

NPN

New Product News



DRILLRUSH

Drill Holders With Equivalent Shank Size As Carbide Drills

3xD



5xD



8xD



KEY POINT

TaeguTec's DRILL-RUSH line introduces A0 type holders with the same shank size as the carbide drills.

The optimal solution for improving productivity and reducing costs with excellent machining performance and longer tool life, the DRILL-RUSH line now includes new A0 shank type holders.

The advantage of the A0 shank type holder, compatible with carbide drills, is the no arbor replacement requirement due to the same shank size. A0 shank type holders are available in a 6.0-9.9 mm diameter range and 3xD, 5xD, and 8xD drilling depths.

For more information, please contact the product manager.

No arbor replacement requirement when replacing carbide drills with DRILL-RUSH option

Carbide drill

DRILLRUSH

Existing cylindrical shank: TCD...S0
Arbor replacement required due to different shank sizes

New cylindrical shank: TCD...A0 **new**
No arbor replacement required due to the same shank size

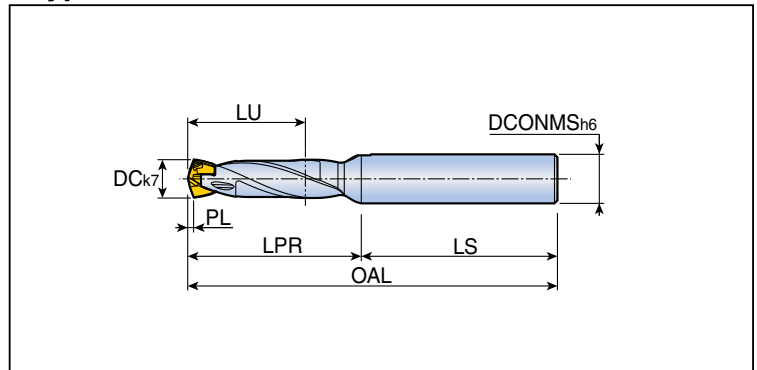
TCD...A0-3D



Head changeable drill holders - Cylindrical type shank



• Drilling depth: 3xdiameter



Designation	Dimension (mm)							Clamping key
	DC	DCONMS	LU	LPR	LS	PL	SSC	
TCD 060-064-08A0-3D	6.0-6.4	8	19	28.0	36	0.96	6	K TCD D060-D099
065-069-08A0-3D	6.5-6.9	8	21	29.8	36	1.18	6.5	
070-074-08A0-3D	7.0-7.4	8	22	31.6	36	1.01	7	
075-079-08A0-3D	7.5-7.9	8	24	33.1	36	1.10	7.5	
080-084-10A0-3D	8.0-8.4	10	25	35.4	40	1.20	8	
085-089-10A0-3D	8.5-8.9	10	27	36.9	40	1.29	8.5	
090-094-10A0-3D	9.0-9.4	10	28	38.8	40	1.35	9	
095-099-10A0-3D	9.5-9.9	10	30	40.3	40	1.44	9.5	

▶ OAL = LPR+LS ▶ SSC : Seat size code

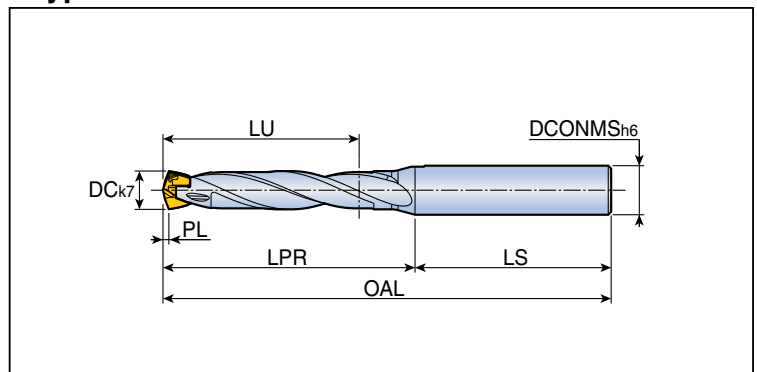
TCD...A0-5D



Head changeable drill holders - Cylindrical type shank



• Drilling depth: 5xdiameter



Designation	Dimension (mm)							Clamping key
	DC	DCONMS	LU	LPR	LS	PL	SSC	
TCD 060-064-08A0-5D	6.0-6.4	8	31	40.0	36	0.96	6	K TCD D060-D099
065-069-08A0-5D	6.5-6.9	8	34	42.8	36	1.18	6.5	
070-074-08A0-5D	7.0-7.4	8	36	45.6	36	1.01	7	
075-079-08A0-5D	7.5-7.9	8	39	48.1	36	1.10	7.5	
080-084-10A0-5D	8.0-8.4	10	41	51.4	40	1.20	8	
085-089-10A0-5D	8.5-8.9	10	44	53.9	40	1.29	8.5	
090-094-10A0-5D	9.0-9.4	10	46	56.8	40	1.35	9	
095-099-10A0-5D	9.5-9.9	10	49	59.3	40	1.44	9.5	

