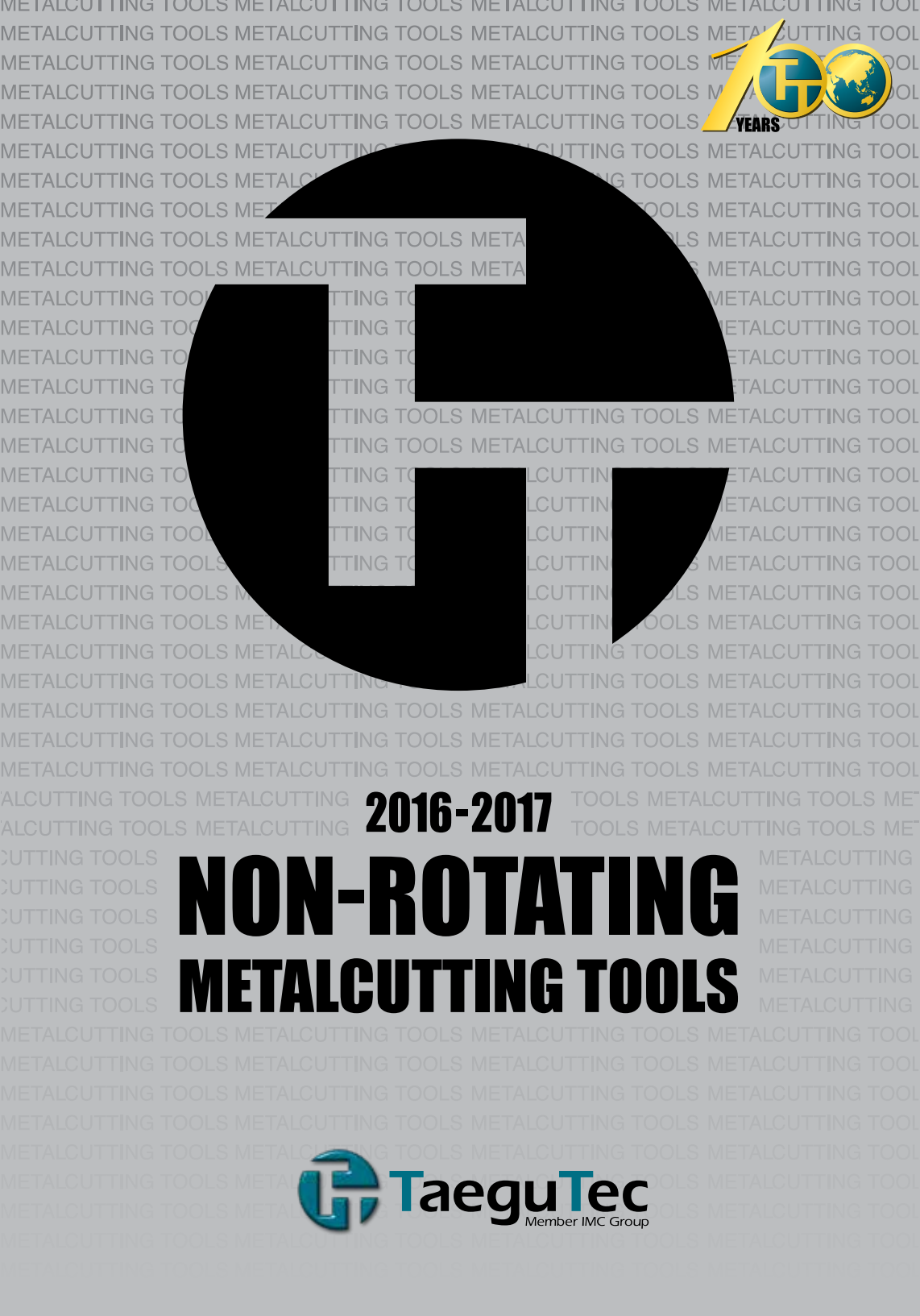


2016-2017

NON-ROTATING METALCUTTING TOOLS

TaeguTec
Member IMC Group

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A Turning

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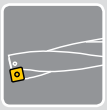
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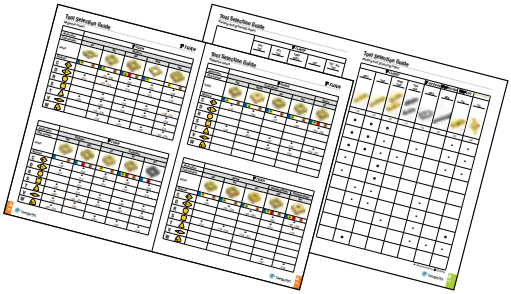
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Select an application line from the main Table of Contents. Each line is color coded in alphabetical order.



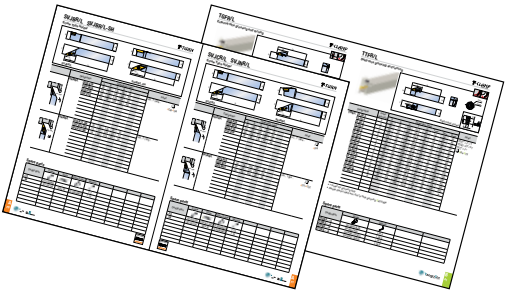
Tool Selection Guide »

Choose the required machining solutions and tools from tool selection guide.



Products Page »

Obtain detailed information of products such as dimensions, grades and related parts etc. Holder and insert pages are organized separately.



Alphabetical Index »

All tools are listed in the alphabetical index at the end of the catalogue.

Should you require more information and data from TaeguTec, please contact the nearest TaeguTec Global Service Center or visit our website. www.taegutec.com

TURNING



TURNING

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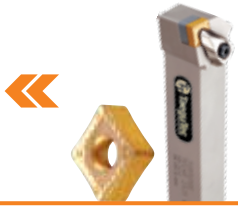
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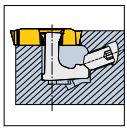
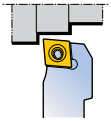
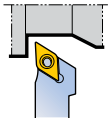
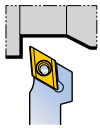
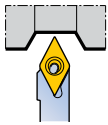
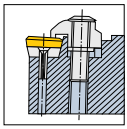
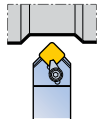
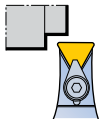
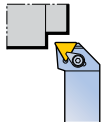
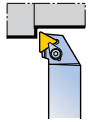
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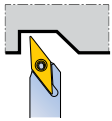
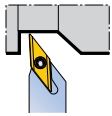
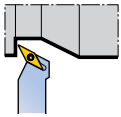
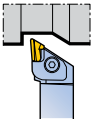
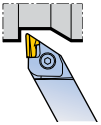
External holder

Holder type	T-TURN				
	80°	55°		90°	60°
B **B-Holder** 	 BCLCR/L-SH A47	 BDJCR/L-SH A48  BDLPR/L-SH A48  BDNCN-SH A49			
C **Top clamp** 				 CSDPN A54	 CTCPN A55  CTFPR/L A55  CTGPR/L A56

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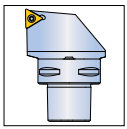
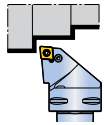
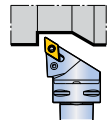
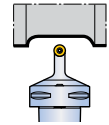
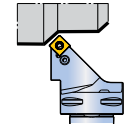
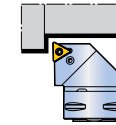
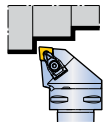
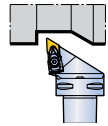
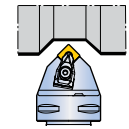
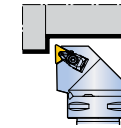
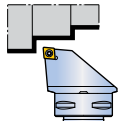
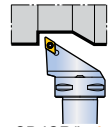
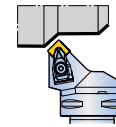
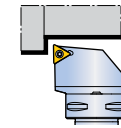
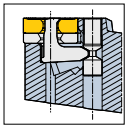
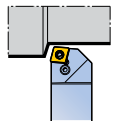
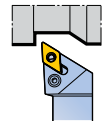
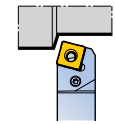
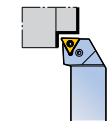
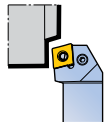
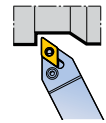
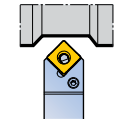
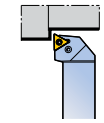
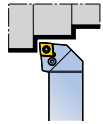
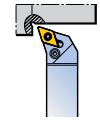
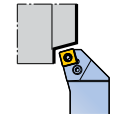
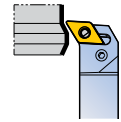
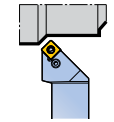
Tool Selection Guide

External holder

T-TURN					
35°	80°	25°	55°	120°	75°
 BVJBR/L-SH A50 BVJCR/L-SH A50  BVJPR/L-SH A51 BVLPR/L-SH A51  BVPPR/L-SH A52					
			 CKJNR/L A53  CKNNR/L A53		

Tool Selection Guide

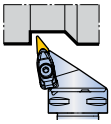
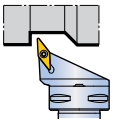
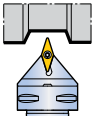
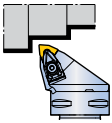
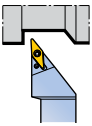
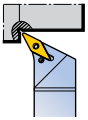
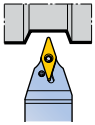
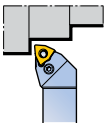
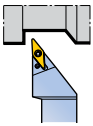
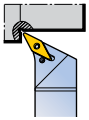
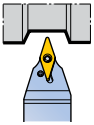
External holder

Holder type	T-TURN				
	80°	55°		90°	60°
C **C-Adapter** 	 C...HCLNR/L A146	 C...HDJNR/L A146	 C...SRDCN A153	 C...HSSNR/L A147	 C...HTGNR/L A147 C...HTJNR/L A147
	 C...TCLNR/L A148	 C...TDJNR/L A148		 C...TSDNN A149	 C...TTGNR/L A150 C...TTJNR/L A150
	 C...SCLCR/L A152	 C...SDJCR/L A152		 C...TSSNR/L A149	 C...STGCR/L A153 C...STJCR/L A153
H **Hook lever holder** 	 HCBNR/L-RS A57 HCBNR/L A57	 HDJNR/L A60		 HSBNR/L A62 A129	 HTFNR/L A64
	 HCKNR/L A58	 HDNNR/L A60		 HSDNN A62 A129	 HTGNR/L A64
	 HCLNR/L-RS A59 HCLNR/L A59	 HDQNR/L A61		 HSKNR/L A63	
		 HDUNR/L A61		 HSSNR/L A63	

Tool Selection Guide

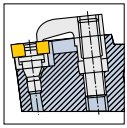
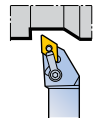
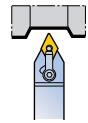
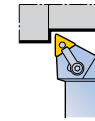
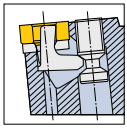
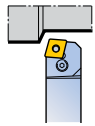
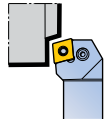
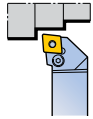
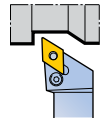
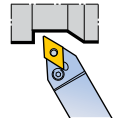
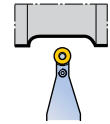
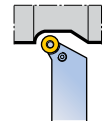
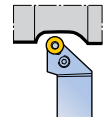
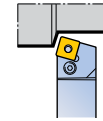
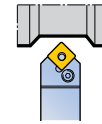
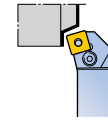
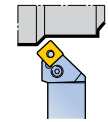
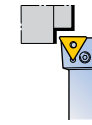
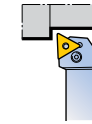
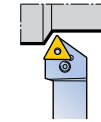
External holder

T-TURN

35°	80°	25°	55°	120°	75°
 C...TVJNR/L A150  C...SVJBR/L A154  C...SVVBN A154	 C...TWLNR/L A151				
 HVJNR/L A65  HVQNR/L A65  HVVNN A66	 HWLNR/L A67	 HVJNR/L A65  HVQNR/L A65  HVVNN A66			

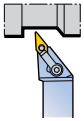
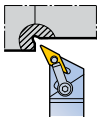
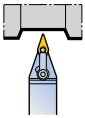
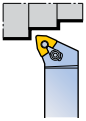
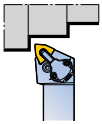
Tool Selection Guide

External holder

Holder type	T-TURN				
	80°	55°		90°	60°
M Multi lock 		 MDJNR/L A68  MDNNN A68  MDQNR/L A69			 MTJNR/L A70
P Lever lock 	 PCBNR/L A74  PCKNR/L A75  PCLNR/L A75 PCLNR/L-TB A133	 PDJNR/L A76 PDJNR/L-TB A134  PDNNR/L A76	 PRDCN A77  PRGCR/L A78  PRGNR/L A79	 PSBNR/L A80  PSDNN A80  PSKNR/L A81  PSSNR/L A81	 PTFNR/L A82  PTGNR/L A83  PTTNR/L A83

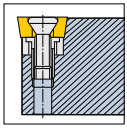
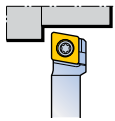
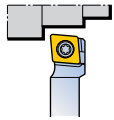
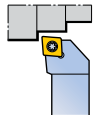
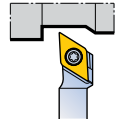
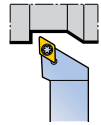
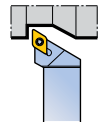
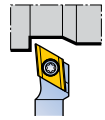
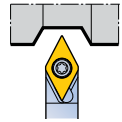
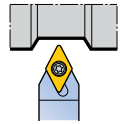
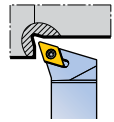
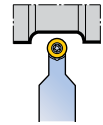
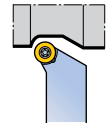
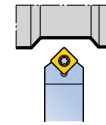
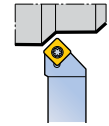
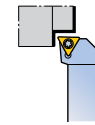
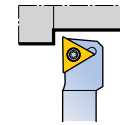
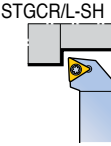
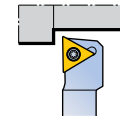
Tool Selection Guide

External holder

T-TURN					
35°	80°	25°	55°	120°	75°
 MVJNR/L A71  MVQNR/L A71  MVVNN A72	 MWLNR/L A73				
	 PWLNR/L-TB A137				

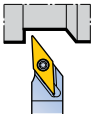
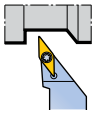
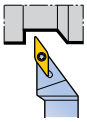
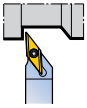
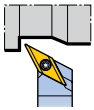
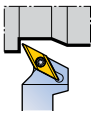
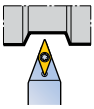
Tool Selection Guide

External holder

Holder type	T-TURN				
	80°	55°		90°	60°
S Screw clamp 	 SCACR/L-SH A84 SCACR/L-SH-TB A138  SCLCR/L-SH A85 SCLCR/L-SH-TB A138  SCLCR/L A85	 SDJCR/L-SH A86 SDJCR/L-SH-TB A139  SDJCR/L A86  SDJNR/L A87  SDLPR/L-SH A87  SDNCN-SH A88 SDNCN-SH-TB A139  SDNCN A88  SDQNR/L A89	 SRDCN A90  SRGCR/L A90 SRGCR/L-TB A135	 SSDCN A91  SSSCR/L A91	 STFCR/L A92  STGCR/L-SH A93  STGCR/L A93 STGCR/L-SH-TB A140  STGPR/L-SH A94

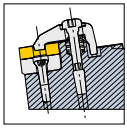
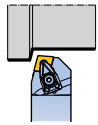
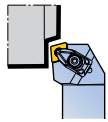
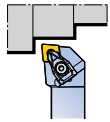
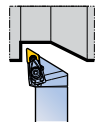
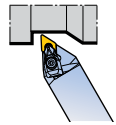
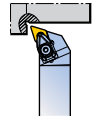
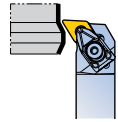
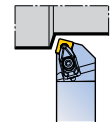
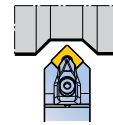
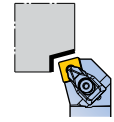
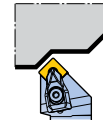
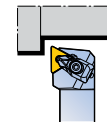
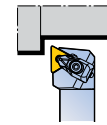
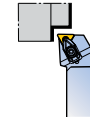
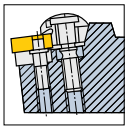
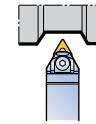
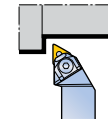
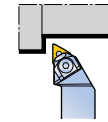
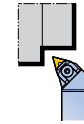
Tool Selection Guide

External holder

T-TURN					
35°	80°	25°	55°	120°	75°
 SVJBR/L-SH A95 SVJBR/L-SH-TB A140  SVJBR/L A95 SVJBR/L-TB A136  SVJCR/L A96 SVJCR/L-SH-TB A141 SVJNR/L A96  SVJPR/L-SH A97 SVLPR/L-SH A97  SVPBR/L A98 SVPPR/L A99  SVPPR/L-SH A99  SVVBN A100 SVVBN-SH A100 SVVBN-SH-TB A141 SVVCN A101					

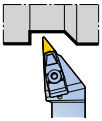
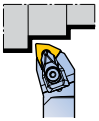
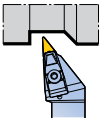
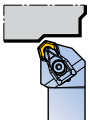
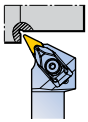
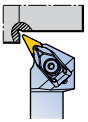
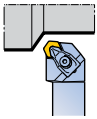
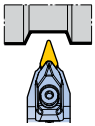
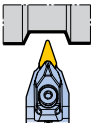
Tool Selection Guide

External holder

Holder type	T-TURN				
	80°	55°		90°	60°
T **T-Holder** 	 TCBNR/L A102  TCKNR/L A102  TCLNR/L A103	 TDJNR/L A104  TDNNR/L A104  TDQNR/L A105  TDUNR/L A105		 TSBNR/L A107  TSDNN A107  TSKNR/L A108  TSSNR/L A108	 TTGNR/L A109  TTJNR/L A109  TTFNR/L A109
W **Wedge clamp** 					 WTENN A113  WTGNR/L A113  WTJNR/L A114  WTQNR/L A114

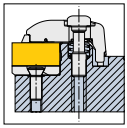
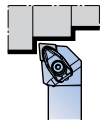
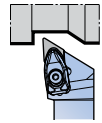
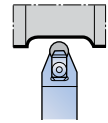
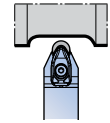
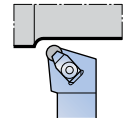
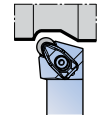
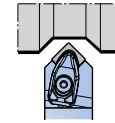
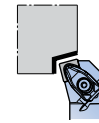
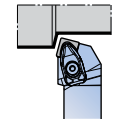
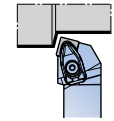
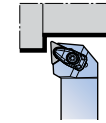
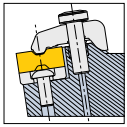
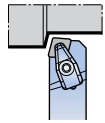
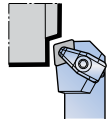
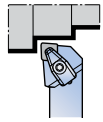
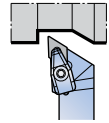
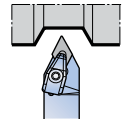
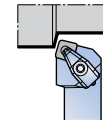
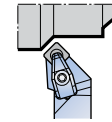
Tool Selection Guide

External holder

T-TURN					
35°	80°	25°	55°	120°	75°
 TVJNR/L A110	 TWLNR/L A112	 TVJNR/L A110		 THSNR/L A106	
 TVQNR/L A110		 TVQNR/L A110		 THXNR/L A106	
 TVVNN A111		 TVVNN A111			

Tool Selection Guide

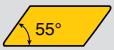
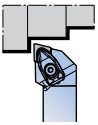
External holder

Holder type	T-TURN				
	80°	55°		90°	60°
T-F **Ceramic T-Holder** 	 TCLNR/L-F A115	 TDJNR/L-F A116	 CRDCN-120 A122 CRDCN-140 A122  TRDNN-F A118  CRGCR/L-120 A123 CRGCR/L-140 A123  TRGNR/L-F A118	 TSDNN-F A119  TSKNR/L-F A119  TSRNR/L-F A120  TSSNR/L-F A120	 TTJNR/L-F A121
T-CH **Ceramic dimple holder** 	 TCBNR/L-CH A124  TCKNR/L-CH A124  TCLNR/L-CH A125	 TDJNR/L-CH A126  TDNNN-CH A126		 TSRNR/L-CH A127  TSSNR/L-CH A127	

TaeguTec
Member IMC Group

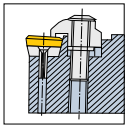
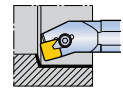
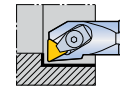
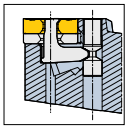
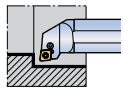
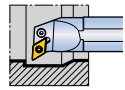
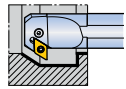
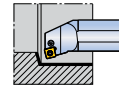
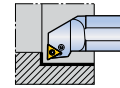
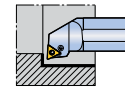
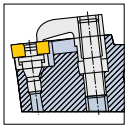
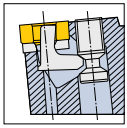
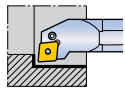
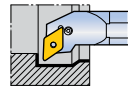
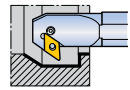
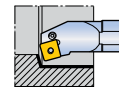
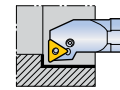
Tool Selection Guide

External holder

T-TURN					
					
					 TEGNR/L-F A117

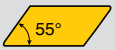
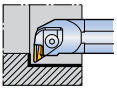
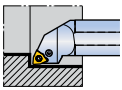
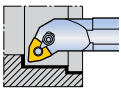
Tool Selection Guide

Internal holder

Holder type	T-TURN				
	80°	55°		90°	60°
C Top clamp 				 S-CSKPR/L A165	 S-CTFCR/L A166 S-CTFPR/L A166
H Hook lever holder 	 S-HCLNR/L A167 A-HCLNR/L A167	 S-HDQNR/L A168 S-HDUNR/L A169 A-HDUNR/L A169  S-HDZNR/L A170 A-HDZNR/L A170		 S-HSKNR/L A171 A-HSKNR/L A171	 S-HTFNR/L A172 A-HTFNR/L A172  S-HTUNR/L A173 A-HTUNR/L A173
M Multi lock 					
P Lever lock 	 S-PCLNR/L A176	 S-PDUNR/L A177  S-PDZNR/L A177		 S-PSKNR/L A178	 S-PTFNR/L A179

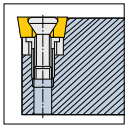
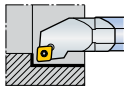
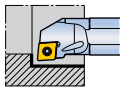
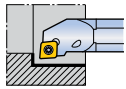
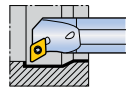
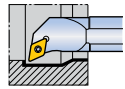
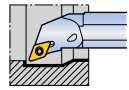
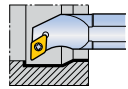
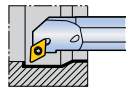
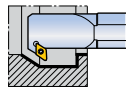
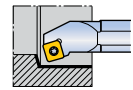
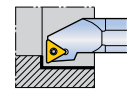
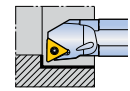
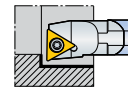
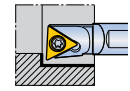
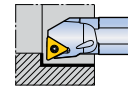
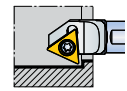
Tool Selection Guide

Internal holder

T-TURN					
					
			 S-CKUNR/L A164		
	 S-HWLNR/L A174 A-HWLNR/L A174				
	 S-MWLNR/L A175				

Tool Selection Guide

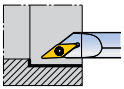
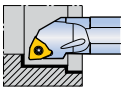
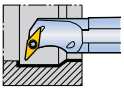
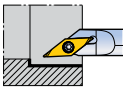
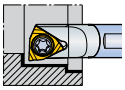
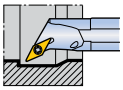
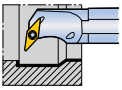
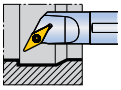
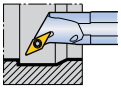
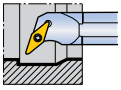
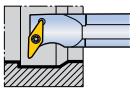
Internal holder

Holder type	T-TURN				
	80°	55°		90°	60°
S Screw clamp 	 S-SCLCR/L A180 C-SCLCR/L A181  S-SCLNR/L A182 A-SCLNR/L A182  S-SCLPR/L A183 A-SCLPR/L A183 E-SCLPR/L A184	 A-SDLNR/L A184  S-SDQCR/L A185  A-SDQNR/L A185  S-SDUCR/L A186  A-SDUNR/L A186  S-SDZCR/L A187		 S-SSKCR/L A188	 S-STFCR/L A189 C-STFCR/L A189  S-STFNR/L A190 A-STFNR/L A190  S-STFPR/L A191 A-STFPR/L A191 C-STFPR/L A192 E-STFPR/L A192  S-STUBR/L A193 C-STUBR/L A193  S-STUNR/L A194 A-STUNR/L A194  C-STZBR/L A195

Tool Selection Guide

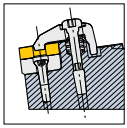
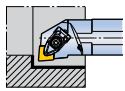
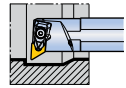
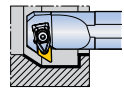
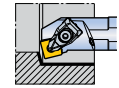
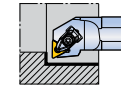
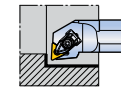
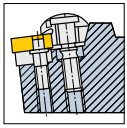
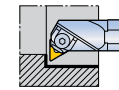
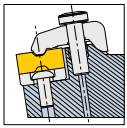
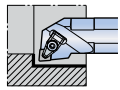
Internal holder

T-TURN

35°	80°	25°	55°	120°	75°
 S-SVJBR/L A196 S-SVJCR/L A196	 S-SWLNR/L A202 A-SWLNR/L A202	 A-SVLNR/L A197			
 S-SVJPR/L A197	 S-SWUBR/L A203 C-SWUBR/L A203	 A-SVPNR/L A199			
 A-SVLNR/L A197					
 S-SVPBR/L A198 S-SVPCR/L A198					
 A-SVPNR/L A199					
 S-SVQBR/L A200 S-SVQCR/L A200					
 S-SVUBR/L A201 S-SVUCR/L A201					

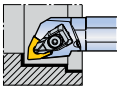
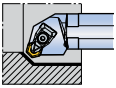
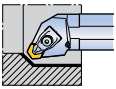
Tool Selection Guide

Internal holder

Holder type	T-TURN				
	80°	55°		90°	60°
T **T-Holder** 	 S-TCLNR/L A204 A-TCLNR/L A204	 S-TDUNR/L A205 A-TDUNR/L A205  S-TDZNR/L A206 A-TDZNR/L A206		 S-TSKNR/L A208 A-TSKNR/L A208	 S-TTFNR/L A209 A-TTFNR/L A209  S-TTUNR/L A210 A-TTUNR/L A210
W **Wedge clamp** 					 S-WTFNR/L A212
T-CH **Ceramic dimple holder** 	 S-TCLNR/L-CH A213				

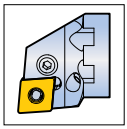
Tool Selection Guide

Internal holder

T-TURN					
35°	80°	25°	55°	120°	75°
	 S-TWLNR/L A211 A-TWLNR/L A211			 A-THSNR/L A207  A-THXNR/L A207	

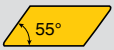
Tool Selection Guide

Internal holder

Holder type	T-TURN				
	80°	55°		90°	60°
HE **Modular bar** 	 HE-PCLNR/L A216  HE-SCLCR/L A218	 HE-PDUNR/L A216  HE-SDQCR/L A218  HE-SDUCR/L A219			 HE-PTFNR/L A217

Tool Selection Guide

Internal holder

T-TURN					
					
 HE-SVUBR/L A219					

Tool Selection Guide

Negative insert

	T-TURN				
Application	Super finishing			Finishing	
Chip breaker	**FA**	**EA**	**FS**	**FG**	**SF**
Insert					
Material	P S	M S	P	P S	P S
C 80°	• A247	• A246	• A248	• A248	• A250
D 55°	• A254	• A253 A254	• A255	• A254 A255	
R					
S 90°		• A263		• A264	
T 60°		• A269	• A270	• A270	• A273
V 35°	• A274	• A274	• A276	• A275 A276	
W 80°		• A277	• A280	• A277 A279	
Y 25°			• A281		

	T-TURN				
Application	Finishing			Medium	
Chip breaker	**FX**	**FC**	**FM**	**MC**	**FT**
Insert					
Material	P M S	P M	P	P	P
C 80°		• A247	• A248	• A248	• A248
D 55°		• A254	• A255	• A255	• A255
R					
S 90°		• A264	• A264	• A265	
T 60°		• A270	• A270	• A271	• A270
V 35°	• A275	• A274	• A276		
W 80°		• A277	• A279	• A278	
Y 25°					

Tool Selection Guide

Negative insert

	T-TURN				
Application	Medium				
Chip breaker	**PC**	**VF**	**ML**	**MP**	**EM**
Insert					
Material	P M	P M S	P M S	P M S	M S
C 80°	• A250		• A244 A249	• A249	• A247
D 55°	• A257	• A257	• A253 A256	• A256	• A254
R					
S 90°	• A266		• A265	• A265	• A263 A264
T 60°	• A272	• A273	• A271	• A271	• A269
V 35°	• A275 A276		• A274 A275		• A274
W 80°	• A278 A280		• A278	• A278	• A277 A279
Y 25°					

	T-TURN				
Application	Medium				Roughing
Chip breaker	**MK**	**MM**	**MT**	**MG-**	**ET**
Insert					
Material	M S	P M	P M S	P K S	M S
C 80°	• A249	• A249	• A249	• A246	• A247
D 55°	• A256	• A256	• A256 A257	• A253	• A254
R				• A260	
S 90°	• A265	• A265	• A265	• A263	• A264
T 60°	• A271	• A271	• A272	• A268 A269	• A270
V 35°	• A276		• A275 A276	• A274	
W 80°	• A280	• A280	• A278 A280		• A277
Y 25°					

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Tool Selection Guide

Negative insert

	T-TURN				
Application	Roughing		Semi-Heavy		
Chip breaker	**RT**	**KT**	**HB**	**RH(N)**	**RX**
Insert					
Material	P M K S	K	P M S	P	P
C 80°	• A250	• A248	• A252	• A252	• A252
D 55°	• A257	• A255			
R					
S 90°	• A266	• A264	• A267	• A267	• A267
T 60°	• A272	• A271			• A273
V 35°					
W 80°	• A279	• A278			
Y 25°					

	T-TURN				
Application	Semi-Heavy	Heavy			
Chip breaker	**RH**	**EH**	**HT**	**HD**	**HY**
Insert					
Material	P M	M	P M K	P	P
C 80°	• A252	• A251	• A245 A251	• A245	• A245 A251
D 55°					
R					
S 90°	• A267	• A266	• A262 A266	• A261	• A262 A267
T 60°	• A273				
V 35°					
W 80°					
Y 25°					

Tool Selection Guide

Negative insert

	T-TURN				
Application	Heavy	Finishing wiper		Medium wiper	Medium
Chip breaker	**HZ**	**WS**	**WA**	**WT**	**GU**
Insert					
Material	P	P M K S	P M K S	P M K S	P K
C 80°	• A245 A251	• A251	• A250	• A244 A251	
D 55°		• A258	• A258	• A258	
H 120°					• A259
S 90°	• A262 A267				
T 60°			• A273		
V 35°					
W 80°		• A279	• A280	• A279	
Y 25°					

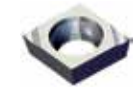
	T-TURN				
Application	Medium	Roughing	Medium		
Chip breaker	**SU**	**KNUX type**	**DNUX type**		
Insert					
Material	P M S	P M K S	P M S		
C 80°					
D 55°			• A258		
H 120°	• A259				
K 55°		• A259			
T 60°					
V 35°					
W 80°					
Y 25°					

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Tool Selection Guide

Positive insert

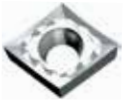
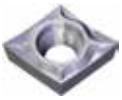
	T-TURN				
Application	Super finishing	Finishing		Medium	
Chip breaker	**FA**	**FG**	**FX**	**PC**	**FM**
Insert					
Material	P M S	P M S	P M S	P M S	P M
C 80°	• A283	• A284 A285		• A284 A285	• A284 A285
D 55°	• A288	• A288		• A288	• A288
R				• A290	
S 90°		• A291		• A291	• A291
T 60°	• A294 A298	• A294 A298		• A295 A298	• A295 A298
V 35°	• A300	• A301	• A301	• A301 A302	• A301 A302
W 80°					
Y 25°					

	T-TURN				
Application	Medium	Roughing			Finishing
Chip breaker	**MT**	**PMR-**	**RA**	**CMX-**	**FF**
Insert					
Material	P M K S	P M K S	P	P	P M S
C 80°	• A284				• A283
D 55°	• A288				• A287 A289
R	• A290		• A290	• A290	
S 90°	• A291	• A292			
T 60°	• A295	• A298			• A293 A297
V 35°	• A301				• A300 A303
W 80°					• A304
Y 25°					

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Member IMC Group

Tool Selection Guide

Positive insert

	T-TURN				
Application	Finishing		Medium wiper	Finishing	
Chip breaker	**GF**	**GW**	**WT**	**FL**	**SA**
Insert					
Material	P M S	P M S	P M K S	M N S	P M S
C 80°	• A282	• A282	• A284	• A306	• A283
D 55°	• A286 A289	• A286		• A306	• A287
R				• A306	
S 90°				• A306	
T 60°	• A294 A296			• A306	• A294
V 35°	• A300 A303	• A300		• A306	• A300 A302
W 80°					
Y 25°					

Grades

Coated carbide, cermet and carbide grades

Grades	ISO	Characteristics & applications
TT7005 CVD coated	K01 – K15	• For high speed machining of gray and ductile cast iron • Excellent wear resistant coated grade assures optimum performance in high speed continous machining of cast iron
TT7015 CVD coated	K10 – K25	• For general machining of gray and ductile cast iron • For continuous and interrupted machining of gray and ductile cast iron
TT7310 CVD coated	K10 – K25	• For general machining of gray and ductile cast iron
TT8105 CVD coated	P01 – P15	• For high speed turning of steel in continuous cutting applications • The highest wear resistant grade used on steel applications
TT8115 CVD coated	P05 – P20	• For high speed turning continuous cutting on steels • Excellent wear resistance and heat-resistance
TT9215 CVD coated	S05 – S20 M05 – M20	• Excellent insert wear resistance • For high cutting speed & continuous cutting on stainless steels
TT5080 PVD coated	S05 – S25 M05 – M25	• For a wide range of turning of high-temp alloys • Very hard submicron substrate with good fracture toughness
TT8125 CVD coated	P15 – P30	• For a wide range of turning on steels • Very good combination of wear resistance and toughness • For general use on steels
TT5100 CVD coated	P20 – P35	• For a wide range of turning of mild steel, low carbon steel and low carbon alloy steel • Excellent chipping resistance and sticking resistance
TT9225 CVD coated	S15 – S30 M15 – M30	• Excellent combination of insert wear resistance & fracture resistance • For general use on stainless steel • For continuous and interrupted cutting on stainless steel
TT9020 PVD coated	P20 – P40 M20 – M40	• Submicron substrate with PVD coating • For stainless steel
TT9080 PVD coated	M20 – M40 S20 – S40	• Very hard submicron substrate • For turning small components
TT8135 CVD coated	P25 – P40	• Tough carbide substrate • For a wide range of medium to roughing applications at low cutting speed on steels • For heavy turning
TT7100 CVD coated	P30 – P45	• Very tough carbide substrate base - with a CVD coating • This combination provides both excellent toughness and chipping resistance • For heavy turning
TT9235 CVD coated	S25 – S40 M25 – M40	• Excellent combination of insert wear resistance & toughness • For low cutting speed & interrupted cutting
TT8020 PVD coated	P30 – P50 M30 – M50 S30 – S50	• For medium to low speed turning of stainless steel, exotic alloys and low carbon steel • Toughest grade in turning grade • For interrupted cut on stainless steel and exotic alloys
PV3010 PVD coated cermet	P05 – P20 M05 – M20 K05 – K20	• For high surface finish turning of steel, stainless steel and cast iron • Excellent wear resistance and low coefficient of friction • Long tool life
CT3000 Uncoated cermet	P10 – P20 M10 – M20 K10 – K20	• Excellent surface finish turning on steel, stainless steel and cast iron • Excellent wear resistance and low coefficient of friction
K10 Carbide	K05 – K15 N05 – N15 S05 – S15	• General turning of cast iron, exotic alloy and non-ferrous materials including aluminum and copper alloy • Excellent wear resistant grade

Grades

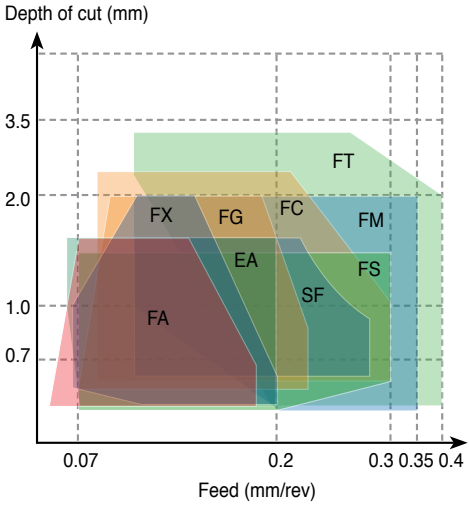
CBN, PCD and ceramic grades

Grades	Composition	Characteristics & applications
KP300 PCD	PCD + Binder	• For general use on aluminum alloy • Excellent combination of wear resistance and toughness
TD810 PCD	PCD + Binder	• Optimal combination of strong wear resistance and superior toughness • Suitably designed for aluminum and non-ferrous materials • Achieves excellent surface finish
TB610 CBN	CBN + Binder	• Excellent wear resistant grade with low CBN content • Continuous cutting at high cutting speeds on hardened steels
TB650 CBN	CBN + Binder	• High wear resistant grade with moderate fracture toughness • Can be applied to light interrupted cutting applications
TB670 CBN	CBN + Binder	• Excellent combination of wear resistance and toughness • For general use on hardened steel • For continuous and interrupted cutting
TB730 CBN	CBN + Binder	• Excellent toughness with high CBN content • For high speed machining of cast iron • Can be applied to interrupted cutting on hardened steel and other materials
KB90A CBN	CBN + Binder	• Solid CBN with excellent impact resistance • For high speed machining of cast iron • Can be applied to rough to medium machining of hardened steel
AW120 Ceramic	Al_2O_3 + ZrO_2	• Excellent wear resistant grade with chemical stability and temperature resistance • For high speed continuous turning of cast iron • For finishing applications on hard materials
AB2010 Coated ceramic	(Al_2O_3 + TiCN) +TiN PVD Coating	• Excellent wear resistance and tool life • Very good combination with improved wear and fracture resistance • Finishing operations on hardened steels and hardened cast irons
AB20 Ceramic	Al_2O_3 +TiCN	• High wear resistant grade with excellent cutting edge stability • For high speed continuous turning of hardened steel and other hard materials • For finishing applications on cast iron.
AB30 Ceramic	Al_2O_3 +TiC	• Mixed ceramic with good toughness and wear resistance • For general use on hardened steel, cast iron and hard materials • Can be applied to interrupted cutting conditions
TC430 Ceramic	Whisker	• SiC whisker reinforced ceramic grade • General turning and milling • For Ni-base superalloy, inconel, waspaloy and rene
AS500 Ceramic	SiAlON	• For roughing to finishing cast iron applications • For higher cutting speeds compared to AS10 • Wet and dry cutting
SC10 Coated ceramic	AS10 + CVD	• Wear resistant grade with excellent toughness and thermal shock resistance • For high speed turning of cast iron • Wet and dry cutting
AS10 Ceramic	Si_3N_4	• High wear resistant grade with excellent toughness and thermal shock resistance • For general use on cast iron • Wet and dry cutting
AS20 Ceramic	Si_3N_4	• Very tough Si_3N_4 ceramic grade with high cutting edge stability • For roughing to finishing applications with high temperature nickel based alloys • Wet and dry cutting

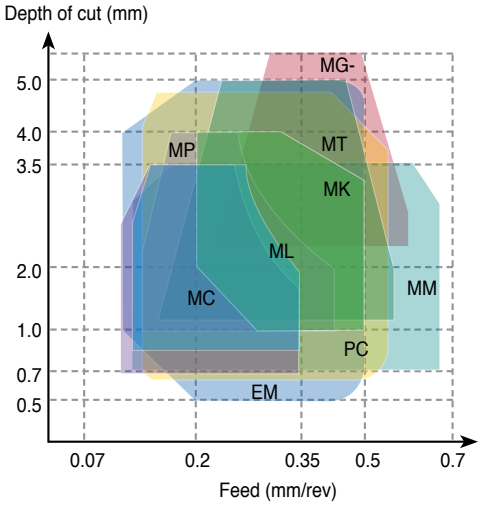
Chip Breakers

Negative inserts

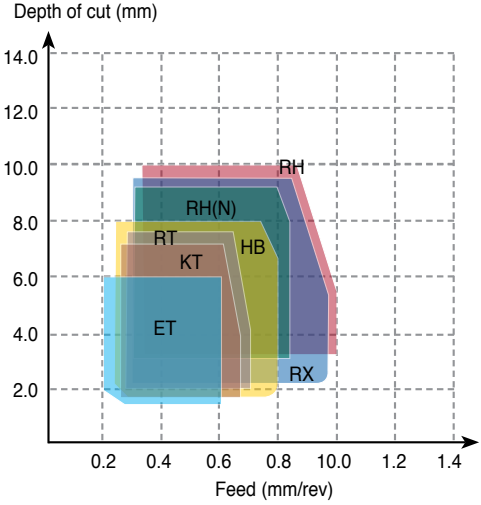
For finishing applications



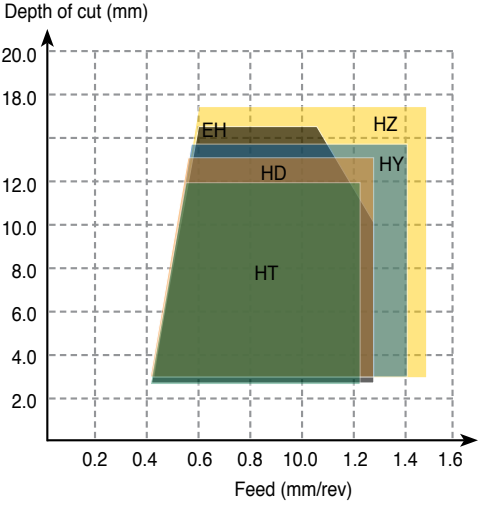
For medium applications



For roughing applications



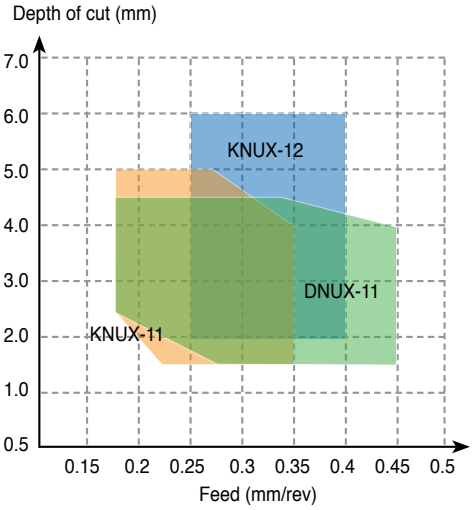
For heavy machining



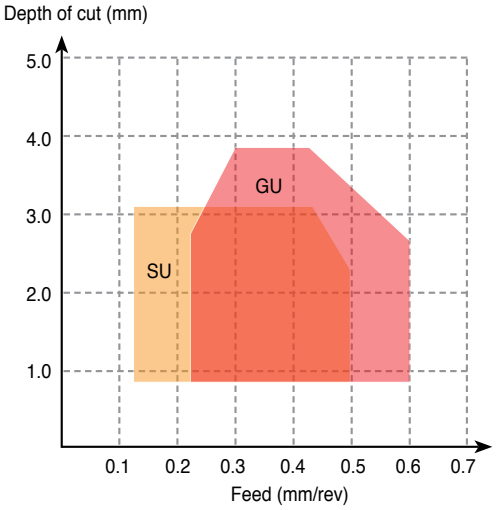
Chip Breakers

Negative inserts

KNUX / DNUX type

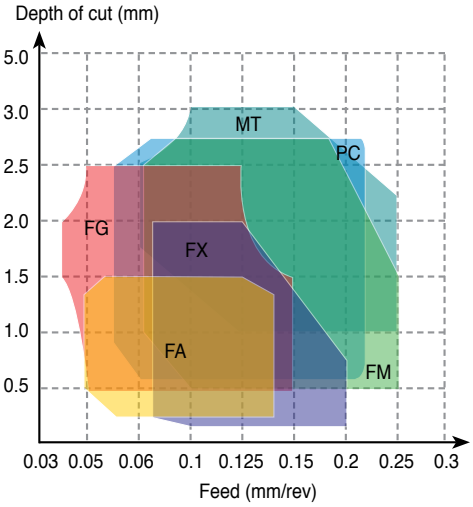


HNMG type

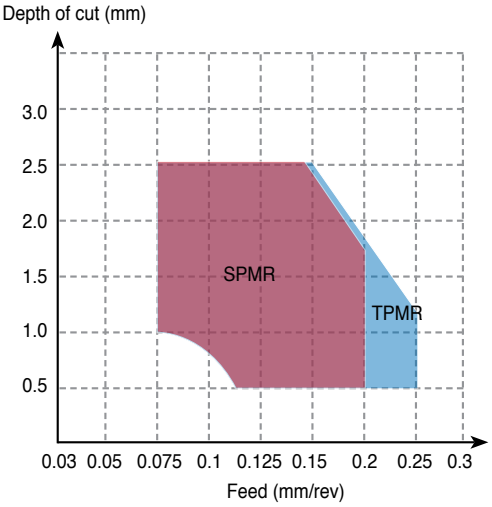


Positive inserts

For Finish to medium applications



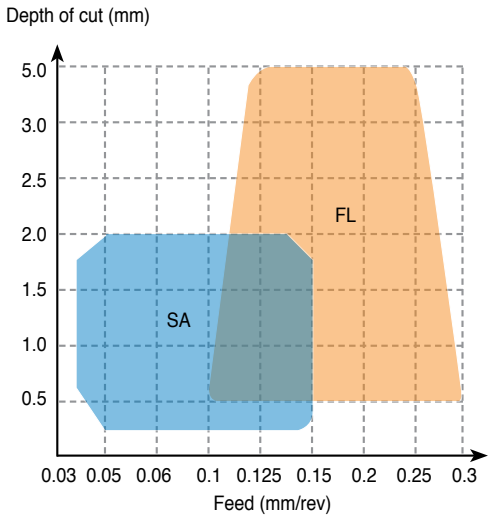
For medium applications



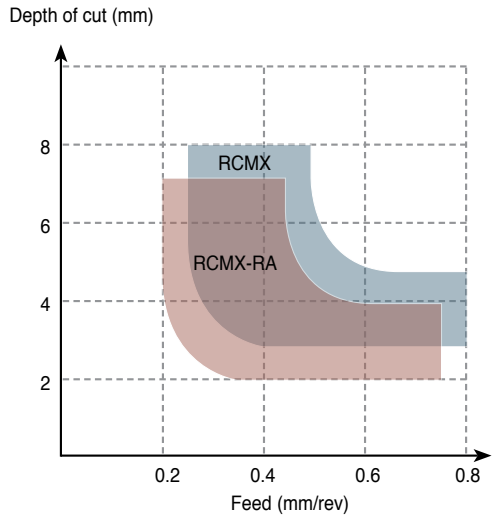
Chip Breakers

Positive inserts

Ground insert for finishing applications

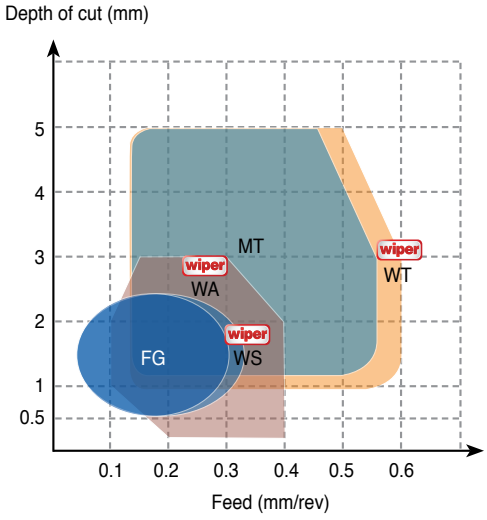


Round insert for roughing applications

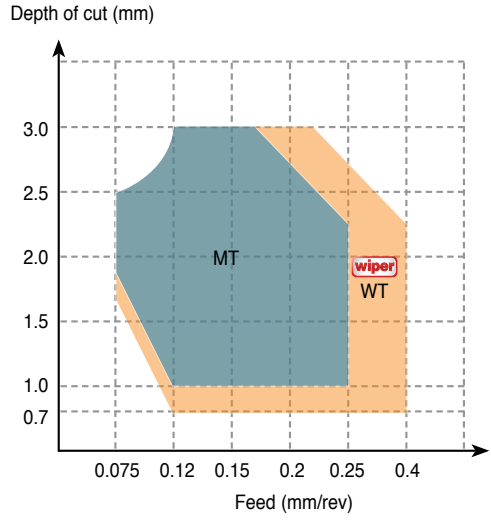


'WS' and 'WT' wiper inserts for high feed turning

Negative inserts

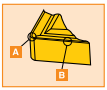


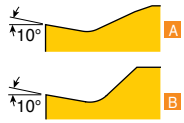
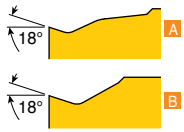
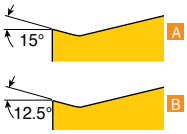
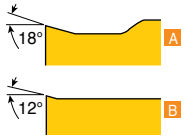
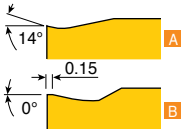
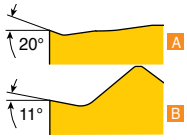
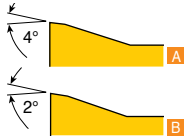
Positive inserts



Chip Breakers

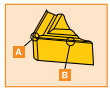
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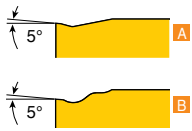
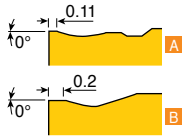
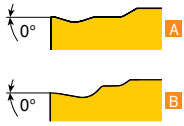
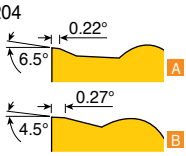
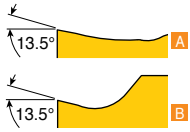
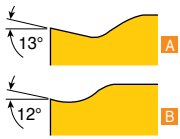
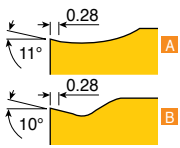


Chip breaker name and geometry			Applications and features
FS		CNMG 0904 	• Super finishing chip breaker for steel machining • Excellent chip control and chip evacuation • Minimal vibration due to less machining load
FA		CNMG 1204 	• For super finish applications • Steel, stainless steel and heat resistant alloy machining • Excellent chip control
EA		CNMG 1204 	• For finishing applications • Exotic materials • Excellent chip control at low feeds and depths of cut
FG		CNMG 1204 	• For finish and semi finish applications • Steel, stainless steel and cast iron machining • Low cutting forces
SF		CNMG 1204 	• For finishing applications • Stainless steel and heat resistant alloy machining • Low cutting forces
FX		VNMG 1604 	• For finishing applications on mild steels • Narrow chip breaker design for optimal chip control
FC		CNMG 1204 	• Ideal for finishing applications • Low carbon steel & low carbon alloy steel • Effective chip breaking in both turning and facing operations

Chip Breakers

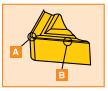
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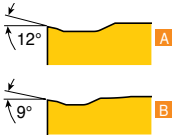
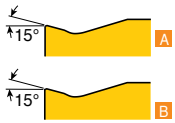
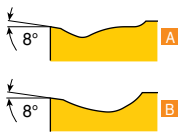
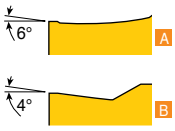
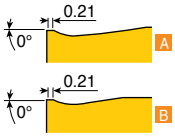
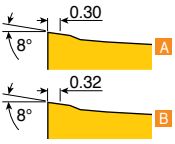
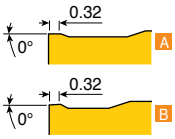


Chip breaker name and geometry			Applications and features
FM		CNMG 0904 	• For steel machining • Improved chip breaking due to 3dimension chipbreaker • Solution for a wide range from semi-finishing to semi-medium machining
MC		CNMG 1204 	• For medium applications • Steel and cast iron machining • Strong rake geometry • Excellent chip control on medium turning applications
FT		CNMG 0904 	• For steel machining • Strong, serrated cutting edge for excellent chip evacuation • Semi-finishing and medium machining • Excellent chip breaking for automotive components
PC		CNMG 1204 	• For medium to semi-finishing applications • Steel & Automotive component • Positive geometry • Excellent chip control on medium applications
VF		DNMG 1504 	• For slender workpiece applications • Vibration free • Steel and stainless steel machining • High positive rake geometry to minimize cutting forces
ML		CNMG 1204 	• For medium light applications • Stainless steel, steel and aluminum • Very high positive rake geometry to minimize built-up-edge and cutting forces
MP		CNMG 1204 	• For medium machining applications • Steel and stainless steel • High positive rake geometry to optimize machining and provide stable machining conditions

Chip Breakers

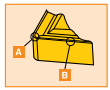
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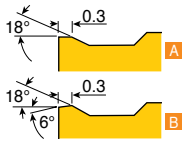
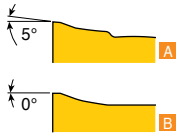
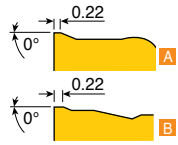
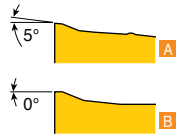
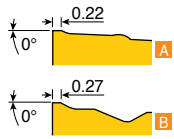
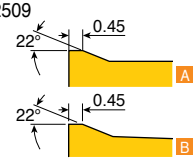
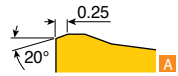


		Chip breaker name and geometry	Applications and features
EM		CNMG 1204 	• For medium applications • Stainless steel machining • Sharp land design for low cutting force
MK		CNMG 0904 	• For medium applications • Stainless steel and heat resistant material machining • Sharp cutting edge to reduce built-up-edge
MM		CNMG 0904 	• For general machining on stainless steel and steel • Positive rake angle provides excellent chip evacuation
MT		CNMG 1204 	• For medium rough applications • Steel, cast iron and stainless steel • Tough rake angle for general use
MG-		CNMG 1204 	• For medium rough applications • Steel and cast iron machining • Strong rake geometry • Suitable for manual lathes
ET		CNMG 1204 	• For roughing applications on exotic materials • Low cutting force • Wide chip control range when roughing
RT		CNMG 1906 	• For roughing applications • Steel and cast iron machining • Very strong rake geometry

Chip Breakers

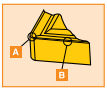
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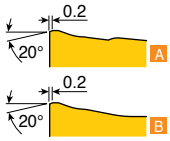
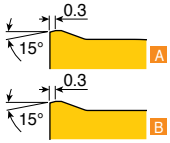
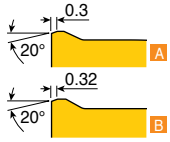
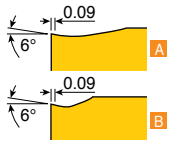
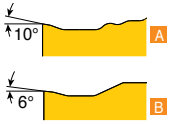
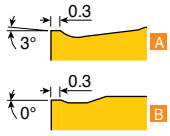


Chip breaker name and geometry			Applications and features
KT		CNMG 1204 	• For roughing applications on cast iron • Stable broad supporting area • Reliable, uniform performance
HB		CNMX 1607 	• For semi heavy roughing applications • Steel and alloy steel machining • Double sided semi-heavy turn insert • Stable contact surface with seat
RH(N)		CNMM 1906 	• For high feed roughing applications • Steel, cast iron and stainless steel machining • Very strong rake geometry
RX		CNMM 1906 	• For semi heavy roughing applications • Steel, stainless steel and cast iron machining • Strong cutting edge with flat land • Low cutting force
RH		CNMM 1906 	• For roughing applications • Steel, stainless steel and cast iron machining • Very strong rake geometry
EH		CNMM 2509 	• Heavy turning for stainless and mild steel • Low cutting force in stainless steel machining • Reliable & uniform performance • Excellent chip control due to the specially designed chip breaker geometry • Single sided insert
HT		CNMM 1906 	• For heavy roughing applications • Low cutting force for low horse power machines • Excellent chip control due to changeable land and a flexible chip breaker

Chip Breakers

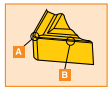
Negative inserts



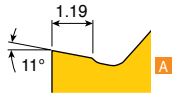
	Chip breaker name and geometry		Applications and features
HD		CNMD 2509 	• For heavy roughing applications • For all kinds of shafts, connecting-rods and ship building components • Flexible chip breaker offers excellent chip evacuation
HY		CNMM 2509 	• For heavy roughing applications • For large depth of cut and high feed • Strong cutting edge credit to a wide land and large land angle
HZ		CNMM 2509 	• For heavy roughing applications • For large depth of cut and high feed • Extremely strong cutting edge credit to a wide land and large land angle • Suitable for high cutting conditions
WS	wiper 	CNMG 1204 	• For super finish applications • Steel, cast iron and stainless steel machining • Excellent chip control and low cutting forces
WA	wiper 	CNMG 0904 	• When compare to existing same type insert, wiper insert gets equivalent roughness under two times feed rate • Under the same feed rate, gets excellent surface roughness (over two more)
WT	wiper 	CNMG 1204 	• For medium to rough machining applications • Steel, cast iron and stainless steel machining • Stable cutting and low cutting forces at high feed rates

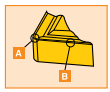
Chip Breakers

Negative inserts

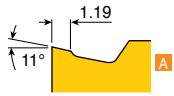
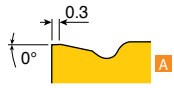


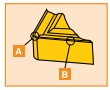
DNUX type

		Chip breaker name and geometry	Applications and features
11		DNUX 1304 	• Suitable for RhinoRush holder and 4 corners insert • For medium light to medium applications less than 5mm depth of cut • Steel and stainless steel machining • Positive rake geometry to decrease cutting forces • Suitable for turning slender bar, thin-wall components and low cutting force machine

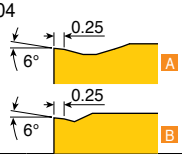
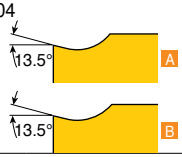


KNUX type

		Chip breaker name and geometry	Applications and features
11		KNUX 1604 	• For medium light to medium applications • Steel and stainless steel machining • Positive rake geometry to minimize cutting forces • Excellent chip control
12		KNUX 1604 	• For medium to medium rough applications • Steel and stainless steel • Strong rake geomerty • Wide chip control range

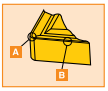


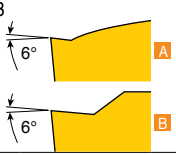
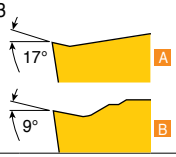
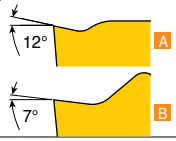
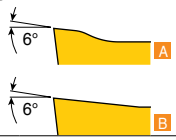
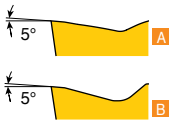
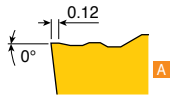
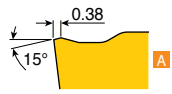
HNMG type

		Chip breaker name and geometry	Applications and features
GU		HNMG 0504 	• For medium applications • For general turning of steels and cast irons • Strong rake geometry
SU		HNMG 0504 	• For exotic materials • Stainless steels, super alloys, low carbon steels, low carbon alloy steel machining • Sharp geometry to minimize built-up edge

Chip Breakers

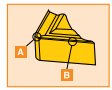
Positive inserts-pressed

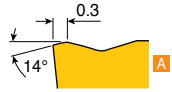
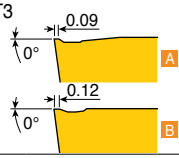


	Chip breaker name and geometry		Applications and features
FA		DCMT 11T3 	• For super finish applications • Very tight chipbreaker • Excellent chip control
FG		CCMT 09T3 	• For finish to medium light applications • Steel and stainless steel machining • Low cutting forces • Excellent chip control
FX		VBMT 1604 	• For finishing applications on mild steels • Narrow chip breaker design for optimal chip control
PC		CCMT 09T3 	• For medium applications • Suitable for a wide variety of meterials • Low cutting force
FM		CCMT 09T3 	• Medium and semi-finishing machining for steel and stainless steel • Precision machining • Low cutting force chip breaker geometry
MT		CCMT 09T3 	• For medium to medium rough applications • Steel, stainless steel and cast iron machining • Negative rake geometry for general use
PMR-		TPMR 1103 	• For medium to medium rough applications • Steel, stainless steel and cast iron • Positive rake geometry
RA		RCMX 3209 	• For heavy and interrupted machining applications • Steel, stainless steel and cast iron machining • Optimized chip groove geometry

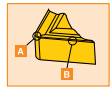
Chip Breakers

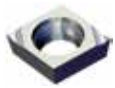
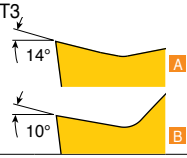
Positive inserts-pressed



Chip breaker name and geometry			Applications and features
CMX-		RCMX 1204 	• For high feed roughing applications • Steel, stainless steel and cast iron machining • Strong rake geometry
WT	wiper 	CCMT 09T3 	• For medium to rough machining applications • Steel, cast iron and stainless steel machining • Stable cutting and low cutting forces at high feed rates

Positive inserts-ground



Chip breaker name and geometry			Applications and features
FF		CCGT 0301 	• For finish to medium applications • For small component machining • Excellent surface finish
GF		CCET 0602 	• For super finish applications • Steel, stainless steel and alloy steel machining
GW		CCET 0602 	• For super finish applications • Wiper geometry for good surface finish • Steel, stainless steel and alloy steel machining
FL		CCGT 1204 	• For finish to medium applications • Aluminum machining • Very high positive rake geomerty to minimize built-up-edge
SA		CCGT 09T3 	• For finish to medium applications • Steel & aluminum machining • Low cutting force

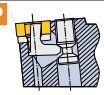
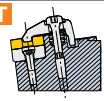
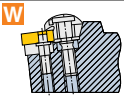
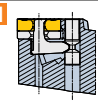
Turning Toolholders



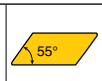
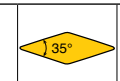
Toolholder Designation System

P	C	L	N	R
1	2	3	4	5

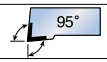
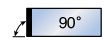
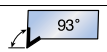
1 Clamping system

P	C	S	M	T	W	H
						
Lever lock	Top clamp	Screw clamp	Multi lock	T-holder	Wedge clamp	Hook lever

2 Insert shape

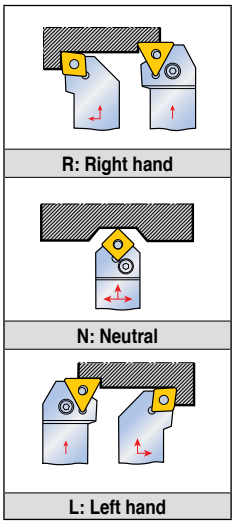
C	D	E	H	K	R	S	T	V	W
									

3 Approach angle

Symbol	Shape	Offset	Symbol	Shape	Offset	Symbol	Shape	Offset
A		×	J		○	V		×
			K		○	W		○
B		×	L		○	X	Special angle	
			M		×	C*		×
D		×	N		×	H*		○
E		×	R		○	Q*		○
F		○	S		○			
G		○	T		○			
			U		○			

* TaeguTec standard

5 Hand of tool



4 Insert clearance angle

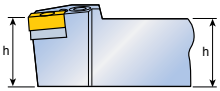
N	B	C	P
0°	5°	7°	11°

TaeguTec

Toolholder Designation System

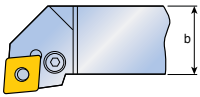
25	25	M	12	-		
6	7	8	9		10	11

6 Shank height



Integers to be preceded by 0
e.g.: h=8mm indicated by 08

7 Shank width



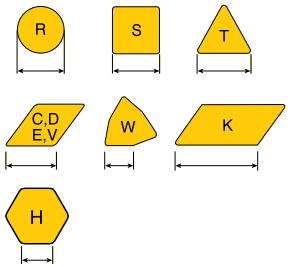
Integers to be preceded by 0
e.g.: b=8mm indicated by 08

8 Tool length



l1 (mm)	Symbol	l1 (mm)	Symbol
32	A	160	N
40	B	170	P
50	C	180	Q
60	D	200	R
70	E	250	S
80	F	300	T
90	G	350	U
100	H	400	V
110	J	450	W
125	K	500	Y
140	L	Special	X
150	M		

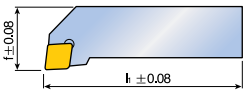
9 Cutting edge length



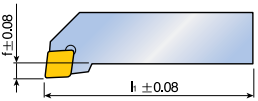
See page A243

10 Qualified tool

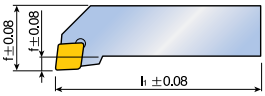
Q



F



B

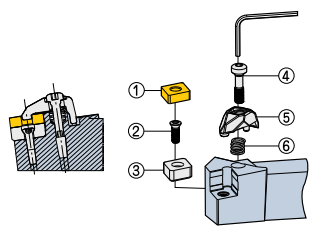


11 Manufacturer's type designation

Unique to manufacturer

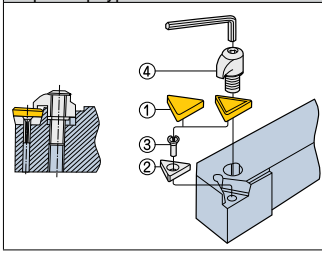
Toolholder Clamping System

T-holder type — T



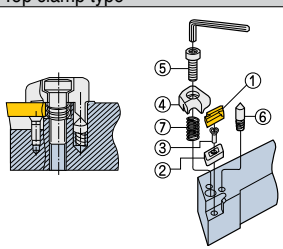
① Insert
② Shim screw
③ Shim
④ Clamp screw
⑤ Clamp
⑥ Spring

Top clamp type — C



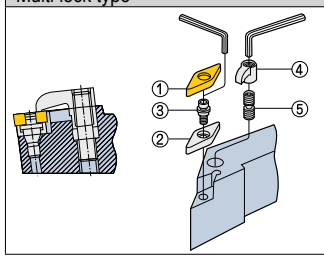
① Insert
② Shim
③ Shim pin
④ Clamp set

Top clamp type — C



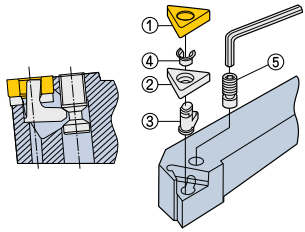
① Insert
② Shim
③ Shim screw
④ Clamp
⑤ Clamp screw
⑥ Pin and spring
⑦ Clamp spring

Multi lock type — M



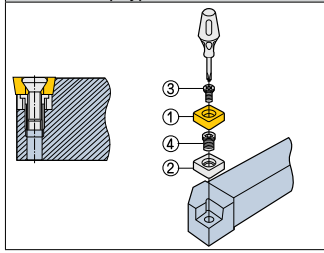
① Insert
② Shim
③ Lock pin
④ Clamp
⑤ Clamp screw

Lever lock type — P



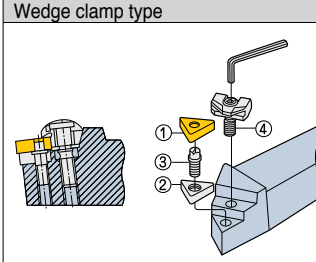
① Insert
② Shim
③ Lever
④ Shim pin
⑤ Screw

Screw clamp type — S



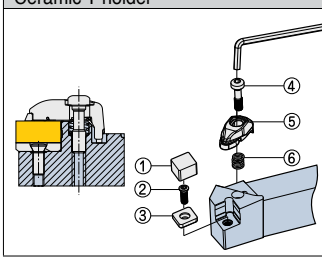
① Insert
② Shim
③ Screw
④ Shim screw

Wedge clamp type — W



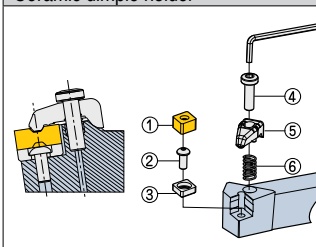
① Insert
② Shim
③ Pin screw
④ Wedge set

Ceramic T-holder — T



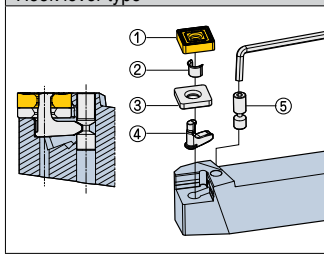
① Insert
② Shim screw
③ Shim
④ Clamp screw
⑤ Clamp
⑥ Spring

