	3.96	0.4	15	12	●
124-P+	12.4	6.7	2.74	3.96	0.4	15	12	●
125-P+	12.5	6.7	2.76	3.94	0.4	15	12	●
126-P+	12.6	6.7	2.76	3.94	0.4	15	12	●
127-P+	12.7	6.7	2.76	3.94	0.4	15	12	●
128-P+	12.8	6.7	2.76	3.94	0.4	15	12	●
129-P+	12.9	6.7	2.76	3.94	0.4	15	12	●
130-P+	13.0	7.3	2.91	4.39	0.4	15	13	●
131-P+	13.1	7.3	2.91	4.39	0.4	15	13	●
132-P+	13.2	7.3	2.91	4.39	0.4	15	13	●
133-P+	13.3	7.3	2.91	4.39	0.4	15	13	●
134-P+	13.4	7.3	2.91	4.39	0.4	15	13	●
135-P+	13.5	7.3	2.93	4.37	0.4	15	13	●
136-P+	13.6	7.3	2.93	4.37	0.4	15	13	●
137-P+	13.7	7.3	2.93	4.37	0.4	15	13	●
138-P+	13.8	7.3	2.93	4.37	0.4	15	13	●
139-P+	13.9	7.3	2.93	4.37	0.4	15	13	●
140-P+	14.0	7.9	3.17	4.73	0.4	15	14	●
141-P+	14.1	7.9	3.17	4.73	0.4	15	14	●
142-P+	14.2	7.9	3.17	4.73	0.4	15	14	●
143-P+	14.3	7.9	3.17	4.73	0.4	15	14	●
144-P+	14.4	7.9	3.17	4.73	0.4	15	14	●
145-P+	14.5	7.9	3.19	4.71	0.4	15	14	●
146-P+	14.6	7.9	3.19	4.71	0.4	15	14	●
147-P+	14.7	7.9	3.19	4.71	0.4	15	14	●
148-P+	14.8	7.9	3.19	4.71	0.4	15	14	●
149-P+	14.9	7.9	3.19	4.71	0.4	15	14	●
150-P+	15.0	8.4	3.31	5.09	0.5	30	15	●
151-P+	15.1	8.4	3.31	5.09	0.5	30	15	●
152-P+	15.2	8.4	3.31	5.09	0.5	30	15	●
153-P+	15.3	8.4	3.31	5.09	0.5	30	15	●
154-P+	15.4	8.4	3.31	5.09	0.5	30	15	●

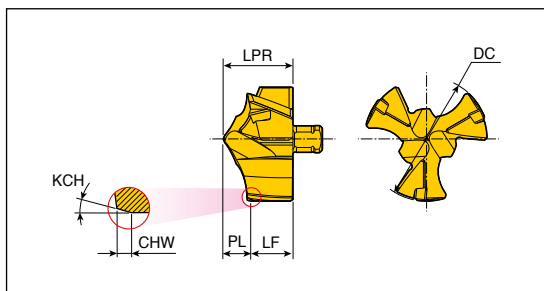


► SSC: Seat size code

●: Standard items

3ED...-P+

3 flute drill heads

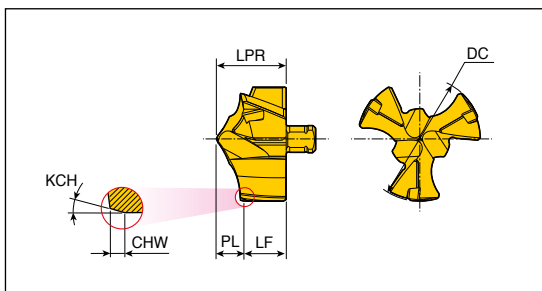


Designation	Dimension (mm)							Grade
	DC	LPR	PL	LF	CHW	KCH	SSC	TT5130
3ED- 155-P+	15.5	8.4	3.32	5.08	0.5	30	15	●
156-P+	15.6	8.4	3.32	5.08	0.5	30	15	●
157-P+	15.7	8.4	3.32	5.08	0.5	30	15	●
158-P+	15.8	8.4	3.32	5.08	0.5	30	15	●
159-P+	15.9	8.4	3.32	5.08	0.5	30	15	●
160-P+	16.0	9.0	3.70	5.30	0.7	30	16	●
161-P+	16.1	9.0	3.70	5.30	0.7	30	16	●
162-P+	16.2	9.0	3.70	5.30	0.7	30	16	●
163-P+	16.3	9.0	3.70	5.30	0.7	30	16	●
164-P+	16.4	9.0	3.70	5.30	0.7	30	16	●
165-P+	16.5	9.0	3.71	5.29	0.7	30	16	●
166-P+	16.6	9.0	3.71	5.29	0.7	30	16	●
167-P+	16.7	9.0	3.71	5.29	0.7	30	16	●
168-P+	16.8	9.0	3.71	5.29	0.7	30	16	●
169-P+	16.9	9.0	3.71	5.29	0.7	30	16	●
170-P+	17.0	9.5	3.88	5.62	0.7	30	17	●
171-P+	17.1	9.5	3.88	5.62	0.7	30	17	●
172-P+	17.2	9.5	3.88	5.62	0.7	30	17	●
173-P+	17.3	9.5	3.88	5.62	0.7	30	17	●
174-P+	17.4	9.5	3.88	5.62	0.7	30	17	●
175-P+	17.5	9.5	3.89	5.61	0.7	30	17	●
176-P+	17.6	9.5	3.89	5.61	0.7	30	17	●
177-P+	17.7	9.5	3.89	5.61	0.7	30	17	●
178-P+	17.8	9.5	3.89	5.61	0.7	30	17	●
179-P+	17.9	9.5	3.89	5.61	0.7	30	17	●
180-P+	18.0	10.1	4.07	6.03	0.7	30	18	●
181-P+	18.1	10.1	4.07	6.03	0.7	30	18	●
182-P+	18.2	10.1	4.07	6.03	0.7	30	18	●
183-P+	18.3	10.1	4.07	6.03	0.7	30	18	●
184-P+	18.4	10.1	4.07	6.03	0.7	30	18	●
185-P+	18.5	10.1	4.08	6.02	0.7	30	18	●
186-P+	18.6	10.1	4.08	6.02	0.7	30	18	●
187-P+	18.7	10.1	4.08	6.02	0.7	30	18	●
188-P+	18.8	10.1	4.08	6.02	0.7	30	18	●
189-P+	18.9	10.1	4.08	6.02	0.7	30	18	●



► SSC: Seat size code

●: Standard items



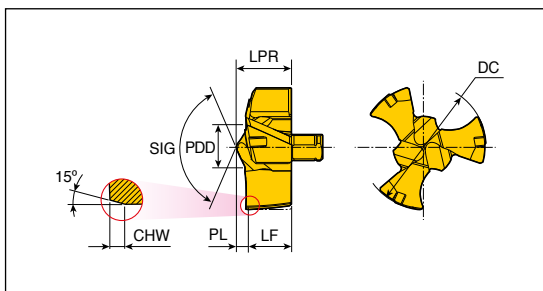
Designation	Dimension (mm)							Grade
	DC	LPR	PL	LF	CHW	KCH	SSC	TT5130
3ED- 190-P+	19.0	10.7	4.26	6.44	0.7	30	19	●
191-P+	19.1	10.7	4.26	6.44	0.7	30	19	●
192-P+	19.2	10.7	4.26	6.44	0.7	30	19	●
193-P+	19.3	10.7	4.26	6.44	0.7	30	19	●
194-P+	19.4	10.7	4.26	6.44	0.7	30	19	●
195-P+	19.5	10.7	4.27	6.43	0.7	30	19	●
196-P+	19.6	10.7	4.27	6.43	0.7	30	19	●
197-P+	19.7	10.7	4.27	6.43	0.7	30	19	●
198-P+	19.8	10.7	4.27	6.43	0.7	30	19	●
199-P+	19.9	10.7	4.27	6.43	0.7	30	19	●
200-P+	20.0	11.3	4.44	6.86	0.7	30	20	●
201-P+	20.1	11.3	4.44	6.86	0.7	30	20	●
202-P+	20.2	11.3	4.44	6.86	0.7	30	20	●
203-P+	20.3	11.3	4.44	6.86	0.7	30	20	●
204-P+	20.4	11.3	4.44	6.86	0.7	30	20	●
205-P+	20.5	11.3	4.45	6.85	0.7	30	20	●
206-P+	20.6	11.3	4.45	6.85	0.7	30	20	●
207-P+	20.7	11.3	4.45	6.85	0.7	30	20	●
208-P+	20.8	11.3	4.45	6.85	0.7	30	20	●
209-P+	20.9	11.3	4.45	6.85	0.7	30	20	●
210-P+	21.0	11.8	4.62	7.18	0.4	15	21	●
215-P+	21.5	11.8	4.64	7.16	0.4	15	21	●
220-P+	22.0	12.4	4.78	7.62	0.4	15	22	●
225-P+	22.5	12.4	4.80	7.60	0.4	15	22	●
230-P+	23.0	12.8	5.02	7.78	0.4	15	23	●
235-P+	23.5	12.8	5.04	7.76	0.4	15	23	●
240-P+	24.0	13.4	5.18	8.22	0.4	15	24	●
245-P+	24.5	13.4	5.20	8.20	0.4	15	24	●
250-P+	25.0	14.0	5.29	8.71	0.4	15	25	●
255-P+	25.5	14.0	5.31	8.69	0.4	15	25	●



► SSC: Seat size code

●: Standard items

3 flute drill heads for flat bottom hole



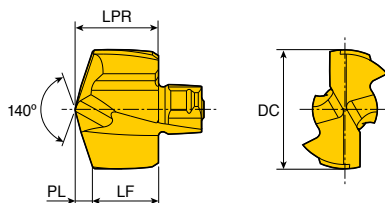
Designation	Dimension (mm)								Grade
	DC	LPR	PL	LF	PDD	SIG	CHW	SSC	TT5130
3ED- 120-F	12.0	5.14	1.18	3.96	3.38	133	0.4	12	●
125-F	12.5	5.14	1.20	3.94	3.38	133	0.4	12	●
130-F	13.0	5.61	1.22	4.39	3.58	132	0.4	13	●
135-F	13.5	5.61	1.24	4.37	3.58	132	0.4	13	●
140-F	14.0	6.01	1.28	4.73	4.01	133	0.4	14	●
145-F	14.5	6.01	1.30	4.71	4.01	133	0.4	14	●
150-F	15.0	6.38	1.32	5.06	4.16	133	0.4	15	●
155-F	15.5	6.38	1.34	5.04	4.16	133	0.4	15	●
160-F	16.0	6.86	1.38	5.48	4.52	134	0.4	16	●
165-F	16.5	6.86	1.40	5.46	4.52	134	0.4	16	●
170-F	17.0	7.22	1.45	5.77	4.79	134	0.4	17	●
175-F	17.5	7.22	1.47	5.75	4.79	134	0.4	17	●
180-F	18.0	7.93	1.75	6.18	5.96	133	0.4	18	●
185-F	18.5	7.93	1.77	6.16	5.96	133	0.4	18	●
190-F	19.0	8.41	1.83	6.58	6.32	133	0.4	19	●
195-F	19.5	8.41	1.85	6.56	6.32	133	0.4	19	●
200-F	20.0	8.89	1.90	6.99	6.61	133	0.4	20	●
205-F	20.5	8.89	1.92	6.97	6.61	133	0.4	20	●
210-F	21.0	9.17	1.99	7.18	7.01	133	0.4	21	●
215-F	21.5	9.17	2.01	7.16	7.01	133	0.4	21	●
220-F	22.0	9.72	2.10	7.62	7.30	133	0.4	22	●
225-F	22.5	9.72	2.12	7.60	7.30	133	0.4	22	●
230-F	23.0	9.96	2.18	7.78	7.49	132	0.4	23	●
235-F	23.5	9.96	2.20	7.76	7.49	132	0.4	23	●
240-F	24.0	10.46	2.24	8.22	7.81	132	0.4	24	●
245-F	24.5	10.46	2.26	8.20	7.81	132	0.4	24	●
250-F	25.0	11.03	2.31	8.72	8.16	132	0.4	25	●
255-F	25.5	11.03	2.33	8.70	8.16	132	0.4	25	●



► SSC: Seat size code

●: Standard items

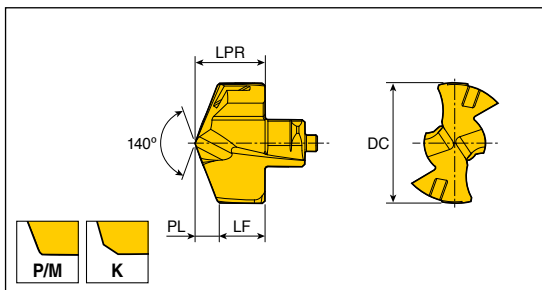
Drill heads

[illegible]

●: Standard items



Drill heads



Designation	Dimension (mm)					Grade
	DC	LPR	PL	LF	SSC	TT9080
TCD - 060-P/M/K	6.0	4.0	0.96	3.04	6	●
061-P/M/K	6.1	4.0	0.98	3.02	6	●
062-P/M/K	6.2	4.0	1.00	3.00	6	●
063-P/M/K	6.3	4.0	1.01	2.99	6	●
064-P/M/K	6.4	4.0	1.03	2.97	6	●
065-P/M/K	6.5	4.3	1.18	3.12	6.5	●
066-P/M/K	6.6	4.3	1.20	3.10	6.5	●
067-P/M/K	6.7	4.3	1.22	3.08	6.5	●
068-P/M/K	6.8	4.3	1.23	3.07	6.5	●
069-P/M/K	6.9	4.3	1.25	3.05	6.5	●
070-P/M/K	7.0	4.6	1.01	3.59	7	●
071-P/M/K	7.1	4.6	1.03	3.57	7	●
072-P/M/K	7.2	4.6	1.05	3.55	7	●
073-P/M/K	7.3	4.6	1.06	3.54	7	●
074-P/M/K	7.4	4.6	1.08	3.52	7	●
075-P/M/K	7.5	4.6	1.10	3.50	7	●
076-P/M/K	7.6	4.6	1.12	3.48	7	●
077-P/M/K	7.7	4.6	1.14	3.46	7	●
078-P/M/K	7.8	4.6	1.16	3.44	7	●
079-P/M/K	7.9	4.6	1.17	3.43	7	●
080-P/M/K	8.0	5.4	1.20	4.20	8	●
081-P/M/K	8.1	5.4	1.22	4.18	8	●
082-P/M/K	8.2	5.4	1.24	4.16	8	●
083-P/M/K	8.3	5.4	1.25	4.15	8	●
084-P/M/K	8.4	5.4	1.27	4.13	8	●
085-P/M/K	8.5	5.4	1.29	4.11	8	●
086-P/M/K	8.6	5.4	1.31	4.09	8	●
087-P/M/K	8.7	5.4	1.33	4.07	8	●
088-P/M/K	8.8	5.4	1.35	4.05	8	●
089-P/M/K	8.9	5.4	1.36	4.04	8	●
090-P/M/K	9.0	5.8	1.35	4.45	9	●
091-P/M/K	9.1	5.8	1.37	4.43	9	●
092-P/M/K	9.2	5.8	1.39	4.41	9	●
093-P/M/K	9.3	5.8	1.40	4.40	9	●
094-P/M/K	9.4	5.8	1.42	4.38	9	●



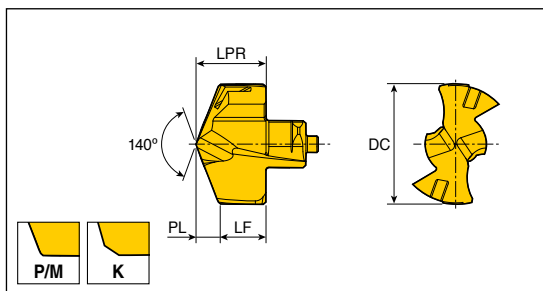
► Drill head can be ordered by an application
Order example) Diameter 10.0mm drill head for
 ISO P application: TCD-100-P TT9080

●: Standard items



Steel Stainless steel Cast iron

Drill heads



Designation	Dimension (mm)					Grade
	DC	LPR	PL	LF	SSC	TT9080
TCD - 095-P/M/K	9.5	5.8	1.44	4.36	9	●
096-P/M/K	9.6	5.8	1.46	4.34	9	●
097-P/M/K	9.7	5.8	1.48	4.32	9	●
098-P/M/K	9.8	5.8	1.50	4.30	9	●
099-P/M/K	9.9	5.8	1.51	4.29	9	●
100-P/M/K	10.0	6.2	1.50	4.70	10	●
101-P/M/K	10.1	6.2	1.52	4.68	10	●
102-P/M/K	10.2	6.2	1.54	4.66	10	●
103-P/M/K	10.3	6.2	1.55	4.65	10	●
104-P/M/K	10.4	6.2	1.57	4.63	10	●
105-P/M/K	10.5	6.2	1.59	4.61	10	●
106-P/M/K	10.6	6.2	1.61	4.59	10	●
107-P/M/K	10.7	6.2	1.63	4.57	10	●
108-P/M/K	10.8	6.2	1.65	4.55	10	●
109-P/M/K	10.9	6.2	1.66	4.54	10	●
110-P/M/K	11.0	6.6	1.67	4.93	11	●
111-P/M/K	11.1	6.6	1.69	4.91	11	●
112-P/M/K	11.2	6.6	1.71	4.89	11	●
113-P/M/K	11.3	6.6	1.72	4.88	11	●
114-P/M/K	11.4	6.6	1.74	4.86	11	●
115-P/M/K	11.5	6.6	1.76	4.84	11	●
116-P/M/K	11.6	6.6	1.78	4.82	11	●
117-P/M/K	11.7	6.6	1.80	4.80	11	●
118-P/M/K	11.8	6.6	1.82	4.78	11	●
119-P/M/K	11.9	6.6	1.83	4.77	11	●
120-P/M/K	12.0	7.0	1.82	5.18	12	●
121-P/M/K	12.1	7.0	1.84	5.16	12	●
122-P/M/K	12.2	7.0	1.86	5.14	12	●
123-P/M/K	12.3	7.0	1.87	5.13	12	●
124-P/M/K	12.4	7.0	1.89	5.11	12	●
125-P/M/K	12.5	7.0	1.91	5.09	12	●
126-P/M/K	12.6	7.0	1.93	5.07	12	●
127-P/M/K	12.7	7.0	1.95	5.05	12	●
128-P/M/K	12.8	7.0	1.97	5.03	12	●
129-P/M/K	12.9	7.0	1.98	5.02	12	●



► Drill head can be ordered by an application
Order example) Diameter 10.0mm drill head for
 ISO P application: TCD-100-P TT9080

●: Standard items



Steel

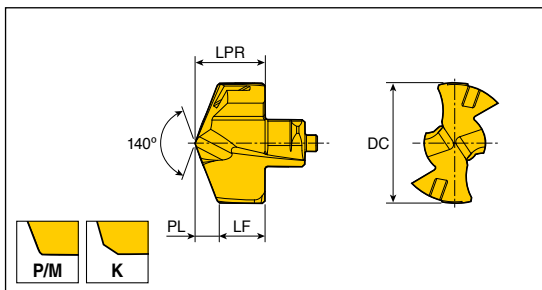


Stainless steel



Cast iron

Drill heads



Designation	Dimension (mm)					Grade
	DC	LPR	PL	LF	SSC	TT9080
TCD - 130-P/M/K	13.0	7.6	1.96	5.64	13	●
131-P/M/K	13.1	7.6	1.98	5.62	13	●
132-P/M/K	13.2	7.6	2.00	5.60	13	●
133-P/M/K	13.3	7.6	2.01	5.59	13	●
134-P/M/K	13.4	7.6	2.03	5.57	13	●
135-P/M/K	13.5	7.6	2.05	5.55	13	●
136-P/M/K	13.6	7.6	2.07	5.53	13	●
137-P/M/K	13.7	7.6	2.09	5.51	13	●
138-P/M/K	13.8	7.6	2.11	5.49	13	●
139-P/M/K	13.9	7.6	2.12	5.48	13	●
140-P/M/K	14.0	8.1	2.12	5.98	14	●
141-P/M/K	14.1	8.1	2.14	5.96	14	●
142-P/M/K	14.2	8.1	2.16	5.94	14	●
143-P/M/K	14.3	8.1	2.17	5.93	14	●
144-P/M/K	14.4	8.1	2.19	5.91	14	●
145-P/M/K	14.5	8.1	2.21	5.89	14	●
146-P/M/K	14.6	8.1	2.23	5.87	14	●
147-P/M/K	14.7	8.1	2.25	5.85	14	●
148-P/M/K	14.8	8.1	2.27	5.83	14	●
149-P/M/K	14.9	8.1	2.28	5.82	14	●
150-P/M/K	15.0	8.7	2.27	6.43	15	●
151-P/M/K	15.1	8.7	2.29	6.41	15	●
152-P/M/K	15.2	8.7	2.31	6.39	15	●
153-P/M/K	15.3	8.7	2.32	6.38	15	●
154-P/M/K	15.4	8.7	2.34	6.36	15	●
155-P/M/K	15.5	8.7	2.36	6.34	15	●
156-P/M/K	15.6	8.7	2.38	6.32	15	●
157-P/M/K	15.7	8.7	2.40	6.30	15	●
158-P/M/K	15.8	8.7	2.42	6.28	15	●
159-P/M/K	15.9	8.7	2.43	6.27	15	●
160-P/M/K	16.0	9.3	2.42	6.88	16	●
161-P/M/K	16.1	9.3	2.44	6.86	16	●
162-P/M/K	16.2	9.3	2.46	6.84	16	●
163-P/M/K	16.3	9.3	2.47	6.83	16	●
164-P/M/K	16.4	9.3	2.49	6.81	16	●



► Drill head can be ordered by an application
Order example) Diameter 10.0mm drill head for
 ISO P application: TCD-100-P TT9080

●: Standard items

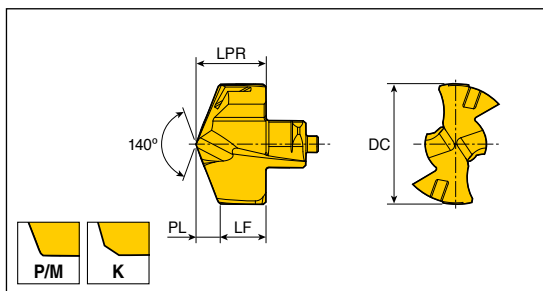


Stainless steel



Cast iron

Drill heads



Designation	Dimension (mm)					Grade
	DC	LPR	PL	LF	SSC	TT9080
TCD - 165-P/M/K	16.5	9.3	2.51	6.79	16	●
166-P/M/K	16.6	9.3	2.53	6.77	16	●
167-P/M/K	16.7	9.3	2.55	6.75	16	●
168-P/M/K	16.8	9.3	2.57	6.73	16	●
169-P/M/K	16.9	9.3	2.58	6.72	16	●
170-P/M/K	17.0	9.9	2.59	7.31	17	●
171-P/M/K	17.1	9.9	2.61	7.29	17	●
172-P/M/K	17.2	9.9	2.63	7.27	17	●
173-P/M/K	17.3	9.9	2.64	7.26	17	●
174-P/M/K	17.4	9.9	2.66	7.24	17	●
175-P/M/K	17.5	9.9	2.68	7.22	17	●
176-P/M/K	17.6	9.9	2.70	7.20	17	●
177-P/M/K	17.7	9.9	2.72	7.18	17	●
178-P/M/K	17.8	9.9	2.74	7.16	17	●
179-P/M/K	17.9	9.9	2.75	7.15	17	●
180-P/M/K	18.0	10.5	2.73	7.77	18	●
181-P/M/K	18.1	10.5	2.75	7.75	18	●
182-P/M/K	18.2	10.5	2.77	7.73	18	●
183-P/M/K	18.3	10.5	2.78	7.72	18	●
184-P/M/K	18.4	10.5	2.80	7.70	18	●
185-P/M/K	18.5	10.5	2.82	7.68	18	●
186-P/M/K	18.6	10.5	2.84	7.66	18	●
187-P/M/K	18.7	10.5	2.86	7.64	18	●
188-P/M/K	18.8	10.5	2.88	7.62	18	●
189-P/M/K	18.9	10.5	2.89	7.61	18	●
190-P/M/K	19.0	11.0	2.88	8.12	19	●
191-P/M/K	19.1	11.0	2.90	8.10	19	●
192-P/M/K	19.2	11.0	2.92	8.08	19	●
193-P/M/K	19.3	11.0	2.93	8.07	19	●
194-P/M/K	19.4	11.0	2.95	8.05	19	●
195-P/M/K	19.5	11.0	2.97	8.03	19	●
196-P/M/K	19.6	11.0	2.99	8.01	19	●
197-P/M/K	19.7	11.0	3.01	7.99	19	●
198-P/M/K	19.8	11.0	3.03	7.97	19	●
199-P/M/K	19.9	11.0	3.04	7.96	19	●



► Drill head can be ordered by an application
Order example) Diameter 10.0mm drill head for
 ISO P application: TCD-100-P TT9080

●: Standard items



Steel

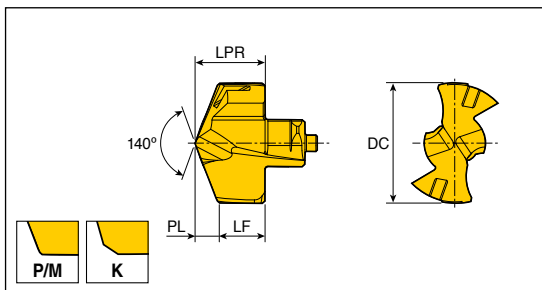


Stainless steel



Cast iron

Drill heads



Designation	Dimension (mm)					Grade
	DC	LPR	PL	LF	SSC	TT9080
TCD - 200-P/M/K	20.0	11.6	3.02	8.58	20	●
201-P/M/K	20.1	11.6	3.04	8.56	20	●
202-P/M/K	20.2	11.6	3.06	8.54	20	●
203-P/M/K	20.3	11.6	3.07	8.53	20	●
204-P/M/K	20.4	11.6	3.09	8.51	20	●
205-P/M/K	20.5	11.6	3.11	8.49	20	●
206-P/M/K	20.6	11.6	3.13	8.47	20	●
207-P/M/K	20.7	11.6	3.15	8.45	20	●
208-P/M/K	20.8	11.6	3.17	8.43	20	●
209-P/M/K	20.9	11.6	3.18	8.42	20	●
210-P/M/K	21.0	12.1	3.18	8.92	21	●
211-P/M/K	21.1	12.1	3.20	8.90	21	●
212-P/M/K	21.2	12.1	3.22	8.88	21	●
213-P/M/K	21.3	12.1	3.23	8.87	21	●
214-P/M/K	21.4	12.1	3.25	8.85	21	●
215-P/M/K	21.5	12.1	3.27	8.83	21	●
216-P/M/K	21.6	12.1	3.29	8.81	21	●
217-P/M/K	21.7	12.1	3.31	8.79	21	●
218-P/M/K	21.8	12.1	3.33	8.77	21	●
219-P/M/K	21.9	12.1	3.34	8.76	21	●
220-P/M/K	22.0	12.7	3.24	9.46	22	●
221-P/M/K	22.1	12.7	3.26	9.44	22	●
222-P/M/K	22.2	12.7	3.28	9.42	22	●
223-P/M/K	22.3	12.7	3.29	9.41	22	●
224-P/M/K	22.4	12.7	3.31	9.39	22	●
225-P/M/K	22.5	12.7	3.33	9.37	22	●
226-P/M/K	22.6	12.7	3.35	9.35	22	●
227-P/M/K	22.7	12.7	3.37	9.33	22	●
228-P/M/K	22.8	12.7	3.39	9.31	22	●
229-P/M/K	22.9	12.7	3.40	9.30	22	●
230-P/M/K	23.0	13.3	3.46	9.84	23	●
231-P/M/K	23.1	13.3	3.48	9.82	23	●
232-P/M/K	23.2	13.3	3.50	9.80	23	●
233-P/M/K	23.3	13.3	3.51	9.79	23	●
234-P/M/K	23.4	13.3	3.53	9.77	23	●



