

NPN

New Product News



DRILLSFEED

INDEXABLE 3 FLUTE

DRILL-SFEED Line Range Expansion



KEY POINT

TaeguTec has expanded the DRILL-SFEED line by adding new diameters and drill increments.

The unique DRILL-SFEED line, with its 3 flute geometry and self-centering capability, has expanded its range with new diameters and drill increments.

The expansion includes drill heads available in 0.1 mm increments along with the existing 0.5 mm drill heads ranging from Ø16 mm to Ø20.9 mm.

The 0.1 mm increment range also applies to the new Ø15 mm to Ø15.9 mm diameters drill range.

For more information, please contact the product manager.

Features

- 3 flute geometry improves productivity
- P+ geometry for excellent hole precision
- New drill head diameter range: Ø15.0 mm - Ø15.9 mm (0.1 mm increments)
- New increments for the existing drill head diameter range: Ø16.0 mm - Ø20.9 mm (0.1 mm increments)

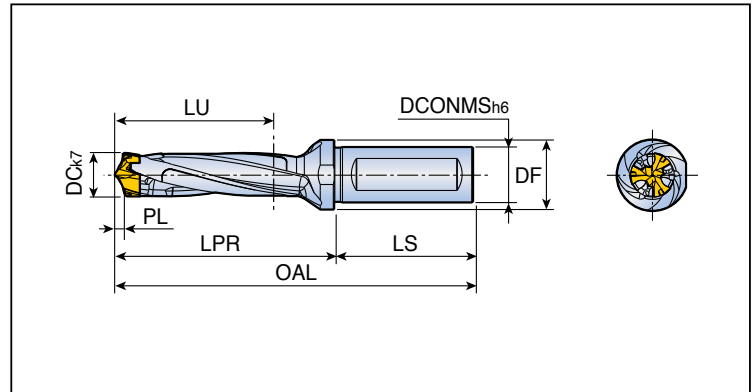
3ED...T...-3D



Head changeable 3 flute drill holders - Weldon shank



- Drilling depth: 3xdiameter



Designation	Dimension (mm)								Clamping key
	DC	DCONMS	DF	LU	LPR	LS	PL	SSC	
3ED 150-159-20T3-3D new	15.0-15.9	20	25	49	73.9	50	3.31	15	K 3ED D14-D15
160-169-20T3-3D	16.0-16.9	20	25	52	79.0	50	3.70	16	K 3ED D16-D17
170-179-20T3-3D	17.0-17.9	20	25	55	84.0	50	3.88	17	K 3ED D16-D17
180-189-25T2-3D	18.0-18.9	25	32	58	90.1	56	4.07	18	K 3ED D18-D19
190-199-25T2-3D	19.0-19.9	25	32	61	94.7	56	4.26	19	K 3ED D18-D19
200-209-25T2-3D	20.0-20.9	25	32	64	99.3	56	4.44	20	K 3ED D20-D21

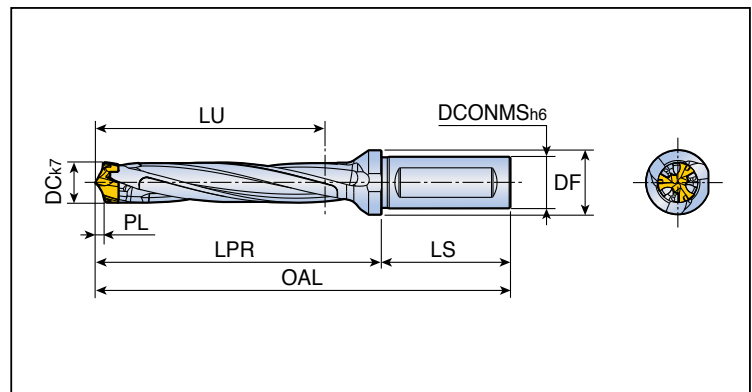
3ED...T...-5D



Head changeable 3 flute drill holders - Weldon shank



- Drilling depth: 5xdiameter



Designation	Dimension (mm)								Clamping key
	DC	DCONMS	DF	LU	LPR	LS	PL	SSC	
3ED 150-159-20T3-5D new	15.0-15.9	20	25	79	103.9	50	3.31	15	K 3ED D14-D15
160-169-20T3-5D	16.0-16.9	20	25	84	111.0	50	3.70	16	K 3ED D16-D17
170-179-20T3-5D	17.0-17.9	20	25	89	118.0	50	3.88	17	K 3ED D16-D17
180-189-25T2-5D	18.0-18.9	25	32	94	126.1	56	4.07	18	K 3ED D18-D19
190-199-25T2-5D	19.0-19.9	25	32	99	132.7	56	4.26	19	K 3ED D18-D19
200-209-25T2-5D	20.0-20.9	25	32	104	139.3	56	4.44	20	K 3ED D20-D21

