

NPN

New Product News



DRILLSPEED

INDEXABLE 3 FLUTE

New 8xD Holder for Deep Hole Drilling and Head Diameter Expansion



KEY POINT

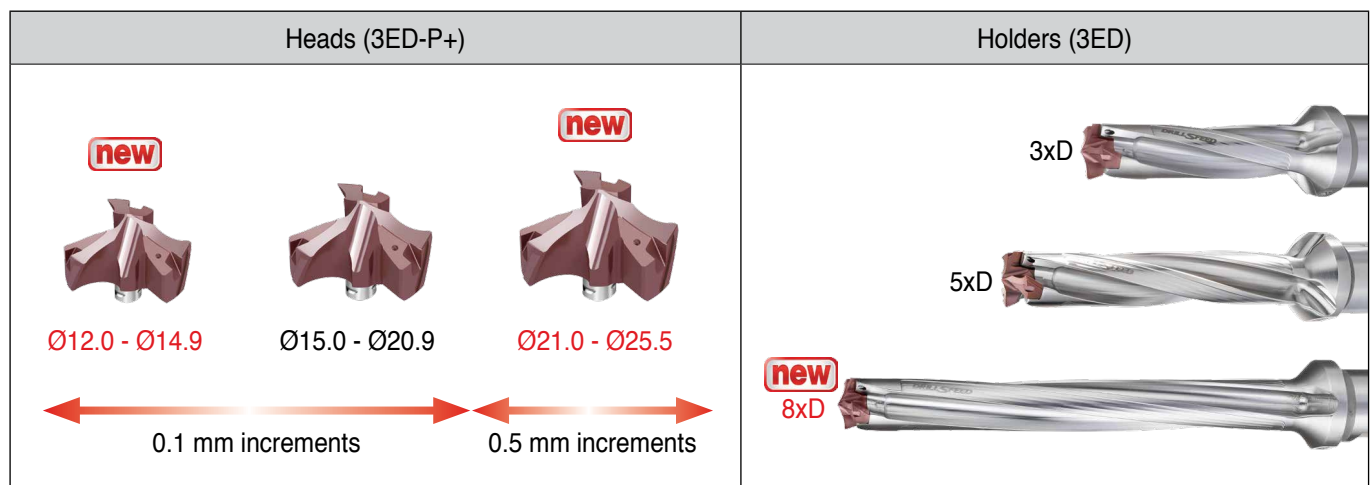
TaeguTec has significantly expanded the 3-flutes head changeable DRILL-SFEED product line's diameter range with the introduction of a new 8xD drilling depth holder.

The DRILL-SFEED family of unique 3-flutes geometry drills, which improve productivity, can be applied to various industries with a wider diameter and drilling depths. The drill diameter range has been expanded from Ø15.0-Ø20.9 mm to Ø12.0-Ø25.5 mm, and an 8xD holder has been included for deep hole drilling, enabling the same high tolerance hole precision at various drilling depths.

For further information, please contact the product manager.

Features

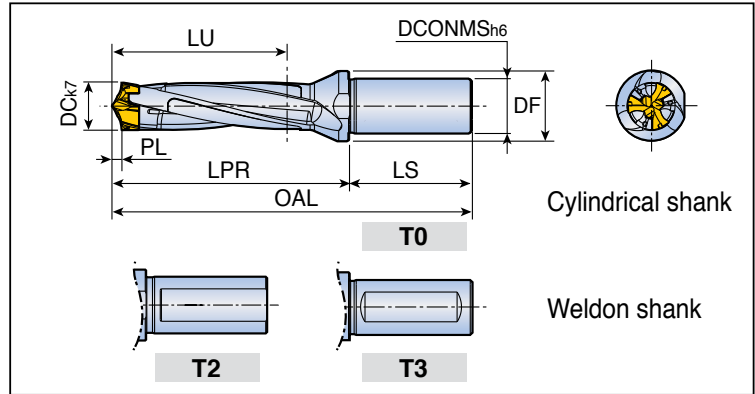
- Wider drill head diameter range: Ø12.0-25.5 mm
 - Ø12.0- Ø20.9: 0.1 mm increments
 - Ø12.0- Ø25.5: 0.5 mm increments
- Line expanded to 8xD following the current 3xD and 5xD depth holders
- 3-flute geometry for improved productivity
- Self-centering P+ geometry for high tolerance hole precision
- Head exchangeable drills reduce tooling downtime