Ceramic dimple holder — T



① Insert
② Shim screw
③ Shim
④ Clamp screw
⑤ Clamp
⑥ Spring

Hook lever type — H

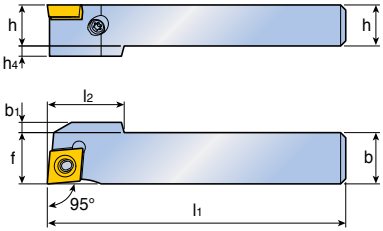


① Insert
② Shim pin
③ Shim
④ Hook lever
⑤ Screw

TaeguTec
Member IMC Group

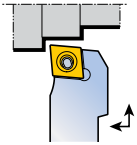
BCLCR/L-SH

Back clamp type



BCLCR/L-SH

Approach angle	Designation		Dimension (mm)							Insert	
			h	h4	b	b1	l1	f	l2		
95°	# BCLCR/L	1010 K06-SH	10	-	10	-	125	10	-	CC...T 0602...	A282-A284 A335
		1212 K06-SH	12	-	12	-	125	12	-		
		1010 K09-SH	10	3	10	4	125	10	17	CC...T 09T3...	
		1212 K09-SH	12	1	12	2	125	12	17		



• # Marked: For TOPMINI insert

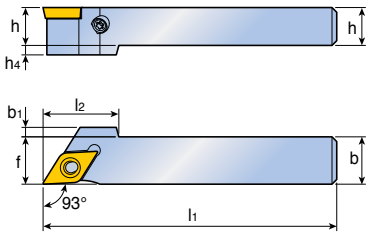
Spare parts

Designation	Lever	Lever screw	Snap ring	Wrench				
								
...06	BLCL 2	BLCS 2	BLSR 2	T 6				
...09	BLCL 3	BLCS 3	BLSR 3	L-W 2F				

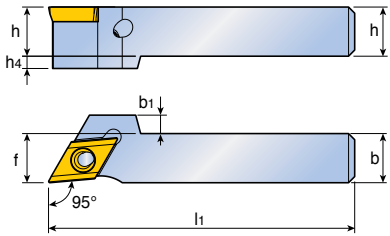
TaeguTec Member IMC Group

BDJCR/L-SH BDLPR/L-SH

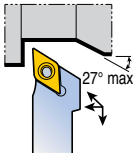
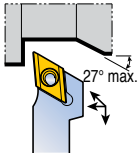
Back clamp type



BDJCR/L-SH



BDLPR/L-SH

Approach angle	Designation		Dimension (mm)							Insert	
			h	h4	b	b1	l1	f	l2		
93°	# BDJCR/L	1010 K07-SH	10	-	10	-	125	10	-	DC...T 0702...	A286-A288 A336
		1212 K07-SH	12	-	12	-	125	12	-		
		1010 K11-SH	10	3	10	4	125	10	17	DC...T 11T3...	
		1212 K11-SH	12	1	12	2	125	12	17		
95°	# BDLPR/L	0808 K07-SH	8	2	8	3	125	8	-	DP...T 0702...	
		1010 K07-SH	10	-	10	1	125	10	-		
		1010 K11-SH	10	3	10	4	125	10	-	DP...T 11T3...	
		1212 K11-SH	12	1	12	2	125	12	-		
		1616 K11-SH	16	-	16	-	125	16	-		

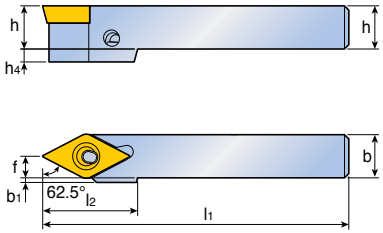
• # Marked: For TOPMINI insert

Spare parts

Designation	Lever	Lever screw	Snap ring	Wrench				
								
...07	BLCL 2	BLCS 2	BLSR 2	T 6				
...11	BLCL 3	BLCS 3	BLSR 3	L-W 2F				

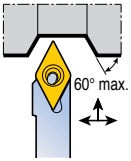
BDNCN-SH

Back clamp type



BDNCN-SH

Approach angle	Designation		Dimension (mm)							Insert	
			h	h4	b	b1	l1	f	l2		
62.5°	# BDNCN	1010 K07-SH	10	-	10	-	125	5	-	DC...T 0702...	A286-A288 A336
		1212 K07-SH	12	-	12	-	125	6	-		
		1010 K11-SH	10	3	10	1	125	5	22	DC...T 11T3...	
		1212 K11-SH	12	1	12	-	125	6	22		



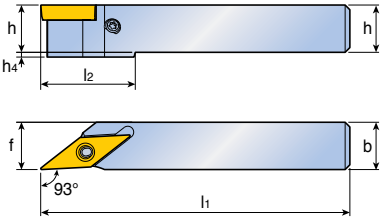
• # Marked: For TOPMINI insert

Spare parts

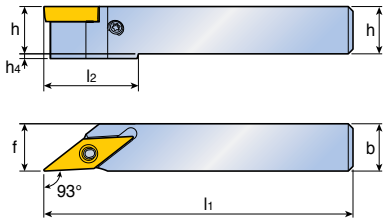
Designation	Lever	Lever screw	Snap ring	Wrench				
								
...07	BLCL 2	BLCS 2	BLSR 2	T 6				
...11	BLCL 3	BLCS 3	BLSR 3	L-W 2F				

BVJBR/L-SH BVJCR/L-SH

Back clamp type

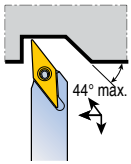


BVJBR/L-SH



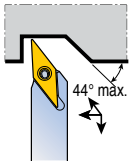
BVJCR/L-SH

Approach angle	Designation		Dimension (mm)						Insert
			h	h4	b	l1	f	l2	
93°	# BVJBR/L	1010 K11-SH	10	1	10	125	10	20	VB...T 1103...
		1212 K11-SH	12	-	12	125	12	-	



A300-A302
A341

Approach angle	Designation		Dimension (mm)						Insert
			h	h4	b	l1	f	l2	
93°	# BVJCR/L	1010 K11-SH	10	1	10	125	10	20	VC...T 1103...
		1212 K11-SH	12	-	12	125	12	-	



• # Marked: For TOPMINI insert

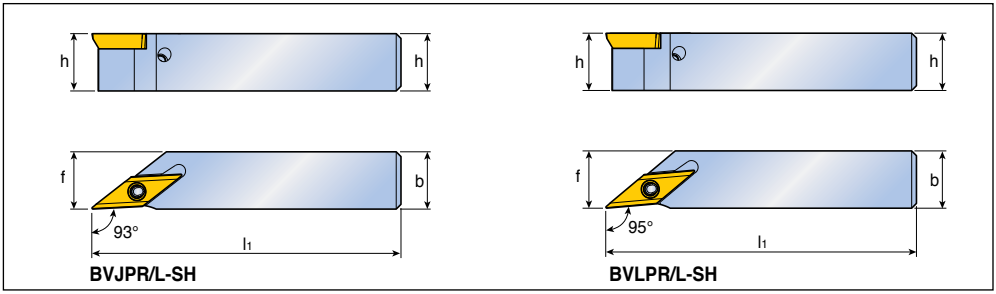
Spare parts

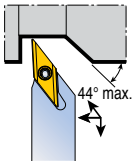
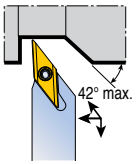
Designation	Lever	Lever screw	Snap ring	Wrench				
...11	BLCL 2	BLCS 2	BLSR 2	T 6				

TaeguTec

BVJPR/L-SH BVLPR/L-SH

Back clamp type



Approach angle	Designation		Dimension (mm)				Insert
			h	b	l1	f	
93°	# **BVJPR/L**	**1212 K11-SH**	12	12	125	12	VP...T 1103... A303
		**1616 K11-SH**	16	16	125	16	
95°	# **BVLPR/L**	**1212 K11-SH**	12	12	125	12	
		**1616 K11-SH**	16	16	125	16	

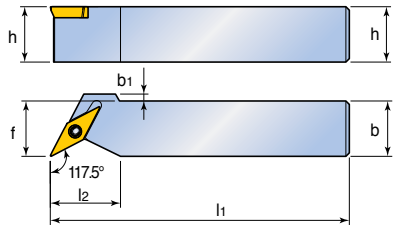
• # Marked: For TOPMINI insert

Spare parts

Designation	Lever	Lever screw	Snap ring	Wrench				
								
...11	BLCL 2	BLCS 2	BLSR 2	T 6				

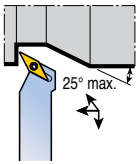
BVPPR/L-SH

Back clamp type



BVPPR/L-SH

Approach angle	Designation		Dimension (mm)						Insert
			h	b	l1	l2	f	b1	
117.5°	# BVPPR/L	1010 K11-SH	10	10	125	20.3	10	8	VP...T 1103... A303
		1212 K11-SH	12	12	125	20.3	12	6	
		1616 K11-SH	16	16	125	20.3	16	2	



• # Marked: For TOPMINI insert

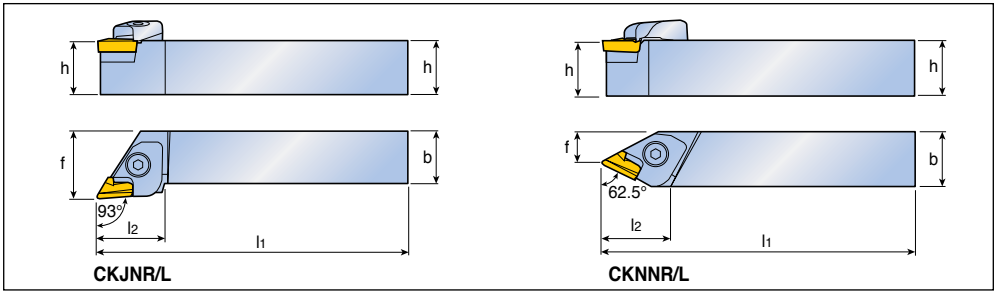
Spare parts

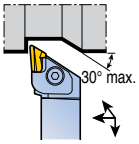
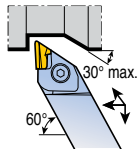
Designation	Lever	Lever screw	Snap ring	Wrench				
								
...11	BLCL 2	BLCS 2	BLSR 2	T 6				

TaeguTec

CKJNR/L CKNNR/L

Top clamp type



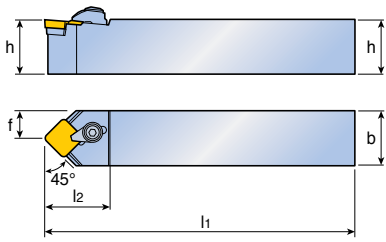
Approach angle	Designation		Dimension (mm)					Insert
			h	b	l_1	l_2	f	
93°	**CKJNR/L**	**2020 K16**	20	20	125	35	25	KNUX 1604...R/L 11 KNUX 1604...R/L 12 A259
		**2020 M16**	20	20	150	35	25	
		2525 M16	25	25	150	32	32	
		3225 P16	32	25	170	33.3	32	
		3232 M16	32	32	150	33.3	40	
		3232 P16	32	32	170	33.3	40	
		4040 R16	40	40	200	33.3	50	
62.5°	**CKNNR/L**	**2525 M16**	25	25	150	44.7	14.4	
		**3225 M16**	32	25	150	44.7	14.4	

Spare parts

Designation	Clamp	Screw	Clamp spring	Pin & spring	Shim	Shim screw	Wrench	
								
...16	CL 16KR/L	CLS 16K	KSP 90	KSP 48 KP 48S	CSK 1604R/L	FH M3×0.5×10	L-W 4	

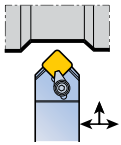
CSDPN

Top clamp type



CSDPN

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
45°	CSDPN	**1616 H09**	16	16	100	24	8.0	SPMR,SP...N 0903...
		2020 K12	20	20	125	29	10	SPMR,SP...N 1203...
		2525 M12	25	25	150	29	12.5	



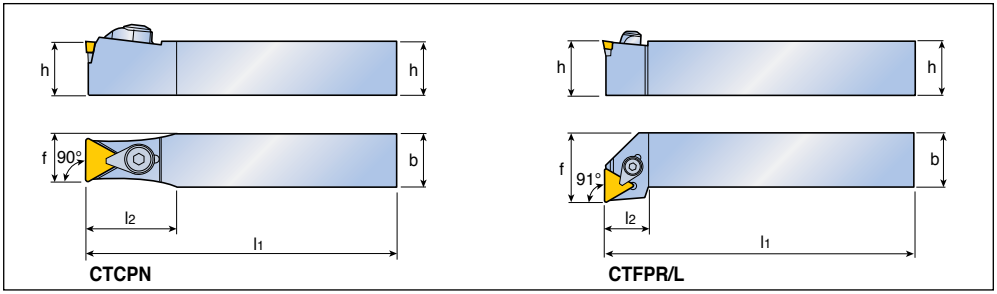
A292, 325, A338

Spare parts

Designation	Clamp	Screw	Shim	Shim pin	Snap ring	Wrench		
...09	CL 2	CLS 2	CSS 32	CSP 3	CSR 2	L-W 2.5		
...12	CL 3	CLS 3	CSS 42	CSP 3	WSR 4	L-W 3		

CTCPN CTFPR/L

Top clamp type



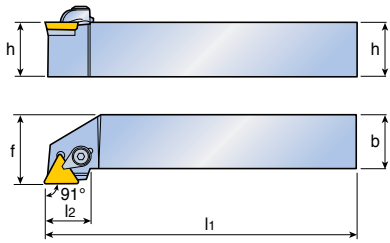
Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l1	l2	f		
90°	**CTCPN**	**2009 K11**	20	9	125	20	9.4	TPMR,TP...N 1103...	
		2513 Q16	25	13	180	30	14.1	TPMR,TP...N 1603...	A296, A298,
		2020 K22	20	20	125	50	19.4	TPMR,TP...N 2204...	A299, A325,
		2525 M22	25	25	150	50	19.4		A339, A340
91°	**CTFPR/L**	**1616 H11**	16	16	100	14.4	20	TPMR,TP...N 1103...	
		2020 K11	20	20	125	16	25		
		2020 K16	20	20	125	20	25	TPMR,TP...N 1603...	
		2525 M16	25	25	150	20	32		

Spare parts

Designation	Clamp	Screw	Shim	Shim pin	Snap ring	Wrench		
CTCPN ...11	CL 2C	CLS 2C	-	-	CSR 2C	L-W 2.5		
CTCPN ...16	CL 3C	CLS 3C	CST 32	CSP 3	CSR 2	L-W 3		
CTCPN ...22	CLM 12	XNSM 0825	CST 43	CSP 16K	CSR 4	L-W 4		
CTFPR/L ...11	CL 2	CLS 2	-	-	CSR 2	L-W 2.5		
CTFPR/L ...16	CL 3	CLS 3	CST 32	CSP 3	WSR 4	L-W 3		

CTGPR/L

Top clamp type



CTGPR/L

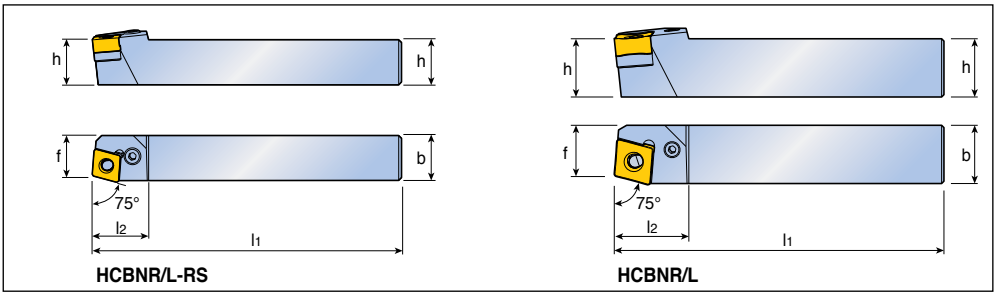
Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l1	l2	f		
91°	CTGPR/L	1212 F11	12	12	80	19	16	TPMR,TP...N 1103...	A296, A298, A299, A325, A339, A340
		1616 H11	16	16	100	18	20		
		2020 K11	20	20	125	19	25		
		2020 K16	20	20	125	25	25	TPMR,TP...N 1603...	
		2525 M16	25	25	150	25	32		
		2525 M22	25	25	150	30	32	TPMR,TP...N 2204...	
		3232 P22	32	32	170	30	40		

Spare parts

Designation	Clamp	Screw	Shim	Shim pin	Snap ring	Wrench		
...11	CL 2	CLS 2	-	-	CSR 2	L-W 2.5		
...16	CL 3	CLS 3	CST 32	CSP 3	WSR 4	L-W 3		
...22	CL 4	CLS 4	CST 43	CSP 16K	CSR 4	L-W 4		

HCBNR/L-RS HCBNR/L

Hook lever type



Approach angle		Designation	Dimension (mm) h	b	l1	l2	f	Insert
75°	✓	**HCBNR/L 1616 K0904-RS**	16	16	125	20	14.5	CN... 0904... A244, A246-A250, A252
75°	✓	**HCBNR/L 2020 K0904**	20	20	125	23	18.5	CN... 0904...
		2525 M0904	25	25	150	23	23.5	
	✳	**HCBNR/L 2525 M1205**	25	25	150	28	22	CNMX 1205...
		3232 M1205	32	32	150	28	27	
		2525 M1607	25	25	150	32	22	CNMX 1607...
		3232 P1607	32	32	170	32	27	

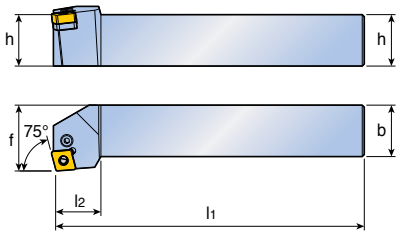
• ✓ Marked: For RHINORUSH insert ✳ Marked: For TURNRUSH insert

Spare parts

Designation	Lever	Screw	Shim		Shim pin	Shim pin punch	Wrench	
...0904	LCL 09-NX	LCS 3	LSC 32A	-	LSP 3A	-	L-W 2.5	
...1205	LCL 12-NX	LCS 5	-	LSC 43-NX	LSP 4	SPP 3-4	L-W 3	
...1607	LCL 16-NX	LCS 5-L25.5	-	LSC 54-NX	LSP 5	SPP 5-6	L-W 3	

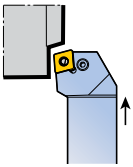
HCKNR/L

Hook lever type



HCKNR/L

Approach angle	Designation	Dimension (mm)					Insert	
		h	b	l_1	l_2	f		
75°	✓ **HCKNR/L 2525 M0904**	25	25	150	22	32	CN... 0904...	A244, A246-A250, A252
	✳ **HCKNR/L 2525 M1205**	25	25	150	25	32	CNMX 1205...	
	3232 P1205	32	32	170	25	40		



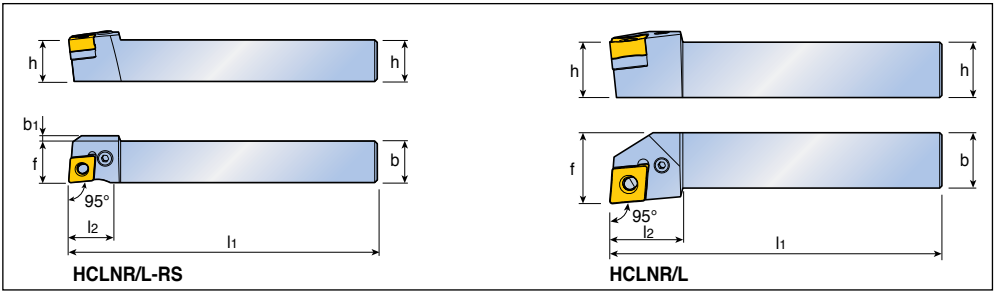
• ✓ Marked: For RHINORUSH insert ✳ Marked: For TURNRUSH insert

Spare parts

Designation	Lever	Screw	Shim		Shim pin	Shim pin punch	Wrench	
								
...0904	LCL 09-NX	LCS 3	LSC 32A	-	LSP 3A	-	L-W 2.5	
...1205	LCL 12-NX	LCS 5	-	LSC 43-NX	LSP 4	SPP 3-4	L-W 3	

HCLNR/L-RS HCLNR/L

Hook lever type



Approach angle		Designation		Dimension (mm)						Insert	
				h	b	b1	l1	l2	f		
95°	✓	HCLNR	1212 K0904-RS	12	16	2	125	18	12	CN... 0904...	A244, A246-A250, A252
	✓	HCLNR/L	1616 K0904-RS	16	16	-	125	20	16		
95°	✓	HCLNR/L	1616 H0904	16	16	-	100	22	20	CN... 0904...	
			2020 H0904	20	20	-	100	22	25		
			2020 K0904	20	20	-	125	22	25		
			2525 M0904	25	25	-	150	22	32		
	✳	HCLNR/L	2525 M1205	25	25	-	150	27	32	CNMX 1205...	
			3232 P1205	32	32	-	170	27	40		
			2525 M1607	25	25	-	150	33	32	CNMX 1607...	
			3232 P1607	32	32	-	170	33	40		

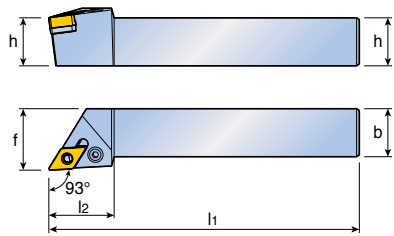
• ✓ Marked: For RHINORUSH insert ✳ Marked: For TURNRUSH insert

Spare parts

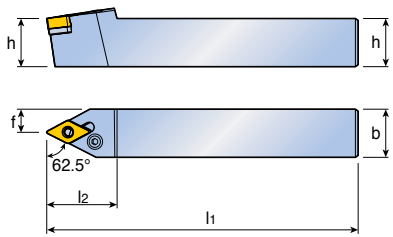
Designation	Lever	Screw	Shim		Shim pin	Shim pin punch	Wrench	Snap ring
...1212...0904	LCL 09B-NX	LCS 3B	-	-	-	-	L-W 2	LSR 3B
...0904	LCL 09-NX	LCS 3	LSC 32A	-	LSP 3A	-	L-W 2.5	
...1205	LCL 12-NX	LCS 5	-	LSC 43-NX	LSP 4	SPP 3-4	L-W 3	
...1607	LCL 16-NX	LCS 5-L25.5	-	LSC 54-NX	LSP 5	SPP 5-6	L-W 3	

HDJNR/L HDNNR/L

Hook lever type

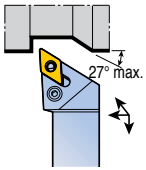


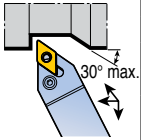
HDJNR/L



HDNNR/L

Approach angle		Designation	Dimension (mm)					Insert
			h	b	l1	l2	f	
93°	✓	HDJNR/L 2020 H1305	20	20	100	34	25	DN... 1305... A253-A258
		2020 K1305	20	20	125	34	25	
		2525 M1305	25	25	150	34	32	
62.5°	✓	HDNNR/L 2020 K1305	20	20	125	36.5	10	
		2525 M1305	25	25	150	36.5	12	





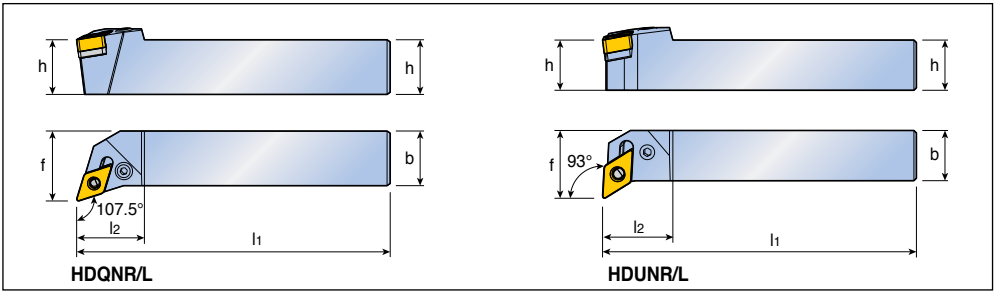
• ✓ Marked: For RHINORUSH insert

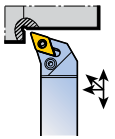
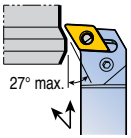
Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
...1305	LCL 11-NX	LCS 4	LSD 3.52	LSP 4	L-W 3			

HDQNR/L HDUNR/L

Hook lever type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
107.5°	✓ **HDQNR/L**	**2020 K1305**	20	20	125	31	25	DN... 1305... A253-A258
		**2525 M1305**	25	25	150	31	32	
93°	✓ **HDUNR/L**	**2020 K1305**	20	20	125	28	27	
								

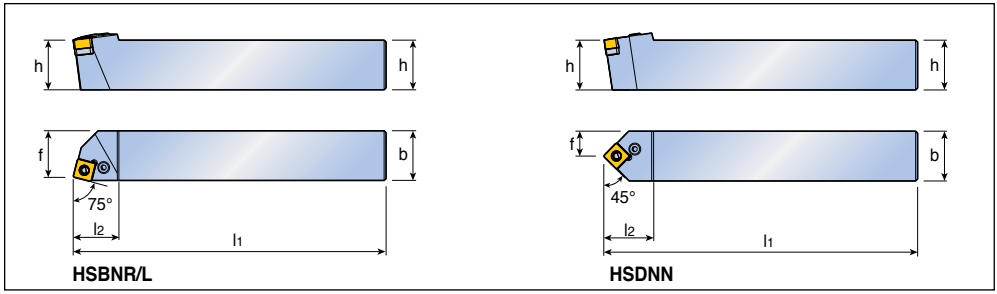
• ✓ Marked: For RHINORUSH insert

Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
								
...1305	LCL 11-NX	LCS 4	LSD 3.52	LSP 4	L-W 3			

HSBNR/L HSDNN

Hook lever type



Approach angle		Designation		Dimension (mm)					Insert
				h	b	l1	l2	f	
75°	✓	HSBNR/L	2020 K0904	20	20	125	23	18.5	SN... 0904...
			2525 M0904	25	25	150	23	23.5	
	✳	HSBNR/L	2525 M1507	25	25	150	34	22	SNMX 1507...
			3232 P1507	32	32	170	34	27	
45°	✓	HSDNN	2020 K0904	20	20	125	25	10	SN... 0904...
			2525 M0904	25	25	150	25	12.5	
	✳	HSDNN	2525 M1507	25	25	150	34	12.5	SNMX 1507...
			3232 P1507	32	32	170	34	16	

A263-A267

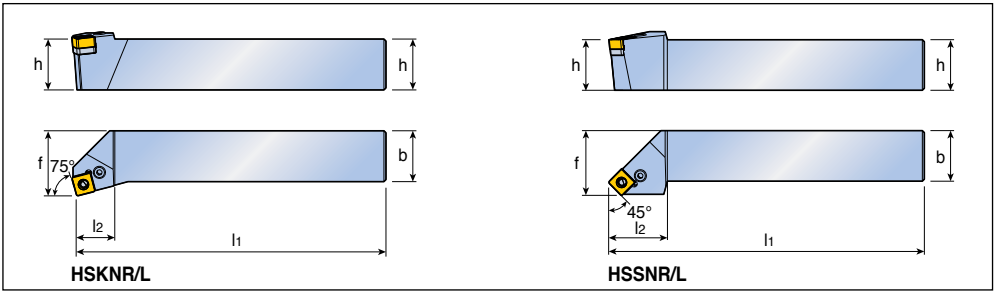
• ✓ Marked: For RHINORUSH insert ✳ Marked: For TURNRUSH insert

Spare parts

Designation	Lever	Screw	Shim		Shim Ppin	Shim pin punch	Wrench	
...0904	LCL 09-NX	LCS 3	LSS 32A	LSP 3A	LSP 3A	-	L-W 2.5	
...1507	LCL 16-NX	LCS 5-L25.5	-	LSS 54-NX	LSP 5	SPP 5-6	L-W 3	

HSKNR/L HSSNR/L

Hook lever type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
75°	✓ HSKNR/L	2020 K0904	20	20	125	19	25	SN... 0904...
		2525 M0904	25	25	150	19	32	
	✳ HSKNR/L	2525 M1507	25	25	150	28	32	SNMX 1507...
		3232 P1507	32	32	170	32	40	
45°	✓ HSSNR/L	2020 K0904	20	20	125	21.5	25	SN... 0904...
		2525 M0904	25	25	150	29	32	

A263-A267

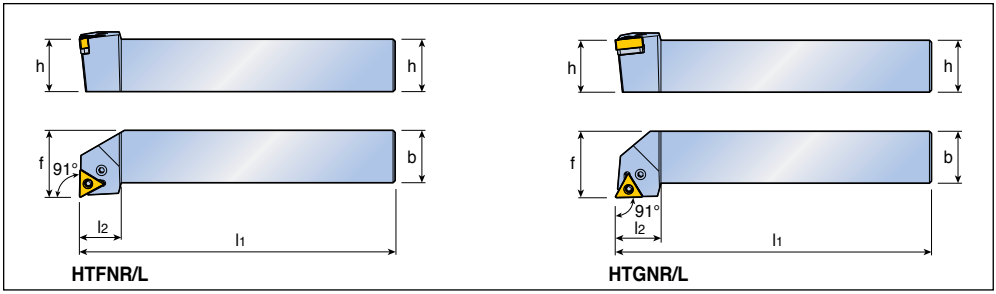
• ✓ Marked: For RHINORUSH insert ✳ Marked: For TURNRUSH insert

Spare parts

Designation	Lever	Screw	Shim		Shim pin	Shim pin punch	Wrench	
...0904	LCL 09-NX	LCS 3	LSS 32A	-	LSP 3A	-	L-W 2.5	
...1507	LCL 16-NX	LCS 5-L25.5	-	LSS 54-NX	LSP 5	SPP 5-6	L-W 3	

HTFNR/L HTGNR/L

Hook lever type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
91°	✓ HTFNR/L	2020 K1304	20	20	125	20	25	TN... 1304... A268-A273
		2525 M1304	25	25	150	20	32	
91°	✓ HTGNR/L	1616 H1304	16	16	100	22	20	
		2020 H1304	20	20	100	22	25	
		2020 K1304	20	20	125	22	25	
		2525 M1304	25	25	150	22	32	

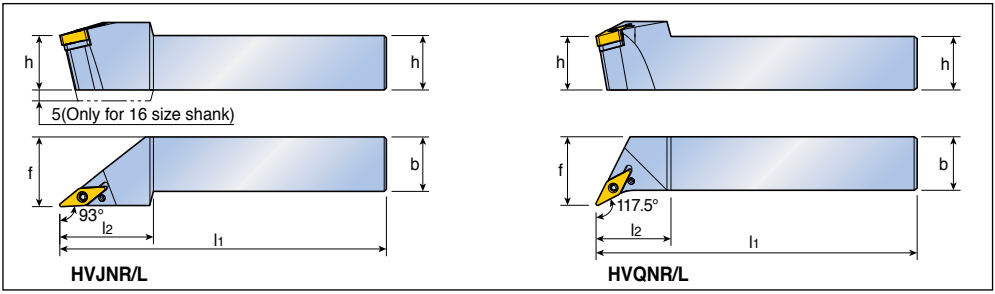
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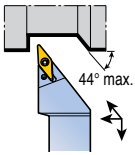
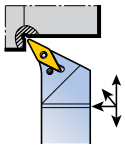
Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
...1304	LCL 08-NX	LCS 3-NX	LST 2.51.8	LSP 3B	L-W 2.5			

HVJNR/L HVQNR/L

Hook lever type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
93°	✓ **HVJNR/L**	**1616 H1304**	16	16	100	30	20	VN...X 1304....
		**2020 K1304**	20	20	125	35	25	YNMG 1304.... A274, A276, A281
		2525 M1304	25	25	150	43	32	
117.5°	✓ **HVQNR/L**	**2020 K1304**	20	20	125	35	25	
		**2525 M1304**	25	25	150	35	32	

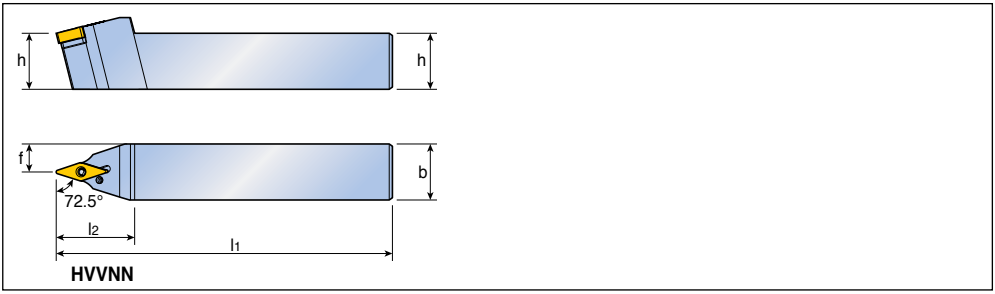
• ✓ Marked: For RHINORUSH insert

Spare parts

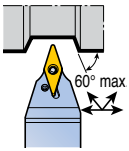
Designation	Lever	Screw	Shim	Shim pin	Wrench			
								
...1304	LCL 08-NX	LCS 4-DH	LSV 2.51.8H	LSP 3B	L-W 2.5			

HVVNN

Hook lever type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
72.5°	✓ **HVVNN**	**2020 K1304**	20	20	125	35	10	VN...X 1304...
		2525 M1304	25	25	150	35	12.5	YNMG 1304.... A274, A276, A281



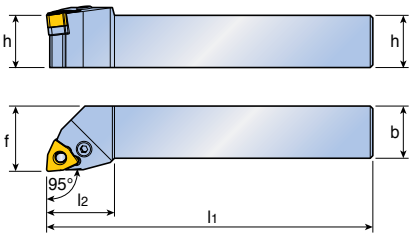
• ✓ Marked: For RHINORUSH insert

Spare parts

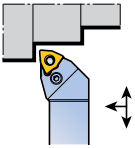
Designation	Lever	Screw	Shim	Shim pin	Wrench			
...1304	LCL 08-NX	LCS 4-DH	LSV 2.51.8H	LSP 3B	L-W 2.5			

HWLNR/L

Hook lever type



HWLNR/L

Approach angle	Designation	Dimension (mm)					Insert
		h	b	l_1	l_2	f	
95°	✓ **HWLNR/L 1616 H0604**	16	16	100	26	20	WN...X 0604... A279-A280
	**2020 K0604**	20	20	125	26	25	
	2525 M0604	25	25	150	26	32	

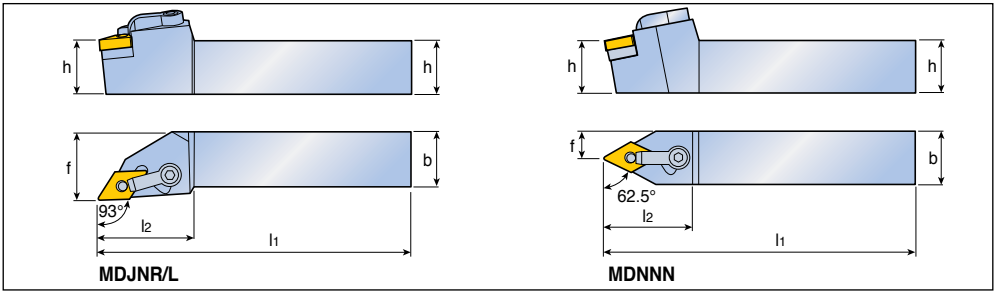
• ✓ Marked: For RHINORUSH insert

Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
								
...0604	LCL 09-NX	LCS 3	LSW 32A	LSP 3A	L-W 2.5			

MDJNR/L MDNNN

Multi lock type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
93°	**MDJNR/L**	**2020 K15**	20	20	125	45	25	DN... 1504...
		2525 M15	25	25	150	45	32	
		2020 K15A	20	20	125	45	25	DN... 1506...
		2525 M15A	25	25	150	45	32	
		3232 P15A	32	32	170	45	40	
62.5°	**MDNNN**	**2525 M15**	25	25	150	45	12.5	DN... 1504...
		3225 P15	32	25	170	45	12.5	
		2525 M15A	25	25	150	45	12.5	DN... 1506...

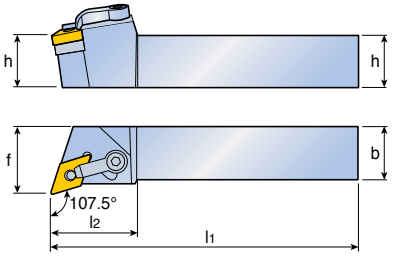
A253-A257, A316, A329

Spare parts

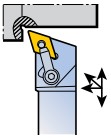
Designation	Clamp	Screw	Shim	Lock pin	Wrench			
...15	CLM 30	XNSM 0825	S 45	MLP 4	L-W 2.5, L-W 4			
...15A	CLM 30	XNSM 0825	MSD 43	MLP 4-06	L-W 2.5, L-W 4			

MDQNR/L

Multi lock type



MDQNR/L

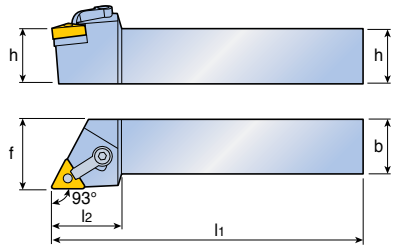
Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l1	l2	f		
107.5°	MDQNR/L	2020 K15	20	20	125	40	25	DN... 1504...	A253-A257, A316, A329
		2525 M15	25	25	150	40	32		
		2525 M15A	25	25	150	40	32	DN... 1506...	

Spare parts

Designation	Clamp	Screw	Shim	Lock pin	Wrench			
								
...15	CLM 30	XNSM 0825	S 45	MLP 4	L-W 2.5, L-W 4			
...15A	CLM 30	XNSM 0825	MSD 43	MLP 4-06	L-W 2.5, L-W 4			

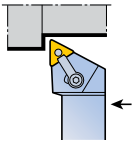
MTJNR/L

Multi lock type



MTJNR/L

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
93°	MTJNR/L	2020 K16	20	20	125	28	25	TN...1603...
		2525 M16	25	25	150	28	32	
		2525 M1604	25	25	150	28	32	TN...1604...



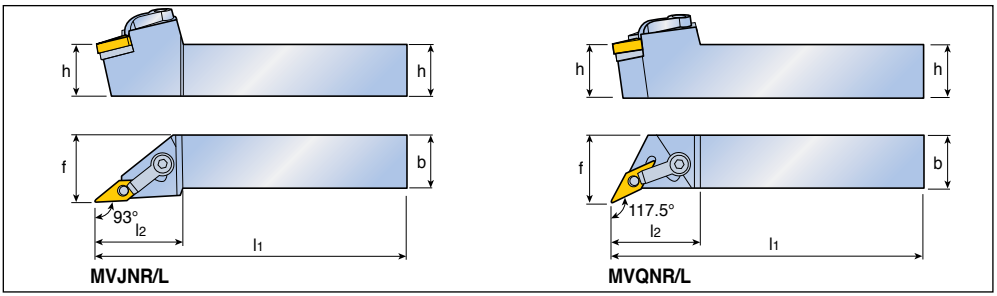
A268-A273, A322, A332

Spare parts

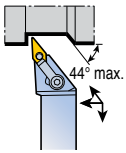
Designation	Clamp	Screw	Shim	Lock pin	Wrench			
...16	CLM 6	XNSM 0520	S 3	MLP 3	L-W 2, L-W 2.5			
...1604	CLM 6	XNSM 0520	S 31	MLP 3	L-W 2, L-W 2.5			

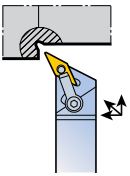
MVJNR/L MVQNR/L

Multi lock type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
93°	**MVJNR/L**	**2020 K16**	20	20	125	42	25	VN... 1604... A274-A275, A323, A333
		2525 M16	25	25	150	42	32	
		3225 P16	32	25	170	42	32	
		3232 P16	32	32	170	42	40	
117.5°	**MVQNR/L**	**2020 K16**	20	20	125	42	25	
		2525 M16	25	25	150	42	32	
		3232 P16	32	32	170	42	40	



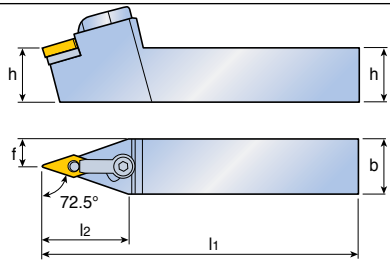


Spare parts

Designation	Clamp	Screw	Shim	Lock pin	Wrench			
								
...16	CLM 30	XNSM 0825	IVSN 324	MLP 3	L-W 2, L-W 4			

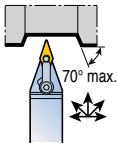
MVVNN

Multi lock type



MVVNN

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
72.5°	**MVVNN**	**2020 K16**	20	20	125	46	10.0	VN... 1604... A274-A275, A323, A333
		2525 M16	25	25	150	46	12.5	

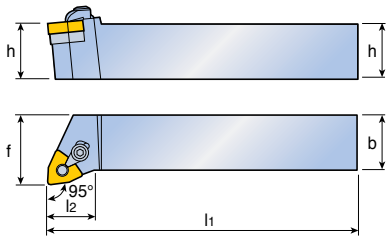


Spare parts

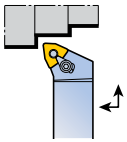
Designation	Clamp	Screw	Shim	Lock pin	Wrench			
...16	CLM 30	XNSM 0825	IVSN 324	MLP 3	L-W 2, L-W 4			

MWLNR/L

Multi lock type



MWLNR/L

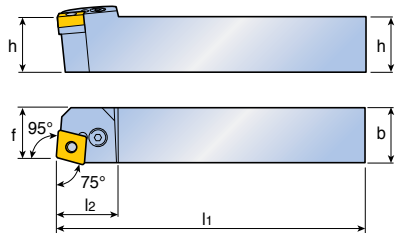
Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l_1	l_2	f		
95°	MWLNR/L	**1616 H06**	16	16	100	19.4	16	WN...0604...	A277-A279, A323-A324
		**2020 K08**	20	20	125	25	25	WN...0804...	
		2525 M08	25	25	150	25	32		

Spare parts

Designation	Clamp	Screw	Shim	Lock pin	Snap ring	Wrench		
								
...06	CL 2	CLS 2	MSW 32	MLP 3	CSR 2	L-W 2, L-W 2.5		
...08	CL 2	CLS 2	MSW 43	MLP 4	CSR 2	L-W 2.5		

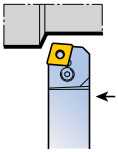
PCBNR/L

Lever lock type



PCBNR/L

Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l1	l2	f		
75°	PCBNR/L	2020 K12	20	20	125	28	17.5	CN... 1204...	A244-A252, A314-A315, A328
		2525 M12	25	25	150	28	22.5		
		3225 P12	32	25	170	28	22.5		
		2525 M16	25	25	150	32	22	CN... 1606...	
		3232 P16	32	32	170	32	27		
		3232 P1906D	32	32	170	37	27	CN... 1906...	
		4040 S1906D	40	40	250	37	37		
		4040 S2509D	40	40	250	50	37	CN... 2509...	
		5050 T2509D	50	50	300	50	47		



• CNMD, CNMM, CNMG type insert can be mounted on "-D" holder

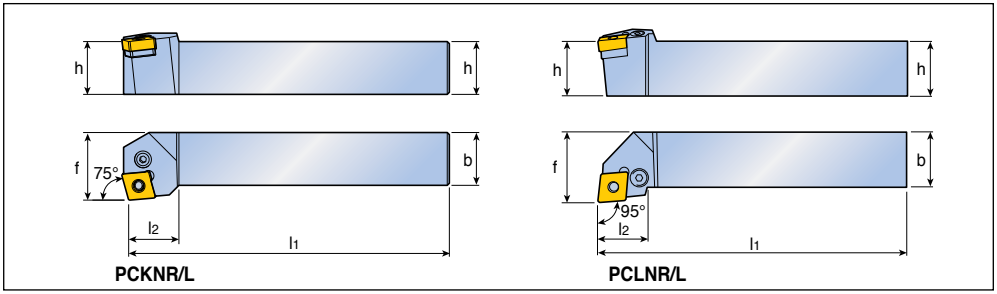
Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
								
...12	LCL 4	LCS 4	LSC 42	LSP 4	L-W 3			
...16	LCL 5	LCS 5	LSC 53	LSP 5	L-W 3			
...1906	LCL 6D	LCS 25C	LSC 64D	LSP 6	L-W 4			
...2509	LCL 8	LCS 8	LSC 84D	LSP 8	L-W 5			

• LSC 85D Shim can be used for CN...2507... insert

PCKNR/L PCLNR/L

Lever lock type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
75°	PCKNR/L	2020 K12	20	20	125	27	25	CN... 1204... A244-A252, A314-A315, A328
		2525 M12	25	25	150	24	32	
95°	PCLNR/L	1616 H12	16	16	100	27	20	CN... 1204...
		2020 K12	20	20	125	27	25	
		2525 M12	25	25	150	27	32	
		3225 P12	32	25	170	27	32	
		3232 P12	32	32	170	27	40	
		2525 M16	25	25	150	33	32	CN... 1606...
		3225 P16	32	25	170	33	32	
		3232 P16	32	32	170	33	40	
		2525 M1906D	25	25	150	38	32	CN... 1906...
		3225 P1906D	32	25	170	38	32	
		3232 P1906D	32	32	170	38	40	
		4040 S1906D	40	40	250	38	50	
		4040 S2509D	40	40	250	47	50	CN... 2509...
		5050 T2509D	50	50	300	47	60	

• CNMD, CNMM, CNMG type insert can be mounted on "-D" holder

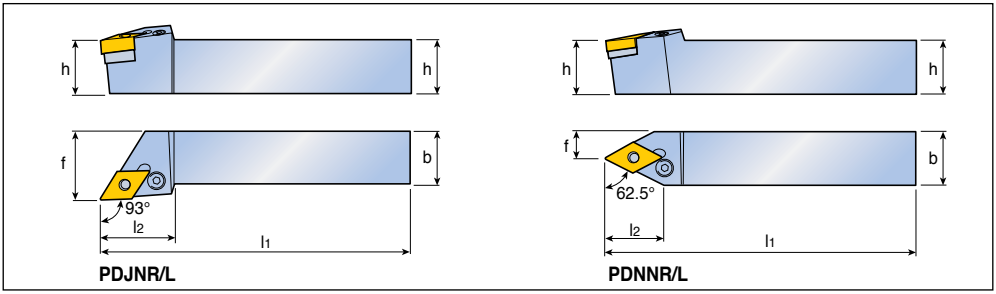
Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
1616...12	LCL 4	LCS 4S	LSC 42	LSP 4	L-W 3			
...12	LCL 4	LCS 4	LSC 42	LSP 4	L-W 3			
...16	LCL 5	LCS 5	LSC 53	LSP 5	L-W 3			
...1906	LCL 6D	LCS 25C	LSC 64D	LSP 6	L-W 4			
...2509	LCL 8	LCS 8	LSC 84D	LSP 8	L-W 5			

• LSC 85D Shim can be used for CN...2507... insert

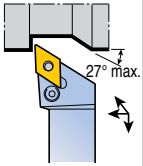
PDJNR/L PDNNR/L

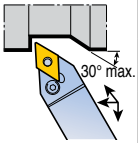
Lever lock type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
93°	PDJNR/L	1616 H11	16	16	100	30	20	DN... 1104...
		2020 K11	20	20	125	30	25	
		2525 M11	25	25	150	30	32	
		2020 K15	20	20	125	34	25	DN... 1506...
		2525 M15	25	25	150	34	32	
		3225 P15	32	25	170	34	32	
		3232 P15	32	32	170	34	40	
		2020 K15A	20	20	125	34	25	DN... 1504...
		2525 M15A	25	25	150	34	32	
62.5°	PDNNR/L	2020 K15	20	20	125	36.5	10	DN... 1506...
		2525 M15	25	25	150	36.5	12	
		3232 P15	32	32	170	36.5	16.8	

A253-A257, A316, A329



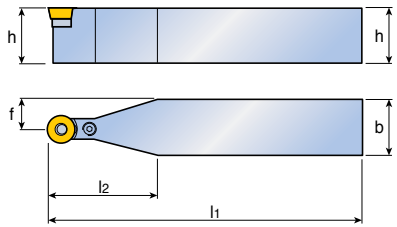


Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
...11	LCL 12C	LCS 3	LSD 32	LSP 3A	L-W 2.5			
...15	LCL 4A	LCS 4	LSD 42	LSP 4	L-W 3			

PRDCN

Lever lock type



PRDCN

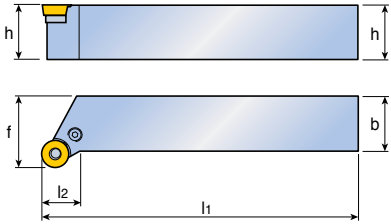
Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l1	l2	f		
45°	PRDCN	2020 M10	20	20	150	50	10.0	RC...X 100300	A290
		2525 M10	25	25	150	50	12.5		
		2020 K12	20	20	125	50	10.0	RC...X 120400	
		2525 M12	25	25	150	50	12.5		
		3225 Q12	32	25	180	50	12.5		
		2525 Q16	25	25	180	50	12.5	RC...X 160600	
		3225 Q16	32	25	180	50	12.5		
		3232 Q16	32	32	180	50	16.0		
		3232 S20	32	32	250	60	16.0	RC...X 200600	
		4040 S20	40	40	250	70	20.0		
		4040 S25	40	40	250	80	20.0	RC...X 250700	
		4040 T25	40	40	300	80	20.0		
		5050 U32	50	50	350	90	25.0	RC...X 320900	

Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
...10	LCL 10C	LCS 2	LSR 32	LSP 3A	L-W 2			
...12	LCL 12C	LCS 3	LSR 1203	LSP 3A	L-W 2.5			
...16	LCL 16C	LCS 16C	LSR 1604	LSP 16C	L-W 2.5			
...20	LCL 20C	LCS 5	LSR 2004	LSP 5	L-W 3			
...25	LCL 25C	LCS 25C	LSR 2506	LSP 6	L-W 4			
...32	LCL 32C	LCS 8	LSR 3206	LSP 8	L-W 5			

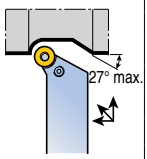
PRGCR/L

Lever lock type



PRGCR/L

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
90°	PRGCR/L	2020 K10	20	20	125	14.5	25	RC...X 100300
		2525 M10	25	25	150	17.5	32	
		3225 P10	32	25	170	17	32	
		2020 K12	20	20	125	18	25	RC...X 120400
		2525 M12	25	25	150	18	32	
		3225 P12	32	25	170	18	32	
		2525 M16	25	25	150	23	32	RC...X 160600
		3225 P16	32	25	170	23	32	
		3232 P16	32	32	170	23	40	
		4040 P16	40	40	170	23	50	
		3232 P20	32	32	170	27.5	40	RC...X 200600
		4040 S25	40	40	250	33.5	50	RC...X 250700
		4040 S32	40	40	250	41	50	RC...X 320900



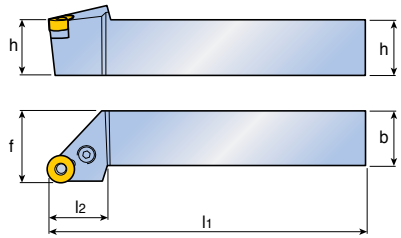
A290

Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
...10	LCL 10C	LCS 2	LSR 32	LSP 3A	L-W 2			
...12	LCL 12C	LCS 3	LSR 1203	LSP 3A	L-W 2.5			
...16	LCL 16C	LCS 16C	LSR 1604	LSP 16C	L-W 2.5			
...20	LCL 20C	LCS 5	LSR 2004	LSP 5	L-W 3			
...25	LCL 25C	LCS 25C	LSR 2506	LSP 6	L-W 4			
...32	LCL 32C	LCS 8	LSR 3206	LSP 8	L-W 5			

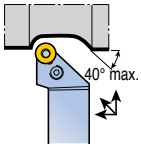
PRGNR/L

Lever lock type



PRGNR/L

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
90°	**PRGNR/L**	**2020 K09**	20	20	125	22	25	RNMG 090300
		2525 M12	25	25	150	28	32	RNMG 120400
		3225 P15	32	25	170	35	32	RNMG 150600
		3232 P19	32	32	170	38	40	RNMG 190600



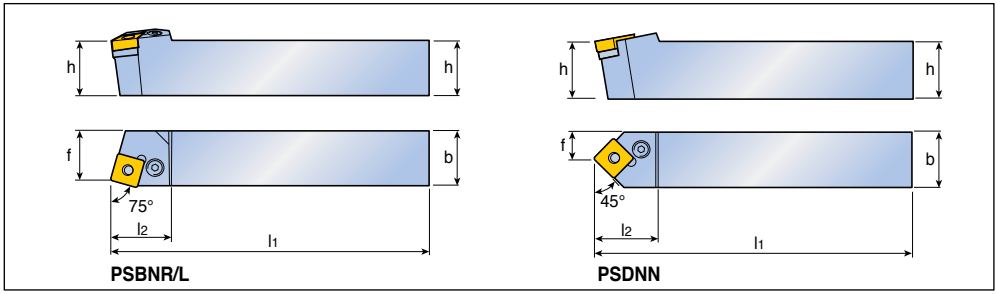
A260

Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
								
...09	LCL 3	LCS 3	LSR 32	LSP 3A	L-W 2.5			
...12	LCL 4	LCS 4	LSR 42	LSP 4	L-W 3			
...15	LCL 5	LCS 5	LSR 53	LSP 5	L-W 3			
...19	LCL 6D	LCS 6	LSR 63	LSP 6	L-W 4			

PSBNR/L PSDNN

Lever lock type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
75°	PSBNR/L	2020 K12	20	20	125	28	17	SN... 1204...
		2525 M12	25	25	150	28	22	
		3225 P12	32	25	170	28	22	
		2525 M15	25	25	150	34	22	SN... 1506...
		3232 P1906D	32	32	170	39	27	SN... 1906...
		4040 S1906D	40	40	250	39	35	
		4040 S2509D	40	40	250	48	35	SN... 2509...
		5050 T2509D	50	50	300	48	43	
45°	PSDNN	2020 K12	20	20	125	28	10.0	SN... 1204...
		2525 M12	25	25	150	28	12.5	
		3225 P12	32	25	170	28	12.5	
		2020 K15	20	20	125	34	10.0	SN... 1506...
		2525 M15	25	25	150	34	12.5	
		3225 P1906D	32	25	170	40.5	12.5	SN... 1906...
		3232 P1906D	32	32	170	40.5	16.0	
		4040 S1906D	40	40	250	40.5	20.0	
		5050 S1906D	50	50	250	40.5	25.0	
		4040 S2509D	40	40	250	49	20.0	SN... 2509...
		5050 T2509D	50	50	300	49	25.0	

A261-A267, A319-A320, A331

• SNMD, SNMM, SNMG type insert can be mounted on "-D" holder

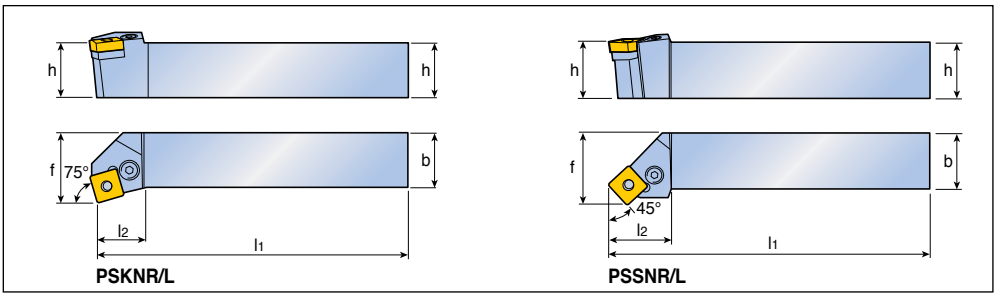
Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
...12	LCL 4	LCS 4	LSS 42	LSP 4	L-W 3			
...15	LCL 5	LCS 5	LSS 53	LSP 5	L-W 3			
...1906	LCL 6D	LCS 25C	LSS 64D	LSP 6	L-W 4			
...2509	LCL 8	LCS 8	LSS 84D	LSP 8	L-W 5			

• LSS 85D Shim can be used for SN... 2507... insert

PSKNR/L PSSNR/L

Lever lock type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l_1	l_2	f	
75°	PSKNR/L	**2020 K12**	20	20	125	25	25	SN... 1204...
		2525 M12	25	25	150	25	32	
		2525 M15	25	25	150	32	32	SN... 1506...
		3232 P15	32	32	170	32	40	
		3232 P1906D	32	32	170	38	40	SN... 1906...
		4040 S1906D	40	40	250	38	50	
		4040 S2509D	40	40	250	42	50	SN... 2509...
		5050 T2509D	50	50	300	42	60	
45°	PSSNR/L	**2020 K12**	20	20	125	30	25	SN... 1204...
		2525 K12	25	25	125	30	32	
		2525 M12	25	25	150	30	32	
		3225 P12	32	25	170	30	32	
		3232 P12	32	32	170	32	40	
		3232 P15	32	32	170	37	40	SN... 1506...
		3232 P1906D	32	32	170	42	40	SN... 1906...
		4040 S1906D	40	40	250	42	50	
		4040 S2509D	40	40	250	53	50	SN... 2509...

A261-A267, A319-A320, A331

• SNMD, SNMM, SNMG type insert can be mounted on "-D" holder

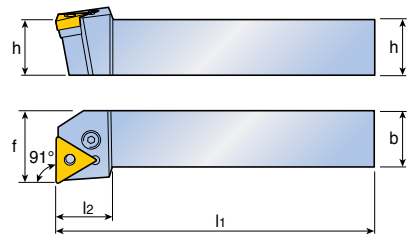
Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
...12	LCL 4	LCS 4	LSS 42	LSP 4	L-W 3			
...15	LCL 5	LCS 5	LSS 53	LSP 5	L-W 3			
...1906	LCL 6D	LCS 25C	LSS 64D	LSP 6	L-W 4			
...2509	LCL 8	LCS 8	LSS 84D	LSP 8	L-W 5			

• LSS 85D Shim can be used for SN... 2507... insert

PTFNR/L

Lever lock type



PTFNR/L

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
91°	PTFNR/L	1616 H16	16	16	100	20	20	TN... 1604...
		2020 K16	20	20	125	20	25	
		2525 M16	25	25	150	20	32	
		2525 M22	25	25	150	25	32	TN... 2204...
		3232 P22	32	32	170	25	40	
		4040 S27	40	40	250	33	50	TN... 2706...

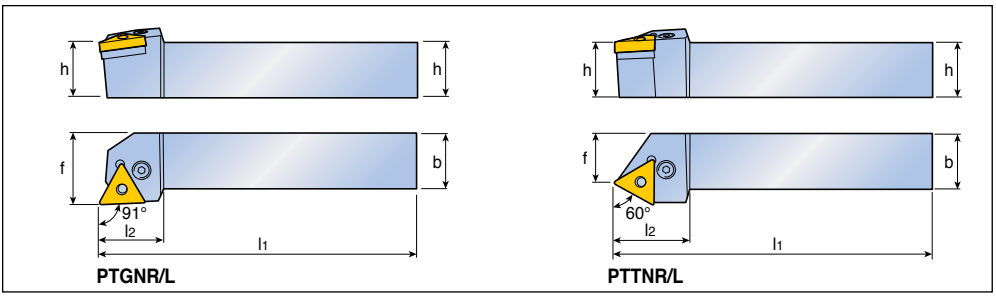
A268-A273, A322, A332

Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
...16	LCL 3	LCS 3	LST 31.8	LSP 3A	L-W 2.5			
...22	LCL 4	LCS 4	LST 42	LSP 4	L-W 3			
...27	LCL 5	LCS 5	LST 53	LSP 5	L-W 3			

PTGNR/L PTTNR/L

Lever lock type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
91°	PTGNR/L	1010 E11	10	10	70	15	12	TN... 1103...
		1212 F11	12	12	80	15	16	A268-A273, A322, A332
		2525 M11	25	25	150	30	32	
		1616 H16	16	16	100	22	20	TN... 1604...
		2020 K16	20	20	125	22	25	
		2525 M16	25	25	150	22	32	
		3225 P16	32	25	170	22	32	
		3232 P16	32	32	170	22	40	
		2525 M22	25	25	150	29	32	TN... 2204...
		3225 P22	32	25	170	29	32	
		3232 P22	32	32	170	29	40	
		4040 S27	40	40	250	35	50	TN... 2706...
60°	PTTNR/L	1616 H16	16	16	100	24	13	TN... 1604...
		2020 K16	20	20	125	24	17	
		2525 M16	25	25	150	24	22	
		2525 M22	25	25	150	34	22	TN... 2204...

