

NEW PRODUCT NEWS

DRILL•RUSH



CHAMFERING RINGS FOR DRILL•RUSH

Available for **TOPDRILL** and **T-DRILL**



CHAMFERING RINGS FOR *DRILL•RUSH*

Available for *TOPDRILL* and *T-DRILL*

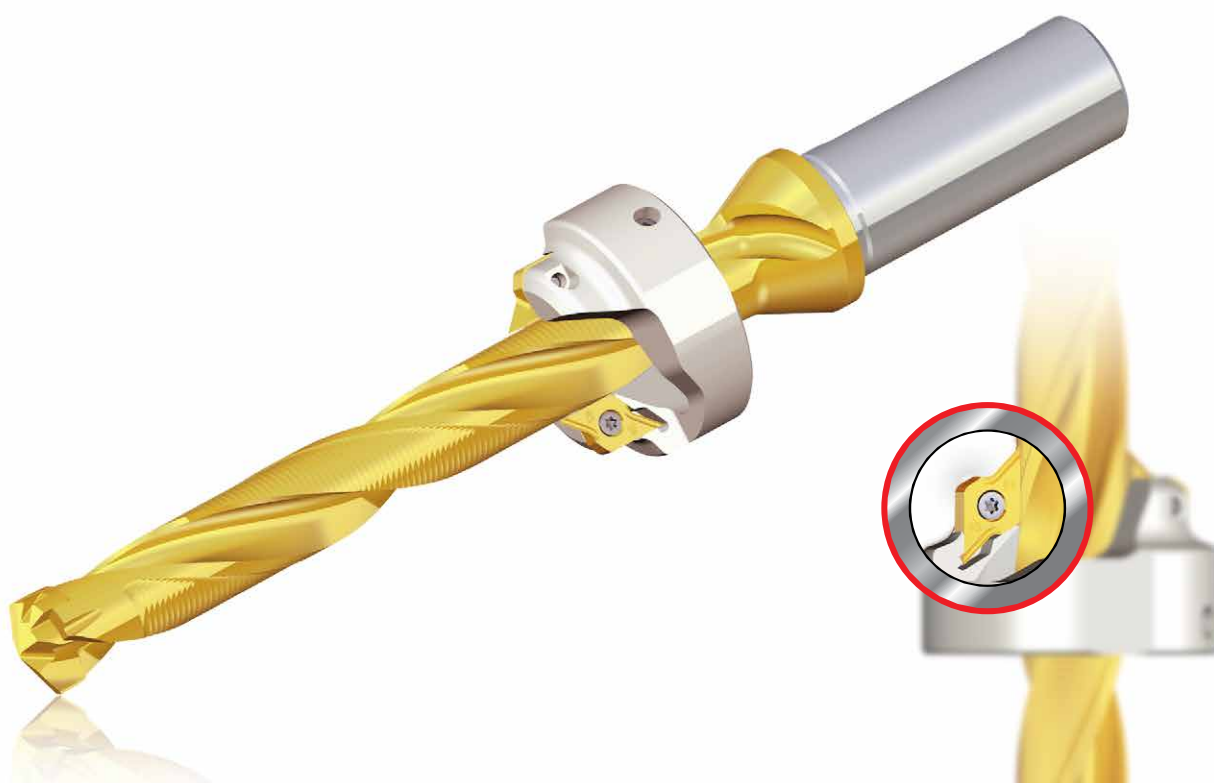
FEATURES

- Compatible with DRILLRUSH
- Available for TOPDRILL and T-DRILL with 3XD, 4XD
- Adjustable step length
- Minimized cycle time credit to drilling / chamfering as a single operation

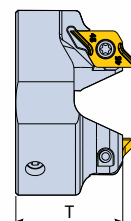
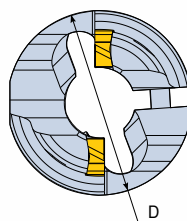
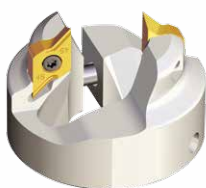
TaeguTec, the supplier of cost competitive high productivity indexable drill lines, now introduces chamfering rings to promote machining convenience for end-users in hole making applications.