D59-D74



D125

► Drill head can be ordered by an application
Order example) Diameter 10.0mm drill head for
 ISO P application: TCD-100-P TT9080

●: Standard items



Steel



Stainless steel

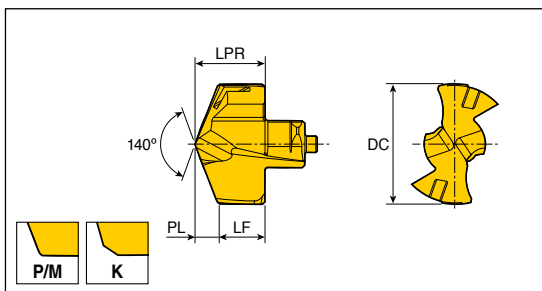


Cast iron

TCD...P/M/K



Drill heads

[illegible]

- ▶ Drill head can be ordered by an application
Order example) Diameter 10.0mm drill head for
ISO P application: TCD-100-P TT9080

●: Standard items



Stee



Stainless steel

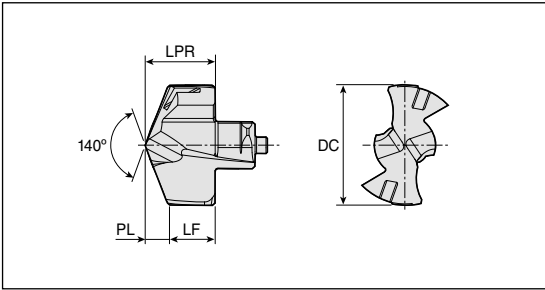


Cast iron

TCD...N



Drill heads for aluminum alloy



Designation	Dimension (mm)					Grade
	DC	LPR	PL	LF	SSC	UF10
TCD - 060-N	6.0	4.00	0.96	3.04	6	●
065-N	6.5	4.30	1.18	3.12	6.5	●
070-N	7.0	4.60	1.01	3.59	7	●
075-N	7.5	4.60	1.10	3.50	7	●
080-N	8.0	5.40	1.20	4.20	8	●
085-N	8.5	5.40	1.29	4.11	8	●
090-N	9.0	5.80	1.35	4.45	9	●
095-N	9.5	5.80	1.44	4.36	9	●
100-N	10.0	6.20	1.50	4.70	10	●
105-N	10.5	6.20	1.59	4.61	10	●
110-N	11.0	6.60	1.67	4.93	11	●
115-N	11.5	6.60	1.76	4.84	11	●
120-N	12.0	7.00	1.82	5.18	12	●
125-N	12.5	7.00	1.91	5.09	12	●
130-N	13.0	7.60	1.96	5.64	13	●
135-N	13.5	7.60	2.05	5.55	13	●
140-N	14.0	8.15	2.12	6.03	14	●
145-N	14.5	8.15	2.21	5.94	14	●
150-N	15.0	8.73	2.27	6.46	15	●
155-N	15.5	8.73	2.36	6.37	15	●
160-N	16.0	9.30	2.42	6.88	16	●
165-N	16.5	9.30	2.51	6.79	16	●
170-N	17.0	9.90	2.59	7.31	17	●
175-N	17.5	9.90	2.68	7.22	17	●
180-N	18.0	10.50	2.73	7.77	18	●
185-N	18.5	10.50	2.82	7.68	18	●
190-N	19.0	11.00	2.88	8.12	19	●
195-N	19.5	11.00	2.97	8.03	19	●



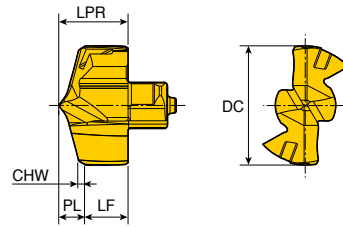
► SSC: Seat size code

●: Standard items

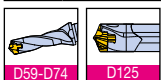
N Nonferrous



Self-centering drill heads



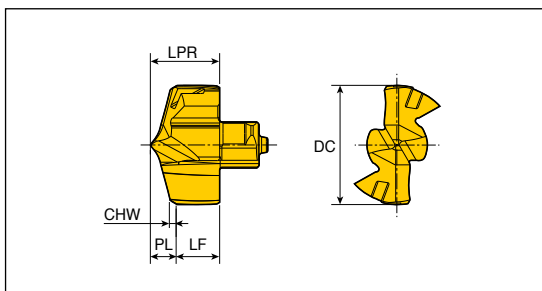
Designation	Dimension (mm)						Grade
	DC	LPR	PL	LF	CHW	SSC	
TCD-060-P+	6.0	4.00	1.46	2.54	0.5	6	●
065-P+	6.5	4.30	1.55	2.75	0.5	6.5	●
068-P+	6.8	4.30	1.59	2.71	0.5	6.5	●
070-P+	7.0	4.60	1.64	2.96	0.5	7	●
072-P+	7.2	4.60	1.67	2.93	0.5	7	●
075-P+	7.5	4.60	1.71	2.89	0.5	7	●
080-P+	8.0	5.40	1.81	3.59	0.5	8	●
081-P+	8.1	5.40	1.82	3.58	0.5	8	●
082-P+	8.2	5.40	1.84	3.56	0.5	8	●
083-P+	8.3	5.40	1.85	3.55	0.5	8	●
085-P+	8.5	5.40	1.88	3.52	0.5	8	●
086-P+	8.6	5.40	1.89	3.51	0.5	8	●
087-P+	8.7	5.40	1.90	3.50	0.5	8	●
088-P+	8.8	5.40	1.92	3.48	0.5	8	●
089-P+	8.9	5.40	1.93	3.47	0.5	8	●
090-P+	9.0	5.80	1.98	3.82	0.5	9	●
093-P+	9.3	5.80	2.02	3.78	0.5	9	●
095-P+	9.5	5.80	2.05	3.75	0.5	9	●
096-P+	9.6	5.80	2.06	3.74	0.5	9	●
097-P+	9.7	5.80	2.07	3.73	0.5	9	●
098-P+	9.8	5.80	2.09	3.71	0.5	9	●
099-P+	9.9	5.80	2.10	3.70	0.5	9	●
100-P+	10.0	6.20	2.33	3.87	0.7	10	●
101-P+	10.1	6.20	2.34	3.86	0.7	10	●
102-P+	10.2	6.20	2.36	3.84	0.7	10	●
103-P+	10.3	6.20	2.37	3.83	0.7	10	●
105-P+	10.5	6.20	2.40	3.80	0.7	10	●
106-P+	10.6	6.20	2.41	3.79	0.7	10	●
107-P+	10.7	6.20	2.42	3.78	0.7	10	●
108-P+	10.8	6.20	2.44	3.76	0.7	10	●
109-P+	10.9	6.20	2.45	3.75	0.7	10	●
110-P+	11.0	6.60	2.50	4.10	0.7	11	●
111-P+	11.1	6.60	2.51	4.09	0.7	11	●
112-P+	11.2	6.60	2.53	4.07	0.7	11	●
113-P+	11.3	6.60	2.54	4.06	0.7	11	●



► SSC: Seat size code

●: Standard items

Self-centering drill heads



Designation	Dimension (mm)						Grade
	DC	LPR	PL	LF	CHW	SSC	TT9080
TCD-114-P+	11.4	6.60	2.55	4.05	0.7	11	●
115-P+	11.5	6.60	2.57	4.03	0.7	11	●
116-P+	11.6	6.60	2.58	4.02	0.7	11	●
117-P+	11.7	6.60	2.59	4.01	0.7	11	●
118-P+	11.8	6.60	2.61	3.99	0.7	11	●
119-P+	11.9	6.60	2.62	3.98	0.7	11	●
120-P+	12.0	7.00	2.67	4.33	0.7	12	●
121-P+	12.1	7.00	2.68	4.32	0.7	12	●
122-P+	12.2	7.00	2.70	4.30	0.7	12	●
123-P+	12.3	7.00	2.71	4.29	0.7	12	●
124-P+	12.4	7.00	2.72	4.28	0.7	12	●
125-P+	12.5	7.00	2.74	4.26	0.7	12	●
126-P+	12.6	7.00	2.75	4.25	0.7	12	●
127-P+	12.7	7.00	2.76	4.24	0.7	12	●
128-P+	12.8	7.00	2.78	4.22	0.7	12	●
130-P+	13.0	7.60	2.85	4.75	0.7	13	●
131-P+	13.1	7.60	2.86	4.74	0.7	13	●
132-P+	13.2	7.60	2.88	4.72	0.7	13	●
133-P+	13.3	7.60	2.89	4.71	0.7	13	●
134-P+	13.4	7.60	2.90	4.70	0.7	13	●
135-P+	13.5	7.60	2.92	4.68	0.7	13	●
136-P+	13.6	7.60	2.93	4.67	0.7	13	●
137-P+	13.7	7.60	2.94	4.66	0.7	13	●
138-P+	13.8	7.60	2.96	4.64	0.7	13	●
139-P+	13.9	7.60	2.97	4.63	0.7	13	●
140-P+	14.0	8.15	3.02	5.13	0.7	14	●
141-P+	14.1	8.15	3.03	5.12	0.7	14	●
142-P+	14.2	8.15	3.05	5.10	0.7	14	●
143-P+	14.3	8.15	3.06	5.09	0.7	14	●
144-P+	14.4	8.15	3.07	5.08	0.7	14	●
145-P+	14.5	8.15	3.09	5.06	0.7	14	●
146-P+	14.6	8.15	3.10	5.05	0.7	14	●
147-P+	14.7	8.15	3.11	5.04	0.7	14	●
148-P+	14.8	8.15	3.13	5.02	0.7	14	●
150-P+	15.0	8.73	3.19	5.54	0.7	15	●



D59-D74

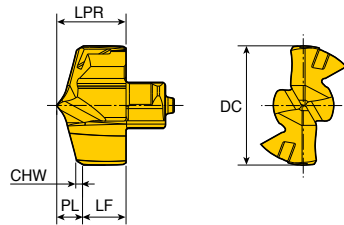


D125

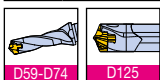
► SSC: Seat size code

●: Standard items

Self-centering drill heads



Designation	Dimension (mm)						Grade
	DC	LPR	PL	LF	CHW	SSC	
TCD- 151-P+	15.1	8.73	3.20	5.53	0.7	15	●
152-P+	15.2	8.73	3.22	5.51	0.7	15	●
153-P+	15.3	8.73	3.23	5.50	0.7	15	●
154-P+	15.4	8.73	3.24	5.49	0.7	15	●
155-P+	15.5	8.73	3.26	5.47	0.7	15	●
156-P+	15.6	8.73	3.27	5.46	0.7	15	●
157-P+	15.7	8.73	3.28	5.45	0.7	15	●
158-P+	15.8	8.73	3.30	5.43	0.7	15	●
159-P+	15.9	8.73	3.31	5.42	0.7	15	●
160-P+	16.0	9.30	3.46	5.84	0.81	16	●
161-P+	16.1	9.30	3.47	5.83	0.81	16	●
162-P+	16.2	9.30	3.49	5.81	0.81	16	●
163-P+	16.3	9.30	3.50	5.80	0.81	16	●
164-P+	16.4	9.30	3.51	5.79	0.81	16	●
165-P+	16.5	9.30	3.53	5.77	0.81	16	●
166-P+	16.6	9.30	3.54	5.76	0.81	16	●
167-P+	16.7	9.30	3.55	5.75	0.81	16	●
168-P+	16.8	9.30	3.57	5.73	0.81	16	●
170-P+	17.0	9.90	3.63	6.27	0.81	17	●
171-P+	17.1	9.90	3.64	6.26	0.81	17	●
172-P+	17.2	9.90	3.66	6.24	0.81	17	●
173-P+	17.3	9.90	3.67	6.23	0.81	17	●
174-P+	17.4	9.90	3.68	6.22	0.81	17	●
175-P+	17.5	9.90	3.70	6.20	0.81	17	●
176-P+	17.6	9.90	3.71	6.19	0.81	17	●
177-P+	17.7	9.90	3.72	6.18	0.81	17	●
178-P+	17.8	9.90	3.74	6.16	0.81	17	●
179-P+	17.9	9.90	3.75	6.15	0.81	17	●
180-P+	18.0	10.50	3.81	6.69	0.81	18	●
181-P+	18.1	10.50	3.82	6.68	0.81	18	●
182-P+	18.2	10.50	3.84	6.66	0.81	18	●
183-P+	18.3	10.50	3.85	6.65	0.81	18	●
185-P+	18.5	10.50	3.88	6.62	0.81	18	●
186-P+	18.6	10.50	3.89	6.61	0.81	18	●
187-P+	18.7	10.50	3.90	6.60	0.81	18	●

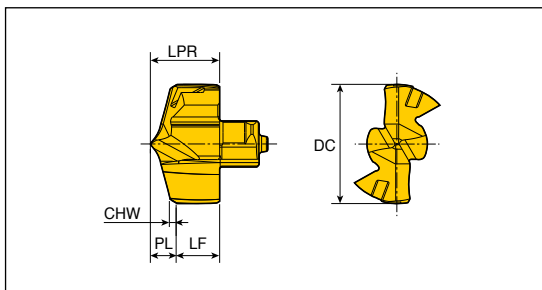


► SSC: Seat size code

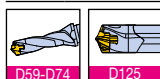
●: Standard items

TCD-P+

Self-centering drill heads



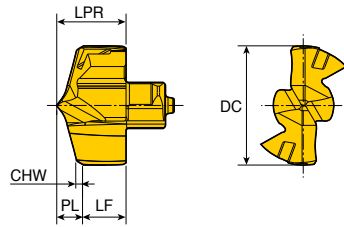
Designation	Dimension (mm)						Grade
	DC	LPR	PL	LF	CHW	SSC	TT9080
TCD-188-P+	18.8	10.50	3.92	6.58	0.81	18	●
190-P+	19.0	11.00	3.98	7.02	0.81	19	●
191-P+	19.1	11.00	3.99	7.01	0.81	19	●
192-P+	19.2	11.00	4.01	6.99	0.81	19	●
193-P+	19.3	11.00	4.02	6.98	0.81	19	●
194-P+	19.4	11.00	4.03	6.97	0.81	19	●
195-P+	19.5	11.00	4.05	6.95	0.81	19	●
196-P+	19.6	11.00	4.06	6.94	0.81	19	●
197-P+	19.7	11.00	4.07	6.93	0.81	19	●
198-P+	19.8	11.00	4.09	6.91	0.81	19	●
199-P+	19.9	11.00	4.10	6.90	0.81	19	●
200-P+	20.0	11.60	4.15	7.45	0.81	20	●
201-P+	20.1	11.60	4.16	7.44	0.81	20	●
202-P+	20.2	11.60	4.18	7.42	0.81	20	●
205-P+	20.5	11.60	4.22	7.38	0.81	20	●
206-P+	20.6	11.60	4.23	7.37	0.81	20	●
207-P+	20.7	11.60	4.24	7.36	0.81	20	●
210-P+	21.0	12.18	4.32	7.86	0.81	21	●
212-P+	21.2	12.18	4.35	7.83	0.81	21	●
213-P+	21.3	12.18	4.36	7.82	0.81	21	●
214-P+	21.4	12.18	4.37	7.81	0.81	21	●
215-P+	21.5	12.18	4.39	7.79	0.81	21	●
218-P+	21.8	12.18	4.43	7.75	0.81	21	●
220-P+	22.0	12.76	4.50	8.26	0.81	22	●
225-P+	22.5	12.76	4.57	8.19	0.81	22	●
229-P+	22.9	12.76	4.62	8.14	0.81	22	●
230-P+	23.0	13.33	4.67	8.66	0.81	23	●
235-P+	23.5	13.33	4.74	8.59	0.81	23	●
240-P+	24.0	13.90	4.84	9.06	0.81	24	●
245-P+	24.5	13.90	4.91	8.99	0.81	24	●
250-P+	25.0	14.50	5.01	9.49	0.81	25	●
254-P+	25.4	14.50	5.06	9.44	0.81	25	●
255-P+	25.5	14.50	5.08	9.42	0.81	25	●
256-P+	25.6	14.50	5.09	9.41	0.81	25	●
257-P+	25.7	14.50	5.10	9.40	0.81	25	●



► SSC: Seat size code

●: Standard items

Self-centering drill heads

[illegible]

D59-D74



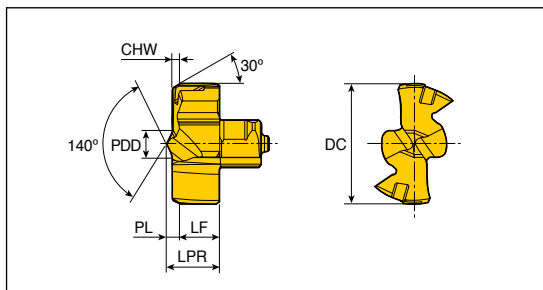
D125

► SSC: Seat size code

●: Standard items

TCD...F

Drill heads for flat bottom hole



Designation	Dimension (mm)							Grade
	DC	PDD	LPR	PL	LF	CHW	SSC	TT9080
TCD - 080-F	8.0	2.33	4.4	1.09	3.3	0.7	8	●
085-F	8.5	2.33	4.4	1.09	3.3	0.7	8	●
090-F	9.0	2.29	4.6	1.11	3.5	0.7	9	●
095-F	9.5	2.29	4.6	1.11	3.5	0.7	9	●
100-F	10.0	2.44	4.9	1.17	3.7	0.7	10	●
105-F	10.5	2.44	4.9	1.17	3.7	0.7	10	●
110-F	11.0	3.09	5.1	1.25	3.8	0.7	11	●
115-F	11.5	3.09	5.1	1.25	3.8	0.7	11	●
120-F	12.0	2.95	5.4	1.26	4.1	0.7	12	●
125-F	12.5	2.95	5.4	1.26	4.1	0.7	12	●
130-F	13.0	3.04	5.7	1.30	4.4	0.7	13	●
135-F	13.5	3.04	5.7	1.30	4.4	0.7	13	●
140-F	14.0	3.30	6.1	1.31	4.8	0.7	14	●
145-F	14.5	3.30	6.1	1.31	4.8	0.7	14	●
150-F	15.0	3.54	6.6	1.35	5.23	0.7	15	●
155-F	15.5	3.54	6.6	1.35	5.23	0.7	15	●
160-F	16.0	3.74	7.0	1.39	5.6	0.7	16	●
165-F	16.5	3.74	7.0	1.39	5.6	0.7	16	●
170-F	17.0	3.75	7.3	1.40	5.9	0.7	17	●
175-F	17.5	3.75	7.3	1.40	5.9	0.7	17	●
180-F	18.0	3.85	7.6	1.42	6.18	0.7	18	●
185-F	18.5	3.85	7.6	1.42	6.18	0.7	18	●
190-F	19.0	3.86	7.9	1.44	6.5	0.7	19	●
195-F	19.5	3.86	7.9	1.44	6.5	0.7	19	●
200-F	20.0	6.76	9.3	1.77	7.5	0.7	20	●
205-F	20.5	6.76	9.3	1.77	7.5	0.7	20	●
210-F	21.0	6.98	9.7	1.79	7.9	0.7	21	●
215-F	21.5	6.98	9.7	1.79	7.9	0.7	21	●
220-F	22.0	7.42	10.0	1.81	8.2	0.7	22	●
225-F	22.5	7.42	10.0	1.81	8.2	0.7	22	●
230-F	23.0	7.60	10.4	1.83	8.6	0.7	23	●
235-F	23.5	7.60	10.4	1.83	8.6	0.7	23	●
240-F	24.0	8.13	10.9	1.86	9.0	0.7	24	●
245-F	24.5	8.13	10.9	1.86	9.0	0.7	24	●
250-F	25.0	8.16	11.3	1.89	9.4	0.7	25	●



D59-D74

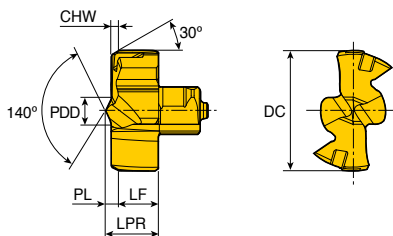


D125

► SSC: Seat size code

●: Standard items

Drill heads for flat bottom hole

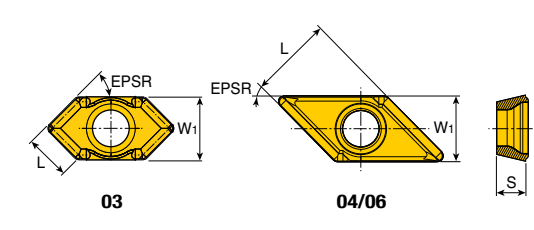


D59-D74

D125

●: Standard items

Chamfering inserts for pre-thread hole



Size	Dimension (mm)			
	W1	L	S	EPSR
03-C30	4.0	4.00	1.59	30
03-C45	4.0	2.80	1.59	45
04-C45	3.6	5.20	1.80	45
06-C45	4.5	5.66	1.96	45

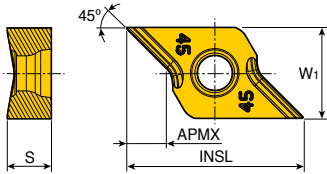
Insert	Designation	Coated						Uncoated	
		TT9080	TT9030	TT8020	TT6030	TT9300	TT7400	K10	
	AOMT 030204-C30	•							
	030204-C45	•							
	AOMT 040204-C45	•							
	060204-C45	•							



•: Standard items

CRNG 0802-45CD

Chamfering inserts for chamfering ring



Size	Dimension (mm)			
	W1	INSL	S	APMX
08	7.5	14.80	3.65	3.3

Insert	Designation	Coated						Uncoated	
		TT9080	TT9030	TT8020	TT6030	TT9300	TT7400	K10	
	CRNG 0802-45CD	•							

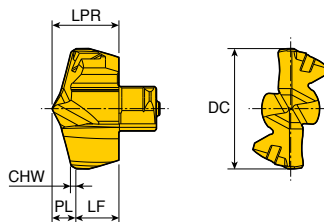


•: Standard items

TCD...P-CO+



Drill heads



Designation	Dimension (mm)						Grade
	DC	LPR	PL	LF	CHW	SSC	TT9080
TCD- 159-P-CO+	15.9	8.73	3.17	5.56	0.7	15	●
169-P-CO+	16.9	9.30	3.34	5.96	0.81	16	●
179-P-CO+	17.9	9.90	3.50	6.40	0.81	17	●
189-P-CO+	18.9	10.50	3.66	6.84	0.81	18	●
199-P-CO+	19.9	11.00	3.82	7.18	0.81	19	●
209-P-CO+	20.9	11.60	3.98	7.62	0.81	20	●
219-P-CO+	21.9	12.18	4.15	8.03	0.81	21	●
229-P-CO+	22.9	12.76	4.31	8.45	0.81	22	●
239-P-CO+	23.9	13.33	4.48	8.85	0.81	23	●
249-P-CO+	24.9	13.90	4.64	9.26	0.81	24	●
259-P-CO+	25.9	14.50	4.81	9.69	0.81	25	●



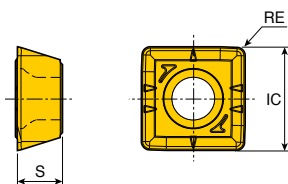
► SSC: Seat size code

●: Standard items

SPGX...DW



Inserts



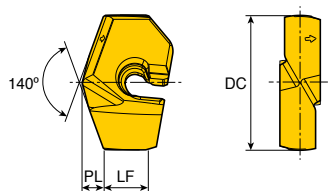
Size	Dimension (mm)			
	IC	S	RE	
06	6.07	2.38	0.4	
07	8.02	3.97	0.8	
09	9.91	4.30	0.8	
11	11.62	4.80	0.8	
14	14.41	5.20	1.2	

Insert	Designation	Coated						Uncoated	
		TT9080	TT8020	TT9300	TT9030	TT6030	TT7400	K10	
	SPGX 060204 DW	●							
	07T308 DW	●							
	090408 DW	●							
	110408 DW	●							
	140512 DW	●							



●: Standard items

Drill heads



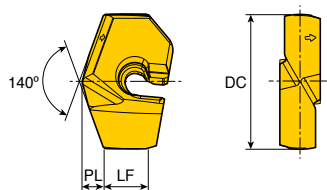
Designation	Dimension (mm)				Grade
	DC	PL	LF	SSC	TT9080
LCD- 200-P	20.0	3.11	6.54	20	●
205-P	20.5	3.20	6.45	20	●
210-P	21.0	3.29	6.36	21	●
215-P	21.5	3.38	6.27	21	●
220-P	22.0	3.42	7.12	22	●
225-P	22.5	3.51	7.03	22	●
230-P	23.0	3.60	6.94	23	●
235-P	23.5	3.69	6.85	23	●
240-P	24.0	3.73	7.03	24	●
245-P	24.5	3.82	6.94	24	●
250-P	25.0	3.91	6.85	25	●
255-P	25.5	4.00	6.76	25	●
260-P	26.0	4.04	7.51	26	●
265-P	26.5	4.13	7.42	26	●
270-P	27.0	4.22	7.33	27	●
275-P	27.5	4.31	7.24	27	●
280-P	28.0	4.35	7.39	28	●
285-P	28.5	4.44	7.30	28	●
290-P	29.0	4.53	7.21	29	●
295-P	29.5	4.62	7.12	29	●
300-P	30.0	4.67	9.47	30	●
305-P	30.5	4.76	9.38	30	●
310-P	31.0	4.85	9.29	31	●
315-P	31.5	4.94	9.20	31	●
320-P	32.0	4.98	9.55	32	●
325-P	32.5	5.07	9.46	32	●
330-P	33.0	5.16	9.37	33	●
335-P	33.5	5.25	9.28	33	●
340-P	34.0	5.34	9.19	34	●
345-P	34.5	5.44	9.10	34	●
350-P	35.0	5.44	11.12	35	●
355-P	35.5	5.53	11.03	35	●
360-P	36.0	5.62	10.94	36	●
365-P	36.5	5.71	10.85	36	●
370-P	37.0	5.80	10.76	37	●



