March 2021
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NPA

New Product Announcement No. 2021-06

new

HDRILL

High Productivity and Tool Life Solid Carbide NHD-K Drills for Cast Iron Machining

ADVANCE MACHINING
TaeguTec Industry 4.0

INDUSTRY 4.0 TaeguTec
Member IMC Group

KEY POINT

TaeguTec expands its holemaking range with new NHD-K solid carbide drills dedicated for cast iron machining.

TaeguTec continues to diversify its holemaking drill range for workpiece materials with the introduction of solid carbide drills dedicated for cast iron machining. The newly released NHD-K type drills are designed to minimize chipping or damage to the cutting edge that may occur when machining cast iron.

The NHD-K type drills are optimized for cast iron machining because of its unique multi-angle cutting edge geometry for maximized edge strength and a cutting edge that evenly distributes the machining load across the cutting edge. The solid carbide drills minimize burrs to produce an excellent surface finish during operation.

Please contact the product manager for more information.

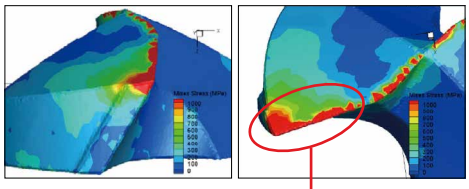
Features

■ Dedicated geometry for cast iron machining

Multi-angle cutting edges

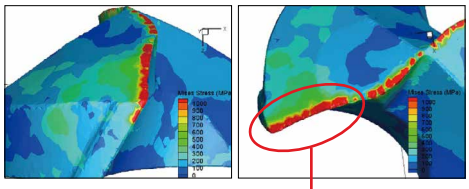
■ Uniform cutting load

General solid drill



Concentrated cutting force on the end of the cutting edge

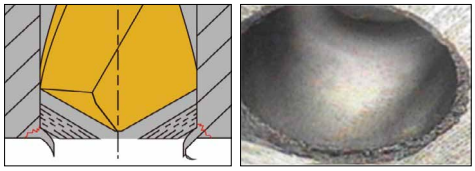
NHD-K solid drill



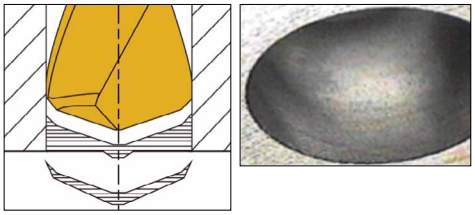
Uniform cutting force across the cutting edge

■ Minimized burrs

General solid drill



NHD-K solid drill



Availability
In stock

Price
Available in the GAL system

Sincerely,
TaeguTec

Sung-chang-ho
Hole-Making General PM

Sincerely,
TaeguTec

Suh-jang-hoon
Hole-Making Drill PM

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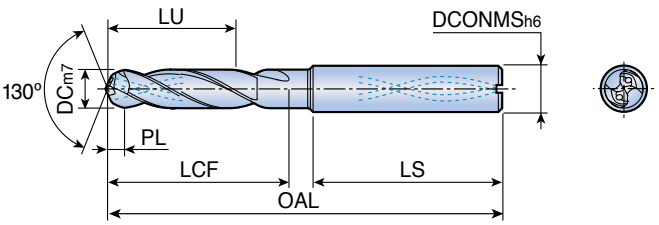
NHD…KI3

HDRILL

Solid carbide drills with oil holes for cast iron machining

• Drilling depth: 3xdiameter



Designation		Dimension (mm)							Grade
		DC	DCONMS	OAL	LU	LCF	LS	PL	TT9030
NHD	030-014-06 KI3	3.0	6.0	62	14	20	34	1.4	●
	033-014-06 KI3	3.3	6.0	62	14	20	34	1.6	●
	035-014-06 KI3	3.5	6.0	62	14	20	34	1.7	●
	040-017-06 KI3	4.0	6.0	66	17	24	35	1.9	●
	041-017-06 KI3	4.1	6.0	66	17	24	35	2.0	●
	042-017-06 KI3	4.2	6.0	66	17	24	35	2.0	●
	045-017-06 KI3	4.5	6.0	66	17	24	35	2.2	●
	046-017-06 KI3	4.6	6.0	66	17	24	35	2.2	●
	050-020-06 KI3	5.0	6.0	66	20	27	36	2.4	●
	051-020-06 KI3	5.1	6.0	66	20	27	36	2.5	●
	052-020-06 KI3	5.2	6.0	66	20	27	36	2.5	●
	055-020-06 KI3	5.5	6.0	66	20	27	36	2.6	●
	060-020-06 KI3	6.0	6.0	66	20	27	36	2.9	●
	061-024-08 KI3	6.1	8.0	79	24	34	36	2.9	●
	065-024-08 KI3	6.5	8.0	79	24	34	36	3.1	●
	067-024-08 KI3	6.7	8.0	79	24	34	36	3.2	●
	068-024-08 KI3	6.8	8.0	79	24	34	36	3.3	●
	070-024-08 KI3	7.0	8.0	79	24	34	36	3.4	●
	075-029-08 KI3	7.5	8.0	79	29	40	36	3.6	●
	080-029-08 KI3	8.0	8.0	79	29	40	36	3.8	●
	081-035-10 KI3	8.1	10.0	89	35	45	40	3.9	●
	085-035-10 KI3	8.5	10.0	89	35	45	40	4.1	●
	087-035-10 KI3	8.7	10.0	89	35	45	40	4.2	●
	089-035-10 KI3	8.9	10.0	89	35	45	40	4.3	●
	090-035-10 KI3	9.0	10.0	89	35	45	40	4.3	●
	095-035-10 KI3	9.5	10.0	89	35	45	40	4.6	●
	100-035-10 KI3	10.0	10.0	89	35	45	40	4.8	●
	103-040-12 KI3	10.3	12.0	102	40	53	45	4.9	●
	105-040-12 KI3	10.5	12.0	102	40	53	45	5.0	●
	110-040-12 KI3	11.0	12.0	102	40	53	45	5.3	●
	115-040-12 KI3	11.5	12.0	102	40	53	45	5.5	●
	120-040-12 KI3	12.0	12.0	102	40	53	45	5.8	●