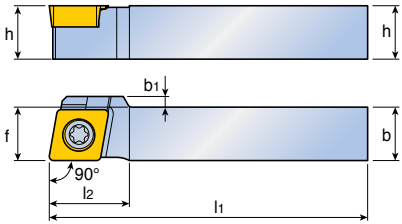
Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
...11	LCL 2B	LCS 2B	-	*LSR 2B	L-W 2			
...16	LCL 3	LCS 3	LST 31.8	LSP 3A	L-W 2.5			
...22	LCL 4	LCS 4	LST 42	LSP 4	L-W 3			
...27	LCL 5	LCS 5	LST 53	LSP 5	L-W 4			

• *Marked: LSR 2B is snap ring

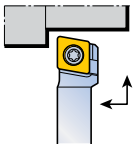
SCACR/L-SH

Screw type



SCACR/L-SH

Approach angle	Designation		Dimension (mm)						Insert
			h	b	l1	l2	f	b1	
90°	#	SCACR/L 0808 K06-SH	8	8	125	8	8	-	CC...T 0602...
		1010 K06-SH	10	10	125	10	10	-	A282-A284, A335
		1010 K09-SH	10	10	125	15	10	2	CC...T 09T3...
		1212 K09-SH	12	12	125	15	12	-	
		1616 K09-SH	16	16	125	16	16	-	



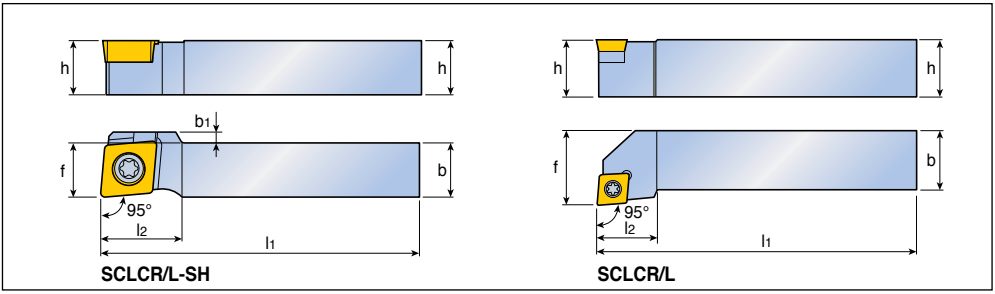
• # Marked: For TOPMINI insert

Spare parts

Designation	Screw	Wrench						
								
...06	SO 25065I	T 7						
...09	SO 35080I	T 15						

SCLCR/L-SH SCLCR/L

Screw type



Approach angle	Designation		Dimension (mm)						Insert
			h	b	l1	l2	f	b1	
95°	# SCLCR/L	0808 K06-SH	8	8	125	8	8	-	CC...T 0602...
		1010 K06-SH	10	10	125	10	10	-	
		1010 K09-SH	10	10	125	15	10	2	CC...T 09T3...
		1212 K09-SH	12	12	125	15	12	-	
		1616 K09-SH	16	16	125	16	16	-	
95°	# SCLCR/L	0808 F06	8	8	80	10	10	-	CC...T 0602...
		1010 F06	10	10	80	10	12	-	
		1212 F09	12	12	80	16	16	-	CC...T 09T3...
		1616 H09	16	16	100	16	20	-	
		2020 K09	20	20	125	20	25	-	
		2525 M09	25	25	150	20	32	-	
		2020 K12	20	20	125	25	25	-	CC...T 1204...
		2525 M12	25	25	150	26	32	-	

A282-A284, A335

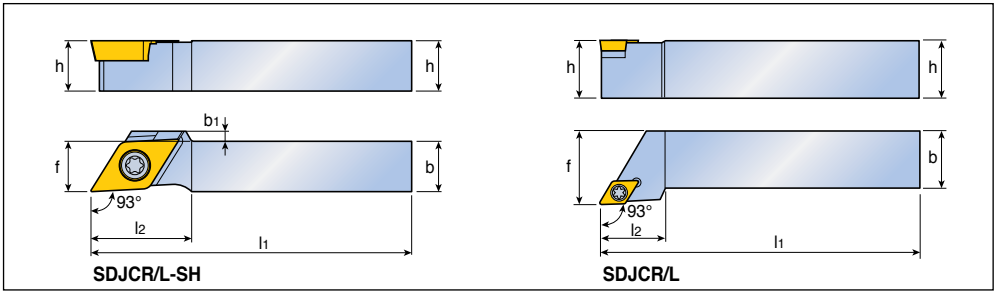
• # Marked: For TOPMINI insert

Spare parts

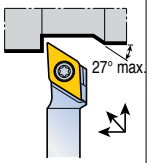
Designation	Screw	Shim	Shim screw	Wrench				
...06	SO 25065I	-	-	T 7				
...09-SH	SO 35080I	-	-	T 15				
...F09	SO 35080I	-	-	T 15				
...09	SO 35124I	SSC 32	SO 50090S	T 15				
...12	SO 45130I	SSC 43N	SO 60105S	T 20				

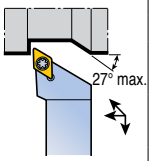
SDJCR/L-SH SDJCR/L

Screw type



Approach angle		Designation	Dimension (mm)						Insert	
			h	b	l1	l2	f	b1		
93°	#	SDJCR/L 0808 K07-SH	8	8	125	12.7	8	-	DC...T 0702...	A286-A288, A336
		1010 K07-SH	10	10	125	15	10	-		
		1010 K11-SH	10	10	125	20	10	2	DC...T 11T3...	
		1212 K11-SH	12	12	125	20	12	-		
		1616 K11-SH	16	16	125	20	16	-		
93°		SDJCR/L 0808 E07	8	8	70	13	10	-	DC...T 0702...	
		1212 F07	12	12	80	15	16	-		
		1616 H07	16	16	100	15	20	-		
		2020 K07	20	20	125	20	25	-		
		1616 H11	16	16	100	24	20	-	DC...T 11T3...	
		2020 K11	20	20	125	24	25	-		
		2525 M11	25	25	150	28	32	-		





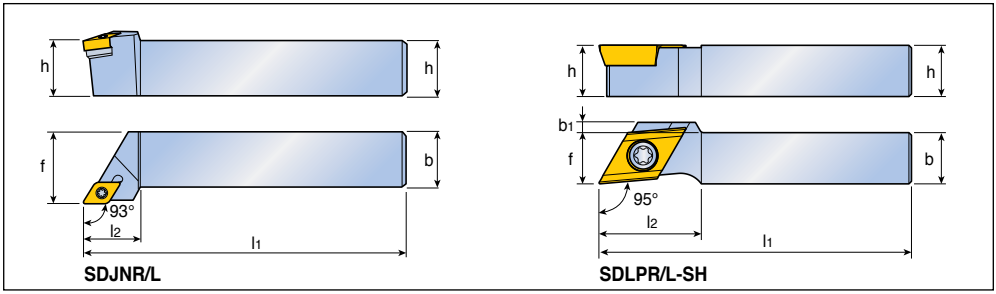
• # Marked: For TOPMINI insert

Spare parts

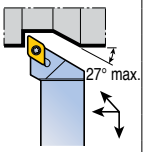
Designation	Screw	Shim	Shim screw	Wrench				
...07	SO 25065I	-	-	T 7				
...11-SH	SO 35080I	-	-	T 15				
...11	SO 35124I	SSD 32	SO 50090S	T 15				

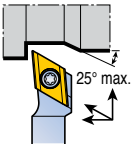
SDJNR/L SDLPR/L-SH

Screw type



Approach angle	Designation		Dimension (mm)						Insert
			h	b	l1	l2	f	b1	
93°	**SDJNR/L**	**1616 H11**	16	16	100	25	20	-	DN... 1104... A253-A257, A289
		2020 K11	20	20	125	25	25	-	
		2525 M11	25	25	150	25	32	-	
95°	# **SDLPR/L**	**0808 K07-SH**	8	8	125	12.7	8	-	DP...T 0702...
		1010 K07-SH	10	10	125	15	10	-	
		1010 K11-SH	10	10	125	20	10	2	DP...T 11T3...
		1212 K11-SH	12	12	125	20	12	-	
		1616 K11-SH	16	16	125	20	16	-	





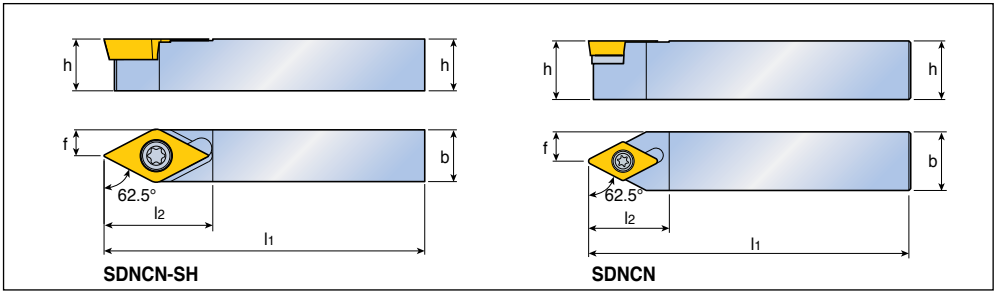
• # Marked: For TOPMINI insert

Spare parts

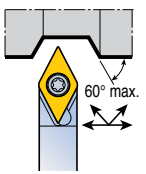
Designation	Screw	Shim	Shim screw	Wrench				
...07-SH	SO 25065I	-	-	T 7				
...11-SH	SO 35080I	-	-	T 15				
...11	SO 35120I	SSD 32	SO 50090S	T 10				

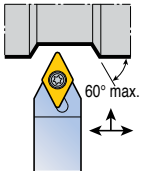
SDNCN-SH SDNCN

Screw type



Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l1	l2	f		
62.5°	# SDNCN	0808 K07-SH	8	8	125	15	4	DC...T 0702...	A286-A288, A336
		1010 K07-SH	10	10	125	15	5		
		1010 K11-SH	10	10	125	22	5	DC...T 11T3...	
		1212 K11-SH	12	12	125	22	6		
		1616 K11-SH	16	16	125	22	8		
62.5°	SDNCN	0808 F07	8	8	80	15	4	DC...T 0702...	
		1010 F07	10	10	80	15	5		
		1616 H11	16	16	100	22	8	DC...T 11T3...	
		2525 M11	25	25	150	22	12.5		





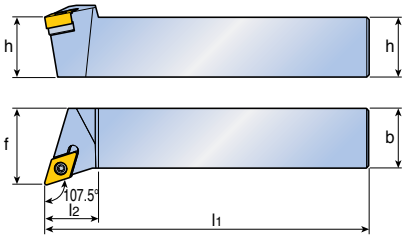
• # Marked: For TOPMINI insert

Spare parts

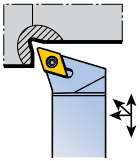
Designation	Screw	Shim	Shim screw	Wrench				
...07	SO 25065I	-	-	T 7				
...11-SH	SO 35080I	-	-	T 7				
...11	SO 35124I	SSD 32	SO 50090S	T 15				

SDQNR/L

Screw type



SDQNR/L

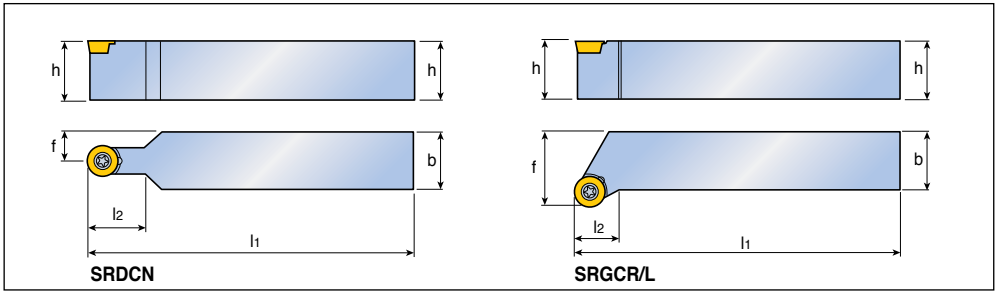
Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
107.5°	**SDQNR/L**	**1616 H11**	16	16	100	22	20	DN... 1104... A253-A257
		**2020 K11**	20	20	125	22	25	
		2525 M11	25	25	150	22	32	

Spare parts

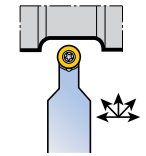
Designation	Screw	Shim	Shim screw	Wrench				
								
...11	SO 35120I	SSD 32	SO 50090S	T 10				

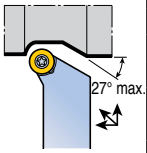
SRDCN SRGCR/L

Screw type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
45°	SRDCN	1616 H10	16	16	100	17.2	8	RC...T 10T3... A290
		2020 K10	20	20	125	22.5	10	
		2525 M10	25	25	150	27.5	12.5	
		2525 M12	25	25	150	27.5	12.5	RC...T 1204...
90°	SRGCR/L	1616 H10	16	16	100	16.7	20	RC...T 10T3...
		2020 K10	20	20	125	15	25	
		2525 M10	25	25	150	15	32	



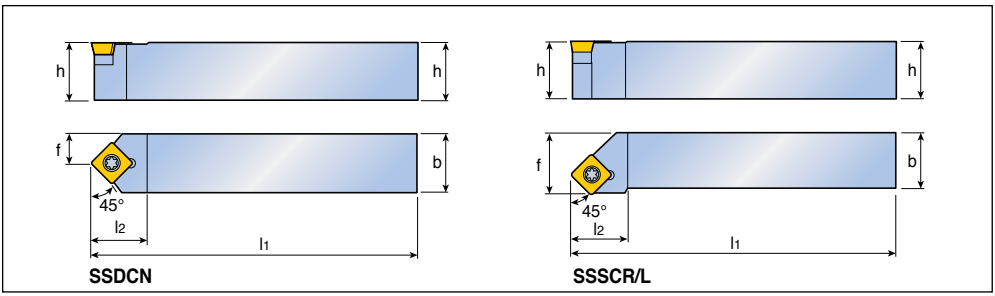


Spare parts

Designation	Screw	Wrench						
								
...10	TS 40097I	T 15						
...12	TS 40050I	T 15						

SSDCN SSSCR/L

Screw type



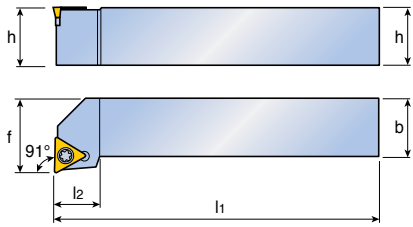
Approach angle	Designation		Dimension (mm) h	b	l1	l2	f	Insert
45°	SSDCN	1212 F09	12	12	80	15.5	6	SC...T 09T3... A291, A338
		1616 H09	16	16	100	15.5	8	
45°	SSSCR/L	1212 F09	12	12	80	15.5	14	SC...T 09T3...
		1616 H09	16	16	100	15.5	17	
		2020 K12	20	20	125	24	22	SC...T 1204...
		2525 M12	25	25	150	24	27	

Spare parts

Designation	Screw	Shim	Shim screw	Wrench
...F09	SO 35080I	-	-	T 15
...H09	SO 35124I	SSS 32	SO 50090S	T 15
...12	SO 45130I	SSS 43N	SO 60105S	T 20

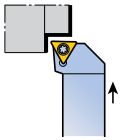
STFCR/L

Screw type



STFCR/L

Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l1	l2	f		
91°	# STFCR/L	1212 F11	12	12	80	14	16	TC...T 1102...	A294-A295, A339, A340
		1616 H11	16	16	100	14	20		
		1616 H16	16	16	100	19	20	TC...T 16T3...	
		2020 K16	20	20	125	19	25		
		2525 M16	25	25	150	20	32		



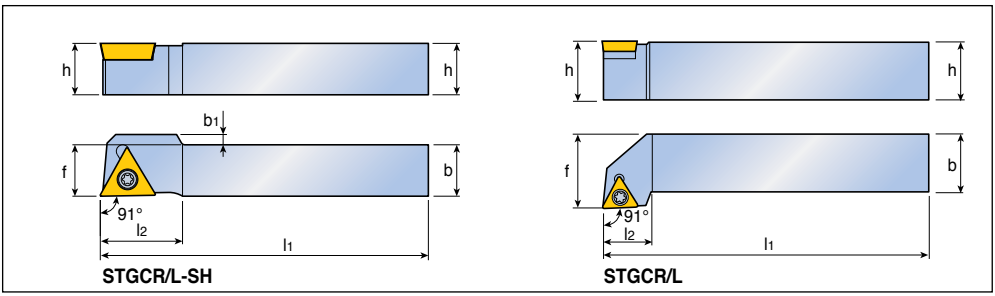
• # Marked: For TOPMINI insert

Spare parts

Designation	Screw	Shim	Shim screw	Wrench				
								
...11	SO 25065I	-	-	T 7				
...16	SO 35124I	SST 32	SO 50090S	T 15				

STGCR/L-SH STGCR/L

Screw type



Approach angle	Designation		Dimension (mm)						Insert	
			h	b	l1	l2	f	b1		
91°	# STGCR/L	0808 E08-SH	8	8	70	11	8	2	TC...T 0802...	A294-A295, A339, A340
		1010 F08-SH	10	10	80	11	10	-		
		1010 K11-SH	10	10	125	16	10	2	TC...T 1103...	
		1212 K11-SH	12	12	125	16	12	-		
		1616 K11-SH	16	16	125	16	16	-		
91°	STGCR/L	0808 E08	8	8	70	10	10	-	TC...T 0802...	
		1010 F08	10	10	80	10	12	-		
		1010 E09	10	10	70	11	12	-	TC...T 0902...	
		1212 F11	12	12	80	14.3	16	-	TC...T 1102...	
		1616 H11	16	16	100	14.3	20	-		
		1616 H16	16	16	100	21	20	-	TC...T 16T3...	
		2020 K16	20	20	125	21	25	-		
		2525 M16	25	25	150	21	32	-		

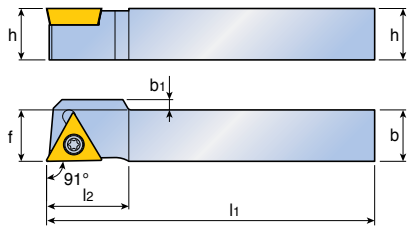
• # Marked: For TOPMINI insert

Spare parts

Designation	Screw	Shim	Shim screw	Wrench				
...08-SH	TS 20043I/HG-P	-	-	T 6P				
...09	SO 22050I	-	-	T 7				
...11-SH	SO 25065I	-	-	T 7				
...11	SO 25065I	-	-	T 7				
...16	SO 35124I	SST 32	SO 50090S	T 15				

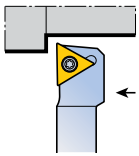
STGPR/L-SH

Screw type



STGPR/L-SH

Approach angle	Designation	Dimension (mm)						Insert	
		h	b	l1	l2	f	b1		
91°	# STGPR/L 0808 K08-SH	8	8	125	11	8	-	TP...T 0802...	A296-A298, A339
	1010 K08-SH	10	10	125	11	10	-		
	1010 K11-SH	10	10	125	16	10	2	TP...T 1103...	
	1212 K11-SH	12	12	125	16	12	-		
	1616 K11-SH	16	16	125	16	16	-		



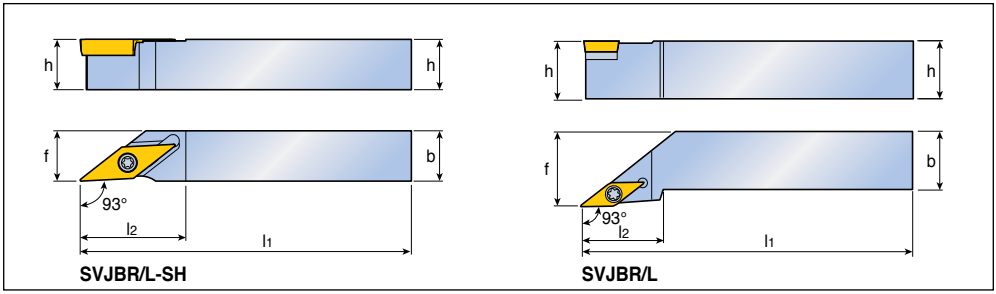
• # Marked: For TOPMINI insert

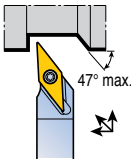
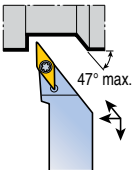
Spare parts

Designation	Screw	Wrench						
								
...08	TS 20043I/HG-P	T 6P						
...11	SO 25065I	T 7						

SVJBR/L-SH SVJBR/L

Screw type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
93°	# **SVJBR/L**	**1010 K11-SH**	10	10	125	21	10	VB...T 1103... A300-A301, A341
		**1212 K11-SH**	12	12	125	21	12	
		1616 K11-SH	16	16	125	21	16	
93°	**SVJBR/L**	**2020 K16**	20	20	125	35	25	VB...T 1604...
		**2525 M16**	25	25	150	35	32	
		3225 P16	32	25	170	35	32	
		3232 P16	32	32	170	35	40	

• # Marked: For TOPMINI insert

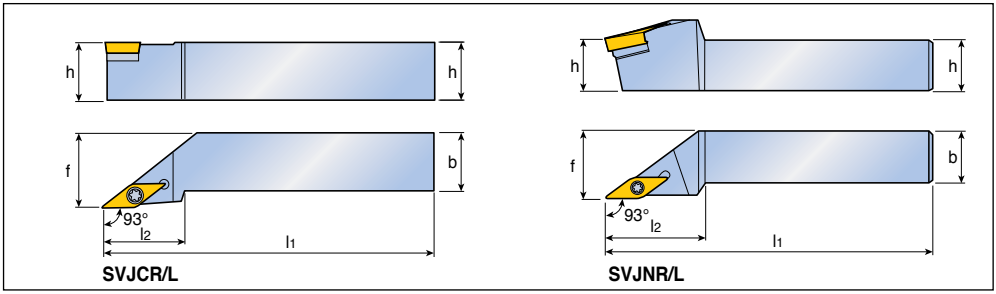
Spare parts

Designation	Screw	Shim	Shim screw	Wrench				
								
...11	SO 25065I	-	-	T 7				
...16	SO 35124I	SSV 32	SO 50090S	T 15				

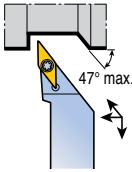
TaeguTec Member IMC Group

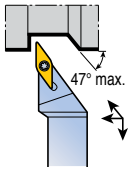
SVJCR/L SVJNR/L

Screw type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
93°	SVJCR/L	2020 K16	20	20	125	35	25	VC...T 1604... A302, A341
		2525 M16	25	25	150	35	32	
		3225 P16	32	25	170	35	32	
		3232 P16	32	32	170	47	40	
93°	SVJNR/L	1616 H13	16	16	100	30	20	VN... 1304... A274, A276, A281
		2020 K13	20	20	125	35	25	
		2525 M13	25	25	150	43	32	





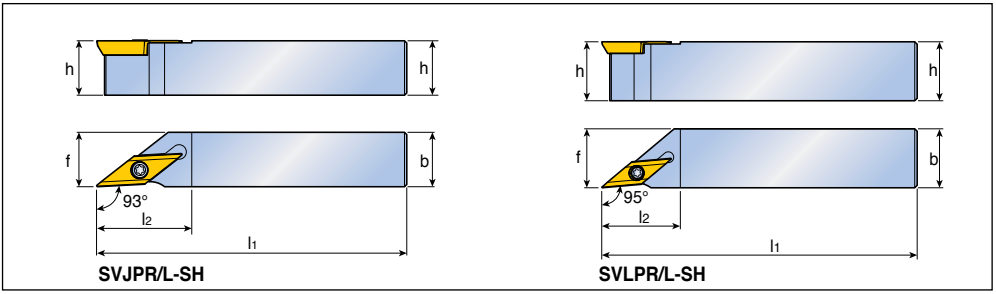
Spare parts

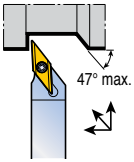
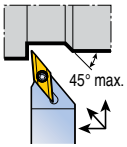
Designation	Screw	Shim	Shim screw	Wrench				
								
...13	SO 35120I	SSVN 2.522	SO 50090S	T 10				
...16	SO 35124I	SSV 32	SO 50090S	T 15				

TaeguTec

SVJPR/L-SH SVLPR/L-SH

Screw type



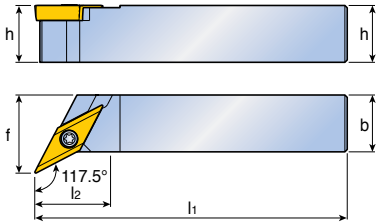
Approach angle	Designation		Dimension (mm)					Insert
			h	b	l_1	l_2	f	
93°	# **SVJPR/L**	**1212 K11-SH**	12	12	125	21	12	VP...T 1103... A303
		**1616 K11-SH**	16	16	125	21	12	
95°	# **SVLPR/L**	**1010 F08-SH**	10	10	80	16	10	VP...T 0802...
		**1212 F08-SH**	12	12	80	16	12	
		1616 F08-SH	16	16	80	16	16	
		1212 F11-SH	12	12	80	21	12	VP...T 1103...
		1616 F11-SH	16	16	80	21	16	

• # Marked: For TOPMINI insert

Spare parts

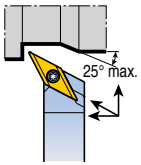
Designation	Screw	Wrench						
								
...08	TS 20043I	T 6P						
...11	SO 25065I	T 7						

Screw type



SVPBR/L

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
117.5	#	**SVPBR/L 1010 E11**	10	10	70	18	14.5	VB...T 1103... A300-A301, A341
		1212 F11	12	12	80	18	16.5	
		1616 F11	16	16	80	18	20.5	
		2020 K11	20	20	125	18	25	
		2525 M11	25	25	150	18	32	
		2020 K16	20	20	125	25	25	VB...T 1604...
		2525 M16	25	25	150	25	32	



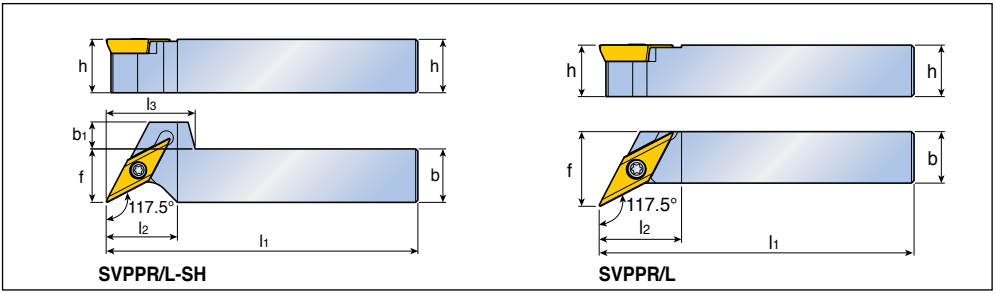
• # Marked: For TOPMINI insert

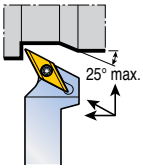
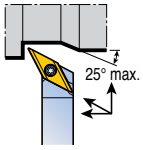
Spare parts

Designation	Screw	Shim	Shim screw	Wrench				
								
...11	SO 25065I	-	-	T 7	-			
...16	SO 35124I	SSV 32	SO 50090S	T 15	L-W 3.5			

SVPPR/L-SH SVPPR/L

Screw type



Approach angle	Designation		Dimension (mm)							Insert
			h	b	l1	l2	l3	f	b1	
117.5°	# **SVPPR/L**	**1010 K08-SH**	10	10	125	14	16	10	4	VP...T 0802... A303
		**1212 K08-SH**	12	12	125	14	-	12	-	
		1616 K08-SH	16	16	125	14	-	16	-	
		1010 K11-SH	10	10	125	16	20	10	8	VP...T 1103...
		1212 K11-SH	12	12	125	16	20	12	6	
		1616 K11-SH	16	16	125	16	-	16	-	
117.5°	**SVPPR/L**	**1010 F11**	10	10	80	16	-	14.5	-	
		**1212 H11**	12	12	100	16	-	14.5	-	

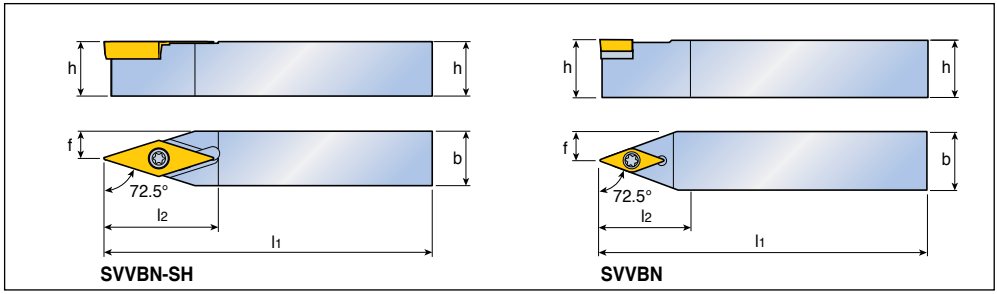
• # Marked: For TOPMINI insert

Spare parts

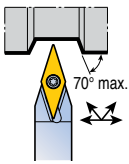
Designation	Screw	Wrench						
								
...08	TS 20043I/HG-P	T 6P						
...11	SO 25065I	T 7						

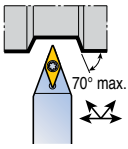
SVVBN-SH SVVBN

Screw type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
72.5°	# SVVBN	1010 K11-SH	10	10	125	22	5	VB...T 1103...
		1212 K11-SH	12	12	125	22	6	
		1616 K11-SH	16	16	125	22	8	
72.5°	SVVBN	2020 K16	20	20	125	31.5	10.0	VB...T 1604...
		2525 M16	25	25	150	31.5	12.5	
		3225 P16	32	25	170	31.5	12.5	





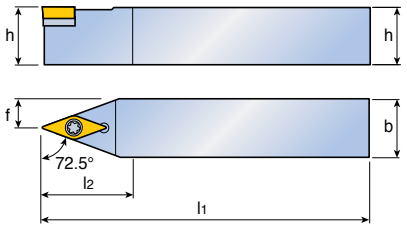
A300-A301, A341

• # Marked: For TOPMINI insert

Spare parts

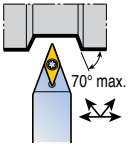
Designation	Screw	Shim	Shim screw	Wrench				
...11	SO 25065I	-	-	T 7				
...16	SO 35124I	SSV 32	SO 50090S	T 15				

Screw type



SVVCN

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
72.5°	**SVVCN**	**2020 K16**	20	20	125	31.5	10.0	VC...T 1604... A302, A341
		2525 M16	25	25	150	31.5	12.5	
		3225 P16	32	25	170	31.5	12.5	
		3232 P16	32	32	170	32	16.0	

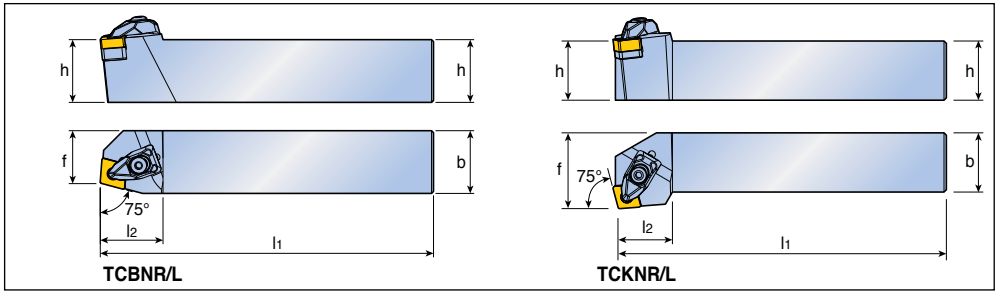


Spare parts

Designation	Screw	Shim	Shim screw	Wrench				
								
...16	SO 35124I	SSV 32	SO 50090S	T 15				

TCBNR/L TCKNR/L

T-holder type



Approach angle		Designation		Dimension (mm)					Insert	
				h	b	l1	l2	f		
75°	✓	TCBNR/L	2020 K0904	20	20	125	26	18.5	CN... 0904...	A244-A252, A314-A315, A328
			2525 M0904	25	25	150	26	23.5		
		TCBNR/L	2525 M12	25	25	150	32	22.5	CN... 1204...	
			3232 P19	32	32	170	42	27	CN... 1906...	
75°	✓	TCKNR/L	2525 M0904	25	25	150	23	32	CN... 0904...	
		TCKNR/L	2525 M12	25	25	150	25	32	CN... 1204...	

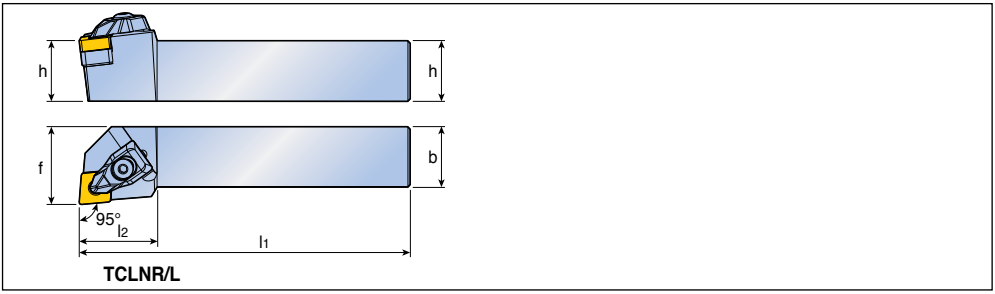
• ✓ Marked: For RHINORUSH insert

Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
...0904	DLM 3-NX	DLS 3	LSC 32A	SO 40085I	DSP 3	L-W 2.5	T 15	
...12	DLM 4	DLS 4	TSC 44	SO 40050I	DSP 4	L-W 3	T 15	
...19	DLM 6	DLS 5	LSC 63	SO 80180I	DSP 5	L-W 4	-	

TCLNR/L

T-holder type



Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l_1	l_2	f		
95°	✓ **TCLNR/L**	**2020 H0904**	20	20	100	25	25	CN... 0904...	A244-A252, A314-A315, A328
		2020 K0904	20	20	125	25	25		
		2525 M0904	25	25	150	25	32		
	TCLNR/L	**2020 K12**	20	20	125	32	25	CN... 1204...	
		2525 M12	25	25	150	32	32		
		3225 P12	32	25	170	32	32		
		3232 P12	32	32	170	32	40		
		2525 M16	25	25	150	36	32	CN... 1606...	
		3232 P16	32	32	170	36	40		
		3232 P19	32	32	170	42	40	CN... 1906...	
		4040 S19	40	40	250	42	50		

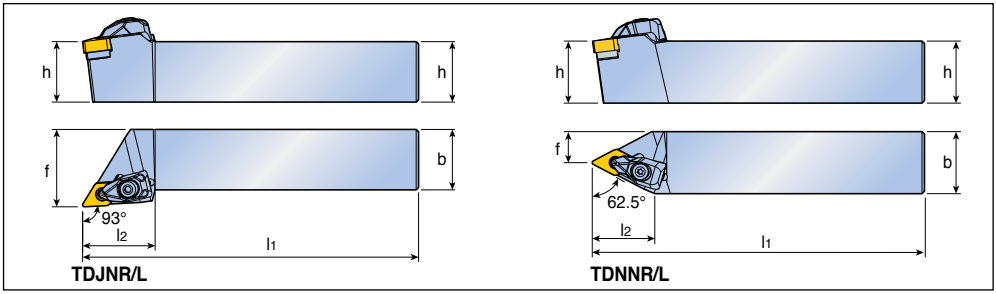
• ✓ Marked: For RHINORUSH insert

Spare parts

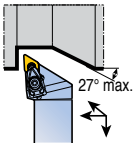
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
...0904	DLM 3-NX	DLS 3	LSC 32A	SO 40085I	DSP 3	L-W 2.5	T 15	
...12	DLM 4	DLS 4	TSC 44	SO 40050I	DSP 4	L-W 3	T 15	
...16	DLM 5	DLS 5	TSC 54	SO 50090I	DSP 5	L-W 4	T 20	
...19	DLM 6	DLS 5	LSC 63	SO 80180I	DSP 5	L-W 4	-	

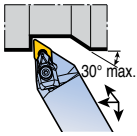
TDJNR/L TDNNR/L

T-holder type



Approach angle		Designation	Dimension (mm) h	b	l1	l2	f	Insert
93°		TDJNR/L 2020 K11	20	20	125	30	25	DN... 1104...
		2525 M11	25	25	150	30	32	
	✓	TDJNR/L 2020 H1305	20	20	100	33	25	DN... 1305...
		2020 K1305	20	20	125	33	25	
		2525 M1305	25	25	150	36	32	
		TDJNR/L 2020 K15	20	20	125	39	25	DN... 1506...
		2525 M15	25	25	150	39	32	
		3232 P15	32	32	170	39	40	
		2020 K1504	20	20	125	39	25	DN... 1504...
		2525 M1504	25	25	150	39	32	
62.5°		TDNNR/L 2525 M11	25	25	150	30	12.5	DN... 1104...
	✓	TDNNR/L 2020 K1305	20	20	125	34	10	DN... 1305...
		2525 M1305	25	25	150	34	12.5	





A253-A258, A316, A329

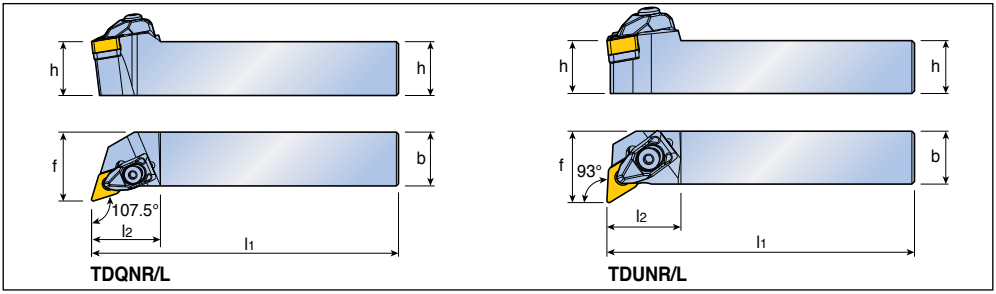
• ✓ Marked: For RHINORUSH insert

Spare parts

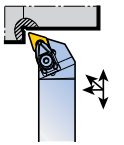
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
...11	DLM 3	DLS 3	LSD 32	SO 40085I	DSP 3	L-W 2.5	T 15	
...1305	DLM 3.5-NX	DLS 4	LSD 3.52	SO 50090I	DSP 4	L-W 3	T 20	
...15	DLM 4	DLS 4	TSD 43	SO 40050I	DSP 4	L-W 3	T 15	
...1504	DLM 4	DLS 4	TSD 44	SO 40050I	DSP 4	L-W 3	T 15	

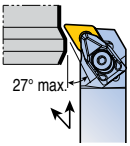
TDQNR/L TDUNR/L

T-holder type



Approach angle		Designation		Dimension (mm)					Insert
				h	b	l1	l2	f	
107.5°	✓	**TDQNR/L**	**2020 K1305**	20	20	125	32	25	DN... 1305... A253-A258, A316, A329
			2525 M1305	25	25	150	32	32	
93°	✓	**TDUNR/L**	**2020 K1305**	20	20	125	28	27	
			2525 M1305	25	25	150	28	32	





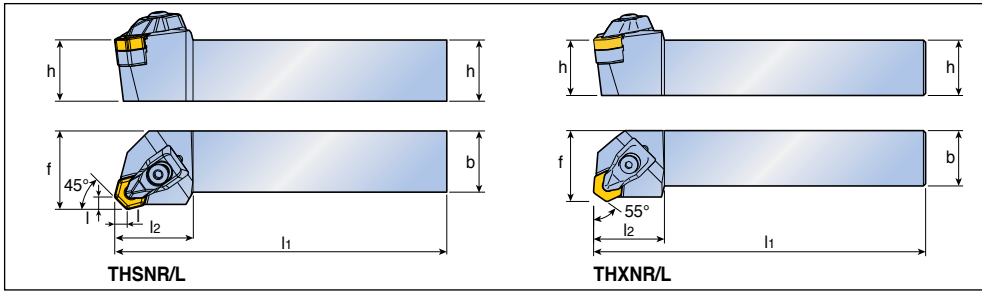
• ✓ Marked: For RHINORUSH insert

Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
								
...1305	DLM 3.5-NX	DLS 4	LSD 3.52	SO 50090I	DSP 4	L-W 3	T 20	

THSNR/L THXNR/L

T-holder type



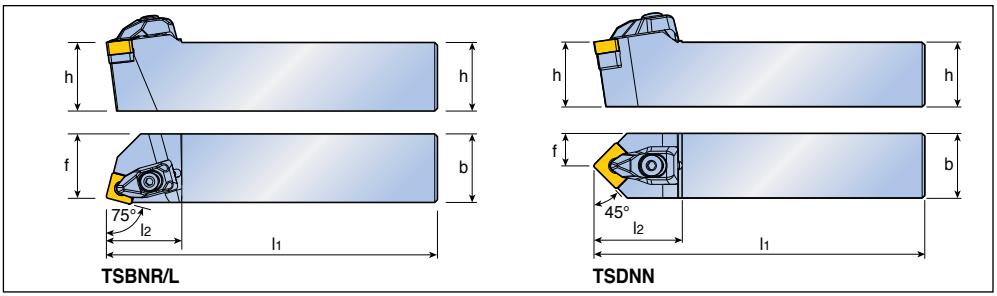
Approach angle	Designation		Dimension (mm)						Insert	
			h	b	l1	l2	f	l		
45°	THSNR/L	2525 M05	25	25	150	32	32	4.2	HN... 0504...	A259
		2525 M10	25	25	150	42	32	6.5	HN... 1006...	
		3232 P05	32	32	170	32	40	4.2	HN... 0504...	
		3232 P10	32	32	170	42	40	6.5	HN... 1006...	
55°	THXNR/L	2525 M05-A55	25	25	150	32	32	-	HN... 0504...	
		3232 P05-A55	32	32	170	32	40	-		

Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
...05	DLM 4	DLS 4	TSH 44	SO 40050I	DSP 4	L-W 3	T 15	
...10	DLM 6	DLS 5	TSH 64	SO 50090I	DSP 5	L-W 4	T 20	
...A55	DLM 4	DLS 4	TSH 44	SO 40050I	DSP 4	L-W 3	-	

TSBNR/L TSDNN

T-holder type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
75°	✓ TSBNR/L	2020 K0904	20	20	125	27.5	18.5	SN... 0904...
		2525 M0904	25	25	150	27.5	23.5	
45°	✓ TSDNN	2020 K0904	20	20	125	28	10	SN... 0904...
		2525 M0904	25	25	150	28	12.5	
	TSDNN	2525 M12	25	25	150	34	12.5	SN... 1204...
		3232 P19	32	32	170	44	16	SN... 1906...

A261-A267, A319-A320, A331

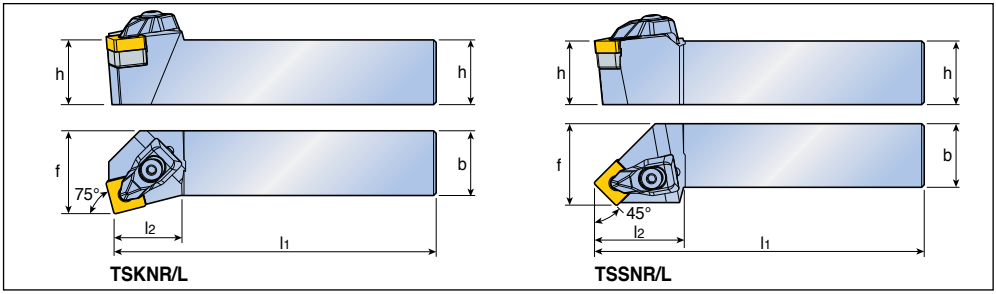
• ✓ Marked: For RHINORUSH insert

Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench	
...0904	DLM 3-NX	DLS 3	LSS 32A	SO 40085I	DSP 3	L-W 2.5	T 15
...12	DLM 4	DLS 4	TSS 44	SO 40050I	DSP 4	L-W 3	T 15
...19	DLM 6	DLS 5	LSS 63	SO 80180I	DSP 5	L-W 4	-

TSKNR/L TSSNR/L

T-holder type



Approach angle		Designation		Dimension (mm) h	b	l1	l2	f	Insert
75°	✓	TSKNR/L	2020 K0904	20	20	125	23	25	SN... 0904...
			2525 M0904	25	25	150	23	32	
		TSKNR/L	2525 M12	25	25	150	27	32	SN... 1204...
45°	✓	TSSNR/L	2020 K0904	20	20	125	29	25	SN... 0904...
			2525 M0904	25	25	150	29	32	
		TSSNR/L	2525 M12	25	25	150	35	32	SN... 1204...

A261-A267, A319-A320, A331

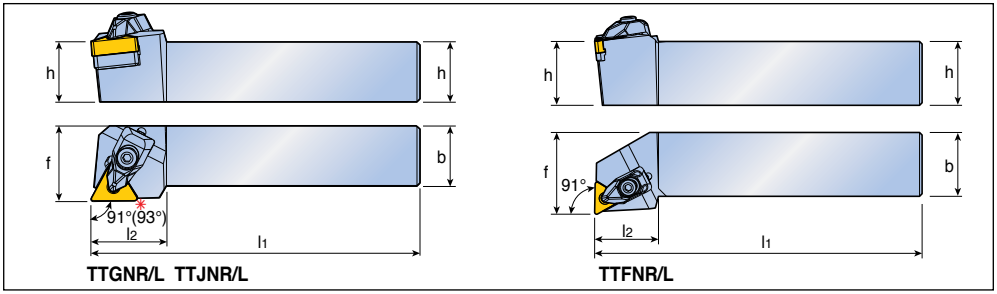
• ✓ Marked: For RHINORUSH insert

Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench	
...0904	DLM 3-NX	DLS 3	LSS 32A	SO 40085I	DSP 3	L-W 2.5	T 15
...12	DLM 4	DLS 4	TSS 44	SO 40050I	DSP 4	L-W 3	T 15

TTGNR/L TTJNR/L TTFNR/L

T-holder type



Approach angle		Designation		Dimension (mm) h	b	l1	l2	f	Insert
91°(*93°)	✓	TTGNR/L	2020 H1304	20	20	100	25	25	TN... 1304...
			2020 K1304	20	20	125	25	25	
			2525 M1304	25	25	150	25	32	
		TTGNR/L	2525 M16	25	25	150	25	32	TN... 1604...
	✓	TTJNR/L	2525 M1304	25	25	150	25	32	TN... 1304...
		TTJNR/L	2020 K16	20	20	125	25	25	TN... 1604...
			2525 M16	25	25	150	25	32	
91°	✓	TTFNR/L	2020 K1304	20	20	125	25	25	TN... 1304...
			2525 M1304	25	25	150	25	32	

A268-A273, A322, A332

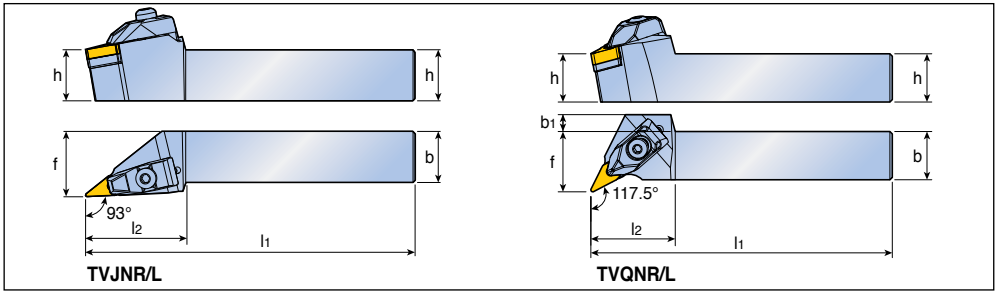
• ✓ Marked: For RHINORUSH insert *Marked: Approach angle of TTJNR/L is 93 degrees

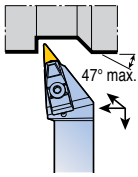
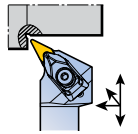
Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
...1304	DLM 2.5-NX	DLS 3	LST 2.52	SO 40085I	DSP 3	L-W 2.5	T 15	
...16	DLM3	DLS 3	TST 33	SO 35080I	DSP 3	L-W 2.5	T 15	

TVJNR/L TVQNR/L

T-holder type



Approach angle		Designation	Dimension (mm)							Insert	
			h	b	l1	l2	f	b1			
93°		TVJNR/L 2020 K13	20	20	125	49	25	-		VN... 1304...	A274-A276, A281, A323, A333
		2525 M13	25	25	150	49	32	-			
		2020 K16	20	20	125	49	25	-		VN... 1604...	
		2525 M16	25	25	150	49	32	-			
	✓	TVJNR/L 2020 K1304	20	20	125	42	25	-		VN...X 1304...	
		2525 M1304	25	25	150	42	32	-		YNMG 1304...	
117.5°		TVQNR/L 2020 K16	20	20	125	42	25	8		VN... 1604...	
		2525 M16	25	25	150	42	32	2			
	✓	TVQNR/L 2020 K1304	20	20	125	35	25	7		VN...X 1304...	
		2525 M1304	25	25	150	35	32	-		YNMG 1304...	

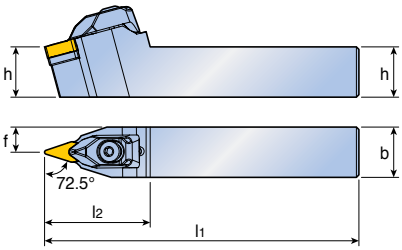
• ✓ Marked: For RHINORUSH insert

Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
								
...13	DLM 3V	DLS 5	MSV 2.522	SC 4-SH	DSP 5	L-W 4	T 15	
...16	DLM 3V	DLS 5	TSV 33	SO 35080I	DSP 5	L-W 4	T 15	
...1304	DLM 2.5V-NX	DLS 4	MSVI 2.522	SO 40085I	DSP 4	L-W 4	T 15	

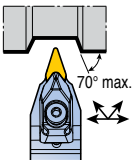
TVVNN

T-holder type



TVVNN

Approach angle	Designation	Dimension (mm)					Insert
		h	b	l1	l2	f	
72.5°	✓ **TVVNN 2020 K1304**	20	20	125	42	10	VN...X 1304...
	2525 M1304	25	25	150	42	12.5	YNMG 1304... A274-A276, A281, A323, A333



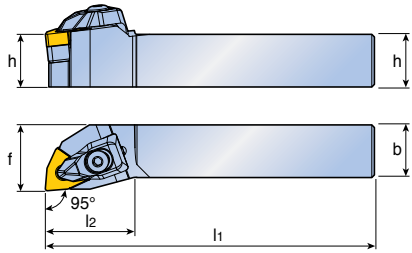
• ✓ Marked: For RHINORUSH insert

Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
								
...1304	DLM 2.5V-NX	DLS 4	MSVI 2.522	SO 40085I	DSP 4	L-W 4	T 15	

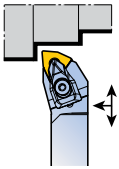
TWLNR/L

T-holder type



TWLNR/L

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
95°	✓ TWLNR/L	2020 K0604	20	20	125	26	25	WN...X 0604...
		2525 M0604	25	25	150	26	32	
	TWLNR/L	2020 K06	20	20	125	26	25	WN...G 0604...
		2525 M06	25	25	150	26	32	
		2020 K08	20	20	125	34.2	25	WN... 0804...
		2525 M08	25	25	150	34.2	32	
		3232 P08	32	32	170	34.2	40	



A277-A280, A323, A324

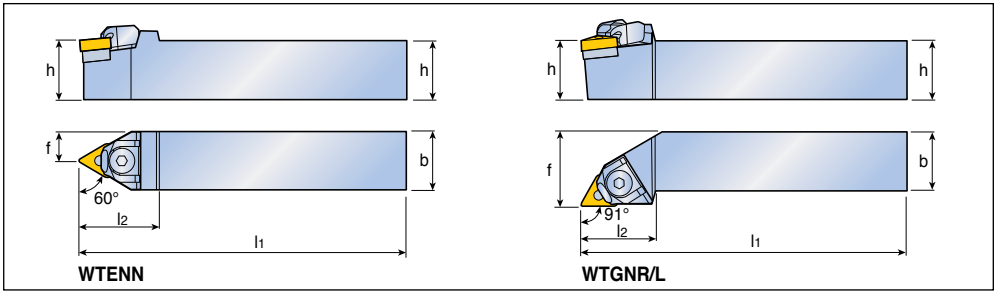
• ✓ Marked: For RHINORUSH insert

Spare parts

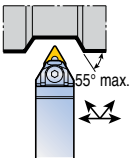
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
								
...0604	DLM 3-NX	DLS 3	LSW 32A	SO 40085I	DSP 3	L-W 2.5	T 15	
...06	DLM 3	DLS 3	PSW 32	SO 40090I	DSP 3	L-W 2.5	T 15	
...08	DLM 4	DLS 4	TSW 44	SO 40050I	DSP 4	L-W 3	T 15	

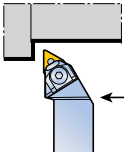
WTENN WTGNR/L

Wedge clamp type



Approach angle		Designation		Dimension (mm) h	b	l1	l2	f	Insert	
60°	✓	**WTENN**	**2020 K1304**	20	20	125	28	10.0	TN... 1304...	A268-A273, A322, A332
			2525 M1304	25	25	150	28	12.5		
		WTENN	**2020 K16**	20	20	125	35	10.0	TN... 1604...	
			2525 M16	25	25	150	35	12.5		
			2525 M22	25	25	150	38	12.5	TN... 2204...	
			3225 P22	32	25	170	38	12.5		
			3232 P22	32	32	170	38	16.0		
91°	✓	**WTGNR/L**	**2020 K1304**	20	20	125	27	25	TN... 1304...	
			2525 M1304	25	25	150	27	32		
		WTGNR/L	**2020 K16**	20	20	125	32	25	TN... 1604...	
			2525 M16	25	25	150	32	32		
			2525 M22	25	25	150	38	32	TN... 2204...	
			3232 P22	32	32	170	38	40		





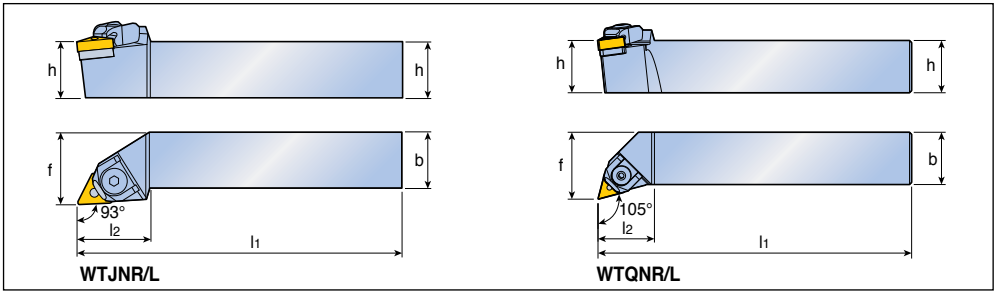
• ✓ Marked: For RHINORUSH insert

Spare parts

Designation	Wedge clamp	Screw	Snap ring	Shim	Pin screw	Wrench		
...1304	WC 2.53	WCS 2.5	CSR 2	WST 2.52	WSS 2.52	L-W 2.5		
...16	WC 33	WCS 4	WSR 4	WST 33	WSS 33	L-W 3, L-W 2.5		
...22	WC 43	WCS 4	WSR 4	WST 43	WSS 43	L-W 3		

WTJNR/L WTQNR/L

Wedge clamp type



Approach angle		Designation	Dimension (mm) h	b	l1	l2	f	Insert
93°	✓	WTJNR/L 2020 K1304	20	20	125	27	25	TN... 1304...
		2525 M1304	25	25	150	27	32	
		WTJNR/L 2020 K16	20	20	125	32	25	TN... 1604...
		2525 M16	25	25	150	32	32	
		3225 P16	32	25	170	32	32	
		3232 P16	32	32	170	38	40	
		2525 M22	25	25	150	38	32	TN... 2204...
		3232 P22	32	32	170	38	40	
105°	✓	WTQNR/L 2020 K1304	20	20	125	27	25	TN... 1304...
		2525 M1304	25	25	150	27	32	

A268-A273, A322, A332

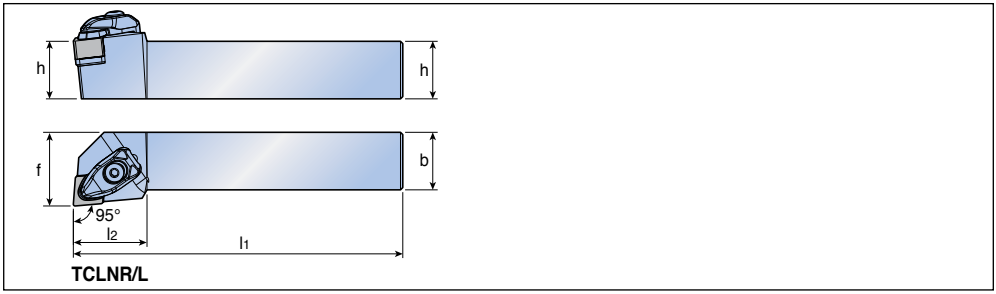
• ✓ Marked: For RHINORUSH insert

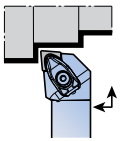
Spare parts

Designation	Wedge clamp	Screw	Snap ring	Shim	Pin screw	Wrench		
...1304	WC 2.53	WCS 2.5	CSR 2	WST 2.52	WSS 2.52	L-W 2.5		
...16	WC 33	WCS 4	WSR 4	WST 33	WSS 33	L-W 3, L-W 2.5		
...22	WC 43	WCS 4	WSR 4	WST 43	WSS 43	L-W 3		

TCLNR/L-F

Ceramic T-holder type



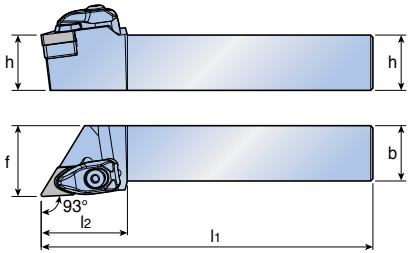
Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l_1	l_2	f		
95°	**TCLNR/L**	**2525 M0903-F**	25	25	150	25	32	CN...N 0903...	A314, A328
		**2020 K1204-F**	20	20	125	32	25	CN...N 1204...	
		2525 M1204-F	25	25	150	32	32		
		3232 P1204-F	32	32	170	32	40		
		2020 K1207-F	20	20	125	32	25	CN...N 1207...	
		2525 M1207-F	25	25	150	32	32		
		3232 P1207-F	32	32	170	32	40		

Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
								
...0903	DCL S-3F	DLS 3	LSC 32	SO 40085I	DSP 3	L-W 2.5	T 15	
...1204	DCL S-4F	DLS 4	TSC 44	SO 40050I	DSP 4	L-W 3	T 15	
...1207	DCL S-4F	DLS 4	TSC 42	SO 40050I	DSP 4	L-W 3	T 15	

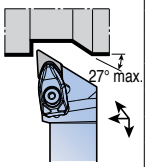
TDJNR/L-F

Ceramic T-holder type



TDJNR/L

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
93°	TDJNR/L	2525 M1504-F	25	25	150	39	32	DN...N 1504... A316
		3232 P1504-F	32	32	170	39	40	
		2525 M1507-F	25	25	150	39	32	DN...N 1507...
		3232 P1507-F	32	32	170	39	40	

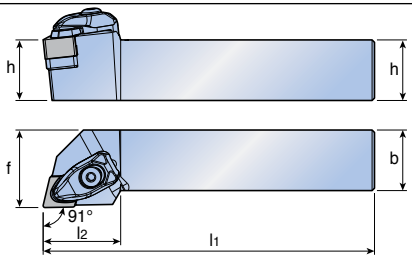


Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
...1504	DCL S-4F	DLS 4	TSD 44	SO 40050I	DSP 4	L-W 3	T 15	
...1507	DCL S-4F	DLS 4	TSD 42	SO 40050I	DSP 4	L-W 3	T 15	

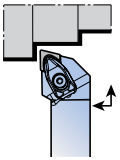
TEGNR/L-F

Ceramic T-holder type



TEGNR/L

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l_1	l_2	f	
91°	**TEGNR/L**	**2525 M1307-F**	25	25	150	32	32	EN...N 1307... A317

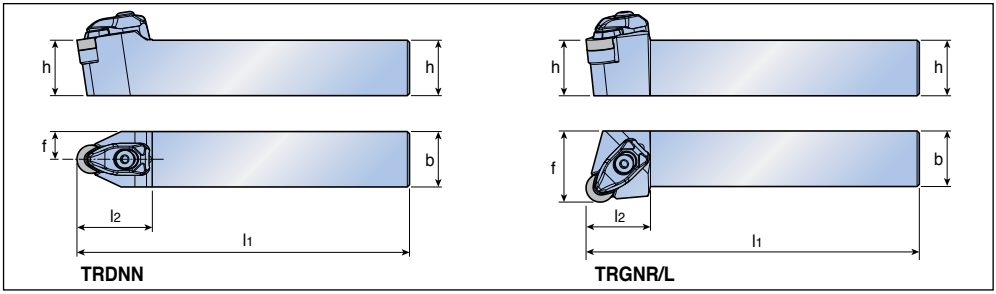


Spare parts

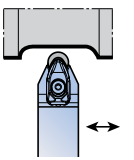
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
...1307	DCL S-4F	DLS 4	E 43	BH M5x0.8x10	DSP 4	L-W 3		

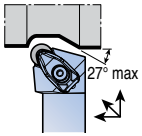
TRDNN-F TRGNR/L-F

Ceramic T-holder type



Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l1	l2	f		
45°	TRDNN	2525 M1203-F	25	25	150	34	10	RN...N 1203...	A318, A330
		2020 K1204-F	20	20	125	34	10	RN...N 1204...	
		2525 M1204-F	25	25	150	34	12.5		
		2020 K1207-F	20	20	125	34	10	RN...N 1207...	
		2525 M1207-F	25	25	150	34	12.5		
		3225 P1207-F	32	25	170	34	12.5		
90°	TRGNR/L	2020 K1204-F	20	20	125	29	25	RN...N 1204...	
		2525 M1204-F	25	25	150	29	32		
		2020 K1207-F	20	20	125	29	25	RN...N 1207...	
		2525 M1207-F	25	25	150	29	32		
		3225 P1207-F	32	25	170	29	32		





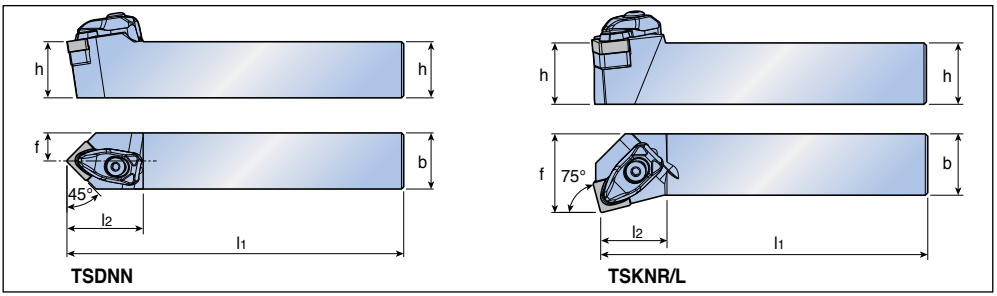
• RN...N 1204/1207 are exchangeable, RN...N 1203 is not exchangeable on same holder

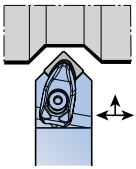
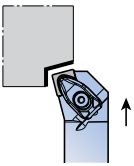
Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
...1203	DCL S-4F	DLS 4	S 43	BH M5x0.8x8	DSP 4	L-W 3		
...1204	DCL S-4F	DLS 4	S 43-T8	BH M5x0.8x10	DSP 4	L-W 3		
...1207	DCL S-4F	DLS 4	S 43	BH M5x0.8x8	DSP 4	L-W 3		

TSDNN-F TSKNR/L-F

Ceramic T-holder type



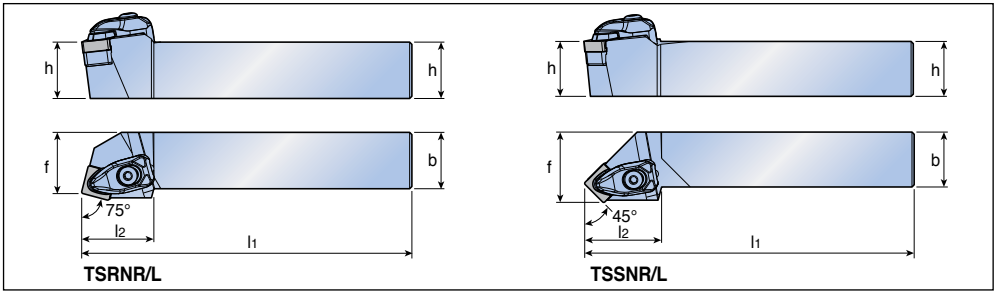
Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l1	l2	f		
45°	**TSDNN**	**2525 M0903-F**	25	25	150	28	12.5	SN...N 0903...	A319, A331
		**2020 K1204-F**	20	20	125	34	10	SN...N 1204...	
		2525 M1204-F	25	25	150	34	12.5		
		2525 M1207-F	25	25	150	34	12.5	SN...N 1207...	
		3225 P1207-F	32	25	170	34	12.5		
		3232 P1207-F	32	32	170	34	16		
75°	**TSKNR/L**	**2525 M1204-F**	25	25	150	27	32	SN...N 1204...	
		**3232 P1204-F**	32	32	170	27	40		
		2525 M1207-F	25	25	150	27	32	SN...N 1207...	
		3232 P1207-F	32	32	170	27	40		

Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
								
...0903	DCL S-3F	DLS 3	LSS 32	SO 40085I	DSP 3	L-W 2.5	T 15	
...1204	DCL S-4F	DLS 4	TSS 44	SO 40050I	DSP 4	L-W 3	T 15	
...1207	DCL S-4F	DLS 4	TSS 42	SO 40050I	DSP 4	L-W 3	T 15	

TSRNR/L-F TSSNR/L-F

Ceramic T-holder type



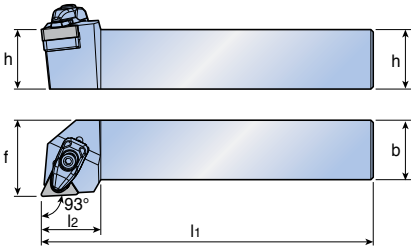
Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l1	l2	f		
75°	TSRNR/L	2525 M1204-F	25	25	150	32	27	SN...N 1204...	A319, A331
		3232 P1204-F	32	32	170	32	35		
		2525 M1207-F	25	25	150	32	27	SN...N 1207...	
		3225 P1207-F	32	25	170	32	27		
		3232 P1207-F	32	32	170	32	35		
45°	TSSNR/L	2525 M1204-F	25	25	150	35	32	SN...N 1204...	
		3232 P1204-F	32	32	170	35	40		
		2525 M1207-F	25	25	150	35	32	SN...N 1207...	
		3232 P1207-F	32	32	170	35	40		

Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
...1204	DCL S-4F	DLS 4	TSS 44	SO 40050I	DSP 4	L-W 3	T 15	
...1207	DCL S-4F	DLS 4	TSS 42	SO 40050I	DSP 4	L-W 3	T 15	

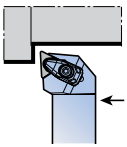
TTJNR/L-F

Ceramic T-holder type



TTJNR/L

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
93°	TTJNR/L	2020 K1604-F	20	20	125	25	25	TN...N 1604...
		2525 M1604-F	25	25	150	25	32	
		2020 K1607-F	20	20	125	25	25	TN...N 1607...
		2525 M1607-F	25	25	150	25	32	



A322

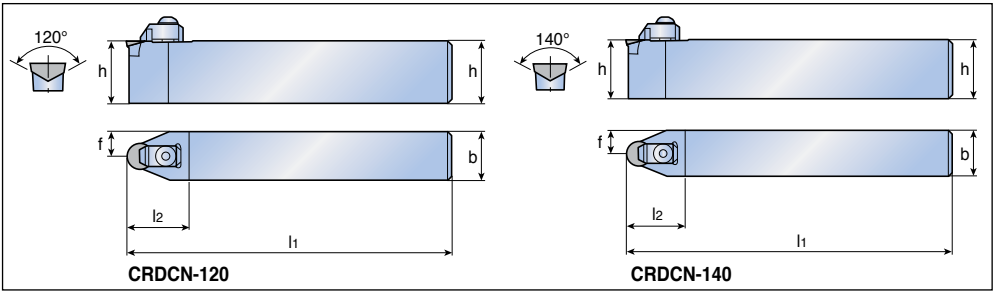
• TNGN 1604/1607 inserts are not exchangable on same holder

Spare parts

Designation	Clamp	Clamp Sscrew	Shim	Shim screw	Spring	Wrench		
...16	DCL S-3F	DLS 3	TST 33	SO 40050I	DSP 3	L-W 3	T 15	

CRDCN

Ceramic holder type



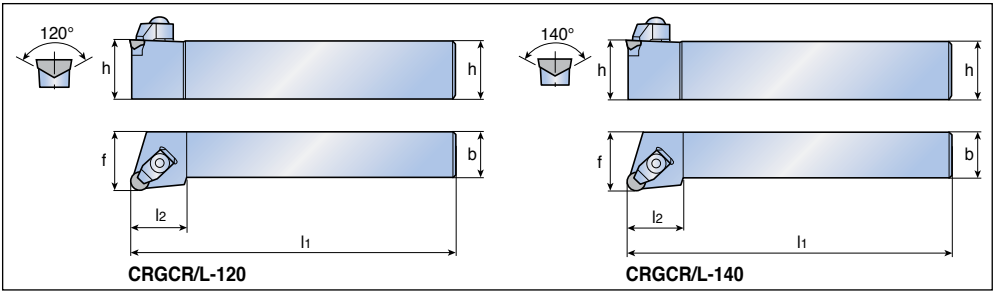
Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l1	l2	f		
45°	CRDCN	2525 M06-120	25	25	150	28	12.5	RCGX 060600	A324
		3225 P06-120	32	25	170	28	12.5		
		3225 P09-120	32	25	170	30	12.5	RCGX 090700	
		3225 P12-120	32	25	170	32	12.5	RCGX 120700	
45°	CRDCN	2525 M06-140	25	25	150	28	12.5	RCGX 060300-FT	A337
		3225 P06-140	32	25	170	28	12.5		
		3225 P09-140	32	25	170	30	12.5	RCGX 090300-FT	
		3225 P12-140	32	25	170	32	12.5	RCGX 120400-FT	

Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Wrench			
...06	BCL 6-20A	BH M6x1x25	CBRS 06	SO 22050I	L-W 4	T 7		
...09	BCL 6-20A	BH M6x1x25	CBRS 09	BH M2.5x0.45x10	L-W 4, L-W 1.5	-		
...12	BCL 6	BH M6x1x25	CBRS 12	BH M2.5x0.45x10	L-W 4, L-W 1.5	-		

CRGCR/L

Ceramic holder type



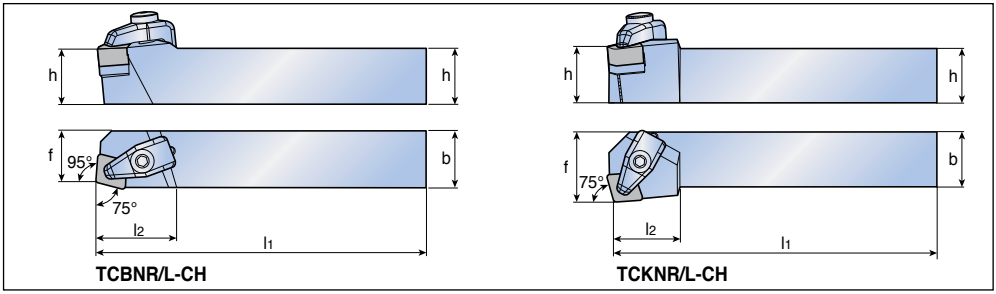
Approach angle	Designation		Dimension (mm)					Insert	
			h	b	l1	l2	f		
90°	**CRGCR/L**	**2525 M06-120**	25	25	150	28	32	RCGX 060600	A324
		3225 P06-120	32	25	170	28	32		
		3225 P09-120	32	25	170	30	32	RCGX 090700	
		3225 P12-120	32	25	170	32	32	RCGX 120700	
90°	**CRGCR/L**	**2525 M06-140**	25	25	150	28	32	RCGX 060300-FT	A337
		3225 P06-140	32	25	170	28	32		
		3225 P09-140	32	25	170	30	32	RCGX 090300-FT	
		3225 P12-140	32	25	170	32	32	RCGX 120400-FT	

Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Wrench			
...06	BCL 6-20A	BH M6x1x25	CBRS 06	SO 22050I	L-W 4	T 7		
...09	BCL 6-20A	BH M6x1x25	CBRS 09	BH M2.5x0.45x10	L-W 4, L-W 1.5	-		
...12	BCL 6	BH M6x1x25	CBRS 12	BH M2.5x0.45x10	L-W 4, L-W 1.5	-		

TCBNR/L-CH TCKNR/L-CH

Ceramic dimple holder type



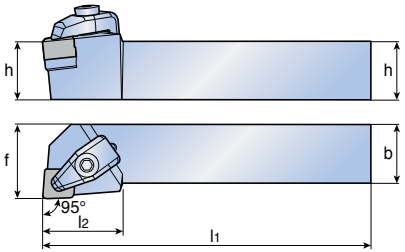
Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
75°	TCBNR/L	2525 M12-CH	25	25	150	34.4	22	CNGX 1207...CH A315
		3225 P12-CH	32	25	170	34	22	
75°	TCKNR/L	2525 M12-CH	25	25	150	28	32	
		3225 P12-CH	32	25	170	28	32	

Spare parts

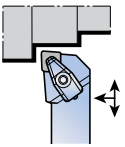
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
...12	CCL 4	CSC 4	S 48	BH M5x0.8x10	DSP 5	L-W 4, L-W 3		

TCLNR/L-CH

Ceramic dimple holder type



TCLNR/L-CH

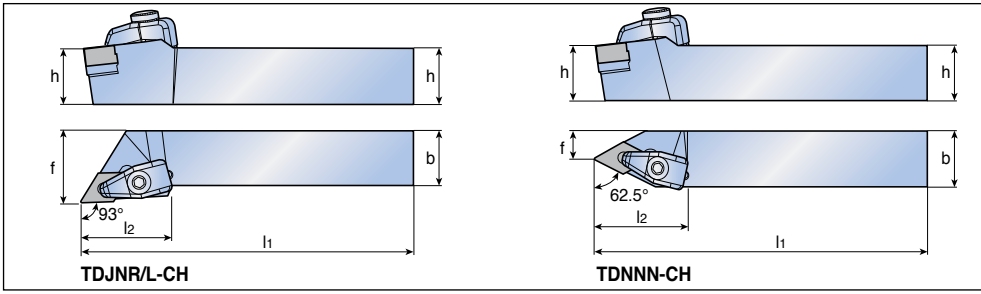
Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
95°	**TCLNR/L**	**2525 M12-CH**	25	25	150	33	32	CNGX 1207...CH A315
		**3225 P12-CH**	32	25	170	33	32	

Spare parts

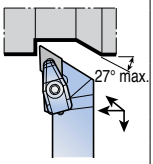
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
								
...12	CCL 4	CSC 4	S 48	BH M5x0.8x10	DSP 5	L-W 4, L-W 3		

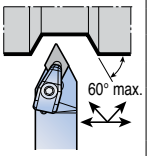
TDJNR/L-CH TDNNN-CH

Ceramic dimple holder type



Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
93°	**TDJNR/L**	**2525 M15-CH**	25	25	150	38	32	DNGX 1507...CH A316
		3225 P15-CH	32	25	170	38	32	
62.5°	**TDNNN**	**2525 M15-CH**	25	25	150	40	12.5	
		3225 P15-CH	32	25	170	40	12.5	



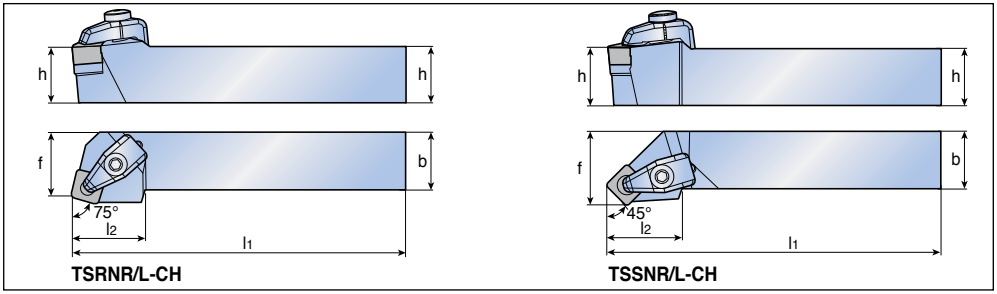


Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
...15	CCL 4	CSC 4	S 45	BH M5x0.8x10	DSP 5	L-W 4, L-W 3		

TSRNR/L-CH TSSNR/L-CH

Ceramic dimple holder type



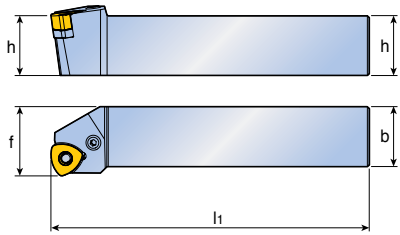
Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
75°	**TSRNR/L**	**2525 M12-CH**	25	25	150	32	27	SNGX 1207...CH A320
		3225 P12-CH	32	25	170	32	27	
45°	**TSSNR/L**	**2525 M12-CH**	25	25	150	35	32	SNGX 1207...CH
		3232 P12-CH	32	32	170	35	40	
		3225 P15-CH	32	25	170	35	32	SNGX 1507...CH

Spare parts

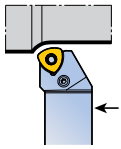
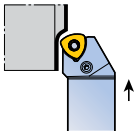
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
...12	CCL 4	CSC 4	S 40	BH M5x0.8x10	DSP 5	L-W 4, L-W 3		
...15	CCL 4	CSC 4	S 50	BH M5x0.8x10	DSP 5	L-W 4, L-W 3		

HBXNR/L

TOPFEED holder



HBXNR/L

Approach angle	Designation		Dimension (mm)				Insert
			h	b	l1	f	
	**HBXNR/L**	**2525 M1507**	25	25	150	30	BNMX 150720R/L-HF A307
		**3232 P1507**	32	32	170	37	

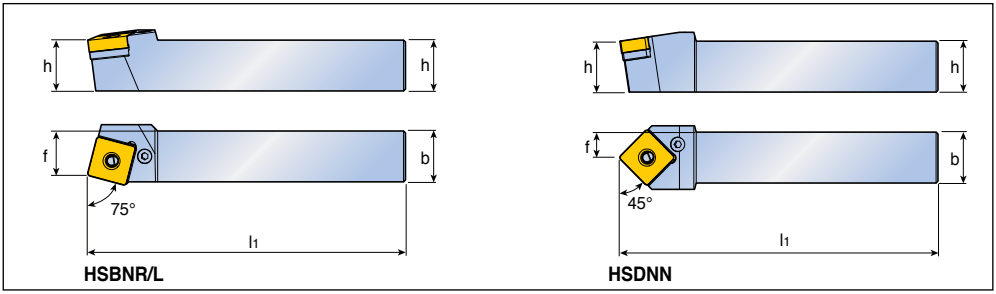
Spare parts

Designation	Lever	Screw	Shim	Shim pin	Shim pin punch	Wrench		
								
...1507	LCL 16-NX	LCS 5-L25.5	LSB 53 R/L	LSP 5	SPP 5-6	L-W 3		

HSBNR/L HSDNN

TOPDUTY

TOPDUTY holder



Approach angle	Designation		Dimension (mm)				Insert
			h	b	l1	f	
75°	HSBNR/L	4040 S3109	40	40	250	35	SNM...3109... A261-A267
		5050 T3109	50	50	300	43	
45°	HSDNN	4040 S3109	40	40	250	20	SNM...3109...
		5050 T3109	50	50	300	25	

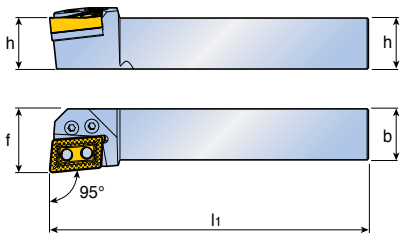
Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
...3109	LCL 32-NX	LCS 8	LSS 104	LSP 8	L-W 5			

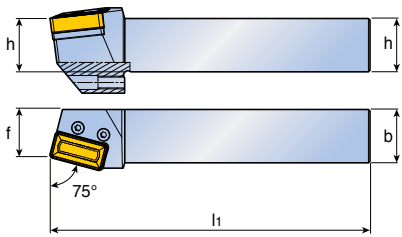
2PLLNR/L 2PLBNR/L

TOPDUTY

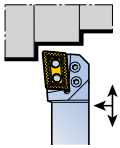
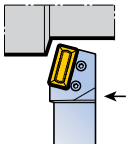
TOPDUTY holder



2PLLNR/L



2PLBNR/L

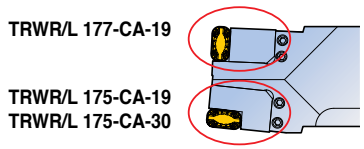
Approach angle	Designation		Dimension (mm)				Insert
			h	b	l1	f	
95° 	**2PLLNR/L**	**4040 S4012**	40	40	250	50	LNMM 401224R/L-HX A308
		5050 T4012	50	50	300	60	
75° 	**2PLBNR/L**	**5050 T5014**	50	50	300	45	LNMX 501432 A309

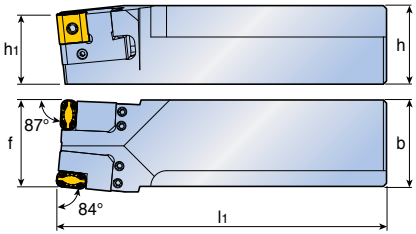
Spare parts

Designation	Lever	Screw	Shim	Shim pin	Set screw	Wrench		
								
2PLLNR/L...	LCL 8	LCS 8-L39	LN 4025-T6.35-R/L	LSP 8	-	L-W 5		
2PLBNR/L...	LCL 8	LCS 8-L43	LN 5025-T6.35	LSP 8	SS M12x1.75x25	L-W 5		

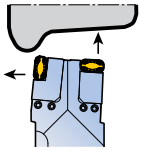
TaeguTec

TOPRAIL holder

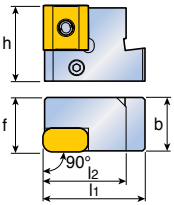




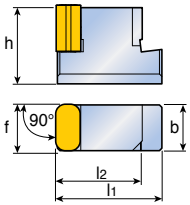
TRWR/L

Approach angle	Designation		Dimension (mm)					Cartridge
			h	h1	b	l1	f	
	TRWR/L	50-55 TG	50	44	55	210	55	Left TRWR/L 175-CA-19 TRWR/L 175-CA-30  Right TRWR/L 177-CA-19 

TOPRAIL cartridge



TRWR/L 175-CA-19
TRWR/L 175-CA-30



TRWR/L 177-CA-19

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
90°	TRWR/L	175-CA-19	32	22.6	43	35	23	LNMX 191940...  A310
		175-CA-30	32	22.6	43	35	23	LNMX 301940...
		177-CA-19	32	18.6	43	35	19	LNMX 191940...

