

NEW PRODUCT NEWS

DRILL-RUSH

expansion

Small Diameter Expansion in 6.0-6.9mm Range



TaeguTec has extended the application range of the successful DRILLRUSH line by introducing 6.0-6.9mm diameter range drill heads for 1.5xD, 3xD and 5xD drilling depth holders.

This innovative exchangeable drill's performance exceeds small carbide drills available in the market today for small diameter machining.

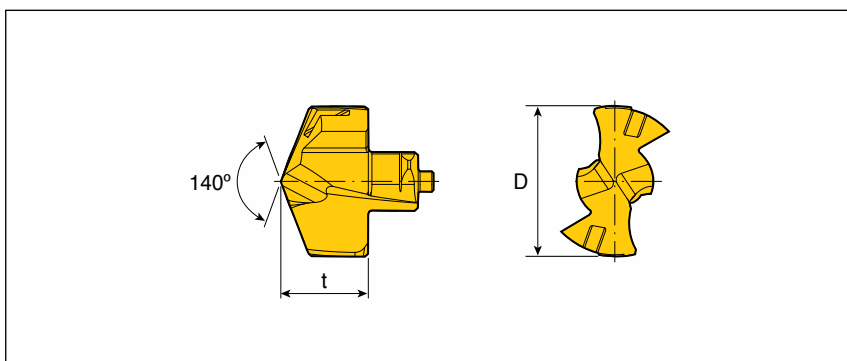
FEATURES

- **Extended diameter range**
: 6.0-6.9mm
- **Drilling depth**
: 1.5xD, 3xD, 5xD
- **Excellent performance and high productivity in small diameters**
- **Rigid clamping system for stable drilling**
- **Available ISO M8 standard pre-thread hole**



TCD...P/M/K

Drill head



Designation	Dimension (mm)			Grade
	D	t	Pocket size	TT9080
TCD - 060-P/M/K	6.0	4.0	6	●
061-P/M/K	6.1	4.0	6	●
062-P/M/K	6.2	4.0	6	●
063-P/M/K	6.3	4.0	6	●
0635-P/M/K	6.35	4.0	6	●
064-P/M/K	6.4	4.0	6	●
065-P/M/K	6.5	4.3	6.5	●
066-P/M/K	6.6	4.3	6.5	●
067-P/M/K	6.7	4.3	6.5	●
068-P/M/K	6.8	4.3	6.5	●
069-P/M/K	6.9	4.3	6.5	●

●: Standard items

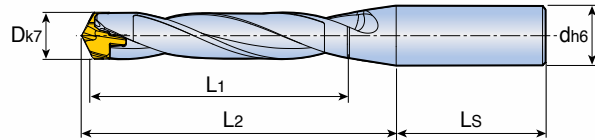
P Steel

M Stainless Steel

K Cast Iron

TCD...S0-1.5D/3D/5D

Head changeable drill holder - Cylindrical type shank

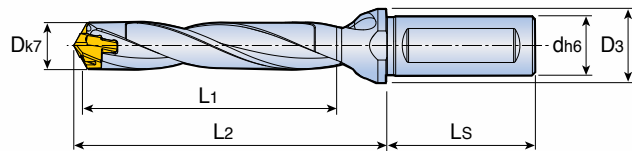


- Drilling depth: 1.5/3/5 x Diameter

Designation	Dimension (mm)						Clamping key
	D range	d	L1	L2	Ls	Pocket size	
TCD 060-064-12S0-1.5D	6.0-6.4	12	9	23.0	45	6.0	K TCD D060-D099
065-069-12S0-1.5D	6.5-6.9	12	10	24.1	45	6.5	
TCD 060-064-12S0-3D	6.0-6.4	12	18	32.0	45	6.0	K TCD D060-D099
065-069-12S0-3D	6.5-6.9	12	20	33.8	45	6.5	
TCD 060-064-12S0-5D	6.0-6.4	12	30	44.0	45	6.0	K TCD D060-D099
065-069-12S0-5D	6.5-6.9	12	33	46.8	45	6.5	