TaeguTec chamfering rings can be used to drill and chamfer in a single operation to minimize cycle time as well as inventory for improved economy.

All chamfering rings are compatible with DRILLRUSH, TOPDRILL as well as T-DRILL holders to control drilling depth. The TT9080 specially treated, multi-layered PVD coated CRNG inserts enable stable machining and long tool life.



Chamfering ring **new**



Designation	Dimension (mm)		Chamfer Size	Chamfer Insert	Insert Screw	Wrench	Clamping Screw	L-Wrench
	D	T						
CFR D100-A45	34	20	2	CRNG 0802-45CD	SO 25065I	TD 7	SH M4x0.7x12 ⁽¹⁾	L-W3
D105-A45	34	20	2					
D110-A45	34	20	2					
D115-A45	34	20	2					
D120-A45	34	20	2					
D125-A45	34	20	2					
D130-A45	34	20	2					
D135-A45	34	20	2					
D140-A45	38	22	2					
D145-A45	38	22	2					
D150-A45	38	22	2					
D160-A45	42	23	2				SH M5x0.8x16 ⁽²⁾	L-W4
D170-A45	42	23	2					
D180-A45	42	23	2					
D190-A45	42	24	2					
D200-A45	42	24	2					
D210-A45	47	24	2					
D220-A45	47	24	2					
D230-A45	47	24	2					
D240-A45	47	24	2					
D250-A45	47	24	2					

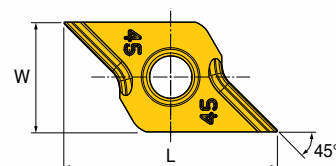
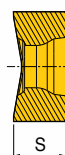
* (1) Clamping torque : 4 [N·m]

* (2) Clamping torque : 6-7 [N·m]

Insert **new**

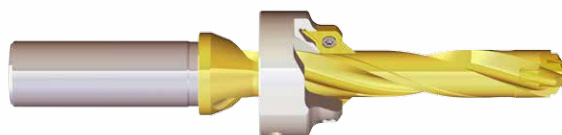
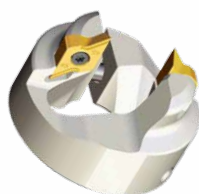


• Grade: TT9080



Designation	L	W	S
CRNG 0802-45CD	14.80	7.5	3.65

Assembly



(Available for TOPDRILL & T-DRILL in 3xD, 4xD)

DRILLRUSH	
Diameter range	Chamfering ring description
10.0-10.4	CFR D100-A45
10.5-10.9	CFR D105-A45
11.0-11.4	CFR D110-A45
11.5-11.9	CFR D115-A45
12.0-12.4	CFR D120-A45
12.4-12.9	CFR D125-A45
13.0-13.4	CFR D130-A45
13.5-13.9	CFR D135-A45
14.0-14.4	CFR D140-A45
14.5-14.9	CFR D145-A45
15.0-15.9	CFR D150-A45
16.0-16.9	CFR D160-A45
17.0-17.9	CFR D170-A45
18.0-18.9	CFR D180-A45
19.0-19.9	CFR D190-A45
20.0-20.9	CFR D200-A45
21.0-21.9	CFR D210-A45
22.0-22.9	CFR D220-A45
23.0-23.9	CFR D230-A45
24.0-24.9	CFR D240-A45
25.0-25.9	CFR D250-A45

