

# NPN

New Product News



## DRILL-RUSH Holder with MAXI-RUSH Connection



## KEY POINT

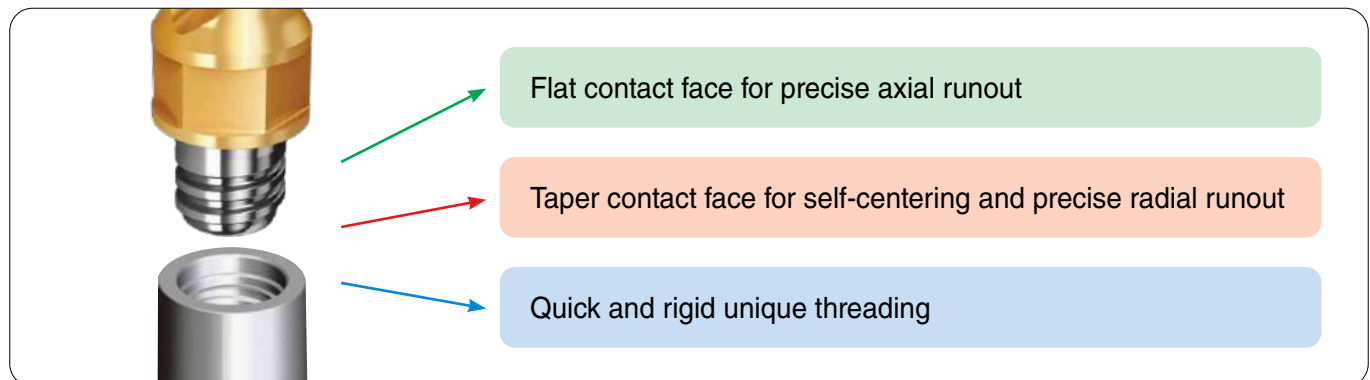
**TaeguTec's WIN-DRILL line now includes the head changeable MAXI-RUSH type holders.**

To improve the productivity of the modular head type WIN-DRILL line, they have been redesigned with the MAXI-RUSH connection, which includes a simplified clamping system and reduced set-up time.

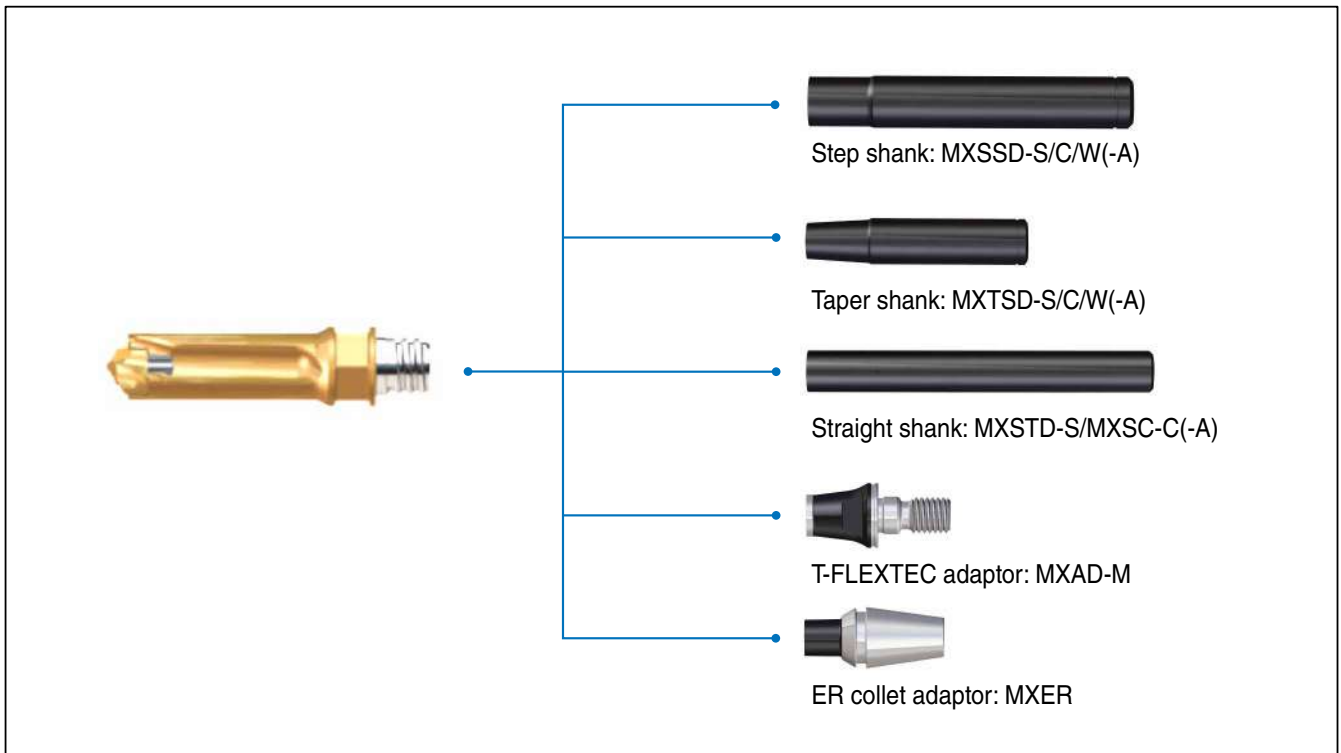
For further information, please contact the product manager.