► SSC: Seat size code

●: Standard items

Drill heads



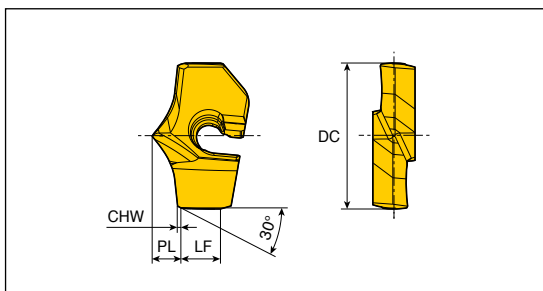
D80-D82

●: Standard items

LCD...-P+



Self-centering drill head



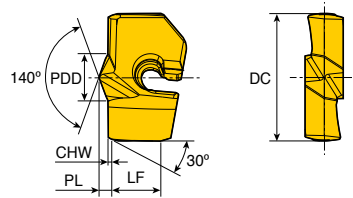
Designation	Dimension (mm)					Grade TT9080
	DC	PL	LF	CHW	SSC	
LCD- 200-P+	20.0	4.55	5.83	0.86	20	●
205-P+	20.5	4.58	5.60	0.86	20	●
210-P+	21.0	4.60	5.36	0.86	21	●
215-P+	21.5	4.63	5.13	0.86	21	●
220-P+	22.0	4.92	6.21	0.86	22	●
225-P+	22.5	4.95	5.98	0.86	22	●
230-P+	23.0	4.97	5.74	0.86	23	●
235-P+	23.5	5.00	5.51	0.86	23	●
240-P+	24.0	5.30	5.93	0.86	24	●
245-P+	24.5	5.33	5.70	0.86	24	●
250-P+	25.0	5.35	5.46	0.86	25	●
255-P+	25.5	5.38	5.23	0.86	25	●
260-P+	26.0	5.67	7.39	0.86	26	●
265-P+	26.5	5.70	7.16	0.86	26	●
270-P+	27.0	5.72	6.92	0.86	27	●
275-P+	27.5	5.75	6.69	0.86	27	●
280-P+	28.0	5.73	7.26	0.86	28	●
285-P+	28.5	5.76	7.03	0.86	28	●
290-P+	29.0	5.78	6.79	0.86	29	●
295-P+	29.5	5.81	6.56	0.86	29	●
300-P+	30.0	6.08	9.17	0.86	30	●
305-P+	30.5	6.11	8.94	0.86	30	●
310-P+	31.0	6.13	8.70	0.86	31	●
315-P+	31.5	6.16	8.47	0.86	31	●
320-P+	32.0	6.43	9.18	0.86	32	●
325-P+	32.5	6.46	8.95	0.86	32	●
330-P+	33.0	6.48	8.71	0.86	33	●
335-P+	33.5	6.51	8.48	0.86	33	●
340-P+	34.0	6.53	8.24	0.86	34	●
345-P+	34.5	6.56	8.01	0.86	34	●



► SSC: Seat size code

●: Standard items

Drill heads for flat bottom hole



Designation	Dimension (mm)						Grade
	DC	PL	LF	CHW	SSC	PDD	TT9080
LCD - 200-F	20.0	2.18	7.63	0.7	20	8.3	●
205-F	20.5	2.18	7.63	0.7	20	8.3	●
210-F	21.0	2.18	7.63	0.7	21	8.3	●
215-F	21.5	2.18	7.63	0.7	21	8.3	●
220-F	22.0	2.38	8.17	0.7	22	9.0	●
225-F	22.5	2.38	8.17	0.7	22	9.0	●
230-F	23.0	2.38	8.17	0.7	23	9.0	●
235-F	23.5	2.38	8.17	0.7	23	9.0	●
240-F	24.0	2.52	8.10	0.7	24	10.0	●
245-F	24.5	2.52	8.10	0.7	24	10.0	●
250-F	25.0	2.52	8.10	0.7	25	10.0	●
255-F	25.5	2.52	8.10	0.7	25	10.0	●
260-F	26.0	2.48	9.84	0.7	26	10.5	●
265-F	26.5	2.48	9.84	0.7	26	10.5	●
270-F	27.0	2.48	9.84	0.7	27	10.5	●
275-F	27.5	2.48	9.84	0.7	27	10.5	●
280-F	28.0	2.72	9.50	0.7	28	11.6	●
285-F	28.5	2.72	9.50	0.7	28	11.6	●
290-F	29.0	2.72	9.50	0.7	29	11.6	●
295-F	29.5	2.72	9.50	0.7	29	11.6	●
300-F	30.0	2.80	11.63	0.7	30	12.4	●
305-F	30.5	2.80	11.63	0.7	30	12.4	●
310-F	31.0	2.80	11.63	0.7	31	12.4	●
315-F	31.5	2.80	11.63	0.7	31	12.4	●
320-F	32.0	3.13	11.59	0.7	32	13.6	●
325-F	32.5	3.13	11.59	0.7	32	13.6	●
330-F	33.0	3.13	11.59	0.7	33	13.6	●
335-F	33.5	3.13	11.59	0.7	33	13.6	●
340-F	34.0	3.13	11.59	0.7	34	13.6	●
345-F	34.5	3.13	11.59	0.7	34	13.6	●
350-F	35.0	3.31	13.20	0.7	35	14.6	●
355-F	35.5	3.31	13.20	0.7	35	14.6	●
360-F	36.0	3.31	13.20	0.7	36	14.6	●
365-F	36.5	3.31	13.20	0.7	36	14.6	●
370-F	37.0	3.31	13.20	0.7	37	14.6	●



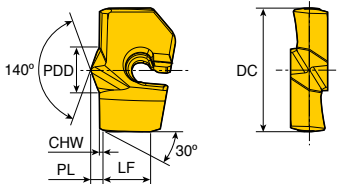
► SSC: Seat size code

●: Standard items

LCD...-F



Drill heads for flat bottom hole

[illegible]

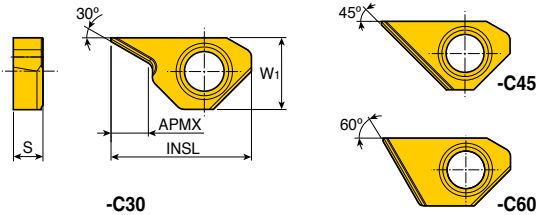
► SSC: Seat size code

●: Standard items

XCGT ...-C



Chamfering inserts for T-CHAMFER holder



Size	Dimension (mm)			
	W1	INSL	S	APMX
06-C30	6.18	12.3	2.8	3.49
09-C30	8.50	16.0	3.3	4.43
06-C45	6.18	12.3	2.8	5.89
09-C45	8.50	16.0	3.3	8.07
06-C60	6.18	12.3	2.8	3.43
09-C60	8.50	16.0	3.3	4.78

Insert	Designation	Coated						Uncoated	
		TT9080	TT9030	TT8020	TT6030	TT9300	TT7400	K10	
	XCGT 0603-C30	•							
	0903-C30	•							
	XCGT 0603-C45	•							
	0903-C45	•							
	XCGT 0603-C60	•							
	0903-C60	•							

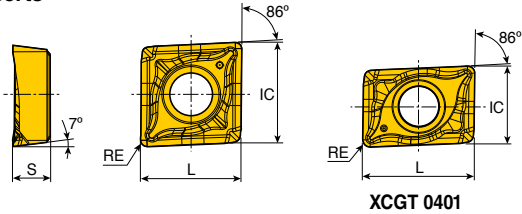
•: Standard items



XCGT...TA



Inserts



Size	Dimension (mm)			
	IC	L	S	RE
04	4.4	6.4	1.70	0.4
05	5.6	5.6	2.10	0.4
06	6.4	6.4	2.38	0.4
07	7.5	7.5	3.18	0.4
08	8.4	8.4	3.18	0.4
10	10.5	10.5	3.97	0.4
13	13.4	13.4	4.76	0.4
17	17.5	17.5	5.56	0.8

- For aluminum alloy

Insert	Designation	Turning		Drilling	Coated						Uncoated	
		ap (mm)	Feed (mm/rev)	Feed (mm/rev)	TT9080	TT8020	TT9300	TT9030	TT6030	TT7400	K10	
 Right hand shown (XCGT 0401)	XCGT 040104R TA	0.2-1.8	0.02-0.15	0.02-0.09							•	
	040104L TA	0.2-1.8	0.02-0.15	0.02-0.09							•	
	050204 TA	0.2-2.2	0.03-0.18	0.02-0.11							•	
	060204 TA	0.3-2.5	0.03-0.20	0.03-0.12							•	
	070304 TA	0.4-2.8	0.05-0.22	0.03-0.13							•	
	080304 TA	0.4-3.2	0.06-0.25	0.03-0.13							•	
	10T304 TA	0.5-3.5	0.06-0.30	0.03-0.13							•	
	130404 TA	0.6-4.3	0.08-0.33	0.03-0.13							•	
	170508 TA	0.7-5.3	0.10-0.38	0.03-0.13							•	

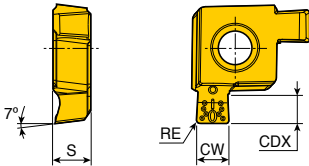
- : Standard items



XCMT..R-GV



Inserts



Size	Dimension (mm)			
	CW	CDX	S	RE
05	2.0	1.8	2.27	0.2
06	2.0	2.0	2.62	0.2
07	2.5	2.0	3.42	0.2
08	2.5	2.5	3.50	0.2
10	3.0	3.0	4.37	0.3
13	3.5	3.5	5.24	0.3
17	4.0	4.0	6.06	0.4

- For grooving

Insert	Designation	Coated						Uncoated	
		TT9080	TT8020	TT9300	TT9030	TT6030	TT7400	K10	
	XCMT 05R-200020GV	•	•						
	06R-200020GV	•	•						
	07R-250020GV	•	•						
	08R-250020GV	•	•						
	10R-300030GV	•	•						
	13R-350030GV	•	•						
	17R-400040GV	•	•						

- Grooving insert is available only for right handed type

- : Standard items



XCMT 0401

Size	Dimension (mm)			
	IC	L	S	RE
04	4.4	6.4	1.70	0.4
05	5.6	5.6	2.10	0.4
06	6.4	6.4	2.38	0.4
07	7.5	7.5	3.18	0.4
08	8.4	8.4	3.18	0.4
10	10.5	10.5	3.97	0.4/0.8
13	13.4	13.4	4.76	0.4/0.8
17	17.4	17.4	5.56	0.8

- [illegible]



D51-D53

Size	Dimension (mm)			
	W ₁	INSL	S	RE
06	6.0	8	3.0	0.4/0.8
08	7.5	10	4.0	0.4/0.8
09	9.0	10	4.0	0.4/0.8
11	11.0	10	4.0	0.4/0.8
13	13.0	10	4.0	0.4/0.8

[illegible]

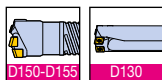
●: Standard items

Technical drawing of a rectangular block. The side view on the left shows a width dimension S . The top view on the right shows a length dimension $INSL$ and a width dimension W_1 . A detail view of the top-right corner shows a rounded edge with radius RE .

Size	Dimension (mm)			
	W ₁	INSL	S	RE
06	5.5	8	3.0	0.8
07	6.5	10	4.0	0.8
08	8.0	10	4.0	0.8
10	10.0	10	4.0	0.8
13	12.5	10	4.0	0.8

[illegible]

●: Standard items



Size	Dimension (mm)			
	W ₁	INSL	S	RE
06	5.5	8	3.0	0.4
07	6.5	10	4.0	0.4
08	8.0	10	4.0	0.4
10	10.0	10	4.0	0.4
13	12.5	10	4.0	0.4

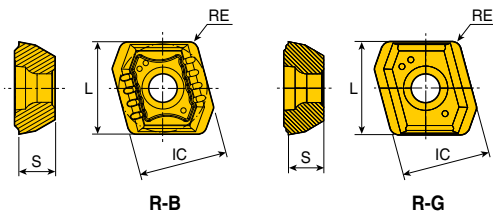
[illegible]

●: Standard items

NPMX...R-B/R-G



Inserts for TBTA...3/5/7/9



Size	Dimension (mm)			
	IC	L	S	RE
08	8.0	8.36	3.18	0.8

Insert	Designation	Pocket			Coated							Uncoated	
		Center	Inner	Outer	TT9030	TT8125	TT7200	TT6130	TT6020	TT5100	TT5030	K10	
	NPMX 080308R-B	●	●	●	●	●		●					
	080308R-G	●	●	●	●	●			●	●			

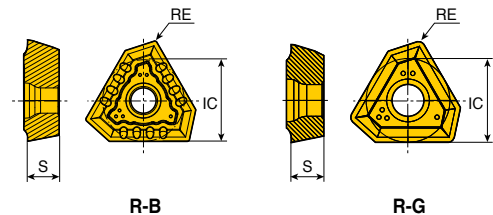


●: Standard items

TPMX...R-B/R-G



Inserts for TBTA...3/5/7/9 & TBTA-R



Size	Dimension (mm)			
	IC	S	RE	
140304 R-B	8.45	3.5	0.4	
140308 R-B/R-G	8.45	3.5	0.8	
170404 R-B	10.30	4.0	0.4	
170408 R-B/R-G	10.30	4.0	0.8	
240504 R-B	14.20	5.5	0.4	
240512 R-B/R-G	14.20	5.5	1.2	
280708 R-B	17.00	7.5	0.8	
280716 R-B/R-G	17.00	7.5	1.6	

Insert	Designation	Pocket			Coated							Uncoated		
		Center	Inner	Outer	TT9030	TT9130	TT8125	TT7200	TT6130	TT6020	TT5100	TT5030	K10	
	TPMX 140304R-B	●	●	●	●		●		●			●		
	140308R-B	●	●	●		●						●		
	140308R-G	●	●	●	●	●	●	●		●	●	●		
	170404R-B	●	●	●	●		●		●					
	170408R-B	●	●	●		●						●		
	170408R-G	●	●	●	●	●	●	●		●	●	●		
	240504R-B	●	●	●	●		●		●					
	240512R-B	●	●	●		●						●		
	240512R-G	●	●	●	●	●	●	●		●	●	●		
	280708R-B	●	●	●	●		●		●					
	280716R-B	●	●	●		●						●		
	280716R-G	●	●	●	●	●	●	●		●	●	●		

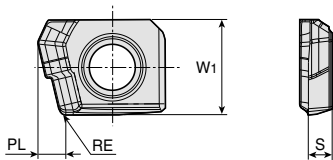


●: Standard items

ZSGT



Deep drilling inserts with single chip splitting cutting edge and a wiper for high hole surface quality



Size	Dimension (mm)			
	W1	RE	PL	S
06	6.00	0.40	1.80	1.50

Insert	Designation	Coated							Uncoated	
		TT9030	TT9130	TT8125	TT7200	TT6130	TT6020	TT5100	TT5030	K10
	ZSGT 060204R-RS		●							

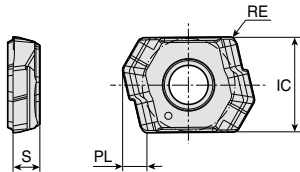


●: Standard items

LOGT



Deep drilling inserts with 2 chip splitting cutting edges, positive rake chipbreaker and a wiper for high hole surface quality



Size	Dimension (mm)			
	IC	RE	PL	S
06	7.00	0.40	1.80	2.00

Insert	Designation	Coated							Uncoated	
		TT9030	TT9130	TT8125	TT7200	TT6130	TT6020	TT5100	TT5030	K10
	LOGT 060204R-RS		●	●						



●: Standard items

TOGT...RS/GF



Inserts for TBTA-TR & TRGD

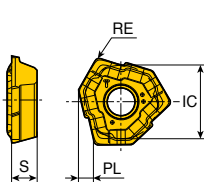


Fig.1

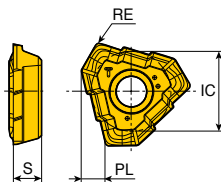


Fig.2

Size	Dimension (mm)			
	IC	PL	S	RE
07	7.69	2.0	2.3	0.4
08	8.32	2.2	2.8	0.5
09	8.55	3.0	3.0	0.5
10	9.23	3.2	3.3	0.5
11	10.40	3.4	3.8	0.5
12	11.59	3.7	4.3	0.5
13	12.85	4.6	4.8	0.8
14	16.85	5.4	5.3	1.0

[illegible]

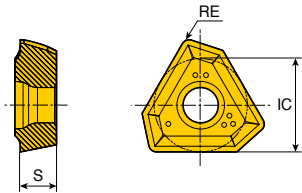
- ▶ RS: First choice for general purpose
- ▶ GF: Exotic materials

- : Standard items

TPMX...LG



Inserts for TBTA-R



Size	Dimension (mm)			
	IC	S	RE	
14	8.45	3.5	0.8	
17	10.30	4.0	0.8	
24	14.20	5.5	1.2	

Insert	Designation	Pocket			Coated							Uncoated		
		Center	Inner	Outer	TT9030	TT9130	TT8125	TT7200	TT6130	TT6020	TT5100	TT5030	K10	
	TPMX 140308 LG			●	●						●			
	170408 LG			●	●	●				●	●			
	240512 LG			●	●	●				●	●			

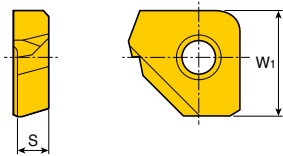


•: Standard items

XPMT...-45



Inserts for TBTA-R



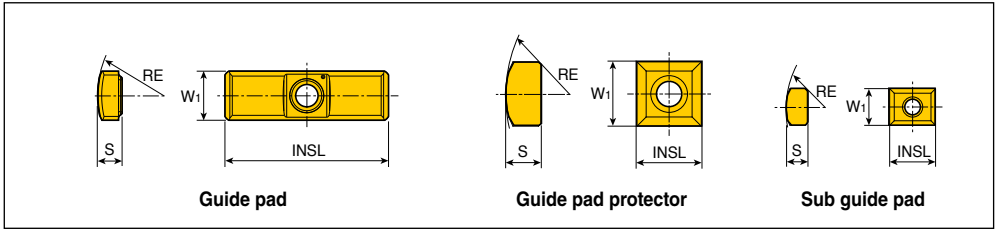
Size	Dimension (mm)			
	W1	S		
16	9.5	2.70		

Insert	Designation	Pocket			Coated							Uncoated	
		Center	Inner	Outer	TT9030	TT8125	TT7100	TT3500	TT6020	TT9300	TT7400	K10	
	XPMT 16002-45			•	•								



•: Standard items

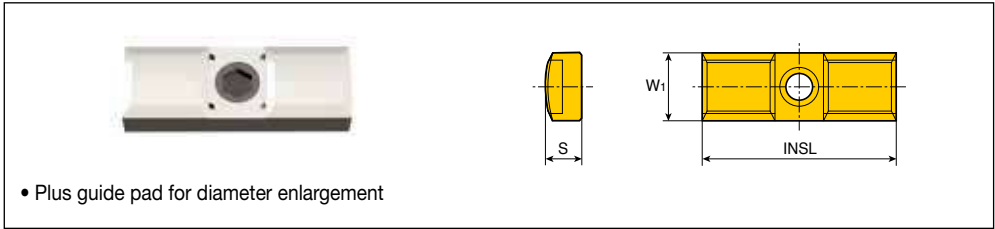
Pad for TBTA 3.../5.../7.../9...



Designation		Dimension (mm)				Screw
		W1	S	INSL	RE	
Guide pad	PAD - GP08-25-155-DC-SB	8	4.5	25	15.5	CSTB3S
	GP08-25-155-DC-SC	8	4.5	25	15.5	CSTB3S
	GP10-35-200-DC-SB	10	6.0	35	20.0	CSTB4S
	GP10-35-200-DC-SC	10	6.0	35	20.0	CSTB4S
	GP14-40-250-DC-SB/SC	14	7.5	40	25.0	CSTA5S
	GP18-40-300-DC-SB/SC	18	9.0	40	30.0	LS1206S
Guide pad protector	PAD - P08	8	4.5	8	17.5	CSTB3S
	P10	10	6.0	10	20.0	CSTB4S
	P14	14	7.5	14	25.0	CSTA5S
	P18	18	9.0	18	30.0	LS1206S
Sub guide pad	PAD - S08	8	4.5	10	17.5	CSTB3S
	S10	10	5.0	10	29.0	CSTB3S
	S14	14	7.0	20	45.0	CCSTA5S

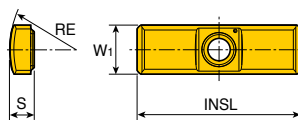


Plus Guide Pad for TBTA 3.../5.../7.../9...



Designation								
DC	PAD-GC08	S	PAD-GC10	S	PAD-GC14	S	PAD-GC18	S
DC+1mm	PAD-GC08-DC+1	5.0	PAD-GC10-DC+1	6.5	PAD-GC14-DC+1	8.0	PAD-GC18-DC+1	9.5
DC+2mm	PAD-GC08-DC+2	5.5	PAD-GC10-DC+2	7.0	PAD-GC14-DC+2	8.5	PAD-GC18-DC+2	10.0
DC+3mm	PAD-GC08-DC+3	6.0	PAD-GC10-DC+3	7.5	PAD-GC14-DC+3	9.0	PAD-GC18-DC+3	10.5
DC+4mm	-	-	PAD-GC10-DC+4	8.0	PAD-GC14-DC+4	9.5	PAD-GC18-DC+4	11.0
DC+5mm	-	-	-	-	PAD-GC14-DC+5	10.0	PAD-GC18-DC+5	11.5





Guide pad



D150-D155

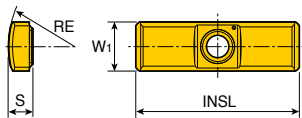
Technical drawing of a yellow cylindrical component. The drawing includes two views: a side view on the left and a front view on the right. The side view shows a cylinder with a diameter dimensioned as S and a height dimensioned as RE . The front view shows a cylinder with a diameter dimensioned as W_1 and a length dimensioned as $INSL$. A central circular feature is visible on the front view.



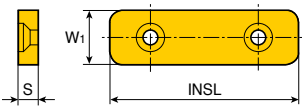
 ▶ Guide pad with "SB" is the first choice in general purpose machining
 "SC" is a excellent toughness grade used with water-soluble coolant



ADVANCECUTTING
TaeguTec



Guide pad

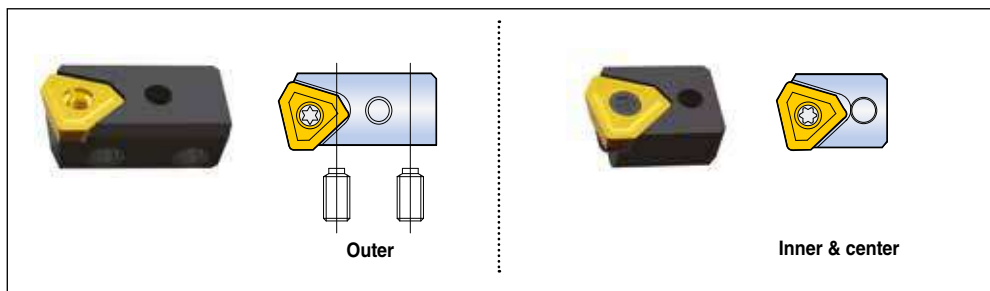


Resin guide pad

Designation		Dimension (mm)				Screw
		W1	S	INSL	RE	
Guide pad	PAD - GP08-25-155-DC-SB	8	4.5	25	15.5	CSTB3S
	GP08-25-155-DC-SC	8	4.5	25	15.5	CSTB3S
	GP10-35-200-DC-SB	10	6.0	35	20.0	CSTB4S
	GP10-35-200-DC-SC	10	6.0	35	20.0	CSTB4S
	GP14-40-250-DC-SB	14	7.5	40	25.0	CSTA5S
	GP14-40-250-DC-SC	14	7.5	40	25.0	CSTA5S
	GP18-40-300-DC-SB	18	9.0	40	30.0	LS1206S
	GP18-40-300-DC-SC	18	9.0	40	30.0	LS1206S
Resin guide pad	PAD - R10	10	4.0	40	-	LS0902.5-6
	R12	12	5.0	45	-	LS0903-8
	R15	15	5.8	50	-	LS0904-10
	R20	20	7.5	70	-	LS0905-12
	R30	30	12.5	80	-	LS0906-15
	R35	35	15.5	100	-	LS0906-15



Cartridge for TBTA 3.../5.../7.../9



	Designation	Adjust screw	Wrench	Lock screw	Wrench	Insert
Outer	PERC 05R	AS0003-5	H1.5	LS1803RH	H2	NPMX0803..
	402-04	AS0004-8	H2	LS1803.5RH	H2.5	TPMX1403..
	402-32	AS0005-10	H2.5	LS1805RH	H3	TPMX1704..
	402-43	AS0005-15	H2.5	L1806RH	H4	TPMX2405..
	402-63	AS0006-15	H3	L1806RH	H4	TPMX2807..
Inner & center	CENC 05R	-	-	CSTB3	T9	NPMX0803..
	402-04	-	-	CSTB3.5	T15	TPMX1403..
	402-32	-	-	CSTA5	T15	TPMX1704..
	402-43	-	-	LS1206	H3	TPMX2405..
	402-63	-	-	LS1206	H3	TPMX2807..