TOPDRILL & T-DRILL	
Diameter range	Chamfering ring description
-	-
-	-
-	-
-	-
-	-
12.5-12.9	CFR D125-A45
13.0-13.4	CFR D130-A45
13.5-13.9	CFR D135-A45
14.0-14.4	CFR D140-A45
14.5-14.9	CFR D145-A45
15.0-15.4	CFR D150-A45
15.5-16.4	CFR D160-A45
16.5-17.4	CFR D170-A45
17.5-18.5	CFR D180-A45
18.6-19.5	CFR D190-A45
19.6-20.5	CFR D200-A45
20.6-21.5	CFR D210-A45
21.6-22.5	CFR D220-A45
22.6-23.5	CFR D230-A45
23.6-24.5	CFR D240-A45
24.6-25.5	CFR D250-A45

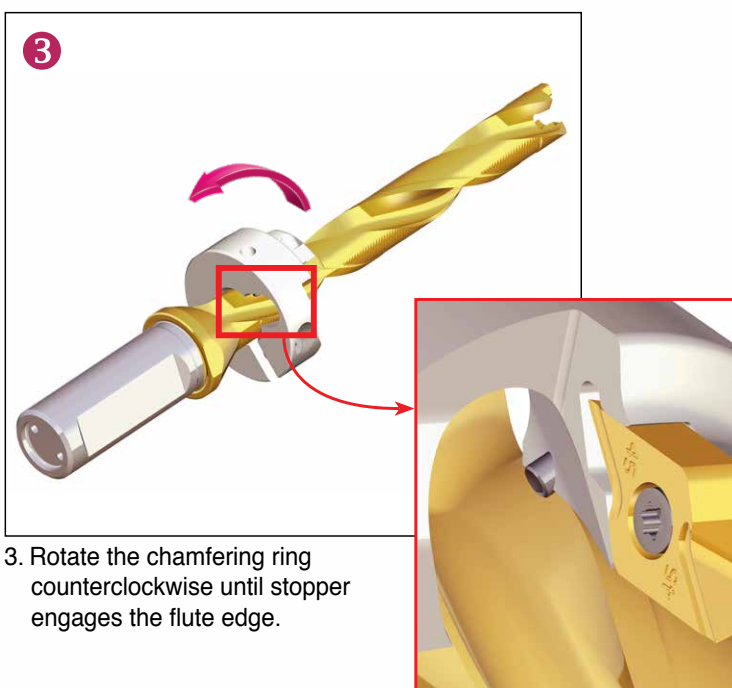
Assembly of chamfering ring



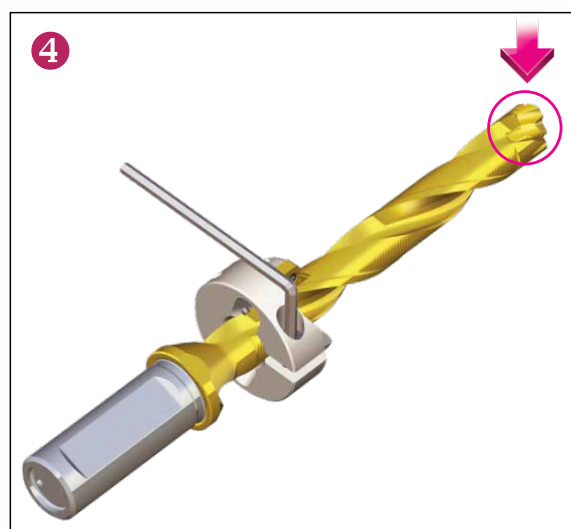
1. Insert the chamfering ring on to the drill body.
The stopper must be inside the flute.



