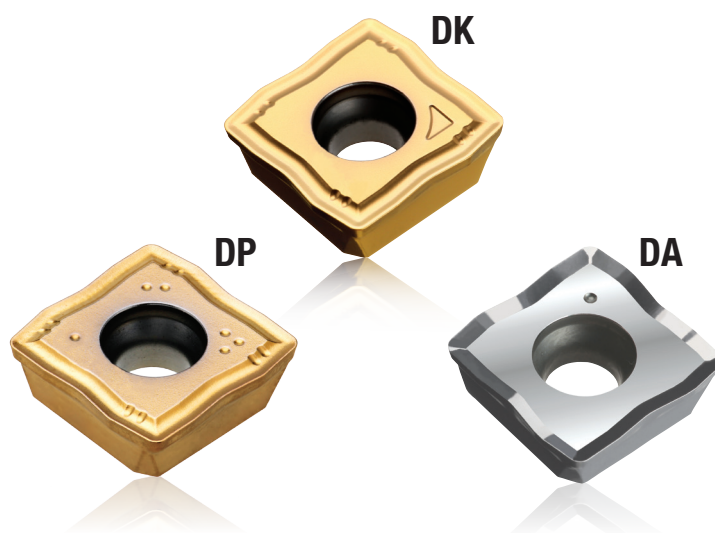
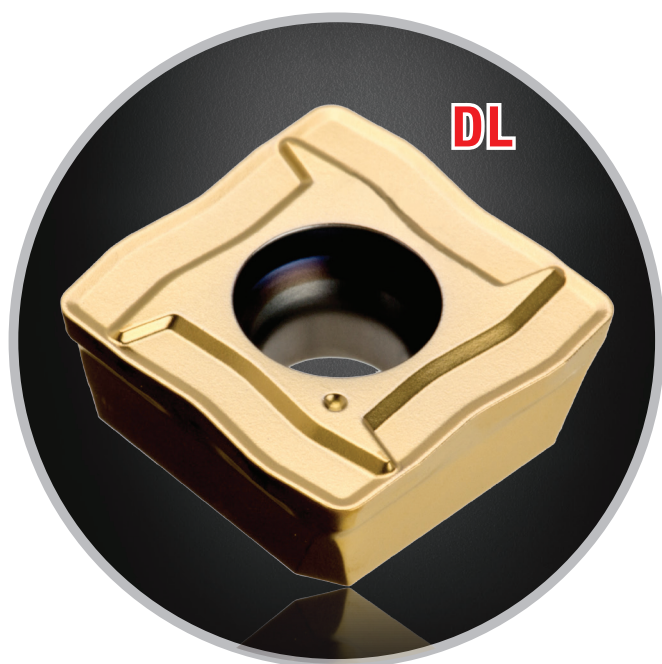


NEW PRODUCT NEWS

TOPDRILL



New 'DL' Chip Former for Mild Steel Machining



KEY POINT

Brand new '**DL**' chip former added to the TOPDRILL product line.

The **TOPDRILL** line's current '**DP**' chip former is a multi-purpose insert that works wonders on various types of materials. Now TaeguTec has expanded the line's capabilities by introducing the '**DL**' chip former specifically dedicated for mild steel machining applications.

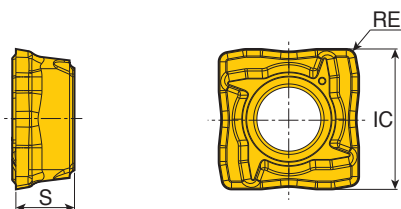
The product line already includes several types dedicated to various materials; the '**DP**' for general purposes, the '**DK**' for cast iron, as well as the '**DA**' for aluminum machining. With the introduction of the '**DL**' insert for mild steel machining, customers now have a wider range of chip former options across more material types.

DL chip former features

- Suitable for mild steel & low carbon steel machining due to its improved chip segmenting capability
- Mild steel application range expanded

SOMT...DL

Insert



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	Coating
		TT9080
	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

Recommended Cutting Conditions

■ 2,3,4,5xD

ISO	Material	Condition	Tensile Strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc (m/min)	Feed (mm/rev) vs. drill diameter Drill length 2,3,4,5xD			
							SOMT 05 Ø14 - Ø16	SOMT 06 Ø17 - Ø19	SOMT 07 Ø20 - Ø22	SOMT 08 Ø23 - Ø26
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C Annealed	420	125	1	220-350	0.04-0.08	0.04-0.08	0.06-0.10	0.06-0.10
		≥0.25%C Annealed	650	190	2	180-280	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12
		<0.55%C Quenched and tempered	850	250	3	140-240	0.06-0.12	0.06-0.12	0.06-0.15	0.06-0.15
		≥0.55%C Annealed	750	220	4	140-240	0.06-0.12	0.06-0.12	0.06-0.15	0.06-0.15
		Quenched and tempered	1000	300	5	140-240	0.06-0.12	0.06-0.12	0.06-0.15	0.06-0.15
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed	600	200	6	140-240	0.06-0.12	0.06-0.12	0.06-0.15	0.06-0.15
			930	275	7	100-180	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
		Quenched and tempered	1000	300	8	100-180	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
			1200	350	9	100-180	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	140-200	0.06-0.10	0.06-0.12	0.06-0.12	0.06-0.12
		Quenched and tempered	1100	325	11	100-160	0.06-0.10	0.06-0.12	0.06-0.12	0.06-0.12

ISO	Material	Condition	Tensile Strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc (m/min)	Feed (mm/rev) vs. drill diameter Drill length 2,3,4,5xD			
							SOMT 09 Ø27 - Ø31	SOMT 09 Ø32 - Ø36	SOMT 13 Ø37 - Ø43	SOMT 15 Ø44 - Ø50
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C Annealed	420	125	1	220-350	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
		≥0.25%C Annealed	650	190	2	180-280	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
		<0.55%C Quenched and tempered	850	250	3	140-240	0.06-0.15	0.06-0.15	0.06-0.15	0.06-0.15
		≥0.55%C Annealed	750	220	4	140-240	0.06-0.15	0.06-0.15	0.06-0.15	0.06-0.15
		Quenched and tempered	1000	300	5	140-240	0.06-0.15	0.06-0.15	0.06-0.15	0.06-0.15
	Low alloy steel and cast steel (Less than 5% of alloying elements)	Annealed	600	200	6	140-240	0.06-0.15	0.06-0.15	0.06-0.15	0.06-0.15
			930	275	7	100-180	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
		Quenched and tempered	1000	300	8	100-180	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
			1200	350	9	100-180	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	140-200	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
		Quenched and tempered	1100	325	11	100-160	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12

Steel