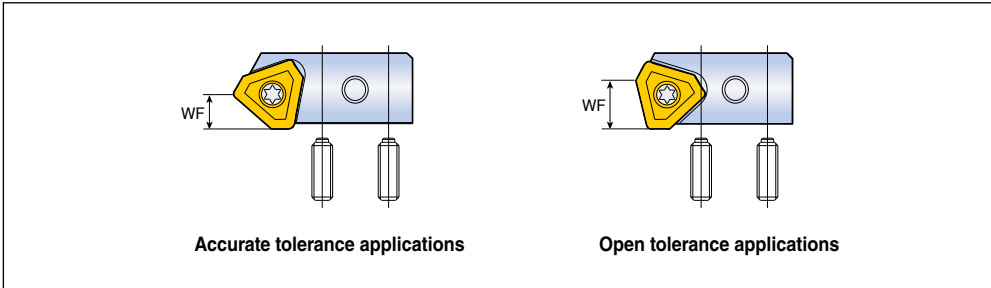


Plus Cartridge for TBTA 3.../5.../7.../9



Designation					
DC	DC+1mm	DC+2mm	DC+3mm	DC+4mm	DC+5mm
PERC 05R	PERC 05R+1	PERC 05R+2	-	-	-
PERC 402-04	PERC 402-04+1	PERC 402-04+2	PERC 402-04+3	-	-
PERC 402-32	PERC 402-32+1	PERC 402-32+2	PERC 402-32+3	PERC 402-32+4	-
PERC 402-43	PERC 402-43+1	PERC 402-43+2	PERC 402-43+3	PERC 402-43+4	PERC 402-43+5
PERC 402-63	PERC 402-63+1	PERC 402-63+2	PERC 402-63+3	PERC 402-63+4	PERC 402-63+5

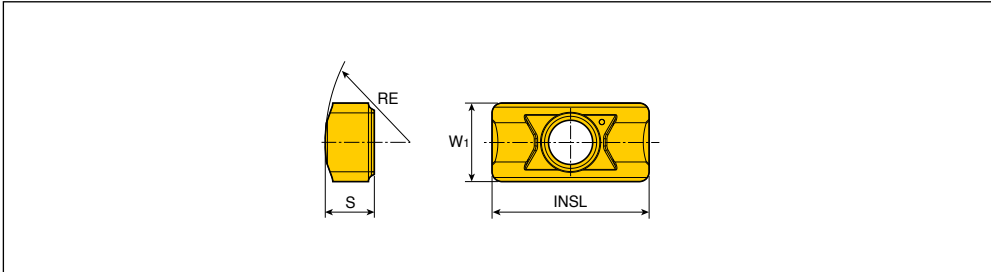




Designation		WF (mm)	Adjust screw	Wrench	Lock screw	Wrench	Insert
Accurate tolerance applications	PERC P04R	5	AS0004-8	H2	LS1803.5RH	H2.5	TPMX1403..LG
	P32R	6	AS0005-10	H2.5	LS1805RH	H3	TPMX1704..LG
	P43R	8	AS0005-15	H2.5	LS1806RH	H4	TPMX2405..LG
Open tolerance applications	PERC 402-04	8	AS0004-8	H2	LS1803.5RH	H2.5	TPMX1403..RG
	402-32	9	AS0005-10	H2.5	LS1805RH	H3	TPMX1704..RG
	402-43	13	AS0005-15	H2.5	LS1806RH	H4	TPMX2405..RG



► PERC-P and PERC 402-□□ cartridges are interchangeable in the same pocket



Designation	Dimension (mm)				Screw	Grade TT9030
	W1	S	INSL	RE		
PAD-G04-08	4	2.5	8	9	TS 20043I/HG-P	●



► Guide pad is sold separately from drill heads

●: Standard items

Recommended Cutting Conditions



Machining data for TOP-DRILL 2,3,4xD

ISO	Material	Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C Annealed	420	125	1	220-350
		>=0.25%C Annealed	650	190	2	180-280
		<0.55%C Quenched and tempered	850	250	3	140-240
		>=0.55%C Annealed	750	220	4	140-240
		Quenched and tempered	1000	300	5	140-240
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed	600	200	6	140-240
		Quenched and tempered	930	275	7	100-180
			1000	300	8	100-180
			1200	350	9	100-180
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	140-200
		Quenched and tempered	1100	325	11	100-160
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	150-250
		Martensitic	820	240	13	150-250
		Austenitic	600	180	14	150-250
K	Gray cast iron (GG)	Ferritic		160	15	160-260
		Pearlitic		250	16	160-260
	Cast iron nodular (GGG)	Ferritic		180	17	160-260
		Pearlitic		260	18	160-260
	Malleable cast iron	Ferritic		130	19	120-220
		Pearlitic		230	20	120-220
N	Aluminum - Wrought alloy	Not cureable		60	21	200-350
		Cured		100	22	200-350
	Aluminum-cast, alloyed	<=12% Si Not cureable		75	23	200-350
		Cured		90	24	200-350
		>12% Si High temp.		130	25	200-350
	Copper alloys	>1% Pb Free cutting		110	26	150-250
		Brass		90	27	150-250
		Electrolitic copper		100	28	150-250
	Non-metallic	Duroplastics, fiber plastics		70 Shore D	29	150-250
		Hard rubber		55 Shore D	30	150-250
S	High temp. alloys	Fe based	Annealed	200	31	30-60
			Cured	280	32	30-60
		Ni or Co based	Annealed	250	33	30-60
			Cured	350	34	30-60
			Cast	320	35	30-60
H	Hardened steel	Pure	Rm 400	190	36	50-80
		Alpha+beta alloys cured	Rm 1050	310	37	50-80
	Chilled cast iron	Hardened		55HRC	38	30-60
		Hardened		60HRC	39	30-60
	Cast iron nodular	Cast		400	40	30-60
		Hardened		55HRC	41	30-60

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for TOP-DRILL 2,3,4xD

Feed (mm/rev) vs. drill diameter Drill length 2,3,4xD								
SOMT 04 Ø12 - Ø13.5	SOMT 05 Ø14 - Ø16	SOMT 06 Ø17 - Ø19	SOMT 07 Ø20 - Ø22	SOMT 08 Ø23 - Ø26	SOMT 09 Ø27 - Ø31	SOMT 11 Ø32 - Ø36	SOMT 13 Ø37 - Ø43	SOMT 15 Ø44 - Ø50
0.04-0.06	0.04-0.06	0.04-0.06	0.04-0.08	0.04-0.08	0.06-0.10	0.06-0.10	0.08-0.12	0.08-0.12
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.08-0.14	0.08-0.14	0.08-0.16	0.10-0.16
0.08-0.12	0.08-0.12	0.08-0.12	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.18	0.10-0.18
0.08-0.12	0.08-0.12	0.08-0.12	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.18	0.10-0.18
0.08-0.12	0.08-0.12	0.08-0.12	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.18	0.10-0.18
0.06-0.16	0.06-0.16	0.06-0.16	0.08-0.20	0.08-0.20	0.08-0.20	0.10-0.22	0.10-0.22	0.10-0.24
0.06-0.16	0.06-0.16	0.06-0.16	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.22	0.10-0.22	0.10-0.22
0.06-0.16	0.06-0.16	0.06-0.16	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.22	0.10-0.22	0.10-0.22
0.06-0.16	0.06-0.16	0.06-0.16	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.22	0.10-0.22	0.10-0.22
0.06-0.12	0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.20	0.10-0.20	0.10-0.20
0.06-0.12	0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.20	0.10-0.20	0.10-0.20
0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.16	0.06-0.16	0.08-0.18	0.08-0.20	0.10-0.20	0.10-0.20
0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.16	0.06-0.16	0.08-0.18	0.08-0.20	0.10-0.20	0.10-0.20
0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.16	0.06-0.16	0.08-0.18	0.08-0.20	0.10-0.20	0.10-0.20
0.08-0.18	0.08-0.18	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.22	0.10-0.22
0.08-0.18	0.08-0.18	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.22	0.10-0.22
0.08-0.18	0.08-0.18	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.22	0.10-0.22
0.08-0.18	0.08-0.18	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.22	0.10-0.22
0.08-0.14	0.08-0.14	0.08-0.14	0.10-0.16	0.10-0.16	0.10-0.16	0.10-0.18	0.10-0.18	0.10-0.18
0.08-0.14	0.08-0.14	0.08-0.14	0.10-0.16	0.10-0.16	0.10-0.16	0.10-0.18	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.18	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.18	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.18	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.18	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.18	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.17	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.17	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.17	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.10-0.17	0.10-0.17	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.10-0.17	0.10-0.17	0.10-0.18	0.10-0.18
0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12
0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12
0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12
0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12
0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12
0.06-0.09	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.09	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10

Recommended Cutting Conditions



Machining data for TOP-DRILL 5xD

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	220-350
		>=0.25%C	Annealed	650	190	2	180-280
		<0.55%C	Quenched and tempered	850	250	3	140-240
		>=0.55%C	Annealed	750	220	4	140-240
			Quenched and tempered	1000	300	5	140-240
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	140-240
			Quenched and tempered	930	275	7	100-180
				1000	300	8	100-180
				1200	350	9	100-180
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	140-200
			Quenched and tempered	1100	325	11	100-160
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	150-250	
		Martensitic	820	240	13	150-250	
		Austenitic	600	180	14	150-250	
K	Gray cast iron (GG)	Ferritic		160	15	160-260	
		Pearlitic		250	16	160-260	
	Cast iron nodular (GGG)	Ferritic		180	17	160-260	
		Pearlitic		260	18	160-260	
	Malleable cast iron	Ferritic		130	19	120-220	
Pearlitic			230	20	120-220		
N	Aluminum - Wrought alloy	Not cureable		60	21	200-350	
		Cured		100	22	200-350	
	Aluminum- cast, alloyed	<=12% Si	Not cureable		75	23	200-350
			Cured		90	24	200-350
		>12% Si	High temp.		130	25	200-350
	Copper alloys	>1% Pb	Free cutting		110	26	150-250
			Brass		90	27	150-250
			Electrolitic copper		100	28	150-250
	Non-metallic		Duroplastics, fiber plastics		70 Shore D	29	150-250
Hard rubber				55 Shore D	30	150-250	
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	30-60
		Ni or Co based	Annealed		250	33	30-60
			Cured		350	34	30-60
			Cast		320	35	30-60
	Titanium, Ti alloys		Pure	Rm 400	190	36	50-80
			Alpha+beta alloys cured	Rm 1050	310	37	50-80
H	Hardened steel	Hardened		55HRC	38	30-60	
				60HRC	39	30-60	
	Chilled cast iron	Cast		400	40	30-60	
	Cast iron nodular	Hardened		55HRC	41	30-60	

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for TOP-DRILL 5xD

Feed (mm/rev) vs. drill diameter Drill length 5xD								
SOMT 04 Ø12 - Ø13.5	SOMT 05 Ø14 - Ø16	SOMT 06 Ø17 - Ø19	SOMT 07 Ø20 - Ø22	SOMT 08 Ø23 - Ø26	SOMT 09 Ø27 - Ø31	SOMT 11 Ø32 - Ø36	SOMT 13 Ø37 - Ø43	SOMT 15 Ø44 - Ø50
0.04-0.05	0.04-0.05	0.04-0.05	0.04-0.05	0.04-0.06	0.06-0.08	0.06-0.08	0.08-0.10	0.08-0.10
0.06-0.08	0.06-0.08	0.06-0.08	0.06-0.10	0.06-0.10	0.08-0.12	0.08-0.12	0.08-0.14	0.10-0.14
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.10-0.15	0.10-0.15	0.10-0.17	0.10-0.17
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.10-0.15	0.10-0.15	0.10-0.17	0.10-0.17
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.10-0.15	0.10-0.15	0.10-0.17	0.10-0.17
0.06-0.12	0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.16	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.22
0.06-0.12	0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.16	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.22
0.06-0.12	0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.16	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.22
0.06-0.12	0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.16	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.22
0.06-0.10	0.06-0.10	0.06-0.10	0.08-0.12	0.08-0.12	0.08-0.16	0.08-0.18	0.10-0.18	0.10-0.20
0.06-0.10	0.06-0.10	0.06-0.10	0.08-0.12	0.08-0.12	0.08-0.16	0.08-0.18	0.10-0.18	0.10-0.20
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.18	0.10-0.18	0.10-0.20
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.18	0.10-0.18	0.10-0.20
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.18	0.10-0.18	0.10-0.20
0.08-0.14	0.08-0.14	0.08-0.14	0.08-0.16	0.08-0.16	0.10-0.18	0.10-0.18	0.10-0.20	0.10-0.20
0.08-0.14	0.08-0.14	0.08-0.14	0.08-0.16	0.08-0.16	0.10-0.18	0.10-0.18	0.10-0.20	0.10-0.20
0.08-0.14	0.08-0.14	0.08-0.14	0.08-0.16	0.08-0.16	0.10-0.18	0.10-0.18	0.10-0.20	0.10-0.20
0.08-0.14	0.08-0.14	0.08-0.14	0.08-0.16	0.08-0.16	0.10-0.18	0.10-0.18	0.10-0.20	0.10-0.20
0.08-0.12	0.08-0.12	0.08-0.14	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.16	0.10-0.16
0.08-0.12	0.08-0.12	0.08-0.14	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.16	0.10-0.16
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.15	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.15	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.15	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.17	0.10-0.17
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10
0.05-0.08	0.05-0.08	0.05-0.08	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.05-0.08	0.05-0.08	0.05-0.08	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10

Recommended Cutting Conditions



Machining data for TOP-DRILL cartridge

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	250-350
		>=0.25%C	Annealed	650	190	2	160-250
		<0.55%C	Quenched and tempered	850	250	3	140-240
		>=0.55%C	Annealed	750	220	4	140-240
			Quenched and tempered	1000	300	5	140-240
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	140-240
			Quenched and tempered	930	275	7	100-180
				1000	300	8	100-180
				1200	350	9	100-180
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	140-200
			Quenched and tempered	1100	325	11	100-160
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	150-250	
		Martensitic	820	240	13	150-250	
		Austenitic	600	180	14	150-250	
K	Gray cast iron (GG)	Ferritic		160	15	160-260	
		Pearlitic		250	16	160-260	
	Cast iron nodular (GGG)	Ferritic		180	17	160-260	
		Pearlitic		260	18	160-260	
	Malleable cast iron	Ferritic		130	19	120-220	
Pearlitic			230	20	120-220		
N	Aluminum - Wrought alloy	Not cureable		60	21	200-350	
		Cured		100	22	200-350	
	Aluminum- cast, alloyed	<=12% Si	Not cureable		75	23	200-350
			Cured		90	24	200-350
		>12% Si	High temp.		130	25	200-350
	Copper alloys	>1% Pb	Free cutting		110	26	150-250
			Brass		90	27	150-250
			Electrolitic copper		100	28	150-250
	Non-metallic		Duroplastics, fiber plastics		70 Shore D	29	150-250
Hard rubber				55 Shore D	30	150-250	
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	30-60
		Ni or Co based	Annealed		250	33	30-60
			Cured		350	34	30-60
			Cast		320	35	30-60
	Titanium, Ti alloys	Pure	Rm 400	190	36	50-80	
		Alpha+beta alloys cured	Rm 1050	310	37	50-80	
H	Hardened steel	Hardened		55HRC	38	30-60	
		Hardened		60HRC	39	30-60	
	Chilled cast iron	Cast		400	40	30-60	
	Cast iron nodular	Hardened		55HRC	41	30-60	

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for TOP-DRILL cartridge

Feed (mm/rev) vs. drill diameter Drill length 2,3,4xD					
SOMT 09 Ø51 - Ø55	SOMT 11 Ø56 - Ø60	SOMT 11 Ø61 - Ø65	SOMT 11 Ø66 - Ø70	SOMT 13 Ø71 - Ø75	SOMT 13 Ø76 - Ø80
0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
0.06-0.16	0.06-0.16	0.06-0.16	0.06-0.16	0.06-0.16	0.06-0.16
0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20
0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20
0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20
0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20
0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.20
0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.10-0.22	0.10-0.22	0.10-0.22	0.10-0.22	0.10-0.22	0.10-0.22
0.10-0.22	0.10-0.22	0.10-0.22	0.10-0.22	0.10-0.22	0.10-0.22
0.10-0.22	0.10-0.22	0.10-0.22	0.10-0.22	0.10-0.22	0.10-0.22
0.10-0.22	0.10-0.22	0.10-0.22	0.10-0.22	0.10-0.22	0.10-0.22
0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18
0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18
0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18
0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18
0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18
0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18
0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18
0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18
0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18
0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18
0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10

Recommended Cutting Conditions



Machining data for T-DRILL 2,3,4xD

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	250-350
		>=0.25%C	Annealed	650	190	2	180-250
		<0.55%C	Quenched and tempered	850	250	3	160-220
		>=0.55%C	Annealed	750	220	4	160-220
			Quenched and tempered	1000	300	5	160-220
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	150-220
			Quenched and tempered	930	275	7	120-160
				1000	300	8	120-160
				1200	350	9	120-160
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	140-180
			Quenched and tempered	1100	325	11	130-180
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	170-240	
		Martensitic	820	240	13	170-240	
		Austenitic	600	180	14	170-240	
K	Gray cast iron (GG)	Ferritic		160	15	180-250	
		Pearlitic		250	16	180-250	
	Cast iron nodular (GGG)	Ferritic		180	17	180-250	
		Pearlitic		260	18	180-250	
	Malleable cast iron	Ferritic		130	19	130-200	
Pearlitic			230	20	130-200		
N	Aluminum - Wrought alloy	Not cureable		60	21	330-380	
		Cured		100	22	330-380	
	Aluminum- cast, alloyed	<=12% Si	Not cureable		75	23	330-380
			Cured		90	24	330-380
		>12% Si	High temp.		130	25	330-380
	Copper alloys	>1% Pb	Free cutting		110	26	150-230
			Brass		90	27	150-230
			Electrolitic copper		100	28	150-230
Non-metallic		Duroplastics, fiber plastics		70 Shore D	29	150-230	
		Hard rubber		55 Shore D	30	150-230	
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	30-60
		Ni or Co based	Annealed		250	33	30-60
			Cured		350	34	30-60
			Cast		320	35	30-60
	Titanium, Ti alloys	Pure	Rm 400	190	36	30-60	
Alpha+beta alloys cured		Rm 1050	310	37	30-60		
H	Hardened steel	Hardened		55HRC	38	30-60	
		Hardened		60HRC	39	30-60	
	Chilled cast iron	Cast		400	40	30-60	
	Cast iron nodular	Hardened		55HRC	41	30-60	

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for T-DRILL 2,3,4xD

Feed (mm/rev) vs. drill diameter Drill length 2,3,4xD					
SPMG 05 Ø12.5 - Ø15	SPMG 06 Ø16 - Ø21	SPMG 07 Ø22 - Ø27	SPMG 09 Ø28 - Ø33	SPMG 11 Ø34 - Ø41	SPMG 14 Ø42 - Ø50
0.04-0.06	0.04-0.06	0.04-0.08	0.04-0.08	0.06-0.10	0.06-0.12
0.05-0.08	0.06-0.10	0.06-0.12	0.07-0.13	0.08-0.15	0.08-0.16
0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.22	0.12-0.24	0.13-0.25
0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.22	0.12-0.24	0.13-0.25
0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.22	0.12-0.24	0.13-0.25
0.06-0.12	0.08-0.14	0.10-0.18	0.12-0.20	0.12-0.20	0.13-0.20
0.06-0.15	0.06-0.15	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.06-0.15	0.06-0.15	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.06-0.15	0.06-0.15	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.06-0.10	0.06-0.10	0.08-0.12	0.08-0.14	0.08-0.14	0.08-0.14
0.06-0.10	0.08-0.12	0.10-0.15	0.12-0.15	0.12-0.18	0.13-0.18
0.05-0.10	0.06-0.12	0.08-0.15	0.09-0.16	0.10-0.17	0.11-0.18
0.05-0.10	0.06-0.12	0.08-0.15	0.09-0.16	0.10-0.17	0.11-0.18
0.05-0.10	0.06-0.12	0.08-0.15	0.09-0.16	0.10-0.17	0.11-0.18
0.06-0.12	0.08-0.16	0.12-0.20	0.15-0.25	0.16-0.28	0.18-0.30
0.06-0.12	0.08-0.16	0.12-0.20	0.15-0.25	0.16-0.28	0.18-0.30
0.06-0.12	0.08-0.16	0.12-0.20	0.15-0.25	0.16-0.28	0.18-0.30
0.06-0.12	0.08-0.16	0.12-0.20	0.15-0.25	0.16-0.28	0.18-0.30
0.06-0.10	0.08-0.15	0.10-0.18	0.12-0.20	0.15-0.23	0.16-0.25
0.06-0.10	0.08-0.15	0.10-0.18	0.12-0.20	0.15-0.23	0.16-0.25
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.10	0.06-0.14	0.08-0.18	0.10-0.22	0.14-0.23	0.15-0.24
0.05-0.10	0.06-0.14	0.08-0.18	0.10-0.22	0.14-0.23	0.15-0.24
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10

Recommended Cutting Conditions



Machining data for T-DRILL 5xD

ISO	Material		Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc (m/min)	
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	250-350	
		>=0.25%C	Annealed	650	190	2	180-250	
		<0.55%C	Quenched and tempered	850	250	3	160-220	
		>=0.55%C	Annealed	750	220	4	160-220	
			Quenched and tempered	1000	300	5	160-220	
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	150-220	
		Quenched and tempered		930	275	7	120-160	
				1000	300	8	120-160	
				1200	350	9	120-160	
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	140-180	
			Quenched and tempered	1100	325	11	130-180	
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	170-240	
			Martensitic	820	240	13	170-240	
			Austenitic	600	180	14	170-240	
K	Gray cast iron (GG)		Ferritic		160	15	180-250	
			Pearlitic		250	16	180-250	
	Cast iron nodular (GGG)		Ferritic		180	17	180-250	
			Pearlitic		260	18	180-250	
	Malleable cast iron		Ferritic		130	19	130-200	
			Pearlitic		230	20	130-200	
N	Aluminum - Wrought alloy		Not cureable		60	21	330-380	
			Cured		100	22	330-380	
	Aluminum- cast, alloyed	<=12% Si	Not cureable		75	23	330-380	
			Cured		90	24	330-380	
	>12% Si		High temp.		130	25	330-380	
		>1% Pb	Free cutting		110	26	150-230	
	Copper alloys		Brass		90	27	150-230	
			Electrolitic copper		100	28	150-230	
	Non-metallic		Duroplastics, fiber plastics		70 Shore D	29	150-230	
			Hard rubber		55 Shore D	30	150-230	
S	High temp. alloys	Fe based		Annealed		200	31	30-60
				Cured		280	32	30-60
		Ni or Co based		Annealed		250	33	30-60
				Cured		350	34	30-60
				Cast		320	35	30-60
	Titanium, Ti alloys		Pure	Rm 400	190	36	30-60	
			Alpha+beta alloys cured	Rm 1050	310	37	30-60	
H	Hardened steel		Hardened		55HRC	38	30-60	
			Hardened		60HRC	39	30-60	
	Chilled cast iron		Cast		400	40	30-60	
	Cast iron nodular		Hardened		55HRC	41	30-60	

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for T-DRILL 5xD

Feed (mm/rev) vs. drill diameter Drill length 5xD					
SPMG 05 Ø12.5 - Ø15	SPMG 06 Ø16 - Ø21	SPMG 07 Ø22 - Ø27	SPMG 09 Ø28 - Ø33	SPMG 11 Ø34 - Ø41	SPMG 14 Ø42 - Ø50
0.04-0.05	0.04-0.05	0.04-0.06	0.04-0.07	0.06-0.08	0.06-0.10
0.06-0.08	0.06-0.08	0.06-0.10	0.07-0.12	0.08-0.13	0.08-0.14
0.06-0.10	0.08-0.13	0.10-0.16	0.12-0.20	0.12-0.22	0.13-0.23
0.06-0.10	0.08-0.13	0.10-0.16	0.12-0.20	0.12-0.22	0.13-0.23
0.06-0.10	0.08-0.13	0.10-0.16	0.12-0.20	0.12-0.22	0.13-0.23
0.06-0.10	0.08-0.12	0.10-0.16	0.12-0.18	0.12-0.18	0.13-0.18
0.06-0.12	0.06-0.13	0.08-0.16	0.08-0.16	0.08-0.17	0.08-0.17
0.06-0.12	0.06-0.13	0.08-0.16	0.08-0.16	0.08-0.17	0.08-0.17
0.06-0.12	0.06-0.13	0.08-0.16	0.08-0.16	0.08-0.17	0.08-0.17
0.06-0.08	0.06-0.08	0.08-0.10	0.08-0.12	0.08-0.12	0.08-0.12
0.06-0.09	0.08-0.10	0.10-0.13	0.12-0.13	0.12-0.15	0.12-0.16
0.05-0.09	0.06-0.10	0.08-0.13	0.09-0.15	0.10-0.15	0.10-0.17
0.05-0.09	0.06-0.10	0.08-0.13	0.09-0.15	0.10-0.15	0.10-0.17
0.05-0.09	0.06-0.10	0.08-0.13	0.09-0.15	0.10-0.15	0.10-0.17
0.06-0.10	0.08-0.15	0.12-0.18	0.15-0.22	0.16-0.25	0.18-0.28
0.06-0.10	0.08-0.15	0.12-0.18	0.15-0.22	0.16-0.25	0.18-0.28
0.06-0.10	0.08-0.15	0.12-0.18	0.15-0.22	0.16-0.25	0.18-0.28
0.06-0.10	0.08-0.15	0.12-0.18	0.15-0.22	0.16-0.25	0.18-0.28
0.06-0.08	0.08-0.12	0.10-0.16	0.12-0.18	0.15-0.22	0.16-0.23
0.06-0.08	0.08-0.12	0.10-0.16	0.12-0.18	0.15-0.22	0.16-0.23
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.09	0.08-0.13	0.08-0.17	0.10-0.20	0.14-0.22	0.14-0.24
0.05-0.09	0.08-0.13	0.08-0.17	0.10-0.20	0.14-0.22	0.14-0.24
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09

Recommended Cutting Conditions



Machining data for T-DRILL cartridge

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	250-350
		>=0.25%C	Annealed	650	190	2	180-250
		<0.55%C	Quenched and tempered	850	250	3	160-220
		>=0.55%C	Annealed	750	220	4	160-220
			Quenched and tempered	1000	300	5	160-220
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	150-220
		Quenched and tempered		930	275	7	120-160
				1000	300	8	120-160
				1200	350	9	120-160
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	140-180
			Quenched and tempered	1100	325	11	130-180
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	170-240
			Martensitic	820	240	13	170-240
			Austenitic	600	180	14	170-240
K	Gray cast iron (GG)		Ferritic		160	15	180-250
			Pearlitic		250	16	180-250
	Cast iron nodular (GGG)		Ferritic		180	17	180-250
			Pearlitic		260	18	180-250
	Malleable cast iron		Ferritic		130	19	130-200
			Pearlitic		230	20	130-200
N	Aluminum - Wrought alloy		Not cureable		60	21	330-380
			Cured		100	22	330-380
	Aluminum- cast, alloyed	<=12% Si	Not cureable		75	23	330-380
			Cured		90	24	330-380
	>12% Si	High temp.		130	25	330-380	
		>1% Pb	Free cutting		110	26	150-230
	Copper alloys		Brass		90	27	150-230
			Electrolitic copper		100	28	150-230
	Non-metallic		Duroplastics, fiber plastics		70 Shore D	29	150-230
			Hard rubber		55 Shore D	30	150-230
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	30-60
		Ni or Co based	Annealed		250	33	30-60
			Cured		350	34	30-60
			Cast		320	35	30-60
	Titanium, Ti alloys		Pure	Rm 400	190	36	30-60
			Alpha+beta alloys cured	Rm 1050	310	37	30-60
H	Hardened steel	Hardened		55HRC	38	30-60	
		Hardened		60HRC	39	30-60	
	Chilled cast iron	Cast		400	40	30-60	
	Cast iron nodular	Hardened		55HRC	41	30-60	