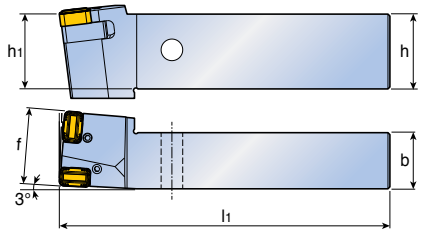
Spare parts

Designation	Screw	Pin	Lever	Screw	Wrench			
								
...50-55 TG	SS M6x1x16	PIN D5x13	-	-	L-W 3			
...CA...	-	-	LCL 5	LCS 5	L-W 3			

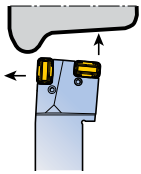
TRWR/L-LD

TOPRAIL

TOPRAIL holder



TRWR/L

Approach angle	Designation	Dimension (mm)					Insert
		h	h1	b	l1	f	
	**TRWR/L 57.2-76.2 LD**	76.2	76.2	57.2	254	76.2	SRR... A311

• Holder can be supplied by quotation

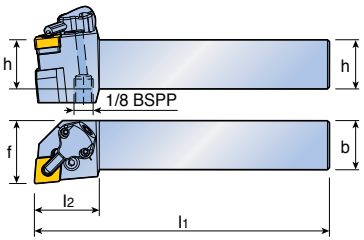
Spare parts

Designation	Shim1	Shim2	Screw	Wrench				
								
...LD	SRR-SHIM	SRR-SH-R/L	SRR-SCR	L-W 5				

PCLNR/L-TB

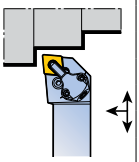
T-BURST HIGH PRESSURE

T-BURST holder



PCLNR/L-TB

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l_1	l_2	f	
95°	**PCLNR/L**	**2525 M12-TB**	25	25	150	33	32	CN... 1204... A244-A252, A314-A315, A328
		3232 P12-TB	32	32	170	33	40	



Spare parts

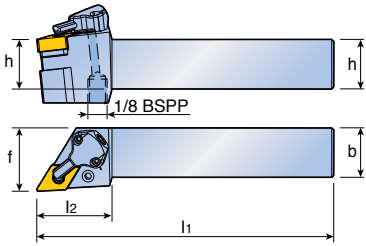
Designation	Lever	Screw	Shim	Shim pin	Oil-supply unit	O-ring	Plug	Wrench1	Wrench2	Wrench3
PCLNR/L...TB	LCL 4	LCS 4	LSC 42	LSP 4	CU-CW-TB	ID 6.4x0.9	SS M4x0.7x4-NL	L-W 2	L-W 3	T 8

TaeguTec Member IMC Group

PDJNR/L-TB

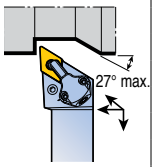
T-BURST HIGH PRESSURE

T-BURST holder



PDJNR/L-TB

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
93°	**PDJNR/L**	**2525 M1504-TB**	25	25	150	37	32	DN... 1504...
		2525 M1506-TB	25	25	150	37	32	DN... 1506...



A253-A257, A316, A329

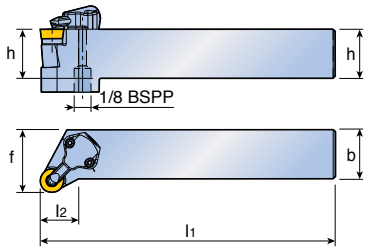
Spare parts

Designation	Lever	Screw	Shim	Shim pin	Oil-supply unit	O-ring	Plug	Wrench1	Wrench2	Wrench3
...M1504	LCL 4A	LCS 4	LSD 43	LSP 4	CU-D-TB	ID 6.4x0.9	SS M4x0.7x4-NL	L-W 2	L-W 3	T 8
...M1506	LCL 4A	LCS 4	LSD 42	LSP 4	CU-D-TB	ID 6.4x0.9	SS M4x0.7x4-NL	L-W 2	L-W 3	T 8

SRGCR/L-TB

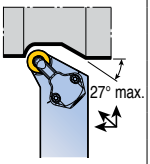
T-BURST HIGH PRESSURE

T-BURST holder



SRGCR/L-TB

Approach angle	Designation	Dimension (mm)					Insert
		h	b	l1	l2	f	
90°	**SRGCR/L 2525 M12-TB**	25	25	150	19.6	32	RC...T 1204... A290



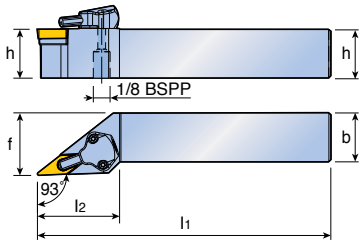
Spare parts

Designation	Screw	Shim	Shim screw	Oil-supply unit	O-ring	Plug	Wrench1	Wrench2	Wrench3	Wrench4
SRGCR/L...TB	TS 35110I	SSR 32	TS 5035062S	CU-R-TB	ID 6.4x0.9	SS M4x0.7x4-NL	L-W 2	L-W 3.5	T 8	T 15

SVJBR/L-TB

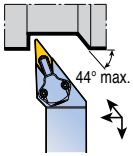
T-BURST HIGH PRESSURE

T-BURST holder



SVJBR/L-TB

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l1	l2	f	
93°	**SVJBR/L**	**2525 M16-TB**	25	25	150	37	32	VB...T 1604... A300-A301, A341



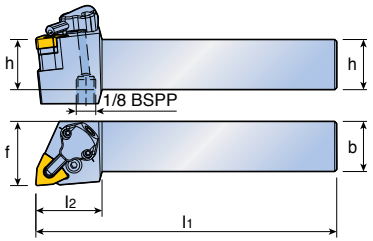
Spare parts

Designation	Screw	Shim	Shim screw	Oil-supply unit	O-ring	Wrench1	Wrench2	Wrench3
SVJBR/L...TB	SO 35124I	SSV 32	TS 5035062S	CU-V-TB	ID 6.4x0.9	L-W 3.5	T 8	T 15

PWLNR/L-TB

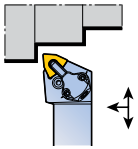
T-BURST HIGH PRESSURE

T-BURST holder



PWLNR/L-TB

Approach angle	Designation		Dimension (mm)					Insert
			h	b	l_1	l_2	f	
95°	**PWLNR/L**	**2525 M08-TB**	25	25	150	33	32	WNM... 0804... A277-A279, A323, A324
		3232 P08-TB	32	32	170	33	40	



Spare parts

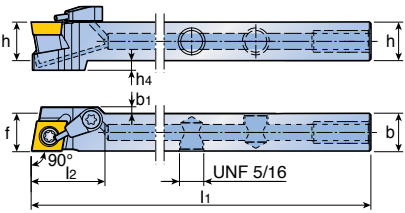
Designation	Lever	Screw	Shim	Shim pin	Oil-supply unit	O-ring	Plug	Wrench1	Wrench2	Wrench3
PWLNR/L...TB	LCL 4	LCS 4	TWN 423(T)	LSP 4	CU-CW-TB	ID 6.4x0.9	SS M4x0.7x4-NL	L-W 2	L-W 3	T 8

TaeguTec Member IMC Group

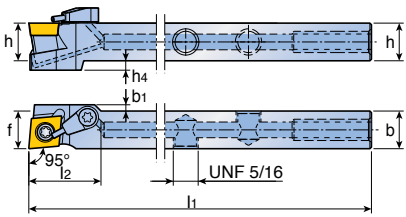
SCACR/L-SH-TB SCLCR/L-SH-TB

T-BURST HIGH PRESSURE

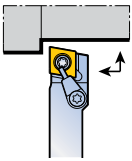
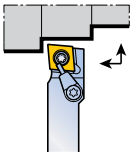
T-BURST holder



SCACR/L-SH-TB



SCLCR/L-SH-TB

Approach angle	Designation		Dimension (mm)							Insert
			h	b	l1	l2	f	b1	h4	
90°	**SCACR/L**	**1212 K09-SH-TB**	12	12	125	23	12	2	3	CC...T 09T3... A282-A284, A335
		**1616 K09-SH-TB**	16	16	125	23	16	-	-	
95°	**SCLCR/L**	**1212 K09-SH-TB**	12	12	125	23	12	2	3	
		**1616 K09-SH-TB**	16	16	125	23	16	-	-	

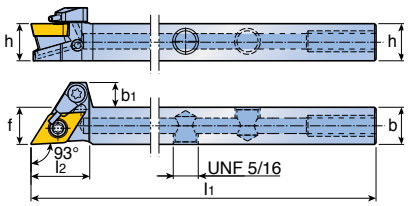
Spare parts

Designation	Screw	Oil-supply unit	Plug1	Plug2	Wrench1	Wrench2		
								
SCACR/L...TB	SO 35080I	S-CU-TB	PLG 5/16 UNF	SS M3x0.5x3-NL	T 15	L-W 5/32		
SCLCR/L...TB	SO 35080I	S-CU-TB	PLG 5/16 UNF	SS M3x0.5x3-NL	T 15	L-W 5/32		

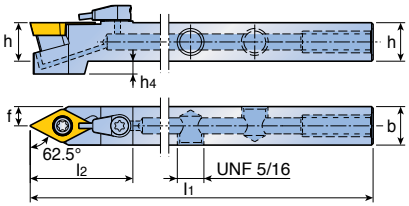
SDJCR/L-SH-TB SDNCN-SH-TB

T-BURST HIGH PRESSURE

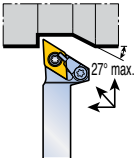
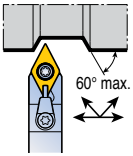
T-BURST holder



SDJCR/L-SH-TB



SDNCN-SH-TB

Approach angle	Designation		Dimension (mm)							Insert
			h	b	l1	l2	f	b1	h4	
93°	**SDJCR/L**	**1212 K11-SH-TB**	12	12	125	19	12	8	-	DC...T 11T3... A286-A288, A336
		**1616 K11-SH-TB**	16	16	125	19	16	4	-	
62.5°	**SDNCN**	**1212 K11-SH-TB**	12	12	125	32	6	-	4	
		**1616 K11-SH-TB**	16	16	125	32	8	-	-	

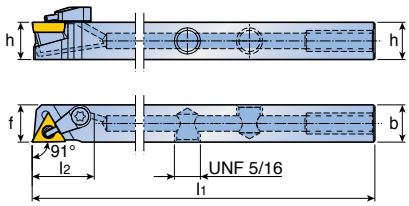
Spare parts

Designation	Screw	Oil-supply unit	Plug1	Plug2	Plug3	Wrench1	Wrench2	
								
SDJCR/L...TB	SO 35080I	S-CU-TB	PLG 5/16 UNF	SS M4x0.7x4-NL	SS M3x0.5x3-NL	T 15	L-W 5/32	
SDNCN...TB	SO 35080I	S-CU-TB	PLG 5/16 UNF	SS M2.5x0.45x2.5 SH-TB	-	T 15	L-W 5/32	

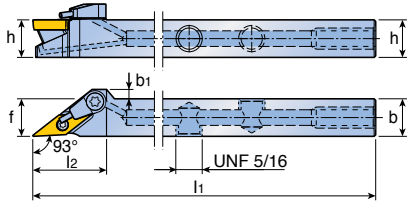
STGCR/L-SH-TB SVJBR/L-SH-TB

T-BURST HIGH PRESSURE

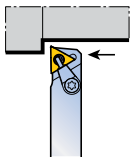
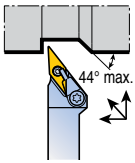
T-BURST holder



STGCR/L-SH-TB



SVJBR/L-SH-TB

Approach angle	Designation		Dimension (mm)						Insert	
			h	b	l1	l2	f	b1		
91°	**STGCR/L**	**1212 K11-SH-TB**	12	12	125	20	12	-	TC...T 1103...	A294-A295, A339, A340
		**1616 K11-SH-TB**	16	16	125	20	16	-		
93°	**SVJBR/L**	**1212 K11-SH-TB**	12	12	125	23.6	12	3	VB...T 1103...	A300-A301, A341
		**1616 K11-SH-TB**	16	16	125	23.6	16	-		

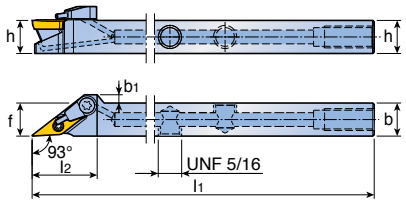
Spare parts

Designation	Screw	Oil-supply unit	Plug1	Plug2	Wrench1	Wrench2		
								
STGCR/L...TB	SO 25065I	S-CU-TB	PLG 5/16 UNF	SS M3x0.5x3-NL	T 7	L-W 5/32		
SVJBR/L...TB	SO 25065I	S-CU-TB	PLG 5/16 UNF	SS M3x0.5x3-NL	T 7	L-W 5/32		

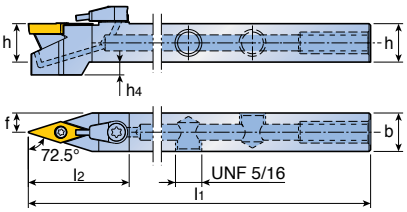
SVJCR/L-SH-TB SVVBN-SH-TB

T-BURST HIGH PRESSURE

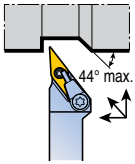
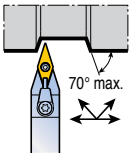
T-BURST holder



SVJCR/L-SH-TB



SVVBN-SH-TB

Approach angle	Designation		Dimension (mm)							Insert
			h	b	l1	l2	f	b1	h4	
93°	**SVJCR/L**	**1212 K11-SH-TB**	12	12	125	23.6	12	3	-	VC...T 1103...
		**1616 K11-SH-TB**	16	16	125	23.6	16	-	-	A302, A341
72.5°	**SVVBN**	**1212 K11-SH-TB**	12	12	125	31.5	6	-	4	VB...T 1103...
		**1616 K11-SH-TB**	16	16	125	31.5	8	-	-	A300-A301, A341

Spare parts

Designation	Screw	Oil-supply unit	Plug1	Plug2	Wrench1	Wrench2		
								
SVJCR/L...TB	SO 25065I	S-CU-TB	PLG 5/16 UNF	SS M3x0.5x3-NL	T 7	L-W 5/32		
SVVBN...TB	SO 25065I	S-CU-TB	PLG 5/16 UNF	SS M2.5x0.45x2.5 SH-TB	T 7	L-W 5/32		

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Hose

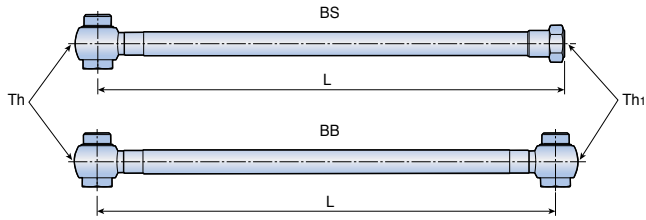


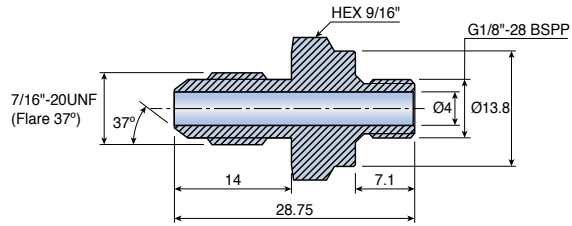
Fig.1

Fig.2

Designation		Dimension				Fig.
		L(mm)	Th	Th1	Max.pressure(Bar)	
TB HOSE	**G1/8-7/16-200BS**	200	G1/8"-28 BSPP	7/16"-20 UNF (Flare 37°)	260	1
	G1/8-7/16-250BS	250	G1/8"-28 BSPP	7/16"-20 UNF (Flare 37°)	260	1
	G1/8-G1/8-200BB	200	G1/8"-28 BSPP	G1/8"-28 BSPP	260	2
	G1/8-G1/8-250BB	250	G1/8"-28 BSPP	G1/8"-28 BSPP	260	2
	5/16-7/16-200BS	200	5/16"-24 UNF	7/16"-20 UNF (Flare 37°)	200	1
	5/16-G1/8-200BS	200	5/16"-24 UNF	G1/8"-28 BSPP	200	1

• Hose is ordered separately

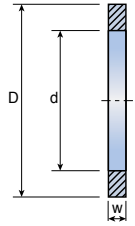
Adapter



Designation
TB NIPPLE G1/8-7/16 UNF

• Adapter is ordered separately

Seal washer

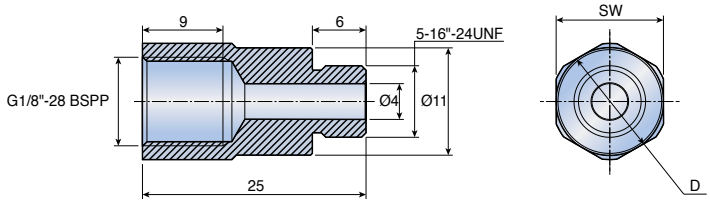


Designation		Dimension (mm)		
		D	d	w
TB COPPER	**SEAL 1/8"**	15	10	1
	SEAL 5/16"	12	8	1

• Seal washer is ordered separately

Components

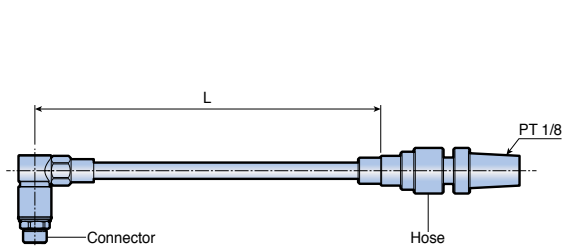
Connector



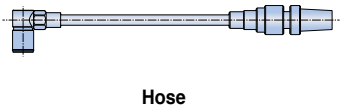
Designation		Dimension (mm)						
		D	SW					
TB CONECTOR	**5/16"-G1/8"**	13	12					
	5/16"-G1/8"-12	12	11					

• Connector is ordered separately

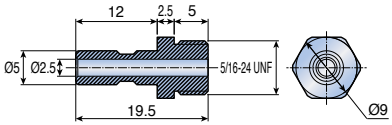
Coupling system



Hose set



Hose



Connector

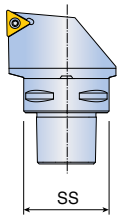
Components	Designation		Dimension	
			L (mm)	Maximum Pressure (Bar)
Hose set	**S-TB HOSE**	**R1/8-COUPLE-200**	200	140
		R1/8-COUPLE-300	300	140
Hose	**TB HOSE**	**R1/8-COUPLE-200**	200	140
		R1/8-COUPLE-300	300	140
Connector	**TB CONNECTOR**	**5/16-COUPLE**	-	-

• Hose set, hose and connector are ordered separately

C-ADAPTER Designation System

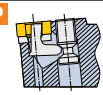
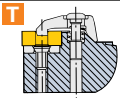
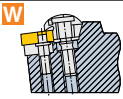
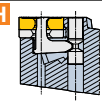
C4	-	T	C	L	N	R
1		2	3	4	5	6

1 Coupling size



Symbol	SS(mm)
C4	40
C5	50
C6	63

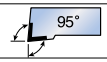
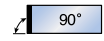
2 Clamping system

P	C	S	M	T	W	H
						
Lever lock	Top clamp	Screw clamp	Multi lock	T-holder	Wedge clamp	Hook lever

3 Insert shape

C	D	E	H	K	R	S	T	V	W
									

4 Approach angle

Symbol	Shape	Offset	Symbol	Shape	Offset	Symbol	Shape	Offset
A		×	J		○	V		×
			K		○	W		○
B		×	L		○	X	Special angle	
			M		×	C*		×
D		×	N		×	H*		○
E		×	R		○	Q*		○
F		○	S		○			
G		○	T		○			
			U		○			

* TaeguTec standard

TaeguTec

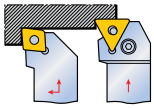
C-ADAPTER Designation System

27	055	-	09	
7	8		9	10

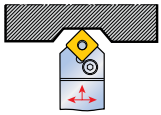
5 Insert clearance angle

			
N	B	C	P

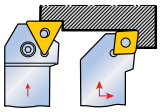
6 Hand of tool



R: Right hand

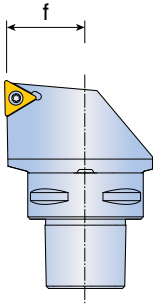


N: Neutral

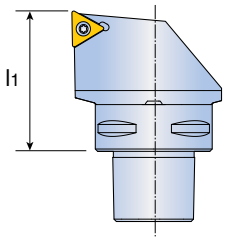


L: Left hand

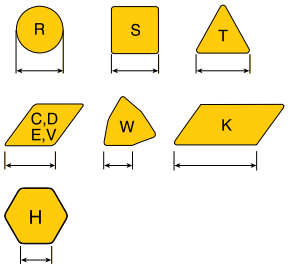
7 f dimension (mm)



8 Tool length (mm)



9 Cutting edge length



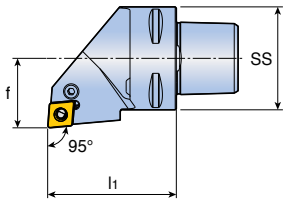
See page A243

10 Manufacturer's type designation

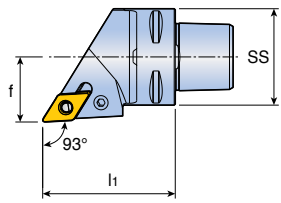
Unique to manufacturer

HCLNR/L HDJNR/L

Hook lever type

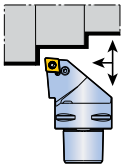


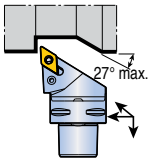
HCLNR/L



HDJNR/L

Approach angle	Designation	Dimension (mm)			Insert
		SS	f	l1	
95°	✓ **C4-HCLNR/L 27050-0904**	40	27	50	CN... 0904... A244, A246-A250
93°	✓ **C4-HDJNR/L 27055-1305**	40	27	55	DN... 1305... A253-A258





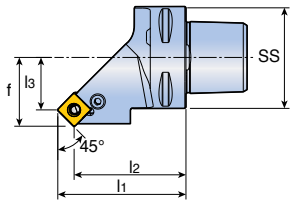
• ✓ Marked: For RHINORUSH insert

Spare parts

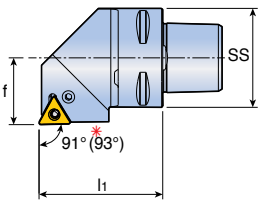
Designation	Lever	Screw	Shim		Shim pin	Shim pin punch	Nozzle	Wrench
C4 ...HCLNR/L	LCL 09-NX	LCS 3	LSC 32	-	LSP 3A	SPP 3-4	NZ 83	L-W 2.5
C4 ...HDJNR/L	LCL 11-NX	LCS 4	-	LSD 3.52	LSP 4	SPP 3-4	NZ 83	L-W 3

HSSNR/L HTGNR/L HTJNR/L

Hook lever type



HSSNR/L



HTGNR/L HTJNR/L

Approach angle	Designation	Dimension (mm)					Insert
		SS	f	l1	l2	l3	
45°	✓ **C4-HSSNR/L 27042-0904**	40	27	50.3	44	20.6	SN... 0904... A263-A266
91°(*93°)	✓ **C4-HTGNR/L 27050-1304**	40	27	50	-	-	TN... 1304... A268-A273
	✓ **C4-HTJNR/L 27050-1304**	40	27	50	-	-	

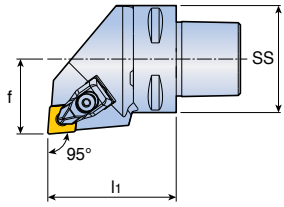
• ✓ Marked: For RHINORUSH insert *Marked: Approach angle of HTJNR/L is 93 degrees

Spare parts

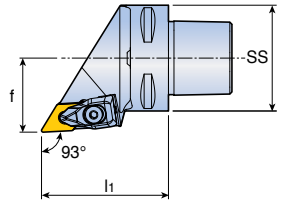
Designation	Lever	Screw	Shim		Shim Pin	Shim pin punch	Nozzle	Wrench
C4 ...0904	LCL 09-NX	LCS 3	LSS 32A	-	LSP 3A	SPP 3-4	NZ 83	L-W 2.5
C4 ...1304	LCL 08-NX	LCS 3-NX	-	LST 2.51.8	LSP 3B	SPP 3-3L	NZ 83	L-W 2.5

TCLNR/L TDJNR/L

T-holder type



TCLNR/L



TDJNR/L

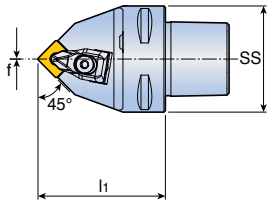
Approach angle	Designation	Dimension (mm)			Insert	
		SS	f	l1		
95°	**C4-TCLNR/L 27050-12**	40	27	50	CN...1204...	A244-A252, A314-A315, A328
	C5-TCLNR/L 35060-12	50	35	60		
	C6-TCLNR/L 45065-12	63	45	65		
	C4-TCLNR/L 27055-16	40	27	55	CN...1606...	
	C5-TCLNR/L 35060-19	50	35	60	CN...1906...	
	C6-TCLNR/L 45065-19	63	45	65		
93°	**C4-TDJNR/L 27055-1504**	40	27	55	DN...1504...	A253-A257, A316, A329
	C4-TDJNR/L 27055-1506	40	27	55	DN...1506...	
	C5-TDJNR/L 35060-1504	50	35	60	DN...1504...	
	C5-TDJNR/L 35060-1506	50	35	60	DN...1506...	
	C6-TDJNR/L 45065-1504	63	45	65	DN...1504...	
	C6-TDJNR/L 45065-1506	63	45	65	DN...1506...	

Spare parts

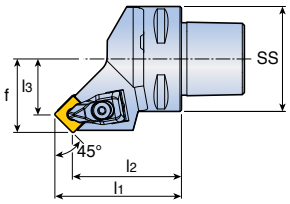
Designation	Clamp	Clamp screw	Shim		Shim screw	Spring	Nozzle	Wrench
C4 ...12	DLM 4	DLS 4	TSC 44	-	SO 40050I	DSP 4	NZ 83	L-W 3
...12	DLM 4	DLS 4	TSC 44	-	SO 40050I	DSP 4	NZ 104	L-W 3
...1504	DLM 4	DLS 4	-	TSD 44	SO 40050I	DSP 4	NZ 83	L-W 3
C4 ...1506	DLM 4	DLS 4	-	TSD 43	SO 40050I	DSP 4	NZ 83	L-W 3
...1506	DLM 4	DLS 4	-	TSD 43	SO 40050I	DSP 4	NZ 104	L-W 3
...16	DLM 5	DLS 5	TSC 54	-	SO 50090I	DSP 5	NZ 83	L-W 4
...19	DLM 6	DLS 5	LSC 63	-	SO 80180I	DSP 5	NZ 104	L-W 4

TSDNN TSSNR/L

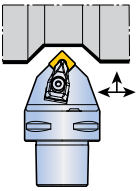
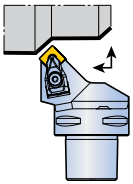
T-holder type



TSDNN



TSSNR/L

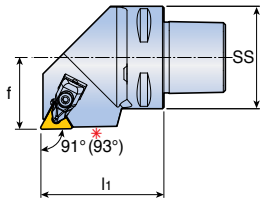
Approach angle	Designation	Dimension (mm)					Insert
		SS	f	l1	l2	l3	
45°	**C4-TSDNN 00050-12**	40	-	50	-	-	SN...1204... A261-A267, A319, A320, A331
	**C5-TSDNN 00060-12**	50	-	60	-	-	
	C6-TSDNN 00065-12	63	-	65	-	-	
45°	**C4-TSSNR/L 27042-12**	40	27	50.3	42	18.7	
	**C5-TSSNR/L 35052-12**	50	35	60.3	52	26.7	
	C6-TSSNR/L 45056-12	63	45	64.3	56	36.7	

Spare parts

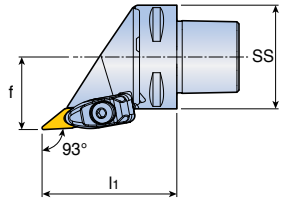
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Nozzle	Wrench	
C4...12	DLM 4	DLS 4	TSS 44	SO 40050I	DSP 4	NZ 83	L-W 3	
...12	DLM 4	DLS 4	TSS 44	SO 40050I	DSP 4	NZ 104	L-W 3	

TTGNR/L TTJNR/L TVJNR/L

T-holder type

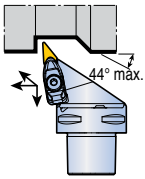


TTGNR/L TTJNR/L



TVJNR/L

Approach angle	Designation	Dimension (mm)			Insert
		SS	f	l1	
91°(*93°)	**C4-TTGNR/L 27050-16**	40	27	50	TN...1604... A268-A273, A322, A332
	C5-TTGNR/L 35060-16	50	35	60	
	C6-TTGNR/L 45065-16	63	45	65	
	C4-TTJNR/L 27050-16	40	27	50	
	C5-TTJNR/L 35060-16	50	35	60	
	C6-TTJNR/L 45065-16	63	45	65	
93°	**C4-TVJNR/L 27062-16**	40	27	62	VN...1604... A274-A275, A323, A333
	C5-TVJNR/L 35065-16	50	35	65	
	C6-TVJNR/L 45068-16	63	45	68	



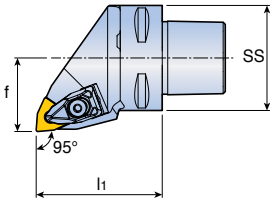
• *Marked: Approach angle of TTJNR/L is 93 degrees

Spare parts

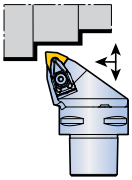
Designation	Clamp		Clamp screw	Shim		Shim screw	Spring	Nozzle	Wrench
C4...TT...16	DLM 3	-	DLS 3	TST 33	-	SO 35080I	DSP 3	NZ 83	L-W 2.5
...TT...16	DLM 3	-	DLS 3	TST 33	-	SO 35080I	DSP 3	NZ 104	L-W 2.5
C4...TV...16	-	DLM 3V	DLS 5	-	TSV 33	SO 35080I	DSP 5	NZ 83	L-W 4
...TV...16	-	DLM 3V	DLS 5	-	TSV 33	SO 35080I	DSP 5	NZ 104	L-W 4

TWLNR/L

T-holder type



TWLNR/L

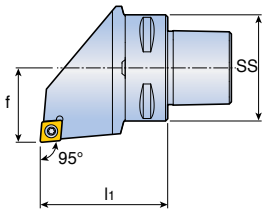
Approach angle	Designation	Dimension (mm)			Insert	
		SS	f	l1		
95°	**C4-TWLNR/L 27050-06**	40	27	50	WN...G 0604...	A277-A279, A323, A324
	**C4-TWLNR/L 27050-08**	40	27	50	WN...0804...	
	C5-TWLNR/L 35060-08	50	35	60		
	C6-TWLNR/L 45065-08	63	45	65		

Spare parts

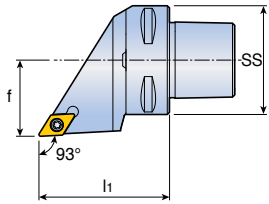
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Nozzle	Wrench	
...06	DLM 3	DLS 3	PSW 32	SO 40090I	DSP 3	NZ 83	L-W 2.5	
C4...08	DLM 4	DLS 4	TSW 44	SO 40050I	DSP 4	NZ 83	L-W 3	
...08	DLM 4	DLS 4	TSW 44	SO 40050I	DSP 4	NZ 104	L-W 3	

SCLCR/L SDJCR/L

Screw type

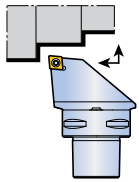


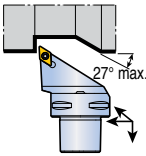
SCLCR/L



SDJCR/L

Approach angle	Designation	Dimension (mm)			Insert	
		SS	f	l1		
95°	**C4-SCLCR/L 27050-09**	40	27	50	CC...T 09T3...	A282-A284, A335
	C5-SCLCR/L 35060-09	50	35	60		
	C6-SCLCR/L 45065-09	63	45	65		
	C4-SCLCR/L 27050-12	40	27	50	CC...T 1204...	
	C5-SCLCR/L 35060-12	50	35	60		
	C6-SCLCR/L 45065-12	63	45	65		
93°	**C4-SDJCR/L 27050-11**	40	27	50	DC...T 11T3...	A286-A288, A336
	C5-SDJCR/L 35060-11	50	35	60		
	C6-SDJCR/L 45065-11	63	45	65		



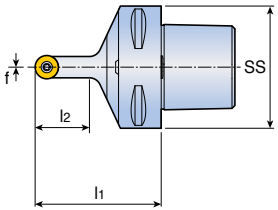


Spare parts

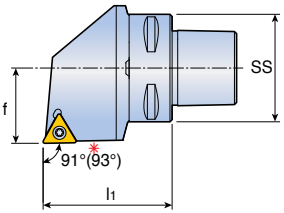
Designation	Screw	Shim		Shim screw	Nozzle	Wrench		
								
C4...09	SO 35124I	SSC 32	-	SO 50090S	NZ 83	T 15		
...09	SO 35124I	SSC 32	-	SO 50090S	NZ 104	T 15		
C4...11	SO 35124I	-	SSD 32	SO 50090S	NZ 83	T 15		
...11	SO 35124I	-	SSD 32	SO 50090S	NZ 104	T 15		
C4...12	SO 45130I	-	SSC 43N	SO 60105S	NZ 83	T 20		
...12	SO 45130I	-	SSC 43N	SO 60105S	NZ 104	T 20		

SRDCN STGCR/L STJCR/L

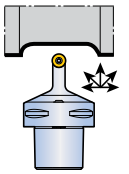
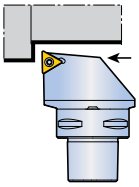
Screw type



SRDCN



STGCR/L STJCR/L

Approach angle	Designation	Dimension (mm)				Insert
		SS	f	l1	l2	
45°	**C4-SRDCN 00050-10A**	40	-	50	25	RC...T 10T300 A290
	**C5-SRDCN 00060-10A**	50	-	60	25	
	C6-SRDCN 00065-10A	63	-	65	25	
	C4-SRDCN 00050-12A	40	-	50	28	RC...T 120400
	C5-SRDCN 00060-12A	50	-	60	28	
	C6-SRDCN 00065-12A	63	-	65	28	
91°(*93°)	**C4-STGCR/L 27050-16**	40	27	50	-	TC...T 16T3... A294-A295, A339, A340
	**C5-STGCR/L 35060-16**	50	35	60	-	
	C4-STJCR/L 27050-16	40	27	50	-	
	C5-STJCR/L 35060-16	50	35	60	-	

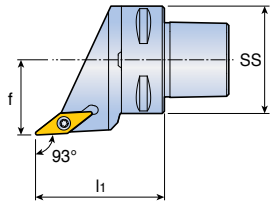
• *Marked: Approach angle of STJCR/L is 93 degrees

Spare parts

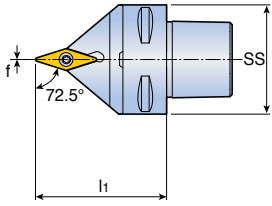
Designation	Screw	Shim		Shim screw	Nozzle	Wrench		
								
C4...10A	TS 40097I	TRC 3-0	-	SR TC-3	NZ 83	T 15		
...10A	TS 40097I	TRC 3-0	-	SR TC-3	NZ 104	T 15		
C4...12A	SO 40050I	TRC 4-0	-	SR TC-4S	NZ 83	T 15		
...12A	SO 40050I	TRC 4-0	-	SR TC-4S	NZ 104	T 15		
C4...16	SO 35124I	-	SST 32	SO 50090S	NZ 83	T 15		
...16	SO 35124I	-	SST 32	SO 50090S	NZ 104	T 15		

SVJBR/L SVVBN

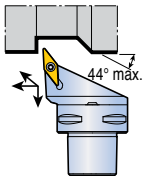
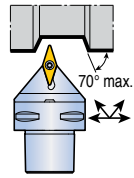
Screw type



SVJBR/L



SVVBN

Approach angle	Designation	Dimension (mm)			Insert
		SS	f	l1	
93°	**C4-SVJBR/L 27050-16**	40	27	50	VB...T 1604... A300-A301, A341
	**C5-SVJBR/L 35060-16**	50	35	60	
	C6-SVJBR/L 45065-16	63	45	65	
72.5°	**C4-SVVBN 00050-16**	40	-	50	
	**C5-SVVBN 00060-16**	50	-	60	
	C6-SVVBN 00065-16	63	-	65	

Spare parts

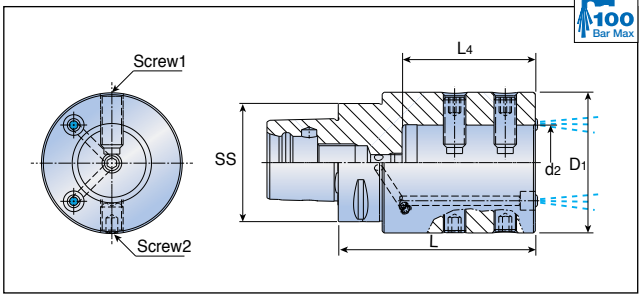
Designation	Screw	Shim	Shim screw	Nozzle	Wrench			
								
C4...16	SO 35124I	SSV 32	TS 5035062S	NZ 83	T 15			
...16	SO 35124I	SSV 32	TS 5035062S	NZ 104	T 15			

C...ABB

C-ADAPTER

Adapters with C-ADAPTER exchangeable shanks for boring bars with reduction sleeves





Designation	Dimension (mm)				
	SS	d2	D1	L	L4
C4 ABB 25-60	40	25	63	100	60
C5 ABB 25-60	50	25	63	100	60
C6 ABB 25-60	63	25	63	100	60
ABB 40-70	63	40	75	105	71
C8 ABB 25-60	80	25	63	100	60
ABB 40-72	80	40	75	105	71

Spare parts

Designation	Stopper screw	Screw1	Screw2	Wrench1	Cooling nozzle	Wrench2
C...60	SR M10x6 DIN913(1)	SR M10x20 DIN915 45H(3)	SR M10x12 DIN1835-B(2)	L-W 5*	SATZ-M12x1-M6	HP M12*
C...70/72	SR M10x6 DIN913(1)	SR M12x30 DIN915 45H(3)	SR M12x16 DIN1835-B(2)	L-W 6*	SATZ-M12x1-M6	HP M12*

- *Marked: Optional, should be ordered separately
- (1) Rear stopper screw (2) Used on A-type sleeves (3) Used on B-type sleeves

SC...T...A/B

Reduction sleeves for bars, used in holders with exchangeable adaptation



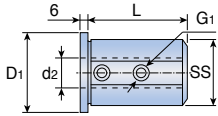


Fig. 1

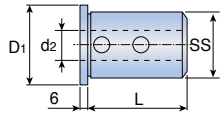


Fig. 2

Designation	Dimension (mm)					Fig.
	SS	d2	D1	L	G1	
SC 25T6A	25	6	31	56	M6	1
25T8A	25	8	31	56	M8	1
25T10A	25	10	31	56	M8	1
25T12A	25	12	31	56	M8	1
25T16B	25	16	31	56	-	2
25T20B	25	20	31	56	-	2
SC 40T6A	40	6	46	60	M6	1
40T8A	40	8	46	60	M8	1
40T10A	40	10	46	60	M8	1
40T12A	40	12	46	60	M8	1
40T16B	40	16	46	60	-	2
40T20B	40	20	46	60	-	2
40T25B	40	25	46	60	-	2
40T32B	40	32	46	60	-	2
SC 50T6A	50	6	56	70	M6	1
50T8A	50	8	56	70	M8	1
50T10A	50	10	56	70	M8	1
50T12A	50	12	56	70	M8	1
50T16B	50	16	56	80	-	2
50T20B	50	20	56	80	-	2
50T25B	50	25	56	80	-	2
50T32B	50	32	56	80	-	2

Spare parts

Designation	Stopper screw	Wrench				
						
...25T/50T 6A	SR M6x6DIN916 45H	L-W 3*				
...25T 8A/10A/12A	SR M8x6DIN916 45H	L-W 4*				
...50T 8A/10A/12A	SR M8x6DIN916 45H	L-W 4*				
...40T 6A	SR M6x10 DIN1835-B	L-W 3*				
...40T 8A/10A/12A	SR M8x10 DIN1835-B	L-W 4*				

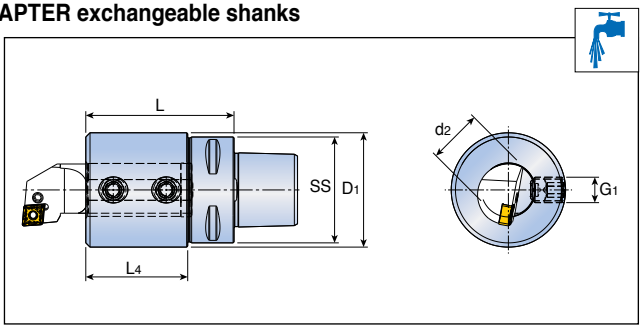
• *Marked: Optional, should be ordered separately

C...ADI

C-ADAPTER

Holders for boring bars with C-ADAPTER exchangeable shanks





Designation		Dimension (mm)					
		SS	L	L4	d2	D1	G1
C3	ADI 10	32	50	20	10	36	M6
	ADI 12	32	50	21.5	12	36	M8
	ADI 16	32	50	29.5	16	36	M8
C4	ADI 10	40	50	20	10	36	M6
	ADI 12	40	50	24	12	36	M8
	ADI 16	40	50	32	16	36	M8
	ADI 20	40	70	49	20	55	M12
	ADI 25	40	70	45	25	54	M12
C5	ADI 10	50	60	26	10	36	M6
	ADI 12	50	60	26	12	36	M8
	ADI 16	50	60	32	16	36	M8
	ADI 20	50	75	49	20	55	M12
	ADI 25	50	85	60	25	60	M12
	ADI 32	50	100	76	32	68	M12
C6	ADI 12	60	65	36	12	36	M8
	ADI 16	60	65	36	16	36	M8
	ADI 20	60	65	40	20	36	M10
	ADI 25	60	76	51	25	54	M12
	ADI 32	60	100	76	32	68	M12
	ADI 40	60	100	76	40	98	M12
	ADI 50	60	115	76	50	98	M12

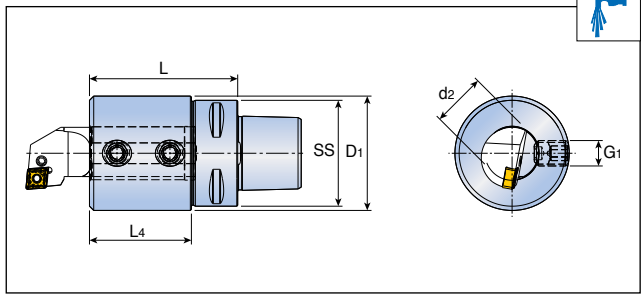
• Use the tools with "AD" suffix. Regular tools should be shortened.

C...ADI

C-ADAPTER

Holders for boring bars with C-ADAPTER exchangeable shanks





Designation		Dimension (mm)					
		SS	L	L_4	d_2	D_1	G_1
C8	**ADI 12**	80	70	36	12	36	M8
	ADI 16	80	70	36	16	36	M8
	ADI 20	80	70	40	20	36	M10
	ADI 25	80	80	51	25	54	M12
	ADI 32	80	110	86	32	68	M12
	ADI 40	80	115	86	40	98	M12
	ADI 50	80	115	86	50	98	M12

• Use the tools with "AD" suffix. Regular tools should be shortened.

Spare parts

Designation	Screw	Wrench				
...10	SR M6x10 DIN1835B	L-W 3*				
...12/16	SR M8x10 DIN1835-B	L-W 4*				
...20	SR M10x12 DIN1835-B	L-W 5*				
...25/32/40/50	SR M12x16 DIN1835-B	L-W 6*				

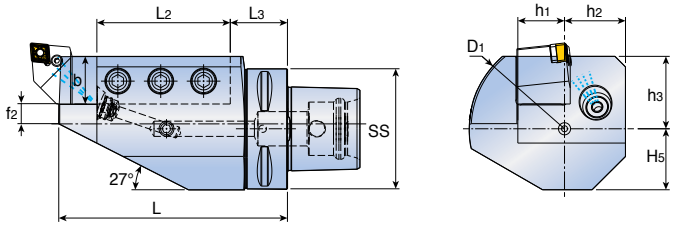
• *Marked: Optional, should be ordered separately

C...ASHR/L

C-ADAPTER

Holders with C-ADAPTER exchangeable shanks for external square-shank tools

100 Bar Max



Left-hand shown

Designation	Dimension (mm)										
	SS	L	L2	L3	f2	h1	b	h2	h3	H5	D1
C4 ASHR/L 16-1	40	104	70	34	16	16	16	20	23	20.5	60
C5 ASHR/L 20-1	50	98	63.5	24.5	10	20	20	33	30	29	90
C6 ASHR/L 20-1	63	100	63.5	36.5	20	20	20	33	30	29	90
ASHR/L 25-1	63	120	70	30	13	25	25	32	38	32	100
C8 ASHR/L 32-1	80	140	95	35	8	32	32	32	40	40	110

Spare parts

Designation	Screw	Wrench1	Cooling nozzle	Wrench2
...16-1	SR M8x16 DIN915 45H	L-W 5*	SATZ-M10x1-M5	HP M10*
...20-1	SR M10x25 DIN915 45H	L-W 5*	SATZ-M10x1-M5	HP M10*
...25-1/32-1	SR M12x30 DIN915 45H	L-W 6*	SATZ-M12x1-M6	HP M12*

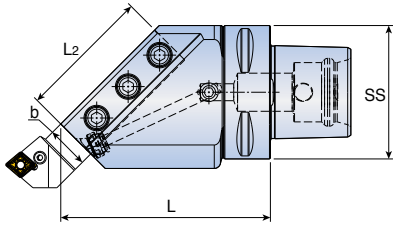
• *Marked: Optional, should be ordered separately

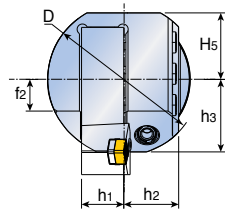
C...ASHR/L-45

C-ADAPTER

Holders with C-ADAPTER shanks carrying square shank tools for 45° mounting on turn-mill machines

100 Bar Max





A left-hand tool in a right-hand adapter are shown

Designation	Dimension (mm)								
	SS	h1	b	L2	L	h2	h3	H5	f2
C5 ASHR/L 20-45	50	20	20	-	127	26	36	31.5	15
C6 ASHR/L 20-45	63	20	20	70	102	33	41.6	38	15
ASHR/L 25-45	63	25	25	70	102	33	41.6	38	15
C8 ASHR/L 32-45	80	32	32	100	140	40	50	60	17

Spare parts

Designation	Screw	Wrench1	Cooling nozzle	Wrench2
...20-45	SR M10x25 DIN915 45H	L-W 5*	SATZ-M10x1-M5	HP M10*
...25-45	SR M12x30 DIN915 45H	L-W 6*	SATZ-M10x1-M5	HP M10*
...32-45	SR M12x30 DIN915 45H	L-W 6*	SATZ-M12x1-M6	HP M12*

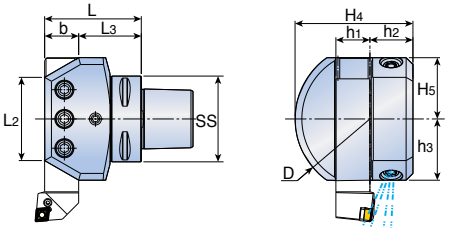
• *Marked: Optional, should be ordered separately

C...ASHA

C-ADAPTER

Perpendicular holders with C-ADAPTER shanks for external square-shank tools

100 Bar Max



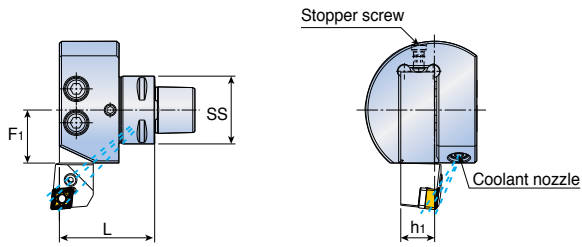
Designation	Dimension (mm)										
	SS	h1	b	L	L2	L3	h3	H5	h2	H4	D
C5 **ASHA 20**	50	20	20	58	46	38	38	38	31.5	76.5	90
C6 **ASHA 20**	63	20	20	60	46	40	38	38	31.5	76.5	90
ASHA 25	63	25	25	71	61	46	45	45	31.6	86.6	110
C8 **ASHA 32**	80	32	32	85	80	53	55	55	30	95	142

Spare parts

Designation	Screw	Wrench1	Cooling nozzle	Wrench2
...20	SR M10x25 DIN915 45H	L-W 5*	SATZ-M10x1-M5	HP M10*
...25	SR M12x30 DIN915 45H	L-W 6*	SATZ-M12x1-M6	HP M12*
...32	SR M12x30 DIN915 45H	L-W 6*	SATZ-M12x1-M6	HP M12*

• *Marked: Optional, should be ordered separately

Holders with C-ADAPTER exchangeable shanks for external square-shank tools



Left-hand shown

Designation	Dimension (mm)			
	SS	F1	h1	L
C3 ADE-16R/L	32	25	16	45
C4 ADE-20R/L	40	25	20	49.2
C5 ADE-20R/L	50	25	20	55.2

Spare parts

Designation	Stopper screw	Wrench1	Screw1	Screw2	Wrench2	Cooling nozzle
C3...16R/L	SR M6x8DIN916 45H(1)	L-W 3*	SR M10x20DIN915 45H	SR M6x6DIN916 45H	L-W 5*	SATZ-M8x1-M3
C4...20R/L	SR M8x10DIN913 45H(1)	L-W 4*	SR M10x20DIN912 12.9	-	L-W 8*	EZ 125
C5...20R/L	SR M8x10DIN916 45H(1)	L-W 4*	SR M10x16	-	L-W 8*	EZ 125

• *Marked: Optional, should be ordered separately (1)Marked: Stopper screw

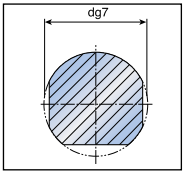
Boring Bar Designation System

S	32	S	-	C	T	F	P	R	-	16	-	
1	2	3		4	5	6	7	8		9		10

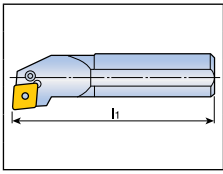
1 Boring bar

S	Steel shank
A	Coolant through steel shank
C	Carbide shank
E	Coolant through carbide shank
X	Special

2 Bar diameter

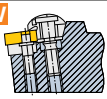


3 Tool length

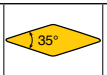


K	125	U	350
M	150	V	400
Q	180	W	450
R	200	Y	500
S	250	X	Special
T	300		

4 Clamping system

P	C	S	M	T	W	H
						
Lever lock	Top clamp	Screw clamp	Multi lock	T-holder	Wedge clamp	Hook lever

5 Insert shape

									
C	D	E	H	K	R	S	T	V	W

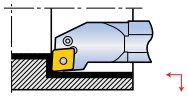
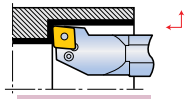
6 Approach angle

						
L	K	U	Z	F	Q	P

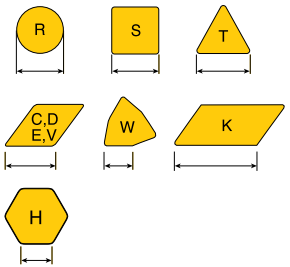
7 Insert clearance angle

	
N	B
	
C	P

8 Hand of tool

R	 Right hand *Left handed insert used
L	 Left hand *Right handed insert used

9 Cutting edge length



See page A243

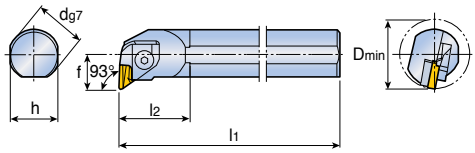
10 Manufacturer's type designation

Unique to manufacturer

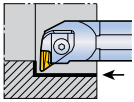
TaeguTec Member IMC Group

S-CKUNR/L

Top clamp type



S-CKUNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
93°	**S32T CKUNR/L 16**	32	30	300	45	22	44	KNUX 1604...R/L A259
	**S40T CKUNR/L 16**	40	38	300	55	27	54	
	S40V CKUNR/L 16	40	38	400	55	27	54	
	S50U CKUNR/L 16	50	48	350	60	35	67.2	

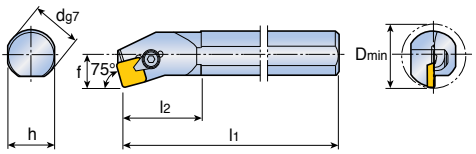
Spare parts

Designation	Clamp	Screw	Clamp spring	Shim	Shim screw	Pin & spring	Wrench	
								
...16	CL 16KR/L	CLS 16K	KSP 90	CSK 1604R/L	FH M3x0.5 x10	KSP 48 KP 48S	L-W 4	

TaeguTec

S-CSKPR/L

Top clamp type



S-CSKPR/L

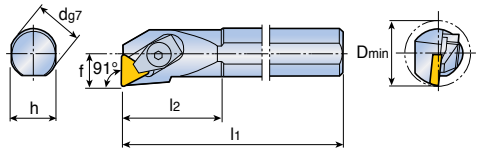
Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
75°	**S16R CSKPR/L 09**	16	15	200	30	11	20	SPMR, SP...N 0903...
	S20S CSKPR/L 09	20	18	250	32	13	25	A292, A325,
	S20R CSKPR/L 12	20	18	200	34	13	25	SPMR, SP...N 1203... A338
	S25T CSKPR/L 12	25	23	300	42	17	32	
	S32U CSKPR/L 12	32	30	350	45	22	40	

Spare parts

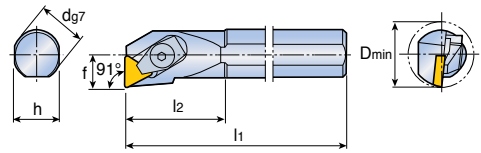
Designation	Clamp	Screw	Snap ring	Shim	Shim pin	Wrench		
...09	CL 2C	CLS 2C	CSR 2C	-	-	L-W 2.5		
S20R...12	CL 3C	CLS 3C	CSR 2	CSS 42	CSP 3	L-W 3		
S25T ...12	CL 3	CLS 3S	WSR 4	CSS 42	CSP 3	L-W 3		
S32U...12	CL 3	CLS 3	WSR 4	CSS 42	CSP 3	L-W 3		

S-CTFCR/L S-CTFPR/L

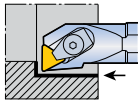
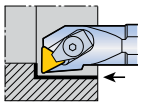
Top clamp type



S-CTFCR/L



S-CTFPR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
91°	**S10K CTFCR/L 06**	10	9	125	25	6.5	12	TCGR 0601...
								
91°	**S10K CTFPR/L 06**	10	9	125	25	6.5	12	TPGR 0601...
	S12M CTFPR/L 06	12	11	150	30	9	16	
	**S12M CTFPR/L 09**	12	11	150	25	9	16	TPGN, TP...R 0902...
	S16R CTFPR/L 09	16	15	200	25	11	20	
	S12M CTFPR/L 11	12	11	150	30	9	16	TPMR, TP...N 1103...
	S16M CTFPR/L 11	16	15	150	30	11	20	
	S16R CTFPR/L 11	16	15	200	30	11	20	
	S20S CTFPR/L 11	20	18	250	35	13	25	
	S16R CTFPR/L 16	16	15	200	40	11	20	TPMR, TP...N 1603...
	S20S CTFPR/L 16	20	18	250	50	13	25	
	S25T CTFPR/L 16	25	23	300	40	17	32	
	S32T CTFPR/L 16	32	30	300	45	22	40	
	S40T CTFPR/L 16	40	37	300	70	27	50	
	S50U CTFPR/L 16	50	47	350	70	35	63	
	S40T CTFPR/L 22	40	37	300	60	27	50	TPMR, TP...N 2204...
	S50U CTFPR/L 22	50	47	350	70	35	63	

A296, A298-A299, A325, A339-A340

Spare parts

Designation	Clamp	Screw	Snap ring	Shim	Shim pin	Wrench		
								
...06	CL 1.25	CLS 1.25	CSR 1.25	-	-	L-W 1.5		
...09	CL 1.25	CLS 1.25	CSR 1.25	-	-	L-W 1.5		
...11	CL 2C	CLS 2C	CSR 2C	-	-	L-W 2.5		
S16R...16	CL 3C	CLS 3C	CSR 2	-	-	L-W 3		
S20S...16	CL 3C	CLS 3C	CSR 2	-	-	L-W 3		
S25T ...16	CL 3	CLS 3S	WSR 4	-	-	L-W 3		
...16	CL 3	CLS 3	WSR 4	CST 32	CSP 3	L-W 3		
...22	CL 4	CLS 4	CSR 4	CST 43	CSP 16K	L-W 4		

S-HCLNR/L A-HCLNR/L

Hook lever type

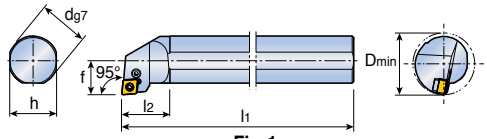


Fig.1

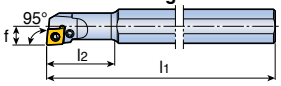
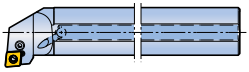


Fig.2

S-HCLNR/L



A-HCLNR/L

Approach angle	Designation	Dimension (mm)						Fig	Insert	
		dg7	h	l1	l2	f	Dmin			
95°	✓ **S16Q HCLNR/L 0904**	16	15	180	25	11	20	1	CN... 0904...	A244, A246-A250, A252
	✓ **S20Q HCLNR/L 0904**	20	18	180	28	13	25	1		
	✓ **S20Q HCLNR/L 0904-D20**	20	18	180	40	11	20	2		
	✓ **S25R HCLNR/L 0904**	25	23	200	31	17	32	1		
	✓ **S32S HCLNR/L 0904**	32	30	250	31	22	40	1		
	✓ **S40T HCLNR/L 0904**	40	37	300	55	27	50	1		
	✳ **S32S HCLNR/L 1205**	32	30	250	45	22	40	1	CNMX 1205...HB	
	✳ **S40T HCLNR/L 1205**	40	37	300	55	27	50	1		
95°	✓ **A16Q HCLNR/L 0904**	16	15	180	25	11	20		CN... 0904...	
	✓ **A20Q HCLNR/L 0904**	20	18	180	28	13	25			
	✓ **A25R HCLNR/L 0904**	25	23	200	31	17	32			
	✓ **A32S HCLNR/L 0904**	32	30	250	31	22	40			
	✳ **A32S HCLNR/L 1205**	32	30	250	45	22	40		CNMX 1205...HB	
	✳ **A40T HCLNR/L 1205**	40	37	300	55	27	50			

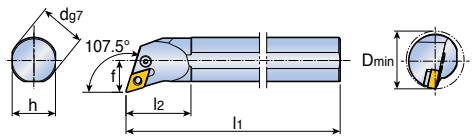
• ✓ Marked: For RHINORUSH insert ✳Marked: For TURNRUSH insert

Spare parts

Designation	Lever	Screw	Shim		Shim pin	Shim pin punch	Snap ring	Wrench
S ...0904	LCL 09B-NX	LCS 3B	-	-	-	-	LSR 3B	L-W 2
S ...0904...D	LCL 09B-NX	LCS 3B	-	-	-	-	LSR 3B	L-W 2
S32S...0904	LCL 09-NX	LCS 3	LSC 32	-	LSP 3A	-	-	L-W 2.5
S40T...0904	LCL 09-NX	LCS 3	LSC 32	-	LSP 3A	-	-	L-W 2.5
A ...0904	LCL 09B-NX	LCS 3B	-	-	-	-	LSR 3B	L-W 2
A32S...0904	LCL 09-NX	LCS 3	LSC 32	-	LSP 3A	-	-	L-W 2.5
...1205	LCL 12-NX	LCS 5	-	LSC 42-NXS	LSP 4	SPP 3-4	-	L-W 3

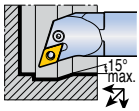
S-HDQNR/L

Hook lever type



S-HDQNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
107.5°	✓ **S32S HDQNR/L 1305**	32	30	250	45	22	40	DN... 1305... A253-A258



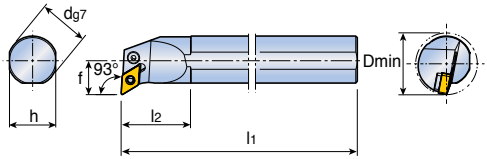
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Spare parts

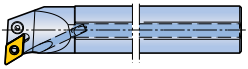
Designation	Lever	Screw	Shim	Shim pin	Wrench			
...1305	LCL 11-NX	LSC 4S	LSD 3.52B	LSP 4	L-W 3			

S-HDUNR/L A-HDUNR/L

Hook lever type

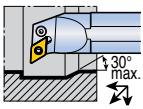


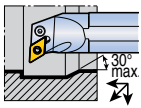
S-HDUNR/L



A-HDUNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
93°	✓ **S32S HDUNR/L 1305**	32	30	250	45	22	40	DN... 1305... A253-A258
	✓ **S40T HDUNR/L 1305**	40	37	300	55	27	50	
93°	✓ **A32S HDUNR/L 1305**	32	30	250	45	22	40	
	✓ **A40T HDUNR/L 1305**	40	37	300	55	27	50	





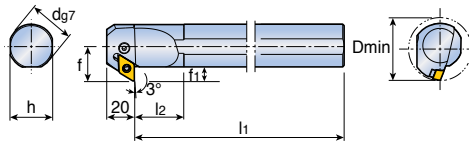
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Spare parts

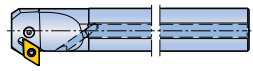
Designation	Lever	Screw	Shim	Shim pin	Wrench			
								
...1305	LCL 11-NX	LCS 4S	LSD 3.52B	LSP 4	L-W 3			

S-HDZNR/L A-HDZNR/L

Hook lever type

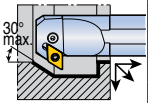


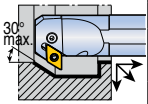
S-HDZNR/L



A-HDZNR/L

Approach angle	Designation	Dimension (mm)							Insert
		dg7	h	l1	l2	f	f1	Dmin	
93°	✓ **S32S HDZNR/L 1305**	32	30	250	35	25	10.5	45	DN... 1305... A253-A258
	✓ **S40T HDZNR/L 1305**	40	37	300	40	29	10.5	50	
93°	✓ **A32S HDZNR/L 1305**	32	30	250	35	25	10.5	45	
	✓ **A40T HDZNR/L 1305**	40	37	300	40	29	10.5	50	





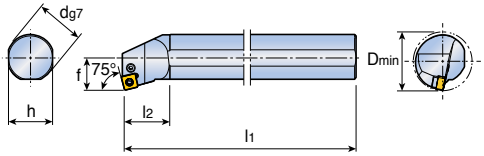
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Spare parts

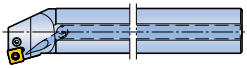
Designation	Lever	Screw	Shim	Shim pin	Wrench			
								
...1305	LCL 11-NX	LCS 4S	LSD 3.52B	LSP 4	L-W 3			

S-HSKNR/L A-HSKNR/L

Hook lever type



S-HSKNR/L



A-HSKNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
75°	✓ **S25R HSKNR/L 0904**	25	23	200	31	17	32	SN... 0904... A263-A266
	✓ **S32S HSKNR/L 0904**	32	30	250	31	22	40	
75°	✓ **A25R HSKNR/L 0904**	25	23	200	31	17	32	
	✓ **A32S HSKNR/L 0904**	32	30	250	31	22	40	

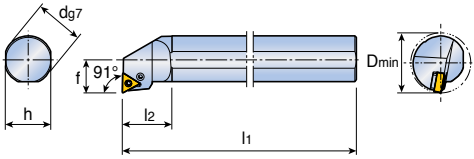
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Spare parts

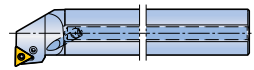
Designation	Lever	Screw	Shim	Shim pin	Snap ring	Wrench		
...25R ...0904	LCL 09B-NX	LCS 3B	-	-	LSR 3B	L-W 2		
...32S ...0904	LCL 09-NX	LCS 3	LSS 32	LSP 3A	-	L-W 2.5		

S-HTFNR/L A-HTFNR/L

Hook lever type



S-HTFNR/L



A-HTFNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
91°	✓ **S16Q HTFNR/L 1304**	16	15	180	25	11	20	TN... 1304... A268-A273
	✓ **S20Q HTFNR/L 1304**	20	18	180	28	13	25	
	✓ **S25R HTFNR/L 1304**	25	23	200	33	17	32	
	✓ **S32S HTFNR/L 1304**	32	30	250	33	22	40	
91°	✓ **A16Q HTFNR/L 1304**	16	15	180	25	11	20	
	✓ **A20Q HTFNR/L 1304**	20	18	180	28	13	25	
	✓ **A25R HTFNR/L 1304**	25	23	200	33	17	32	
	✓ **A32S HTFNR/L 1304**	32	30	250	33	22	40	

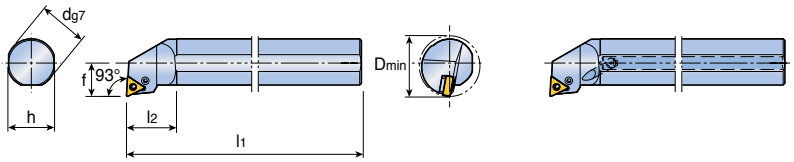
• ✓ Marked: For RHINORUSH insert

Spare parts

Designation	Lever	Screw	Shim	Shim pin	Snap ring	Wrench		
...1304	LCL 08B-NX	LCS 3B	-	-	LSR 3B	L-W 2		
...32S ...1304	LCL 08-NX	LCS 3-NX	LST 2.51.8B	LSP 3B	-	L-W 2.5		

S-HTUNR/L A-HTUNR/L

Hook lever type



S-HTUNR/L A-HTUNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
93°	✓ S16Q HTUNR/L 1304	16	15	180	25	11	20	TN... 1304... A268-A273
	✓ S20Q HTUNR/L 1304	20	18	180	28	13	25	
	✓ S25R HTUNR/L 1304	25	23	200	33	17	32	
	✓ S32S HTUNR/L 1304	32	30	250	33	22	40	
93°	✓ A16Q HTUNR/L 1304	16	15	180	25	11	20	
	✓ A20Q HTUNR/L 1304	20	18	180	28	13	25	
	✓ A25R HTUNR/L 1304	25	23	200	33	17	32	
	✓ A32S HTUNR/L 1304	32	30	250	33	22	40	

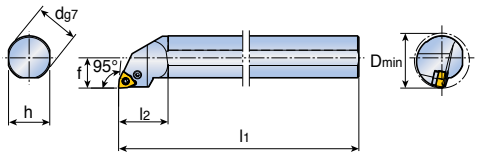
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Spare parts

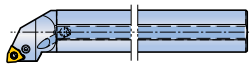
Designation	Lever	Screw	Shim	Shim pin	Snap ring	Wrench		
...1304	LCL 08B-NX	LCS 3B	-	-	LSR 3B	L-W 2		
...32S ...1304	LCL 08-NX	LCS 3-NX	LST 2.51.8B	LSP 3B	-	L-W 2.5		

S-HWLNR/L A-HWLNR/L

Hook lever type



S-HWLNR/L



A-HWLNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
95°	✓ **S16Q HWLNR/L 0604**	16	15	180	30	11	20	WN...X 0604... A279-A280
	✓ **S20Q HWLNR/L 0604**	20	18	180	33	13	25	
	✓ **S25R HWLNR/L 0604**	25	23	200	36	17	32	
	✓ **S32S HWLNR/L 0604**	32	30	250	36	22	40	
95°	✓ **A16Q HWLNR/L 0604**	16	15	180	30	11	20	
	✓ **A20Q HWLNR/L 0604**	20	18	180	33	13	25	
	✓ **A25R HWLNR/L 0604**	25	23	200	36	17	32	
	✓ **A32S HWLNR/L 0604**	32	30	250	36	22	40	

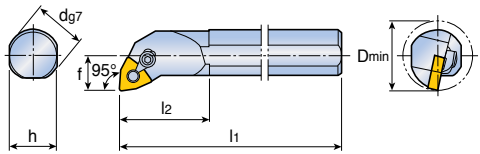
• ✓ Marked: For RHINORUSH insert

Spare parts

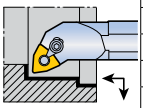
Designation	Lever	Screw	Shim	Shim pin	Snap ring	Wrench		
...0604	LCL 09B-NX	LCS 3B	-	-	LSR 3B	L-W 2		
...32S ...0604	LCL 09-NX	LCS 3	LSW 32	LSP 3A	-	L-W 2.5		

S-MWLNR/L

Multi lock type



S-MWLNR/L

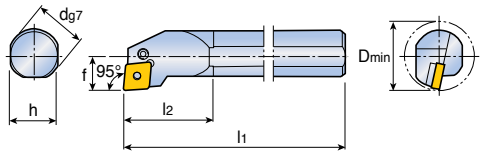
Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
95°	**S25R MWLNR/L 08**	25	23	200	42	17	32	WN... 0804... A277-A279, A323, A324
	**S32S MWLNR/L 08**	32	30	250	45	22	44	

Spare parts

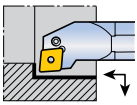
Designation	Clamp	Screw	Snap ring	Lock pin	Wrench			
								
...08	CL 2	CLS 2	CSR 2	MLP 4S	L-W 2.5			

S-PCLNR/L

Lever lock type



S-PCLNR/L

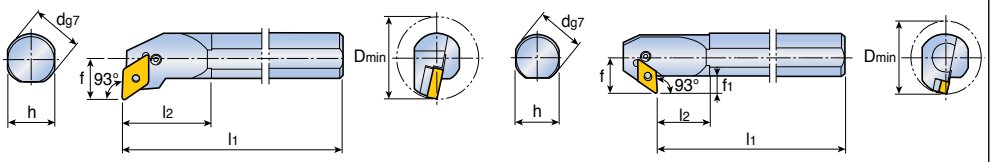
Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
95°	**S25T PCLNR/L 12**	25	23	300	40	17	32	CN...1204...
	**S32S PCLNR/L 12**	32	30	250	45	22	40	A244-A252, A314-A315, A328
	S32T PCLNR/L 12	32	30	300	45	22	40	
	S40T PCLNR/L 12	40	37	300	55	27	50	
	S50U PCLNR/L 12	50	47	350	70	35	63	
	S50U PCLNR/L 16	50	47	350	70	35	63	CN...1606...
	S50U PCLNR/L 19	50	47	350	70	35	63	CN...1906...