2. Slide the chamfering ring to the desired position.

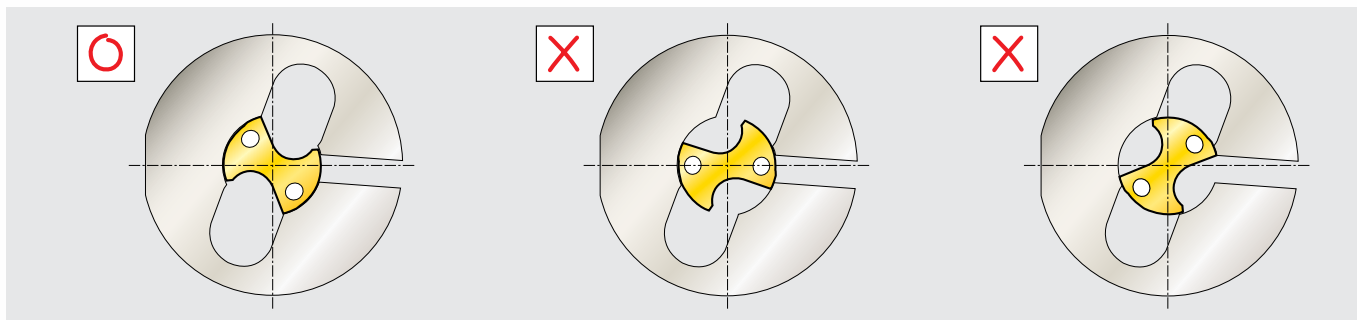


3. Rotate the chamfering ring counterclockwise until stopper engages the flute edge.

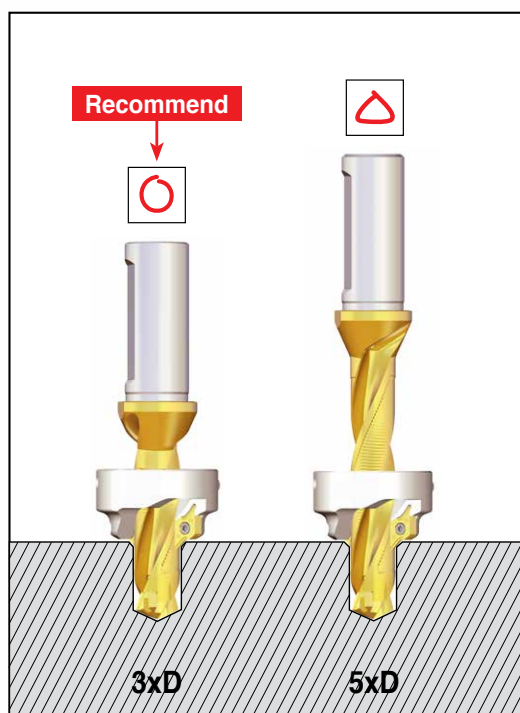


4. Tighten the chamfering ring and clamp the drill head.

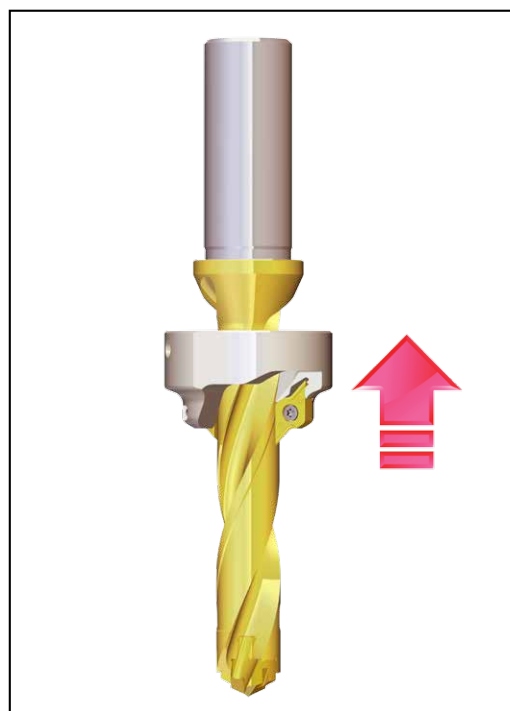
**When the chamfering ring is clamped correctly,
the drill flute will be aligned with the chamfering ring flute.**