- SSC: Seat size code

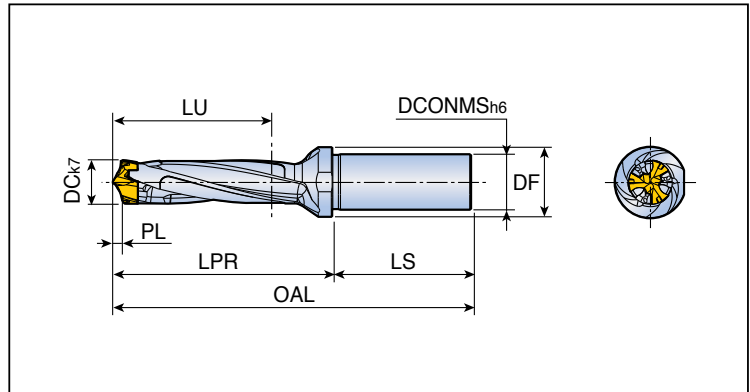
3ED...T0...-3D



Head changeable 3 flute drill holders - Cylindrical shank



- Drilling depth: 3xdiameter



Designation	Dimension (mm)								Clamping key
	DC	DCONMS	DF	LU	LPR	LS	PL	SSC	
3ED 150-159-20T0-3D new	15.0-15.9	20	25	49	73.9	50	3.31	15	K 3ED D14-D15
160-169-20T0-3D	16.0-16.9	20	25	52	79.0	50	3.70	16	K 3ED D16-D17
170-179-20T0-3D	17.0-17.9	20	25	55	84.0	50	3.88	17	K 3ED D16-D17
180-189-25T0-3D	18.0-18.9	25	32	58	90.1	56	4.07	18	K 3ED D18-D19
190-199-25T0-3D	19.0-19.9	25	32	61	94.7	56	4.26	19	K 3ED D18-D19
200-209-25T0-3D	20.0-20.9	25	32	64	99.3	56	4.44	20	K 3ED D20-D21