### Features

- MAXI-RUSH type modular drill holders
- Modular design with interchangeable heads for reduced tool change and set-up time
- Shorter tool lengths allow for ease of use on multi-spindle and Swiss type machines
- Compatibility with the existing DRILL-RUSH heads: TCD-P/P+/M/K/F/N
- Available in internal coolant type

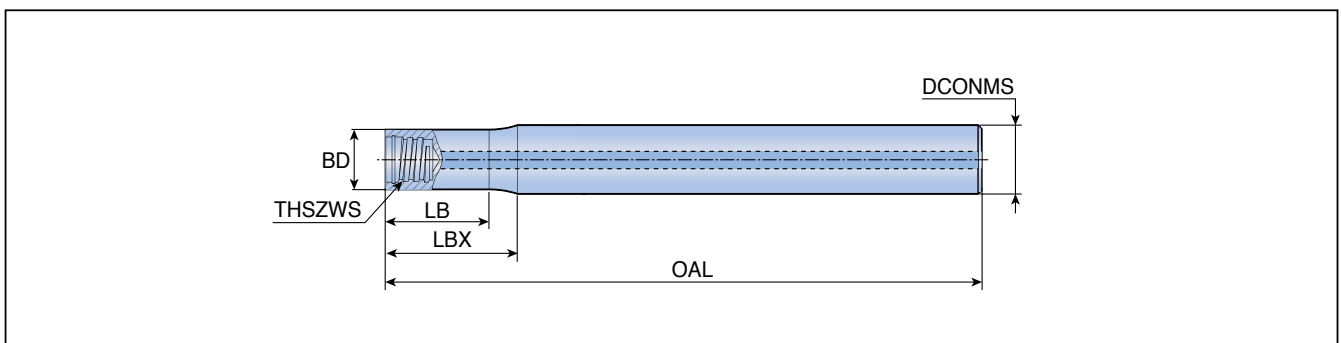


## Compatible with various MAXI-RUSH shank types



## Shank recommendations

- Shanks with center coolant supply are recommended.



Designation	Dimension (mm)						Shank material
	THSZWS	DCONMS	BD	OAL	LB	LBX	
<b>MXSSD 10L075S06-S-A</b>	S06	10	9.6	75	10.6	12	Steel
<b>12L070S08-C-A</b>	S08	12	11.5	70	17.0	20	Carbide
<b>12L090LS08-C-A</b>	S08	12	11.5	90	37.0	40	Carbide
<b>12L090S08-S-A</b>	S08	12	11.5	90	13.6	16	Steel
<b>12L090LS08-S-A</b>	S08	12	11.5	90	37.0	42	Steel
<b>12L110S08-C-A</b>	S08	12	11.5	110	57.0	60	Carbide
<b>12L130S08-C-A</b>	S08	12	11.5	130	77.0	80	Carbide

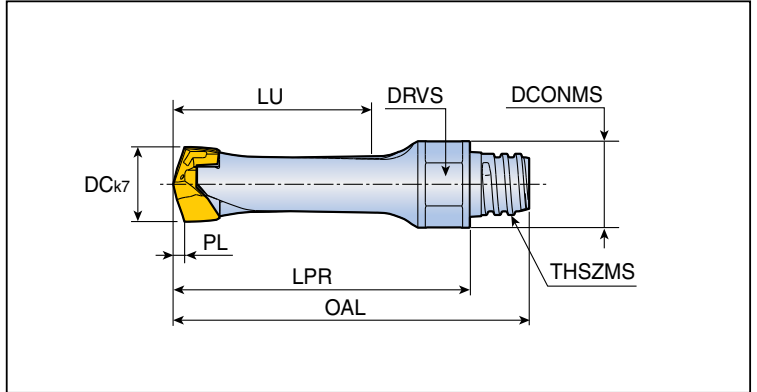
## TCD...-MRS-2D



### MAXI-RUSH type head exchangeable drill holders



- Drilling depth: 2xdiameter



Designation	Dimension (mm)										Clamping key
	DC	DCONMS	LU	LPR	PL	OAL	DRVS	THSZMS	SSC		
<b>TCD 060-064-MRS06-2D</b>	6.0-6.4	9.6	13.0	28.0	1.0	34.3	8	S06	6	K TCD D060-D099	
<b>080-084-MRS06-2D</b>	8.0-8.4	9.6	17.2	32.9	1.2	39.2	8	S06	8		
<b>100-104-MRS08-2D</b>	10.0-10.4	11.6	21.5	39.8	1.5	47.3	10	S08	10	K TCD D100-D199	

- ▶ SSC: Seat size code
- ▶ Matched with MAXI-RUSH holder
- ▶ Wrench for holder clamping should be ordered separately.