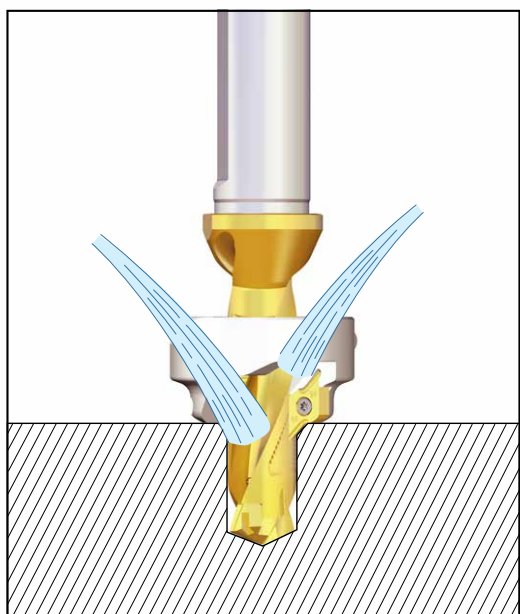
Recommendations for stable machining



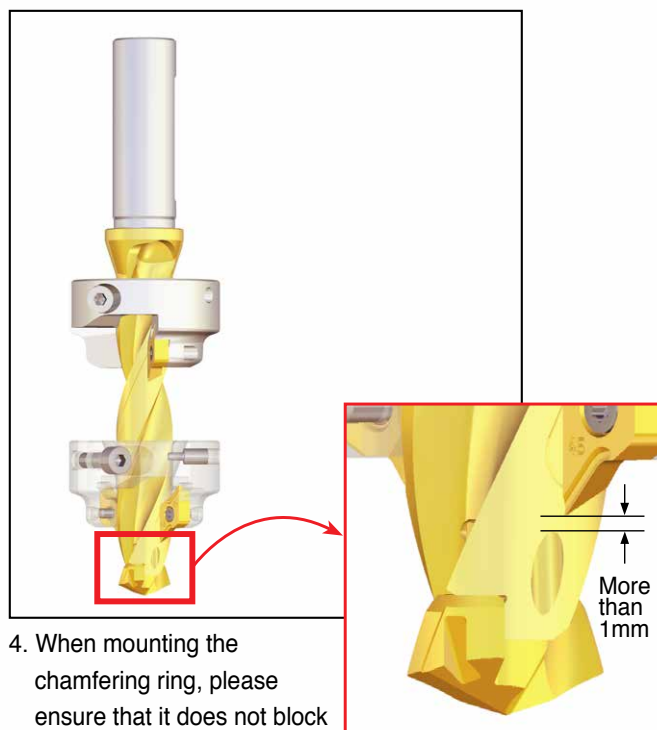
1. If possible, always use a short holder.
If not, reduce the cutting speed to minimize vibration.