Spare parts

Designation	Lever	Screw	Shim	Shim pin	Snap ring	Wrench		
								
S25T ...12	LCL 4B	LCS 4B	-	-	LSR 4B	L-W 2.5		
S32 ...12	LCL 4	LCS 4S	LSC 42	LSP 4	-	L-W 3		
...12	LCL 4	LCS 4	LSC 42	LSP 4	-	L-W 3		
...16	LCL 5	LCS 5	LSC 53	LSP 5	-	L-W 3		
...19	LCL 6D	LCS 6	LSC 63	LSP 6	-	L-W 4		

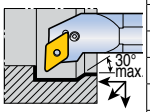
S-PDUNR/L S-PDZNR/L

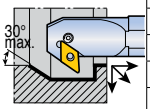
Lever lock type



S-PDUNR/L S-PDZNR/L

Approach angle	Designation	Dimension (mm)							Insert
		dg7	h	l1	l2	f	f1	Dmin	
93°	**S32T PDUNR/L 15**	32	30	300	45	22	-	40	DN...1506...
	S40T PDUNR/L 15	40	37	300	55	27	-	50	
	S50U PDUNR/L 15	50	47	350	70	35	-	63	
	S32T PDUNR/L 15-A	32	30	300	45	22	-	40	DN...1504...
93°	**S32T PDZNR/L 15**	32	30	300	29.5	25	10.5	45	DN...1506...
	S40T PDZNR/L 15	40	37	300	35	29	10.5	50	
	S50U PDZNR/L 15	50	47	350	45	35	11.5	63	





For back boring

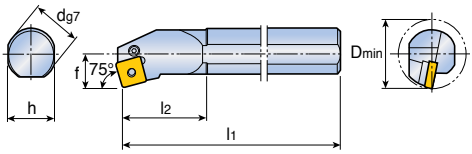
A253-A257, A316, A329

Spare parts

Designation	Lever	Screw	Shim	Shim pin	Wrench			
S32T ...15	LCL 4A	LCS 4S	LSD 42	LSP 4	L-W 3			
S40T PDZ...15	LCL 4A	LCS 4S	LSD 42	LSP 4	L-W 3			
...15	LCL 4A	LCS 4	LSD 42	LSP 4	L-W 3			
...15-A	LCL 4A	LCS 4S	LSD 42	LSP 4	L-W 3			

S-PSKNR/L

Lever lock type



S-PSKNR/L

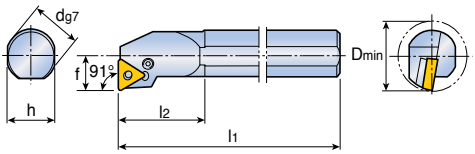
Approach angle	Designation	Dimension (mm)						Insert	
		dg7	h	l1	l2	f	Dmin		
75°	**S25T PSKNR/L 12**	25	23	300	39	17	32	SN...1204...	A261-A267, A319-A320, A331
	S32T PSKNR/L 12	32	30	300	45	22	40		
	S40T PSKNR/L 12	40	37	300	55	27	50		
	S50U PSKNR/L 19	50	47	350	66	35	63	SN...1906...	

Spare parts

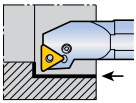
Designation	Lever	Screw	Shim	Shim pin	Snap ring	Wrench		
S25T ...12	LCL 4B	LCS 4B	-	-	LSR 4B	L-W 2.5		
S32T ...12	LCL 4	LCS 4S	LSS 42	LSP 4	-	L-W 3		
S40T ...12	LCL 4	LCS 4	LSS 42	LSP 4	-	L-W 3		
...19	LCL 6D	LCS 6	LSS 63	LSP 6	-	L-W 4		

S-PTFNR/L

Lever lock type



S-PTFNR/L

Approach angle	Designation	Dimension (mm)							Insert	
		dg7	h	l1	l2	f	Dmin			
91°	**S20Q PTFNR/L 11**	20	18	180	40	13	25		TN...1103...	A268-A273, A322, A332
	**S25T PTFNR/L 16**	25	23	300	40	17	32		TN...1604...	
	S32T PTFNR/L 16	32	30	300	45	22	40			
	S40T PTFNR/L 16	40	37	300	60	27	50			
	S50U PTFNR/L 16	50	47	350	70	35	63			
	S40T PTFNR/L 22	40	37	300	70	27	50		TN...2204...	
	S50U PTFNR/L 22	50	47	350	70	35	63			

Spare parts

Designation	Lever	Screw	Shim	Shim pin	Snap ring	Wrench		
								
...11	LCL 2B	LCS 2B	-	-	LSR 2B	L-W 2		
S25T ...16	LCL 3BH	LCS 3B	-	-	LSR 3B	L-W 2		
...16	LCL 3	LCS 3	LST 31.8	LSP 3A	-	L-W 2.5		
... 22	LCL 4	LCS 4	LST 42	LSP 4	-	L-W 3		

S-SCLCR/L

Screw type

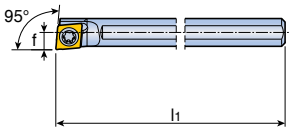


Fig.1

S-SCLCR/L

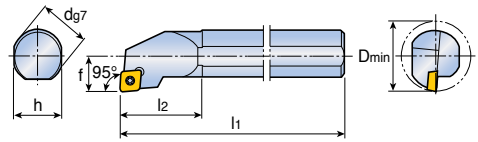


Fig.2

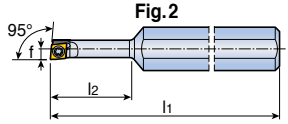


Fig.3

Approach angle	Designation	Dimension (mm)						Fig.	Insert	
		dg7	h	l1	l2	f	Dmin			
95°	**S04F SCLCR/L 03-D05**	4	3.75	80	-	2.5	5	1	CC...T 0301...	A282-A284, A335
	S05G SCLCR/L 03-D06	5	4.75	90	-	3	6	1		
	S06H SCLCR/L 04-D07	6	5.5	100	-	3.5	7	1	CC...T 0401...	
	S07J SCLCR/L 04-D08	7	6.5	110	-	4	8	1		
	S10H SCLCR/L 03-D05	10	9	100	15	2.5	5	3	CC...T 0301...	
	S08K SCLCR/L 06	8	7	125	18	6	11	2	CC...T 0602...	
	S10K SCLCR/L 06	10	9	125	20	7	13	2		
	S12M SCLCR/L 06	12	11	150	25	9	16	2		
	S16R SCLCR/L 06	16	15	200	30	11	20	2		
	S12M SCLCR/L 09	12	11	150	23	9	16	2	CC...T 09T3...	
	S16M SCLCR/L 09	16	15	150	30	11	20	2		
	S16R SCLCR/L 09	16	15	200	30	11	20	2		
	S20R SCLCR/L 09	20	18	200	32	13	25	2		
	S20S SCLCR/L 09	20	18	250	32	13	25	2		
	S25T SCLCR/L 12	25	23	300	42	17	32	2	CC...T 1204...	
	S32T SCLCR/L 12	32	30	300	45	22	40	2		
	S40T SCLCR/L 12	40	37	300	55	27	50	2		

• L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

Designation	Screw	Shim	Shim screw	Wrench			
							
...03	TS 16031I	-	-	T 6			
...04	TS 20038I/HG-P	-	-	T 6P			
S...K ...06	SO 25050I	-	-	T 7			
...06	SO 25065I	-	-	T 7			
...09	SO 35080I	-	-	T 15			
S25T ...12	SO 45100I	-	-	T 20			
...12	SO 45130I	SSC 43N	SO 60105S	T 20			

Screw type

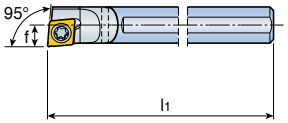


Fig.1

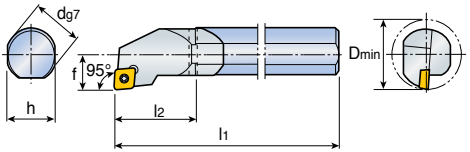
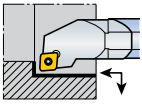


Fig.2

C-SCLCR/L

Approach angle	Designation	Dimension (mm)						Fig.	Insert	
		d_{g7}	h	l_1	l_2	f	D_{min}			
95°	✓ **C04G SCLCR/L 03-D05**	4	3.75	90	-	2.5	5	1	CC...T 0301...	A282-A284, A335
	✓ **C05H SCLCR/L 03-D06**	5	4.75	100	-	3	6	1		
	✓ **C06J SCLCR/L 04-D07**	6	5.5	110	-	3.5	7	1	CC...T 0401...	
	✓ **C07K SCLCR/L 04-D08**	7	6.5	125	-	4	8	1		
	✓ **C08K SCLCR/L 06**	8	7	125	15	6	11	2	CC...T 0602...	
	✓ **C10K SCLCR/L 06**	10	9	125	15	7	13	2		
	✓ **C12K SCLCR/L 06**	12	11	125	20	9	16	2		
	✓ **C12M SCLCR/L 06**	12	11	150	20	9	16	2		
	✓ **C12M SCLCR/L 09**	12	11	150	20	9	16	2	CC...T 09T3...	
	✓ **C16R SCLCR/L 09**	16	15	200	25	11	20	2		
	✓ **C20S SCLCR/L 09**	20	18	250	25	13	25	2		

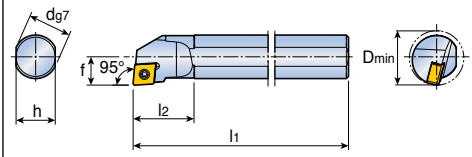
• ✓ Marked: Designates carbide shank • L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

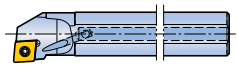
Designation	Screw	Wrench					
							
...03	TS 16031I	T 6					
...04	TS 20038I/HG-P	T 6P					
...06	SO 25050I	T 7					
...09	SO 35080I	T 15					

S-SCLNR/L A-SCLNR/L

Screw type



S-SCLNR/L



A-SCLNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
95°	✓ **S16Q SCLNR/L 0904**	16	15	180	25	11	20	CN... 0904... A244, A246-A250
	✓ **S20Q SCLNR/L 0904**	20	18	180	28	13	20	
	✓ **S20Q SCLNR/L 0904-D20**	20	18	180	40	11	20	
95°	✓ **A16Q SCLNR/L 0904**	16	15	180	25	11	20	
	✓ **A20Q SCLNR/L 0904**	20	18	180	28	13	25	

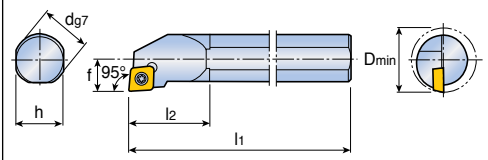
• ✓ Marked: For RHINORUSH insert

Spare parts

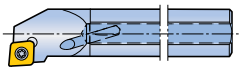
Designation	Screw	Sealing screw	Wrench					
S...0904	TS 35083I/HG	-	T 10					
A...0904	TS 35083I/HG	RSS M4	T 10					

S-SCLPR/L A-SCLPR/L

Screw type



S-SCLPR/L



A-SCLPR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
95°	**S10K SCLPR/L 08**	10	9	125	20	6	12	CP...T 0802... A285
	S10M SCLPR/L 08	10	9	150	20	6	12	
	S12M SCLPR/L 08	12	11	150	23	8	16	
	S16N SCLPR/L 09	16	15	160	30	10	20	CP...T 0903...
	S16R SCLPR/L 09	16	15	200	30	10	20	
	S20N SCLPR/L 09	20	18	160	32	12.5	25	
	S20S SCLPR/L 09	20	18	250	32	12.5	25	
95°	**A08H SCLPR/L 06**	8	7	100	15	6	11	CP...T 0602...
	A10K SCLPR/L 06	10	9	125	15	7	13	
	A12M SCLPR/L 0903	12	11	150	19	9	16	CP...T 0903...
	A16Q SCLPR/L 0903	16	15	180	21.5	11	20	
	A20R SCLPR/L 0903	20	18	200	22	13	25	
	A12M SCLPR/L 09T3	12	11	150	19	9	16	CP...T 09T3...
	A16Q SCLPR/L 09T3	16	15	180	20	11	20	
	A20R SCLPR/L 09T3	20	18	200	22	13	25	

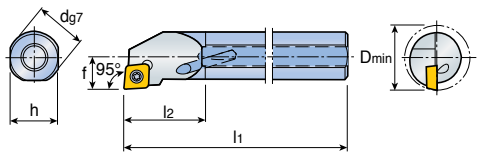
• L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

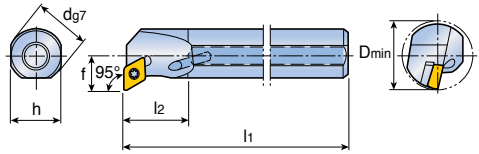
Designation	Screw	Wrench						
...06	SO 25050I	T 7						
...08	SO 30055I	T 9						
...09	SO 35080I	T 15						
...0903, 09T3	TS 35070I/HG	T 15						

E-SCLPR/L A-SDLNR/L

Screw type

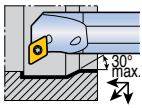


E-SCLPR/L



A-SDLNR/L

Approach angle	Designation	Dimension (mm)						Insert	
		dg7	h	l1	l2	f	Dmin		
95°	✓ **E08K SCLPR/L 06**	8	7	125	15	6	11	CP...T 0602...	A285
	✓ **E10K SCLPR/L 06**	10	9	125	15	7	13		
	✓ **E12M SCLPR/L 0903**	12	11	150	19	9	16	CP...T 0903...	
	✓ **E16R SCLPR/L 0903**	16	15	200	21.73	11	20		
	✓ **E12M SCLPR/L 09T3**	12	11	150	19	9	16	CP...T 09T3...	
	✓ **E16R SCLPR/L 09T3**	16	15	200	21.5	11	20		
95°	**A20S SDLNR/L 11**	20	18	250	31	13	24	DN...1104...	A253-A257
	A25T SDLNR/L 11	25	23	300	30	17	31		



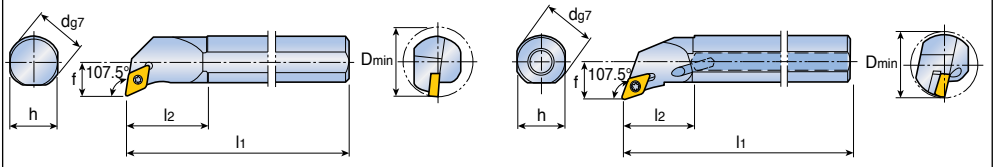
• ✓ Marked: Designates carbide shank • L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

Designation	Screw	Shim	Shim screw	Wrench	Seal			
...06	SO 25050I	-	-	T 7	-			
...09	TS 35070I/HG	-	-	T 15	-			
A20S...11	SO 35120I	-	-	T 10	PL 20			
A25T...11	SO 35120I	SSD 32	SO 50090S	T 10	PL 25			

S-SDQCR/L A-SDQNR/L

Screw type



S-SDQCR/L A-SDQNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
107.5°	S10K SDQCR/L 07	10	9	125	20	7	13	DC...T 0702... A286-A288, A336
	S10M SDQCR/L 07	10	9	150	20	7	13	
	S12M SDQCR/L 07	12	11	150	22	9	16	
	S16R SDQCR/L 07	16	15	200	27	11	20	
	S20N SDQCR/L 11	20	18	160	40	13	25	DC...T 11T3...
	S20S SDQCR/L 11	20	18	250	40	13	25	
	S25T SDQCR/L 11	25	23	300	50	17	32	
107.5°	A16S SDQNR/L 11	16	15	250	30	13	23	DN... 1104... A253-A257
	A20S SDQNR/L 11	20	18	250	31	15	27	
	A25T SDQNR/L 11	25	23	300	35	19	33	
	A32T SDQNR/L 11	32	30	300	44	26	44	

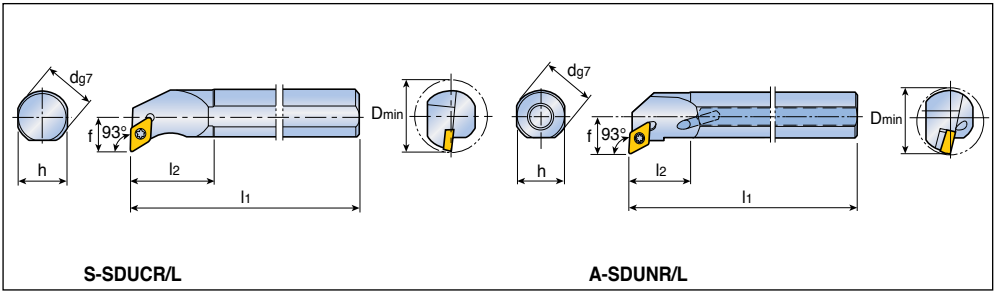
• L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

Designation	Screw	Shim	Shim screw	Wrench	Seal			
S10 ...07	SO 25050I	-	-	T 7	-			
S ...07	SO 25065I	-	-	T 7	-			
S ...11	SO 35080I	-	-	T 15	-			
A16S...11	SO 35120I	-	-	T 10	PL 16			
A20S...11	SO 35120I	SSD 32	SO 50090S	T 10	PL 20			
A25T...11	SO 35120I	SSD 32	SO 50090S	T 10	PL 25			
A32T...11	SO 35120I	SSD 32	SO 50090S	T 10	PL 32			

S-SDUCR/L A-SDUNR/L

Screw type



S-SDUCR/L A-SDUNR/L

Approach angle	Designation	Dimension (mm)						Insert	
		dg7	h	l1	l2	f	Dmin		
93°	**S10K SDUCR/L 07**	10	9	125	20	7	13	DC...T 0702...	A286-A288, A336
	S12M SDUCR/L 07	12	11	150	23	9	16		
	S16M SDUCR/L 07	16	15	150	30	11	20		
	S16R SDUCR/L 07	16	15	200	30	11	20		
	S16R SDUCR/L 11	16	15	200	27	11	20	DC...T 11T3...	
	S20S SDUCR/L 11	20	18	250	32	13	25		
	S25T SDUCR/L 11	25	23	300	42	17	32		
	S32T SDUCR/L 11	32	30	300	55	22	40		
93°	**A20S SDUNR/L 11**	20	18	250	30	15	27	DN... 1104...	A253-A257
	A25T SDUNR/L 11	25	23	300	30	19	33		
	A32T SDUNR/L 11	32	30	300	44	26	44		

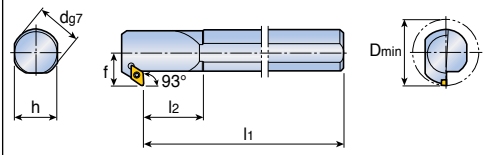
• L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

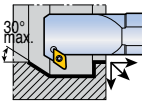
Designation	Screw	Shim	Shim screw	Wrench	Seal			
S10K...07	SO 25050I	-	-	T 7	-			
S ...07	SO 25065I	-	-	T 7	-			
S ...11	SO 35080I	-	-	T 15	-			
A20S...11	SO 35120I	-	-	T 10	PL 20			
A25T...11	SO 35120I	SSD 32	SO 50090S	T 10	PL 25			
A32T...11	SO 35120I	SSD 32	SO 50090S	T 10	PL 32			

S-SDZCR/L

Screw type



S-SDZCR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
93°	**S16R SDZCR/L 07**	16	15	200	23	13	22	DC...T 0702...
	S20S SDZCR/L 07	20	18	250	28	15	27	A286-A288, A336
	**S25T SDZCR/L 07**	25	23	300	33	18	33	
	S20S SDZCR/L 11	20	18	250	24	15	27	DC...T 11T3...
	S32T SDZCR/L 11	32	30	300	34	22	40	

For back boring

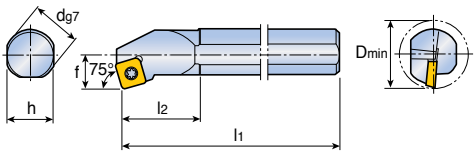
• L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

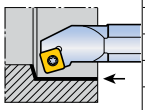
Designation	Screw	Shim	Shim screw	Wrench				
								
...07	SO 25065I	-	-	T 7				
S20S ...11	SO 35080I	-	-	T 15				
S32T ...11	SO 35124I	SSD 32	SO 50090S	T 15				

S-SSKCR/L

Screw type



S-SSKCR/L

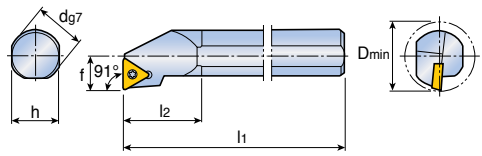
Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
75°	**S16R SSKCR/L 09**	16	15	200	28	11	20	SC...T 09T3...
	**S20S SSKCR/L 09**	20	18	250	30	13	25	A291, A338
	S25T SSKCR/L 12	25	23	300	39	17	32	SC...T 1204...

Spare parts

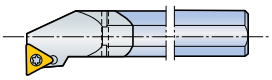
Designation	Screw	Wrench						
								
...09	SO 35080I	T 15						
...12	SO 45100I	T 20						

S-STFCR/L C-STFCR/L

Screw type



S-STFCR/L



C-STFCR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
91°	**S06H STFCR/L 06T1**	6	5.4	100	12	4.5	8	TC...T 06T1...
	S08K STFCR/L 09	8	7	125	20	6	11	TC...T 0902...
	S10K STFCR/L 09	10	9	125	22.5	7	13	
	S12M STFCR/L 09	12	11	150	30	9	16	
	S16R STFCR/L 09	16	15	200	35	11	20	
	S12M STFCR/L 11	12	11	150	25	9	16	TC...T 1102...
	S16R STFCR/L 11	16	15	200	35	11	20	
	S20S STFCR/L 11	20	18	250	36	13	25	
	S20S STFCR/L 16	20	18	250	36	13	25	TC...T 16T3...
	S25T STFCR/L 16	25	23	300	49	17	32	
	S32T STFCR/L 16	32	30	300	45	22	40	
	S40T STFCR/L 16	40	37	300	60	27	50	
91°	✓ **C10K STFCR/L 09**	10	9	125	15	7	13	TC...T 0902...
	✓ **C10K STFCR/L 11**	10	9	125	15	7	13	TC...T 1102...
	✓ **C12M STFCR/L 11**	12	11	150	20	9	16	
	✓ **C16R STFCR/L 11**	16	15	200	25	11	20	

A294-A295, A339-A340

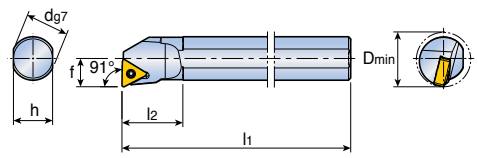
• ✓ Marked: Designates carbide shank • L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

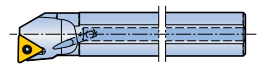
Designation	Screw	Shim	Shim screw	Wrench				
...06T1	TS 20038I	-	-	T 6				
S08K...09	TS 22046I	-	-	T 7				
...09	SO 22050I	-	-	T 7				
...11	SO 25065I	-	-	T 7				
C10K...11	SO 25050I	-	-	T 7				
S20S...16	SO 35080I	-	-	T 15				
S25T...16	SO 35080I	-	-	T 15				
S32T...16	SO 35124I	SST 32	SO 50090S	T 15				
S40T...16	SO 35124I	SST 32	SO 50090S	T 15				

S-STFNR/L A-STFNR/L

Screw type



S-STFNR/L



A-STFNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
91°	✓ **S16Q STFNR/L 1304**	16	15	180	25	11	20	TN... 1304... A268-A273
	✓ **S20Q STFNR/L 1304**	20	18	180	28	13	25	
91°	✓ **A16Q STFNR/L 1304**	16	15	180	25	11	20	
	✓ **A20Q STFNR/L 1304**	20	18	180	28	13	25	

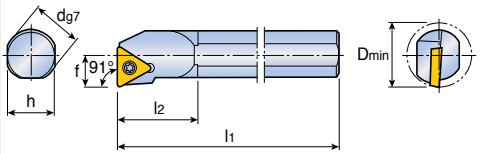
• ✓ Marked: For RHINORUSH insert

Spare parts

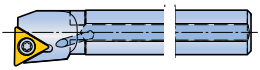
Designation	Screw	Sealing screw	Wrench					
S...1304	TS 30080I/HG	-	T 9					
A...1304	TS 30080I/HG	RSS M4	T 9					

S-STFPR/L A-STFPR/L

Screw type



S-STFPR/L



A-STFPR/L

Approach angle	Designation	Dimension (mm)							Insert	
		dg7	h	l1	l2	f	Dmin			
91°	**S08K STFPR/L 09-X01**	8	7	125	15	6	11		TPGX 0902...	A296-A298, A339
	S08K STFPR/L 09	8	7	125	14	6	11		TP...T 0902...	
	S10K STFPR/L 11	10	9	125	25	6	12		TP...T 1103...	
	S10M STFPR/L 11	10	9	150	25	6	12			
	S12M STFPR/L 11	12	11	150	30	8	16			
	S16N STFPR/L 11	16	15	160	35	10	20			
	S16R STFPR/L 11	16	15	200	35	10	20			
	S16N STFPR/L 16	16	15	160	30	10	20		TP...T 1604...	
	S20N STFPR/L 16	20	18	160	35	12.5	25			
	S20S STFPR/L 16	20	18	250	36	12.5	25			
91°	**A08H STFPR/L 09**	8	7	100	-	6	11		TP...T 0902...	
	A10K STFPR/L 1102	10	9	125	-	7	13		TP...T1102...	
	A12M STFPR/L 1102	12	11	150	-	9	16			
	A16Q STFPR/L 1102	16	15	180	-	11	20			
	A12M STFPR/L 1103	12	11	150	-	9	16		TP...T1103...	
	A16Q STFPR/L 1103	16	15	180	-	11	20			
	A20R STFPR/L 16T3	20	18	200	-	13	25		TP...T 16T3...	

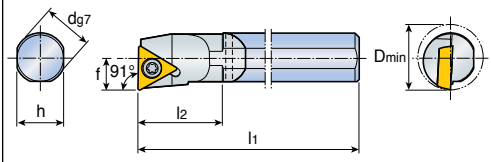
- TPGX type inserts are available with alternate screw. (TPGX 1103 → SO 30081I)
- L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

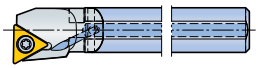
Designation	Screw	Wrench						
...09-X01	SO 25061I	T 8						
...09	TS 22046I	T 7						
S10 ...11	SO 30055I	T 9						
...11	SO 30100I	T 9						
S16R...11	SO 30040I	T 9						
...1102	SO 25050I	T 7						
...1103	SO 30100I	T 9						
...16T3	TS 35070I/HG	T 15						
...16	SO 35124I	T 15						

C-STFPR/L E-STFPR/L

Screw type



C-STFPR/L



E-STFPR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
91°	✓ **C10K STFPR/L 11**	10	9	125	15	6	12	TPGT 1103...
	✓ **C12M STFPR/L 11**	12	11	150	20	8	16	
91°	✓ **E08K STFPR/L 09**	8	7	125	-	6	11	TP...T 0902...
	✓ **E10K STFPR/L 1102**	10	9	125	-	7	13	TP...T 1102...
	✓ **E12M STFPR/L 1102**	12	11	150	-	9	16	
	✓ **E16R STFPR/L 1102**	16	15	200	-	11	20	
	✓ **E12M STFPR/L 1103**	12	11	150	-	9	16	TP...T 1103...
	✓ **E16R STFPR/L 1103**	16	15	200	-	11	20	

A296-A298, A339

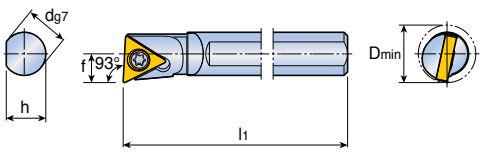
• ✓ Marked: Designates carbide shank • L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

Designation	Screw	Wrench
...09	TS 22046I	T 7
C10K ...11	SO 30055I	T 9
C12M...11	SO 30100I	T 9
...1102	SO 25050I	T 7
...1103	SO 30100I	T 9

S-STUBR/L C-STUBR/L

Screw type



S-STUBR/L C-STUBR/L

Approach angle	Designation	Dimension (mm)					Insert
		dg7	h	l1	f	Dmin	
93°	**S06H STUBR/L 06-D08**	6	5.5	100	4	8	TB...T 0601... A293
93°	✓ **C06J STUBR/L 06-D08**	6	5.5	110	4	8	

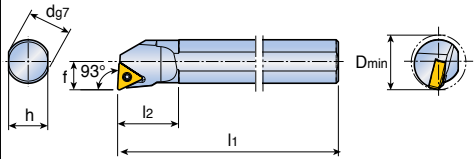
• ✓ Marked: Designates carbide shank • L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

Designation	Screw	Wrench
...06-D08	TS 20043I/HG-P	T 6P

S-STUNR/L A-STUNR/L

Screw type



S-STUNR/L



A-STUNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
93°	✓ **S16Q STUNR/L 1304**	16	15	180	25	11	20	TN... 1304... A268-A273
	✓ **S20Q STUNR/L 1304**	20	28	180	28	13	25	
93°	✓ **A16Q STUNR/L 1304**	16	15	180	25	11	20	
	✓ **A20Q STUNR/L 1304**	20	18	180	28	13	25	

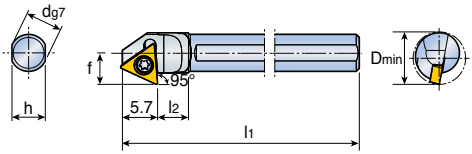
• ✓ Marked: For RHINORUSH insert

Spare parts

Designation	Screw	Sealing screw	Wrench					
								
S...1304	TS 30080I/HG	-	T 9					
A...1304	TS 30080I/HG	RSS M4	T 9					

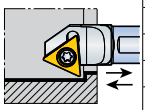
C-STZBR/L

Screw type



C-STZBR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
95°	✓ C06J STZBR/L 06-D085	6	5.4	110	5	5.4	8.5	TB...T 0601... A293



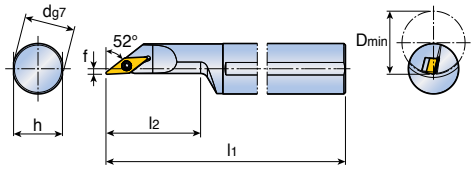
• ✓ Marked: Designates carbide shank

Spare parts

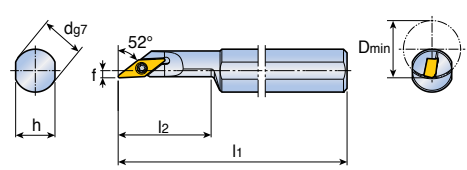
Designation	Screw	Wrench						
								
...06-D085	SO 25043I	T 6P						

S-SVJBR/L S-SVJCR/L

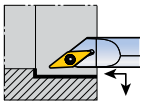
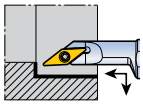
Screw type



S-SVJBR/L



S-SVJCR/L

Approach angle	Designation	Dimension (mm)						Insert	
		dg7	h	l1	l2	f	Dmin		
52°	**S20R SVJBR/L 11-D25**	20	19	200	37.5	2	25	VB...T 1103...	A300-A301, A341
	**S25S SVJBR/L 11-D30**	25	24	250	45	3.5	30		
	S32S SVJBR/L 16	32	31	250	60	3.5	40	VB...T 1604...	
	S40T SVJBR/L 16	40	39	300	75	4.5	50		
52°	**S12M SVJCR/L 08-D16**	12	11	150	26	2	16	VC...T 0802...	A302, A341
	**S16Q SVJCR/L 08-D20**	16	15	180	36	2	20		

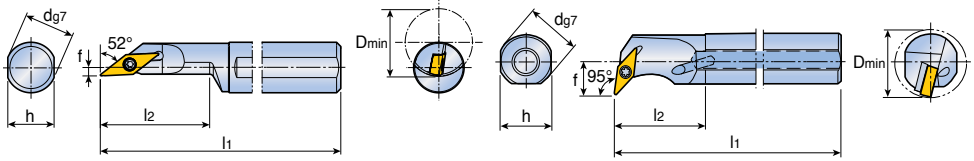
• L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

Designation	Screw	Shim	Shim screw	Wrench				
								
...08-...	TS 20038I/HG-P	-	-	T 6P	-			
...11-...	SO 25065I	-	-	T 7	-			
...16	SO 35124I	SSV32	TS 5035062S	T15	L-W 3.5			

S-SVJPR/L A-SVLNR/L

Screw type



S-SVJPR/L A-SVLNR/L

Approach angle	Designation	Dimension (mm)						Insert	
		dg7	h	l1	l2	f	Dmin		
52°	**S12M SVJPR/L 08-D16**	12	11	150	26	2	16	VP...T 0802...	A303
95°	✓ **A25T SVLNR/L 1304**	25	23	300	40	16	31	VN...X 1304...	A274-A276, A281
	✓ **A32T SVLNR/L 1304**	32	30	300	45	20	38	YNMG 1304...	
	A25T SVLNR/L 13	25	23	300	40	16	31	VN... 13...	
	A32T SVLNR/L 13	32	30	300	45	20	38		

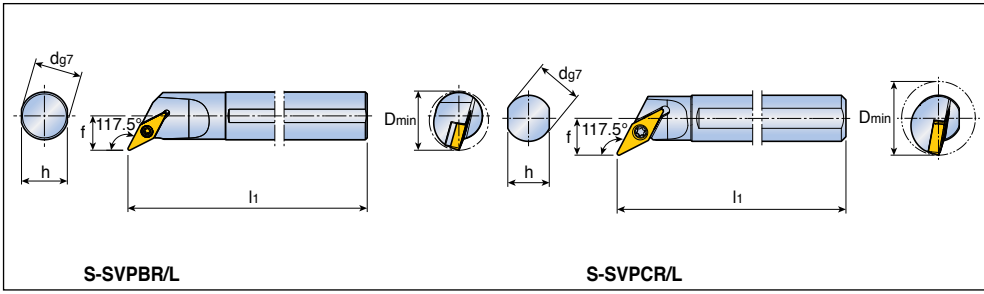
• ✓ Marked: For RHINORUSH insert • L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

Designation	Screw	Shim	Shim screw	Wrench		Seal		
S...08-D16	SO 25065I	-	-	T 7	-			
A..1304	TS 30120I/HG	SSVN 2.523	TS 5030062S	T 9	L-W 3.5	-		
A25T ...13	SO 35120I	SSVN 2.523	TS 5035062S	T 10	-	PL 25		
A32T ...13	SO 35120I	SSVN 2.523	TS 5035062S	T 10	-	PL 32		

S-SVPBR/L S-SVPCR/L

Screw type



S-SVPBR/L S-SVPCR/L

Approach angle	Designation	Dimension (mm)						Insert	
		dg7	h	l1	l2	f	Dmin		
117.5°	**S20R SVPBR/L 11-D22**	16	15	180	-	13.5	22	VB...T 1103...	A300-A301, A341
	S25S SVPBR/L 11-D22	20	19	200	-	15.5	26		
	S32S SVPBR/L 16	25	24	250	-	18	31	VB...T 1604...	
	S40T SVPBR/L 16	32	31	250	-	23	40		
117.5°	**S10K SVPCR/L 08-D16**	10	9	125	-	8	16	VC...T 0802...	A302
	S12M SVPCR/L 11-D20	12	11	150	-	10	20	VC...T 1103...	

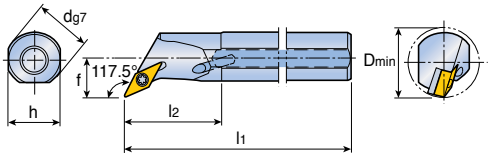
• L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

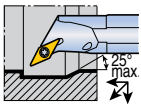
Designation	Screw	Shim	Shim screw	Wrench				
...08-...	TS 20038I/HG-P	-	-	T 6P	-			
...11-...	SO 25065I	-	-	T 7	-			
...16	SO 35124I	SSV32	TS 5035062S	T15	L-W 3.5			

A-SVPNR/L

Screw type



A-SVPNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
117.5°	✓ **A25T SVPNR/L 1304**	25	23	300	45	19	33	VN...X 1304...
	✓ **A32T SVPNR/L 1304**	32	30	300	47	26	44	YNMG 1304... A274-A276, A281
	A25T SVPNR/L 13	25	23	300	45	19	33	VN... 13...
	A32T SVPNR/L 13	32	30	300	47	26	44	

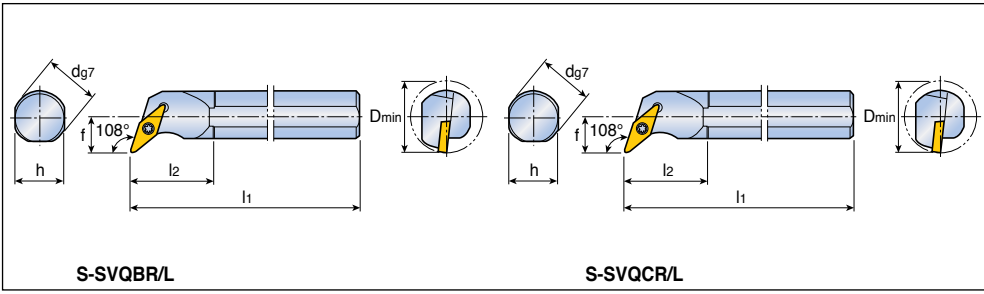
• ✓ Marked: For RHINORUSH insert

Spare parts

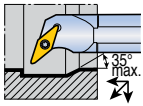
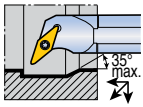
Designation	Screw	Shim	Shim screw	Wrench		Seal		
								
A..1304	TS 30120I/HG	SSVN 2.523	TS 5030062S	T 9	L-W 3.5	-		
A25T ...13	SO 35120I	SSVN 2.523	TS 5035062S	T 10	-	PL 25		
A32T ...13	SO 35120I	SSVN 2.523	TS 5035062S	T 10	-	PL 32		

S-SVQBR/L S-SVQCR/L

Screw type



S-SVQBR/L S-SVQCR/L

Approach angle	Designation	Dimension (mm)						Insert	
		dg7	h	l1	l2	f	Dmin		
108°	**S25T SVQBR/L 16**	25	23	300	40	17	32	VB...T 1604...	A300-A301, A341
	**S32T SVQBR/L 16**	32	30	300	45	22	40		
	S40T SVQBR/L 16	40	38	300	55	27	50		
108°	**S32T SVQCR/L 16**	32	30	300	45	22	40	VC...T 1604...	A302, A341
	**S40T SVQCR/L 16**	40	38	300	55	27	50		

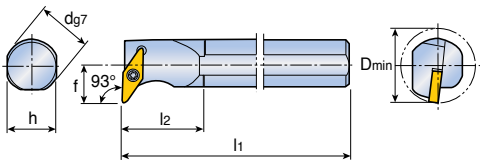
• L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

Designation	Screw	Shim	Shim screw	Wrench				
								
S25T ...16	SO 35080I	-	-	T 15				
...16	SO 35124I	SSV 32	SO 50090S	T 15				

S-SVUBR/L S-SVUCR/L

Screw type



S-SVUBR/L

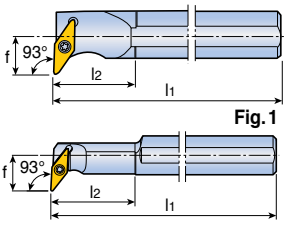
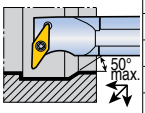
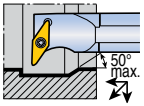


Fig. 1

S-SVUCR/L

Fig. 2

Approach angle	Designation	Dimension (mm)						Fig.	Insert	
		dg7	h	l1	l2	f	Dmin			
93°	**S32T SVUBR/L 16**	32	30	300	45	22	40		VB...T 1604...	A300-A301, A341
	**S40T SVUBR/L 16**	40	38	300	55	27	50			
93°	**S12M SVUCR/L 08-D16**	12	11	150	26	11	16	2	VC...T 0802...	A302, A341
	**S16Q SVUCR/L 11-D20**	16	15	180	32	15.5	20	2	VC...T 1103...	
	S20R SVUCR/L 11-D25	20	18	200	40	17.5	25	2		
	S32T SVUCR/L 16	32	30	300	45	22	40	1	VC...T 1604...	
	S40T SVUCR/L 16	40	38	300	60	27	50	1		

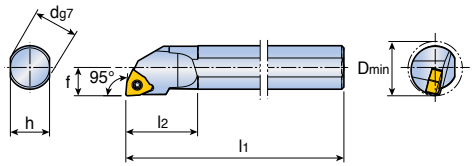
• L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

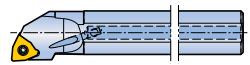
Designation	Screw	Shim	Shim screw	Wrench				
								
...08-...	TS 20038I/HG-P	-	-	T 6P				
...11-...	SO 25065I	-	-	T 7				
...16	SO 35124I	SSV 32	SO 50090S	T 15				

S-SWLNR/L A-SWLNR/L

Screw type



S-SWLNR/L



A-SWLNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
95°	✓ **S16Q SWLNR/L 0604**	16	15	180	30	11	20	WN...X 0604... A279-A280
	✓ **S20Q SWLNR/L 0604**	20	18	180	33	13	25	
95°	✓ **A16Q SWLNR/L 0604**	16	15	180	30	11	20	
	✓ **A20Q SWLNR/L 0604**	20	18	180	33	13	25	

• ✓ Marked: For RHINORUSH insert

Spare parts

Designation	Screw	Sealing screw	Wrench					
S...0604	TS 35083I/HG	-	T 10					
A...0604	TS 35083I/HG	RSS M4	T 10					

S-SWUBR/L C-SWUBR/L

Screw type

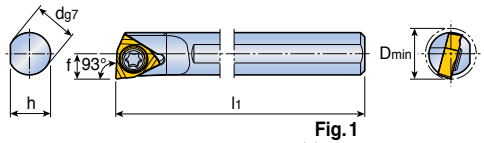
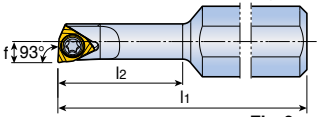
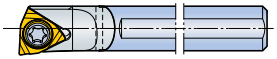


Fig. 1



S-SWUBR/L Fig. 2



C-SWUBR/L

Approach angle	Designation	Dimension (mm)						Fig.	Insert
		dg7	h	l1	l2	f	Dmin		
93°	**S05G SWUBR/L 06-D06**	5	4.75	90	-	3	6	1	WB...T 0601... A304
	S06H SWUBR/L 06-D07	6	5.5	100	-	3.5	7	1	
	S07J SWUBR/L 06-D08	7	6.5	110	-	4	8	1	
	S10H SWUBR/L 06-D06	10	9	100	18	3	6	2	
93°	✓ **C05H SWUBR/L 06-D06**	5	4.75	100	-	3	6		
	✓ **C06J SWUBR/L 06-D07**	6	5.5	110	-	3.5	7		
	✓ **C07K SWUBR/L 06-D08**	7	6.5	125	-	4	8		

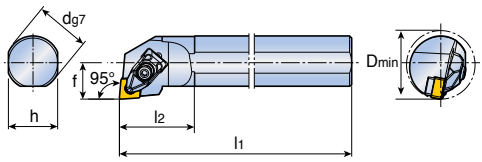
• ✓ Marked: Designates carbide shank • L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

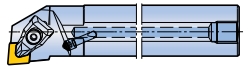
Designation	Screw	Wrench
		
...06-...	TS 20038I/HG-P	T 6P

S-TCLNR/L A-TCLNR/L

T-holder type



S-TCLNR/L



A-TCLNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
95°	✓ **S25R TCLNR/L 0904**	25	23	200	35	17	32	CN... 0904...
	✓ **S32S TCLNR/L 0904**	32	30	250	35	22	40	
	✓ **S40T TCLNR/L 0904**	40	37	300	45	27	50	
95°	✓ **A25R TCLNR/L 0904**	25	23	200	35	17	32	CN... 0904...
	✓ **A32S TCLNR/L 0904**	32	30	250	35	22	40	
	A25T TCLNR/L 12	25	23	300	45	17	32	CN... 1204...
	A32T TCLNR/L 12	32	30	300	45	22	40	
	A40T TCLNR/L 12	40	37	300	45	27	50	
	A50U TCLNR/L 12	50	47	350	45	35	63	

A244-A252, A314-A315, A328

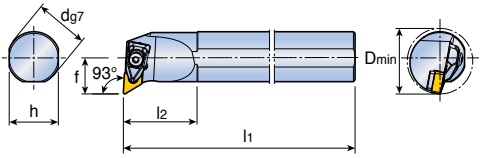
• ✓ Marked: For RHINORUSH insert

Spare parts

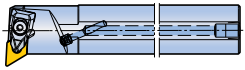
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Nozzle	Wrench	
S25R...0904	DLM 3-NX	DLS 3	LSC 32	SO 40073I	DSP 3	-	L-W 2.5	T 15
S32S,S40T...0904	DLM 3-NX	DLS 3	LSC 32	SO 40085I	DSP 3	-	L-W 2.5	T 15
A25R...0904	DLM 3-NX	DLS 3	LSC 32	SO 40073I	DSP 3	NZ 62	L-W 2.5	T 15
A32S...0904	DLM 3-NX	DLS 3	LSC 32	SO 40085I	DSP 3	NZ 62	L-W 2.5	T 15
A25T...12	DLM 4	DLS 4	LSC 42	TS 50A105I	DSP 4	NZ 62	L-W 3	T 20
A32T...12	DLM 4	DLS 4	LSC 42	TS 50A105I	DSP 4	NZ 62	L-W 3	T 20
A40T...12	DLM 4	DLS 4	TSC 44	SO 40050I	DSP 4	NZ 62	L-W 3	T 15
A50U...12	DLM 4	DLS 4	TSC 44	SO 40050I	DSP 4	NZ 62	L-W 3	T 15

S-TDUNR/L A-TDUNR/L

T-holder type



S-TDUNR/L



A-TDUNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
93°	✓ **S32S TDUNR/L 1305**	32	30	250	45	22	40	DN... 1305...
	✓ **S40T TDUNR/L 1305**	40	37	300	55	27	50	
93°	✓ **A32S TDUNR/L 1305**	32	30	250	45	22	40	DN... 1305...
	✓ **A40T TDUNR/L 1305**	40	37	300	55	27	50	
	A32T TDUNR/L 15	32	30	300	45	22	40	DN... 1506...
	A40T TDUNR/L 15	40	37	300	45	27	50	
	A50U TDUNR/L 15	50	47	350	45	35	63	

A253-A258, A316, A329

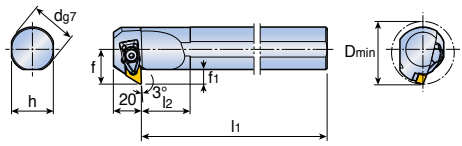
• ✓ Marked: For RHINORUSH insert

Spare parts

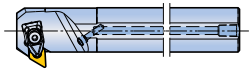
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Nozzle	Wrench	
S ...1305	DLM 3.5-NX	DLS 4	LSD 3.52B	TS 50A105I	DSP 4	-	L-W 3	T 20
A32S...1305	DLM 3.5-NX	DLS 4	LSD 3.52B	TS 50A105I	DSP 4	NZ 62	L-W 3	T 20
A40T...1305	DLM 3.5-NX	DLS 4	LSD 3.52B	TS 50A105I	DSP 4	NZ 104	L-W 3	T 20
A32T...15	DLM 4	DLS 4	LSD 42	TS 50A105I	DSP 4	NZ 62	L-W 3	T 20
...15	DLM 4	DLS 4	TSD 43	SO 40050I	DSP 4	NZ 104	L-W 3	T 15

S-TDZNR/L A-TDZNR/L

T-holder type

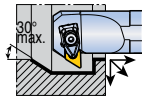


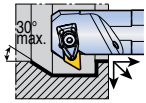
S-TDZNR/L



A-TDZNR/L

Approach angle	Designation	Dimension (mm)							Insert
		dg7	h	l1	l2	f	f1	Dmin	
93°	✓ S32S TDZNR/L 1305	32	30	250	35	25	10.5	45	DN... 1305... A253-A258
	✓ S40T TDZNR/L 1305	40	37	300	40	29	10.5	50	
93°	✓ A32S TDZNR/L 1305	32	30	250	35	25	10.5	45	
	✓ A40T TDZNR/L 1305	40	37	300	40	29	10.5	50	





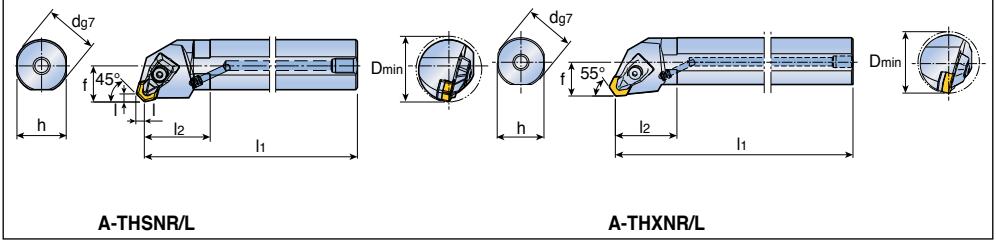
• ✓ Marked: For RHINORUSH insert

Spare parts

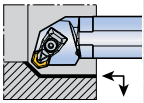
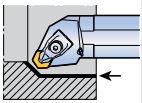
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Nozzle	Wrench	
S ...1305	DLM 3.5-NX	DLS 4	LSD 3.52B	TS 50A105I	DSP 4	-	L-W 3	T 20
A32S...1305	DLM 3.5-NX	DLS 4	LSD 3.52B	TS 50A105I	DSP 4	NZ 62	L-W 3	T 20
A40T...1305	DLM 3.5-NX	DLS 4	LSD 3.52B	TS 50A105I	DSP 4	NZ 104	L-W 3	T 20

A-THSNR/L A-THXNR/L

T-holder type



A-THSNR/L A-THXNR/L

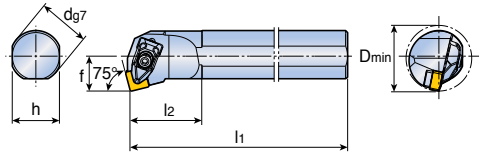
Approach angle	Designation	Dimension (mm)							Insert
		dg7	h	l1	l2	f	Dmin	l	
45°	**A32T THSNR/L 05**	32	30	300	40	22	40	4.2	HN...G 0504... A259
	A40T THSNR/L 05	40	37	300	45	27	50	4.2	
	**A50U THSNR/L 05**	50	47	350	45	35	63	4.2	
55°	**A32U THXNR/L 05-A55**	32	30	350	40	22	40		
	A40V THXNR/L 05-A55	40	37	400	45	27	50		
	**A50W THXNR/L 05-A55**	50	47	450	50	35	63		

Spare parts

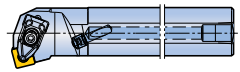
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Nozzle	Wrench	
								
A32T ...05	DLM 4	DLS 4	TSH 42	SO 40050I	DSP 4	NZ 62	L-W 3	T 15
...05	DLM 4	DLS 4	TSH 44	SO 40050I	DSP 4	NZ 104	L-W 3	T 15
...05-A55	DLM 4	DLS 4	TSH 44	SO 40050I	DSP 4	NZ 104	L-W 3	-

S-TSKNR/L A-TSKNR/L

T-holder type



S-TSKNR/L



A-TSKNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
75°	✓ **S25R TSKNR/L 0904**	25	23	200	35	17	32	SN... 0904...
	✓ **S32S TSKNR/L 0904**	32	30	250	35	22	40	
75°	✓ **A25R TSKNR/L 0904**	25	23	200	35	17	32	SN... 0904...
	✓ **A32S TSKNR/L 0904**	32	30	250	35	22	40	
	A25T TSKNR/L 12	25	23	300	45	17	32	SN... 1204...

A261-A267, A319-A320, A331

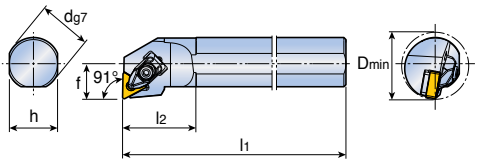
• ✓ Marked: For RHINORUSH insert • L-hand insert for R-hand toolholder, R-hand insert for L-hand toolholder

Spare parts

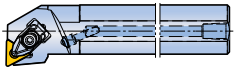
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Nozzle	Wrench	
S25R...0904	DLM 3.5-NX	DLS 3	LSS 32	SO 40073I	DSP 3	-	L-W 2.5	T 15
S32S...0904	DLM 3.5-NX	DLS 3	LSS 32	SO 40085I	DSP 3	-	L-W 2.5	T 15
A25R...0904	DLM 3.5-NX	DLS 3	LSS 32	SO 40073I	DSP 3	NZ 62	L-W 2.5	T 15
A32S...0904	DLM 3.5-NX	DLS 3	LSS 32	SO 40085I	DSP 3	NZ 62	L-W 2.5	T 15
A25T ...12	DLM 4	DLS 4	LSS 42	TS 50A105I	DSP 4	NZ 62	L-W 3	T 20

S-TTFNR/L A-TTFNR/L

T-holder type



S-TTFNR/L



A-TTFNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
91°	✓ **S25R TTFNR/L 1304**	25	23	200	35	17	32	TN... 1304... A268-A273
	✓ **S32S TTFNR/L 1304**	32	30	250	35	22	40	
91°	✓ **A25R TTFNR/L 1304**	25	23	200	35	17	32	
	✓ **A32S TTFNR/L 1304**	32	30	250	35	22	40	

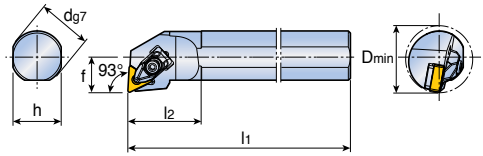
• ✓ Marked: For RHINORUSH insert

Spare parts

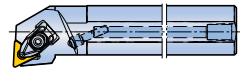
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Nozzle	Wrench	
S25R...1304	DLM 2.5-NX	DLS 3	LST 2.52B	SO 40073I	DSP 3	-	L-W 2.5	T 15
S32S...1304	DLM 2.5-NX	DLS 3	LST 2.52B	SO 40085I	DSP 3	-	L-W 2.5	T 15
A25R...1304	DLM 2.5-NX	DLS 3	LST 2.52B	SO 40073I	DSP 3	NZ 62	L-W 2.5	T 15
A32S...1304	DLM 2.5-NX	DLS 3	LST 2.52B	SO 40085I	DSP 3	NZ 62	L-W 2.5	T 15

S-TTUNR/L A-TTUNR/L

T-holder type



S-TTUNR/L



A-TTUNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
93°	✓ **S25R TTUNR/L 1304**	25	23	200	35	17	32	TN... 1304... A268-A273
	✓ **S32S TTUNR/L 1304**	32	30	250	35	22	40	
93°	✓ **A25R TTUNR/L 1304**	25	23	200	35	17	32	
	✓ **A32S TTUNR/L 1304**	32	30	250	35	22	40	

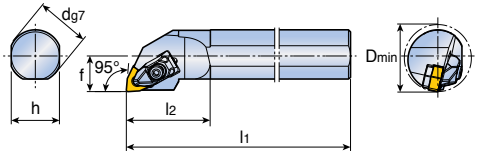
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Spare parts

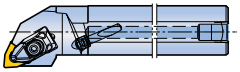
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Nozzle	Wrench	
S25R...1304	DLM 2.5-NX	DLS 3	LST 2.52B	SO 40073I	DSP 3	-	L-W 2.5	T 15
S32S...1304	DLM 2.5-NX	DLS 3	LST 2.52B	SO 40085I	DSP 3	-	L-W 2.5	T 15
A25R...1304	DLM 2.5-NX	DLS 3	LST 2.52B	SO 40073I	DSP 3	NZ 62	L-W 2.5	T 15
A32S...1304	DLM 2.5-NX	DLS 3	LST 2.52B	SO 40085I	DSP 3	NZ 62	L-W 2.5	T 15

S-TWLNR/L A-TWLNR/L

T-holder type



S-TWLNR/L



A-TWLNR/L

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
95°	✓ **S25R TWLNR/L 0604**	25	23	200	40	17	32	WN...X 0604...
	✓ **S32S TWLNR/L 0604**	32	30	250	45	22	40	
	S25T TWLNR/L 08	25	23	300	35	17	32	WN... 0804...
	S32T TWLNR/L 08	32	30	300	45	22	40	
95°	✓ **A25R TWLNR/L 0604**	25	23	200	40	17	32	WN...X 0604...
	✓ **A32S TWLNR/L 0604**	32	30	250	45	22	40	
	A20S TWLNR/L 06	20	18	250	35	13	25	WN... 0604...
	A25T TWLNR/L 06	25	23	300	40	17	32	
	A32T TWLNR/L 06	32	30	300	45	22	40	
	A25T TWLNR/L 08	25	23	300	40	17	32	WN... 0804...
	A32T TWLNR/L 08	32	30	300	45	22	40	
	A40T TWLNR/L 08	40	37	300	45	27	50	

A277-A280, A323, A324

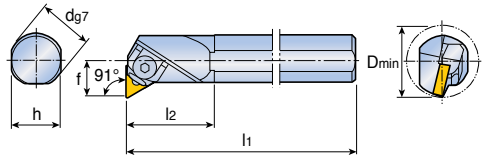
• ✓ Marked: For RHINORUSH insert

Spare parts

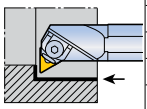
Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Nozzle	Wrench	
S25R...0604	DLM 3-NX	DLS 3	LSW 32	SO 40073I	DSP 3	-	L-W 2.5	T 15
S32S...0604	DLM 3-NX	DLS 3	LSW 32	SO 40085I	DSP 3	-	L-W 2.5	T 15
A25R...0604	DLM 3-NX	DLS 3	LSW 32	SO 40073I	DSP 3	NZ 62	L-W 2.5	T 15
A32S...0604	DLM 3-NX	DLS 3	LSW 32	SO 40085I	DSP 3	NZ 62	L-W 2.5	T 15
A20S...06	DLM 3	DLS 3	-	-	DSP 3	NZ 62	L-W 2.5	-
...06	DLM 3	DLS 3	PSW 32	SO 40090I	DSP 3	NZ 62	L-W 2.5	T 15
...08	DLM 4	DLS 4	PSW 42	TS 50A105I	DSP 4	NZ 62	L-W 3	T 20
A40T...08	DLM 4	DLS 4	TSW 44	SO 40050I	DSP 4	NZ 104	L-W 3	T 15

S-WTFNR/L

Wedge clamp type



S-WTFNR/L

Approach angle	Designation	Dimension (mm)						Insert	
		dg7	h	l1	l2	f	Dmin		
91°	✓ S25R WTFNR/L 1304	25	23	200	40	17	32	TN... 1304...	A268-A273, A322, A332
	✓ S32S WTFNR/L 1304	32	30	250	45	22	40		
	S25T WTFNR/L 16	25	23	300	50	17	32	TN... 1604...	
	S32T WTFNR/L 16	32	30	300	55	22	40		
	S40T WTFNR/L 16	40	37	300	60	27	50		
	S40T WTFNR/L 22	40	37	300	60	27	50	TN... 2204...	
	S50U WTFNR/L 22	50	47	350	65	35	63		

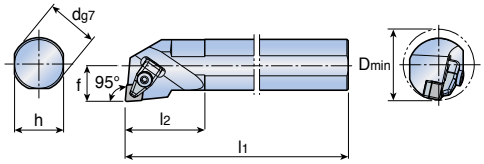
• ✓ Marked: For RHINORUSH insert

Spare parts

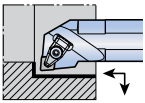
Designation	Wedge clamp	Screw	Snap ring	Shim	Pin screw	Wrench		
S25R...1304	WC 2.53	WCS 2.5	CSR 2	-	WSS 2.52-1	L-W 2.5		
S32S...1304	WC 2.53	WCS 2.5	CSR 2	WST 2.52	WSS 2.52	L-W 2.5		
S25T ...16	WC 33	WCS 4B	WSR 4	-	WSS 33-1	L-W 3		
...16	WC 33	WCS 4	WSR 4	WST 33	WSS 33	L-W 3		
...22	WC 43	WCS 4	WSR 4	WST 43	WSS 43	L-W 3		

S-TCLNR/L-CH

Ceramic dimple holder type



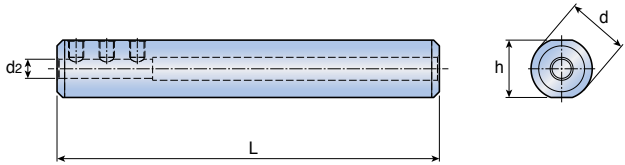
S-TCLNR/L-CH

Approach angle	Designation	Dimension (mm)						Insert
		dg7	h	l1	l2	f	Dmin	
95°	**S40T TCLNR/L 1207-CH**	40	37	300	50	27	70	CN...X 1207... A315
	**S50U TCLNR/L 1207-CH**	50	47	350	50	32	70	

Spare parts

Designation	Clamp	Clamp screw	Shim	Shim screw	Spring	Wrench		
								
...1207-CH	CCL 4	CSC 4	S 48	BH M5×0.8×1.0	DSP 5	L-W 4, L-W 3		

Sleeve



TSL

Designation	Dimension (mm)			
	d2	h	L	d
TSL 16-04	4	15	100	16
16-05	5	15	100	16
16-06	6	15	100	16
16-07	7	15	100	16