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for T-DRILL cartridge

Feed (mm/rev) vs. drill diameter Drill length 5xD					
SPMG 07 Ø51 - Ø53	SPMG 07 Ø54 - Ø56	SPMG 09 Ø57 - Ø62	SPMG 09 Ø63- Ø66	SPMG 11 Ø67 - Ø73	SPMG 12 Ø74 - Ø80
0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
0.06-0.16	0.06-0.12	0.06-0.16	0.06-0.16	0.06-0.16	0.06-0.16
0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.18
0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.18
0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.18
0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16
0.06-0.12	0.06-0.12	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.12	0.06-0.12	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.12	0.06-0.12	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.12-0.20	0.12-0.20	0.12-0.20	0.12-0.20	0.15-0.22	0.15-0.22
0.12-0.20	0.12-0.20	0.12-0.20	0.12-0.20	0.15-0.22	0.15-0.22
0.12-0.20	0.12-0.20	0.12-0.20	0.12-0.20	0.15-0.22	0.15-0.22
0.12-0.20	0.12-0.20	0.12-0.20	0.12-0.20	0.15-0.22	0.15-0.22
0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.12-0.20	0.12-0.20
0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.12-0.20	0.12-0.20
0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18
0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18
0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18
0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18
0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18	0.06-0.18
0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18
0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18
0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18
0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18
0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18	0.10-0.18
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10

Recommended Cutting Conditions



Machining data for TOP-CAP

ISO	Material		Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	
		>=0.25%C	Annealed	650	190	2	
		<0.55%C	Quenched and tempered	850	250	3	
		>=0.55%C	Annealed	750	220	4	
			Quenched and tempered	1000	300	5	
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	
			Quenched and tempered		930	275	7
					1000	300	8
					1200	350	9
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	
			Quenched and tempered	1100	325	11	
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12		
		Martensitic	820	240	13		
		Austenitic	600	180	14		
K	Gray cast iron (GG)	Ferritic		160	15		
		Pearlitic		250	16		
	Cast iron nodular (GGG)	Ferritic		180	17		
		Pearlitic		260	18		
	Malleable cast iron	Ferritic		130	19		
Pearlitic			230	20			
N	Aluminum - Wrought alloy	Not cureable		60	21		
		Cured		100	22		
	Aluminum- cast, alloyed	<=12% Si	Not cureable		75	23	
			Cured		90	24	
		>12% Si	High temp.		130	25	
	Copper alloys	>1% Pb	Free cutting		110	26	
			Brass		90	27	
			Electrolitic copper		100	28	
	Non-metallic		Duroplastics, fiber plastics		70 Shore D	29	
			Hard rubber		55 Shore D	30	
S	High temp. alloys	Fe based	Annealed		200	31	
			Cured		280	32	
		Ni or Co based	Annealed		250	33	
			Cured		350	34	
			Cast		320	35	
	Titanium, Ti alloys	Pure	Rm 400	190	36		
		Alpha+beta alloys cured	Rm 1050	310	37		
H	Hardened steel	Hardened		55HRC	38		
		Hardened		60HRC	39		
	Chilled cast iron	Cast		400	40		
	Cast iron nodular	Hardened		55HRC	41		

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for TOP-CAP

Drilling		Turning & boring		Grooving	
Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)
120-260	0.05-0.06	140-280	0.04-0.14	120-250	0.04-0.25
80-190	0.05-0.15	90-200	0.04-0.12	80-180	0.04-0.25
100-280	0.06-0.18	100-200	0.04-0.15	80-180	0.04-0.25
100-280	0.06-0.18	100-200	0.04-0.15	80-180	0.04-0.25
100-280	0.06-0.18	100-200	0.04-0.15	80-180	0.04-0.25
100-280	0.06-0.18	100-200	0.04-0.15	80-180	0.04-0.25
60-180	0.04-0.15	80-180	0.07-0.12	60-160	0.04-0.25
60-180	0.04-0.15	80-180	0.07-0.12	60-160	0.04-0.25
60-180	0.04-0.15	80-180	0.07-0.12	60-160	0.04-0.25
80-190	0.05-0.15	80-200	0.04-0.12	80-160	0.04-0.25
50-150	0.04-0.14	60-150	0.04-0.12	50-120	0.04-0.25
50-210	0.04-0.15	60-230	0.07-0.12	50-200	0.04-0.25
50-210	0.04-0.15	60-230	0.07-0.12	50-200	0.04-0.25
50-210	0.04-0.15	60-230	0.07-0.12	50-200	0.04-0.25
100-300	0.06-0.23	120-230	0.07-0.2	100-200	0.04-0.25
100-300	0.06-0.23	120-230	0.07-0.2	100-200	0.04-0.25
100-300	0.06-0.23	120-230	0.07-0.2	100-200	0.04-0.25
100-300	0.06-0.23	120-230	0.07-0.2	100-200	0.04-0.25
100-200	0.06-0.15	120-230	0.04-0.13	100-200	0.04-0.25
100-200	0.06-0.15	120-230	0.04-0.13	100-200	0.04-0.25
120-500	0.05-0.3	120-700	0.04-0.25	100-700	0.04-0.25
120-500	0.05-0.3	120-700	0.04-0.25	100-700	0.04-0.25
120-500	0.05-0.3	120-700	0.04-0.25	100-700	0.04-0.25
120-500	0.05-0.3	120-700	0.04-0.25	100-700	0.04-0.25
80-380	0.05-0.23	80-500	0.04-0.2	80-350	0.04-0.25
80-380	0.05-0.23	80-500	0.04-0.2	80-350	0.04-0.25
80-380	0.05-0.23	80-500	0.04-0.2	80-350	0.04-0.25
50-140	0.04-0.14	50-160	0.04-0.12	50-140	0.04-0.25
50-140	0.04-0.14	50-160	0.04-0.12	50-140	0.04-0.25
20-50	0.04-0.05	20-80	0.04-0.05	20-50	0.04-0.05
20-50	0.04-0.05	20-80	0.04-0.05	20-50	0.04-0.05
20-50	0.04-0.05	20-80	0.04-0.05	20-50	0.04-0.05
20-50	0.04-0.05	20-80	0.04-0.05	20-50	0.04-0.05
20-50	0.04-0.05	20-80	0.04-0.05	20-50	0.04-0.05
30-60	0.04-0.05	30-100	0.04-0.05	30-80	0.04-0.05
30-60	0.04-0.05	30-100	0.04-0.05	30-80	0.04-0.05
20-40	0.04-0.05	20-70	0.04-0.05	20-50	0.04-0.05
20-40	0.04-0.05	20-70	0.04-0.05	20-50	0.04-0.05
20-40	0.04-0.05	20-70	0.04-0.05	20-50	0.04-0.05
20-40	0.04-0.05	20-70	0.04-0.05	20-50	0.04-0.05

Recommended Cutting Conditions



Machining data for DRILL-SFEED 3,5,8xD

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1
		>=0.25%C	Annealed	650	190	2
		<0.55%C	Quenched and tempered	850	250	3
		>=0.55%C	Annealed	750	220	4
			Quenched and tempered	1000	300	5
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed		600	200	6
				930	275	7
		Quenched and tempered		1000	300	8
				1200	350	9
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	
		Quenched and tempered	1100	325	11	
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	
		Martensitic	820	240	13	
		Austenitic	600	180	14	
K	Gray cast iron (GG)	Ferritic		160	15	
		Pearlitic		250	16	
	Cast iron nodular (GGG)	Ferritic		180	17	
		Pearlitic		260	18	
	Malleable cast iron	Ferritic		130	19	
Pearlitic			230	20		
N	Aluminum - Wrought alloy	Not cureable		60	21	
		Cured		100	22	
	Aluminum-cast, alloyed	<=12% Si	Not cureable	75	23	
			Cured	90	24	
		>12% Si	High temp.	130	25	
	Copper alloys	>1% Pb	Free cutting	110	26	
			Brass	90	27	
			Electrolitic copper	100	28	
	Non-metallic	Duroplastics, fiber plastics		70 Shore D	29	
		Hard rubber		55 Shore D	30	
S	High temp. alloys	Fe based	Annealed		200	31
			Cured		280	32
		Ni or Co based	Annealed		250	33
			Cured		350	34
			Cast		320	35
	Titanium, Ti alloys	Pure	Rm 400	190	36	
		Alpha+beta alloys cured	Rm 1050	310	37	
H	Hardened steel	Hardened		55HRC	38	
		Hardened		60HRC	39	
	Chilled cast iron	Cast		400	40	
	Cast iron nodular	Hardened		55HRC	41	

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Drill Speed
INTEGRABLE & FLEXIBLE

Recommended Cutting Conditions



Machining data for DRILL-RUSH

ISO	Material		Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc (m/min)	
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	80-140	
		>=0.25%C	Annealed	650	190	2	80-130	
		<0.55%C	Quenched and tempered	850	250	3	80-120	
		>=0.55%C	Annealed	750	220	4	70-110	
			Quenched and tempered	1000	300	5	50-90	
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	70-120	
			Quenched and tempered		930	275	7	70-110
					1000	300	8	50-90
					1200	350	9	40-70
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	50-90	
			Quenched and tempered	1100	325	11	40-80	
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	40-70		
		Martensitic	820	240	13	40-70		
		Austenitic	600	180	14	30-70		
K	Gray cast iron (GG)	Ferritic		160	15	90-160		
		Pearlitic		250	16	80-140		
	Cast iron nodular (GGG)	Ferritic		180	17	90-180		
		Pearlitic		260	18	80-140		
	Malleable cast iron	Ferritic		130	19	90-160		
		Pearlitic		230	20	80-140		
N	Aluminum - Wrought alloy	Not cureable		60	21	90-220		
		Cured		100	22	90-220		
	Aluminum- cast, alloyed	<=12% Si	Not cureable		75	23	90-220	
			Cured		90	24	90-220	
		>12% Si	High temp.		130	25	80-160	
	Copper alloys	>1% Pb	Free cutting		110	26	90-220	
			Brass		90	27	90-220	
			Electrolitic copper		100	28	90-220	
	Non-metallic		Duroplastics, fiber plastics		70 Shore D	29		
Hard rubber				55 Shore D	30			
S	High temp. alloys	Fe based	Annealed		200	31	30-60	
			Cured		280	32	20-50	
		Ni or Co based	Annealed		250	33	20-50	
			Cured		350	34	20-50	
	Titanium, Ti alloys		Cast		320	35	20-50	
			Pure	Rm 400	190	36	20-50	
			Alpha+beta alloys cured	Rm 1050	310	37	20-50	
H	Hardened steel	Hardened		55HRC	38	20-50		
		Hardened		60HRC	39	20-50		
	Chilled cast iron	Cast		400	40			
	Cast iron nodular	Hardened		55HRC	41			

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for DRILL-RUSH

Feed (mm/rev) vs. drill diameter								
Ø4 - Ø4.9	Ø5 - Ø5.9	Ø6 - Ø7.9	Ø8 - Ø9.9	Ø10 - Ø11.9	Ø12 - Ø13.9	Ø14 - Ø15.9	Ø16 - Ø19.9	Ø20 - Ø25.9
0.04-0.08	0.07-0.11	0.09-0.13	0.12-0.22	0.15-0.28	0.18-0.30	0.20-0.35	0.25-0.45	0.25-0.45
0.04-0.08	0.07-0.11	0.09-0.13	0.12-0.22	0.15-0.28	0.18-0.30	0.20-0.35	0.25-0.45	0.25-0.45
0.04-0.08	0.07-0.11	0.09-0.13	0.12-0.22	0.15-0.28	0.18-0.30	0.20-0.35	0.25-0.45	0.25-0.45
0.04-0.08	0.07-0.11	0.09-0.13	0.12-0.22	0.15-0.28	0.18-0.30	0.20-0.35	0.25-0.45	0.25-0.45
0.04-0.08	0.07-0.11	0.09-0.13	0.12-0.22	0.15-0.28	0.18-0.30	0.20-0.35	0.25-0.45	0.25-0.45
0.04-0.08	0.07-0.13	0.09-0.15	0.12-0.25	0.14-0.28	0.16-0.32	0.18-0.35	0.23-0.40	0.25-0.45
0.04-0.08	0.07-0.13	0.09-0.15	0.12-0.25	0.14-0.28	0.16-0.32	0.18-0.35	0.23-0.40	0.25-0.45
0.04-0.08	0.07-0.13	0.09-0.15	0.12-0.25	0.14-0.28	0.16-0.32	0.18-0.35	0.23-0.40	0.25-0.45
0.04-0.08	0.07-0.13	0.09-0.15	0.12-0.25	0.14-0.28	0.16-0.32	0.18-0.35	0.23-0.40	0.25-0.45
0.06-0.08	0.07-0.11	0.09-0.12	0.12-0.20	0.12-0.22	0.15-0.25	0.18-0.28	0.20-0.30	0.22-0.33
0.06-0.08	0.07-0.11	0.09-0.12	0.12-0.20	0.12-0.22	0.15-0.25	0.18-0.28	0.20-0.30	0.22-0.33
0.05-0.07	0.06-0.08	0.08-0.10	0.10-0.15	0.12-0.18	0.14-0.20	0.16-0.24	0.16-0.26	0.18-0.30
0.05-0.07	0.06-0.08	0.08-0.10	0.10-0.15	0.12-0.18	0.14-0.20	0.16-0.24	0.16-0.26	0.18-0.30
0.05-0.07	0.06-0.08	0.08-0.10	0.10-0.15	0.12-0.18	0.14-0.20	0.16-0.24	0.16-0.26	0.18-0.30
0.04-0.08	0.10-0.15	0.12-0.18	0.15-0.30	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.55	0.35-0.60
0.04-0.08	0.10-0.15	0.12-0.18	0.15-0.30	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.55	0.35-0.60
0.04-0.08	0.10-0.15	0.12-0.18	0.15-0.30	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.55	0.35-0.60
0.04-0.08	0.10-0.15	0.12-0.18	0.15-0.30	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.55	0.35-0.60
0.04-0.08	0.10-0.15	0.12-0.18	0.15-0.30	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.55	0.35-0.60
0.04-0.08	0.10-0.15	0.12-0.18	0.15-0.30	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.55	0.35-0.60
			0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
			0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
			0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
			0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
			0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
			0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
			0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
			0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
		0.05-0.07	0.06-0.11	0.08-0.13	0.10-0.15	0.12-0.18	0.12-0.20	0.14-0.22
		0.05-0.07	0.06-0.11	0.08-0.13	0.10-0.15	0.12-0.18	0.12-0.20	0.14-0.22
		0.05-0.07	0.06-0.11	0.08-0.13	0.10-0.15	0.12-0.18	0.12-0.20	0.14-0.22
		0.05-0.07	0.06-0.11	0.08-0.13	0.10-0.15	0.12-0.18	0.12-0.20	0.14-0.22
		0.05-0.07	0.06-0.11	0.08-0.13	0.10-0.15	0.12-0.18	0.12-0.20	0.14-0.22
		0.05-0.07	0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.20	0.14-0.22	0.16-0.25
		0.05-0.07	0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.20	0.14-0.22	0.16-0.25
		0.05-0.07	0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.20	0.14-0.22	0.16-0.25
		0.05-0.07	0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.20	0.14-0.22	0.16-0.25

Recommended Cutting Conditions



Machining data for MODU-R-DRILL

ISO	Material	Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C Annealed	420	125	1	120-200
		>=0.25%C Annealed	650	190	2	120-200
		<0.55%C Quenched and tempered	850	250	3	130-190
		>=0.55%C Annealed	750	220	4	130-190
		Quenched and tempered	1000	300	5	130-190
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed	600	200	6	100-200
			930	275	7	100-200
		Quenched and tempered	1000	300	8	100-200
			1200	350	9	100-200
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	100-160
		Quenched and tempered	1100	325	11	100-160
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	80-140
		Martensitic	820	240	13	80-140
		Austenitic	600	180	14	80-140
K	Gray cast iron (GG)	Ferritic		160	15	100-250
		Pearlitic		250	16	100-250
	Cast iron nodular (GGG)	Ferritic		180	17	100-250
		Pearlitic		260	18	100-250
	Malleable cast iron	Ferritic		130	19	100-250
		Pearlitic		230	20	100-250
N	Aluminum - Wrought alloy	Not cureable		60	21	160-260
		Cured		100	22	160-260
	Aluminum-cast, alloyed	<=12% Si Not cureable		75	23	160-260
		Cured		90	24	160-260
		>12% Si High temp.		130	25	160-260
	Copper alloys	>1% Pb Free cutting		110	26	160-260
		Brass		90	27	160-260
		Electrolitic copper		100	28	160-260
	Non-metallic	Duroplastics, fiber plastics		70 Shore D	29	
		Hard rubber		55 Shore D	30	
S	High temp. alloys	Fe based Annealed		200	31	30-60
				280	32	30-80
		Ni or Co based Annealed		250	33	30-80
				350	34	30-80
				320	35	30-80
	Titanium, Ti alloys	Pure	Rm 400	190	36	30-80
		Alpha+beta alloys cured	Rm 1050	310	37	30-80
H	Hardened steel	Hardened		55HRC	38	20-50
		Hardened		60HRC	39	20-50
	Chilled cast iron	Cast		400	40	
	Cast iron nodular	Hardened		55HRC	41	

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for MODU-R-DRILL

Feed (mm/rev) vs. drill diameter					
SPGX 06 Ø26 - Ø28	SPGX 07 Ø29 - Ø32	SPGX 09 Ø33 - Ø36	SPGX 11 Ø37 - Ø43	SPGX 11 Ø44 - Ø45	SPGX 14 Ø46 - Ø50
0.20-0.35	0.25-0.35	0.2-0.4	0.25-0.4	0.28-0.45	0.28-0.45
0.20-0.35	0.25-0.35	0.2-0.4	0.25-0.4	0.28-0.45	0.28-0.45
0.20-0.35	0.25-0.35	0.2-0.4	0.25-0.4	0.28-0.45	0.28-0.45
0.20-0.35	0.25-0.35	0.2-0.4	0.25-0.4	0.28-0.45	0.28-0.45
0.20-0.35	0.25-0.35	0.2-0.4	0.25-0.4	0.28-0.45	0.28-0.45
0.20-0.33	0.25-0.33	0.25-0.36	0.25-0.36	0.25-0.40	0.25-0.40
0.20-0.33	0.25-0.33	0.25-0.36	0.25-0.36	0.25-0.40	0.25-0.40
0.20-0.33	0.25-0.33	0.25-0.36	0.25-0.36	0.25-0.40	0.25-0.40
0.20-0.33	0.25-0.33	0.25-0.36	0.25-0.36	0.25-0.40	0.25-0.40
0.20-0.33	0.25-0.33	0.25-0.36	0.25-0.36	0.25-0.40	0.25-0.40
0.12-0.24	0.15-0.24	0.16-0.25	0.18-0.28	0.18-0.30	0.18-0.30
0.12-0.24	0.15-0.24	0.16-0.25	0.18-0.28	0.18-0.30	0.18-0.30
0.12-0.24	0.15-0.24	0.16-0.25	0.18-0.28	0.18-0.30	0.18-0.30
0.25-0.45	0.25-0.45	0.3-0.5	0.3-0.5	0.35-0.55	0.35-0.55
0.25-0.45	0.25-0.45	0.3-0.5	0.3-0.5	0.35-0.55	0.35-0.55
0.25-0.45	0.25-0.45	0.3-0.5	0.3-0.5	0.35-0.55	0.35-0.55
0.25-0.45	0.25-0.45	0.3-0.5	0.3-0.5	0.35-0.55	0.35-0.55
0.25-0.45	0.25-0.45	0.3-0.5	0.3-0.5	0.35-0.55	0.35-0.55
0.25-0.45	0.25-0.45	0.3-0.5	0.3-0.5	0.35-0.55	0.35-0.55
0.3-0.5	0.3-0.5	0.35-0.55	0.35-0.55	0.4-0.6	0.4-0.6
0.3-0.5	0.3-0.5	0.35-0.55	0.35-0.55	0.4-0.6	0.4-0.6
0.3-0.5	0.3-0.5	0.35-0.55	0.35-0.55	0.4-0.6	0.4-0.6
0.3-0.5	0.3-0.5	0.35-0.55	0.35-0.55	0.4-0.6	0.4-0.6
0.3-0.5	0.3-0.5	0.35-0.55	0.35-0.55	0.4-0.6	0.4-0.6
0.3-0.5	0.3-0.5	0.35-0.55	0.35-0.55	0.4-0.6	0.4-0.6
0.3-0.5	0.3-0.5	0.35-0.55	0.35-0.55	0.4-0.6	0.4-0.6
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24	0.16-0.24
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24	0.16-0.24
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24	0.16-0.24
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24	0.16-0.24
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24	0.16-0.24
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24	0.16-0.24
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24	0.16-0.24
0.1-0.16	0.12-0.18	0.14-0.20	0.14-0.20	0.16-0.22	0.16-0.22
0.1-0.16	0.12-0.18	0.14-0.20	0.14-0.20	0.16-0.22	0.16-0.22

Recommended Cutting Conditions



Machining data for SPADE-RUSH

ISO	Material		Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	80-140
		>=0.25%C	Annealed	650	190	2	80-130
		<0.55%C	Quenched and tempered	850	250	3	80-120
		>=0.55%C	Annealed	750	220	4	70-110
			Quenched and tempered	1000	300	5	50-90
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	80-120
			Quenched and tempered	930	275	7	70-110
				1000	300	8	50-90
				1200	350	9	40-70
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	50-90
			Quenched and tempered	1100	325	11	40-80
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	40-70	
		Martensitic	820	240	13	40-70	
		Austenitic	600	180	14	30-70	
K	Gray cast iron (GG)	Ferritic		160	15	90-180	
		Pearlitic		250	16	80-140	
	Cast iron nodular (GGG)	Ferritic		180	17	90-165	
		Pearlitic		260	18	80-140	
	Malleable cast iron	Ferritic		130	19	90-160	
		Pearlitic		230	20	80-140	
N	Aluminum - Wrought alloy	Not cureable		60	21	90-220	
		Cured		100	22	90-220	
	Aluminum- cast, alloyed	<=12% Si	Not cureable		75	23	90-220
			Cured		90	24	90-220
	>12% Si	High temp.		130	25	80-160	
	Copper alloys	>1% Pb	Free cutting		110	26	90-220
			Brass		90	27	90-220
			Electrolitic copper		100	28	90-220
	Non-metallic		Duroplastics, fiber plastics		70 Shore D	29	
Hard rubber				55 Shore D	30		
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	20-50
		Ni or Co based	Annealed		250	33	20-50
			Cured		350	34	20-50
			Cast		320	35	20-50
	Titanium, Ti alloys	Pure	Rm 400	190	36	20-50	
		Alpha+beta alloys cured	Rm 1050	310	37	20-50	
H	Hardened steel	Hardened		55HRC	38	20-50	
		Hardened		60HRC	39	20-50	
	Chilled cast iron	Cast		400	40		
	Cast iron nodular	Hardened		55HRC	41		

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for SPADE-RUSH

Feed (mm/rev) vs. drill diameter						
Ø20 - Ø25.9		Ø26 - Ø29.9		Ø30 - Ø34.9		Ø35 - Ø41
LCD...-P	LCD...-P+	LCD...-P	LCD...-P+	LCD...-P	LCD...-P+	
0.30-0.50	0.25-0.45	0.30-0.50	0.30-0.50	0.30-0.50	0.30-0.50	0.35-0.55
0.30-0.50	0.25-0.45	0.30-0.50	0.30-0.50	0.30-0.50	0.30-0.50	0.35-0.55
0.30-0.50	0.25-0.45	0.30-0.50	0.30-0.50	0.30-0.50	0.30-0.50	0.35-0.55
0.30-0.50	0.25-0.45	0.30-0.50	0.30-0.50	0.30-0.50	0.30-0.50	0.35-0.55
0.30-0.50	0.25-0.45	0.30-0.50	0.30-0.50	0.30-0.50	0.30-0.50	0.35-0.55
0.25-0.45	0.20-0.40	0.25-0.45	0.25-0.45	0.25-0.45	0.25-0.45	0.30-0.50
0.25-0.45	0.20-0.40	0.25-0.45	0.25-0.45	0.25-0.45	0.25-0.45	0.30-0.50
0.25-0.45	0.20-0.40	0.25-0.45	0.25-0.45	0.25-0.45	0.25-0.45	0.30-0.50
0.25-0.45	0.20-0.40	0.25-0.45	0.25-0.45	0.25-0.45	0.25-0.45	0.30-0.50
0.25-0.35	0.20-0.30	0.25-0.35	0.25-0.35	0.25-0.35	0.25-0.35	0.30-0.40
0.25-0.35	0.20-0.30	0.25-0.35	0.25-0.35	0.25-0.35	0.25-0.35	0.30-0.40
0.15-0.30		0.15-0.30		0.15-0.30		0.20-0.35
0.15-0.30		0.15-0.30		0.15-0.30		0.20-0.35
0.15-0.30		0.15-0.30		0.15-0.30		0.20-0.35
0.35-0.55	0.30-0.50	0.35-0.55	0.35-0.55	0.35-0.55	0.35-0.55	0.40-0.60
0.35-0.55	0.30-0.50	0.35-0.55	0.35-0.55	0.35-0.55	0.35-0.55	0.40-0.60
0.35-0.55	0.30-0.50	0.35-0.55	0.35-0.55	0.35-0.55	0.35-0.55	0.40-0.60
0.35-0.55	0.30-0.50	0.35-0.55	0.35-0.55	0.35-0.55	0.35-0.55	0.40-0.60
0.35-0.55	0.30-0.50	0.35-0.55	0.35-0.55	0.35-0.55	0.35-0.55	0.40-0.60
0.35-0.55	0.30-0.50	0.35-0.55	0.35-0.55	0.35-0.55	0.35-0.55	0.40-0.60
0.40-0.60		0.40-0.60		0.40-0.60		0.50-0.70
0.40-0.60		0.40-0.60		0.40-0.60		0.50-0.70
0.40-0.60		0.40-0.60		0.40-0.60		0.50-0.70
0.40-0.60		0.40-0.60		0.40-0.60		0.50-0.70
0.40-0.60		0.40-0.60		0.40-0.60		0.50-0.70
0.40-0.60		0.40-0.60		0.40-0.60		0.50-0.70
0.40-0.60		0.40-0.60		0.40-0.60		0.50-0.70
0.10-0.20		0.10-0.20		0.15-0.25		0.15-0.25
0.10-0.20		0.10-0.20		0.15-0.25		0.15-0.25
0.10-0.20		0.10-0.20		0.15-0.25		0.15-0.25
0.10-0.20		0.10-0.20		0.15-0.25		0.15-0.25
0.10-0.20		0.10-0.20		0.15-0.25		0.15-0.25
0.10-0.20		0.10-0.20		0.15-0.25		0.15-0.25
0.10-0.20		0.10-0.20		0.15-0.25		0.15-0.25
0.10-0.20		0.10-0.20		0.15-0.25		0.15-0.25