2. Mount the chamfering ring as close as possible to the drill shank when drilling a through hole.

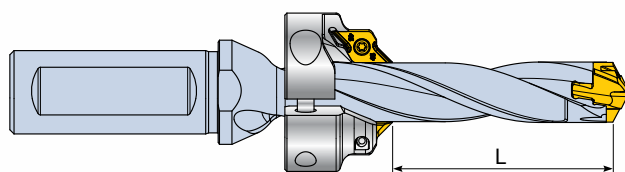


3. For better insert life, apply external and internal coolant to the insert.



4. When mounting the chamfering ring, please ensure that it does not block the coolant.

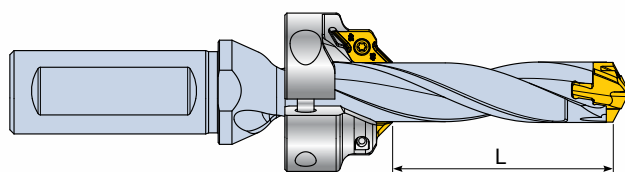
DRILLRUSH



	Designation	CFR Designation	L	
			min	max
3D	TCD 130-134-16T3-3D	CFR D130-A45	19	19
	135-139-16T3-3D	CFR D135-A45	19	20
	140-144-16T3-3D	CFR D140-A45	21	22
	145-149-16T3-3D	CFR D145-A45	22	23
	150-159-20T3-3D	CFR D150-A45	23	23
	160-169-20T3-3D	CFR D160-A45	24	25
	170-179-20T3-3D	CFR D170-A45	26	28
	180-189-25T2-3D	CFR D180-A45	27	30
	190-199-25T2-3D	CFR D190-A45	29	33
	200-209-25T2-3D	CFR D200-A45	30	36
	210-219-25T2-3D	CFR D210-A45	32	39
	220-229-25T2-3D	CFR D220-A45	33	42
	230-239-32T2-3D	CFR D230-A45	35	45
	240-249-32T2-3D	CFR D240-A45	36	48
	250-259-32T2-3D	CFR D250-A45	38	51
5D	TCD 100-104-16T3-5D	CFR D100-A45	28	28
	105-109-16T3-5D	CFR D105-A45	29	30
	110-114-16T3-5D	CFR D110-A45	31	33
	115-119-16T3-5D	CFR D115-A45	32	35
	120-124-16T3-5D	CFR D120-A45	33	45
	125-129-16T3-5D	CFR D125-A45	34	40
	130-134-16T3-5D	CFR D130-A45	36	43
	135-139-16T3-5D	CFR D135-A45	37	43
	140-144-16T3-5D	CFR D140-A45	38	48
	145-149-16T3-5D	CFR D145-A45	39	48
	150-159-20T3-5D	CFR D150-A45	41	53
	160-169-20T3-5D	CFR D160-A45	43	58
	170-179-20T3-5D	CFR D170-A45	46	63
	180-189-25T2-5D	CFR D180-A45	48	68
	190-199-25T2-5D	CFR D190-A45	51	73
	200-209-25T2-5D	CFR D200-A45	53	78
	210-219-25T2-5D	CFR D210-A45	56	79
8D	220-229-25T2-5D	CFR D220-A45	58	84
	230-239-32T2-5D	CFR D230-A45	61	89
	240-249-32T2-5D	CFR D240-A45	63	94
	250-259-32T2-5D	CFR D250-A45	66	99
	TCD 100-104-16T3-8D	CFR D100-A45	45	58
	105-109-16T3-8D	CFR D105-A45	49	62
	110-114-16T3-8D	CFR D110-A45	49	66