Spare parts

Designation	Set screw	Wrench						
								
TSL...	SS M4x0.7x4	L-W 2						

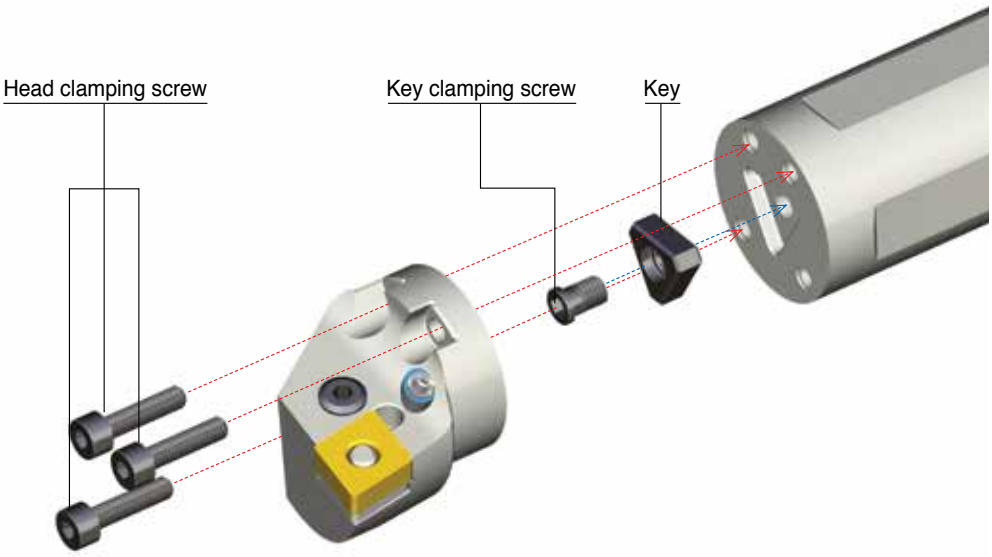
HE - D32 - PCLNR 12

1 2 3

1 Head

2 Shank diameter

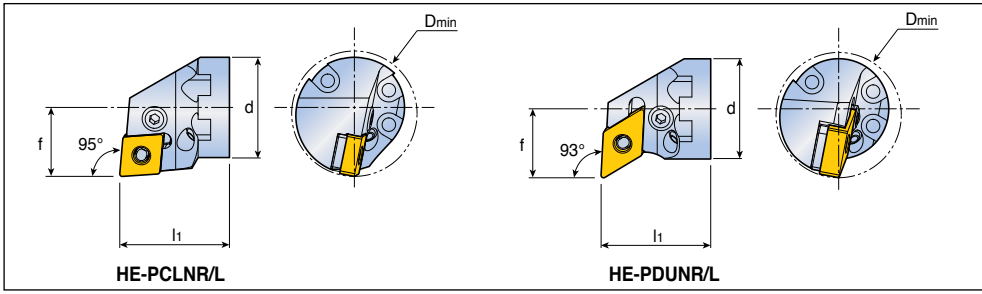
3 Designation follows boring bar system, see page A163



- Triangular detachable anti-rotator induces auto-centering and durability
- High repeatability during head change
- Possibility of inner coolant
- Head for ISO turning

HE-PCLNR/L HE-PDUNR/L

Lever lock type



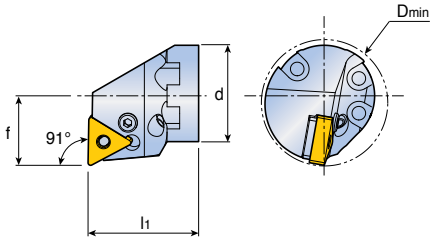
Approach angle	Designation	Dimension (mm)				Insert	
		d	l1	f	Dmin		
95°	**HE-D32-PCLNR/L 12**	32	35	22	40	CN...1204...	A244-A252, A314-A315, A328
93°	**HE-D32-PDUNR/L 15**	32	35	22	40	DN...1506...	A253-A257, A316, A329

Spare parts

Designation	Lever	Screw	Shim		Shim pin	Nozzle	Wrench	
...12	LCL 4	LCS 4S	LSC 42	-	LSP 4	NZ 62	L-W 3	
...15	LCL 4A	LCS 4S	-	LSD 42	LSP 4	NZ 62	L-W 3	

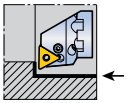
HE-PTFNR/L

Lever lock type



HE-PTFNR/L

Approach angle	Designation	Dimension (mm)				Insert
		d	l1	f	Dmin	
91°	**HE-D32-PTFNR/L 16**	32	35	22	40	TN...1604... A268-A273, A322, A332

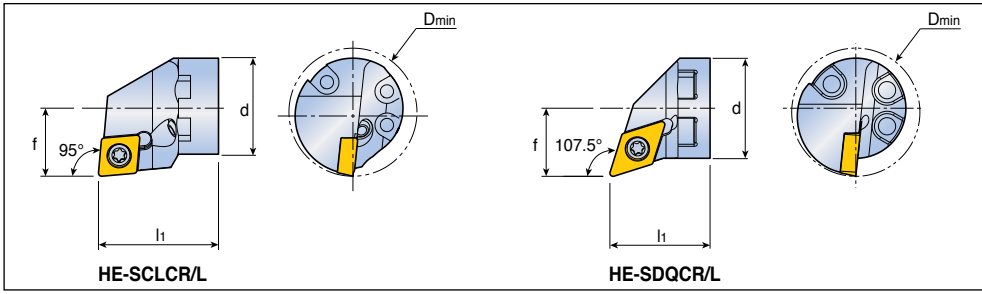


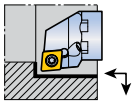
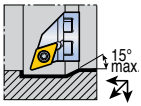
Spare parts

Designation	Lever	Screw	Shim	Shim pin	Nozzle	Wrench		
...16	LCL 3	LCS 3	LST 31.8	LSP 3A	NZ 62	L-W 2.5		

HE-SCLCR/L HE-SDQCR/L

Screw type



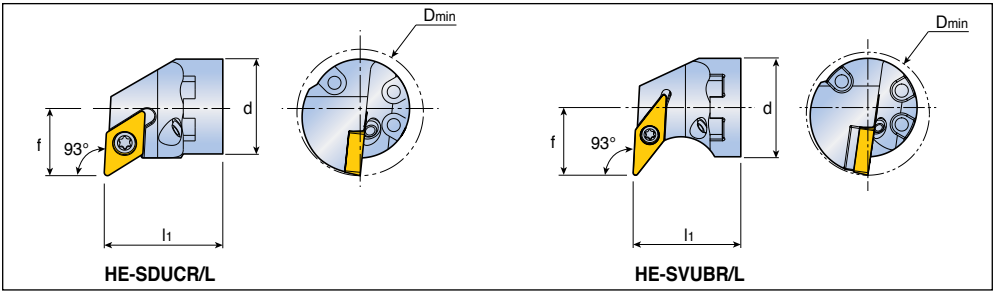
Approach angle	Designation	Dimension (mm)				Insert
		d	l1	f	Dmin	
95°	**HE-D25-SCLCR/L 09**	25	23	300	45	CC...T 09T3...
	**D32-SCLCR/L 12**	32	30	300	45	CC...T 1204... A282-A284, A335
107.5°	**HE-D25-SDQCR/L 11**	25	25	17	32	DC...T 11T3... A286-A288, A336
						

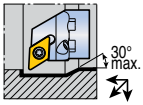
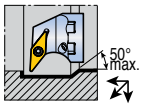
Spare parts

Designation	Screw	Shim	Shim screw	Nozzle	Wrench			
								
...09	SO 35080I	-	-	-	T 15			
...11	SO 35080I	-	-	-	T 15			
...12	SO 45130I	SSC 43N	SO 60105S	NZ 62	T 20			

HE-SDUCR/L HE-SVUBR/L

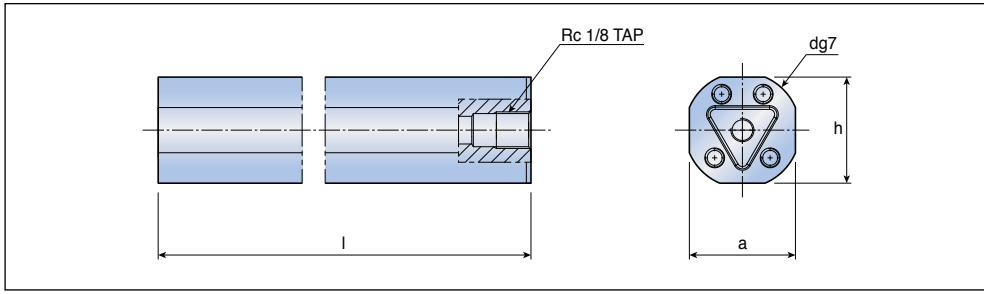
Screw type



Approach angle	Designation	Dimension (mm)				Insert
		d	l1	f	Dmin	
93° 	**HE- D25-SDUCR/L 11**	25	25	17	32	DC...T 11T3... A286-A288, A336
	D32-SDUCR/L 11	32	35	22	40	
93° 	**HE- D32-SVUBR/L 16**	32	35	22	40	VB...T 1604... A300-A301, A341

Spare parts

Designation	Screw	Shim	Shim screw	Nozzle	Wrench			
...D25...11	SO 35080I	-	-	-	T 15			
...D32...11	SO 35080I	-	-	NZ 62	T 15			
...16	SO 35124I	SSV 32	SO 50090S	NZ 62	T 15			



	Designation	Dimension (mm)							
		d	l	h	a				
	SK- D25	25	170	23	23				
	D32	32	215	30	30				

Spare parts

Designation	Key	Key screw	Clamp screw	Wrench				
								
SK...	SDK T10-5	SO 50090S	SH M4x0.7x16	L-W 3				

Cartridge Designation System

P	C	L	N	R	-	16	C	A	-	12
1	2	3	4	5		6	7	8		9

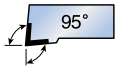
1 Clamping system

P	
Lever lock	
C	
Top clamp	
S	
Screw clamp	
H	
Hook lever	

2 Insert shape

	
T	
	
C	
	
S	

3 Approach angle

	
L	S
	
F	R
	
K	G
	
W	T

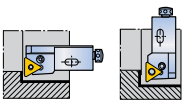
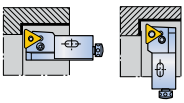
4 Insert clearance angle


C

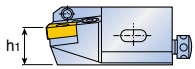
P

N

5 Hand of tool

R	 Right hand
L	 Left hand

6 Shank height



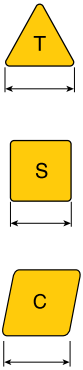
7 Type of tool

C: Cartridge

8 Type of design

A: Letter for alternative designs

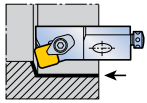
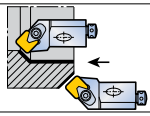
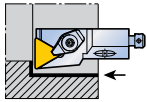
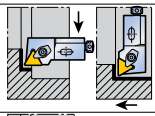
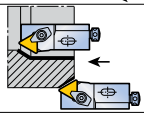
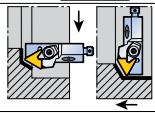
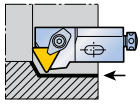
9 Cutting edge length



See page A243

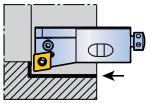
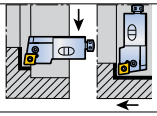
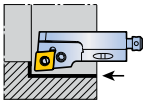
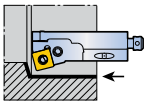
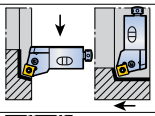
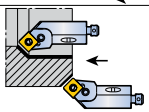
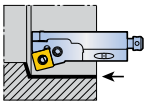
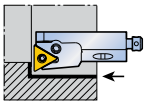
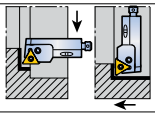
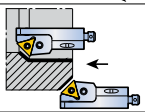
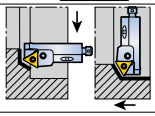
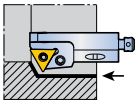
Cartridge Program

Top clamp type

Approach angle	Style		Cartridge size				
			10CA	12CA	16CA	20CA	25CA
75°		**CSKPR/L**	10CA 09	12CA 12	16CA 12		
45°		**CSSPR/L**		12CA 12	16CA 12		
90°		**CTFPR/L**	10CA 11	12CA 16	16CA 16		
90°		**CTGPR/L**	10CA 11	12CA 16	16CA 16		
45°		**CTSPR/L**	10CA 11	12CA 16	16CA 16		
60°		**CTTPR/L**	10CA 11	12CA 16	16CA 16		
60°		**CTWPR/L**	10CA 11	12CA 16	16CA 16		

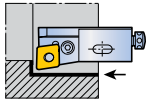
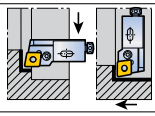
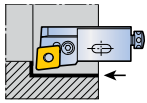
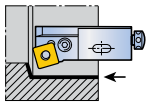
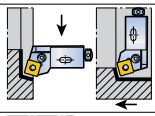
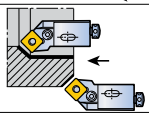
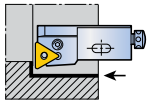
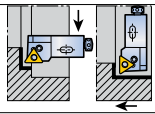
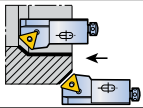
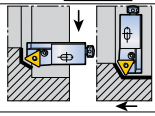
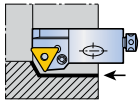
Cartridge Program

Hook lever lock type

Approach angle	Style		Cartridge size				
			10CA	12CA	16CA	20CA	25CA
90°		HCFNR/L			16CA 0904		
90°		HCGNR/L			16CA 0904		
95°		HCLNR/L		12CA 0904	16CA 0904		
75°		HSKNR/L	10CA 0904	12CA 0904			
75°		HSRNR/L			16CA 0904		
45°		HSSNR/L		12CA 0904	16CA 0904		
85°		HSYNR/L	10CA 0904	12CA 0904			
90°		HTFNR/L		12CA 1304	16CA 1304		
90°		HTGNR/L		12CA 1304	16CA 1304		
45°		HTSNR/L		12CA 1304	16CA 1304		
60°		HTTNR/L		12CA 1304			
60°		HTWNR/L		12CA 1304			

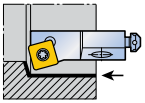
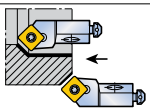
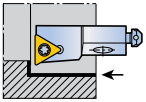
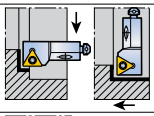
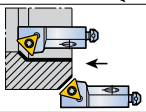
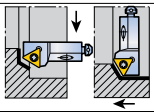
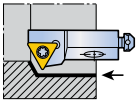
Cartridge Program

Lever lock type

Approach angle	Style		Cartridge size				
			10CA	12CA	16CA	20CA	25CA
90°		PCFNR/L			16CA 12		25CA 19
90°		PCGNR/L			16CA 12		25CA 19
95°		PCLNR/L			16CA 12		25CA 19
75°		PSKNR/L		12CA 12	16CA 12	20CA 15	25CA 19
75°		PSRNR/L			16CA 12	20CA 15	
45°		PSSNR/L		12CA 12	16CA 12	20CA 15	
90°		PTFNR/L	10CA 11	12CA 16	16CA 16	20CA 22	25CA 27
90°		PTGNR/L	10CA 11	12CA 16	16CA 16	20CA 22	
45°		PTSNR/L	10CA 11	12CA 16	16CA 16	20CA 22	
60°		PTTNR/L	10CA 11	12CA 16	16CA 16	20CA 22	
60°		PTWNR/L	10CA 11	12CA 16	16CA 16	20CA 22	

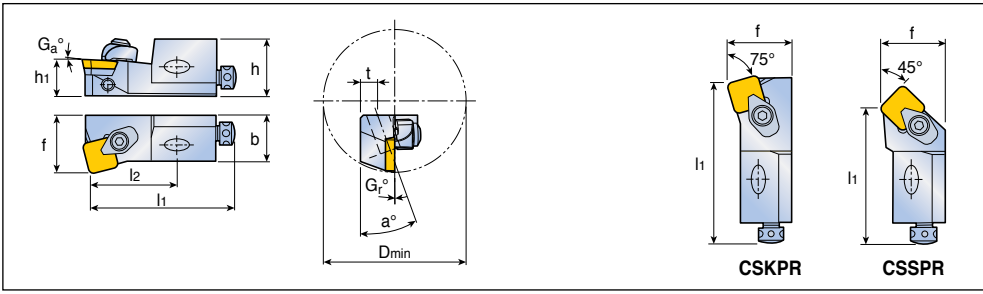
Cartridge Program

Screw clamp type

Approach angle	Style		Cartridge size				
			10CA	12CA	16CA	20CA	25CA
75°		**SSKCR/L**	10CA 09	12CA 09			
45°		**SSSCR/L**	10CA 09	12CA 12			
90°		**STFCR/L**	10CA 11	12CA 16	16CA 16		
90°		**STGCR/L**	10CA 11	12CA 16	16CA 16		
45°		**STSCR/L**	10CA 11	12CA 16	16CA 16		
60°		**STTCR/L**	10CA 11	12CA 16	16CA 16		
60°		**STWCR/L**	10CA 11	12CA 16	16CA 16		

CSKPR/L CSSPR/L

Top clamp type



Approach angle	Designation		Dimension (mm)										Insert
			h	h1	b	l1	l2	f	Ga°	Gr°	t	a°	Dmin	
75°	**CSKPR/L**	**10CA 09**	15	10	11	50	30	14	6	2	5	20	40	SPMR, SP...N 0903...
		12CA 12	20	12	15	55	35	20	6	2	6	20	50	SPMR, SP...N 1203...
		16CA 12	21	16	20	63	38	25	6	2	-	45	55	
45°	**CSSPR/L**	**12CA 12**	20	12	15	47	27	20	4	4	6	20	50	
		16CA 12	21	16	20	53	28	25	3	3	-	45	55	

A292, A325, A338

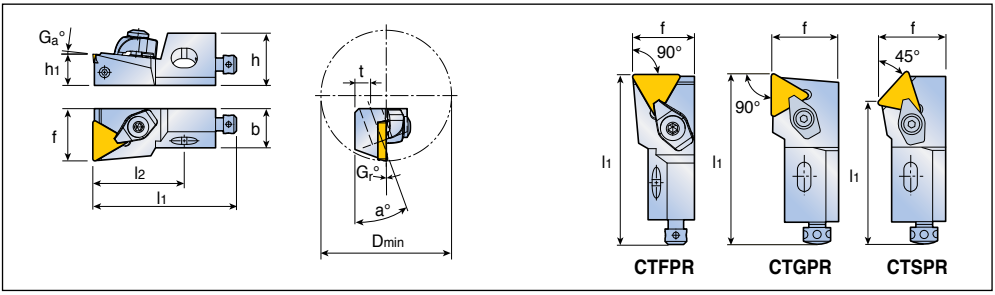
• All cartridges are to be ordered as specials

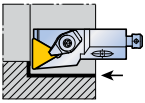
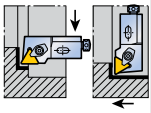
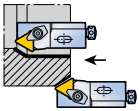
Spare parts

Designation	Clamp	Screw	Shim	Shim pin	Snap ring	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
...10CA 09	CL 2C	CLS 2C	-	-	CSR 2C	AJM 5F	RSS M4	BH M6x1x20	-	L-W 2.5
...12CA 12	CL 3C	CLS 3C	-	-	CSR 2	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	L-W 3
...16CA 12	CL 3C	CLS 3C	CSS 42	CSP 3	CSR 2	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	L-W 3

CTFPR/L CTGPR/L CTSPR/L

Top clamp type



Approach angle	Designation		Dimension (mm)											Insert
			h	h1	b	l1	l2	f	Ga°	Gr°	t	a°	Dmin	
90°	**CTFPR/L**	**10CA 11**	15	10	11	50	30	14	6°	0°	5	20°	40	TPMR 1103...
		**12CA 16**	20	12	15	55	35	20	6°	0°	6	20°	50	TPMR 1603...
		16CA 16	21	16	20	63	38	25	6°	0°	-	45°	55	
90°	**CTGPR/L**	**10CA 11**	15	10	11	50	30	14	0°	4°	5	20°	40	TPMR 1103...
		**12CA 16**	20	12	15	55	35	20	0°	4°	6	20°	50	TPMR 1603...
		16CA 16	21	16	20	63	38	25	0°	4°	-	45°	60	
45°	**CTSPR/L**	**10CA 11**	15	10	11	44	24	14	3°	3°	5	20°	40	TPMR 1103...
		**12CA 16**	20	12	15	47	27	20	3°	3°	6	20°	50	TPMR 1603...
		16CA 16	21	16	20	53	28	25	3°	3°	-	45°	55	


A296, A298-A299, A325, A339, A340

• All cartridges are to be ordered as specials

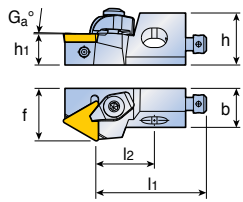
Spare parts

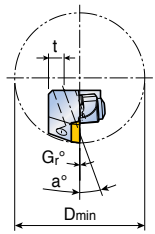
Designation	Clamp	Screw	Shim	Shim pin	Snap ring	Axial adj.screw	Radial adj.Sscrew	Mounting screw	Washer	Wrench
										
...10CA 11	CL 2C	CLS 2C	-	-	CSR 2C	AJM 5F	RSS M4	BH M6x1x20	-	L-W 2.5
...12CA 16	CL 3C	CLS 3C	-	-	CSR 2	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	L-W 3
...16CA 16	CL 3C	CLS 3C	CST 32	CSP 3	CSR 2	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	L-W 3

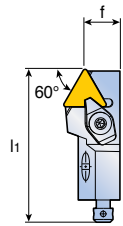
TaeguTec Member IMC Group

CTTPR/L CTWPR/L

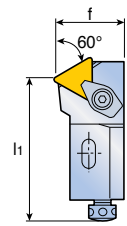
Top clamp type







CTTPR



CTWPR

Approach angle	Designation		Dimension (mm)										Insert
			h	h1	b	l1	l2	f	Ga°	Gr°	t	a°	Dmin	
60°	CTTPR/L	10CA 11	15	10	11	50	30	9	3°	4°	5	20°	40	TPMR 1103...
		12CA 16	20	12	15	55	35	13	3°	4°	6	20°	50	TPMR 1603...
		16CA 16	21	16	20	63	38	15	2°	3°	-	45°	60	
60°	CTWPR/L	10CA 11	15	10	11	44	24	14	5°	3°	5	20°	40	TPMR 1103...
		12CA 16	20	12	15	47	27	20	5°	3°	6	20°	50	TPMR 1603...
		16CA 16	21	16	20	53	28	25	3°	2°	-	45°	55	

A296, A298-A299, A325, A339-A340

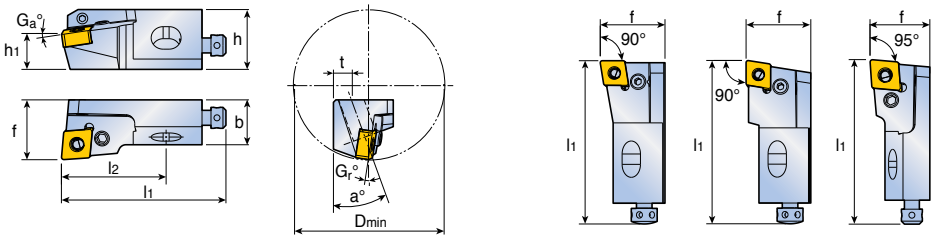
• All cartridges are to be ordered as specials

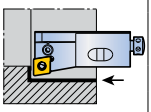
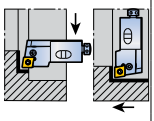
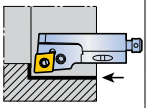
Spare parts

Designation	Clamp	Screw	Shim	Shim pin	Snap ring	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
...10CA 11	CL 2C	CLS 2C	-	-	CSR 2C	AJM 5F	RSS M4	BH M6x1x20	-	L-W 2.5
...12CA 16	CL 3C	CLS 3C	-	-	CSR 2	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	L-W 3
...16CA 16	CL 3C	CLS 3C	CST 32	CSP 3	CSR 2	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	L-W 3

HCFNR/L HCGNR/L HCLNR/L

Hook lever type



Approach angle	Designation	Dimension (mm)											Insert
		h	h1	b	l1	l2	f	G_a°	G_r°	t	a°	Dmin	
90°	✓ **HCFNR/L 16CA 0904**	25	16	20	63	38	25	-6°	-8°	-	45°	55	CN... 0904... A244, A246-A250
													
90°	✓ **HCGNR/L 16CA 0904**	25	16	20	63	38	25	-10°	-8°	-	45°	55	
													
95°	✓ **HCLNR/L 12CA 0904**	20	12	15	55	35	20	-8°	-8°	6	20°	50	
	16CA 0904	25	16	20	63	38	25	-8°	-8°	-	45°	55	
													

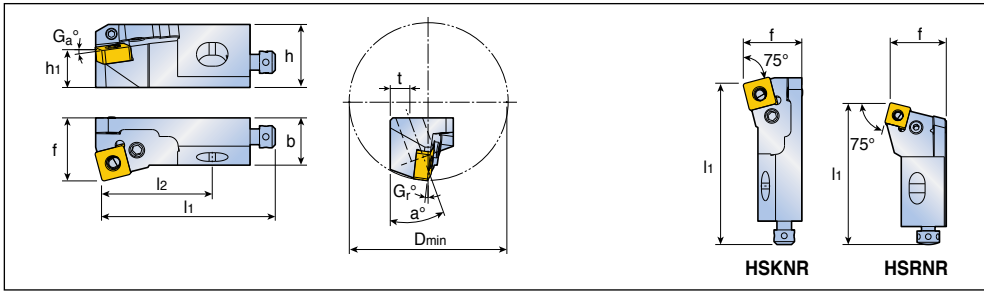
• ✓ Marked: For RHINORUSH insert • All cartridges are to be ordered as specials

Spare parts

Designation	Hook lever	Screw	Shim	Shim pin	Snap ring	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
										
...12CA 0904	LCL 09B-NX	LCS 3B	-	-	LSR 3B	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	L-W 2
...16CA 0904	LCL 09-NX	LCS 3	LSC 32	LSP 3A	-	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	L-W 2.5

HSKNR/L HSRNR/L

Hook lever type



Approach angle	Designation	Dimension (mm)											Insert
		h	h1	b	l1	l2	f	Ga°	Gr°	t	a°	Dmin	
75°	✓ **HSKNR/L 10CA 0904**	17	10	11	50	30	14	- 4°	- 9°	5	20°	40	SN... 0904... A263-A266
	12CA 0904	20	12	15	55	35	20	- 4°	- 9°	6	20°	50	
75°	✓ **HSRNR/L 16CA 0904**	25	16	20	63	38	25	- 11°	- 3°	-	45°	60	

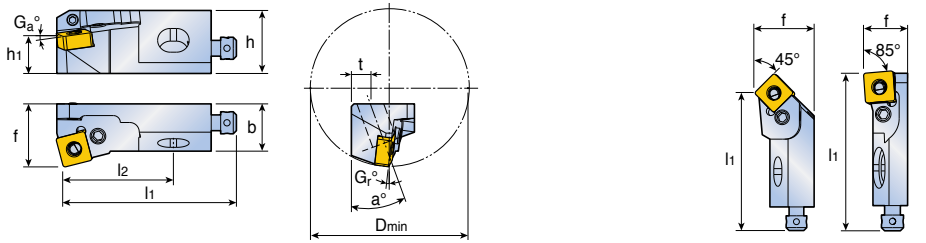
• ✓ Marked: For RHINORUSH insert • All cartridges are to be ordered as specials

Spare parts

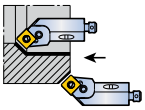
Designation	Hook lever	Screw	Shim	Shim pin	Snap ring	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
										
...10CA 0904 ...12CA 0904	LCL 09B-NX	LCS 3B	-	-	LSR 3B	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	L-W 2
...16CA 0904	LCL 09-NX	LCS 3	LSS 32	LSP 3A	-	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	L-W 2.5

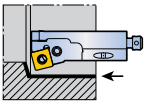
HSSNR/L HSYNR/L

Hook lever type



Approach angle	Designation		Dimension (mm)											Insert
			h	h1	b	l1	l2	f	Ga°	Gr°	t	a°	Dmin	
45°	✓ **HSSNR/L**	**12CA 0904**	20	12	15	47	27	20	- 9°	- 8°	6	20°	50	SN... 0904... A263-A266
		16CA 0904	25	16	20	53	28	25	- 8°	- 8°	-	45°	55	
85°	✓ **HSYNR/L**	**10CA 0904**	17	10	11	50	30	14	- 5°	- 9°	5	20°	40	
		12CA 0904	20	12	15	55	35	20	- 4°	- 9°	6	20°	50	





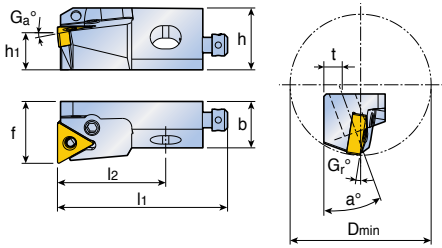
• ✓ Marked: For RHINORUSH insert • All cartridges are to be ordered as specials

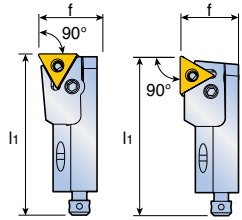
Spare parts

Designation	Hook lever	Screw	Shim	Shim pin	Snap ring	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
										
...10CA 0904 **...12CA 0904**	LCL 09B-NX	LCS 3B	-	-	LSR 3B	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	L-W 2
...16CA 0904	LCL 09-NX	LCS 3	LSS 32	LSP 3A	-	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	L-W 2.5

HTFNR/L HTGNR/L

Hook lever type





Approach angle	Designation		Dimension (mm)											Insert
			h	h1	b	l1	l2	f	Ga°	Gr°	t	a°	Dmin	
90°	✓ HTFNR/L	12CA 1304	20	12	15	55	35	20	- 6°	- 9°	6	20°	50	TN...1304... A268-A273
		16CA 1304	25	16	20	63	38	25	- 6°	- 8°	-	45°	55	
90°	✓ HTGNR/L	12CA 1304	20	12	15	55	35	20	- 10°	- 8°	6	20°	50	
		16CA 1304	25	16	20	63	38	25	- 10°	- 8°	-	45°	60	

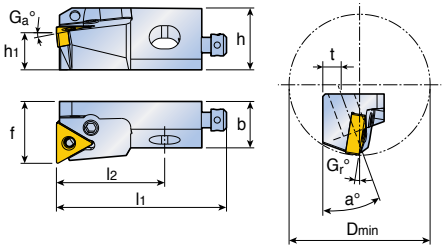
• ✓ Marked: For RHINORUSH insert • All cartridges are to be ordered as specials

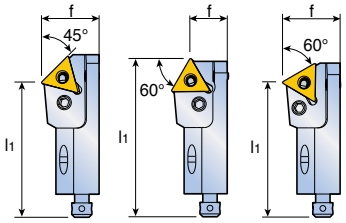
Spare parts

Designation	Hook lever	Screw	Shim	Shim pin	Snap ring	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
...12CA 1304	LCL 08B-NX	LCS 3B	-	-	LSR 3B	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	L-W 2
...16CA 1304	LCL 08-NX	LCS 3-NX	LST 2.51.8B	LSP 3B	-	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	L-W 2.5

HTSNR/L HTTNR/L HTWNR/L

Hook lever type





Approach angle	Designation		Dimension (mm)											Insert
			h	h1	b	l1	l2	f	Ga°	Gr°	t	a°	Dmin	
45°	✓ **HTSNR/L**	**12CA 1304**	20	12	15	47	27	20	- 5°	- 9°	6	20°	50	TN...1304... A268-A273
		16CA 1304	25	16	20	53	28	25	- 8°	- 8°	-	45°	55	
60°	✓ **HTTNR/L**	**12CA 1304**	20	12	15	55	35	13	- 6°	- 7°	6	20°	50	
60°	✓ **HTWNR/L**	**12CA 1304**	20	12	15	47	27	20	- 3°	- 9°	6	20°	50	

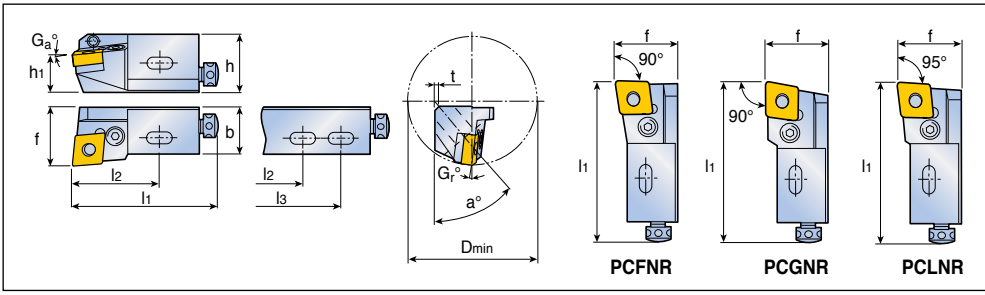
• ✓ Marked: For RHINORUSH insert • All cartridges are to be ordered as specials

Spare parts

Designation	Hook lever	Screw	Shim	Shim pin	Snap ring	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
...12CA 1304	LCL 08B-NX	LCS 3B	-	-	LSR 3B	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	L-W 2
...16CA 1304	LCL 08-NX	LCS 3-NX	LST 2.51.8B	LSP 3B	-	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	L-W 2.5

PCFNR/L PCGNR/L PCLNR/L

Lever lock type



Approach angle	Designation		Dimension (mm)												Insert
			h	h1	b	l1	l2	l3	f	Ga°	Gr°	t	a°	Dmin	
90°	**PCFNR/L**	**16CA 12**	25	16	20	63	38	-	25	- 6°	- 8°	-	45°	55	CN... 1204...
		25CA 19	38	25	25	100	50	70	32	- 6°	- 8°	-	45°	100	CN... 1906...
90°	**PCGNR/L**	**16CA 12**	25	16	20	63	38	-	25	- 10°	6°	-	45°	55	CN... 1204...
		25CA 19	38	25	25	100	50	70	32	- 8°	6°	-	45°	100	CN... 1906...
95°	**PCLNR/L**	**16CA 12**	25	16	20	63	38	-	25	- 8°	- 8°	-	45°	55	CN... 1204...
		25CA 19	38	25	25	100	50	70	32	- 8°	- 8°	-	45°	100	CN... 1906...

A244-A252, A314-A315, A328

• All cartridges are to be ordered as specials

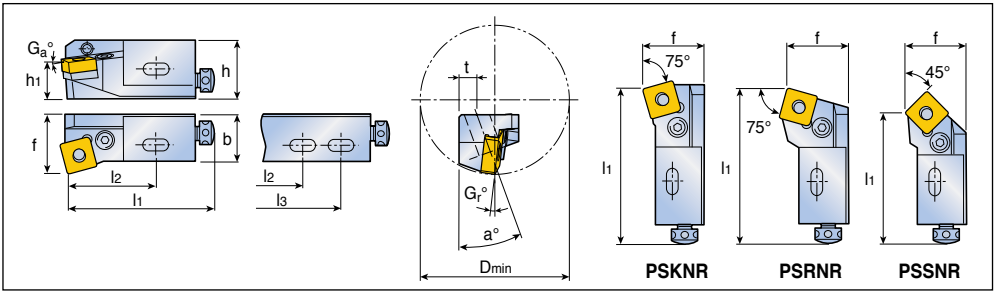
Spare parts

Designation	Lever	Screw	Shim	Shim pin	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
...16CA 12	LCL 4	LCS 4S	LSC 42	LSP 4	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	L-W 3
...25CA 19	LCL 6D	LCS 6	LSC 63	LSP 6	ASM 6	RSS M5	BH M10x1.5x40	MW 10.4x21	L-W 4

PSKNR/L PSRNR/L PSSNR/L

T-TURN

Lever lock type



Approach angle	Designation	Dimension (mm)												Insert
		h	h1	b	l1	l2	l3	f	Ga°	Gr°	t	a°	Dmin	
75°	**PSKNR/L 12CA 12**	20	12	15	55	35	-	20	- 4°	- 9°	6	20°	50	SN...1204...
	16CA 12	25	16	20	63	38	-	25	- 4°	- 8°	-	45°	55	
	20CA 15	30	20	20	70	40	-	25	- 4°	- 9°	-	45°	70	SN...1506...
	25CA 19	38	25	25	100	50	70	32	- 4°	- 8°	-	45°	100	SN...1906...
75°	**PSRNR/L 16CA 12**	25	16	20	63	38	-	25	- 11°	- 3°	-	45°	60	SN...1204...
	20CA 15	30	20	20	70	40	-	25	- 11°	- 3°	-	45°	70	SN...1506...
45°	**PSSNR/L 12CA 12**	20	12	15	47	27	-	20	- 9°	- 5°	6	20°	50	SN...1204...
	16CA 12	25	16	20	53	28	-	25	- 9°	- 5°	-	45°	55	
	20CA 15	30	20	20	60	30	-	25	- 9°	- 5°	-	45°	70	SN...1506...

A261-A267, A319-A320, A331

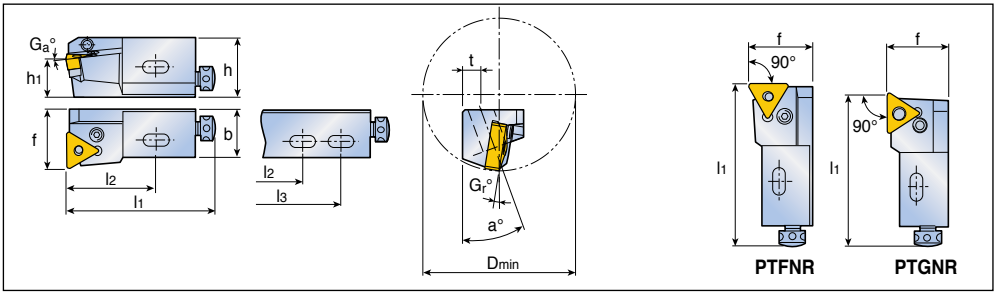
• All cartridges are to be ordered as specials

Spare parts

Designation	Lever	Screw	Shim	Shim pin	Snap ring	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
...12CA 12	LCL 4B	LCS 4B	-	-	LSR 4B	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	L-W 2.5
...16CA 12	LCL 4	LCS 4S	LSS 42	LSP 4	-	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	L-W 3
...20CA 15	LCL 5	LCS 5	LSS 53	LSP 5	-	ASM 6	RSS M5	BH M8x1.25x35	MW 8.4x18	L-W 3
...25CA 19	LCL 5	LCS 5	LSS 53	LSP 5	-	ASM 6	RSS M5	BH M10x1.5x40	MW 10.4x20	L-W 3

PTFNR/L PTGNR/L

Lever lock type



Approach angle	Designation		Dimension (mm)												Insert
			h	h1	b	l1	l2	l3	f	Ga°	Gr°	t	a°	Dmin	
90°	PTFNR/L	10CA 11	17	10	11	50	30	-	14	- 6°	- 8°	5	20°	40	TN...1103...
		12CA 16	20	12	15	55	35	-	20	- 6°	- 9°	6	20°	50	TN...1604...
		16CA 16	25	16	20	63	38	-	25	- 6°	- 8°	-	45°	55	
		20CA 22	30	20	20	70	40	-	25	- 6°	- 8°	-	45°	70	TN...2204...
		25CA 27	38	25	25	100	50	70	32	- 6°	- 9°	-	45°	100	TN...2706...
90°	PTGNR/L	10CA 11	17	10	11	50	30	-	14	- 10°	- 6°	5	20°	40	TN...1103...
		12CA 16	20	12	15	55	35	-	20	- 10°	- 6°	6	20°	50	TN...1604...
		16CA 16	25	16	20	63	38	-	25	- 10°	- 6°	-	45°	60	
		20CA 22	30	20	20	70	40	-	25	- 8°	- 6°	-	45°	70	TN...2204...

A268-A273, A322, A332

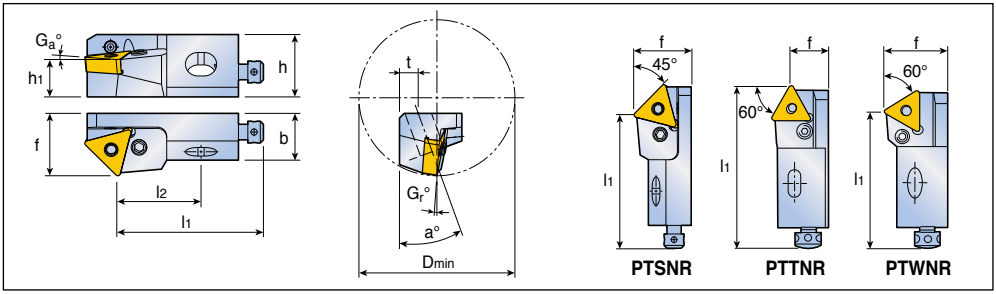
• All cartridges are to be ordered as specials

Spare parts

Designation	Lever	Screw	Shim	Shim pin	Snap ring	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
...10CA 11	LCL 2B	LCS 2B	-	-	LSR 2B	AJM 5F	RSS M4	BH M6x1x20	-	L-W 2
...12CA 16	LCL 3BH	LCS 3B	-	-	LSR 3B	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	L-W 2
...16CA 16	LCL 3	LCS 3	LST 31.8	LSP 3A	-	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	L-W 2.5
...20CA 22	LCL 4	LCS 4	LST 42	LSP 4	-	ASM 6	RSS M5	BH M8x1.25x35	MW 8.4x18	L-W 3
...25CA 27	LCL 5	LCS 5	LST 53	LSP 5	-	ASM 6	RSS M5	BH M10x1.5x40	MW 10.4x20	L-W 3

PTSNR/L PTTNR/L PTWNR/L

Lever lock type



Approach angle	Designation		Dimension (mm)											Insert
			h	h1	b	l1	l2	f	Ga°	Gr°	t	a°	Dmin	
45°	PTSNR/L	10CA 11	17	10	11	44	24	14	- 5°	- 9°	5	20°	40	TN...1103...
		12CA 16	20	12	15	47	27	20	- 5°	- 9°	6	20°	50	TN...1604...
		16CA 16	25	16	20	53	28	25	- 8°	- 8°	-	45°	55	
		20CA 22	30	20	20	60	30	25	- 8°	- 8°	-	45°	70	TN...2204...
60°	PTTNR/L	10CA 11	17	10	11	50	30	9	- 6°	- 7°	5	20°	40	TN...1103...
		12CA 16	20	12	15	55	35	13	- 6°	- 7°	6	20°	50	TN...1604...
		16CA 16	25	16	20	63	38	15	- 7°	- 8°	-	45°	60	
		20CA 22	30	20	20	70	40	15	- 7°	- 8°	-	45°	70	TN...2204...
60°	PTWNR/L	10CA 11	17	10	11	44	24	14	- 1°	- 10°	5	20°	40	TN...1103...
		12CA 16	20	12	15	47	27	20	- 3°	- 9°	6	20°	50	TN...1604...
		16CA 16	25	16	20	53	28	25	- 2°	- 8°	-	45°	55	
		20CA 22	30	20	20	60	30	25	- 2°	- 8°	-	45°	70	TN...2204...

A268-A273, A322, A332

• All cartridges are to be ordered as specials

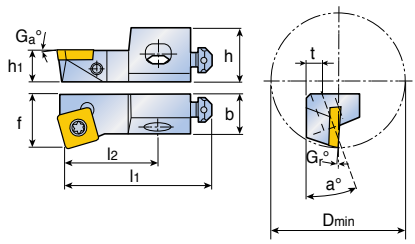
Spare parts

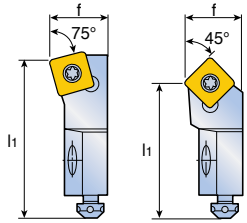
Designation	Lever	Screw	Shim	Shim Pin	Snap ring	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
...10CA 11	LCL 2B	LCS 2B	-	-	LSR 2B	AJM 5F	RSS M4	BH M6x1x20	-	L-W 2
...12CA 16	LCL 3BH	LCS 3B	-	-	LSR 3B	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	L-W 2
...16CA 16	LCL 3	LCS 3	LST 31.8	LSP 3A	-	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	L-W 2.5
...20CA 22	LCL 4	LCS 4	LST 42	LSP 4	-	ASM 6	RSS M5	BH M8x1.25x35	MW 8.4x18	L-W 3

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SSKCR/L SSSCR/L

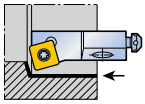
Screw type

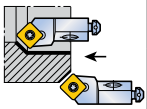




Approach angle	Designation	Dimension (mm)											Insert
		h	h1	b	l1	l2	f	Ga°	Gr°	t	a°	Dmin	
75°	**SSKCR/L 10CA 09**	15	10	11	50	30	14	- 1°	- 4°	5	20°	40	SC...T 09T3...
	12CA 12	20	12	15	55	35	20	- 1°	- 4°	6	20°	50	SC...T 1204...
45°	**SSSCR/L 10CA 09**	15	10	11	44	24	14	- 4°	- 4°	5	20°	40	SC...T 09T3...
	12CA 12	20	12	15	47	27	20	- 4°	- 4°	6	20°	50	SC...T 1204...

A291, A338





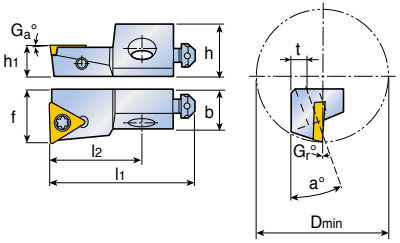
• All cartridges are to be ordered as specials

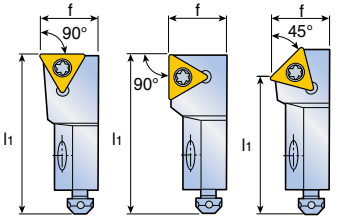
Spare parts

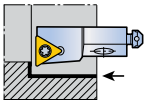
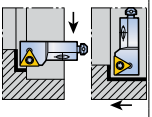
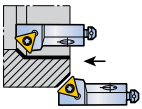
Designation	Screw	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
						
...10CA 09	SO 35080I	AJM 5F	RSS M4	BH M6x1x16	-	T 15
...12CA 12	SO 45100I	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	T 20

STFCR/L STGCR/L STSCR/L

Screw type





Approach angle	Designation		Dimension (mm)											Insert	
			h	h1	b	l1	l2	f	Ga°	Gr°	t	a°	Dmin		
90°	**STFCR/L**	**10CA 11**	15	10	11	50	30	14	0°	- 3°	5	20°	40	TC...T 1102...	A294-A295, A339-A340
		**12CA 16**	20	12	15	55	35	20	0°	- 3°	6	20°	50	TC...T16T3...	
		16CA 16	21	16	20	63	38	25	0°	- 6°	-	45°	55		
90°	**STGCR/L**	**10CA 11**	15	10	11	50	30	14	0°	- 3°	5	20°	40	TC...T 1102...	
		**12CA 16**	20	12	15	55	35	20	0°	- 3°	6	20°	50	TC...T 16T3...	
		16CA 16	21	16	20	63	38	25	- 3°	- 5°	-	45°	60		
45°	**STSCR/L**	**10CA 11**	15	10	11	44	24	14	- 3°	- 3°	5	20°	40	TC...T 1102...	
		**12CA 16**	20	12	15	47	27	20	- 4°	- 4°	6	20°	50	TC...T 16T3...	
		16CA 16	21	16	20	53	28	25	- 2°	- 6°	-	45°	55		

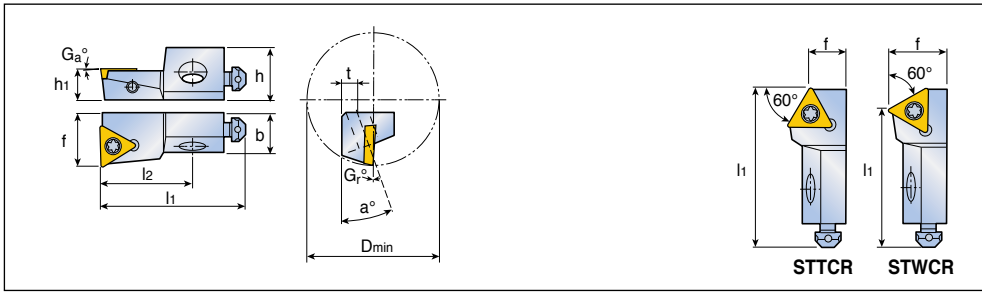
• All cartridges are to be ordered as specials

Spare parts

Designation	Screw	Shim	Shim pin	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
								
...10CA 11	SO 25065I	-	-	AJM 5F	RSS M4	BH M6x1x16	-	T 7
...12CA 16	SO 35080I	-	-	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	T 15
...16CA 16	SO 35124I	SST 32	SO 50090S	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	T 15

STTCR/L STWCR/L

Screw type



Approach angle	Designation		Dimension (mm)											Insert
			h	h1	b	l1	l2	f	Ga°	Gr°	t	a°	Dmin	
60°	**STTCR/L**	**10CA 11**	15	10	11	50	30	9	- 3°	- 4°	5	20°	40	TC...T 1102...
		12CA 16	20	12	15	55	35	13	- 3°	- 2°	6	20°	50	TC...T 16T3...
		16CA 16	21	16	20	63	38	15	- 4°	- 3°	-	45°	60	
60°	**STWCR/L**	**10CA 11**	15	10	11	44	24	14	- 2°	- 3°	5	20°	40	TC...T 1102...
		12CA 16	20	12	15	47	27	20	- 4°	- 2°	6	20°	50	TC...T 16T3...
		16CA 16	21	16	20	53	28	25	- 5°	- 3°	-	45°	55	

A294-A295, A339-A340

• All cartridges are to be ordered as specials

Spare parts

Designation	Screw	Shim	Shim pin	Axial adj.screw	Radial adj.screw	Mounting screw	Washer	Wrench
...10CA 11	SO 25065I	-	-	AJM 5F	RSS M4	BH M6x1x16	-	T 7
...12CA 16	SO 35080I	-	-	AJM 5F	RSS M4	BH M6x1x25	MW 6.4x12	T 15
...16CA 16	SO 35124I	SST 32	SO 50090S	ASM 6	RSS M5	BH M8x1.25x30	MW 8.4x18	T 15

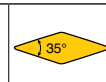
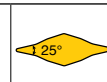
Turning Inserts



Insert Designation System

C	N	M	G
1	2	3	4

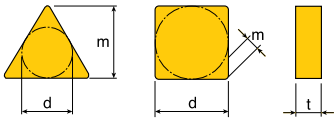
1 Shape

										
C	D	E	H	K	R	S	T	V	W	Y

2 Clearance angle

			
N	B	C	P

3 Tolerance



Class	m	t	d
A	±0.005	±0.025	±0.025
F	±0.005	±0.025	±0.013
C	±0.013	±0.025	±0.025
H	±0.013	±0.025	±0.013
E	±0.025	±0.025	±0.025
G	±0.025	±0.13	±0.025
M	±0.08~±0.18	±0.13	±0.05~±0.13
U	±0.13~±0.38	±0.13	±0.08~±0.25

Diameter of IC	Tolerance			
	On m		On d	
	Class M	Class U	Class M	Class U
6.35	±0.08	±0.13	±0.05	±0.08
9.52	±0.08	±0.13	±0.05	±0.08
12.70	±0.13	±0.20	±0.08	±0.13
15.88	±0.15	±0.27	±0.10	±0.18
19.05	±0.15	±0.27	±0.10	±0.18
25.40	±0.18	±0.38	±0.13	±0.25
31.75	±0.18	±0.38	±0.13	±0.25

4 Type

					
A	G	M	R	B, W	T, H

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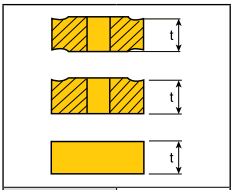
Insert Designation System

12	04	08	(R)	MP
5	6	7	8	9

5 Cutting edge length

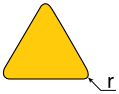
I.C(mm)	C	D	E	R	S	T	V	W	K	H
3.97	03	04			03	06		02		
4.76	04	05			04	08	08			
5.56	05	06			05	09	09	03		
6.35	06	07			06	11	11	04		
7.94	08	09			07	13	13	05		
8.0				08						
9.52	09	11		09	09	16	16	06	16	
10.0				10						
11.11		13								
12.0				12						
12.7	12	15	13		12	22	22	08		05
15.88	16	19		15	15	27	27	10		
16.0				16						
19.05	19	23		19	19	33	33	13		10
20.0				20						
25.0				25						
25.4	25	31		25	25	44	44	17		
31.75	32	38			31	54	54	21		
32.0				32						

6 Thickness



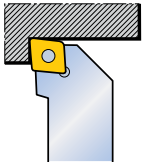
01	1.59mm
T1	1.98mm
02	2.38mm
T2	2.78mm
03	3.18mm
T3	3.97mm
04	4.76mm
05	5.56mm
06	6.35mm
07	7.94mm
09	9.52mm

7 Corner radius

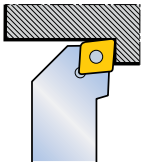


01	0.1mm
02	0.2mm
04	0.4mm
05	0.5mm
08	0.8mm
12	1.2mm
16	1.6mm
20	2.0mm
24	2.4mm
32	3.2mm

8 Hand of insert



R: Right hand



L: Left hand

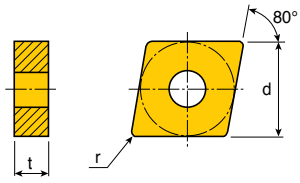
9 Chip breaker

For chip breakers, see page A32-A42

CNGG CNMA

T-TURN

Negative 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	4.76	0.1-1.2
12	12.7	4.76	0.1-1.6
16	15.88	6.35	1.2-1.6
19	19.05	6.35	0.4-1.6

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
RHINO-ROCK	**CNGG**	**090401 ML**	0.03-0.10	0.1-1.0															●				●	
		090402 ML	0.05-0.15	0.2-1.2															●				●	
		090404 ML	0.05-0.20	0.5-1.5															●				●	
		090408 ML	0.08-0.25	0.5-1.5															●				●	
Medium																								
	CNGG	**120401 ML**	0.03-0.10	0.1-3.5															●					
		120402 ML	0.05-0.15	0.2-3.5															●				●	
		120404 ML	0.10-0.30	0.8-3.5															●				●	
		120408 ML	0.12-0.35	1.0-3.5															●				●	
Medium																								
RHINO-ROCK	**CNMA**	**090408**	0.15-0.60	1.0-3.0			●	●																
		090412	0.15-0.70	1.0-3.0			●	●																
Roughing																								
	CNMA	**120404**	0.15-0.50	1.0-5.0			●	●	○														●	
		120408	0.15-0.60	1.0-6.0			●	●	○														●	
		120412	0.15-0.70	1.5-6.0			●	●	○		●													
		120416	0.20-0.80	2.0-6.0			●	●	○															
		160612	0.15-0.70	2.0-8.0			●	●	○															
		160616	0.20-0.80	2.0-8.0				●																
		190604	0.15-0.50	2.0-10.0																				
		190608	0.15-0.70	2.0-10.0					○															
		190612	0.15-0.70	2.0-10.0				●	○															
		190616	0.15-1.00	3.0-10.0			●	●	○															
Roughing																								
wiper	**CNMA**	**120408 WT** ✱	0.15-0.80	0.7-5.0			●																	
Roughing																								

A57, A58, A59, A74, A75, A102, A103, A133, A146, A148, A167, A176, A182, A204, A216, A229, A234

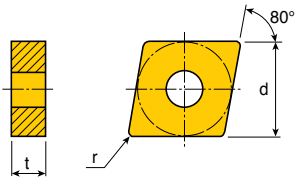
• ✱ Marked: Wiper inserts should be applied to ☐CLNR/L..., ☐CBNR/L..., ☐CKNR/L...

● : Standard items
○ : Semi standard items

TaeguTec
Member IMC Group

CNMD

Negative 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
19	19.05	6.35	2.4
25	25.4	9.52	2.4

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
TOPDUTY	**CNMD**	**250924 HD**									●	●	●											
		Roughing	0.55-1.50	4.0-15.0																				
		Finishing	0.40-0.80	2.0-5.0																				
Roughing																								
																								
Finishing																								
TOPDUTY	**CNMD**	**190624 HT**									●	●												
		Roughing	0.35-0.90	4.0-9.0																				
		Finishing	0.40-0.80	2.0-5.0																				
Roughing																								
		250924 HT									●	●												
		Roughing	0.55-1.30	5.0-12.0																				
		Finishing	0.40-0.80	2.0-5.0																				
Finishing																								
TOPDUTY	**CNMD**	**190624 HY**									●	●												
		Roughing	0.50-1.10	4.0-12.0																				
		Finishing	0.40-0.80	2.0-5.0																				
Roughing																								
		250924 HY									●	●	●											
		Roughing	0.55-1.50	4.0-15.0																				
		Finishing	0.40-0.80	2.0-5.0																				
Finishing																								
TOPDUTY	**CNMD**	**250924 HZ**									●	●	●											
		Roughing	0.55-1.50	4.0-15.0																				
		Finishing	0.40-0.80	2.0-5.0																				
Roughing																								
																								
Finishing																								



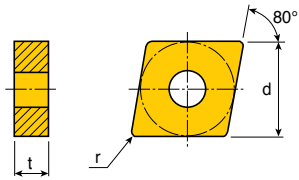
A74, A75

● : Standard items
○ : Semi standard items

TaeguTec

CNMG

Negative 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	4.76	0.4-1.2
12	12.7	4.76	0.4-1.6
16	15.88	4.76-6.35	0.4-1.6
19	19.05	6.35	0.4-1.6

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
RHINO-ROCK	**CNMG**	**090404**	0.10-0.45	0.5-3.0			●	●																
		090408	0.10-0.50	0.5-3.0			●	●																
		090412	0.10-0.55	0.5-3.0			●	●																
Medium																								
	CNMG	**120404**	0.17-0.45	1.0-5.0		●	●	●	○		●	●	●				●			●			●	
		120408	0.23-0.60	1.5-5.0		●	●	●	○		●	●	●				●		●	●		●		●
		120412	0.25-0.60	2.0-5.0			●	●	○		●	●					●							
		120416	0.27-0.60	2.5-5.0																				
		160408	0.25-0.60	2.0-6.5																				
		160604	0.20-0.45	2.0-6.5								●												
		160608	0.25-0.60	2.0-6.5							●	●					●							
		160612	0.27-0.60	2.0-6.5																				
		160616	0.29-0.60	2.0-6.5																				
		190604	0.20-0.45	3.0-8.0							●	●					●							
		190608	0.25-0.60	3.0-8.0			●	●	○		●	●	●				●							
		190612	0.30-0.60	3.0-8.0			●	●			●	●	●				●	●						
		190616	0.35-0.70	3.0-8.0							●	●	●				●							
RHINO-ROCK	**CNMG**	**090404 EA**	0.05-0.30	0.20-1.5										●	●	●			●		●			
		090408 EA	0.07-0.40	0.30-1.5										●	●	●			●		●			
Finishing																								
	CNMG	**120404 EA**	0.05-0.30	0.15-1.5							●	●		●	●	●	●		●	●	●			
		120408 EA	0.07-0.40	0.15-1.5		●					●			●	●	●			●		●			
Finishing																								

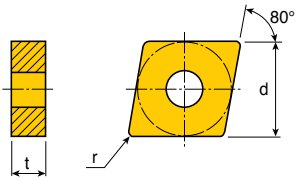
A57, A58, A59, A74, A75, A102,
A103, A133, A146, A148, A167,
A176, A182, A204, A216, A229, A234

● : Standard items
○ : Semi standard items

TaeguTec
Member IMC Group

CNMG

Negative 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	4.76	0.8-1.2
12	12.7	4.76	0.4-1.6
16	15.88	6.35	0.8-1.6
19	19.05	6.35	0.8-1.6

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated									PVD coated			Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
Medium	**CNMG**	**090408 EM**	0.13-0.40	0.5-3.0										●	●	●			●		●			
		090412 EM	0.15-0.40	0.7-3.0										●	●	●			●		●			
Medium	**CNMG**	**120404 EM**	0.11-0.50	0.5-5.0										●	●	●			●		●			
		120408 EM	0.13-0.50	0.5-5.0										●	●	●			●		●			
		120412 EM	0.15-0.55	0.5-5.0										●	●	●			●		●			
		120416 EM	0.17-0.60	0.5-5.0											●				●					
		160608 EM	0.13-0.50	0.5-6.5															●					
		160612 EM	0.15-0.55	0.5-6.5															●					
		160616 EM	0.17-0.60	0.5-6.5																				
		190608 EM	0.13-0.50	0.5-8.0															●					
		190612 EM	0.15-0.55	0.5-8.0											●				●		●			
		190616 EM	0.17-0.60	0.5-8.0															●					
Roughing	**CNMG**	**120408 ET**	0.17-0.55	1.2-5.5								●		●	●	●	●		●		●			
		120412 ET	0.20-0.60	1.2-5.5										●	●	●			●		●			
		160608 ET	0.20-0.60	2.5-7.0																				
		160612 ET	0.25-0.60	2.5-7.0											●				●		●			
		190608 ET	0.20-0.60	3.0-9.0																				
		190612 ET	0.25-0.60	3.0-9.0								●			●	●			●		●			
		190616 ET	0.30-0.65	3.0-9.0															●					
Finishing	**CNMG**	**120404 FA**	0.05-0.20	0.2-2.0		●					●	●					●							
		120408 FA	0.05-0.25	0.3-2.0		●					●	●												
Finishing	**CNMG**	**120404 FC**	0.05-0.30	0.2-2.5	●	●				●	●	●		●	●		●							
		120408 FC	0.08-0.35	0.3-2.5	●					●	●	●		●	●		●							
		120412 FC	0.10-0.40	0.3-2.5							●	●												

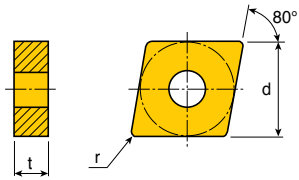
A57, A58, A59, A74, A75, A102,
A103, A133, A146, A148, A167,
A176, A182, A204, A216, A229, A234

● : Standard items
○ : Semi standard items

TaeguTec

CNMG

Negative 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	4.76	0.2-1.2
12	12.7	4.76	0.4-1.6
16	15.88	6.35	1.2-1.6
19	19.05	6.35	1.2-1.6

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Finishing	**CNMG**	**090404 FG**	0.07-0.30	0.2-2.0							●	●					●							
		090408 FG	0.10-0.35	0.5-2.0							●	●					●							
		090412 FG	0.15-0.40	0.5-2.0							●	●					●							
 Finishing	**CNMG**	**120404 FG**	0.05-0.30	0.2-2.5	●	●					●	●					●							
		120408 FG	0.08-0.35	0.3-2.5	●	●					●	●					●							
 Finishing	**CNMG**	**090404 FM**	0.07-0.30	0.25-2.0		●				●	●	●	●				●							
		090408 FM	0.10-0.35	0.3-2.0		●				●	●	●	●				●							
		090412 FM	0.15-0.40	0.35-2.0		●				●	●	●	●				●							
 Finishing	**CNMG**	**090402 FS**	0.05-0.25	0.2-1.5	●	●					●	●												
		090404 FS	0.08-0.30	0.3-1.5	●	●					●	●												
		090408 FS	0.10-0.30	0.5-1.5	●	●					●	●												
 Finishing	**CNMG**	**090404 FT**	0.07-0.30	0.4-3.0						●	●	●	●				●							
		090408 FT	0.10-0.40	0.5-3.0						●	●	●	●				●							
		090412 FT	0.15-0.50	0.6-3.0						●	●	●	●				●							
 Roughing	**CNMG**	**120408 KT**	0.19-0.53	0.38-7.0			●	●			●													
		120412 KT	0.25-0.70	0.50-7.0			●	●			●													
		120416 KT	0.28-0.85	0.75-7.0			●	●			●													
		160612 KT	0.25-0.75	0.8-9.0			●	●			●													
		160616 KT	0.30-0.85	1.0-9.0			●	●			●													
		190612 KT	0.25-0.75	1.0-14.0			●	●			●													
		190616 KT	0.30-0.85	1.5-14.0			●	●			●													
 Medium	**CNMG**	**120404 MC**	0.10-0.30	0.5-3.5		●					●	●					●			●				
		120408 MC	0.12-0.35	0.7-3.5		●		●	○		●	●					●	●		●				
		120412 MC	0.15-0.40	0.7-3.5							●	●					●							



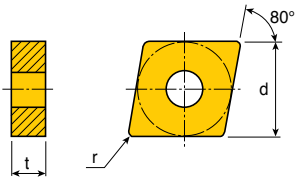
A57, A58, A59, A74, A75, A102,
A103, A133, A146, A148, A167,
A176, A182, A204, A216, A229, A234

● : Standard items
○ : Semi standard items

TaeguTec

CNMG

Negative 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	4.76	0.4-1.2
12	12.7	4.76	0.4-1.2
16	15.88	6.35	0.8-1.6
19	19.05	6.35	0.8-1.6

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Medium	**CNMG**	**090404 MK**	0.17-0.40	0.7-3.0											●	●		●			●			
		090408 MK	0.20-0.50	1.0-3.0											●	●		●			●			
		090412 MK	0.23-0.50	1.5-3.0											●	●		●			●			
 Medium	**CNMG**	**120404 ML**	0.10-0.30	0.8-3.5		●					●	●		●	●	●		●	●			●		
		120408 ML	0.12-0.35	1.0-3.5		●					●	●		●	●	●		●	●	●		●		
		120412 ML	0.15-0.35	1.3-3.5												●		●						
 Medium	**CNMG**	**090404 MM**	0.15-0.45	0.4-3.0							●	●	●	●	●	●	●				●			
		090408 MM	0.20-0.50	0.5-3.0							●	●	●	●	●	●	●				●			
		090412 MM	0.23-0.50	0.7-3.0							●	●	●	●	●	●	●				●			
 OLD Medium	**CNMG**	**120404 MP**	0.10-0.30	0.8-4.0							●	●		●	●	●		●	●					
		120408 MP	0.12-0.40	1.0-4.0							●	●		●	●	●	●	●	●		●			
		120412 MP	0.15-0.50	1.5-4.0							●	●		●	●	●		●	●					
		160612 MP ✓	0.15-0.50	2.5-6.0								●												
 Medium	**CNMG**	**090404 MT**	0.10-0.35	0.8-3.0						●	●	●				●								
		090408 MT	0.15-0.45	1.0-3.0						●	●	●				●								
		090412 MT	0.20-0.55	1.2-3.0						●	●	●				●								
 OLD Medium	**CNMG**	**120404 MT**	0.15-0.40	1.0-5.0		●	●	●	○		●	●				●		●	●					
		120408 MT	0.17-0.55	1.2-5.0		●	●	●	○		●	●	●	●	●	●	●	●	●		●			
		120412 MT	0.20-0.55	1.5-5.0			●	●	○		●	●	●	●	●	●	●	●	●					
		160608 MT ✓	0.20-0.55	2.0-6.5			●					●												
		160612 MT ✓	0.25-0.55	2.0-6.5			●				●	●				●		●	●					
		160616 MT ✓	0.30-0.55	2.0-6.5							●													
		190608 MT	0.23-0.55	3.0-8.0			●				●	●		●	●	●		●	●					
		190612 MT	0.25-0.55	3.0-8.0							●	●	●		●	●		●	●					
		190616 MT ✓	0.30-0.55	3.0-8.0								●												



A57, A58, A59, A74, A75, A102, A103, A133, A146, A148, A167, A176, A182, A204, A216, A229, A234

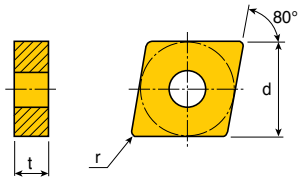
• ✓ Marked: Old type chip breaker

●: Standard items

○: Semi standard items

CNMG

Negative 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	4.76	0.4-1.2
12	12.7	4.76	0.4-1.6
16	15.88	6.35	0.8-1.6
19	19.05	6.35	0.8-1.6
25	25.4	9.52	2.4

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
RHINO-ROCK	**CNMG**	**090404 PC**	0.10 - 0.30	0.4 - 3.0						●	●	●					●							
		090408 PC	0.15 - 0.40	0.5 - 3.0						●	●	●	●				●							
Medium		**090412 PC**	0.18 - 0.50	0.6 - 3.0						●	●	●												
	CNMG	**120404 PC**	0.10-0.40	0.4-5.0						●	●	●		●	●	●	●							
		120408 PC	0.15-0.50	0.5-5.0						●	●	●	●	●	●	●	●				●			
		120412 PC	0.17-0.55	0.6-5.0						●	●	●			●	●					●			
Medium		**120416 PC**	0.20-0.60	0.8-5.0							●	●					●							
		160608 PC	0.20-0.55	2.0-6.5							●	●												
		160612 PC	0.25-0.55	2.0-6.5							●	●												
		160616 PC	0.30-0.55	2.0-6.5																				
		190608 PC	0.23-0.55	3.0-8.0							●	●												
		190612 PC	0.25-0.55	3.0-8.0							●	●												
		190616 PC	0.30-0.55	3.0-8.0								●												
	CNMG	**120408 RT**	0.25-0.70	2.5-6.0			●	●	○		●	●	●		●	●	●	●	●					
		120412 RT	0.25-0.70	2.5-6.0			●	●	○		●	●	●		●	●	●	●						
		120416 RT	0.30-0.70	2.5-6.0				●	○		●													
		160612 RT	0.25-0.70	3.0-7.0			●	●	○		●	●	●				●	●						
		160616 RT	0.30-0.85	3.0-7.0			●	●	○		●	●												
		190608 RT	0.25-0.70	3.0-9.0								●	●				●							
		190612 RT	0.25-0.70	3.0-9.0			●	●	○		●	●	●		●		●	●	●					
		190616 RT	0.30-0.85	3.0-9.0			●	●	○		●	●	●				●	●		●				
Roughing		**250924 RT**	0.45-1.00	5.0-12.0							●	●												
	CNMG	**120404 SF**	0.08-0.25	0.5-1.5		●											●		●	●				
		120408 SF	0.10-0.30	0.7-1.5		●					●	●					●		●	●				
Finishing																								
RHINO-ROCK	**CNMG**	**090404 WA** *	0.08-0.25	0.25-2.5	●	●	●	●		●	●	●					●							
wiper		**090408 WA** *	0.10-0.40	0.25-3.0	●	●	●	●		●	●	●					●							
Finishing		**090412 WA** *	0.20-0.50	0.4-3.0	●	●	●	●		●	●	●					●							

A57, A58, A59, A74, A75, A102, A103, A133, A146, A148, A167, A176, A182, A204, A216, A229, A234

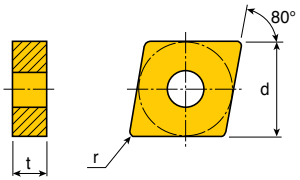
• * Marked: Wiper inserts should be applied to ☐CLNR/L..., ☐CBNR/L..., ☐CKNR/L...