Recommended Cutting Conditions



Machining data for SOLID-3-DRILL

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	80-140
		>=0.25%C	Annealed	650	190	2	80-130
		<0.55%C	Quenched and tempered	850	250	3	80-120
		>=0.55%C	Annealed	750	220	4	70-110
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Quenched and tempered	1000	300	5	50-90
		Annealed	600	200	6	80-120	
			Quenched and tempered	930	275	7	70-110
				1000	300	8	50-90
		1200	350	9	40-70		
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	50-90	
		Quenched and tempered	1100	325	11	40-80	
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12		
		Martensitic	820	240	13		
		Austenitic	600	180	14		
K	Gray cast iron (GG)	Ferritic		160	15	80-140	
		Pearlitic		250	16	70-120	
	Cast iron nodular (GGG)	Ferritic		180	17	80-120	
		Pearlitic		260	18	70-110	
	Malleable cast iron	Ferritic		130	19	80-120	
Pearlitic			230	20	70-110		
N	Aluminum - Wrought alloy	Not cureable		60	21		
		Cured		100	22		
	Aluminum- cast, alloyed	<=12% Si	Not cureable		75	23	
			Cured		90	24	
		>12% Si	High temp.		130	25	
	Copper alloys	>1% Pb	Free cutting		110	26	
		Brass			90	27	
			Electrolitic copper			100	28
	Non-metallic	Duroplastics, fiber plastics			70 Shore D	29	
		Hard rubber			55 Shore D	30	
S	High temp. alloys	Fe based	Annealed		200	31	
			Cured		280	32	
		Ni or Co based	Annealed		250	33	
			Cured		350	34	
			Cast		320	35	
	Titanium, Ti alloys	Pure	Rm 400	190	36		
		Alpha+beta alloys cured	Rm 1050	310	37		
H	Hardened steel	Hardened		55HRC	38		
		Hardened		60HRC	39		
	Chilled cast iron	Cast		400	40		
	Cast iron nodular	Hardened		55HRC	41		

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

[illegible]

Recommended Cutting Conditions



Machining data for H-DRILL

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	80-120
		>=0.25%C	Annealed	650	190	2	80-110
		<0.55%C	Quenched and tempered	850	250	3	70-100
		>=0.55%C	Annealed	750	220	4	70-100
			Quenched and tempered	1000	300	5	70-100
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	70-90
			Quenched and tempered	930	275	7	70-90
				1000	300	8	50-80
				1200	350	9	40-70
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	50-80
			Quenched and tempered	1100	325	11	40-70
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	30-60	
		Martensitic	820	240	13	30-60	
		Austenitic	600	180	14	30-60	
K	Gray cast iron (GG)	Ferritic		160	15	65-80	
		Pearlitic		250	16	65-80	
	Cast iron nodular (GGG)	Ferritic		180	17	85-105	
		Pearlitic		260	18	75-90	
	Malleable cast iron	Ferritic		130	19	65-80	
Pearlitic			230	20	65-80		
N	Aluminum - Wrought alloy	Not cureable		60	21	70-200	
		Cured		100	22	70-200	
	Aluminum- cast, alloyed	<=12% Si	Not cureable		75	23	70-200
			Cured		90	24	70-200
		>12% Si	High temp.		130	25	70-150
	Copper alloys	>1% Pb	Free cutting		110	26	70-200
			Brass		90	27	70-200
			Electrolitic copper		100	28	70-200
	Non-metallic	Duroplastics, fiber plastics		70 Shore D	29		
Hard rubber			55 Shore D	30			
S	High temp. alloys	Fe based	Annealed		200	31	15-40
			Cured		280	32	15-40
		Ni or Co based	Annealed		250	33	15-40
			Cured		350	34	15-40
			Cast		320	35	15-40
	Titanium, Ti alloys	Pure	Rm 400	190	36		
		Alpha+beta alloys cured	Rm 1050	310	37		
H	Hardened steel	Hardened		55HRC	38	10-40	
		Hardened		60HRC	39	10-40	
	Chilled cast iron	Cast		400	40		
	Cast iron nodular	Hardened		55HRC	41		

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for H-DRILL

Feed (mm/rev) vs. drill diameter		
Ø3 - Ø5	Ø5.1 - Ø8	Ø8.1 - Ø12
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.08-0.18	0.10-0.20	0.15-0.25
0.08-0.18	0.10-0.20	0.15-0.25
0.06-0.12	0.10-0.15	0.12-0.18
0.06-0.12	0.10-0.15	0.12-0.18
0.06-0.12	0.10-0.15	0.12-0.18
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.25	0.15-0.35	0.25-0.45
0.10-0.25	0.15-0.35	0.25-0.45
0.10-0.25	0.15-0.35	0.25-0.45
0.10-0.25	0.15-0.35	0.25-0.45
0.10-0.25	0.15-0.35	0.25-0.45
0.08-0.18	0.15-0.25	0.20-0.35
0.08-0.18	0.15-0.25	0.20-0.35
0.08-0.18	0.15-0.25	0.20-0.35
0.02-0.08	0.04-0.10	0.06-0.12
0.02-0.08	0.04-0.10	0.06-0.12
0.02-0.08	0.04-0.10	0.06-0.12
0.02-0.08	0.04-0.10	0.06-0.12
0.02-0.08	0.04-0.10	0.06-0.12
0.02-0.08	0.04-0.10	0.06-0.12
0.02-0.08	0.04-0.10	0.06-0.12

Recommended Cutting Conditions



Machining data for TBTA 3/5/7/9 & TBTA-R

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	60-120
		>=0.25%C	Annealed	650	190	2	60-120
		<0.55%C	Quenched and tempered	850	250	3	60-120
		>=0.55%C	Annealed	750	220	4	60-120
			Quenched and tempered	1000	300	5	50-100
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	50-100
			Quenched and tempered	930	275	7	50-100
				1000	300	8	50-100
				1200	350	9	50-100
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	60-120
			Quenched and tempered	1100	325	11	60-120
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	60-110	
		Martensitic	820	240	13	60-110	
		Austenitic	600	180	14	60-110	
K	Gray cast iron (GG)	Ferritic		160	15	60-100	
		Pearlitic		250	16	60-100	
	Cast iron nodular (GGG)	Ferritic		180	17	60-100	
		Pearlitic		260	18	60-100	
	Malleable cast iron	Ferritic		130	19	60-100	
Pearlitic			230	20	60-100		
N	Aluminum - Wrought alloy	Not cureable		60	21	60-130	
		Cured		100	22	60-130	
	Aluminum- cast, alloyed	<=12% Si	Not cureable		75	23	60-130
			Cured		90	24	60-130
		>12% Si	High temp.		130	25	60-130
	Copper alloys	>1% Pb	Free cutting		110	26	60-130
			Brass		90	27	60-130
			Electrolitic copper		100	28	60-130
	Non-metallic		Duroplastics, fiber plastics		70 Shore D	29	
Hard rubber				55 Shore D	30		
S	High temp. alloys	Fe based	Annealed		200	31	20-65
			Cured		280	32	20-65
		Ni or Co based	Annealed		250	33	20-65
			Cured		350	34	20-65
			Cast		320	35	20-65
	Titanium, Ti alloys	Pure	Rm 400	190	36	30-100	
		Alpha+beta alloys cured	Rm 1050	310	37	30-100	
H	Hardened steel	Hardened		55HRC	38		
		Hardened		60HRC	39		
	Chilled cast iron	Cast		400	40		
	Cast iron nodular	Hardened		55HRC	41		

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for TBTA 3/5/7/9 & TBTA-R

Feed (mm/rev) vs. drill diameter				
Ø38.00 - Ø39.99	Ø40.00 - Ø51.99	Ø52.00 - Ø63.99	Ø64.00 - Ø84.99	Ø85.00 -
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.13	0.10-0.15	0.13-0.18	0.15-0.20	0.18-0.23
0.08-0.13	0.10-0.15	0.13-0.18	0.15-0.20	0.18-0.23
0.08-0.13	0.10-0.15	0.13-0.18	0.15-0.20	0.18-0.23
0.08-0.13	0.10-0.15	0.13-0.18	0.15-0.20	0.18-0.23
0.08-0.13	0.10-0.15	0.13-0.18	0.15-0.20	0.18-0.23
0.08-0.13	0.10-0.15	0.13-0.18	0.15-0.20	0.18-0.23
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30

Recommended Cutting Conditions



Machining data for TBTA-FB

ISO	Material	Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C Annealed	420	125	1	70-130
		>=0.25%C Annealed	650	190	2	70-130
		<0.55%C Quenched and tempered	850	250	3	70-130
		>=0.55%C Annealed	750	220	4	70-130
		Quenched and tempered	1000	300	5	70-130
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed	600	200	6	70-120
			930	275	7	60-120
		Quenched and tempered	1000	300	8	60-120
			1200	350	9	60-120
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	70-130
		Quenched and tempered	1100	325	11	70-130
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	70-130
		Martensitic	820	240	13	70-130
		Austenitic	600	180	14	70-130
K	Gray cast iron (GG)	Ferritic		160	15	60-110
		Pearlitic		250	16	60-110
	Cast iron nodular (GGG)	Ferritic		180	17	50-110
		Pearlitic		260	18	50-110
	Malleable cast iron	Ferritic		130	19	70-110
		Pearlitic		230	20	70-110
N	Aluminum - Wrought alloy	Not cureable		60	21	65-130
		Cured		100	22	65-130
	Aluminum-cast, alloyed	<=12% Si Not cureable		75	23	65-130
		Cured		90	24	65-130
		>12% Si High temp.		130	25	65-130
	Copper alloys	>1% Pb Free cutting		110	26	65-130
		Brass		90	27	65-130
		Electrolitic copper		100	28	65-130
S	High temp. alloys	Fe based Annealed		70 Shore D	29	
				55 Shore D	30	
		Cured		200	31	20-50
				280	32	20-50
		Ni or Co based Annealed		250	33	20-50
				350	34	20-50
	Titanium, Ti alloys	Cast		320	35	20-50
		Pure	Rm 400	190	36	30-60
		Alpha+beta alloys cured	Rm 1050	310	37	30-60
H	Hardened steel	Hardened		55HRC	38	
		Hardened		60HRC	39	
	Chilled cast iron	Cast		400	40	
	Cast iron nodular	Hardened		55HRC	41	

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for TBTA-FB

Feed (mm/rev) vs. drill diameter			
Ø25.00 - Ø43.00	Ø43.01 - Ø65.00		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.25	0.12-0.35		
0.10-0.25	0.12-0.35		
0.10-0.25	0.12-0.35		
0.10-0.25	0.12-0.35		
0.10-0.25	0.12-0.35		
0.10-0.25	0.12-0.35		
0.10-0.25	0.12-0.35		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		

Recommended Cutting Conditions



Machining data for BTA & BTS

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	70-120
		>=0.25%C	Annealed	650	190	2	70-120
		<0.55%C	Quenched and tempered	850	250	3	40-70
		>=0.55%C	Annealed	750	220	4	70-120
			Quenched and tempered	1000	300	5	55-100
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed		600	200	6	70-100
				930	275	7	55-100
		Quenched and tempered		1000	300	8	55-100
				1200	350	9	55-100
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	50-85	
Quenched and tempered		1100	325	11	55-100		
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	60-100	
		Martensitic	820	240	13	60-100	
		Austenitic	600	180	14	60-100	
K	Gray cast iron (GG)	Ferritic		160	15	60-100	
		Pearlitic		250	16	60-100	
	Cast iron nodular (GGG)	Ferritic		180	17	80-100	
		Pearlitic		260	18	80-100	
	Malleable cast iron	Ferritic		130	19	50-100	
Pearlitic			230	20	50-100		
N	Aluminum - Wrought alloy	Not cureable		60	21	65-130	
		Cured		100	22	65-100	
	Aluminum- cast, alloyed	<=12% Si	Not cureable	75	23	65-130	
			Cured	90	24	65-130	
	>12% Si	High temp.	130	25	65-130		
		>1% Pb	Free cutting	110	26	65-130	
	Copper alloys	Brass	90	27	65-130		
		Electrolitic copper		100	28	65-130	
	Non-metallic	Duroplastics, fiber plastics		70 Shore D	29		
Hard rubber			55 Shore D	30			
S	High temp. alloys	Fe based	Annealed		200	31	10-50
			Cured		280	32	10-50
		Ni or Co based	Annealed		250	33	10-50
			Cured		350	34	10-50
			Cast		320	35	10-50
	Titanium, Ti alloys	Pure	Rm 400	190	36	30-50	
		Alpha+beta alloys cured	Rm 1050	310	37	30-50	
H	Hardened steel	Hardened		55HRC	38		
		Hardened		60HRC	39		
	Chilled cast iron	Cast		400	40		
	Cast iron nodular	Hardened		55HRC	41		

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel



Machining data for BTA & BTS

Feed (mm/rev) vs. drill diameter				
Ø8.00 - Ø20.00	Ø15.60 - Ø20.00	Ø20.01 - Ø31.00	Ø31.01 - Ø43.00	Ø43.01 - Ø65.00
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.10	0.08-0.12	0.10-0.15	0.13-0.17	0.15-0.28
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.10	0.08-0.12	0.10-0.15	0.13-0.17	0.15-0.28
0.05-0.10	0.08-0.12	0.10-0.15	0.13-0.17	0.15-0.28
0.05-0.10	0.08-0.12	0.10-0.15	0.13-0.17	0.15-0.28
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.10	0.08-0.12	0.10-0.15	0.13-0.17	0.15-0.28
0.05-0.13	0.08-0.15	0.10-0.28	0.13-0.30	0.16-0.35
0.05-0.13	0.08-0.15	0.10-0.28	0.13-0.30	0.16-0.35
0.05-0.12	0.05-0.12	0.08-0.25	0.10-0.28	0.15-0.33
0.05-0.13	0.06-0.13	0.08-0.18	0.10-0.20	0.15-0.25
0.05-0.13	0.06-0.13	0.08-0.18	0.10-0.20	0.15-0.25
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.13	0.06-0.13	0.08-0.18	0.10-0.20	0.15-0.25
0.05-0.13	0.06-0.13	0.08-0.18	0.10-0.20	0.15-0.25
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.12	0.06-0.12	0.08-0.15	0.12-0.18	0.15-0.25
0.05-0.12	0.06-0.12	0.08-0.15	0.12-0.18	0.15-0.25
0.05-0.12	0.06-0.12	0.08-0.15	0.12-0.18	0.15-0.25
0.05-0.12	0.06-0.12	0.08-0.15	0.12-0.18	0.15-0.25
0.05-0.12	0.06-0.12	0.08-0.15	0.12-0.18	0.15-0.25
0.05-0.10	0.05-0.10	0.08-0.12	0.10-0.15	0.12-0.20
0.05-0.10	0.05-0.10	0.08-0.12	0.10-0.15	0.12-0.20

Recommended Cutting Conditions



Machining data for WIN-GUN

ISO	Material	Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C Annealed	420	125	1	80-110-140
		>=0.25%C Annealed	650	190	2	80-105-130
		<0.55%C Quenched and tempered	850	250	3	80-100-120
		>=0.55%C Annealed	750	220	4	70-90-110
		Quenched and tempered	1000	300	5	50-70-90
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed	600	200	6	80-100-120
		Quenched and tempered	930	275	7	70-90-110
			1000	300	8	50-70-90
			1200	350	9	40-55-70
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	50-70-90
		Quenched and tempered	1100	325	11	40-60-80
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	40-55-70
		Martensitic	820	240	13	
K	Gray cast iron (GG)	Ferritic		160	15	90-125-160
		Pearlitic		250	16	80-110-140
	Cast iron nodular (GGG)	Ferritic		180	17	90-135-180
		Pearlitic		260	18	80-110-140
	Malleable cast iron	Ferritic		130	19	90-125-160
		Pearlitic		230	20	80-110-140
N	Aluminum - Wrought alloy	Not cureable		60	21	90-155-220
		Cured		100	22	
	Aluminum-cast, alloyed	<=12% Si Not cureable		75	23	
		Cured		90	24	
		>12% Si High temp.		130	25	80-120-160

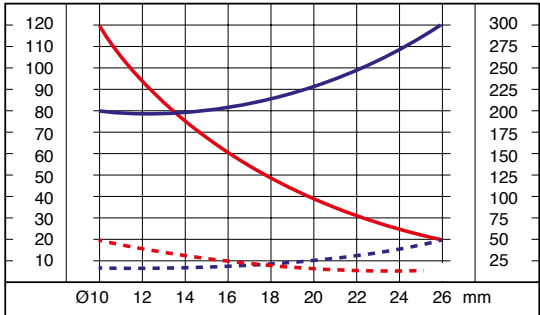
► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous

Pressure and Coolant Flow Rate for WIN-GUN

Pressure (Bar)

Coolant Flow Rate (l/min)



Drilling Diameter (mm)

Q (l/min) P (bar)

— — GUN-DRILL Machines
- - - - - - Milling and Turning Machines

Recommended Cutting Conditions



Machining data for WIN-GUN

Feed (mm/rev) vs. drill diameter				
Ø10 - Ø11.9	Ø12 - Ø13.9	Ø14 - Ø15.9	Ø16 - Ø19.9	Ø20 - Ø25.9
0.15 0.18 0.21	0.18 0.21 0.24	0.20 0.23 0.27	0.25 0.30 0.35	0.25 0.30 0.35
0.14 0.17 0.21	0.16 0.20 0.24	0.18 0.22 0.26	0.23 0.27 0.31	0.25 0.30 0.35
0.12 0.14 0.17	0.15 0.17 0.20	0.18 0.20 0.23	0.20 0.22 0.25	0.22 0.24 0.27
0.12 0.13 0.15	0.14 0.15 0.17	0.16 0.18 0.20	0.16 0.19 0.21	0.18 0.21 0.24
0.20 0.23 0.27	0.25 0.28 0.32	0.30 0.33 0.37	0.35 0.40 0.45	0.35 0.42 0.47
0.25 0.28 0.32	0.30 0.33 0.37	0.35 0.38 0.42	0.40 0.45 0.50	0.45 0.50 0.57

- **Red text:** Recommended cutting data
- Mandatory use of emulsion or oil when drilling
- For the 400 mm long tools, please reduce the cutting speed by 20%

Recommended Cutting Conditions



Machining data for TRGD / TRGD3 / TRGDL / TBTA-TR

ISO	Material	Condition	Tensile strength (N/mm²)	Hardness HB	Material No.
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C Annealed	420	125	1
		≥0.25%C Annealed	650	190	2
		<0.55%C Quenched and tempered	850	250	3
		≥0.55%C Annealed	750	220	4
		Quenched and tempered	1000	300	5
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed	600	200	6
		Quenched and tempered	930	275	7
			1000	300	8
			1200	350	9
	High alloy steel, cast steel and tool steel	Annealed	680	200	10
		Quenched and tempered	1100	325	11
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12
		Martensitic	820	240	13
		Austenitic	600	180	14
K	Gray cast iron (GG)	Ferritic		160	15
		Pearlitic		250	16
	Cast iron nodular (GGG)	Ferritic		180	17
		Pearlitic		260	18
	Malleable cast iron	Ferritic		130	19
		Pearlitic		230	20
N	Aluminum - Wrought alloy	Not cureable		60	21
		Cured		100	22
	Aluminum-cast, alloyed	≤12% Si Not cureable		75	23
		Cured		90	24
		>12% Si High temp.		130	25
	Copper alloys	>1% Pb Free cutting		110	26
		Brass		90	27
		Electrolitic copper		100	28
	Non-metallic	Duroplastics, fiber plastics		70 Shore D	29
		Hard rubber		55 Shore D	30
S	High temp. alloys	Fe based	Annealed	200	31
			Cured	280	32
		Ni or Co based	Annealed	250	33
			Cured	350	34
			Cast	320	35
	Titanium, Ti alloys	Pure	Rm 400	190	36
		Alpha+beta alloys cured	Rm 1050	310	37
H	Hardened steel	Hardened		55 HRC	38
		Hardened		60 HRC	39
	Chilled cast iron	Cast		400	40
	Cast iron nodular	Hardened		55 HRC	41

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for TRGD / TRGD3 / TRGDL / TBTA-TR

Feed (mm/rev) vs. drill diameter							
TRGD / TRGD3 / TRGDL						TBTA-TR	
Cutting speed Vc (m/min)	Ø10.00-Ø11.80	Ø12.00-Ø13.99	Ø14.00-Ø15.99	Ø16.00-Ø28.00	Ø28.01-Ø40.00	Cutting speed Vc (m/min)	Ø16.00-Ø28.00
80-140	0.05-0.08	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.15	90-130	0.15-0.20
80-140	0.05-0.14	0.05-0.16	0.05-0.10	0.05-0.10	0.05-0.15	90-130	0.15-0.20
80-140	0.05-0.14	0.05-0.16	0.05-0.16	0.05-0.20	0.05-0.20	90-130	0.15-0.20
80-140	0.05-0.14	0.05-0.16	0.05-0.16	0.05-0.20	0.05-0.20	70-130	0.10-0.25
80-140	0.05-0.14	0.05-0.16	0.05-0.16	0.05-0.20	0.05-0.20	70-130	0.10-0.25
80-140	0.05-0.14	0.05-0.16	0.05-0.10	0.05-0.10	0.05-0.15	70-120	0.10-0.25
80-120	0.05-0.14	0.05-0.16	0.05-0.16	0.05-0.20	0.05-0.20	60-120	0.10-0.25
80-120			0.05-0.16	0.05-0.20	0.05-0.20	60-120	0.10-0.25
80-120			0.05-0.16	0.05-0.20	0.05-0.20	60-120	0.10-0.25
80-140			0.05-0.10	0.05-0.10	0.05-0.15	70-130	0.10-0.25
80-120			0.05-0.16	0.05-0.20	0.05-0.20	70-130	0.10-0.25
60-100	0.05-0.08	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.15	80-130	0.06-0.10
60-100	0.05-0.08	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.15	80-130	0.06-0.10
60-100	0.05-0.08	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.15	80-130	0.06-0.10
80-140	0.05-0.20	0.05-0.25	0.05-0.25	0.05-0.30	0.05-0.30	50-110	0.10-0.20
80-140	0.05-0.20	0.05-0.25	0.05-0.25	0.05-0.30	0.05-0.30	50-110	0.10-0.20
80-140	0.05-0.20	0.05-0.25	0.05-0.25	0.05-0.30	0.05-0.30	60-110	0.10-0.20
80-140	0.05-0.20	0.05-0.25	0.05-0.25	0.05-0.30	0.05-0.30	60-110	0.10-0.20
80-140			0.05-0.25	0.05-0.30	0.05-0.30	70-110	0.10-0.20
80-140			0.05-0.25	0.05-0.30	0.05-0.30	70-110	0.10-0.20
100-200	0.05-0.18	0.05-0.20	0.05-0.20	0.05-0.20	0.05-0.25	65-130	0.08-0.18
100-200	0.05-0.18	0.05-0.20	0.05-0.20	0.05-0.20	0.05-0.25	65-130	0.08-0.18
100-200	0.05-0.18	0.05-0.20	0.05-0.20	0.05-0.20	0.05-0.25	65-130	0.08-0.18
100-200	0.05-0.18	0.05-0.20	0.05-0.20	0.05-0.20	0.05-0.25	65-130	0.08-0.18
						65-130	0.08-0.18
						65-130	0.08-0.18
						65-130	0.08-0.18
						65-130	0.08-0.18
						65-130	0.08-0.18
						65-130	0.08-0.18
20-50	0.04-0.06	0.04-0.08	0.04-0.08	0.04-0.10	0.04-0.13	20-50	0.08-0.18
20-50	0.04-0.06	0.04-0.08	0.04-0.08	0.04-0.10	0.04-0.13	20-50	0.08-0.18
20-50	0.04-0.06	0.04-0.08	0.04-0.08	0.04-0.10	0.04-0.13	20-50	0.08-0.18
20-50	0.04-0.06	0.04-0.08	0.04-0.08	0.04-0.10	0.04-0.13	20-50	0.08-0.18
20-50	0.04-0.06	0.04-0.08	0.04-0.08	0.04-0.10	0.04-0.13	20-50	0.08-0.18
30-60	0.04-0.10	0.05-0.13	0.05-0.13	0.05-0.15	0.05-0.18	30-60	0.08-0.18
30-60	0.04-0.10	0.05-0.13	0.05-0.13	0.05-0.15	0.05-0.18	30-60	0.08-0.18
50-100	0.04-0.06	0.04-0.08	0.04-0.08	0.04-0.10	0.04-0.13		
50-100	0.04-0.06	0.04-0.08	0.04-0.08	0.04-0.10	0.04-0.13		
50-100	0.04-0.06	0.04-0.08	0.04-0.08	0.04-0.10	0.04-0.13		
50-100	0.04-0.06	0.04-0.08	0.04-0.08	0.04-0.10	0.04-0.13		

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Recommended Cutting Conditions



Machining data for XM-REAM

ISO	Material	Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)	Feed (mm/rev) vs. reamer diameter		
							Ø8-9.99	Ø10-11.99	Ø12-12.99
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C Annealed	420	125	1	50-150	0.25-0.50	0.30-0.60	0.35-0.80
		>=0.25%C Annealed	650	190	2	50-150	0.25-0.50	0.30-0.60	0.35-0.80
		<0.55%C Quenched and tempered	850	250	3	50-150	0.25-0.50	0.30-0.60	0.35-0.80
		>=0.55%C Annealed	750	220	4	50-150	0.25-0.50	0.30-0.60	0.35-0.80
		Quenched and tempered	1000	300	5	50-150	0.25-0.50	0.30-0.60	0.35-0.80
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed	600	200	6	50-150	0.25-0.50	0.30-0.60	0.35-0.80
			930	275	7	50-150	0.25-0.50	0.30-0.60	0.35-0.80
		Quenched and tempered	1000	300	8	50-150	0.25-0.50	0.30-0.60	0.35-0.80
			1200	350	9	50-150	0.25-0.50	0.30-0.60	0.35-0.80
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	20-60	0.20-0.30	0.25-0.40	0.30-0.50
		Quenched and tempered	1100	325	11	20-60	0.20-0.30	0.25-0.40	0.30-0.50
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	20-40	0.20-0.30	0.25-0.40	0.30-0.50
		Martensitic	820	240	13	20-40	0.20-0.30	0.25-0.40	0.30-0.50
		Austenitic	600	180	14	20-40	0.20-0.30	0.25-0.40	0.30-0.50
K	Gray cast iron (GG)	Ferritic		160	15	50-200	0.30-0.60	0.35-0.80	0.40-1.00
		Pearlitic		250	16	50-200	0.30-0.60	0.35-0.80	0.40-1.00
	Cast iron nodular (GGG)	Ferritic		180	17	50-200	0.30-0.60	0.35-0.80	0.40-1.00
		Pearlitic		260	18	50-200	0.30-0.60	0.35-0.80	0.40-1.00
	Malleable cast iron	Ferritic		130	19	50-200	0.30-0.60	0.35-0.80	0.40-1.00
		Pearlitic		230	20	50-200	0.30-0.60	0.35-0.80	0.40-1.00
N	Aluminum - Wrought alloy	Not cureable		60	21	100-250	0.30-0.60	0.35-0.80	0.40-1.00
		Cured		100	22	100-250	0.30-0.60	0.35-0.80	0.40-1.00
	Aluminum-cast, alloyed	<=12% Si Not cureable		75	23	100-250	0.30-0.60	0.35-0.80	0.40-1.00
		Cured		90	24	100-250	0.30-0.60	0.35-0.80	0.40-1.00
	>12% Si	High temp.		130	25	100-250	0.30-0.60	0.35-0.80	0.40-1.00
		Free cutting		110	26	100-250	0.30-0.60	0.35-0.80	0.40-1.00
	Copper alloys	Brass		90	27	100-250	0.30-0.60	0.35-0.80	0.40-1.00
		Electrolitic copper		100	28	100-250	0.30-0.60	0.35-0.80	0.40-1.00
S	High temp. alloys	Fe based							
		Ni or Co based							
	Titanium, Ti alloys	Pure	Rm 400	190	36				
		Alpha+beta alloys cured	Rm 1050	310	37				
H	Hardened steel	Hardened		55 HRC	38				
		Hardened		60 HRC	39				
	Chilled cast iron	Cast		400	40				
	Cast iron nodular	Hardened		55 HRC	41				