TCD...T3-1.5D/3D/5D

Head changeable drill holder - Weldon type shank

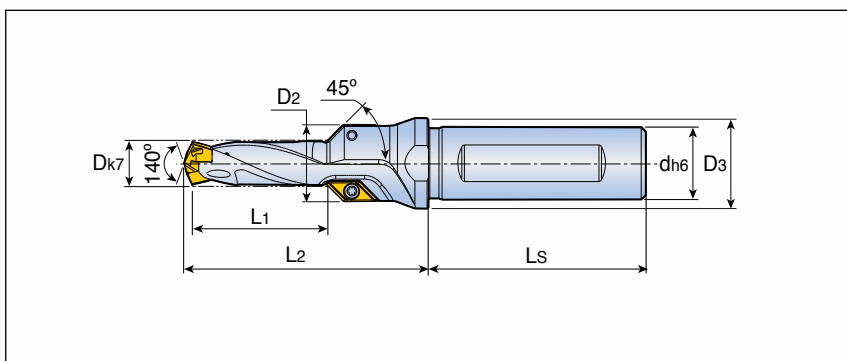


- Drilling depth: 1.5/3/5 x Diameter

Designation	Dimension (mm)							Clamping key
	D range	d	D3	L1	L2	Ls	Pocket size	
TCD 060-064-12T3-1.5D	6.0-6.4	12	16	9	23.0	45	6.0	K TCD D060-D099
065-069-12T3-1.5D	6.5-6.9	12	16	10	24.1	45	6.5	
TCD 060-064-12T3-3D	6.0-6.4	12	16	18	32.0	45	6.0	K TCD D060-D099
065-069-12T3-3D	6.5-6.9	12	16	20	33.8	45	6.5	
TCD 060-064-12T3-5D	6.0-6.4	12	16	30	44.0	45	6.0	K TCD D060-D099
065-069-12T3-5D	6.5-6.9	12	16	33	46.8	45	6.5	




TCD...-M8

Head changeable drill holder for pre-thread hole



Designation	ISO Thread	Drill Dia.(D)	Dimension (mm)						Drill dia. range	Insert
			L1	L2	Ls	D2	d	D3		
TCD 068X21X12T3-M8	M8	6.8	21	45	45	13.5	12	16	6.5-6.9	AOMT 060204-C45

Spare parts

Designation	Screw	Wrench	Clamping key		
TCD 068	TS 22046I 	TD 7 	K TCD D060-D099 		

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	
							Ø6.0-Ø7.9	
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	80-140	0.09-0.13
		>=0.25%C	Annealed	650	190	2	80-130	0.09-0.13
		<0.55%C	Quenched and tempered	850	250	3	80-120	0.09-0.13
		>=0.55%C	Annealed	750	220	4	70-110	0.09-0.13
		>=0.55%C	Quenched and tempered	1000	300	5	50-90	0.09-0.13
	Low alloy steel and cast steel (less than 5% of alloying elements)	Quenched and tempered	Annealed	600	200	6	70-120	0.09-0.15
			930	275	7	70-110	0.09-0.15	
			1000	300	8	50-90	0.09-0.15	
			1200	350	9	40-70	0.09-0.15	
	High alloy steel, cast steel and tool steel.	Annealed	680	200	10	50-90	0.09-0.12	
		Quenched and tempered	1100	325	11	40-80	0.09-0.12	
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	40-70	0.08-0.10	
		Martensitic	820	240	13	40-70	0.08-0.10	
		Austenitic	600	180	14	30-70	0.08-0.10	
K	Gray cast iron (GG)	Ferritic		160	15	90-160	0.12-0.18	
		Pearlitic		250	16	80-140	0.12-0.18	
	Cast iron nodular (GGG)	Ferritic		180	17	90-180	0.12-0.18	
		Pearlitic		260	18	80-140	0.12-0.18	
	Malleable cast iron	Ferritic		130	19	90-160	0.12-0.18	
Pearlitic			230	20	80-140	0.12-0.18		
S	High temp. alloys	Fe based	Annealed		200	31	30-60	0.05-0.07
			Cured		280	32	20-50	0.05-0.07
		Ni or Co based	Annealed		250	33	20-50	0.05-0.07
			Cured		350	34	20-50	0.05-0.07
			Cast		320	35	20-50	0.05-0.07
	Titanium, Ti alloys		RM400		36	20-50	0.05-0.07	
		Alpha+beta alloys cured	RM1050		37	20-50	0.05-0.07	
H	Hardened steel	Hardened		55HRC	38	20-50	0.05-0.07	
		Hardened		60HRC	39	20-50	0.05-0.07	
	Chilled cast iron	Cast		400	40			
Cast iron nodular	Hardened		55HRC	41				

■ Steel
 ■ Stainless Steel
 ■ Cast Iron
 ■ High Temp. Alloys
 ■ Hardened Steel