● : Standard items
○ : Semi standard items

TaeguTec

CNMG CNMM

Negative 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
12	12.7	4.76	0.4-1.2
19	19.05	6.35	1.2-2.4
25	25.4	7.94-9.52	2.4-3.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
wiper	**CNMG**	**120404 WS** ✱	0.05-0.35	0.5-2.0		●					●													
Finishing																								
wiper	**CNMG**	**120408 WT** ✱	0.15-0.60	1.0-5.0		●	●	●			●	●		●			●							
		120412 WT ✱	0.20-0.80	1.0-5.0							●	●					●							
Medium																								
	CNMM	**250924 EH**	0.45-1.20	2.5-15.0										●	●	●								
Heavy																								
	CNMM	**190612 HT**	0.35-0.90	4.0-9.0							●													
		190616 HT	0.45-1.00	4.0-9.0							●	●												
		190624 HT	0.55-1.20	4.0-9.0							●	●						●						
		250724 HT	0.55-1.30	5.0-12.0																				
		250924 HT	0.55-1.30	5.0-12.0																				
		250932 HT	0.65-1.30	5.0-13.0																				
Heavy																								
	CNMM	**190624 HY**	0.50-1.10	4.0-12.0							●	●												
		250924 HY	0.55-1.50	4.0-15.0							●	●	●											
Heavy																								
	CNMM	**250924 HZ**	0.55 - 1.50	4.0 - 15.0							●	●												
Heavy																								

A57, A58, A59, A74, A75, A102, A103, A133, A146, A148, A167, A176, A182, A204, A216, A229, A234

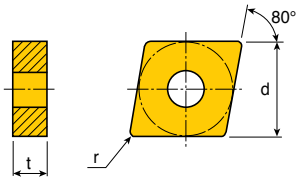
• ✱ Marked: Wiper inserts should be applied to ☐CLNR/L..., ☐CBNR/L..., ☐CKNR/L...

● : Standard items
○ : Semi standard items

TaeguTec Member IMC Group

CNMM CNMX

Negative 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
12	12.7	4.76-5.56	0.8-1.2
16	15.88	6.35-7.94	0.8-2.4
19	19.05	6.35	0.8-2.4
25	25.4	7.94-9.52	2.4

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 RH(N)	**CNMM**	**120408 RH**	0.30-0.70	2.5-6.0							●	●					●							
		120408 RH(N)	0.25-0.60	2.0-5.0																				
		120412 RH	0.30-0.80	2.5-6.0							●	●					●							
		160608 RH	0.30-0.70	3.0-8.0																				
		160612 RH	0.30-0.80	3.0-8.0																				
		160616 RH	0.45-1.00	4.0-8.0																				
 RH Roughing		**190608 RH** ✱	0.30-0.70	3.0-9.0																				
		190612 RH	0.35-0.80	4.0-9.0							●	●					●							
		190612 RH(N)	0.30-0.70	3.0-8.0																				
		190616 RH	0.45-1.00	4.0-9.0							●	●			●		●							
		190616 RH(N)	0.45-0.90	3.0-8.0																				
		190624 RH	0.55-1.20	4.0-9.0							●	●					●							
		250724 RH ✱	0.55-1.20	5.0-12.0																				
		250924 RH ✱	0.55-1.20	5.0-12.0								●												
 Roughing	**CNMM**	**120408 RX**	0.20-0.55	0.7-7.0							●	●												
		120412 RX	0.25-0.70	1.0-7.0							●	●												
		160612 RX	0.25-0.70	1.0-9.0							●													
		160616 RX	0.30-0.90	1.5-9.0																				
		160624 RX	0.35-1.20	2.0-9.0																				
		190608 RX	0.20-0.55	0.7-10.0																				
		190612 RX	0.25-0.70	1.0-10.0							●	●												
		190616 RX	0.30-0.90	1.5-10.0																				
		190624 RX	0.35-1.10	2.0-10.0								●	●											
		250724 RX	0.35-1.20	2.0-12.0																				
		250924 RX	0.35-1.20	2.0-12.0																				
 Semi-heavy	**CNMX**	**120508 HB**	0.25-0.80	1.5-6.0							●	●	●											
		120512 HB	0.25-0.80	1.5-6.0							●	●	●		●									
		160712 HB	0.30-0.80	1.5-8.0							●	●							●					
		160716 HB	0.30-0.80	1.5-8.0							●	●												



A57, A58, A59, A74, A75, A102, A103, A133, A146, A148, A167, A176, A182, A204, A216, A229, A234

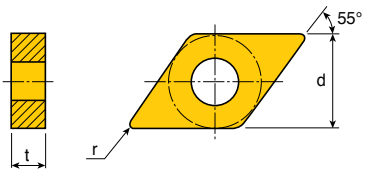
• ✱ Marked: Chip breaker shape is not the same as shown in the catalogue

● : Standard items
○ : Semi standard items

TaeguTec

DNGG DNMA DNMG

Negative 55° rhombic inserts



Size	Dimension (mm)		
	d	t	r
11	9.52	4.76	0.8-1.2
13	11.11	5.56	0.1-1.2
15	12.7	4.76-6.35	0.1-1.6

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Medium	**DNGG**	**130501 ML**	0.03-0.10	0.1-1.0															●				●	
		130502 ML	0.05-0.15	0.2-1.2															●				●	
		130504 ML	0.05-0.20	0.5-1.5															●				●	
		130508 ML	0.08-0.25	0.5-1.5															●				●	
 Medium	**DNGG**	**150401 ML**	0.03-0.10	0.1-1.0															●				●	
		150402 ML	0.05-0.15	0.2-1.2															●				●	
		150404 ML	0.10-0.30	0.8-3.5															●				●	
		150408 ML	0.12-0.35	1.0-3.5															●				●	
 Roughing	**DNMA**	**110408 #**	0.15-0.50	0.8-3.0																				
		110412 #	0.15-0.50	0.8-3.0			○																	
		150404	0.15-0.50	0.4-4.0																				
		150604	0.15-0.50	0.4-4.0																				
		150408	0.15-0.65	0.8-4.0			●	●	○															
		150608	0.15-0.65	0.8-4.0				●	○															
		150412	0.15-0.65	1.2-4.0				●	○															
		150612	0.15-0.65	1.2-4.0					○															
 Medium	**DNMG**	**130504**	0.10-0.45	0.5-3.5			●	●																
		130508	0.10-0.50	0.5-3.5			●	●																
		130512	0.10-0.55	0.5-3.5			●	●																
 Medium	**DNMG**	**150404**	0.17-0.45	1.0-4.0				●				●												
		150604	0.17-0.45	1.0-4.0		●	●	●			●	●					●							
		150408	0.17-0.55	1.5-4.0							●													
		150608	0.17-0.55	1.5-4.0		●	●	●	○		●	●	●				●							
		150412	0.25-0.55	1.5-4.0																				
		150612	0.25-0.55	1.5-4.0			●		○		●	●					●							
		150416	0.25-0.65	2.5-4.0																				
		150616	0.25-0.65	2.5-4.0							●													
 Finishing	**DNMG**	**130504 EA**	0.05-0.30	0.20-1.5										●	●	●			●		●			
		130508 EA	0.07-0.40	0.30-1.5										●	●	●			●		●			



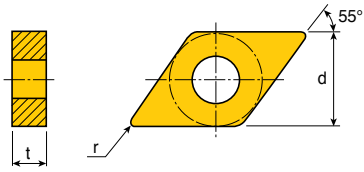
A60, A61, A68, A69, A76, A87, A89, A104, A105, A134, A146, A148, A168, A169, A170, A184, A185, A186, A205, A206, A216

• # Marked: Insert with screw hole

● : Standard items
○ : Semi standard items

DNMG

Negative 55° rhombic inserts



Size	Dimension (mm)		
	d	t	r
11	9.52	4.76	0.4-0.8
13	11.11	5.56	0.4-1.2
15	12.7	4.76-6.35	0.4-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Finishing	**DNMG**	**150404 EA**	0.05-0.2	0.1-1.5											●									
		150408 EA	0.10-0.4	0.1-1.5																				
		150604 EA	0.05-0.2	0.1-1.5											●				●		●			
		150608 EA	0.10-0.4	0.1-1.5															●		●			
 Medium	**DNMG**	**130508 EM**	0.13-0.40	0.5-3.0										●	●	●			●		●			
		130512 EM	0.15-0.40	0.7-3.0										●	●	●			●		●			
 Medium	**DNMG**	**110408 EM #**	0.13-0.50	0.5-4.0										○	○	○								
		150408 EM	0.13-0.50	0.5-5.0										●	●	●								
		150608 EM	0.13-0.50	0.5-5.0										●	●	●			●		●			
		150412 EM	0.15-0.55	0.5-5.0										●	●	●								
		150612 EM	0.15-0.55	0.5-5.0										●	●	●								
 Roughing	**DNMG**	**150408 ET**	0.20-0.60	1.0-6.0										●	●	●			●		●			
		150412 ET	0.25-0.60	1.0-6.0										●	●	●			●		●			
		150608 ET	0.20-0.60	1.0-6.0										●		●			●		●			
		150612 ET	0.25-0.60	1.0-6.0										●		●			●		●			
 Finishing	**DNMG**	**150408 FA**	0.05-0.20	0.2-2.0		●					●													
		150608 FA	0.05-0.20	0.2-2.0		●					●													
 Finishing	**DNMG**	**110404 FC #**	0.07-0.20	0.5-2.0	○												○							
		110408 FC #	0.10-0.25	0.7-2.0		○					○	○			○		○							
		150404 FC	0.05-0.30	0.2-2.5						●	●	●												
		150604 FC	0.05-0.30	0.2-2.5	●	●					●				●									
		150408 FC	0.08-0.35	0.3-2.5		●				●	●	●												
		150608 FC	0.08-0.35	0.3-2.5		●				●	●	●												
		150412 FC	0.08-0.35	0.5-2.5																				
		150612 FC	0.08-0.35	0.5-2.5								●												
 Finishing	**DNMG**	**130504 FG**	0.07-0.30	0.2-2.0							●	●					●							
		130508 FG	0.10-0.35	0.5-2.0							●	●					●							
		130512 FG	0.15-0.40	0.5-2.0							●	●					●							



A60, A61, A68, A69, A76, A87, A89, A104, A105, A134, A146, A148, A168, A169, A170, A184, A185, A186, A205, A206, A216

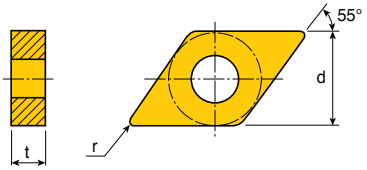
• # Marked: Insert with screw hole

● : Standard items
○ : Semi standard items

TaeguTec

DNMG

Negative 55° rhombic inserts



Size	Dimension (mm)		
	d	t	r
11	9.52	4.76	0.4-0.8
13	11.11	5.56	0.2-1.2
15	12.7	4.76-6.35	0.4-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated									PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Finishing	**DNMG**	**110404 FG #**	0.07-0.20	0.5-2.0	○	○					○	○			○		○							
		110408 FG #	0.10-0.25	0.7-2.0	○	○					○						○							
		150404 FG	0.07-0.20	0.5-2.0	●	●					●	●					●							
		150604 FG	0.07-0.20	0.5-2.0	●	●					●	●					●							
		150408 FG ✓	0.10-0.25	0.7-2.0	●	●					●	●					●							
		150412 FG	0.12-0.25	1.0-2.0							●													
		150608 FG ✓	0.10-0.25	0.7-2.0	●	●					●	●					●							
 Finishing	**DNMG**	**130504 FM**	0.07-0.30	0.25-2.0		●				●	●	●	●				●							
		130508 FM	0.10-0.35	0.3-2.0		●				●	●	●	●				●							
		130512 FM	0.15-0.40	0.35-2.0		●				●	●	●	●				●							
 Finishing	**DNMG**	**130502 FS**	0.05-0.25	0.20-2.0	●	●					●	●												
		130504 FS	0.08-0.30	0.30-2.0	●	●					●	●												
		130508 FS	0.10-0.30	0.50-2.0	●	●					●	●												
 Finishing	**DNMG**	**130504 FT**	0.07-0.30	0.25-3.0						●	●	●	●				●							
		130508 FT	0.10-0.40	0.3-3.0						●	●	●	●				●							
		130512 FT	0.15-0.50	0.35-3.0						●	●	●	●				●							
 Roughing	**DNMG**	**150408 KT**	0.17-0.47	0.38-7.0			●	●			●													
		150608 KT	0.17-0.47	0.38-7.0			●	●			●													
		150412 KT	0.23-0.63	0.50-7.0			●	●			●													
		150612 KT	0.23-0.63	0.50-7.0			●	●			●													
 Medium	**DNMG**	**150404 MC**	0.10-0.30	0.5-3.5																				
		150604 MC	0.10-0.30	0.5-3.5																				
		150408 MC	0.12-0.35	0.7-3.5								●												
		150608 MC	0.12-0.35	0.7-3.5							●	●					●	●		●				
		150412 MC	0.15-0.35	1.0-3.5																				
		150612 MC	0.15-0.35	1.0-3.5							●						●							



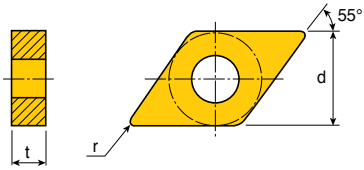
A60, A61, A68, A69, A76, A87, A89, A104, A105, A134, A146, A148, A168, A169, A170, A184, A185, A186, A205, A206, A216

- ✓ Marked: Old type chip breaker
- # Marked: Insert with screw hole

●: Standard items
○: Semi standard items

DNMG

Negative 55° rhombic inserts



Size	Dimension (mm)		
	d	t	r
13	11.11	5.56	0.4-1.2
15	12.7	4.76-6.35	0.4-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Medium	**DNMG**	**130504 MK**	0.17-0.40	0.7-4.0											●	●			●			●			
		130508 MK	0.20-0.45	1.0-4.0											●	●			●			●			
		130512 MK	0.23-0.50	1.5-4.0											●	●			●			●			
 Medium	**DNMG**	**150404 ML**	0.10-0.30	0.8-3.5								●							●						
		150604 ML	0.10-0.30	0.8-3.5							●	●					●		●				●		
		150408 ML	0.12-0.35	1.0-3.5								●					●		●						
		150608 ML	0.12-0.35	1.0-3.5							●	●			●		●		●	●			●		
 Medium	**DNMG**	**130504 MM**	0.15-0.45	0.4-4.0							●	●	●	●	●	●	●								
		130508 MM	0.20-0.50	0.5-4.0							●	●	●	●	●	●	●								
		130512 MM	0.23-0.50	0.7-4.0							●	●	●	●	●	●	●								
 Medium	**DNMG**	**150404 MP**	0.10-0.30	0.8-4.0							●				●				●						
		150604 MP	0.10-0.30	0.8-4.0								●			●		●		●						
		150408 MP	0.12-0.40	1.0-4.0													●		●	●					
		150608 MP	0.12-0.40	1.0-4.0							●	●			●	●	●		●	●		●			
		150612 MP ✓	0.15-0.40	1.0-4.0																					
 Medium	**DNMG**	**130504 MT**	0.10-0.35	0.8-4.0						●	●	●	●				●								
		130508 MT	0.15-0.45	1.0-4.0						●	●	●	●				●								
		130512 MT	0.20-0.55	1.2-4.0						●	●	●	●				●								



A60, A61, A68, A69, A76, A87, A89, A104, A105, A134, A146, A148, A168, A169, A170, A184, A185, A186, A205, A206, A216

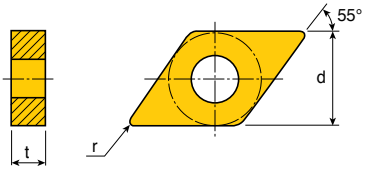
• ✓ Marked: Old type chip breaker

● : Standard items
○ : Semi standard items

TaeguTec

DNMG

Negative 55° rhombic inserts



Size	Dimension (mm)		
	d	t	r
11	9.52	4.76	0.8-1.2
13	11.11	5.56	0.4-1.2
15	12.7	4.76-6.35	0.4-1.6

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Medium	**DNMG**	**110408 MT #**	0.17-0.40	1.0-3.0		○	○	○			○	○					○		○					
		110412 MT #	0.20-0.45	1.0-3.0			○	○			○													
		150404 MT	0.15-0.40	0.8-4.0		●		●	○		●	●					●							
		150604 MT	0.15-0.40	0.8-4.0		●	●	●	○		●	●					●		●					
		150408 MT	0.17-0.50	1.0-4.0		●		●	○		●	●		●	●		●		●	●				
		150608 MT	0.17-0.50	1.0-4.0		●	●	●	○		●	●		●	●	●	●	●	●	●				
		150412 MT	0.20-0.50	1.3-4.0				●			●													
		150612 MT	0.20-0.50	1.3-4.0			●	●			●	●					●		●	●				
 Medium	**DNMG**	**130504 PC**	0.10-0.30	0.4-3.5						●	●	●	●				●							
		130508 PC	0.15-0.40	0.5-3.5						●	●	●	●				●							
		130512 PC	0.18-0.50	0.6-3.5						●	●	●	●				●							
 Medium	**DNMG**	**110408 PC #**	0.17-0.40	0.5-3.0								○												
		150404 PC	0.10-0.40	0.4-4.0						●	●	●												
		150604 PC	0.10-0.40	0.4-4.0							●	●		●	●									
		150408 PC	0.15-0.50	0.5-4.0						●	●	●					●							
		150608 PC	0.15-0.50	0.5-4.0						●	●	●		●	●	●	●							
		150412 PC	0.17-0.55	0.6-4.0						●	●	●												
		150612 PC	0.17-0.55	0.6-4.0						●	●	●												
 Roughing	**DNMG**	**150408 RT**	0.25-0.65	2.0-4.0				●	○		●						●							
		150608 RT	0.25-0.65	2.0-4.0			●	●	○		●	●					●							
		150412 RT	0.25-0.65	2.5-4.0				●				●												
		150612 RT	0.25-0.65	2.5-4.0			●	●	○			●												
		150616 RT	0.25-0.70	2.5-5.5							●	●					●							
 Right hand Medium	**DNMG**	**150404 L-VF**	0.10-0.35	0.7-4.5								●												
		150404 R-VF	0.10-0.35	0.7-4.5								●					●							
		150604 L-VF	0.10-0.35	0.7-4.5							●	●					●							
		150604 R-VF	0.10-0.35	0.7-4.5		●					●	●					●	●						
		150408 L-VF	0.12-0.45	1.0-4.5																				
		150408 R-VF	0.12-0.45	1.0-4.5																				
		150608 L-VF	0.12-0.45	1.0-4.5							●	●					●	●						
		150608 R-VF	0.12-0.45	1.0-4.5		●					●	●												



A60, A61, A68, A69, A76, A87, A89, A104, A105, A134, A146, A148, A168, A169, A170, A184, A185, A186, A205, A206, A216

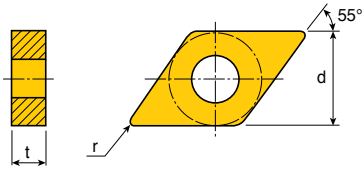
• # Marked: Insert with screw hole

● : Standard items
○ : Semi standard items

TaeguTec Member IMC Group

DNMG DNUX

Negative 55° rhombic inserts



Size	Dimension (mm)		
	d	t	r
13	11.11	5.56	0.4-1.2
15	12.7	4.76-6.35	0.8-1.2

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated											PVD coated				Uncoated		
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
RHINO-ROCK wiper Finishing	**DNMG 130504 WA** ✱	0.08-0.25	0.25-2.5	●	●	●	●		●	●	●					●								
	130508 WA ✱	0.10-0.35	0.25-3.0	●	●	●	●		●	●	●					●								
	130512 WA ✱	0.15-0.45	0.4-3.5	●	●	●	●		●	●	●					●								
wiper Finishing	**DNMG 150408 WS** ✱	0.10-0.30	0.8-4.0		●									●										
	150608 WS ✱	0.10-0.30	0.8-4.0							●														
wiper Medium	**DNMG 150412 WT** ✱	0.15-0.60	1.0-5.0																					
	150612 WT ✱	0.15-0.60	1.0-5.0							●														
RHINO-ROCK Right hand Medium	**DNUX 130504 R11**	0.15-0.35	1.5-4.5							●	●			●		●				●				
	130504 L11	0.15-0.35	1.5-4.5							●	●			●		●				●				
	130508 R11	0.21-0.45	2.0-4.5						●	●	●			●		●				●				
	130508 L11	0.21-0.45	2.0-4.5						●	●	●			●		●				●				

A60, A61, A68, A69, A76, A87, A89, A104, A105, A134, A146, A148, A168, A169, A170, A184, A185, A186, A205, A206, A216

• ✱ Marked: Wiper inserts should be applied to ☐DJNR/L..., ☐DUNR/L..., ☐DENR/L...

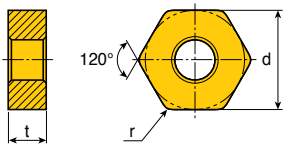
● : Standard items
○ : Semi standard items

TaeguTec

HNMG

T-TURN

Negative 120° hexagonal inserts



Size	Dimension (mm)		
	d	t	r
05	12.7	4.76	0.8
10	19.05	6.35	1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Medium	**HNMG**	**050408 GU**	0.15-0.60	0.5-3.5			●	●	○			●					●							
		100612 GU	0.25-0.70	1.0-5.0					○															
 Medium	**HNMG**	**050408 SU**	0.15-0.50	0.5-3.5										●			●		●					
		100612 SU	0.25-0.70	1.0-5.0															●					



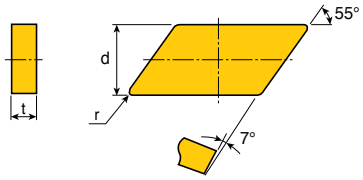
A106, A207

● : Standard items
○ : Semi standard items

KNUX

T-TURN

Negative 55° rhombic inserts



Size	Dimension (mm)		
	d	t	r
16	9.52	4.76	0.5-1.0

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Right hand Medium	**KNUX**	**160405 L11**	0.15-0.35	1.5-5.0							●	●			●		●							
		160405 R11	0.15-0.35	1.5-5.0		●	●				●	●	●		●		●	●		●		●		
		160410 L11	0.21-0.45	2.0-5.0							●	●					●							
		160410 R11	0.21-0.45	2.0-5.0							●	●					●							
 Right hand Medium	**KNUX**	**160405 L12**	0.24-0.50	2.0-5.0																				
		160405 R12	0.24-0.50	2.0-5.0							●	●					●							
		160410 L12	0.30-0.60	2.5-6.0								●												
		160410 R12	0.30-0.60	2.5-6.0								●												

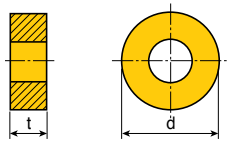


A53, A164

● : Standard items
○ : Semi standard items

RNMG

Negative round inserts



Size	Dimension (mm)		
	d	t	
12	12.7	4.76	
15	15.88	6.35	
19	19.05	6.35	
25	25.4	9.52	
31	31.75	9.52	

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Roughing	**RNMG**	**120400**	0.30-0.60	2.0-5.0								●					●							
		150600	0.35-0.70	3.5-7.0																				
		190600	0.45-0.80	4.5-9.0																				
		250900	0.55-1.20	4.0-12.0																				●
		310900	0.65-1.20	5.5-14.0																				


A79

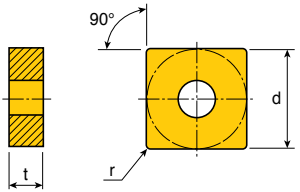
● : Standard items
○ : Semi standard items

TaeguTec
Member IMC Group

SNGG SNMA SNMD

T-TURN

Negative square inserts



Size	Dimension (mm)		
	d	t	r
12	12.7	4.76	0.4-1.6
15	15.88	6.35	1.2-1.6
19	19.05	6.35	1.2-1.6
25	25.4	7.94-9.52	1.6-2.4
31	31.75	9.52	2.4

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Right hand Medium	**SNGG**	**120404 L**	0.15-0.35	1.0-4.0	●																		
		120404 R	0.12-0.35	1.0-4.0	●																		
		120408 L	0.15-0.40	1.0-4.0																			
		120408 R	0.15-0.35	1.0-4.0	●																●		
 Roughing	**SNMA**	**120408**	0.15-0.70	1.0-6.0			●	●	○													●	
		120412	0.20-0.80	1.5-6.0			●	●	○														
		120416	0.30-1.00	2.0-6.0			●	●	○														
		150612	0.20-0.80	2.0-8.0			●																
		150616	0.30-1.00	2.0-8.0																			
		190612	0.20-0.80	2.0-10.0			●	●	○													●	
		190616	0.30-1.00	2.0-10.0				●	○														
		250716	0.30-1.00	3.0-13.0																			
		250724	0.40-1.20	3.0-13.0				●	○														
TOPDUTY  Roughing  Finishing	**SNMD**	**250924 HD**									●	●	●										
		Roughing	0.55-1.50	4.0-15.0																			
		Finishing	0.40-0.80	2.0-5.0																			
TOPDUTY  Heavy  Finishing	**SNMD**	**310924 HD**									●	●					●						
		Roughing	0.60-1.50	7.0-25.0																			
		Finishing	0.40-0.80	2.0-5.0																			



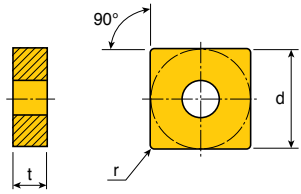
A80, A81, A107, A108, A129, A149, A178, A208, A235

● : Standard items
○ : Semi standard items

TaeguTec

SNMD

Negative square inserts



Size	Dimension (mm)		
	d	t	r
19	19.05	6.35	2.4
25	25.4	9.52	2.4
31	31.75	9.52	2.4

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
TOPDUTY	**SNMD**	**190624 HT**									●	●												
		Roughing	0.55-1.20	4.0-9.0																				
Roughing		Finishing	0.40-0.80	2.0-5.0																				
		250924 HT									●	●												
		Roughing	0.55-1.30	5.0-12.0																				
Finishing		Finishing	0.40-0.80	2.0-5.0																				
TOPDUTY	**SNMD**	**310924 HT**									●	●						●						
		Roughing	0.50-1.40	6.0-22.0																				
Heavy		Finishing	0.40-0.80	2.0-5.0																				
																								
Finishing																								
TOPDUTY	**SNMD**	**190624 HY**									●	●												
		Roughing	0.50-1.10	4.0-12.0																				
Roughing		Finishing	0.40-0.80	2.0-5.0																				
		250924 HY																						
		Roughing	0.55-1.50	4.0-15.0																				
Finishing		Finishing	0.40-0.80	2.0-5.0																				
TOPDUTY	**SNMD**	**250924 HZ**									●	●	●											
		Roughing	0.55-1.50	4.0-15.0																				
Roughing		Finishing	0.40-0.80	2.0-5.0																				
																								
Finishing																								



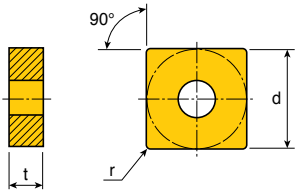
A80, A81, A129

● : Standard items
○ : Semi standard items

TaeguTec

SNMG

Negative square inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	4.76	0.4-1.2
12	12.7	4.76	0.4-1.6
15	15.88	6.35	0.8-1.6
19	19.05	6.35	0.4-1.6
25	25.4	7.94-9.52	1.6-2.4

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Medium	**SNMG**	**090404**	0.10-0.45	0.5-3.0			●	●																
		090408	0.10-0.50	0.5-3.0			●	●																
		090412	0.10-0.55	0.5-3.0			●	●																
 Medium	**SNMG**	**120404**	0.17-0.45	1.0-5.0							●	●					●							
		120408	0.23-0.60	1.5-5.0		●	●	●	○		●	●	●				●					●		
		120412	0.25-0.60	2.0-5.0				●	○			●					●							
		120416	0.35-0.70	2.0-5.0								●					●							
		150608	0.25-0.60	1.5-6.0								●					●							
		150612	0.25-0.60	2.0-6.0																				
		150616	0.35-0.70	2.0-6.0																				
		190604	0.17-0.45	3.0-8.0								●												
		190608	0.25-0.60	3.0-8.0			●		○		●	●					●		●					
		190612	0.30-0.60	3.0-8.0			●	●	○		●	●	●				●							
		190616	0.35-0.70	3.0-8.0							●	●	●				●							
		250716	0.35-0.70	4.0-12.0							●	●					●							
		250724	0.50-1.00	5.0-12.0							●	●					●							
		250924	0.50-1.00	5.0-12.0								●												
 Finishing	**SNMG**	**090404 EA**	0.05-0.30	0.2-1.5										●	●	●			●		●			
		090408 EA	0.07-0.40	0.3-1.5										●	●	●			●		●			
 Finishing	**SNMG**	**120404 EA**	0.05-0.20	0.1-1.5											●									
		120408 EA	0.10-0.40	0.1-1.5											●									
 Medium	**SNMG**	**090408 EM**	0.13-0.40	0.5-3.0										●	●	●			●		●			
		090412 EM	0.15-0.40	0.7-3.0										●	●	●			●		●			



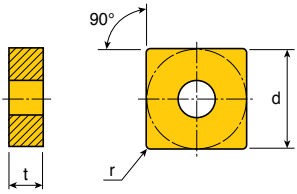
A62, A63, A80, A81, A107, A108, A147, A149, A171, A178, A208, A230, A231, A235

● : Standard items
○ : Semi standard items

TaeguTec

SNMG

Negative square inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	4.76	0.4-1.2
12	12.7	4.76	0.4-1.6
15	15.88	6.35	1.2-1.6
19	19.05	6.35	0.8-1.6

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Medium	**SNMG**	**120408 EM**	0.13-0.50	0.8-5.0											●	●			●		●			
		120412 EM	0.15-0.55	0.8-5.0															●		●			
		150612 EM	0.15-0.55	0.8-6.5																				
		150616 EM	0.17-0.60	0.8-6.5																				
		190612 EM	0.15-0.55	0.8-8.0																				
		190616 EM	0.17-0.60	0.8-8.0															●					
 Roughing	**SNMG**	**120408 ET**	0.25-0.70	2.0-7.0															●		●			
		120412 ET	0.30-0.70	2.0-7.0															●					
		190608 ET	0.30-0.75	3.0-9.0																				
		190612 ET	0.35-0.75	3.0-9.0											●				●		●			
 Finishing	**SNMG**	**120404 FC**	0.05-0.30	0.2-2.5																				
		120408 FC	0.08-0.35	0.2-2.5								●												
		120412 FC	0.10-0.40	0.3-2.5																				
 Finishing	**SNMG**	**090404 FG**	0.07-0.30	0.2-2.0							●	●					●							
		090408 FG	0.10-0.35	0.5-2.0							●	●					●							
		090412 FG	0.15-0.40	0.5-2.0							●	●					●							
 Finishing	**SNMG**	**120404 FG**	0.07-0.20	0.5-3.0		●						●							●					
		120408 FG	0.10-0.25	0.7-3.0	●	●					●	●												
 Finishing	**SNMG**	**090404 FM**	0.07-0.30	0.25-2.0		●				●	●	●	●				●							
		090408 FM	0.10-0.35	0.3-2.0		●				●	●	●	●				●							
		090412 FM	0.15-0.40	0.35-2.0		●				●	●	●	●				●							
 Roughing	**SNMG**	**120408 KT**	0.19-0.53	0.38-7.0			●	●			●													
		120412 KT	0.28-0.70	0.50-7.0			●	●			●													
		120416 KT	0.30-0.75	0.75-7.0			●	●			●													
		150612 KT	0.30-0.75	0.6-8.5			●	●			●													
		150616 KT	0.30-0.85	0.9-8.5			●	●			●													
		190616 KT	0.30-0.85	1.3-12.0			●	●			●													



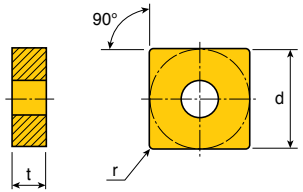
A62, A63, A80, A81, A107, A108, A147, A149, A171, A178, A208, A230, A231, A235

● : Standard items
○ : Semi standard items

TaeguTec

SNMG

Negative square inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	4.76	0.4-1.2
12	12.7	4.76	0.4-1.2
15	15.88	6.35	0.8-1.2
19	19.05	6.35	0.8-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Medium	**SNMG**	**120408 MC**	0.12-0.35	0.7-3.5							●	●					●			●				
		120412 MC	0.15-0.40	0.7-3.5																				
 Medium	**SNMG**	**090404 MK**	0.17-0.40	0.7-3.0											●	●			●		●			
		090408 MK	0.20-0.50	1.0-3.0											●	●			●		●			
		090412 MK	0.23-0.50	1.5-3.0											●	●			●		●			
 Medium	**SNMG**	**120408 ML**	0.12-0.35	1.0-3.5							●	●					●			●			●	
		120412 ML	0.15-0.35	1.0-3.5																				
 Medium	**SNMG**	**090404 MM**	0.15-0.45	0.4-3.0							●	●	●	●	●	●	●							
		090408 MM	0.20-0.50	0.5-3.0							●	●	●	●	●	●	●							
		090412 MM	0.23-0.50	0.7-3.0							●	●	●	●	●	●	●							
 OLD Medium	**SNMG**	**120404 MP** ✓	0.10-0.30	0.8-4.0																				
		120408 MP	0.12-0.40	1.0-4.0							●	●			●		●		●	●	●			
		120412 MP	0.15-0.40	1.3-4.0																				
		150608 MP	0.25-0.60	1.5-6.0							●													
 Medium	**SNMG**	**090404 MT**	0.10-0.35	0.8-3.0						●	●	●	●				●							
		090408 MT	0.15-0.45	1.0-3.0						●	●	●	●				●							
		090412 MT	0.20-0.55	1.2-3.0						●	●	●	●				●							
 OLD Medium	**SNMG**	**120404 MT** ✓	0.12-0.40	1.0-5.0		●						●					●							
		120408 MT	0.17-0.55	1.2-5.0		●	●	●	○		●	●			●	●	●		●	●				
		120412 MT ✓	0.20-0.55	1.5-5.0			●				●	●			●		●		●	●				
		150612 MT ✓	0.30-0.65	2.0-7.0								●	●											
		190608 MT	0.17-0.55	3.0-8.0								●			●									
		190612 MT	0.20-0.55	3.0-8.0								●			●	●	●			●				



A62, A63, A80, A81, A107, A108, A147, A149, A171, A178, A208, A230, A231, A235

• ✓ Marked: Old type chip breaker

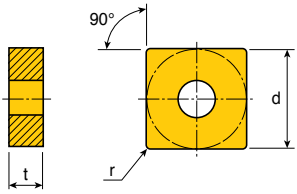
● : Standard items

○ : Semi standard items

TaeguTec Member IMC Group

SNMG SNMM

Negative square inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	4.76	0.4-1.2
12	12.7	4.76	0.4-1.6
15	15.88	6.35	1.2
19	19.05	6.35	1.2-2.4
25	25.4	7.94-9.52	2.4-3.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
RHINO-ROCK	**SNMG**	**090404 PC**	0.10-0.30	0.4-3.0						●	●	●	●				●							
		090408 PC	0.15-0.40	0.5-3.0						●	●	●	●				●							
Medium		**090412 PC**	0.18-0.50	0.6-3.0						●	●	●	●				●							
	SNMG	**120404 PC**	0.12-0.40	0.4-5.0								●												
		120408 PC	0.15-0.50	0.5-5.0							●	●			●		●				●			
Medium		**120412 PC**	0.15-0.50	0.6-5.0							●	●												
	SNMG	**120408 RT**	0.25-0.70	2.5-6.0			●	●			●	●					●							
		120412 RT	0.30-0.70	2.5-6.0			●	●	○		●	●				●								
OLD		**120416 RT**	0.40-0.70	2.5-6.0							●	●												
		150612 RT	0.30-0.70	3.0-7.0				●												●				
Roughing		**190612 RT**	0.30-0.75	3.0-9.0							●	●	●		●		●		●					
		190616 RT ✓	0.40-0.90	3.0-9.0							●	●			●		●		●	●				
		250724 RT	0.40-1.00	5.0-12.0																				
		250924 RT	0.40-1.00	5.0-12.0									●											
	SNMM	**250924 EH**	0.45-1.2	2.8-18.0										●	●	●								
Heavy																								
	SNMM	**190612 HT**	0.35-0.9	4.0-9.0							●	●												
		190616 HT	0.45-1.0	4.0-9.0							●	●						●						
		190624 HT	0.55-1.2	4.0-9.0							●													
Heavy		**250724 HT**	0.55-1.3	5.0-12.0							●	●			●		●	●						
		250924 HT	0.55-1.3	5.0-12.0							●							●						
		250932 HT	0.65-1.3	5.0-13.0																				

A62, A63, A80, A81, A107, A108, A147, A149, A171, A178, A208, A230, A231, A235

• ✓ Marked: Old type chip breaker

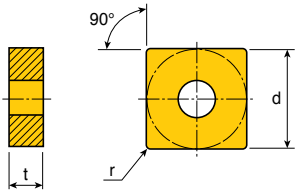
● : Standard items

○ : Semi standard items

TaeguTec

SNMM SNMX

Negative square inserts



Size	Dimension (mm)		
	d	t	r
12	12.7	4.76	0.8-1.2
15	15.88	6.35-7.94	1.2-1.6
19	19.05	6.35	0.8-2.4
25	25.4	7.94-9.52	1.6-2.4

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Heavy	**SNMM**	**190624 HY**	0.50-1.10	4.0-12.0							●	●												
		250924 HY	0.55-1.50	4.0-15.0							●	●												
 Heavy	**SNMM**	**250924 HZ**	0.55-1.50	4.0-15.0							●	●												
 RH(N)	**SNMM**	**120408 RH**	0.30-0.70	2.5-6.0								●					●							
		120408 RH(N)	0.25-0.60	2.5-5.0													●							
		120412 RH	0.30-0.80	2.5-6.0								●					●							
		120412 RH(N)	0.30-0.70	3.0-5.0																				
 RH Roughing		**150612 RH**	0.30-0.80	3.0-7.0								●					●							
		190608 RH ✱	0.30-0.70	3.0-9.0								●												
		190612 RH	0.30-0.80	4.0-9.0								●	●					●						
		190612 RH(N)	0.30-0.70	3.0-8.0																				
		190616 RH	0.45-1.00	4.0-9.0								●			●		●			●				
		190616 RH(N)	0.40-0.90	3.0-8.0																				
		190624 RH	0.55-1.20	4.0-9.0								●												
		250716 RH ✱	0.55-1.00	5.0-12.0								●												
		250724 RH ✱	0.55-1.20	5.0-12.0								●	●				●							
		250924 RH ✱	0.55-1.20	5.0-12.0								●												
 Roughing	**SNMM**	**120408 RX**	0.20-0.55	0.7-7.0							●	●	●											
		120412 RX	0.25-0.70	1.0-7.0							●	●	●											
		150612 RX	0.25-0.70	1.0-9.0							●	●	●											
		190612 RX	0.25-0.70	1.0-10.0							●	●												
		190616 RX	0.30-0.90	1.5-10.0								●												
		190624 RX	0.35-1.10	2.0-10.0								●												
		250724 RX	0.35-1.20	2.0-12.0							●													
		250924 RX	0.35-1.20	2.0-12.0							●	●												
 Semi-heavy	**SNMX**	**150712 HB**	0.30-0.80	1.5-8.0							●	●												
		150716 HB	0.30-0.80	1.5-8.0							●	●												



A62, A63, A80, A81, A107, A108, A147, A149, A171, A178, A208, A230, A231, A235

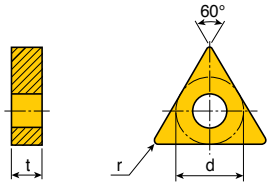
• ✱ Marked: Chip breaker shape is not the same as shown in the catalogue

● : Standard items
○ : Semi standard items

TaeguTec Member IMC Group

TNGG TNMA TNMG

Negative triangular inserts



Size	Dimension (mm)		
	d	t	r
11	6.35	3.18	0.4
13	7.94	4.76	0.2-1.2
16	9.52	4.76	0.4-1.6
22	12.7	4.76	0.4-1.6

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
RHINO-ROCK	**TNGG**	**130402 L**	0.10-0.30	0.8-3.5	●																			
		**130402 R**	0.10-0.30	0.8-3.5	●																			
		130404 L	0.12-0.30	1.0-3.5	●																			
		130408 R	0.15-0.35	1.3-3.5	●																			
Left hand		**130408 L**	0.15-0.35	1.3-3.5	●																			
Finishing		**130408 R**	0.15-0.35	1.3-3.5	●																			
	**TNGG**	**160404 L**	0.12-0.30	1.0-3.5	●							●										●		
		160404 R	0.12-0.30	1.0-3.5	●							●					●					●		
		160408 L	0.15-0.35	1.3-3.5	●																			
Left hand		**160408 R**	0.15-0.35	1.3-3.5	●							●										●		
Medium		**220404 L**	0.12-0.30	1.0-5.0	●																			
		220404 R	0.12-0.30	1.0-5.0	●							●										●		
		220408 L	0.15-0.35	1.3-5.0	●																			
		220408 R	0.15-0.35	1.3-5.0	●																			
	**TNMA**	**110304**	0.15-0.30	0.5-2.0																			○	
		160404	0.15-0.30	1.0-4.0			●	●	○															
		160408	0.15-0.40	1.0-4.0			●	●	○															
		160412	0.20-0.50	1.5-4.5				●	○															
Roughing		**160416**	0.20-0.50	1.0-4.5			●																	
		220404	0.15-0.30	1.5-5.0																				
		220408	0.15-0.40	1.5-5.0				●	○															
		220412	0.20-0.50	1.5-5.0			●	●																
		220416	0.20-0.61	2.0-5.0																				
RHINO-ROCK	**TNMG**	**130404**	0.10-0.45	0.5-3.5			●	●																
		**130408**	0.10-0.50	0.5-3.5			●	●																
		130412	0.10-0.55	0.5-3.5			●	●																
Medium																								



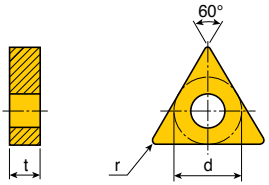
A64, A70, A82, A83, A109, A113, A114, A147, A150, A172, A173, A179, A190, A194, A209, A210, A217, A232, A233, A236, A237

● : Standard items
○ : Semi standard items

TaeguTec
Member IMC Group

TNMG

Negative triangular inserts



Size	Dimension (mm)		
	d	t	r
11	6.35	3.18	0.4-0.8
13	7.94	4.76	0.4-1.2
16	9.52	4.76	0.4-1.2
22	12.7	4.76	0.4-1.6
27	15.88	6.35	0.8-1.6
33	19.05	7.94-9.52	1.6-2.4

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Medium	**TNMG**	**110304**	0.15-0.40	1.2-3.0							○	○												
		110308	0.17-0.40	1.5-3.0							○													
		160404	0.17-0.45	1.5-3.5		●	●	●	○		●	●					●			●				
		160408	0.17-0.55	2.0-3.5		●	●	●	○		●	●					●			●				
		160412	0.25-0.55	2.0-3.5							●													
		220404	0.17-0.45	1.5-5.0							●	●					●							
		220408	0.17-0.55	2.0-5.0				●			●	●					●	●						
		220412	0.25-0.55	2.0-5.0							●	●												
		220416	0.30-0.60	2.0-5.0								●												
		270608	0.17-0.55	2.0-5.0																				
		270612	0.25-0.55	3.0-7.0								●												
		270616	0.30-0.60	3.0-7.0								●												
		330716	0.35-0.70	3.0-9.0								●						●						
		330924	0.40-0.80	3.0-9.0																				
 Finishing	**TNMG**	**130404 EA**	0.05-0.30	0.2-1.5										●	●	●			●		●			
		130408 EA	0.07-0.40	0.3-1.5										●	●	●			●		●			
 Finishing	**TNMG**	**160404 EA**	0.05-0.20	0.1-1.5										●	●				●		●			
		160408 EA	0.10-0.40	0.1-1.5															●		●			
 Medium	**TNMG**	**130408 EM**	0.13-0.40	0.5-3.0										●	●	●			●		●			
		130412 EM	0.15-0.40	0.7-3.0										●	●	●			●		●			
 Medium	**TNMG**	**160408 EM**	0.13-0.50	0.8-4.5										●	●				●		●			
		160412 EM	0.15-0.55	0.8-4.5															●		●			
		220408 EM	0.13-0.50	0.8-6.0											●	●			●		●			
		220412 EM	0.15-0.55	0.8-6.0																	●			



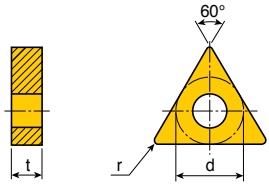
A64, A70, A82, A83, A109, A113, A114, A147, A150, A172, A173, A179, A190, A194, A209, A210, A217, A232, A233, A236, A237

● : Standard items
○ : Semi standard items

TaeguTec
Member IMC Group

TNMG

Negative triangular inserts



Size	Dimension (mm)		
	d	t	r
11	6.35	3.18	0.4
13	7.94	4.76	0.2-1.2
16	9.52	4.76	0.4-1.2
22	12.7	4.76	0.8-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated									PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Roughing	**TNMG**	**160408 ET**	0.25-0.65	2.0-5.0										●	●	●			●		●			
		160412 ET	0.25-0.65	2.0-5.0																				
		220408 ET	0.25-0.65	2.5-7.0										●	●				●		●			
		220412 ET	0.25-0.65	2.5-7.0										●		●			●		●			
 Finishing	**TNMG**	**160404 FC**	0.05-0.30	0.2-2.5	●	●				●	●	●			●									
		160408 FC	0.08-0.35	0.2-2.5	●	●				●	●	●			●	●								
		160412 FC	0.10-0.40	0.3-2.5						●	●													
 Finishing	**TNMG**	**130404 FG**	0.07-0.30	0.25-1.5							●	●					●							
		130408 FG	0.10-0.35	0.3-1.5							●	●					●							
		130412 FG	0.15-0.40	0.35-1.5							●	●					●							
 Finishing	**TNMG**	**110304 FG**	0.07-0.20	0.5-1.5		○											○							
		160404 FG	0.07-0.20	0.5-2.0	●	●					●	●					●							
		160408 FG	0.10-0.25	0.7-2.0	●	●					●	●					●							
		160412 FG	0.13-0.30	0.7-2.0		●																		
		220408 FG	0.10-0.25	0.7-2.0																				
 Finishing	**TNMG**	**130404 FM**	0.07-0.30	0.25-1.5		●				●	●	●	●				●							
		130408 FM	0.10-0.35	0.3-1.5		●				●	●	●	●				●							
		130412 FM	0.15-0.40	0.35-1.5		●				●	●	●	●				●							
 Finishing	**TNMG**	**130402 FS**	0.05-0.25	0.2-1.0	●	●					●	●												
		130404 FS	0.08-0.30	0.3-1.0	●	●					●	●												
		130408 FS	0.10-0.30	0.5-1.0	●	●					●	●												
 Finishing	**TNMG**	**130404 FT**	0.07-0.30	0.25-2.5						●	●	●	●				●							
		130408 FT	0.10-0.40	0.3-2.5						●	●	●	●				●							
		130412 FT	0.15-0.50	0.35-2.5						●	●	●	●				●							



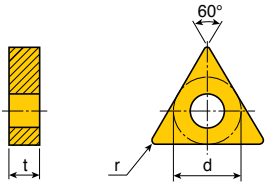
A64, A70, A82, A83, A109, A113, A114, A147, A150, A172, A173, A179, A190, A194, A209, A210, A217, A232, A233, A236, A237

● : Standard items
○ : Semi standard items

TaeguTec

TNMG

Negative triangular inserts



Size	Dimension (mm)		
	d	t	r
13	7.94	4.76	0.4-1.2
16	9.52	4.76	0.4-1.2
22	12.7	4.76	0.4-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Right hand Medium	**TNMG**	**160404 L-FS**	0.15-0.30	0.8-3.0	●							●					●							
		160404 R-FS	0.15-0.30	0.8-3.0	●							●					●			●				
		160408 L-FS	0.20-0.40	1.0-3.5								●												
		160408 R-FS	0.20-0.40	1.0-3.5								●					●			●				
 Roughing	**TNMG**	**160408 KT**	0.17-0.42	0.34-6.2			●	●			●													
		160412 KT	0.20-0.56	0.45-6.3			●	●			●													
		220408 KT	0.19-0.53	0.38-7.0			●	●			●													
		220412 KT	0.25-0.70	0.5-7.0			●	●			●													
 Medium	**TNMG**	**160408 MC**	0.17-0.40	0.7-3.5							●	●					●							
 Medium	**TNMG**	**130404 MK**	0.17-0.40	0.7-3.0											●	●			●		●			
		130408 MK	0.20-0.45	1.0-3.0											●	●			●		●			
		130412 MK	0.23-0.50	1.5-3.0											●	●			●		●			
 Medium	**TNMG**	**160404 ML**	0.10-0.30	0.8-3.5							●	●					●		●	●			●	
		160408 ML	0.12-0.35	1.0-3.5							●	●	●				●		●	●			●	
		160412 ML	0.15-0.35	1.5-3.5																				
		220404 ML	0.10-0.30	1.0-4.0													●							
		220408 ML	0.12-0.35	1.0-4.0								●					●							
 Medium	**TNMG**	**130404 MM**	0.15-0.45	0.4-3.0							●	●	●	●	●	●	●							
		130408 MM	0.20-0.50	0.5-3.0							●	●	●	●	●	●	●							
		130412 MM	0.23-0.50	0.7-3.0							●	●	●	●	●	●	●							
 Medium	**TNMG**	**160404 MP**	0.10-0.30	0.8-3.5								●			●		●		●	●		●		
		160408 MP	0.12-0.40	1.0-3.5							●	●			●	●	●		●	●				
		160412 MP	0.15-0.40	1.5-3.5							●						●							
		220404 MP	0.12-0.35	1.0-3.5															●					
		220408 MP	0.12-0.40	1.0-4.0							●	●			●				●	●				
		220412 MP	0.15-0.40	1.0-4.0																				

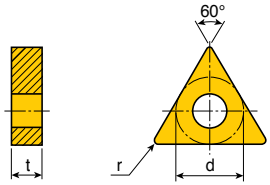


A64, A70, A82, A83, A109, A113, A114, A147, A150, A172, A173, A179, A190, A194, A209, A210, A217, A232, A233, A236, A237

● : Standard items
○ : Semi standard items

TNMG

Negative triangular inserts



Size	Dimension (mm)		
	d	t	r
11	6.35	3.18	0.8
13	7.94	4.76	0.4-1.2
16	9.52	4.76	0.4-1.2
22	12.7	4.76	0.4-1.2
27	15.88	6.35	1.2
33	19.05	9.52	2.4

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
RHINO-ROCK	**TNMG**	**130404 MT**	0.10-0.35	0.8-3.0						●	●	●	●				●								
		130408 MT	0.15-0.45	1.0-3.0						●	●	●	●				●								
		130412 MT	0.20-0.55	1.2-3.0						●	●	●	●				●								
Medium																									
	TNMG	**110308 MT**	0.17-0.40	1.0-3.0							○	○					○								
		160404 MT	0.17-0.40	1.0-3.5		●	●	●	○		●	●					●		●	●					
		160408 MT	0.17-0.50	1.2-3.5		●	●	●	○		●	●			●		●		●	●					
OLD		**160412 MT**	0.20-0.50	1.5-3.5			●				●	●					●								
		220404 MT ✓	0.15-0.40	1.2-5.0							●	●													
		220408 MT ✓	0.17-0.50	1.2-5.0			●				●	●					●			●					
		220412 MT	0.20-0.50	1.5-5.0							●	●					●			●					
		270612 MT ✓	0.20-0.50	3.0-7.0																					
Medium																									
RHINO-ROCK	**TNMG**	**130404 PC**	0.10-0.30	0.4-3.0						●	●	●	●				●								
		130408 PC	0.15-0.40	0.5-3.0						●	●	●	●				●								
		130412 PC	0.18-0.50	0.6-3.0						●	●	●	●				●								
Medium																									
	TNMG	**160404 PC**	0.15-0.40	1.0-3.5						●	●	●			●										
		160408 PC	0.15-0.50	0.5-4.5						●	●	●		●	●	●	●				●				
		160412 PC	0.17-0.55	0.6-4.5						●	●	●													
Medium		**220408 PC**	0.17-0.50	1.2-5.0							●	●													
		220412 PC	0.20-0.50	1.5-5.0							●	●													
	TNMG	**160408 RT**	0.25-0.65	2.0-5.0			●	●	○			●													
		160412 RT	0.25-0.65	2.0-5.0			●		○			●													
		220408 RT	0.25-0.65	2.0-7.0								●	●												
Roughing		**220412 RT**	0.25-0.65	2.5-7.0				●																	
		330924 RT	0.35-0.70	3.0-9.0																					

A64, A70, A82, A83, A109, A113, A114, A147, A150, A172, A173, A179, A190, A194, A209, A210, A217, A232, A233, A236, A237

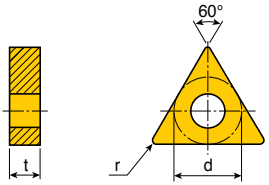
• ✓ Marked: Old type chip breaker

● : Standard items
○ : Semi standard items

TaeguTec

TNMG TNMM

Negative triangular inserts



Size	Dimension (mm)		
	d	t	r
13	7.94	4.76	0.4-1.2
16	9.52	4.76	0.4-1.2
22	12.7	4.76	0.8-1.6
27	15.88	6.35	1.2

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Finishing	**TNMG 160408 SF**	0.10-0.30	0.7-1.5		●											●		●						
 Right hand Medium	**TNMG 160404 L-VF**	0.10-0.30	0.7-3.5		●					●	●					●								
	160404 R-VF	0.10-0.30	0.7-3.5	●	●					●	●					●			●					
	160408 L-VF	0.12-0.35	1.0-3.5								●					●								
	160408 R-VF	0.12-0.35	1.0-3.5							●	●					●								
wiper  Finishing	**TNMG 130404 WA** ✱	0.08-0.25	0.25 - 2.5	●	●	●	●		●	●	●					●								
	130408 WA ✱	0.10-0.35	0.25 - 3.0	●	●	●	●		●	●	●					●								
	130412 WA ✱	0.15-0.45	0.40 - 3.5	●	●	●	●		●	●	●					●								
 Roughing	**TNMM 160408 RH**	0.30-0.70	2.0-7.0								●													
	220408 RH	0.30-0.70	2.0-7.0								●													
	220412 RH	0.30-0.70	2.5-7.0								●													
	220416 RH	0.40-0.85	3.0-7.0																					
	270612 RH	0.30-0.80	3.0-8.0																					
 Roughing	**TNMM 160408 RX**	0.20-0.55	0.7-6.0							●	●	●												
	160412 RX	0.25-0.70	1.0-7.0							●	●	●												
	220408 RX	0.20-0.55	0.7-7.5							●	●	●												
	220412 RX	0.25-0.70	1.0-7.5							●	●	●												
	220416 RX	0.30-0.90	1.5-7.5							●	●	●												



A64, A70, A82, A83, A109, A113, A114, A147, A150, A172, A173, A179, A190, A194, A209, A210, A217, A232, A233, A236, A237

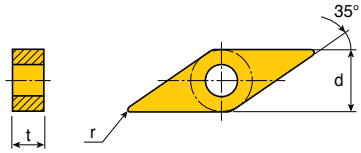
• ✱ Marked: Wiper inserts should be applied to ☐TGNR/L..., ☐TFNR/L...

● : Standard items
○ : Semi standard items

TaeguTec Member IMC Group

VNGG VNGX VNMG

Negative 35° rhombic inserts



Size	Dimension (mm)		
	d	t	r
13	7.94	4.76	0.1-0.8
16	9.52	4.76	0.1-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Medium	**VNGG**	**160401 ML**	0.03-0.10	0.1-1.0																				
		160402 ML	0.05-0.15	0.2-1.2															●					
		160404 ML	0.10-0.27	0.8-3.0															●				●	
		160408 ML	0.10-0.30	0.8-3.5																				
RHINO-ROCK  Medium	**VNGX**	**130401 ML**	0.03-0.10	0.1-1.0															●				●	
		130402 ML	0.05-0.15	0.2-1.2															●				●	
		130404 ML	0.05-0.20	0.5-1.5															●				●	
 Medium	**VNMG**	**160404**	0.17-0.40	1.0-3.0		●	●	●	○		●	●					●							
		160408	0.17-0.50	1.5-3.0		●	●	●	○		●	●					●							
		160412	0.20-0.50	1.5-3.0			●	●				●												
 Finishing	**VNMG**	**160404 EA**	0.05-0.2	0.1-1.5										●	●				●		●			
		160408 EA	0.08-0.3	0.2-2.5															●					
 Medium	**VNMG**	**160408 EM**	0.13-0.50	0.8-3.5										●							●			
 Finishing	**VNMG**	**160408 FA**	0.05-0.25	0.3-2.0							●						●		●					
 Finishing	**VNMG**	**130404 FC #**	0.08-0.20	0.5-1.5		○					○	○			○									
		130408 FC #	0.10-0.23	0.5-2.0								○												
		160404 FC	0.05-0.30	0.3-2.5		●					●	●			●									
		160408 FC	0.08-0.35	0.3-2.5	●						●	●			●									



A65, A66, A71, A72, A96, A110, A111, A197, A199

• # Marked: Insert with screw hole

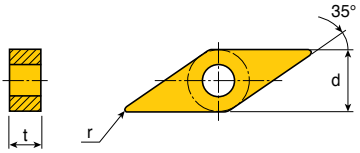
● : Standard items
○ : Semi standard items

TaeguTec
Member IMC Group

VNMG VNMM

T-TURN

Negative 35° rhombic inserts



Size	Dimension (mm)		
	d	t	r
13	7.94	4.76	0.4-0.8
16	9.52	4.76	0.4-0.8

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Finishing	**VNMG**	**130404 FG #**	0.08-0.20	0.5-1.5		●					●	●					●		●					
		130408 FG #	0.10-0.23	0.5-2.0		●					●	●												
		160404 FG	0.08-0.20	0.5-2.0	●	●					●	●			●		●		●	●				
		160408 FG	0.10-0.23	0.5-2.0	●	●					●	●					●		●					
 Finishing	**VNMG**	**160404 FX**	0.05-0.20	0.2-2.0		●					●	●												
		160408 FX	0.07-0.20	0.2-2.0		●				●	●	●												
 OLD Medium	**VNMG**	**130404 MT #**	0.15-0.36	0.8-2.5		●		●			●						●							
		130408 MT #	0.17-0.36	1.0-2.5			●				●	●					●							
		160404 MT ✓	0.15-0.36	0.8-3.0		●					●	●			●		●		●					
		160408 MT	0.17-0.36	1.0-2.5		●	●	●	○		●	●			●	●	●		●	●				
 Medium	**VNMG**	**160404 PC**	0.15-0.36	0.4-3.0							●	●												
		160408 PC	0.17-0.36	0.5-3.0						●	●	●												
 Medium	**VNMM**	**160404 ML**	0.10-0.27	0.8-3.0																			●	
		160408 ML	0.12-0.32	1.0-3.0																			●	



A71, A72, A96, A110, A111

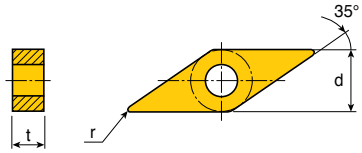
- ✓ Marked: Old type chip breaker
- # Marked: Insert with screw hole

● : Standard items
○ : Semi standard items

TaeguTec

VNMX

Negative 35° rhombic inserts



Size	Dimension (mm)		
	d	t	r
13	7.94	4.76	0.2-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9080	P20	K10	K20
 Finishing	**VNMX**	**130404 FG**	0.08-0.20	0.5-2.0		●					●	●					●		●		●			
		130408 FG	0.10-0.23	0.5-2.0		●					●	●					●		●		●			
 Finishing	**VNMX**	**130404 FM**	0.07-0.30	0.25-1.5		●				●	●	●					●		●		●			
		130408 FM	0.10-0.35	0.3-1.5		●				●	●	●					●		●		●			
 Finishing	**VNMX**	**130402 FS**	0.05-0.20	0.2-1.0	●	●					●	●												
		130404 FS	0.08-0.20	0.3-1.0	●	●					●	●												
		130408 FS	0.10-0.23	0.5-1.0	●	●				●	●	●												
 Medium	**VNMX**	**130404 MK**	0.17-0.35	0.7-3.0											●	●			●		●			
		130408 MK	0.20-0.40	1.0-3.0											●	●			●		●			
 Medium	**VNMX**	**130404 MT**	0.15-0.36	0.8-3.0		●				●	●	●	●				●		●		●			
		130408 MT	0.17-0.36	1.0-3.0		●	●	●		●	●	●	●				●		●		●			
		130412 MT	0.20-0.40	1.5-3.0			●	●		●	●	●	●				●		●		●			
 Medium	**VNMX**	**130404 PC**	0.15-0.36	0.4-3.0						●	●	●	●				●		●		●			
		130408 PC	0.17-0.36	0.5-3.0						●	●	●	●				●		●		●			
		130412 PC	0.20-0.40	1.0-3.0						●	●	●	●				●		●		●			



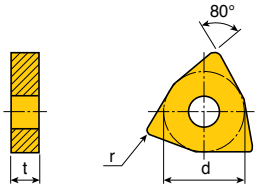
A65, A66, A110, A111, A197, A199

● : Standard items
○ : Semi standard items

TaeguTec

WNMA WNMG

Negative 80° trigon inserts



Size	Dimension (mm)		
	d	t	r
06	9.52	4.76	0.4-1.2
08	12.7	4.76	0.4-1.6

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated									PVD coated			Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Roughing	**WNMA**	**060408**	0.15-0.70	1.0-4.0				○																
		060412	0.20-0.80	1.5-4.0			○																	
		080408	0.15-0.70	1.0-5.0			●	●	○															
		080412	0.20-0.80	1.5-5.0			●	●	○															
		080416	0.20-0.80	1.5-5.0																				
 Finishing	**WNMG**	**080404 EA**	0.05-0.20	0.1-1.5															●		●			
		080408 EA	0.10-0.40	0.1-1.5															●					
 Medium	**WNMG**	**060408 EM**	0.13-0.50	0.8-3.0											○				○		○			
		060412 EM	0.15-0.55	0.8-3.0																	●			
		080404 EM	0.10-0.45	0.8-4.0										●	●	●					●			
		080408 EM	0.12-0.45	0.8-4.0										●	●	●			●		●			
		080412 EM	0.12-0.45	0.8-4.0																				
 Roughing	**WNMG**	**060408 ET**	0.15-0.50	0.8-4.0										○	○	○			○		○			
		060412 ET	0.15-0.50	0.8-4.0										○	○	○			○		○			
		080408 ET	0.15-0.55	0.8-4.5											●	●			●					
		080412 ET	0.20-0.50	0.8-4.5											●	●			●					
 Finishing	**WNMG**	**060404 FC**	0.07-0.20	0.5-2.0		○					○	○			○									
		060408 FC	0.10-0.25	0.5-2.0		○					○	○												
		080404 FC	0.07-0.20	0.5-2.0						●		●												
		080408 FC	0.07-0.20	0.5-2.0	●					●	●	●		●										
		080412 FC	0.10-0.25	0.5-2.0																				
 Finishing	**WNMG**	**060404 FG**	0.07-0.20	0.5-2.0	○	○					○	○					○							
		060408 FG	0.10-0.25	0.7-2.0	○	○					○													
		080404 FG	0.07-0.20	0.5-2.0	●	●					●	●					●		●					
		080408 FG	0.10-0.25	0.7-2.0	●	●					●	●					●							



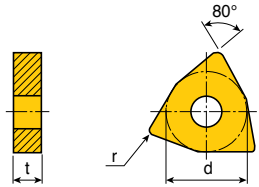
A73, A112, A137,
A151, A175,
A211, A212

● : Standard items
○ : Semi standard items

TaeguTec
Member IMC Group

WNMG

Negative 80° trigon inserts



Size	Dimension (mm)		
	d	t	r
06	9.52	4.76	0.4-1.2
08	12.7	4.76	0.4-1.6

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Roughing	**WNMG**	**080408 KT**	0.17-0.47	0.29-5.5			●	●			●													
		080412 KT	0.23-0.63	0.39-5.5			●	●			●													
		080416 KT	0.25-0.60	0.5-5.5			●	●			●													
 Medium	**WNMG**	**060404 MC**	0.10-0.30	0.5-2.5							○						○							
		060408 MC	0.12-0.35	0.7-3.0							○													
		080408 MC	0.12-0.35	0.7-3.5							●	●					●							
		080412 MC	0.15-0.40	0.7-3.5							●	●												
 Medium	**WNMG**	**080408 ML**	0.12-0.35	1.0-3.5								●		●	●		●		●	●			●	
		080412 ML	0.15-0.35	1.3-3.5																				
 OLD Medium	**WNMG**	**060408 MP**	0.12-0.35	1.0-3.0								○			○		○		○	○				
		060412 MP	0.15-0.40	1.3-3.0													○							
		080404 MP ✓	0.10-0.35	1.0-4.0								●												
		080408 MP	0.12-0.40	1.0-4.0							●	●		●	●	●	●		●	●	●			
		080412 MP	0.15-0.40	1.3-4.0													●							
 OLD Medium	**WNMG**	**060404 MT**	0.12-0.40	1.0-3.0			○	○			○	○			○		○		○	○				
		060408 MT	0.15-0.45	1.2-3.0			○	○			○	○			○		○		○	○				
		060412 MT	0.23-0.50	1.5-3.0							●													
		080404 MT ✓	0.12-0.40	1.0-4.0		●		●	○		●	●			●		●		●	●				
		080408 MT	0.17-0.55	1.2-4.0		●	●	●	○		●	●	●	●		●	●		●	●	●			
		080412 MT	0.25-0.55	1.5-4.0				●	○		●	●			●	●	●			●				
 Medium	**WNMG**	**060408 PC**	0.15-0.50	0.5-4.0							○	○												
		060412 PC	0.17-0.50	0.6-4.0							○	○												
		080408 PC	0.15-0.50	0.5-4.0						●	●	●		●	●	●			●		●			
		080412 PC	0.17-0.50	0.6-4.0						●	●	●	●		●						●			
		080416 PC	0.20-0.50	0.8-4.0							●													



A73, A112, A137, A151, A175, A211, A212

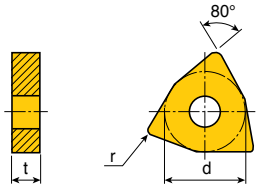
• ✓ Marked: Old type chip breaker

● : Standard items
○ : Semi standard items

TaeguTec

WNMG WNMX

Negative 80° trigon inserts



Size	Dimension (mm)		
	d	t	r
06	9.52	4.76	0.4-1.2
08	12.7	4.76	0.8-1.6

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Roughing	**WNMG**	**080408 RT**	0.25-0.70	2.5-4.0			●	●	○		●	●	●		●	●	●	●						
		080412 RT	0.25-0.70	2.5-4.0			●	●	○		●	●					●							
		080416 RT	0.30-0.75	2.5-4.0			●				●	●												
wiper  Finishing	**WNMG**	**080408 WS** ✱	0.07-0.35	0.5-2.0				●			●													
wiper  Medium	**WNMG**	**060408 WT** ✱	0.15-0.60	0.7-3.5							○													
		060412 WT ✱	0.20-0.80	0.7-3.5				○	○		○													
		080408 WT ✱	0.15-0.60	1.0-4.0		●					●	●					●							
		080412 WT ✱	0.20-0.80	1.0-4.0				●	○		●	●	●											
RHINO-ROCK  Medium	**WNMX**	**060404 EM**	0.10-0.35	0.4-3.0										●	●	●			●		●			
		060408 EM	0.13-0.40	0.5-3.0										●	●	●			●		●			
		060412 EM	0.15-0.40	0.7-3.0										●	●	●			●		●			
RHINO-ROCK  Medium	**WNMX**	**060404 FG**	0.07-0.30	0.2-2.0	●	●					●	●					●		●					
		060408 FG	0.10-0.35	0.5-2.0	●	●					●	●												
RHINO-ROCK  Medium	**WNMX**	**060404 FM**	0.07-0.30	0.25-2.0		●				●	●	●					●							
		060408 FM	0.10-0.35	0.3-2.0		●				●	●	●					●							
		060412 FM	0.15-0.40	0.35-2.0		●				●	●	●					●							



A67, A73, A112, A137, A151, A174, A175, A202, A211, A212

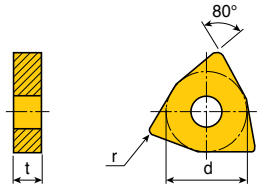
• ✱ Marked: Wiper inserts should be applied to ☐WLNR/L...