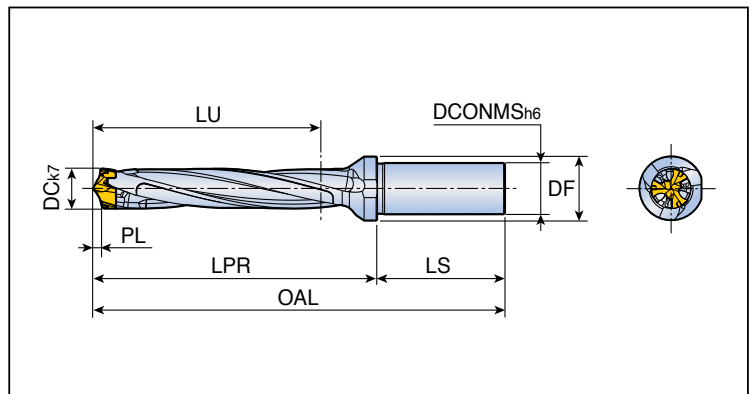
3ED...T0...-5D



Head changeable 3 flute drill holders - Cylindrical shank



- Drilling depth: 5xdiameter



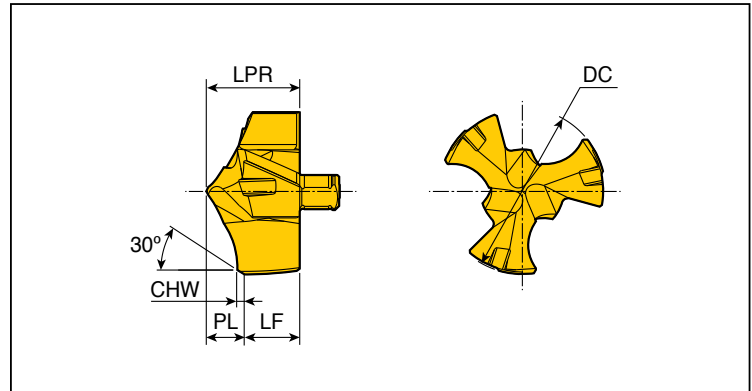
Designation	Dimension (mm)								Clamping key
	DC	DCONMS	DF	LU	LPR	LS	PL	SSC	
3ED 150-159-20T0-5D new	15.0-15.9	20	25	79	103.9	50	3.31	15	K 3ED D14-D15
160-169-20T0-5D	16.0-16.9	20	25	84	111.0	50	3.70	16	K 3ED D16-D17
170-179-20T0-5D	17.0-17.9	20	25	89	118.0	50	3.88	17	K 3ED D16-D17
180-189-25T0-5D	18.0-18.9	25	32	94	126.1	56	4.07	18	K 3ED D18-D19
190-199-25T0-5D	19.0-19.9	25	32	99	132.7	56	4.26	19	K 3ED D18-D19
200-209-25T0-5D	20.0-20.9	25	32	104	139.3	56	4.44	20	K 3ED D20-D21

- SSC: Seat size code

3ED...-P+



3 flute drill heads



Designation	Dimension (mm)						Grade TT5130
	DC	LPR	PL	LF	CHW	SSC	
3ED-150-P+ new	15.0	8.40	3.31	5.09	0.50	15	●
151-P+ new	15.1	8.40	3.31	5.09	0.50	15	●
152-P+ new	15.2	8.40	3.31	5.09	0.50	15	●
153-P+ new	15.3	8.40	3.31	5.09	0.50	15	●
154-P+ new	15.4	8.40	3.31	5.09	0.50	15	●
155-P+ new	15.5	8.40	3.32	5.08	0.50	15	●
156-P+ new	15.6	8.40	3.32	5.08	0.50	15	●
157-P+ new	15.7	8.40	3.32	5.08	0.50	15	●
158-P+ new	15.8	8.40	3.32	5.08	0.50	15	●
159-P+ new	15.9	8.40	3.32	5.08	0.50	15	●
160-P+	16.0	9.00	3.70	5.30	0.70	16	●
161-P+ new	16.1	9.00	3.70	5.30	0.70	16	●
162-P+ new	16.2	9.00	3.70	5.30	0.70	16	●
163-P+ new	16.3	9.00	3.70	5.30	0.70	16	●
164-P+ new	16.4	9.00	3.70	5.30	0.70	16	●
165-P+	16.5	9.00	3.71	5.29	0.70	16	●
166-P+ new	16.6	9.00	3.71	5.29	0.70	16	●
167-P+ new	16.7	9.00	3.71	5.29	0.70	16	●
168-P+ new	16.8	9.00	3.71	5.29	0.70	16	●
169-P+ new	16.9	9.00	3.71	5.29	0.70	16	●
170-P+	17.0	9.50	3.88	5.62	0.70	17	●
171-P+ new	17.1	9.50	3.88	5.62	0.70	17	●
172-P+ new	17.2	9.50	3.88	5.62	0.70	17	●
173-P+ new	17.3	9.50	3.88	5.62	0.70	17	●
174-P+ new	17.4	9.50	3.88	5.62	0.70	17	●
175-P+	17.5	9.50	3.89	5.61	0.70	17	●
176-P+ new	17.6	9.50	3.89	5.61	0.70	17	●
177-P+ new	17.7	9.50	3.89	5.61	0.70	17	●
178-P+ new	17.8	9.50	3.89	5.61	0.70	17	●
179-P+ new	17.9	9.50	3.89	5.61	0.70	17	●