▶ OAL = LPR+LS ▶ SSC : Seat size code

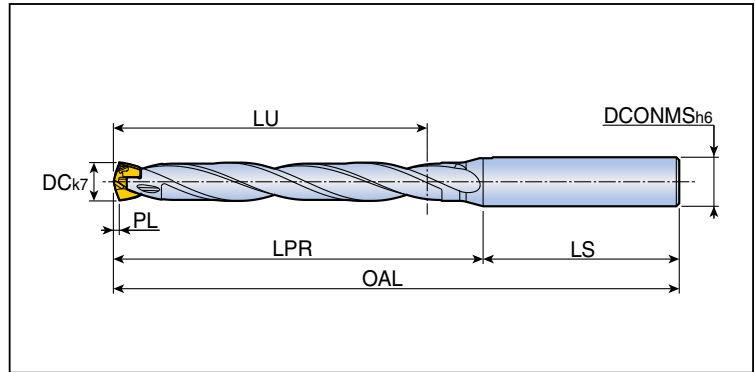
TCD...A0-8D



Head changeable drill holders - Cylindrical type shank



• Drilling depth: 8xdiameter



Designation	Dimension (mm)							Clamping key
	DC	DCONMS	LU	LPR	LS	PL	SSC	
TCD 060-064-08A0-8D	6.0-6.4	8	49	58.0	36	0.96	6	K TCD D060-D099
065-069-08A0-8D	6.5-6.9	8	53	62.3	36	1.18	6.5	
070-074-08A0-8D	7.0-7.4	8	57	66.6	36	1.01	7	
075-079-08A0-8D	7.5-7.9	8	61	70.6	36	1.10	7.5	
080-084-10A0-8D	8.0-8.4	10	65	75.4	40	1.20	8	
085-089-10A0-8D	8.5-8.9	10	69	79.4	40	1.29	8.5	
090-094-10A0-8D	9.0-9.4	10	73	83.8	40	1.35	9	
095-099-10A0-8D	9.5-9.9	10	77	87.8	40	1.44	9.5	

▶ OAL = LPR+LS ▶ SSC : Seat size code

Recommended Cutting Conditions

ISO	Material	Condition	Tensile Strength (N/mm ²)	Hardness HB	Material No.	Cutting speed Vc(m/min)	Feed (mm/rev) vs. drill diameter	
							Ø6 - Ø7.9	Ø8 - Ø9.9
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
		>=0.25%C Annealed	650	190	2	80-130	0.09-0.13	0.12-0.22
		<0.55%C Quenched and tempered	850	250	3	80-120	0.09-0.13	0.12-0.22
		>=0.55%C Annealed	750	220	4	70-110	0.09-0.13	0.12-0.22
		>=0.55%C Quenched and tempered	1000	300	5	50-90	0.09-0.13	0.12-0.22
	Low alloy steel and cast steel (less than 5% of alloying elements)	Annealed	600	200	6	70-120	0.09-0.15	0.12-0.25
		Quenched and tempered	930	275	7	70-110	0.09-0.15	0.12-0.25
			1000	300	8	50-90	0.09-0.15	0.12-0.25
			1200	350	9	40-70	0.09-0.15	0.12-0.25
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	50-90	0.09-0.12	0.12-0.20
Quenched and tempered		1100	325	11	40-80	0.09-0.12	0.12-0.20	
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	40-70	0.08-0.10	0.10-0.15
		Martensitic	820	240	13	40-70	0.08-0.10	0.10-0.15
		Austenitic	600	180	14	30-70	0.08-0.10	0.10-0.15
K	Grey cast iron (GG)	Ferritic / pearlitic		160	15	90-160	0.12-0.18	0.15-0.30
		Pearlitic		250	16	80-140	0.12-0.18	0.15-0.30
	Cast iron nodular (GGG)	Ferritic		180	17	90-180	0.12-0.18	0.15-0.30
		Pearlitic		260	18	80-140	0.12-0.18	0.15-0.30
	Malleable cast iron	Ferritic		130	19	90-160	0.12-0.18	0.15-0.30
		Pearlitic		230	20	80-140	0.12-0.18	0.15-0.30
N	Aluminum-wrought alloy	Not cureable		60	21	90-220	0.15-0.30	0.20-0.35
		Cured		100	22	90-220	0.15-0.30	0.20-0.35
	Aluminum-cast, alloyed	<=12% Si Not cureable		75	23	90-220	0.15-0.30	0.20-0.35
		>12% Si Cured		90	24	90-220	0.15-0.30	0.20-0.35
		>12% Si High temperature		130	25	80-160	0.15-0.30	0.20-0.35
	Copper alloys	>1% Pb Free cutting		110	26	90-220	0.15-0.30	0.20-0.35
		Brass		90	27	90-220	0.15-0.30	0.20-0.35
		Electrolitic copper		100	28	90-220	0.15-0.30	0.20-0.35
Non-metallic	Duroplastics, fiber plastics			29				
	Hard rubber			30				
S	High temp. alloys	Fe based Annealed		200	31	30-60	0.05-0.07	0.06-0.11
		Fe based Cured		280	32	20-50	0.05-0.07	0.06-0.11
		Ni or Co based Annealed		250	33	20-50	0.05-0.07	0.06-0.11
		Ni or Co based Cured		350	34	20-50	0.05-0.07	0.06-0.11
	Titanium and Ti alloys	Cast		320	35	20-50	0.05-0.07	0.06-0.11
		Alpa+bata alloys cured	Rm 400		36	20-50	0.05-0.07	0.06-0.12
H	Hardened steel	Hardened		55HRC	38	20-50	0.05-0.07	0.06-0.12
		Hardened		60HRC	39	20-50	0.05-0.07	0.06-0.12
	Chilled cast iron	Cast		400	40			
	Cast iron nodular (GGG)	Hardened		55HRC	41			

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