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



Head changeable 3 flute drill holders



• Drilling depth: 3xdiameter



Designation	Dimension (mm)								Clamping key
	DC	DCONMS	DF	LU	LPR	LS	PL	SSC	
3ED 120-124-16T3/T0-3D new	12.0-12.4	16	20	40.0	60.7	48	2.74	12	K 3ED D12-D13
125-129-16T3/T0-3D new	12.5-12.9	16	20	41.5	62.5	48	2.76	12	K 3ED D12-D13
130-134-16T3/T0-3D new	13.0-13.4	16	20	43.0	64.8	48	2.91	13	K 3ED D12-D13
135-139-16T3/T0-3D new	13.5-13.9	16	20	44.5	66.6	48	2.93	13	K 3ED D12-D13
140-144-16T3/T0-3D new	14.0-14.4	16	20	46.0	68.9	48	3.17	14	K 3ED D14-D15
145-149-16T3/T0-3D new	14.5-14.9	16	20	47.5	70.7	48	3.19	14	K 3ED D14-D15
150-159-20T3/T0-3D	15.0-15.9	20	25	49.0	73.9	50	3.31	15	K 3ED D14-D15
160-169-20T3/T0-3D	16.0-16.9	20	25	52.0	79.0	50	3.70	16	K 3ED D16-D17
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	K 3ED D18-D19
190-199-25T2/T0-3D	19.0-19.9	25	32	61.0	94.7	56	4.26	19	K 3ED D18-D19
200-209-25T2/T0-3D	20.0-20.9	25	32	64.0	99.3	56	4.44	20	K 3ED D20-D21
210-219-25T2/T0-3D new	21.0-21.9	25	32	67.0	103.8	56	4.62	21	K 3ED D20-D21
220-229-25T2/T0-3D new	22.0-22.9	25	32	70.0	108.4	56	4.78	22	K 3ED D22-D23
230-239-32T2/T0-3D new	23.0-23.9	32	42	73.0	112.8	60	5.02	23	K 3ED D22-D23
240-249-32T2/T0-3D new	24.0-24.9	32	42	76.0	117.4	60	5.18	24	K 3ED D24-D25
250-259-32T2/T0-3D new	25.0-25.9	32	42	79.0	122.0	60	5.29	25	K 3ED D24-D25