## Recommended Cutting Conditions

ISO	Material	Condition	Tensile Strength (N/mm <sup>2</sup> )	Hardness HB	Material No.	Cutting speed Vc(m/min)	Feed (mm/rev) vs. drill diameter		
							Ø6 - Ø7.9	Ø8 - Ø9.9	Ø10 - Ø11.9
P	Non-alloy steel and cast steel, free cutting steel	<0.25%C Annealed	420	125	1	80-140	0.09-0.13	0.12-0.22	0.15-0.28
		>=0.25%C Annealed	650	190	2	80-130	0.09-0.13	0.12-0.22	0.15-0.28
		<0.55%C Quenched and tempered	850	250	3	80-120	0.09-0.13	0.12-0.22	0.15-0.28
		>=0.55%C Annealed	750	220	4	70-110	0.09-0.13	0.12-0.22	0.15-0.28
	Low alloy steel and cast steel (less than 5% of alloying elements)	Quenched and tempered	1000	300	5	50-90	0.09-0.13	0.12-0.22	0.15-0.28
		Annealed	600	200	6	70-120	0.09-0.15	0.12-0.25	0.14-0.28
		Quenched and tempered	930	275	7	70-110	0.09-0.15	0.12-0.25	0.14-0.28
			1000	300	8	50-90	0.09-0.15	0.12-0.25	0.14-0.28
	High alloy steel, cast steel and tool steel	1200	350	9	40-70	0.09-0.15	0.12-0.25	0.14-0.28	
		Annealed	680	200	10	50-90	0.09-0.12	0.12-0.20	0.12-0.22
M	Stainless steel and cast steel	Quenched and tempered	1100	325	11	40-80	0.09-0.12	0.12-0.20	0.12-0.22
		Ferritic / martensitic	680	200	12	40-70	0.08-0.10	0.10-0.15	0.12-0.18
		Martensitic	820	240	13	40-70	0.08-0.10	0.10-0.15	0.12-0.18
K	Grey cast iron (GG)	Austenitic	600	180	14	30-70	0.08-0.10	0.10-0.15	0.12-0.18
		Ferritic / pearlitic		160	15	90-160	0.12-0.18	0.15-0.30	0.20-0.35
	Cast iron nodular (GGG)	Pearlitic		250	16	80-140	0.12-0.18	0.15-0.30	0.20-0.35
		Ferritic		180	17	90-180	0.12-0.18	0.15-0.30	0.20-0.35
	Malleable cast iron	Pearlitic		260	18	80-140	0.12-0.18	0.15-0.30	0.20-0.35
		Ferritic		130	19	90-160	0.12-0.18	0.15-0.30	0.20-0.35
N	Aluminum-wrought alloy	Pearlitic		230	20	80-140	0.12-0.18	0.15-0.30	0.20-0.35
		Not cureable		60	21	90-220	0.15-0.30	0.20-0.35	0.25-0.40
	Aluminum-cast, alloyed	Cured		100	22	90-220	0.15-0.30	0.20-0.35	0.25-0.40
		<=12% Si Not cureable		75	23	90-220	0.15-0.30	0.20-0.35	0.25-0.40
	Copper alloys	>12% Si High temperature		130	25	80-160	0.15-0.30	0.20-0.35	0.25-0.40
		>1% Pb Free cutting		110	26	90-220	0.15-0.30	0.20-0.35	0.25-0.40
		Brass		90	27	90-220	0.15-0.30	0.20-0.35	0.25-0.40
		Electrolitic copper		100	28	90-220	0.15-0.30	0.20-0.35	0.25-0.40
	Non-metallic	Duroplastics, fiber plastics			29				
		Hard rubber			30				
S	High temp. alloys	Annealed		200	31	30-60	0.05-0.07	0.06-0.11	0.08-0.13
		Cured		280	32	20-50	0.05-0.07	0.06-0.11	0.08-0.13
		Ni or Co based Annealed		250	33	20-50	0.05-0.07	0.06-0.11	0.08-0.13
		Cured		350	34	20-50	0.05-0.07	0.06-0.11	0.08-0.13
	Titanium and Ti alloys	Cast		320	35	20-50	0.05-0.07	0.06-0.11	0.08-0.13
			Rm 400		36	20-50	0.05-0.07	0.06-0.12	0.08-0.15
		Alpa+bata alloys cured	Rm 1050		37	20-50	0.05-0.07	0.06-0.12	0.08-0.15
H	Hardened steel			55HRC	38	20-50	0.05-0.07	0.06-0.12	0.08-0.15
		Hardened		60HRC	39	20-50	0.05-0.07	0.06-0.12	0.08-0.15
	Chilled cast iron	Cast		400	40				
	Cast iron nodular (GGG)	Hardened		55HRC	41				

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