► For more information of material groups, see the materials & grades "material conversion table"

Steel Stainless steel Cast iron Nonferrous High temp. alloys Hardened steel

Recommended Cutting Conditions



Machining data for TM-REAM - Through hole

ISO	Material	Condition	Material No.	Through hole		Interrupted through Hole		
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	1	TT9030	BL	TT9030	BL
		>=0.25%C	Annealed	2	Vc = 80 - 200		Vc = 60 - 120	
		<0.55%C	Quenched and tempered	3	B4 - B6	fz = 0.08 - 0.21	B4 - B6	fz = 0.08 - 0.21
		>=0.55%C	Annealed	4				
		Quenched and tempered	5	B7 - B9	fz = 0.12 - 0.27	B7 - B9	fz = 0.09 - 0.21	
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed	6	TT9030	BL	TT9030	BL	
		Quenched and tempered	7	Vc = 80 - 200		Vc = 60 - 120		
			8	B4 - B6	fz = 0.08 - 0.21	B4 - B6	fz = 0.08 - 0.21	
			9	B7 - B9	fz = 0.12 - 0.27	B7 - B9	fz = 0.09 - 0.21	
	High alloy steel, cast steel and tool steel	Annealed	10	TT9030	BL	TT9030	BL	
		Quenched and tempered	11	Vc = 20 - 60		Vc = 20 - 60		
B4 - B6				fz = 0.05 - 0.13	B4 - B6	fz = 0.04 - 0.11		
M	Stainless steel and cast steel	Ferritic / martensitic	12	TT9030	BL	TT9030	BL	
		Martensitic	13	Vc = 20 - 40		Vc = 20 - 40		
				B4 - B6	fz = 0.05 - 0.13	B4 - B6	fz = 0.04 - 0.11	
				B7 - B9	fz = 0.07 - 0.17	B7 - B9	fz = 0.05 - 0.14	
K	Gray cast iron (GG)	Ferritic	15	TT9030	BL	TT9030	BL	
		Pearlitic	16	Vc = 120 - 220		Vc = 80 - 200		
				B4 - B6	fz = 0.08 - 0.18	B4 - B6	fz = 0.05 - 0.13	
				B7 - B9	fz = 0.10 - 0.24	B7 - B9	fz = 0.07 - 0.17	
	Cast iron nodular (GGG)	Ferritic	17	TT9030	AS or BL	TT9030	BL	
		Pearlitic	18	Vc = 160 - 280		Vc = 150 - 250		
				B4 - B6	fz = 0.11 - 0.20	B4 - B6	fz = 0.06 - 0.15	
				B7 - B9	fz = 0.11 - 0.24	B7 - B9	fz = 0.08 - 0.19	
	Malleable cast iron	Ferritic	19	TT9030	AS or BL	TT9030	BL	
		Pearlitic	20	Vc = 100 - 220		Vc = 100 - 220		
B4 - B6				fz = 0.11 - 0.20	B4 - B6	fz = 0.06 - 0.15		
				B7 - B9	fz = 0.11 - 0.24	B7 - B9	fz = 0.08 - 0.20	

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for TM-REAM - Through hole

ISO	Material		Condition	Material No.	Through hole		Interrupted through Hole	
N	Aluminum - Wrought alloy		Not cureable	21	B7 - B9	BL or GS	UF10	BL
			Cured	22	Vc = 150 - 400		Vc = 150 - 400	
	Aluminum-cast, alloyed	<=12% Si	Not cureable	23	B4 - B6	fz = 0.08 - 0.16	B4 - B6	fz = 0.08 - 0.16
			Cured	24				
		>12% Si	High temp.	25	B7 - B9	fz = 0.10 - 0.20	B7 - B9	fz = 0.10 - 0.20
	Copper alloys	>1% Pb	Free cutting	26	TT9030	BL	TT9030	BL
			Vc = 50 - 200		Vc = 50 - 200			
		Brass	27	B4 - B6	fz = 0.08 - 0.18	B4 - B6	fz = 0.05 - 0.13	
	Electrolitic copper	28	B7 - B9	fz = 0.10 - 0.23	B7 - B9	fz = 0.07 - 0.16		
	Non-metallic		Duroplastics, fiber plastics	29	TT9030	AS	TT9030	AS
				Vc = 25 - 80		Vc = 25 - 80		
			Hard rubber	30	B4 - B6	fz = 0.05 - 0.10	B4 - B6	fz = 0.05 - 0.10
	B7 - B9	fz = 0.10 - 0.20		B7 - B9	fz = 0.10 - 0.20			
S	High temp. alloys	Fe based	Annealed	31	TT9030	L *	TT9030	L *
			Cured	32	Vc = 15 - 50		Vc = 15 - 50	
		Ni or Co based	Annealed	33				
			Cured	34	B4 - B6	fz = 0.04 - 0.10	B4 - B6	fz = 0.03 - 0.08
			Cast	35				
	Titanium, Ti alloys	Pure	36	B7 - B9	fz = 0.05 - 0.13	B4 - B6	fz = 0.04 - 0.11	
		Alpha+beta alloys cured	37					
H	Hardened steel		Hardened	38	TT9030	BL	TT9030	BL
			Hardened	39	Vc = 25 - 50		Vc = 25 - 50	
	Chilled cast iron		Cast	40	B4 - B6	fz = 0.06 - 0.15	B4 - B6	fz = 0.06 - 0.15
	Cast iron nodular		Hardened	41	B7 - B9	fz = 0.10 - 0.20	B7 - B9	fz = 0.10 - 0.20

* Standard edge geometries are not suitable for reaming titanium and high temperature alloys.
In order to choose a proper geometry, please ask for our recommendations.

- ▶ The given cutting data recommendations refer to the short holders (3xD effective reaming overhang).
For longer holders, the cutting speed to be reduced proportionally.
- ▶ For relatively large leading angles (spot-facing geometries), the feed to be reduced up to 30%.
- ▶ All the given cutting data recommendations refer to the machines with spindle through coolant supply.

Legend:

Grade	→	TT9030	BL	←	Cutting geometry
Cutting speed (m/min)	→	Vc = 10 - 20		←	Feed (mm/tooth)
TM-REAM head size	→	B4-B6	fz = 0.04 - 0.15	←	
	→	B7-B9	fz = 0.05 - 0.20	←	

Recommended Cutting Conditions



Machining data for TM-REAM - Blind hole

ISO	Material	Condition	Material No.	Blind hole		Interrupted blind hole		
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	1	TT9030	AS	TT9030	AS
		>=0.25%C	Annealed	2	Vc = 60-160		Vc = 60 - 120	
		<0.55%C	Quenched and tempered	3	B4 - B6	fz = 0.06 - 0.18	B4 - B6	fz = 0.05 - 0.15
		>=0.55%C	Annealed	4				
			Quenched and tempered	5	B7 - B9	fz = 0.08 - 0.20	B7 - B9	fz = 0.07 - 0.16
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed	6	TT9030	AS	TT9030	AS	
		Quenched and tempered	7	Vc = 60-160		Vc = 60 - 120		
			8	B4 - B6	fz = 0.06 - 0.18	B4 - B6	fz = 0.05 - 0.15	
			9	B7 - B9	fz = 0.08 - 0.20	B7 - B9	fz = 0.07 - 0.16	
	High alloy steel, cast steel and tool steel	Annealed	10	TT9030	AS	TT9030	AS	
		Quenched and tempered	11	Vc = 20 - 60		Vc = 20 - 60		
				B4 - B6	fz = 0.04 - 0.10	B4 - B6	fz = 0.03 - 0.08	
				B7 - B9	fz = 0.05 - 0.13	B7 - B9	fz = 0.04 - 0.10	
M	Stainless steel and cast steel	Ferritic / martensitic	12	TT9030	AS	TT9030	AS	
				Vc = 20 - 40		Vc = 20 - 40		
		Martensitic	13	B4 - B6	fz = 0.04 - 0.10	B4 - B6	fz = 0.03 - 0.08	
		Austenitic	14	B7 - B9	fz = 0.05 - 0.13	B7 - B9	fz = 0.05 - 0.10	
K	Gray cast iron (GG)	Ferritic	15	TT9030	AS	TT9030	AS	
				Vc = 80 - 200		Vc = 60 - 120		
		Pearlitic	16	B4 - B6	fz = 0.06 - 0.18	B4 - B6	fz = 0.05 - 0.13	
				B7 - B9	fz = 0.08 - 0.23	B7 - B9	fz = 0.08 - 0.18	
	Cast iron nodular (GGG)	Ferritic	17	TT9030	AS	TT9030	AS	
				Vc = 160 - 280		Vc = 160 - 240		
		Pearlitic	18	B4 - B6	fz = 0.06 - 0.18	B4 - B6	fz = 0.06 - 0.16	
				B7 - B9	fz = 0.08 - 0.23	B7 - B9	fz = 0.08 - 0.18	
	Malleable cast iron	Ferritic	19	TT9030	AS	TT9030	AS	
			Vc = 100 - 220		Vc = 100 - 220			
Pearlitic		20	B4 - B6	fz = 0.06 - 0.18	B4 - B6	fz = 0.05 - 0.15		
			B7 - B9	fz = 0.08 - 0.23	B7 - B9	fz = 0.08 - 0.20		

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for TM-REAM - Blind hole

ISO	Material		Condition	Material No.	Blind hole		Interrupted blind hole	
N	Aluminum - Wrought alloy		Not cureable	21	UF10	GS or AS	UF10	GS or AS
			Cured	22	Vc = 150 - 400		Vc = 150 - 300	
	Aluminum-cast, alloyed	<=12% Si	Not cureable	23	B4 - B6	fz = 0.08 - 0.16	B4 - B6	fz = 0.07 - 0.15
			Cured	24				
		>12% Si	High temp.	25	B7 - B9	fz = 0.11 - 0.20	B7 - B9	fz = 0.11 - 0.20
	Copper alloys	>1% Pb	Free cutting	26	TT9030	AS	TT9030	AS
			Vc = 50 - 200		Vc = 50 - 200			
		Brass	27	B4 - B6	fz = 0.08 - 0.16	B4 - B6	fz = 0.08 - 0.16	
	Electrolytic copper	28	B7 - B9	fz = 0.10 - 0.20	B7 - B9	fz = 0.10 - 0.20		
	Non-metallic		Duroplastics, fiber plastics	29	TT9030	AS	TT9030	AS
			Vc = 25 - 80		Vc = 25 - 80			
			Hard rubber	30	B4 - B6	fz = 0.05 - 0.10	B4 - B6	fz = 0.05 - 0.10
S	High temp. alloys	Fe based	Annealed	31	TT9030	L *	TT9030	L *
			Cured	32	Vc = 15 - 50		Vc = 15 - 50	
		Ni or Co based	Annealed	33				
			Cured	34				
			Cast	35				
	Titanium, Ti alloys	Pure	36	B7 - B9	fz = 0.04 - 0.11	B7 - B9	fz = 0.04 - 0.11	
		Alpha+beta alloys cured	37					
	H	Hardened steel	Hardened	38	TT9030	AS	TT9030	AS
			Hardened	39	Vc = 25 - 50		Vc = 25 - 50	
		Chilled cast iron	Cast	40	B4 - B6	fz = 0.05 - 0.13	B4 - B6	fz = 0.05 - 0.13
Cast iron nodular		Hardened	41	B7 - B9	fz = 0.10 - 0.20	B7 - B9	fz = 0.10 - 0.20	

* Standard edge geometries are not suitable for reaming titanium and high temperature alloys.

In order to choose a proper geometry, please ask for our recommendations.

- ▶ The given cutting data recommendations refer to the short holders (3xD effective reaming overhang). For longer holders, the cutting speed to be reduced proportionally.
- ▶ For relatively large leading angles (spot-facing geometries), the feed to be reduced up to 30%.
- ▶ All the given cutting data recommendations refer to the machines with spindle through coolant supply.

Legend:

Grade	→	TT9030	BL	←	Cutting geometry
Cutting speed (m/min)	→	Vc = 10 - 20		←	Feed (mm/tooth)
TM-REAM head size	→	B4-B6	fz = 0.04 - 0.15	←	
	→	B7-B9	fz = 0.05 - 0.20	←	

Recommended Cutting Conditions



Machining data for TB-REAM

			Lead A (15°/3°) (Reaming allowance: 0.1 ~ 0.3)						
			Feed (mm/rev)	Rake (°)	Cutting speed Vc (m/min)				
ISO	Material	Material No.			Carbide	Coated carbide	Cermet	PCD	CBN
P	Non-alloy steel and cast steel, free cutting steel	1 - 5	0.1-0.4	6	40-60	60-80	110-160		
	Low alloy steel and cast steel (Less than 5% of alloying elements)	6 - 9	0.1-0.4	6	20-40	40-60	110-160		
	High alloyed steel, cast steel and tool steel	10 - 11	0.1-0.4	6	20-40	20-60	20-60		
M	Stainless steel, cast steel	12 - 14	0.1-0.3	12	20-40	40-60	20-60		
K	Grey cast iron (GG)	15 - 16	0.1-0.3	0 / 6	40-60	60-100			Please ask
	Cast iron nodular (GGG)	17 - 18	0.1-0.3	0 / 6	40-60	60-100			
	Malleable cast iron	19 - 20	0.1-0.3	0 / 6	40-60	60-100			
N	Aluminum wrought alloy	21 - 22						Please ask	
	Aluminum-cast, alloyed	23 - 25							
	Copper alloys	26 - 28							
	Non-metallic	29 - 30							

			Lead C (75°) (Reaming allowance: 0.2 ~ 0.4)						
			Feed (mm/rev)	Rake (°)	Cutting speed Vc (m/min)				
ISO	Material	Material No.			Carbide	Coated carbide	Cermet	PCD	CBN
P	Non-alloy steel and cast steel, free cutting steel	1 - 5							
	Low alloy steel and cast steel (Less than 5% of alloying elements)	6 - 9							
	High alloyed steel, cast steel and tool steel	10 - 11							
M	Stainless steel, cast steel	12 - 14							
K	Grey cast iron (GG)	15 - 16							Please ask
	Cast iron nodular (GGG)	17 - 18							
	Malleable cast iron	19 - 20							
N	Aluminum wrought alloy	21 - 22	0.15-0.3	12	150-250			Please ask	
	Aluminum-cast, alloyed	23 - 25	0.15-0.3	12	150-250				
	Copper alloys	26 - 28							
	Non-metallic	29 - 30							

► The cutting conditions in the table below should be used to start a new application.
Optimal conditions for a specific application should be evaluated by examining the results and changing the machining conditions accordingly.

► For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous

Recommended Cutting Conditions



Machining data for TB-REAM

			Lead B (30°/3°) (Reaming allowance: 0.1 ~ 0.3)						
			Feed (mm/rev)	Rake (°)	Cutting speed Vc (m/min)				
ISO	Material	Material No.			Carbide	Coated carbide	Cermet	PCD	CBN
P	Non-alloy steel and cast steel, free cutting steel	1 - 5	0.1-0.4	6	60-80	80-120	110-160		
	Low alloy steel and cast steel (Less than 5% of alloying elements)	6 - 9	0.1-0.4	6	60-80	80-120	110-160		
	High alloyed steel, cast steel and tool steel	10 - 11	0.1-0.4	6	40-60	40-80	40-80		
M	Stainless steel, cast steel	12 - 14	0.1-0.3	12	40-60	60-80	60-80		
K	Grey cast iron (GG)	15 - 16	0.1-0.3	0 / 6	60-80	80-120			Please ask
	Cast iron nodular (GGG)	17 - 18	0.1-0.3	0 / 6	60-80	80-120			
	Malleable cast iron	19 - 20	0.1-0.3	0 / 6	60-80	80-120			
N	Aluminum wrought alloy	21 - 22		12	160-200			Please ask	
	Aluminum-cast, alloyed	23 - 25		12	160-200				
	Copper alloys	26 - 28		0	80-100				
	Non-metallic	29 - 30		0	10-70				

			Lead D (30°/3°) (Reaming allowance: 0.1 ~ 0.2)						
			Feed (mm/rev)	Rake (°)	Cutting speed Vc (m/min)				
ISO	Material	Material No.			Carbide	Coated carbide	Cermet	PCD	CBN
P	Non-alloy steel and cast steel, free cutting steel	1 - 5	0.1-0.4	6	60-80	80-120	110-160		
	Low alloy steel and cast steel (Less than 5% of alloying elements)	6 - 9	0.1-0.4	6	60-80	80-120	110-160		
	High alloyed steel, cast steel and tool steel	10 - 11	0.1-0.4	6	40-60	40-80	40-80		
M	Stainless steel, cast steel	12 - 14	0.1-0.3	12	40-60	60-80	60-80		
K	Grey cast iron (GG)	15 - 16	0.1-0.3	0 / 6	60-80	80-120			Please ask
	Cast iron nodular (GGG)	17 - 18	0.1-0.3	0 / 6	60-80	80-120			
	Malleable cast iron	19 - 20	0.1-0.3	0 / 6	60-80	80-120			
N	Aluminum wrought alloy	21 - 22		12	110-200			Please ask	
	Aluminum-cast, alloyed	23 - 25		12	160-200				
	Copper alloys	26 - 28		0	80-100				
	Non-metallic	29 - 30							

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Optimal conditions for a specific application should be evaluated by examining the results and changing the machining conditions accordingly.

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■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous

Recommended Cutting Conditions



Machining data for TS-REAM

ISO	Material	Condition	Tensile strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C Annealed	420	125	1	120-250
		>=0.25%C Annealed	650	190	2	120-250
		<0.55%C Quenched and tempered	850	250	3	120-250
		>=0.55%C Annealed	750	220	4	
		Quenched and tempered	1000	300	5	
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed	600	200	6	120-250
			930	275	7	120-250
		Quenched and tempered	1000	300	8	120-250
			1200	350	9	120-250
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	120-250
		Quenched and tempered	1100	325	11	120-250
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	60-120
		Martensitic	820	240	13	60-120
		Austenitic	600	180	14	60-120
K	Gray cast iron (GG)	Ferritic		160	15	60-120
		Pearlitic		250	16	60-120
	Cast iron nodular (GGG)	Ferritic		180	17	60-120
		Pearlitic		260	18	60-120
	Malleable cast iron	Ferritic		130	19	60-120
		Pearlitic		230	20	60-120
N	Aluminum - Wrought alloy	Not cureable		60	21	250-500
		Cured		100	22	250-500
	Aluminum-cast, alloyed	<=12% Si Not cureable		75	23	250-500
		Cured		90	24	250-500
		>12% Si High temp.		130	25	
	Copper alloys	>1% Pb Free cutting		110	26	
		Brass		90	27	
		Electrolitic copper		100	28	
S	High temp. alloys	Fe based Annealed		70 Shore D	29	
				55 Shore D	30	
		Cured		200	31	
				280	32	
		Ni or Co based Annealed		250	33	25-50
				350	34	25-50
	Titanium, Ti alloys	Cast		320	35	
		Pure	Rm 400	190	36	30-80
		Alpha+beta alloys cured	Rm 1050	310	37	30-80
H	Hardened steel	Hardened		55HRC	38	25-60
		Hardened		60HRC	39	
	Chilled cast iron	Cast		400	40	
	Cast iron nodular	Hardened		55HRC	41	

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■ Steel
 ■ Stainless steel
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 ■ High temp. alloys
 ■ Hardened steel

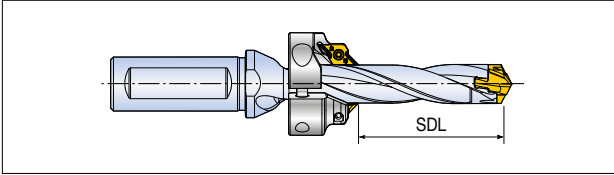
Recommended Cutting Conditions



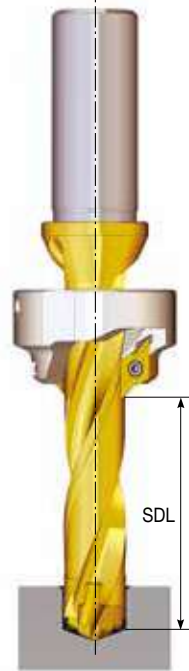
Machining data for TS-REAM

Feed (mm/rev) vs. reamer diameter			
Ø3.0 - Ø5.0	Ø6.0 - Ø7.0	Ø8.0 - Ø10.0	Ø10.5 - Ø12.0
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60
0.10-0.40	0.15-0.70	0.50-1.40	0.80-1.60

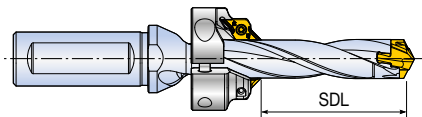
► Chamfering ring design - DRILL-RUSH



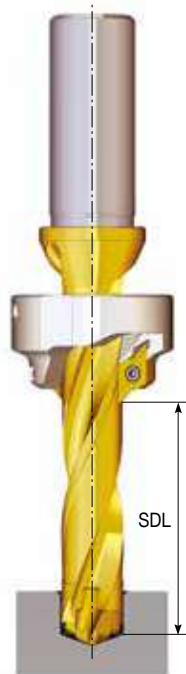
	Designation	CFR designation	SDL	
			min	max
3D	TCD 130-134-16T3/S0-3D	CFR D130-A45	19	19
	135-139-16T3/S0-3D	CFR D135-A45	19	20
	140-144-16T3/S0-3D	CFR D140-A45	21	22
	145-149-16T3/S0-3D	CFR D145-A45	22	23
	150-159-20T3/S0-3D	CFR D150-A45	23	23
	160-169-20T3/S0-3D	CFR D160-A45	24	25
	170-179-20T3/S0-3D	CFR D170-A45	26	28
	180-189-25T2/S0-3D	CFR D180-A45	27	30
	190-199-25T2/S0-3D	CFR D190-A45	29	33
	200-209-25T2/S0-3D	CFR D200-A45	30	36
	210-219-25T2/S0-3D	CFR D210-A45	32	39
	220-229-25T2/S0-3D	CFR D220-A45	33	42
	230-239-32T2/S0-3D	CFR D230-A45	35	45
	240-249-32T2/S0-3D	CFR D240-A45	36	48
5D	250-259-32T2/S0-3D	CFR D250-A45	38	51
	TCD 100-104-16T3/S0-5D	CFR D100-A45	28	28
	105-109-16T3/S0-5D	CFR D105-A45	29	30
	110-114-16T3/S0-5D	CFR D110-A45	31	33
	115-119-16T3/S0-5D	CFR D115-A45	32	35
	120-124-16T3/S0-5D	CFR D120-A45	33	45
	125-129-16T3/S0-5D	CFR D125-A45	34	40
	130-134-16T3/S0-5D	CFR D130-A45	36	43
	135-139-16T3/S0-5D	CFR D135-A45	37	43
	140-144-16T3/S0-5D	CFR D140-A45	38	48
	145-149-16T3/S0-5D	CFR D145-A45	39	48
	150-159-20T3/S0-5D	CFR D150-A45	41	53
	160-169-20T3/S0-5D	CFR D160-A45	43	58
	170-179-20T3/S0-5D	CFR D170-A45	46	63
	180-189-25T2/S0-5D	CFR D180-A45	48	68
	190-199-25T2/S0-5D	CFR D190-A45	51	73
	200-209-25T2/S0-5D	CFR D200-A45	53	78
	210-219-25T2/S0-5D	CFR D210-A45	56	79
	220-229-25T2/S0-5D	CFR D220-A45	58	84
	230-239-32T2/S0-5D	CFR D230-A45	61	89
	240-249-32T2/S0-5D	CFR D240-A45	63	94
	250-259-32T2/S0-5D	CFR D250-A45	66	99



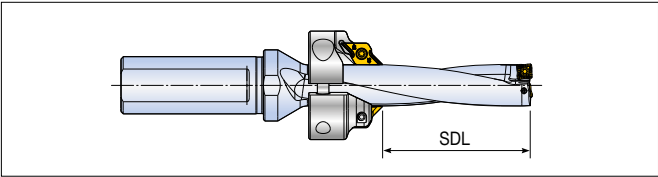
► Chamfering ring designation - DRILL-RUSH