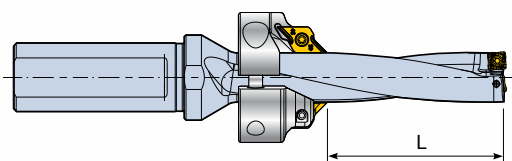
DRILLRUSH



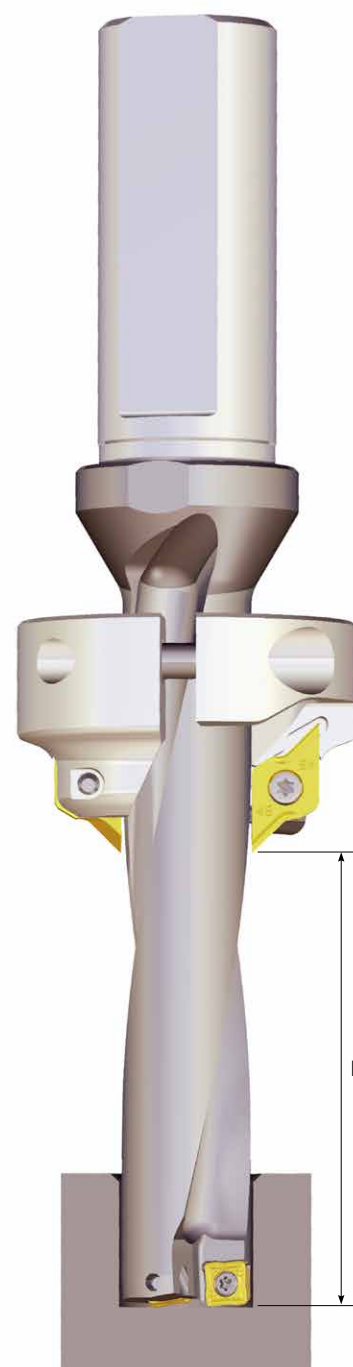
	Designation	CFR Designation	L	
			min	max
8D	TCD 115-119-16T3-8D	CFR D115-A45	53	70
	120-124-16T3-8D	CFR D120-A45	53	74
	125-129-16T3-8D	CFR D125-A45	57	78
	130-134-16T3-8D	CFR D130-A45	57	82
	135-139-16T3-8D	CFR D135-A45	61	84
	140-144-16T3-8D	CFR D140-A45	61	88
	145-149-16T3-8D	CFR D145-A45	65	92
	150-159-20T3-8D	CFR D150-A45	65	96
	160-169-20T3-8D	CFR D160-A45	69	103
	170-179-20T3-8D	CFR D170-A45	73	111
	180-189-25T2-8D	CFR D180-A45	77	118
	190-199-25T2-8D	CFR D190-A45	81	126
	200-209-25T2-8D	CFR D200-A45	85	134
	210-219-25T2-8D	CFR D210-A45	89	142
	220-229-25T2-8D	CFR D220-A45	93	150
	230-239-32T2-8D	CFR D230-A45	97	158
	240-249-32T2-8D	CFR D240-A45	101	166
	250-259-32T2-8D	CFR D250-A45	105	174
12D	TCD 100-104-16T3-12D	CFR D100-A45	75	97
	105-109-16T3-12D	CFR D105-A45	78	103
	110-114-16T3-12D	CFR D110-A45	81	109
	115-119-16T3-12D	CFR D115-A45	84	115
	120-124-16T3-12D	CFR D120-A45	87	121
	125-129-16T3-12D	CFR D125-A45	90	127
	130-134-16T3-12D	CFR D130-A45	93	133
	135-139-16T3-12D	CFR D135-A45	96	137
	140-144-16T3-12D	CFR D140-A45	99	143
	145-149-16T3-12D	CFR D145-A45	102	149
	150-159-20T3-12D	CFR D150-A45	105	155
	160-169-20T3-12D	CFR D160-A45	111	166
	170-179-20T3-12D	CFR D170-A45	117	178
	180-189-25T2-12D	CFR D180-A45	123	189
	190-199-25T2-12D	CFR D190-A45	129	201
	200-209-25T2-12D	CFR D200-A45	135	213
	210-219-25T2-12D	CFR D210-A45	141	225
	220-229-25T2-12D	CFR D220-A45	147	237
	230-239-32T2-12D	CFR D230-A45	153	249
	240-249-32T2-12D	CFR D240-A45	159	261
	250-259-32T2-12D	CFR D250-A45	165	273