► SSC: Seat size code
► OAL: LPR+LS

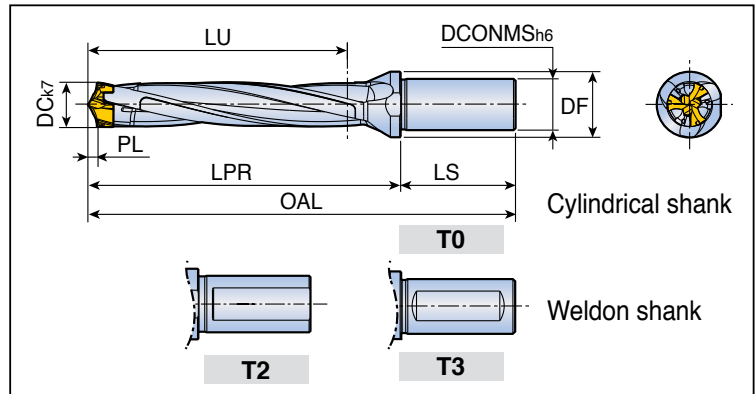
3ED...T...-5D



Head changeable 3 flute drill holders



- Drilling depth: 5xdiameter

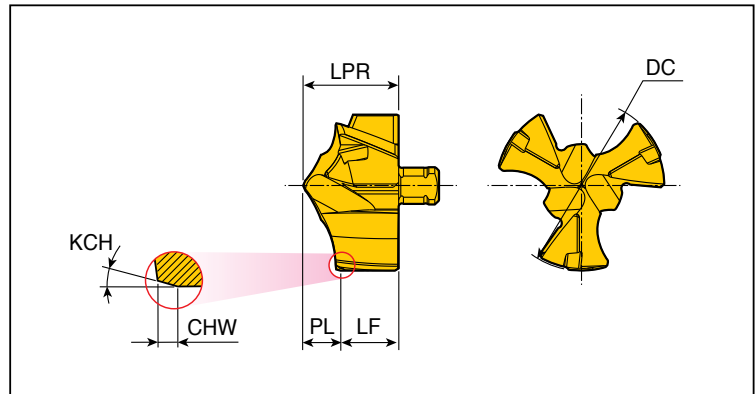


Designation	Dimension (mm)									Clamping key
	DC	DCONMS	DF	LU	LPR	LS	PL	SSC		
3ED 120-124-16T3/T0-5D new	12.0-12.4	16	20	64.0	84.7	48	2.74	12	K 3ED D12-D13	
125-129-16T3/T0-5D new	12.5-12.9	16	20	66.5	87.5	48	2.76	12	K 3ED D12-D13	
130-134-16T3/T0-5D new	13.0-13.4	16	20	69.0	90.8	48	2.91	13	K 3ED D12-D13	
135-139-16T3/T0-5D new	13.5-13.9	16	20	71.5	93.6	48	2.93	13	K 3ED D12-D13	
140-144-16T3/T0-5D new	14.0-14.4	16	20	74.0	96.9	48	3.17	14	K 3ED D14-D15	
145-149-16T3/T0-5D new	14.5-14.9	16	20	76.5	99.7	48	3.19	14	K 3ED D14-D15	
150-159-20T3/T0-5D	15.0-15.9	20	25	79.0	103.9	50	3.31	15	K 3ED D14-D15	
160-169-20T3/T0-5D	16.0-16.9	20	25	84.0	111.0	50	3.70	16	K 3ED D16-D17	
170-179-20T3/T0-5D	17.0-17.9	20	25	89.0	118.0	50	3.88	17	K 3ED D16-D17	
180-189-25T2/T0-5D	18.0-18.9	25	32	94.0	126.1	56	4.07	18	K 3ED D18-D19	
190-199-25T2/T0-5D	19.0-19.9	25	32	99.0	132.7	56	4.26	19	K 3ED D18-D19	
200-209-25T2/T0-5D	20.0-20.9	25	32	104.0	139.3	56	4.44	20	K 3ED D20-D21	
210-219-25T2/T0-5D new	21.0-21.9	25	32	109.0	145.8	56	4.62	21	K 3ED D20-D21	
220-229-25T2/T0-5D new	22.0-22.9	25	32	114.0	152.4	56	4.78	22	K 3ED D22-D23	
230-239-32T2/T0-5D new	23.0-23.9	32	42	119.0	158.8	60	5.02	23	K 3ED D22-D23	
240-249-32T2/T0-5D new	24.0-24.9	32	42	124.0	165.4	60	5.18	24	K 3ED D24-D25	
250-259-32T2/T0-5D new	25.0-25.9	32	42	129.0	172.0	60	5.29	25	K 3ED D24-D25	

► SSC: Seat size code
► OAL: LPR+LS

3ED...-P+

3 flute self-centering drill heads



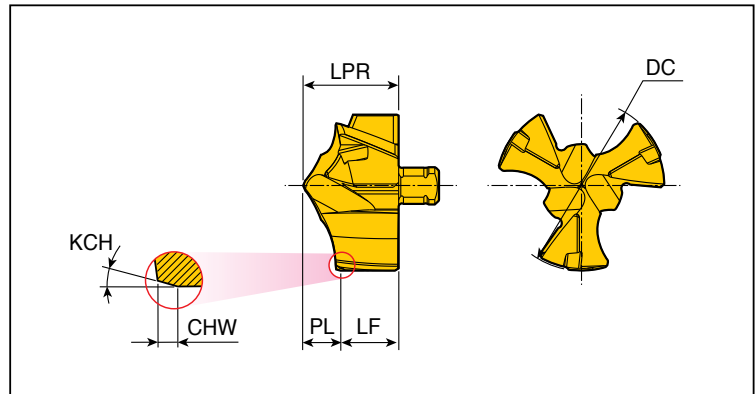
Designation	Dimension (mm)							Grade
	DC	LPR	PL	LF	CHW	KCH	SSC	TT5130
3ED- 120-P+ new	12.0	6.7	2.74	3.96	0.4	15	12	●
121-P+ new	12.1	6.7	2.74	3.96	0.4	15	12	●
122-P+ new	12.2	6.7	2.74	3.96	0.4	15	12	●
123-P+ new	12.3	6.7	2.74	3.96	0.4	15	12	●
124-P+ new	12.4	6.7	2.74	3.96	0.4	15	12	●
125-P+ new	12.5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