	Designation	CFR designation	SDL	
			min	max
8D	TCD 100-104-16T3/S0-8D	CFR D100-A45	45	58
	105-109-16T3/S0-8D	CFR D105-A45	49	62
	110-114-16T3/S0-8D	CFR D110-A45	49	66
	115-119-16T3/S0-8D	CFR D115-A45	53	70
	120-124-16T3/S0-8D	CFR D120-A45	53	74
	125-129-16T3/S0-8D	CFR D125-A45	57	78
	130-134-16T3/S0-8D	CFR D130-A45	57	82
	135-139-16T3/S0-8D	CFR D135-A45	61	84
	140-144-16T3/S0-8D	CFR D140-A45	61	88
	145-149-16T3/S0-8D	CFR D145-A45	65	92
	150-159-20T3/S0-8D	CFR D150-A45	65	96
	160-169-20T3/S0-8D	CFR D160-A45	69	103
	170-179-20T3/S0-8D	CFR D170-A45	73	111
	180-189-25T2/S0-8D	CFR D180-A45	77	118
	190-199-25T2/S0-8D	CFR D190-A45	81	126
	200-209-25T2/S0-8D	CFR D200-A45	85	134
	210-219-25T2/S0-8D	CFR D210-A45	89	142
	220-229-25T2/S0-8D	CFR D220-A45	93	150
	230-239-32T2/S0-8D	CFR D230-A45	97	158
	240-249-32T2/S0-8D	CFR D240-A45	101	166
	250-259-32T2/S0-8D	CFR D250-A45	105	174
12D	TCD 120-124-16S0-12D	CFR D120-A45	87	121
	125-129-16S0-12D	CFR D125-A45	90	127
	130-134-16S0-12D	CFR D130-A45	93	133
	135-139-16S0-12D	CFR D135-A45	96	137
	140-144-16S0-12D	CFR D140-A45	99	143
	145-149-16S0-12D	CFR D145-A45	102	149
	150-159-20S0-12D	CFR D150-A45	105	155
	160-169-20S0-12D	CFR D160-A45	111	166
	170-179-20S0-12D	CFR D170-A45	117	178
	180-189-25S0-12D	CFR D180-A45	123	189
	190-199-25S0-12D	CFR D190-A45	129	201
	200-209-25S0-12D	CFR D200-A45	135	213
	210-219-25S0-12D	CFR D210-A45	141	225
	220-229-25S0-12D	CFR D220-A45	147	237



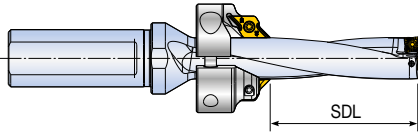
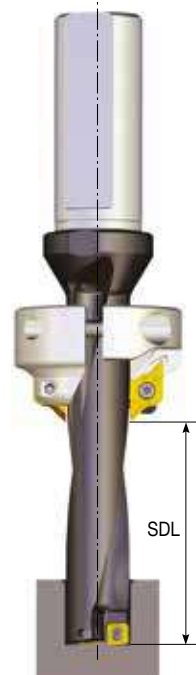
► Chamfering ring design - TOP-DRILL and T-DRILL



	TOP-DRILL	T-DRILL	CFR designation	SDL	
				min	max
3D	TOP -	TDR 3125-20T2-05	CFR D125-A45	16	16
	-	3130-20T2-05	CFR D130-A45	16	16
	-	3135-20T2-05	CFR D135-A45	17	18
	3140-20T2-05	3140-20T2-05	CFR D140-A45	17	18
	3145-20T2-05	3145-20T2-05	CFR D145-A45	18	19
	3150-20T2-05	3150-20T2-05	CFR D150-A45	18	19
	3155-20T2-05	3155-25T2-06	CFR D160-A45	19	21
	3160-20T2-05	3160-25T2-06	CFR D160-A45	19	21
	3165-25T2-06	3165-25T2-06	CFR D170-A45	21	24
	3170-25T2-06	3170-25T2-06	CFR D170-A45	22	24
	3175-25T2-06	3175-25T2-06	CFR D180-A45	23	27
	3180-25T2-06	3180-25T2-06	CFR D180-A45	23	26
	3185-25T2-06	3185-25T2-06	CFR D180-A45	24	29
	3190-25T2-06	3190-25T2-06	CFR D190-A45	25	29
	3195-25T2-07	3195-25T2-06	CFR D190-A45	25	32
	3200-25T2-07	3200-25T2-06	CFR D200-A45	26	32
	3205-25T2-07	3205-25T2-06	CFR D200-A45	27	35
	3210-25T2-07	3210-25T2-06	CFR D210-A45	27	35
	3215-25T2-07	3215-25T2-07	CFR D210-A45	28	38
	3220-25T2-07	3220-25T2-07	CFR D220-A45	29	38
	3225-25T2-08	3225-25T2-07	CFR D220-A45	29	41
	3230-25T2-08	3230-25T2-07	CFR D230-A45	30	41
	3235-25T2-08	3235-25T2-07	CFR D230-A45	31	44
	3240-25T2-08	3240-25T2-07	CFR D240-A45	31	44
	3245-25T2-08	3245-25T2-07	CFR D240-A45	32	47
	3250-25T2-08	3250-25T2-07	CFR D250-A45	33	47

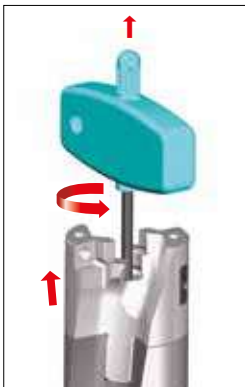


► Chamfering ring designation - TOP-DRILL and T-DRILL

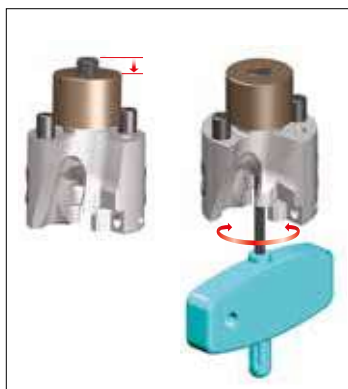
[illegible]

► Modular head replacement instructions

1. Remove both outer inserts, then remove the center drill head.
(When clamping, go in the reverse order)
2. Use a wrench to turn the screw counter-clock-wise to remove the modular head.
3. Insert the setting gauge into the bottom of the disconnected modular head.



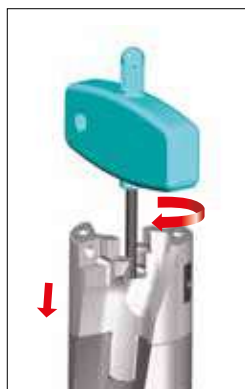
4. Rotate the screw to adjust to the same height with the setting gauge.



Setting gauge

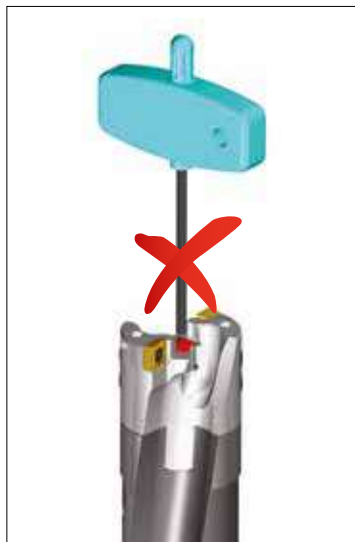
Drill dia.	Designation
D26-D29	SG TNDH D26-29-TP
D30-D35	SG TNDH D30-35-TP
D36-D39	SG TNDH D36-39-TP
D40-D43	SG TNDH D40-43-TP
D44-D50	SG TNDH D44-50-TP

5. Remove the height adjusted modular head from the setting gauge and attach it to the holder.



► Modular head disassembly in the event of center drill damage

If the modular head cannot be unclamped due to center drill damage, insert the wrench into the rear section of the shank. Then, turn it clock-wise to disassemble the modular head.



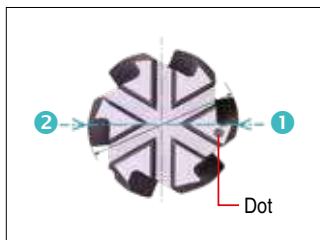
Damaged center drill



► Disassembling wrench and handle are included with the modular drill holder. (MDB Dxx/xx...)

► XM-REAM user guide and notice

How to check reamer diameter



Measure the dot side edge ① and opposite side edge ②.

Reaming allowance

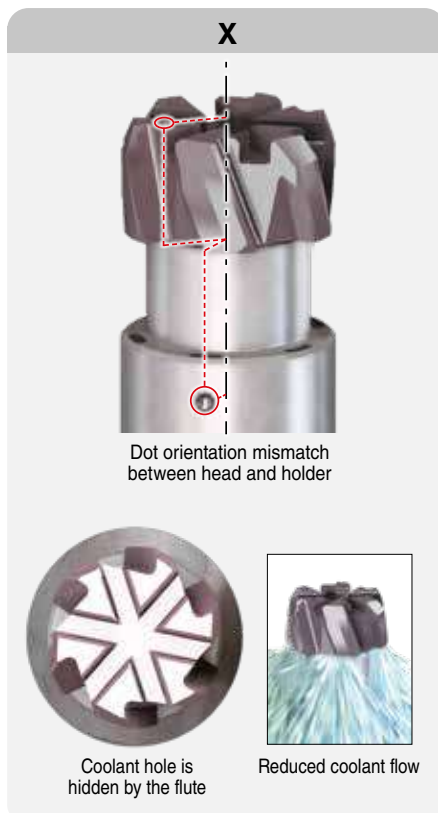
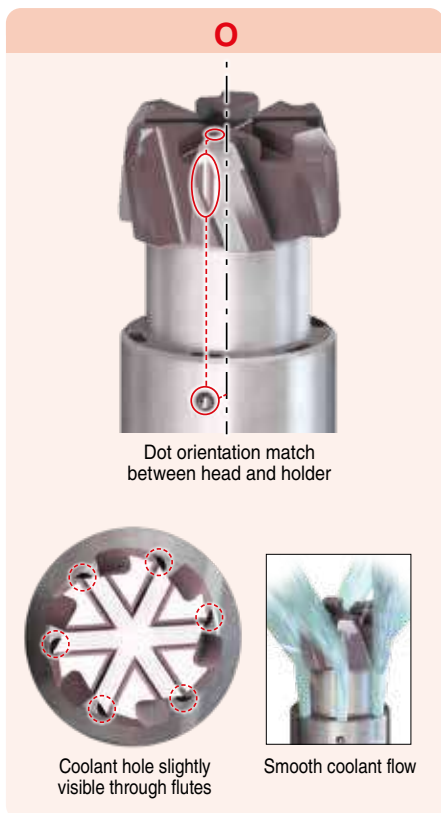
Material	Diameter	
	< Ø10	Ø10-12
Steel & Cast iron	0.07-0.10	0.07-0.15
Aluminum & brass	0.07-0.10	0.10-0.15

* Based on diameter

Ex) Ø9.85-9.93 mm pre-hole is recommended for Ø10H7 reaming in cast iron.

Caution

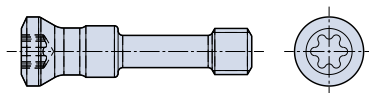
- To ensure smooth coolant flow, the dot and slot orientation of the head must be aligned as illustrated.



► Screw torque

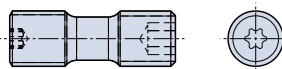
For SPADE-RUSH

Designation	Thread	Length	Torx	Tightening Torque
TS 30138D33	M3	13.8	Torx 10	2.0 Nm
TS 40178D25	M4	17.8	Torx 20	4.5 Nm
TS 40198D28	M4	19.8	Torx 20	4.5 Nm
TS 40210D3	M4	21	Torx 20	5.0 Nm
TS 50230D3	M5	23	Torx 20	5.0 Nm
TS 50250D35	M5	25	Torx 25	5.5 Nm
TS 60265D4	M6	26.5	Torx 25	6.0 Nm
TS 60285D42	M6	28.5	Torx 25	6.0 Nm
TS 60320D5	M6	31	Torx 25	6.0 Nm
TS 80340D6	M8	34	Torx 25	7.0 Nm



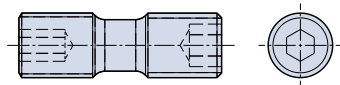
For MODU-R-DRILL

Designation	Thread	Length	Torx	Tightening Torque
TDPS 0512-T7	M5	12	Torx 7	1.0 Nm
TDPS 0618-T8	M6	18	Torx 8	2.0 Nm



For MODU-R-DRILL

Designation	Thread	Length	Torx	Tightening Torque
TDPS 0722-W3.0	M7	22	Hexa 3.0 mm	5.0 Nm



Technical Data

► Hole tolerance

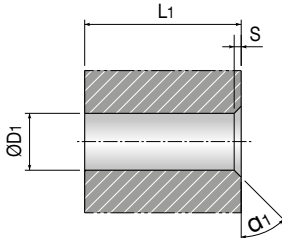
Diameter D(mm)		Tolerance (µm)															
>D	≤D	B10	C9	C10	D8	D9	D10	E7	E8	E9	F6	F7	F8	G6	G7	H6	H7
–	3	+180 +140	+85 +60	+100 +60	+34 +20	+45 +20	+60 +20	+24 +14	+28 +14	+39 +14	+12 +6	+16 +6	+20 +6	+8 +2	+12 +2	+6 0	+10 0
3	6	+180 +140	+100 +70	+118 +70	+48 +30	+60 +30	+78 +30	+32 +20	+38 +20	+50 +20	+18 +10	+22 +10	+28 +10	+12 +4	+16 +4	+8 0	+12 0
6	10	+208 +150	+116 +80	+138 +80	+62 +40	+76 +40	+98 +40	+40 +25	+47 +25	+61 +25	+22 +13	+28 +13	+35 +13	+14 +5	+20 +5	+9 0	+15 0
10	14	+220 +150	+138 +95	+165 +95	+77 +50	+93 +50	+120 +50	+50 +32	+59 +32	+75 +32	+27 +16	+34 +16	+43 +16	+17 +6	+24 +6	+11 0	+18 0
14	18																
18	24	+244 +160	+162 +110	+194 +110	+98 +65	+117 +65	+149 +65	+61 +40	+73 +40	+92 +40	+33 +20	+41 +20	+53 +20	+20 +7	+28 +7	+13 0	+21 0
24	30																
30	40	+270 +170	+182 +120	+220 +120	+119 +80	+142 +80	+180 +80	+75 +50	+89 +50	+112 +50	+41 +25	+50 +25	+64 +25	+25 +9	+34 +9	+16 0	+25 0
40	50	+280 +180	+192 +130	+230 +130													
50	65	+310 +190	+214 +140	+260 +140	+146 +100	+174 +100	+220 +146	+90 +60	+106 +60	+134 +60	+49 +30	+60 +30	+76 +30	+29 +10	+40 +10	+19 0	+30 0
65	80	+320 +200	+224 +150	+270 +150													

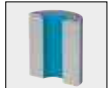
Technical Data

► Hole tolerance

Tolerance (µm)																		
H8	H9	H10	JS6	JS7	K6	K7	M6	M7	N6	N7	P6	P7	R7	S7	T7	U7	X7	
+14 0	+25 0	+40 0	±3	±5	0 -6	0 -10	-2 -8	-2 -12	-4 -10	-4 -14	-6 -12	-6 -16	-10 -20	-14 -24	-	-18 -28	-20 -30	
+18 0	+30 0	+48 0	±4	±6	+2 -6	+3 -9	-1 -9	0 -12	-5 -13	-4 -16	-9 -17	-8 -20	-11 -23	-15 -27	-	-19 -31	-24 -36	
+22 0	+36 0	+58 0	±4.5	±7.5	+2 -7	+5 -10	-3 -12	0 -15	-7 -16	-4 -19	-12 -21	-9 -24	-13 -28	-17 -32	-	-22 -37	-28 -43	
+27 0	+43 0	+70 0	±5.5	±9	+2 -9	+6 -12	-4 -15	0 -18	-9 -20	-5 -23	-15 -26	-11 -29	-16 -34	-21 -39	-	-26	-33 -51	
																-44	-38 -56	
+33 0	+52 0	+84 0	±6.5	±10.5	+2 -11	+6 -15	-4 -17	0 -21	-11 -24	-7 -28	-18 -31	-14 -35	-20 -41	-27 -48	-	-33 -54	-46 -67	
															-33 -54	-40 -61	-56 -77	
+39 0	+62 0	+100 0	±8	±12.5	+3 -13	+7 -18	-4 -20	0 -25	-12 -28	-8 -33	-21 -37	-17 -42	-25 -50	-34 -59	-39 -64	-51 -76	-	
															-45 -70	-61 -86		
+46 0	+74 0	+120 0	±9.5	±15	+4 -15	+9 -21	-5 -24	0 -30	-14 -33	-9 -39	-26 -45	-21 -51	-30 -60	-42 -72	-55 -85	-76 -106	-	
													-32 -62	-48 -78	-64 -94	-91 -121		

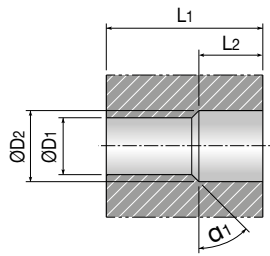
► Specific dimensions






Through ☐
 ØD1 _____
 Q1 _____
 •Hole tolerance _____

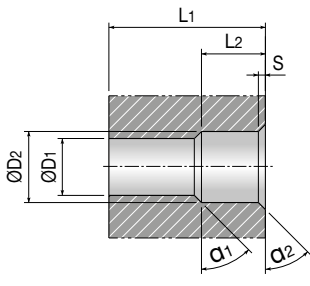
Blind ☐
 L1 _____
 S _____






Through ☐
 ØD1 _____
 L1 _____
 Q1 _____
 •Hole tolerance _____

Blind ☐
 ØD2 _____
 L2 _____






Through ☐
 ØD1 _____
 L1 _____
 Q1 _____
 S _____
 •Hole tolerance _____

Blind ☐
 ØD2 _____
 L2 _____
 Q2 _____

Comment

Drill type

•TOPDRILL _____ ☐
 •T-DRILL _____ ☐

Technical data

•Machine type
 MCT ☐ Lathe ☐
 Vertical ☐ Horizontal ☐
 Machine name _____
 Power _____ kW

•Coolant supply
 Internal ☐ External ☐
 Coolant pressure _____ bar
 Coolant type _____

Workpiece

•Part _____
 •Material _____
 •Hardness _____

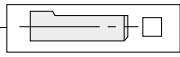
Shank type



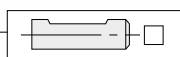
Cylindrical shank (ISO 9766)



Whistle notch shank



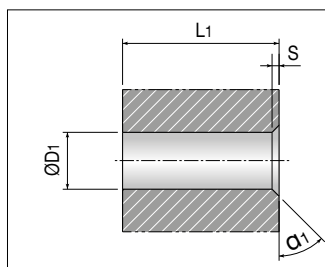
Cylindrical with flat type



Weldon shank

Tailor-made Order Form

► Specific dimensions



Through ☐

Blind ☐

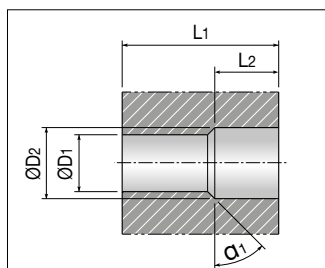
ØD1 _____

L1 _____

α1 _____

S _____

•Hole tolerance _____



Through ☐

Blind ☐

ØD1 _____

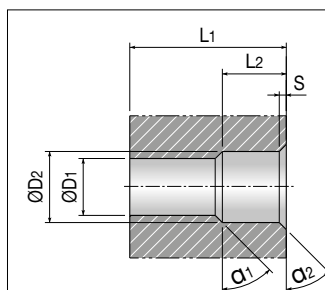
ØD2 _____

L1 _____

L2 _____

α1 _____

•Hole tolerance _____



Through ☐

Blind ☐

ØD1 _____

ØD2 _____

L1 _____

L2 _____

α1 _____

α2 _____

•Hole tolerance _____

Comment

Technical data

•Machine type

MCT ☐ Lathe ☐

Vertical ☐ Horizontal ☐

Machine name _____

Power _____ kW

•Coolant supply

Internal ☐ External ☐

Coolant pressure _____ bar

Coolant type _____

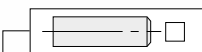
Workpiece

•Part

•Material

•Hardness

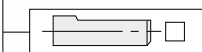
Shank type



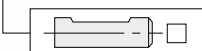
Cylindrical shank (ISO 9766)



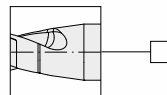
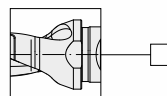
Whistle notch shank



Cylindrical with flat type



Weldon shank



•Shank dia: _____

•Shank length: _____

► Specific dimensions

• DC, DC_2 would be hole dimensions and please note hole tolerance if possible

Technical data

•Machine type

MCT ☐ Lathe ☐

Vertical ☐ Horizontal ☐

Machine name _____

Power _____ kW

•Coolant supply

Internal ☐ External ☐

Coolant pressure _____ bar

Coolant type _____

Workpiece

•Part _____

•Material _____

•Hardness _____

Hole type

•Blind hole ☐

•Through hole ☐

Coating

•TiAlN ☐

•Non-coated ☐

Shank type



Cylindrical shank



Whistle notch shank



Cylindrical with flat type



Weldon shank

Comment

Tailor-made Order Form



► Deep hole drilling order form

★: Mandatory data field

Company name :	Inquiry number :
Address :	Inquiry date :
Contact person :	Customer No :

Workpiece (If possible, please attach a drawing)	
Product name	
Hole diameter (ø)	(mm)
Hole depth (drilling length)	(mm)
No. of holes	
Tolerance (of hole)	
Surface finish (Rz, Ra...)	
Deviation (mm/100)	
Straightness (mm/100)	
Material	
Material (DIN, AISI, JIS...)	
Hardness (HB, HS, HRC...)	
Condition ★	☐ Annealed ☐ Quenched ☐ Tempered
	☐ Cast ☐
	☐ Other ☐

Machine	
Machine supplier name	
Machine type/model	
Rigidity	☐ Good ☐ Normal ☐ Bad
Date of manufacture	
Retrofitted	☐ NC lathe ☐ M/C ☐ Other
Double rotation (TR/WR)	☐ Tool and workpiece
Rotating workpiece (WR)	☐
Rotating tool (TR)	☐
Safety devices	
Motor power	(kW)

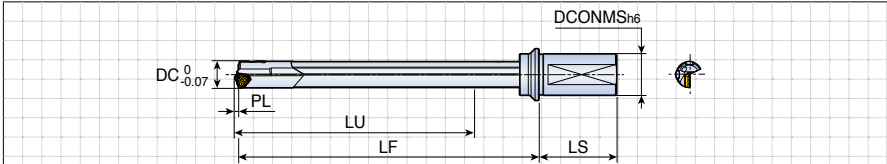
Type of coolant	
Coolant supplier name	
Water based	☐ Soluble ☐ Emulsion %
Oil based	☐
Coolant pressure	(bar)
Coolant volume	(L/min)

★: Mandatory data field

★ Please sketch your drilling application

D

► Deep hole drilling order form



Sketch of drilling application

• Note: It may be necessary to change several of the parameters that you indicated based on our experience with your application.

Tool	
Quantity	
Nominal diameter and tolerance	
- Please fill in dimensions on the sketch above.	
Driver	
Code No	

- For standard drivers, please use codes from next pages and for special drivers, please attach sketch and specifications.

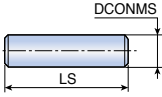
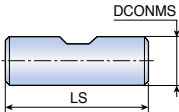
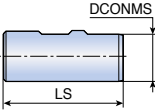
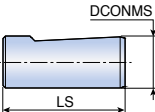
Workpiece (If possible, please attach a drawing)			
Material description (DIN material number or any other standard)			
Hardness and properties			
Hole type		☐ Blind hole ☐ Through hole ☐ Drilling into pre-hole ☐ Angled entry ☐ Drilling into solid ☐ Boring ☐ Angled exit	
Drilling depth		mm	
Hole tolerance			
Application	Workpiece	☐ Stationary ☐ Rotating	
	Tool	☐ Stationary ☐ Rotating	

Machine					
Machine type					
Power		kW			
Cutting data	Cutting speed (Vc)	m/min			
	Revolutions	Nmin :	RPM	Nmax :	RPM
	Feed	Fmin :	mm/rev	Fmin :	mm/rev
	Feed rate (VF)	mm/min			
Coolant	Coolant type	☐ Oil	☐ Soluble oil	☐ Other	
	Coolant pressure	Bar			
	Coolant volume	liter/min			

► Standard gundrill drivers for machining centers and lathes

Drivers

Drivers are available for dedicated and CNC machines as well as any specified diameter or length. Please note that the driver codes and technical data can be found in the chart below.

Driver type	Drawing	DCONMS x LS	Driver code
Cylindrical DIN1835A DIN6535HA		20x50	10
		25x56	11
		32x60	12
		40x70	13
		.75x2.03"	95
		1.00x2.28"	96
		1.25x2.28"	97
Weldon DIN1835B DIN6535HB	 	20x50	22
		25x56	23
		32x60	24
		40x70	25
		.75x2.03"	99
		1.00x2.28"	100
		1.25x2.28"	101
Whistle notch DIN1835E		20x50	34
		25x56	35
		32x60	36
		40x70	37

► Standard drivers for gundrill machines

Driver type	Drawing	DCONMS x LS	Driver code
DIN228AK		CM2	46
		CM3	47
		CM4	48
DIN228BK		CM2	50
		CM3	51
		CM4	52
Central clamping surface 15°		.750x2.75"	56
		25x70	57
		1.00x2.75"	58
		1.25x2.75"	59
		1.50x2.75"	60
Frontal clamping surface 15°		16x50	61
Cylindrical with thread		25x100 M16x1.5	66
		36x120 M24x1.5	67
VDI design		25x112 M16x1.5	70
		36x135 M24x1.5	71
Central clamping hexagonal		25x70	72
		32x70	73
Central clamping tapered		.75x2.75"	76
		20x70	77
Frontal clamping surface 2°		1.00x2.75"	80
		1.00x3.94"	81
		1.25x2.75"	82
		1.25x3.94"	83
		1.50x2.75"	84
		1.50x3.94"	85
Trapezoidal thread		28x126 Tr 28x2	88
		36x162 Tr 36x2	89
Spraymist driver		25x50	91
		35x60	92

► Reamer order form

★: Mandatory data field

Date: _____ Subsidiary: _____

Company★ : _____ Enquiry dead line: _____

Contact person: _____

Address: _____

Request reason	
New tool ☐	Problem ☐
Quality	
Cycle time	
Alternative supplier	
Other	

Existing tool	
Maker	
Tool type	
Speed & Feed	
Tool life	
No of teeth	
Coolant type	

Machine	
Model	
Type★	vertical ☐ horizontal ☐ multi-spindle ☐
Adaption★	
Max RPM	
Power	
Spindle accuracy	
Coolant	

Workpiece	
Description★	
Hardness★	
Pre-hole size★	(Tolerance : _____)
Depth★	

Bore type	
☐	☐
☐	☐
☐	☐
☐	☐
☐	☐
☐	☐

Clamping information	

Lubricant	
Oil	☐
MQL	☐
Emulsion	☐
Ratio of mixture	
Coolant pressure	

Quality requirement	
Tolerance★	
Surface finish(Ra)★	
Roundness	
Straightness	
Cylindricity	
Concentricity	

Tool	
Type★	TM(Index multi-edge) ☐ TB(Single blade) ☐ TS(Solid) ☐ Other ☐ (_____)
Diameter★	
Depth of cut★	
Coolant★	Internal ☐ External ☐
Shank type★	
Holder type	Collet ☐ Hydraulic ☐ Other ☐
Adjustable adaptor	Yes ☐ No ☐