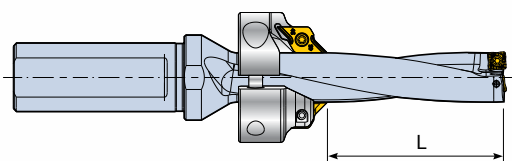
TOPDRILL and T-DRILL



	TOPDRILL	T-DRILL	CFR Designation	L	
				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
4D	TOP -	TDR 4125-20T2-05	CFR D125-A45	25	26
	-	4130-20T2-05	CFR D130-A45	25	26
	-	4135-20T2-05	CFR D135-A45	27	30
	4140-20T2-05	4140-20T2-05	CFR D140-A45	28	30
	4145-20T2-05	4145-20T2-05	CFR D145-A45	29	34
	4150-20T2-05	4150-20T2-05	CFR D150-A45	30	34
	4155-20T2-05	4155-25T2-06	CFR D160-A45	31	37
	4160-20T2-05	4160-25T2-06	CFR D160-A45	32	37
	4165-25T2-06	4165-25T2-06	CFR D170-A45	33	41
	4170-25T2-06	4170-25T2-06	CFR D170-A45	34	41
	4175-25T2-06	4175-25T2-06	CFR D180-A45	35	45
	4180-25T2-06	4180-25T2-06	CFR D180-A45	36	44
	4185-25T2-06	4185-25T2-06	CFR D180-A45	37	48
	4190-25T2-06	4190-25T2-06	CFR D190-A45	38	48
	4195-25T2-07	4195-25T2-06	CFR D190-A45	39	52



TOPDRILL and T-DRILL



	TOPDRILL	T-DRILL	CFR Designation	L	
				min	max
4D	TOP 4200-25T2-07	TDR 4200-25T2-06	CFR D200-A45	40	52
	4205-25T2-07	4205-25T2-06	CFR D200-A45	41	56
	4210-25T2-07	4210-25T2-06	CFR D210-A45	42	56
	4215-25T2-07	4215-25T2-07	CFR D210-A45	43	60
	4220-25T2-07	4220-25T2-07	CFR D220-A45	44	60
	4225-25T2-08	4225-25T2-07	CFR D220-A45	45	64
	4230-25T2-08	4230-25T2-07	CFR D230-A45	46	64
	4235-25T2-08	4235-25T2-07	CFR D230-A45	47	68
	4240-25T2-08	4240-25T2-07	CFR D240-A45	48	68
	4245-25T2-08	4245-25T2-07	CFR D240-A45	49	72
5D	4250-25T2-08	4250-25T2-07	CFR D250-A45	50	72
	TOP -	TDR 5125-20T2-05	CFR D125-A45	31	39
	-	5130-20T2-05	CFR D130-A45	33	39
	-	5135-20T2-05	CFR D135-A45	34	44
	5140-20T2-05	5140-20T2-05	CFR D140-A45	35	44
	5145-20T2-05	5145-20T2-05	CFR D145-A45	36	49
	5150-20T2-05	5150-20T2-05	CFR D150-A45	38	49
	5155-20T2-05	5155-25T2-06	CFR D160-A45	39	53
	5160-20T2-05	5160-25T2-06	CFR D160-A45	40	53
	5165-25T2-06	5165-25T2-06	CFR D170-A45	41	58
	5170-25T2-06	5170-25T2-06	CFR D170-A45	43	58
	5175-25T2-06	5175-25T2-06	CFR D180-A45	44	63
	5180-25T2-06	5180-25T2-06	CFR D180-A45	45	62
	5185-25T2-06	5185-25T2-06	CFR D180-A45	46	67
	5190-25T2-06	5190-25T2-06	CFR D190-A45	48	67
	5195-25T2-07	5195-25T2-06	CFR D190-A45	49	72
	5200-25T2-07	5200-25T2-06	CFR D200-A45	50	72
	5205-25T2-07	5205-25T2-06	CFR D200-A45	51	77
	5210-25T2-07	5210-25T2-06	CFR D210-A45	53	77
	5215-25T2-07	5215-25T2-07	CFR D210-A45	54	82
	5220-25T2-07	5220-25T2-07	CFR D220-A45	55	82
	5225-25T2-08	5225-25T2-07	CFR D220-A45	56	87
	5230-25T2-08	5230-25T2-07	CFR D230-A45	58	87
	5235-25T2-08	5235-25T2-07	CFR D230-A45	59	92
	5240-25T2-08	5240-25T2-07	CFR D240-A45	60	92
	5245-25T2-08	5245-25T2-07	CFR D240-A45	61	97
	5250-25T2-08	5250-25T2-07	CFR D250-A45	63	97