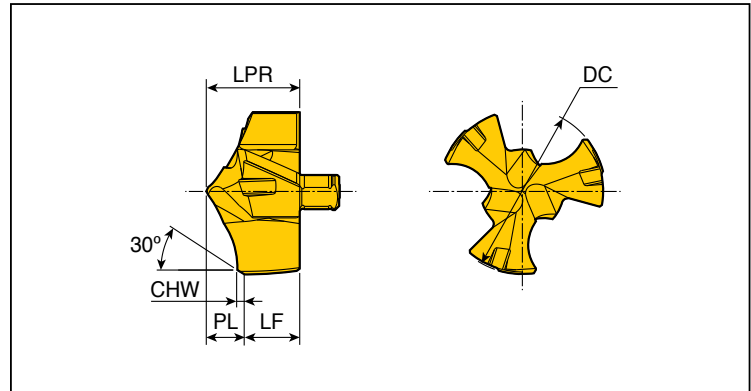
● SSC: Seat size code

●: Standard items

3ED...-P+



3 flute drill heads



Designation	Dimension (mm)						Grade
	DC	LPR	PL	LF	CHW	SSC	TT5130
3ED-180-P+	18.0	10.10	4.07	6.03	0.70	18	●
181-P+ new	18.1	10.10	4.07	6.03	0.70	18	●
182-P+ new	18.2	10.10	4.07	6.03	0.70	18	●
183-P+ new	18.3	10.10	4.07	6.03	0.70	18	●
184-P+ new	18.4	10.10	4.07	6.03	0.70	18	●
185-P+	18.5	10.10	4.08	6.02	0.70	18	●
186-P+ new	18.6	10.10	4.08	6.02	0.70	18	●
187-P+ new	18.7	10.10	4.08	6.02	0.70	18	●
188-P+ new	18.8	10.10	4.08	6.02	0.70	18	●
189-P+ new	18.9	10.10	4.08	6.02	0.70	18	●
190-P+	19.0	10.70	4.26	6.44	0.70	19	●
191-P+ new	19.1	10.70	4.26	6.44	0.70	19	●
192-P+ new	19.2	10.70	4.26	6.44	0.70	19	●
193-P+ new	19.3	10.70	4.26	6.44	0.70	19	●
194-P+ new	19.4	10.70	4.26	6.44	0.70	19	●
195-P+	19.5	10.70	4.27	6.43	0.70	19	●
196-P+ new	19.6	10.70	4.27	6.43	0.70	19	●
197-P+ new	19.7	10.70	4.27	6.43	0.70	19	●
198-P+ new	19.8	10.70	4.27	6.43	0.70	19	●
199-P+ new	19.9	10.70	4.27	6.43	0.70	19	●
200-P+	20.0	11.30	4.44	6.86	0.70	20	●
201-P+ new	20.1	11.30	4.44	6.86	0.70	20	●
202-P+ new	20.2	11.30	4.44	6.86	0.70	20	●
203-P+ new	20.3	11.30	4.44	6.86	0.70	20	●
204-P+ new	20.4	11.30	4.44	6.86	0.70	20	●
205-P+	20.5	11.30	4.45	6.85	0.70	20	●
206-P+ new	20.6	11.30	4.45	6.85	0.70	20	●
207-P+ new	20.7	11.30	4.45	6.85	0.70	20	●
208-P+ new	20.8	11.30	4.45	6.85	0.70	20	●
209-P+	20.9	11.30	4.45	6.85	0.70	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)			
							Ø15 - Ø15.9	Ø16 - Ø19.9	Ø20 - Ø20.9	
P	Non-alloy steel and cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	80-140	0.30-0.50	0.35-0.55	0.40-0.60
		>=0.25%C	Annealed	650	190	2	80-130	0.30-0.50	0.35-0.55	0.40-0.60
		<0.55%C	Quenched and tempered	850	250	3	80-120	0.30-0.50	0.35-0.55	0.40-0.60
		>=0.55%C	Annealed	750	220	4	70-110	0.30-0.50	0.35-0.55	0.40-0.60
		>=0.55%C	Quenched and tempered	1000	300	5	50-90	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	0.25-0.45	0.30-0.50	0.35-0.55	
		Quenched and tempered	930	275	7	70-110	0.25-0.45	0.30-0.50	0.35-0.55	
			1000	300	8	50-90	0.25-0.45	0.30-0.50	0.35-0.55	
			1200	350	9	40-70	0.25-0.45	0.30-0.50	0.35-0.55	
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	50-90	0.25-0.40	0.30-0.45	0.35-0.50	
Quenched and tempered		1100	325	11	40-80	0.25-0.40	0.30-0.45	0.35-0.50		
K	Grey cast iron (GG)	Ferritic/Pearlitic		180	15	90-160	0.40-0.60	0.45-0.65	0.50-0.70	
		Pearlitic		260	16	80-140	0.40-0.60	0.45-0.65	0.50-0.70	
	Cast iron nodular (GGG)	Ferritic		160	17	90-180	0.35-0.55	0.40-0.60	0.45-0.65	
		Pearlitic		250	18	80-140	0.35-0.55	0.40-0.60	0.45-0.65	
	Malleable cast iron	Ferritic		130	19	90-160	0.35-0.55	0.40-0.60	0.45-0.65	
		Pearlitic		230	20	80-140	0.35-0.55	0.40-0.60	0.45-0.65	

■ Steel ■ Cast iron