► SSC: Seat size code

●: Standard items

3ED...-P+

3 flute self-centering drill heads



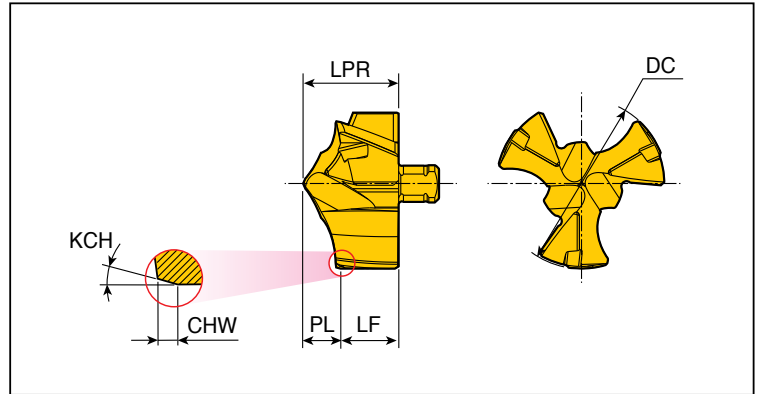
Designation	Dimension (mm)							Grade
	DC	LPR	PL	LF	CHW	KCH	SSC	TT5130
3ED- 150-P+	15.0	8.4	3.31	5.09	0.5	30	15	●
151-P+	15.1	8.4	3.31	5.09	0.5	30	15	●
152-P+	15.2	8.4	3.31	5.09	0.5	30	15	●
153-P+	15.3	8.4	3.31	5.09	0.5	30	15	●
154-P+	15.4	8.4	3.31	5.09	0.5	30	15	●
155-P+	15.5	8.4	3.32	5.08	0.5	30	15	●
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	●

► SSC: Seat size code

●: Standard items

3ED...-P+

3 flute self-centering drill heads



Designation	Dimension (mm)							Grade
	DC	LPR	PL	LF	CHW	KCH	SSC	TT5130
3ED- 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	●
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	●

► SSC: Seat size code

●: Standard items

Recommended Cutting Conditions

ISO	Material	Condition	Tensile Strength (N/mm ²)	Hardness HB	Material Group No	Cutting Speed Vc (m/min)	Feed vs. Drill Diameter (mm/rev)			
							Ø12-Ø13.9	Ø14-Ø15.9	Ø16-Ø19.9	Ø20-Ø25.9
P	Non-alloy steel and cast steel, free cutting steel	<0.25%C Annealed	420	125	1	80-140	0.25-0.45	0.30-0.50	0.35-0.55	0.40-0.60
		>=0.25%C Annealed	650	190	2	80-130	0.25-0.45	0.30-0.50	0.35-0.55	0.40-0.60
		<0.55%C Quenched and tempered	850	250	3	80-120	0.25-0.45	0.30-0.50	0.35-0.55	0.40-0.60
		>=0.55%C Annealed	750	220	4	70-110	0.25-0.45	0.30-0.50	0.35-0.55	0.40-0.60
		Quenched and tempered	1000	300	5	50-90	0.25-0.45	0.30-0.50	0.35-0.55	0.40-0.60
	Low alloy steel and cast steel (less than 5% of alloying elements)	Annealed	600	200	6	80-120	0.20-0.40	0.25-0.45	0.30-0.50	0.35-0.55
		Quenched and tempered	930	275	7	70-110	0.20-0.40	0.25-0.45	0.30-0.50	0.35-0.55
			1000	300	8	50-90	0.20-0.40	0.25-0.45	0.30-0.50	0.35-0.55
	High alloy steel, cast steel and tool steel	Quenched and tempered	1200	350	9	40-70	0.20-0.40	0.25-0.45	0.30-0.50	0.35-0.55
			Annealed	680	200	10	50-90	0.20-0.35	0.25-0.40	0.30-0.45
K	Grey cast iron (GG)	Ferritic		160	15	90-160	0.35-0.50	0.40-0.60	0.45-0.65	0.50-0.70
		Pearlitic		250	16	80-140	0.35-0.50	0.40-0.60	0.45-0.65	0.50-0.70
	Cast iron nodular (GGG)	Ferritic		180	17	90-180	0.30-0.45	0.35-0.55	0.40-0.60	0.45-0.65
		Pearlitic		260	18	80-140	0.30-0.45	0.35-0.55	0.40-0.60	0.45-0.65
	Malleable cast iron	Ferritic		130	19	90-160	0.30-0.45	0.35-0.55	0.40-0.60	0.45-0.65
		Pearlitic		230	20	80-140	0.30-0.45	0.35-0.55	0.40-0.60	0.45-0.65

■ Steel ■ Cast iron

► For 8xD drill holder, reduce the feed by 30%.