●: Standard items

NHD…KI5

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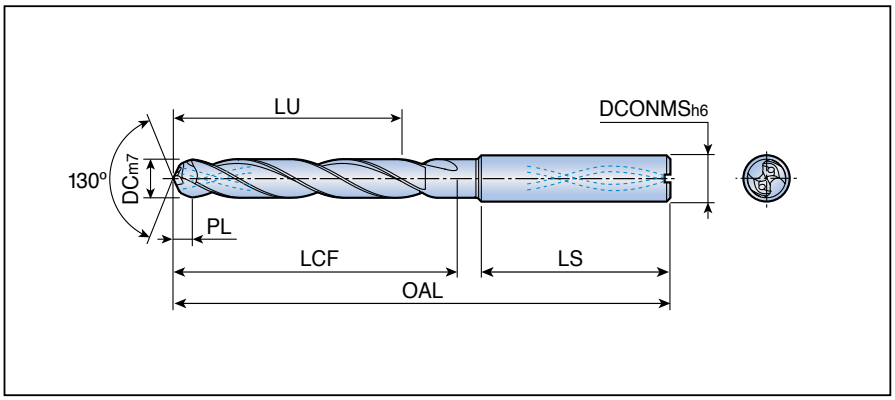
Solid carbide drills with oil holes for cast iron machining

• Drilling depth: 5xdiameter



Designation		Dimension (mm)							Grade
		DC	DCONMS	OAL	LU	LCF	LS	PL	TT9030
NHD	030-023-06 KI5	3.0	6.0	66	23	27	34	1.4	●
	033-023-06 KI5	3.3	6.0	66	23	27	34	1.6	●
	035-023-06 KI5	3.5	6.0	66	23	27	34	1.7	●
	040-029-06 KI5	4.0	6.0	74	29	34	35	1.9	●
	042-029-06 KI5	4.2	6.0	74	29	34	35	2.0	●
	045-029-06 KI5	4.5	6.0	74	29	35	35	2.2	●
	046-029-06 KI5	4.6	6.0	74	29	35	35	2.2	●
	050-035-06 KI5	5.0	6.0	82	35	43	36	2.4	●
	052-035-06 KI5	5.2	6.0	82	35	43	36	2.5	●
	055-035-06 KI5	5.5	6.0	82	35	43	36	2.6	●
	060-035-06 KI5	6.0	6.0	82	35	43	36	2.9	●
	065-043-08 KI5	6.5	8.0	91	43	52	36	3.1	●
	067-043-08 KI5	6.7	8.0	91	43	52	36	3.2	●
	068-043-08 KI5	6.8	8.0	91	43	52	36	3.3	●
	070-043-08 KI5	7.0	8.0	91	43	52	36	3.4	●
	075-043-08 KI5	7.5	8.0	91	43	52	36	3.6	●
	080-043-08 KI5	8.0	8.0	91	43	52	36	3.8	●
	081-049-10 KI5	8.1	10.0	103	49	59	40	3.9	●
	085-049-10 KI5	8.5	10.0	103	49	59	40	4.1	●
	087-049-10 KI5	8.7	10.0	103	49	59	40	4.2	●
	089-049-10 KI5	8.9	10.0	103	49	59	40	4.3	●
	090-049-10 KI5	9.0	10.0	103	49	59	40	4.3	●
	095-049-10 KI5	9.5	10.0	103	49	59	40	4.6	●
	100-049-10 KI5	10.0	10.0	103	49	59	40	4.8	●
	103-056-12 KI5	10.3	12.0	118	56	69	45	4.9	●
	105-056-12 KI5	10.5	12.0	118	56	69	45	5.0	●
	110-056-12 KI5	11.0	12.0	118	56	69	45	5.3	●
	115-056-12 KI5	11.5	12.0	118	56	69	45	5.5	●
	120-056-12 KI5	12.0	12.0	118	56	69	45	5.8	●

●: Standard items

Recommended Cutting Conditions

HDRILL

Machining data for H-DRILL (NHD-K)

ISO	Material	Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)	Feed (mm/rev) vs. drill diameter		
							Ø3 - Ø5	Ø5.1 - Ø8	Ø8.1 - Ø12
K	Gray cast iron (GG)	Ferritic		160	15	100 -120	0.10-0.20	0.20-0.30	0.25-0.35
		Pearlitic		250	16	100 -120	0.10-0.20	0.20-0.30	0.25-0.35
	Cast iron nodular (GGG)	Ferritic		180	17	120-140	0.10-0.20	0.15-0.25	0.20-0.30
		Pearlitic		260	18	80-100	0.10-0.20	0.15-0.25	0.20-0.30
	Malleable cast iron	Ferritic		130	19	70-90	0.10-0.20	0.15-0.25	0.20-0.30
		Pearlitic		230	20	65-80	0.10-0.20	0.15-0.25	0.20-0.30

Cast iron