● : Standard items
○ : Semi standard items

TaeguTec Member IMC Group

WNMX

Negative 80° trigon inserts



Size	Dimension (mm)		
	d	t	r
06	9.52	4.76	0.4-1.2

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
Finishing	WNMX 060404 FS	0.08-0.30	0.3-1.5	●	●					●	●												
	060408 FS	0.10-0.30	0.5-1.5	●	●					●	●												
Medium	WNMX 060404 MK	0.17-0.40	0.7-3.0											●	●			●			●			
	060408 MK	0.20-0.45	1.0-3.0											●	●			●			●			
	060412 MK	0.23-0.50	1.5-3.0											●	●			●			●			
Medium	WNMX 060404 MM	0.15-0.45	0.4-3.0										●	●	●			●			●			
	060408 MM	0.20-0.50	0.5-3.0								●		●	●	●			●	●		●			
	060412 MM	0.23-0.50	0.7-3.0										●	●	●			●			●			
Medium	WNMX 060404 MT	0.10-0.35	0.8-3.0						●	●	●		●	●	●	●		●						
	060408 MT	0.15-0.45	1.0-3.0			●	●		●	●	●		●	●	●	●		●						
	060412 MT	0.20-0.55	1.2-3.0			●	●		●	●	●					●								
Medium	WNMX 060404 PC	0.10-0.30	0.4-3.0						●	●	●													
	060408 PC	0.15-0.40	0.5-3.0						●	●	●										●			
	060412 PC	0.18-0.50	0.6-3.0						●	●	●										●			
wiper Finishing	WNMX 060404 WA ✱	0.08-0.25	0.25-2.5	●	●	●	●		●	●	●					●								
	060408 WA ✱	0.10-0.40	0.25-3.0	●	●	●	●		●	●	●					●								
	060412 WA ✱	0.20-0.50	0.4-3.0	●	●	●	●		●	●	●					●								

A67, A112, A174, A202, A211, A212

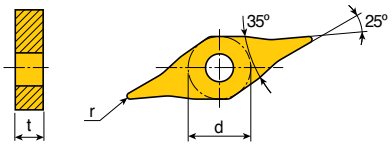
• ✱ Marked: Wiper inserts should be applied to ☐WLNR/L...

● : Standard items
○ : Semi standard items

TaeguTec

YNMG

Negative 25° rhombic inserts



Size	Dimension (mm)		
	d	t	r
13	7.94	4.76	0.4-0.8

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Finishing	**YNMG**	**130404 FS**	0.08-0.20	0.3-1.0	●	●					●								●					
		130408 FS	0.08-0.25	0.5-1.5	●	●					●								●					

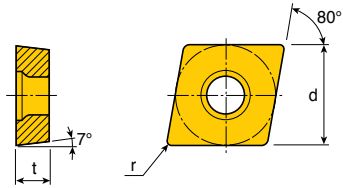


A65, A66,
A110, A111,
A197, A199

● : Standard items
○ : Semi standard items

TaeguTec
Member IMC Group

Positive 7° clearance 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
06	6.35	2.38	0.03-0.8
09	9.52	3.97	0.03-0.8

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated		
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
TOPMiNi	CCET 0602003 L-GF	0.02-0.15	0.1-1.5	●															●				
	0602003 R-GF	0.02-0.15	0.1-1.5	●															●				
	060201 L-GF	0.02-0.15	0.2-1.5																				
	060201 R-GF	0.02-0.15	0.2-1.5																				
Right hand	060202 L-GF	0.03-0.17	0.3-1.5																●				
Finishing	060202 R-GF	0.03-0.17	0.3-1.5																				
	060204 L-GF	0.05-0.20	0.3-1.5																				
	060204 R-GF	0.05-0.20	0.3-1.5																				
	060208 L-GF	0.07-0.22	0.4-1.5	●																			
	060208 R-GF	0.07-0.22	0.4-1.5	●															●				
	09T3003 L-GF	0.02-0.15	0.1-2.5	●															●				
	09T3003 R-GF	0.02-0.15	0.1-2.5	●															●				
	09T301 L-GF	0.02-0.15	0.2-2.5																				
	09T301 R-GF	0.02-0.15	0.2-2.5																●				
	09T302 L-GF	0.03-0.17	0.3-2.5																				
	09T302 R-GF	0.03-0.17	0.3-2.5																●				
	09T304 L-GF	0.05-0.20	0.3-2.5																●				
	09T304 R-GF	0.05-0.20	0.3-2.5																●				
	09T308 L-GF	0.07-0.22	0.4-2.5	●																			
	09T308 R-GF	0.07-0.22	0.4-2.5	●															●				
TOPMiNi	CCET 0602003 L-GW✱	0.02-0.15	0.1-1.5																				
wiper	0602003 R-GW✱	0.02-0.15	0.1-1.5																				
	09T3003 L-GW✱	0.02-0.15	0.1-2.5																				
	09T3003 R-GW✱	0.02-0.15	0.1-2.5																●				
Right hand																							
Finishing																							



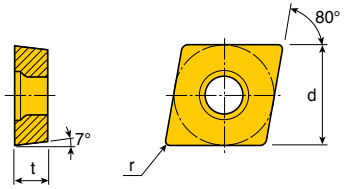
A47, A84, A85, A138, A152, A180, A181, A218

• ✱ Marked: Wiper inserts should be applied to ☐CLNR/L..., ☐CBNR/L..., ☐CKNR/L...

● : Standard items
○ : Semi standard items

CCGT CCMT

Positive 7° clearance 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
03	3.97	1.59	0.03-0.4
04	4.76	1.59	0.03-0.4
06	6.35	2.38	0.1-0.4
09	9.52	3.97	0.1-0.8

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated		
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
TOPMINI	**CCGT 0301003 R-FF**	0.03-0.10	0.05-0.3																●				
	**0301003 L-FF**	0.03-0.10	0.05-0.3																●				
	030101 R-FF	0.03-0.12	0.08-0.4																●				
Finishing	**030101 L-FF**	0.03-0.12	0.08-0.4		●														●				
	030102 R-FF	0.03-0.15	0.1-0.4		●														●				
	030102 L-FF	0.03-0.15	0.1-0.4		●														●				
	030104 R-FF	0.05-0.20	0.1-0.4		●														●				
	030104 L-FF	0.05-0.20	0.1-0.4		●														●				
	0401003 R-FF	0.03-0.10	0.05-0.4																●				
	0401003 L-FF	0.03-0.10	0.05-0.4																●				
	040101 R-FF	0.03-0.12	0.1-0.5																●				
	040101 L-FF	0.03-0.12	0.1-0.5		●														●				
	040102 R-FF	0.03-0.15	0.1-0.5		●														●				
	040102 L-FF	0.03-0.15	0.1-0.5		●														●				
	040104 R-FF	0.05-0.20	0.1-0.5		●														●				
	040104 L-FF	0.05-0.20	0.1-0.5		●														●				
TOPMINI	**CCGT 060201 SA**	0.02-0.15	0.1-1.5															●		●			
	**060202 SA**	0.02-0.15	0.1-1.5															●		●			
	060204 SA	0.03-0.20	0.1-2.4															●		●			
Finishing	**09T301 SA**	0.02-0.15	0.1-2.5															●		●			
	09T302 SA	0.02-0.15	0.1-2.5															●		●			
	09T304 SA	0.03-0.20	0.1-2.5															●		●			
	09T308 SA	0.03-0.25	0.1-2.5															●		●			
	**CCMT 060202 FA**	0.03-0.15	0.1-1.5		●									●		●		●					
	060204 FA	0.05-0.15	0.2-1.5	●	●						●							●	●				
Finishing	**09T302 FA**	0.03-0.15	0.1-2.0	●	●											●		●					
	09T304 FA	0.05-0.20	0.2-2.0	●	●						●					●		●	●				
	09T308 FA	0.08-0.25	0.3-2.0								●							●					

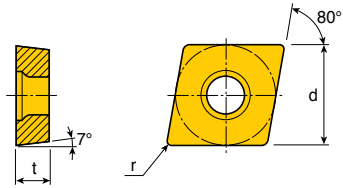


A47, A84, A85,
A138, A152, A180,
A181, A218

● : Standard items
○ : Semi standard items

CCMT

Positive 7° clearance 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
06	6.35	2.38	0.2-0.8
09	9.52	3.97	0.2-0.8
12	12.7	4.76	0.4-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 OLD Finishing	**CCMT**	**060204 FG**	0.05-0.15	0.3-1.5	●	●						●			●	●	●		●	●					
		09T304 FG	0.07-0.20	0.4-2.0	●	●	●				●	●			●	●	●		●	●		●			
		09T308 FG	0.10-0.25	0.6-2.0	●	●					●	●			●		●		●	●					
		120408 FG ✓	0.10-0.25	0.6-2.0								●					●								
 Medium	**CCMT**	**060202 FM**	0.07-0.15	0.5-1.5	●	●					●	●					●		●	●					
		060204 FM	0.08-0.15	0.5-1.5	●	●					●	●					●		●	●					
		09T302 FM	0.07-0.20	0.5-2.0	●	●					●	●					●		●	●					
		09T304 FM	0.08-0.25	0.5-2.5	●	●					●	●					●		●	●					
		09T308 FM	0.10-0.25	0.8-2.5	●	●					●	●					●		●	●					
 OLD Medium	**CCMT**	**060204 MT** ✓	0.07-0.20	0.5-2.0	●	●	●	●	○		●	●			●	●	●		●	●				●	
		060208 MT ✓	0.13-0.30	0.7-2.0		●	●	●	○		●	●	●				●		●			●			
		09T304 MT	0.10-0.25	0.7-3.5	●	●	●	●	○		●	●			●	●	●		●	●					
		09T308 MT	0.13-0.30	1.0-3.5		●	●	●	○		●	●	●		●	●	●		●	●					
		120404 MT ✓	0.10-0.25	1.0-5.0		●	●	●	○		●	●					●			●					
		120408 MT	0.13-0.30	1.3-5.0		●	●	●	○		●	●	●		●	●	●		●	●					
		120412 MT	0.17-0.35	1.5-5.0			●				●	●													
 Semi finishing	**CCMT**	**060204 PC**	0.06-0.18	0.3-2.0		●					●	●			●							●			
		060208 PC	0.08-0.25	0.4-2.0		●					●	●			●							●			
		09T304 PC	0.08-0.25	0.35-3.0		●					●	●			●		●					●			
		09T308 PC	0.10-0.28	0.5-3.0							●	●			●							●			
		120404 PC	0.08-0.25	0.4-4.0		●					●	●			●							●			
		120408 PC	0.10-0.30	0.7-4.0		●					●	●			●							●			
		120412 PC	0.12-0.35	1.0-4.0																		●			
wiper  Medium	**CCMT**	**09T308 WT** ✱	0.10-0.40	0.7-3.0			●				●	●													



A47, A84, A85, A138, A152, A180, A181, A218

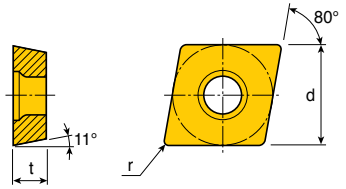
- ✓ Marked: Old type chip breaker
- ✱ Marked: Wiper inserts should be applied to ☐CLNR/L..., ☐CBNR/L..., ☐CKNR/L...

● : Standard items
○ : Semi standard items

TaeguTec

CPGT CPMT

Positive 11° clearance 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
06	6.35	2.38	0.4-0.8
08	7.94	2.38	0.4-0.8
09	9.52	3.18-3.97	0.4-0.8

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Finishing	**CPGT**	**080204 C**	0.05-0.20	0.4-1.5																				
		090304 C	0.05-0.20	0.4-2.0																				
 Finishing	**CPMT**	**080204 FG**	0.07-0.20	0.4-1.5		●						●					●							
		080208 FG	0.10-0.25	0.6-1.5		●																		
		090304 FG	0.07-0.20	0.4-2.0		●						●					●							
		090308 FG	0.10-0.25	0.6-2.0		●						●					●							
 Medium	**CPMT**	**080204 FM**	0.08-0.20	0.5-2.0	●	●					●	●					●		●	●				
		080208 FM	0.10-0.20	0.8-2.0	●	●					●	●					●		●	●				
		090304 FM	0.08-0.25	0.5-2.5	●	●					●	●					●		●	●				
		090308 FM	0.10-0.25	0.8-2.5	●	●					●	●					●		●	●				
 Semi finishing	**CPMT**	**060204 PC**	0.06-0.18	0.3-2.0													●							
		060208 PC	0.08-0.25	0.4-2.0															●					
		090304 PC	0.08-0.25	0.45-3.0																				
		090308 PC	0.10-0.30	0.6-3.0								●												
		09T304 PC	0.08-0.25	0.45-3.0								●							●					
		09T308 PC	0.10-0.30	0.6-3.0															●					

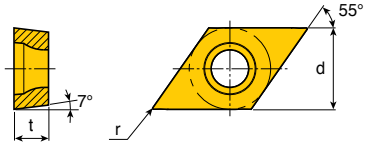

A183, A184

● : Standard items
○ : Semi standard items

TaeguTec
Member IMC Group

DCET

Positive 7° clearance 55° rhombic inserts



Size	Dimension (mm)		
	d	t	r
07	6.35	2.38	0.03-0.8
11	9.52	3.97	0.03-0.8

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
TOPMINI	**DCET 0702003 L-GF**	0.01-0.15	0.2-1.5	●															●				
	**0702003 R-GF**	0.01-0.15	0.2-1.5	●															●				
	070201 L-GF	0.02-0.15	0.2-1.5																				
	070201 R-GF	0.02-0.15	0.2-1.5																●				
Right hand	**070202 L-GF**	0.03-0.17	0.3-1.5																●				
Finishing	**070202 R-GF**	0.03-0.17	0.3-1.5																●				
	070204 L-GF	0.05-0.20	0.3-1.5																				
	070204 R-GF	0.05-0.20	0.3-1.5																				
	070208 L-GF	0.05-0.20	0.3-1.5	●																			
	070208 R-GF	0.05-0.20	0.3-1.5	●															●				
	11T3003 L-GF	0.02-0.15	0.2-2.5	●															●				
	11T3003 R-GF	0.02-0.15	0.2-2.5	●															●				
	11T301 L-GF	0.02-0.15	0.2-2.5																				
	11T301 R-GF	0.02-0.15	0.2-2.5																●				
	11T302 L-GF	0.03-0.17	0.3-2.5																●				
	11T302 R-GF	0.03-0.17	0.3-2.5																●				
	11T304 L-GF	0.05-0.20	0.3-2.5																●				
	11T304 R-GF	0.05-0.20	0.3-2.5																●	●			
	11T308 L-GF	0.05-0.20	0.3-2.5	●																			
	11T308 R-GF	0.05-0.20	0.3-2.5	●															●				
TOPMINI wiper	**DCET 0702003 L-GW***	0.02-0.15	0.1-1.5																				
	**0702003 R-GW***	0.02-0.15	0.1-1.5																●				
	11T3003 L-GW*	0.02-0.15	0.1-2.5																●				
Right hand	**11T3003 R-GW***	0.02-0.15	0.1-1.5																●				
Finishing																							



A48, A49, A86, A88, A139, A152, A185, A186, A187, A218, A219

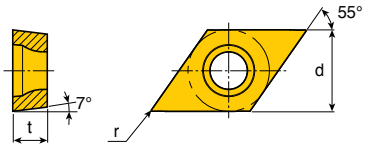
• * Marked: Wiper inserts should be applied to ☐DJNR/L..., ☐DUNR/L..., ☐DZNR/L...

● : Standard items
○ : Semi standard items

TaeguTec

DCGT

Positive 7° clearance 55° rhombic inserts



Size	Dimension (mm)		
	d	t	r
07	6.35	2.38	0.03-0.4
11	9.52	3.97	0.03-0.8

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated		
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
TOPMINI	**DCGT 0702003 L-FF**	0.03-0.10	0.05-0.3	●															●				
	**0702003 R-FF**	0.03-0.10	0.05-0.3	●															●				
	070201 L-FF	0.03-0.12	0.08-0.4	●															●				
	070201 R-FF	0.03-0.12	0.08-0.4	●															●				
Finishing	**070202 L-FF**	0.03-0.15	0.1-0.4	●															●				
	070202 R-FF	0.03-0.15	0.1-0.4	●															●				
	070204 L-FF	0.05-0.20	0.1-0.4	●															●				
	070204 R-FF	0.05-0.20	0.1-0.4	●															●				
	11T3003 L-FF	0.03-0.10	0.05-0.4	●															●				
	11T3003 R-FF	0.03-0.10	0.05-0.4	●															●				
	11T301 L-FF	0.03-0.12	0.1-0.5	●															●				
	11T301 R-FF	0.03-0.12	0.1-0.5	●															●				
	11T302 L-FF	0.03-0.15	0.1-0.5	●															●				
	11T302 R-FF	0.03-0.15	0.1-0.5	●															●				
	11T304 L-FF	0.05-0.20	0.1-0.5	●															●				
	11T304 R-FF	0.05-0.20	0.1-0.5	●															●				
TOPMINI	**DCGT 070201 SA**	0.02-0.15	0.1-1.5															●	●				
	**070202 SA**	0.02-0.15	0.1-1.5															●	●				
	070204 SA	0.03-0.20	0.1-1.5															●	●				
Finishing	**11T301 SA**	0.01-0.05	0.1-2.5															●	●				
	11T302 SA	0.02-0.15	0.1-2.5															●	●				
	11T304 SA	0.03-0.20	0.1-2.5															●	●				
	11T308 SA	0.03-0.20	0.1-2.5															●	●				



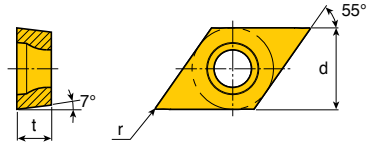
A48, A49, A86, A88, A139, A152, A185, A186, A187, A218, A219

● : Standard items
○ : Semi standard items

TaeguTec Member IMC Group

DCMT

Positive 7° clearance 55° rhombic inserts



Size	Dimension (mm)		
	d	t	r
07	6.35	2.38	0.2-0.8
11	9.52	3.97	0.2-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Finishing	**DCMT**	**070202 FA**	0.03-0.15	0.1-1.5	●	●											●		●		●			
		070204 FA	0.05-0.20	0.2-1.5	●	●					●	●							●	●				
		11T302 FA	0.03-0.15	0.1-2.0	●	●								●			●		●					
		11T304 FA	0.05-0.20	0.2-2.0	●	●					●	●							●	●				
		11T308 FA	0.08-0.25	0.3-2.0	●	●					●	●							●	●				
 Finishing	**DCMT**	**070204 FG**	0.07-0.20	0.4-1.5	●	●					●	●			●		●		●	●	●			
		070208 FG	0.07-0.20	0.4-2.0	●	●					●	●			●		●			●				
		11T304 FG	0.10-0.25	0.6-1.5	●	●					●	●		●	●	●	●		●	●	●			
		11T308 FG	0.10-0.25	0.6-2.0	●	●					●	●			●	●	●		●					
 Medium	**DCMT**	**070202 FM**	0.07-0.20	0.5-1.5	●	●					●	●					●		●	●				
		070204 FM	0.08-0.20	0.5-1.5	●	●					●	●					●		●	●				
		070208 FM	0.10-0.20	0.8-1.5	●	●					●	●					●		●	●				
		11T302 FM	0.07-0.20	0.5-2.0	●	●					●	●					●		●	●				
		11T304 FM	0.08-0.20	0.5-2.0	●	●					●	●					●		●	●				
		11T308 FM	0.10-0.25	0.8-2.5	●	●					●	●					●		●	●				
 Medium	**DCMT**	**11T304 MT**	0.10-0.25	0.7-3.0	●	●	●	●	○		●	●	●		●		●		●	●				
		11T308 MT	0.13-0.30	1.0-3.0		●	●	●	○		●	●			●		●		●	●				
		11T312 MT	0.17-0.35	1.5-3.0							●													
 Semi finishing	**DCMT**	**070204 PC**	0.06-0.18	0.3-2.0		●					●	●			●						●			
		070208 PC	0.08-0.25	0.4-2.0								●			●						●			
		11T304 PC	0.08-0.25	0.35-3.0		●					●	●			●						●			
		11T308 PC	0.10-0.28	0.5-3.0							●	●			●						●			
		11T312 PC	0.12-0.32	0.5-3.0																				



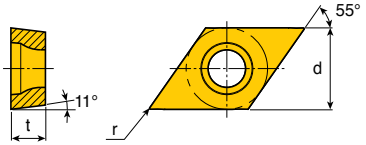
A48, A49, A86, A88, A139, A152, A185, A186, A187, A218, A219

● : Standard items
○ : Semi standard items

TaeguTec

DPET DPGT

Positive 11° clearance 55° rhombic inserts



Size	Dimension (mm)		
	d	t	r
07	6.35	2.38	0.03-0.2
11	9.52	3.97	0.03-0.2

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
TOPMiNi	**DPET 0702003 L-GF**	0.01-0.15	0.2-1.5	●															●			
	**0702003 R-GF**	0.01-0.15	0.2-1.5	●															●			
	070201 L-GF	0.02-0.15	0.2-1.5	●															●			
	070201 R-GF	0.02-0.15	0.2-1.5	●															●			
Right hand	**070202 L-GF**	0.03-0.17	0.3-1.5	●															●			
Finishing	**070202 R-GF**	0.03-0.17	0.3-1.5	●															●			
	11T3003 L-GF	0.02-0.15	0.2-2.5	●															●			
	11T3003 R-GF	0.02-0.15	0.2-2.5	●															●			
	11T301 L-GF	0.02-0.15	0.2-2.5	●															●			
	11T301 R-GF	0.02-0.15	0.2-2.5	●															●			
	11T302 L-GF	0.03-0.17	0.3-2.5	●															●			
	11T302 R-GF	0.03-0.17	0.3-2.5	●															●			
TOPMiNi	**DPGT 0702003 L-FF**	0.03-0.10	0.05-0.3	●															●			
	**0702003 R-FF**	0.03-0.10	0.05-0.3	●															●			
	070201 L-FF	0.03-0.12	0.08-0.4	●															●			
	070201 R-FF	0.03-0.12	0.08-0.4	●															●			
Finishing	**070202 L-FF**	0.03-0.15	0.1-0.4	●															●			
	070202 R-FF	0.03-0.15	0.1-0.4	●															●			
	11T3003 L-FF	0.03-0.10	0.05-0.4	●															●			
	11T3003 R-FF	0.03-0.10	0.05-0.4	●															●			
	11T301 L-FF	0.03-0.12	0.1-0.5	●															●			
	11T301 R-FF	0.03-0.12	0.1-0.5	●															●			
	11T302 L-FF	0.03-0.15	0.1-0.5	●															●			
	11T302 R-FF	0.03-0.15	0.1-0.5	●															●			



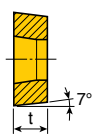
A48, A87

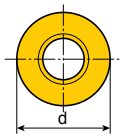
●: Standard items
○: Semi standard items

TaeguTec

RCMT RCMX

Positive 7° clearance round inserts





Size	Dimension (mm)	
	d	t
08	8.0	3.18
10	10.0	3.18-3.97
12	12.0	4.76
16	16.0	6.35
20	20.0	6.35
25	25.0	7.94
32	32.0	9.52

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Medium	**RCMT**	**080300 MT**	0.15-0.40	0.5-3.0								●											
		10T300 MT	0.20-0.50	1.0-4.0			●				●	●					●						
		120400 MT	0.30-0.60	2.0-5.0			●	●	○		●	●											
		160600 MT	0.40-0.80	3.0-7.0								●											
 Semi finishing	**RCMT**	**120400 PC**	0.30-0.60	2.0-5.0							●	●							●				
 Roughing	**RCMX**	**100300**	0.25-0.50	1.5-4.0				●	○		●	●					●						
		120400	0.30-0.60	2.5-5.0							●	●					●						
		160600	0.40-0.75	3.0-7.0			●	●			●	●					●					●	
		200600	0.48-0.90	3.5-9.0			●	●	○		●	●	●										
		250700	0.55-1.20	4.0-12.0			●	●	○		●	●						●					
		320900	0.65-1.50	5.0-15.0							●	●											
 Roughing	**RCMX**	**100300 RA**	0.20-0.50	1.0-4.0								●	●										
		120400 RA	0.25-0.60	2.0-5.0							●	●	●										
		160600 RA	0.35-0.75	2.5-7.0							●	●	●										
		200600 RA	0.40-0.90	3.0-9.0							●	●											
		250700 RA	0.50-1.20	3.5-12.0							●	●											
		320900 RA	0.60-1.50	4.0-15.0								●											



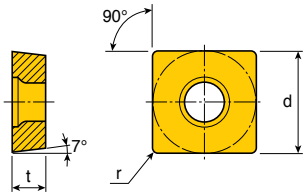
A77, A78, A90, A135, A153

● : Standard items
○ : Semi standard items

TaeguTec

SCMT

Positive 7° clearance square inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	3.97	0.4-0.8
12	12.7	4.76	0.4-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Finishing	**SCMT**	**09T304 FG**	0.08-0.25	0.6-2.0											●									
		09T308 FG	0.10-0.25	0.6-2.0								●			●		●		●	●				
 Medium	**SCMT**	**09T304 FM**	0.08-0.25	0.5-2.5	●	●					●	●					●		●	●				
		09T308 FM	0.10-0.25	0.8-2.5	●	●					●	●					●		●	●				
 Medium	**SCMT**	**09T304 MT**	0.10-0.25	0.7-3.5		●		●	○		●	●			●		●			●				
		09T308 MT	0.13-0.30	1.0-3.5		●	●	●	○		●	●			●	●	●		●	●				
		120404 MT	0.10-0.25	1.0-5.0		●	●				●	●					●							
		120408 MT	0.13-0.30	1.0-5.0		●		●	○		●	●			●	●	●		●	●				
		120412 MT	0.15-0.35	1.0-5.0																●				
 Semi finishing	**SCMT**	**09T304 PC**	0.08-0.25	0.35-3.0		●						●									●			
		09T308 PC	0.10-0.28	0.5-3.0		●						●			●						●			
		120404 PC	0.08-0.25	0.4-4.0																				
		120408 PC	0.10-0.30	0.7-4.0							●										●			
		120412 PC	0.12-0.35	1.0-4.0																				



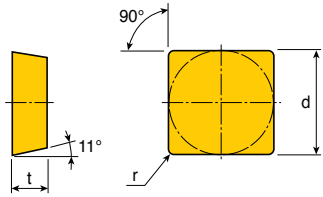
A91, A188, A238

● : Standard items
○ : Semi standard items

TaeguTec

SPGN SPMR SPUN

Positive 11° clearance square inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	3.18	0.4-0.8
12	12.7	3.18-4.76	0.4-1.6
15	15.88	4.76	0.4-1.2
19	19.05	4.76	0.4-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated			
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	P20	P30	K10	K20
 Finishing	**SPGN**	**090304**	0.08-0.20	0.7-3.5																			●	
		090308	0.10-0.25	0.7-3.5																			●	
		120304	0.08-0.20	1.0-5.0																	●		●	
		120308	0.10-0.25	1.0-5.0							●	●									●		●	
		120312	0.15-0.30	1.0-5.0																				
		120404	0.08-0.20	1.0-5.0																				●
		120408	0.10-0.25	1.0-5.0																				
		120412	0.15-0.30	1.0-5.0																				
		120416	0.18-0.33	1.0-5.0																				
		150404	0.08-0.20	1.5-7.0							●										●		●	
		150408	0.10-0.25	1.5-7.0																	●			
		150412	0.15-0.30	1.5-7.0																				
		190404	0.08-0.20	1.5-9.0																				
		190408	0.10-0.25	1.5-9.0																	●		●	
 Medium	**SPMR**	**090304**	0.10-0.25	0.7-3.5																				
		090308	0.13-0.30	1.0-3.5								●												
		120304	0.10-0.25	1.0-5.0								●					●							
		120308	0.13-0.30	1.0-5.0							●	●					●							
 Medium	**SPUN**	**090304**	0.10-0.30	1.0-3.5																				
		090308	0.15-0.40	1.0-3.5																				
		120304	0.10-0.30	1.0-5.0								●									●			
		120308	0.15-0.40	1.0-5.0		●					●	●											●	
		120312	0.20-0.50	1.0-5.0																				
		150404	0.10-0.30	1.5-7.0																				
		190412	0.20-0.50	1.5-9.0																				

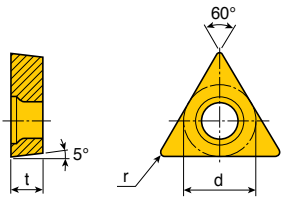

A54, A165, A226

● : Standard items
○ : Semi standard items

TaeguTec
Member IMC Group

TBGT

Positive 5° clearance triangular inserts



Size	Dimension (mm)		
	d	t	r
06	3.97	1.59	0.03-0.4

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated											PVD coated				Uncoated		
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
TOPMINI	**TBGT 0601003 R-FF**	0.03-0.1	0.05-0.3																				
	**0601003 L-FF**	0.03-0.1	0.05-0.3																				
	060101 R-FF	0.03-0.12	0.08-0.4																				
	060101 L-FF	0.03-0.12	0.08-0.4																				
	060102 R-FF	0.03-0.15	0.1-0.4																				
	060102 L-FF	0.03-0.15	0.1-0.4		●																		
	060104 R-FF	0.05-0.20	0.1-0.4		●																		
	060104 L-FF	0.05-0.20	0.1-0.4		●																		

Finishing



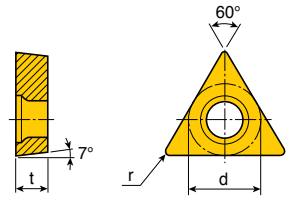
A193, A195

● : Standard items
○ : Semi standard items

TaeguTec Member IMC Group

TCET TCGT TCMT

Positive 7° clearance triangular inserts



Size	Dimension (mm)		
	d	t	r
06	3.97	1.98	0.2
08	4.76	2.38	0.03-0.2
09	5.56	2.38	0.8
11	6.35	2.38-3.18	0.03-0.8
16	9.52	3.97	0.4-0.8

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated									PVD coated			Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
TOPMINI	**TCET**	**0802003 L-GF**	0.02-0.12	0.2-1.5	●															●				
		**0802003 R-GF**	0.02-0.12	0.2-1.5	●															●				
		080201 L-GF	0.02-0.15	0.2-1.5	●															●				
		080201 R-GF	0.02-0.15	0.2-1.5	●															●				
Right hand		**080202 L-GF**	0.03-0.17	0.3-1.5	●															●				
Finishing		**080202 R-GF**	0.03-0.17	0.3-1.5	●															●				
		1103003 L-GF	0.02-0.12	0.2-1.5	●															●				
		1103003 R-GF	0.02-0.12	0.2-1.5	●															●				
		110301 L-GF	0.02-0.15	0.2-1.5	●															●				
		110301 R-GF	0.02-0.15	0.2-1.5	●																			
		110302 L-GF	0.03-0.17	0.3-1.5	●															●				
		110302 R-GF	0.03-0.17	0.3-1.5	●																			
		110304 L-GF	0.05-0.20	0.5-1.5																●				
		110304 R-GF	0.05-0.20	0.5-1.5	●																			
TOPMINI	**TCGT**	**110201 SA**	0.01-0.05	0.1-2.5																●				
		**110202 SA**	0.02-0.15	0.2-2.5																●				
		110204 SA	0.03-0.20	0.2-2.5															●	●				
Finishing																								
	**TCMT**	**06T102 FA**	0.03-0.15	0.4-1.2		●																		
		110202 FA	0.03-0.15	0.1-1.5		●						●							●			●		
		110204 FA	0.05-0.15	0.1-1.5	●												●							
Finishing																								
	**TCMT**	**090208 FG**	0.10-0.25	0.6-1.5	●	●						●					●							
		110204 FG	0.07-0.20	0.4-1.5	●	●						●			●		●		●	●				
		110208 FG	0.10-0.25	0.6-1.5	●	●						●					●		●					
		16T304 FG	0.07-0.20	0.4-2.0	●	●						●					●			●				
		16T308 FG	0.10-0.25	0.6-2.0		●					●	●			●		●							
Finishing																								



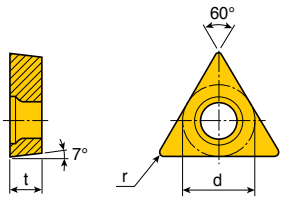
A92, A93, A140,
A153, A189,
A239, A240

● : Standard items
○ : Semi standard items

TaeguTec

TCMT

Positive 7° clearance triangular inserts



Size	Dimension (mm)		
	d	t	r
09	5.56	2.38	0.4-0.8
11	6.35	2.38	0.2-0.8
16	9.52	3.97	0.4-1.2
22	12.7	4.76	0.8

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Medium	**TCMT**	**090202 FM**	0.07-0.20	0.5-1.5	●	●					●	●					●		●	●				
		090204 FM	0.08-0.20	0.5-1.5	●	●					●	●					●		●	●				
		110202 FM	0.07-0.20	0.5-1.5	●	●					●	●					●		●	●				
		110204 FM	0.08-0.20	0.5-1.5	●	●					●	●					●		●	●				
		110208 FM	0.10-0.20	0.8-1.5	●	●					●	●					●		●	●				
		16T304 FM	0.08-0.20	0.5-2.0	●	●					●	●					●		●	●				
		16T308 FM	0.10-0.20	0.8-2.0	●	●					●	●					●		●	●				
		16T312 FM	0.10-0.25	1.0-2.5	●	●					●	●					●		●	●				
 OLD Medium	**TCMT**	**090204 MT** ✓	0.10-0.25	0.6-2.0	●	●	●	●	○		●	●			●		●		●	●				
		090208 MT ✓	0.13-0.30	0.8-2.0		●	●	●	○		●	●					●							
		110204 MT ✓	0.10-0.25	0.6-3.0		●	●	●	○		●	●			●	●	●		●	●			●	
		110208 MT ✓	0.13-0.30	0.8-3.0		●	●	●	○		●	●					●		●	●				
		16T304 MT	0.10-0.25	0.8-5.0		●	●	●	○		●	●			●		●		●					
		16T308 MT	0.10-0.30	1.0-5.0		●	●	●	○		●	●	●		●		●		●	●				
		16T312 MT	0.10-0.30	1.5-5.0			●					●												
		220408 MT	0.10-0.35	2.0-6.0							●													
 Semi finishing	**TCMT**	**090204 PC**	0.06-0.18	0.3-2.0		●					●				●						●			
		090208 PC	0.08-0.25	0.4-2.0											●									
		110204 PC	0.06-0.2	0.3-2.5		●					●	●			●						●			
		110208 PC	0.09-0.26	0.42-2.5							●										●			
		16T304 PC	0.08-0.25	0.35-3.0							●	●			●						●			
		16T308 PC	0.10-0.28	0.5-3.0							●	●									●			
		16T312 PC	0.12-0.36	0.6-3.0								●												



A92, A93, A140, A153, A189, A239, A240

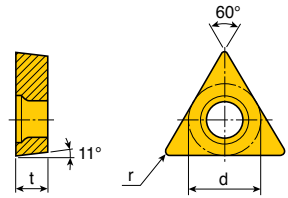
• ✓ Marked: Old type chip breaker

●: Standard items
○: Semi standard items

TaeguTec

TPET TPGN

Positive 11° clearance triangular inserts



Size	Dimension (mm)		
	d	t	r
08	4.76	2.38	0.03-0.2
09	5.56	2.38	0.4
11	6.35	3.18	0.03-0.8
16	9.52	3.18	0.2-1.2
22	12.7	4.76	0.4-3.0
27	15.88	6.35	0.8

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated			
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	P20	P30	K10	K20
TOPMINI	**TPET 0802003 L-GF**	0.02-0.12	0.2-1.5	●															●				
	**0802003 R-GF**	0.02-0.12	0.2-1.5	●															●				
	080201 L-GF	0.02-0.15	0.2-1.5	●															●				
	080201 R-GF	0.02-0.15	0.2-1.5	●															●				
	080202 L-GF	0.03-0.17	0.3-1.5	●															●				
	080202 R-GF	0.03-0.17	0.3-1.5	●															●				
	1103003 L-GF	0.02-0.12	0.2-1.5	●															●				
	1103003 R-GF	0.02-0.12	0.2-1.5	●															●				
	110301 L-GF	0.02-0.15	0.2-1.5	●															●				
	110301 R-GF	0.02-0.15	0.2-1.5	●															●				
	110302 L-GF	0.03-0.17	0.3-1.5	●															●				
Right hand Finishing	**110302 R-GF**	0.03-0.17	0.3-1.5	●															●				
	TPGN 090204	0.07-0.20	0.5-3.0																			●	
	**110304**	0.07-0.20	0.7-3.0	●																●		●	
	110308	0.10-0.25	1.0-3.0							●												●	
	160302	0.05-0.18	1.0-5.0																				
	160304	0.07-0.20	1.0-5.0	●						●										●		●	
	160308	0.10-0.25	1.0-5.0	●		●				●	●									●		●	
	160312	0.15-0.30	1.0-5.0																				
	220404	0.07-0.20	1.5-7.0																	●		●	
	220408	0.10-0.25	1.5-7.0								●											●	
	220412	0.15-0.30	1.5-7.0																	●			
	220416	0.20-0.35	1.5-7.0																				
	220425	0.25-0.40	1.5-7.0																				
	220430	0.30-0.45	1.5-7.0																		●		
	270608	0.15-0.25	3.0-8.0							●													
Finishing																							



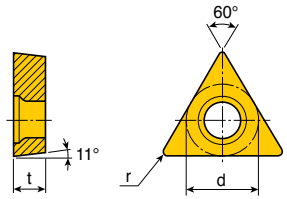
A55, A56, A94,
A166, A191, A192,
A227, A228

● : Standard items
○ : Semi standard items

TaeguTec
Member IMC Group

TPGT TPGX

Positive 11° clearance triangular inserts



Size	Dimension (mm)		
	d	t	r
08	4.76	2.38	0.03-0.2
09	5.56	2.38	0.2-0.4
11	6.35	3.18	0.03-0.8
16	9.52	4.76	0.4

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated			
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	P20	P30	K10	K20
TOPMINI	**TPGT 0802003 L-FF**	0.03-0.10	0.05-0.3	●															●				
	**0802003 R-FF**	0.03-0.10	0.05-0.3	●															●				
Right hand Finishing	**080201 L-FF**	0.03-0.12	0.08-0.4	●															●				
	080201 R-FF	0.03-0.12	0.08-0.4	●															●				
	080202 L-FF	0.03-0.15	0.1-0.4	●															●				
	080202 R-FF	0.03-0.15	0.1-0.4	●															●				
	1103003 L-FF	0.03-0.10	0.05-0.4	●															●				
	1103003 R-FF	0.03-0.10	0.05-0.4	●															●				
	110301 L-FF	0.03-0.12	0.1-0.5	●															●				
	110301 R-FF	0.03-0.12	0.1-0.5	●															●				
	110302 L-FF	0.03-0.15	0.1-0.5	●															●				
	110302 R-FF	0.03-0.15	0.1-0.5	●															●				
	**TPGT 090204 L-C**	0.05-0.20	0.3-1.5	●																			
	110304 L-C	0.05-0.20	0.5-2.0	●																		●	
Right hand Finishing	**110304 R-C**	0.05-0.20	0.5-2.0	●																			
	110308 L-C	0.07-0.25	0.5-2.0	●																			
	160404 L-C	0.05-0.20	0.7-3.0	●																			
	160404 R-C	0.05-0.20	0.7-3.0	●																			
	**TPGX 090202 L**	0.05-0.15	0.4-1.5	●																			
	090204 L	0.08-0.20	0.6-1.5	●																		●	
Left hand Finishing	**110302 L**	0.08-0.20	0.5-1.5	●																			
	110302 R	0.08-0.20	0.5-1.5																				
	110304 L	0.08-0.20	0.6-2.0	●																		●	
	110304 R	0.08-0.20	0.6-2.0	●																			



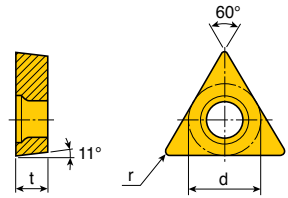
A56, A94, A191, A192

●: Standard items
○: Semi standard items

TaeguTec

TPMR TPMT

Positive 11° clearance triangular inserts



Size	Dimension (mm)		
	d	t	r
09	5.56	2.38	0.2-0.8
11	6.35	2.38-3.18	0.2-0.8
16	9.52	3.18-3.97	0.2-1.2
22	12.7	4.76	0.4-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated		Uncoated			
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	P20	P30	K10	K20
 Medium	**TPMR**	**090204**	0.10-0.25	0.5-2.0							●													
		090208	0.13-0.30	0.7-2.0							●													
		110304 ✓	0.10-0.25	0.7-3.0		●					●	●					●			●				
		110308	0.13-0.30	1.0-3.0		●					●	●					●							
		160304 ✓	0.10-0.25	1.0-5.0		●		●	○		●	●					●		●	●				
		160308	0.13-0.30	1.0-5.0		●	●				●	●					●		●	●				
		160312	0.15-0.35	1.0-5.0																				
		220404 ✓	0.10-0.25	1.0-7.0								●					●							
		220408 ✓	0.13-0.30	1.5-7.0			●					●					●							
		220412 ✓	0.15-0.35	1.5-7.0																				
 Finishing	**TPMT**	**090202 FA**	0.03-0.15	0.1-1.2	●	●					●	●							●	●				
		090204 FA	0.05-0.20	0.2-1.2	●	●					●	●							●	●				
		110302 FA	0.03-0.15	0.1-1.5	●	●					●	●							●	●				
		110304 FA	0.05-0.20	0.2-1.5	●	●					●	●							●	●				
		110308 FA	0.08-0.25	0.3-1.5	●	●					●	●							●	●				
		16T304 FA	0.05-0.20	0.2-2.0	●	●					●	●							●	●				
		16T308 FA	0.08-0.25	0.3-2.0	●	●					●	●							●	●				
 Finishing	**TPMT**	**110304 FG**	0.07-0.20	0.4-1.5	●	●					●	●					●			●				
 Medium	**TPMT**	**090202 FM**	0.07-0.20	0.5-1.5	●	●					●	●					●		●	●				
		090204 FM	0.08-0.20	0.5-1.5	●	●					●	●					●		●	●				
		110302 FM	0.07-0.20	0.5-1.5	●	●					●	●					●		●	●				
		110304 FM	0.08-0.20	0.5-1.5	●	●					●	●					●		●	●				
		110308 FM	0.10-0.20	0.8-1.5	●	●					●	●					●		●	●				
		160302 FM	0.07-0.20	0.5-2.0	●	●					●	●					●		●	●				
		160304 FM	0.08-0.20	0.5-2.0	●	●					●	●					●		●	●				
		160308 FM	0.10-0.25	0.8-2.5	●	●					●	●					●		●	●				
 Semi finishing	**TPMT**	**090204 PC**	0.06-0.18	0.3-2.0		●											●		●					
		110204 PC	0.06-0.2	0.4-2.5		●																		
		110208 PC	0.1-0.26	0.5-2.5																				
		110304 PC	0.06-0.2	0.4-2.5		●									●				●					
		110308 PC	0.1-0.26	0.5-2.5		●						●			●				●					
		16T304 PC	0.08-0.25	0.45-3.0															●					
		16T308 PC	0.1-0.3	0.5-3.0															●					



A55, A56, A94, A166, A191, A192, A227, A228

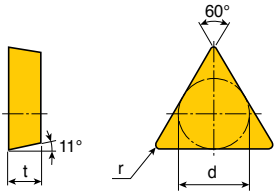
• ✓ Marked: Old type chip breaker

● : Standard items
○ : Semi standard items

TaeguTec

TPUN

Positive 11° clearance triangular inserts



Size	Dimension (mm)		
	d	t	r
11	6.35	3.18	0.4-0.8
16	9.52	3.18	0.4-1.6
22	12.7	4.76	0.4-1.6

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated			
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	P20	P30	K10	K20
 Medium	**TPUN**	**110304**	0.10-0.30	1.0-3.0								●									●		●	
		110308	0.15-0.40	1.0-3.0																				
		160304	0.10-0.30	1.0-5.0								●									●		●	
		160308	0.15-0.40	1.0-5.0							●	●									●			
		160312	0.20-0.50	1.5-5.0																				
		160316	0.25-0.55	1.5-5.0																				
		220404	0.10-0.30	1.5-7.0							●													
		220408	0.15-0.40	1.5-7.0								●									●			
		220412	0.20-0.50	1.5-7.0																				
		220416	0.25-0.55	1.5-7.0																				

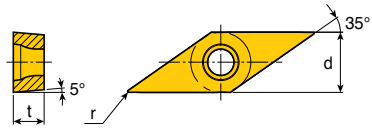

A55, A166, A227, A228

● : Standard items
○ : Semi standard items

VBET VBGT VBMT

T-TURN

Positive 5° clearance 35° rhombic inserts



Size	Dimension (mm)		
	d	t	r
11	6.35	3.18	0.03-0.4
16	9.52	4.76	0.1-0.8

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
TOPMiNi	VBET	110301 L-GF	0.02-0.15	0.2-1.5	●																			
		110301 R-GF	0.02-0.15	0.2-1.5	●															●				
		110302 L-GF	0.03-0.17	0.3-1.5	●																			
Right hand		110302 R-GF	0.03-0.17	0.3-1.5	●															●				
Finishing		110304 L-GF	0.05-0.20	0.3-1.5	●																			
		110304 R-GF	0.05-0.20	0.3-1.5	●															●				
TOPMiNi	VBET	1103003 L-GW*	0.02-0.15	0.1-1.5																				
wiper		1103003 R-GW*	0.02-0.15	0.1-1.5																●				
Right hand																								
Finishing																								
TOPMiNi	VBGT	1103003 L-FF	0.03-0.10	0.05-0.4	●															●				
		1103003 R-FF	0.03-0.10	0.05-0.4	●															●				
		110301 L-FF	0.03-0.12	0.1-0.5	●															●				
Finishing		110301 R-FF	0.03-0.12	0.1-0.5	●															●				
		110302 L-FF	0.03-0.15	0.1-0.5	●															●				
		110302 R-FF	0.03-0.15	0.1-0.5	●															●				
TOPMiNi	VBGT	110301 SA	0.01-0.20	0.1-1.5															●	●				
		110302 SA	0.02-0.20	0.2-1.5															●	●				
		110304 SA	0.05-0.20	0.2-1.5															●	●				
Finishing		160401 SA	0.01-0.20	0.1-1.5																●				
		160402 SA	0.02-0.20	0.2-1.5															●	●				
		160404 SA	0.03-0.20	0.2-2.5																●				
	VBMT	110304 FA	0.05-0.20	0.2-1.5	●	●					●	●							●	●				
Finishing		160404 FA	0.05-0.20	0.2-2.0	●	●					●	●							●	●				
		160408 FA	0.08-0.25	0.3-2.0	●	●					●	●							●	●				



A50, A95, A98, A100, A136, A140, A141, A154, A196, A198, A200, A201, A219

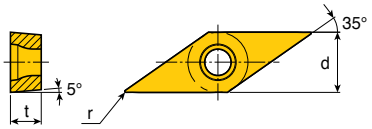
• ✱ Marked: Wiper inserts should be applied to ☐VJBR/L...

● : Standard items
○ : Semi standard items

TaeguTec
Member IMC Group

VBMT

Positive 5° clearance 35° rhombic inserts



Size	Dimension (mm)		
	d	t	r
11	6.35	3.18	0.4-0.8
16	9.52	4.76	0.4-1.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Finishing	**VBMT**	**160404 FG**	0.07-0.20	0.5-1.5	●	●					●	●		●	●		●		●	●					
		160408 FG	0.10-0.25	0.7-2.0	●	●					●	●		●	●		●		●						
 Medium	**VBMT**	**110304 FM**	0.08-0.20	0.5-1.5	●	●					●	●					●		●	●					
		110308 FM	0.10-0.20	0.5-1.5	●	●					●	●					●		●	●					
		160404 FM	0.08-0.20	0.5-2.0	●	●					●	●					●		●	●					
		160408 FM	0.10-0.20	0.8-2.0	●	●					●	●					●		●	●					
		160412 FM	0.10-0.25	1.0-2.5	●	●					●	●					●		●	●					
 Finishing	**VBMT**	**160404 FX**	0.05-0.20	0.2-2.0		●					●	●													
		160408 FX	0.07-0.20	0.2-2.0		●					●	●													
 Medium	**VBMT**	**160404 MT**	0.10-0.25	0.6-3.0	●	●	●	●	○		●	●			●		●		●	●					
		160408 MT	0.13-0.30	0.9-3.0	●	●	●	●	○		●	●			●		●		●	●					
		160412 MT	0.15-0.30	1.2-3.0							●	●					●								
 Semi finishing	**VBMT**	**160404 PC**	0.07-0.22	0.5-2.8		●					●	●			●						●				
		160408 PC	0.10-0.27	0.5-2.8		●					●	●			●						●				
		160412 PC	0.10-0.28	0.5-2.8																					



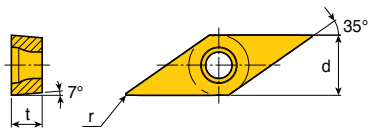
A50, A95, A98, A100, A136, A140, A141, A154, A196, A198, A200, A201, A219

● : Standard items
○ : Semi standard items

TaeguTec Member IMC Group

VCGT VCMT

Positive 7° clearance 35° rhombic inserts



Size	Dimension (mm)		
	d	t	r
08	4.76	2.38	0.2-0.4
11	6.35	3.18	0.1-0.4
16	9.52	4.76	0.4-0.8

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated									PVD coated			Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
TOPMini	**VCGT**	**110301 SA**	0.01-0.20	0.1-1.5															●		●				
		**110302 SA**	0.02-0.20	0.2-1.5															●		●				
Finishing		**110304 SA**	0.05-0.20	0.2-1.5															●		●				
	**VCMT**	**080202 FM**	0.07-0.15	0.5-1.5	●	●					●	●					●		●	●					
		080204 FM	0.08-0.15	0.5-1.5	●	●					●	●					●		●	●					
Medium		**110304 FM**	0.08-0.20	0.5-1.5	●	●					●	●					●		●	●					
		160404 FM	0.08-0.20	0.5-2.0	●	●					●	●					●		●	●					
		160408 FM	0.10-0.20	0.8-2.0	●	●					●	●					●		●	●					
	**VCMT**	**080202 PC**	0.02-0.15	0.2-1.5		●						●			●									
		080204 PC	0.05-0.20	0.2-1.5	●	●					●	●			●										
VCMT 08, 11		**110304 PC**	0.05-0.20	0.1-1.7		●					●	●			●						●				
		**160404 PC**	0.05-0.20	0.3-2.0		●					●	●		●	●						●				
VCMT 16		**160408 PC**	0.07-0.20	0.3-2.0		●					●	●			●						●				
Semi finishing																									



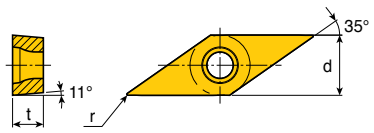
A50, A96, A101,
A141, A196, A198,
A200, A201

● : Standard items
○ : Semi standard items

TaeguTec

VPET VPGT

Positive 11° clearance 35° rhombic inserts



Size	Dimension (mm)		
	d	t	r
08	4.76	2.38	0.1-0.2
11	6.35	3.18	0.03-0.2

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated			Uncoated		
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
TOPMINI  Right hand Finishing	VPET 080201 L-GF	0.02-0.15	0.2-1.5	●															●				
	080201 R-GF	0.02-0.15	0.2-1.5	●															●				
	080202 L-GF	0.03-0.17	0.3-1.5	●															●				
	080202 R-GF	0.03-0.17	0.3-1.5	●															●				
	1103003 L-GF	0.02-0.12	0.2-1.5	●															●				
	1103003 R-GF	0.02-0.12	0.2-1.5	●															●				
	110301 L-GF	0.02-0.15	0.2-1.5	●															●				
	110301 R-GF	0.02-0.15	0.2-1.5	●															●				
	110302 L-GF	0.03-0.17	0.3-1.5	●															●				
	110302 R-GF	0.03-0.17	0.3-1.5	●															●				
TOPMINI  Finishing	VPGT 080201 L-FF	0.03-0.12	0.08-0.4	●															●				
	080201 R-FF	0.03-0.12	0.08-0.4	●															●				
	080202 L-FF	0.03-0.15	0.1-0.4	●															●				
	080202 R-FF	0.03-0.15	0.1-0.4	●															●				
	1103003 L-FF	0.03-0.10	0.05-0.4	●															●				
	1103003 R-FF	0.03-0.10	0.05-0.4	●															●				
	110301 L-FF	0.03-0.12	0.1-0.5	●															●				
	110301 R-FF	0.03-0.12	0.1-0.5	●															●				
	110302 L-FF	0.03-0.15	0.1-0.5	●															●				
	110302 R-FF	0.03-0.15	0.1-0.5	●															●				



A51, A52, A97, A99, A197

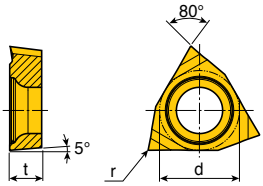
● : Standard items
○ : Semi standard items

TaeguTec Member IMC Group

WBGT WBMT

T-TURN

Positive 5° clearance 80° trigon inserts



Size	Dimension (mm)		
	d	t	r
06	3.97	1.59	0.03-0.4

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
TOPMini	**WBGT 0601003 R-FF**	0.03-0.10	0.05-0.3																				
	**0601003 L-FF**	0.03-0.10	0.05-0.3																				
	060101 R-FF	0.03-0.12	0.08-0.4	●																			
	060101 L-FF	0.03-0.12	0.08-0.4	●																			
	060102 R-FF	0.03-0.15	0.1-0.4	●																			
	060102 L-FF	0.03-0.15	0.1-0.4	●																			
	060104 R-FF	0.05-0.20	0.1-0.4	●																			
	060104 L-FF	0.05-0.20	0.1-0.4	●																			
Finishing	**WBMT 060102 R-C**	0.03-0.15	0.1-0.4	●																			
	060102 L-C	0.03-0.15	0.1-0.4	●																			

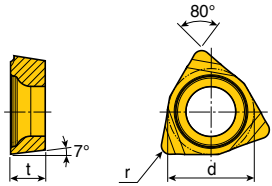

A203

●: Standard items
○: Semi standard items

WCGT

T-TURN

Positive 7° clearance 80° trigon inserts



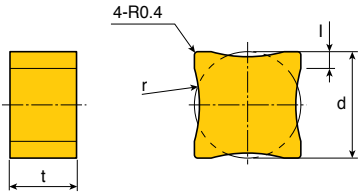
Size	Dimension (mm)		
	d	t	r
02	3.97	1.59	0.2-0.4

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
	**WCGT 020102 L-FF**	0.03-0.15	0.1-0.4		●																		
	020104 L-FF	0.05-0.20	0.1-0.4		●																		
Finishing																							

●: Standard items
○: Semi standard items

TaeguTec
Member IMC Group

Negative square insert for pipe skiving



Size	Dimension (mm)			
	l	d	t	r
SNG 452	2	12.70	7.94	10-70

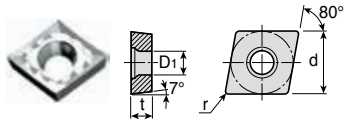
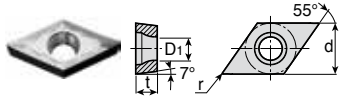
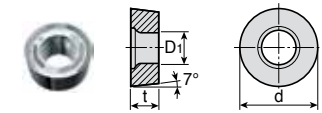
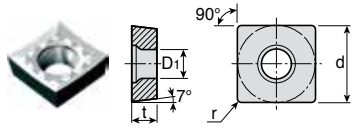
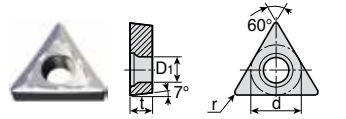
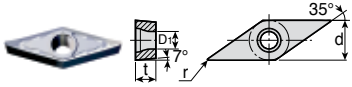
Insert	Designation	Coated
		TT5100
 Pipe skiving	**SNG 452 10R**	●
	16R	●
	20R	●
	25R	●
	30R	●
	40R	●
	50R	●
	60R	●
	70R	●

● : Standard items

Inserts for Aluminum

T-TURN

Positive 7° clearance inserts for aluminum machining

Insert	Designation		Dimension (mm)					Uncoated
			d	t	r	D_1		K10
	CCGT	060202 FL	6.35	2.38	0.2	2.8		●
		060204 FL	6.35	2.38	0.4	2.8		●
		09T302 FL	9.52	3.97	0.2	4.4		●
		09T304 FL	9.52	3.97	0.4	4.4		●
		09T308 FL	9.52	3.97	0.8	4.4		●
		120402 FL	12.7	4.76	0.2	5.5		●
		120404 FL	12.7	4.76	0.4	5.5		●
		120408 FL	12.7	4.76	0.8	5.5		●
	DCGT	070202 FL	6.35	2.38	0.2	2.8		●
		070204 FL	6.35	2.38	0.4	2.8		●
		11T302 FL	9.52	3.97	0.2	4.4		●
		11T304 FL	9.52	3.97	0.4	4.4		●
		11T308 FL	9.52	3.97	0.8	4.4		●
	RCGT	0803M0 FL	8.0	3.18	-	3.4		●
		1003M0 FL	10.0	3.18	-	4.4		●
		10T3M0 FL	10.0	3.97	-	4.4		●
	SCGT	09T308 FL	9.52	3.97	0.8	4.4		●
		120402 FL	12.7	4.76	0.2	5.5		●
		120404 FL	12.7	4.76	0.4	5.5		●
		120408 FL	12.7	4.76	0.8	5.5		●
	TCGT	090204 FL	5.56	2.38	0.4	2.5		●
		110204 FL	6.35	2.38	0.4	2.8		●
		16T304 FL	9.52	3.97	0.4	4.4		●
		16T308 FL	9.52	3.97	0.8	4.4		●
	VCGT	110302 FL	6.35	3.18	0.2	2.8		●
		110304 FL	6.35	3.18	0.4	2.8		●
		160402 FL	9.52	4.76	0.2	4.4		●
		160404 FL	9.52	4.76	0.4	4.4		●
		160408 FL	9.52	4.76	0.8	4.4		●
		160412 FL	9.52	4.76	1.2	5.5		●
		220530 FL	12.7	5.56	3.0	5.5		●

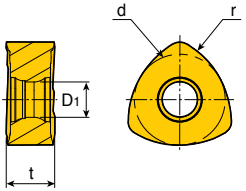
● : Standard items

TaeguTec
Member IMC Group

BNMX

TOPFEED

TOPFEED inserts



Size	Dimension (mm)			
	d	t	r	D1
15	15	8	15	6.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
	**BNMX**	**150720 L-HF**	0.5-2.5	0.5-2.5								●												
		150720 R-HF	0.5-2.5	0.5-2.5								●												



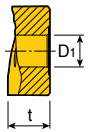
A128

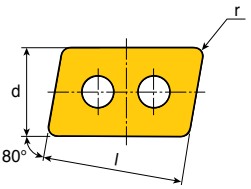
● : Standard items

LNMM

TOPDUTY

TOPDUTY inserts





Size	Dimension (mm)				
	l	d	t	r	D1
40	40.2	25.4	11.65	2.38	9.15

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
	**LNMM**	**401224 R-HX**	0.70-1.50	6.0-32.0																			
		401224 L-HX	0.70-1.50	6.0-32.0																			



A130

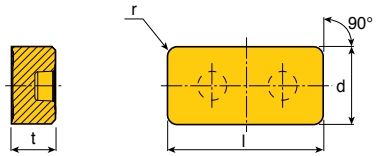
● : Standard items

TaeguTec
Member IMC Group

LNMX

TOPDUTY

TOPDUTY inserts



Size	Dimension (mm)			
	l	d	t	r
50	50.8	25.4	14.2	3.2

Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
	**LNMX**	**501432 HD**	0.70-1.60	6.0-40.0																				
	**LNMX**	**501432 HY**	0.65-1.50	5.0-40.0														●						

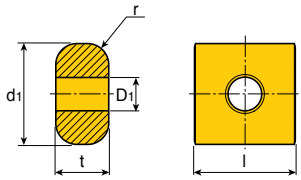


A130

● : Standard items

LNMX

TOPRAIL inserts



Size	Dimension (mm)				
	D1	d1	r	t	l
19	6.35	19.05	4	10	19.05
30	6.35	30	4	12	19.05

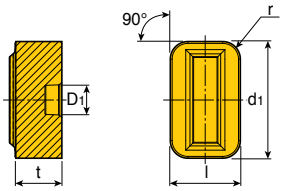
Insert	Designation		Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
					PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
 Finishing	**LNMX**	**191940 TWF**	0.30-1.0	0.3-5.0								●												
	**LNMX**	**191940 TWM**	0.45-1.5	1.5-9.0							●													
		301940 TWM	0.50-1.5	1.5-15.0																				
 Medium																								
 Roughing	**LNMX**	**301940 TWR**	0.70-1.8	2.0-15.0																				


A131

● : Standard items

TaeguTec
Member IMC Group

TOPRAIL inserts



Size	Dimension (mm)				
	D1	d1	r	t	l
SRR-TX	8.1	31.75	4.8	12.7	19.05

Insert	Designation	Feed (mm/rev)	ap (mm)	Cermet		CVD coated										PVD coated				Uncoated		
				PV3010	CT3000	TT7005	TT7015	TT7310	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225	TT9235	TT5100	TT7100	TT5080	TT8020	TT9020	TT9080	P20	K10	K20
	**SRR-TX**	0.60-1.8	1.5-20.0																			


A132

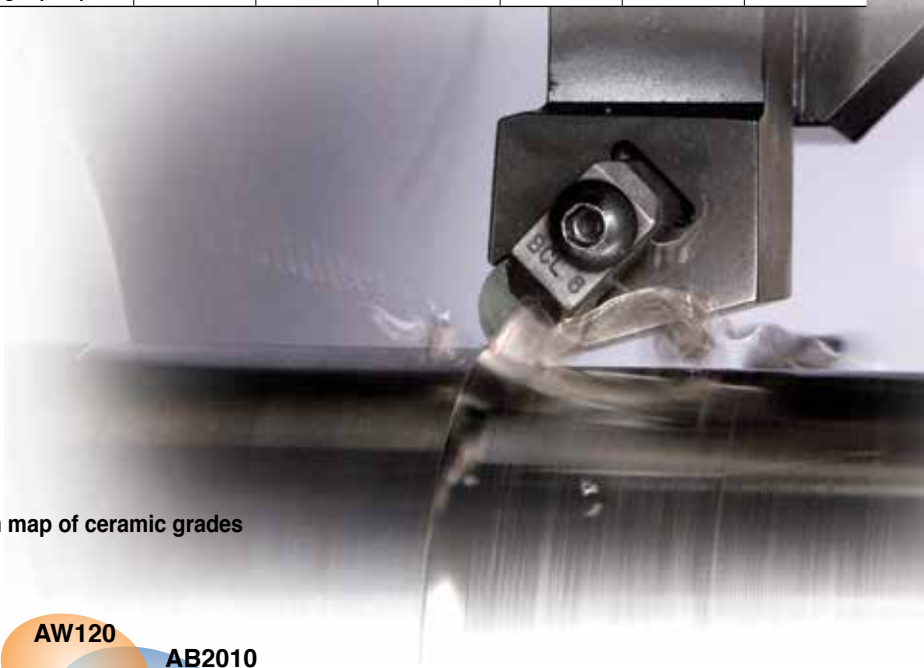
• Insert can be supplied by quotation

● : Standard items

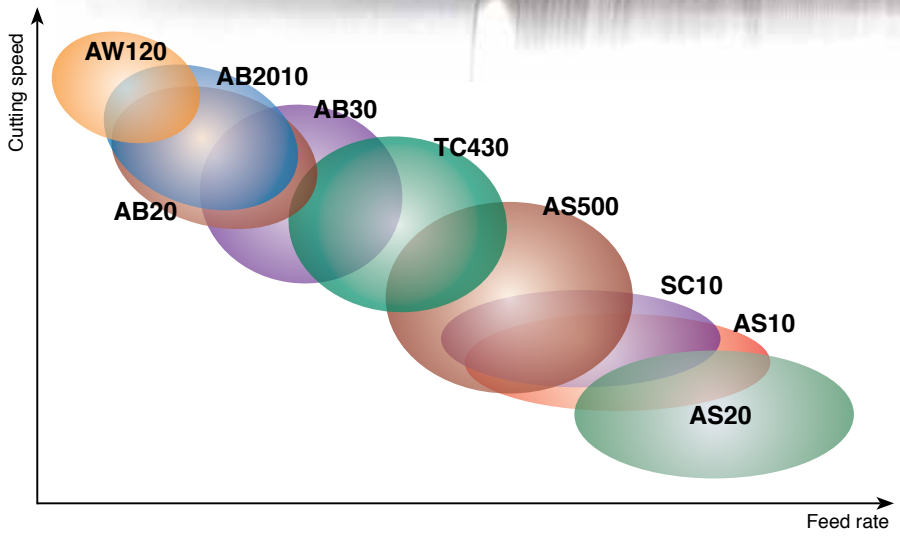
Ceramic Inserts

Physical properties

Grade		AW120	AB2010	AB20	AB30	TC430	AS500
Composition		Al_2O_3 ZrO_2	Al_2O_3- Ti(C,N)	Al_2O_3- Ti(C,N)	Al_2O_3- TiC	SiC Whisker	SiAlON
Density (g/cm³)		4.05	4.30	4.30	4.25	3.74	3.21
Hardness	**HRA**	94.0	94.5	94.5	94.5	95.1	94.3
	Vickers	1,800	2,050	2,050	2,050	2,100	1,800
Bending strength (MPa)		600	650	650	700	700	850



Application map of ceramic grades



Edge preparation for ceramic inserts

1. Common style (no designation)

Grade	Land specification	
	Width (mm)	Angle (°)
AB2010, AB20, AB30, TC430, AS500, SC10, AS10, AS20	0.2	25
AW120	0.2	20

2. Others (single T-land)

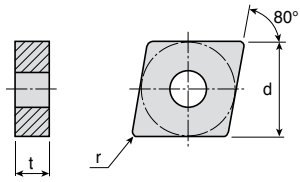
Designation	Land specification	
	Width (mm)	Angle (°)
T2	0.10	30
T3	0.15	30
T4	0.20	30
T5	0.30	30
T6	0.10	20
T7	0.20	20

3. Edge preparation "E" is only honing without T-land

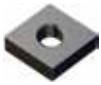
4. Various special edge preparations such as "Double Land" or "S" can be made upon request

CNGA CNGN

Negative 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
12	12.7	4.76-7.94	0.4-1.6
16	15.88	4.76-6.35	0.8-2.4
19	19.05	6.35-7.94	0.8-2.4

Insert	Designation		Ceramic												
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20	CT3030			
	**CNGA**	**120404**	●	●	●										
		120408	●	●	●	●	●	●	●						
		120408 E									●				
		120408 T7					●								
		120412	●	●	●			●	●						
		120412 E									●				
		120412 T7					●								
		120416		●	●			●	●						
		160408			●										
		160608		●											
		160612		●	●				●						
		160616		●	●										
		160624			●										
		190608		●	●										
		190612		●	●										
		190616			●										
		190624			●				●						
		190716 U3							●						
	**CNGN**	**120404**			●										
		120404 T6								●					
		120408	●	●	●				●						
		120408 E									●	●			
		120408 T6								●					
		120412		●				●	●						
		120412 E									●	●			
		120412 T6								●					
		120416		●					●						
		120416 T6								●	●				
		120708	●	●	●										
		120708 E									●	●			
		120708 T6								●					
		120712			●				●						
		120712 E									●	●			
		120712 T6								●					
		120716			●			●	●						
		120716 E									●				



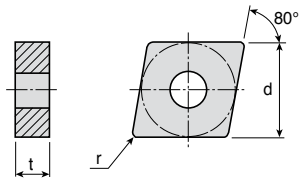
A74, A75, A102, A103,
A115, A133, A148, A176,
A204, A216, A234

● : Standard items

TaeguTec
Member IMC Group

CNGX CNMG

Negative 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
12	12.7	4.76-7.94	0.4-1.6

Insert	Designation		Ceramic												
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20				
	**CNGX**	**120712 CH**							●						
		120712 T7-CH					●		●						
		120716 CH						●	●						
		120716 T7-CH					●		●						
	**CNMG**	**120404 CE**			●										
		120408 CE		●	●										



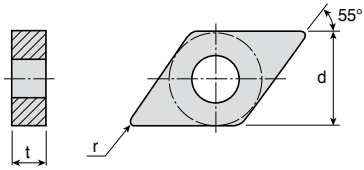
A74, A75, A102, A103, A124,
A125, A133, A148, A176,
A204, A216, A234, A315

● : Standard items

TaeguTec
Member IMC Group

DNGA DNGN DNGX DNMG

Negative 55° rhombic inserts



Size	Dimension (mm)		
	d	t	r
12	10	7.94	0.8-1.2
15	12.7	4.76-7.94	0.4-1.6

Insert	Designation		Ceramic												
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20				
	**DNGA**	**150404**		●	●										
		150404 T6		●											
		150408	●	●	●										
		150408 T6			●										
		150412	●	●	●										
		150416		●											
		150416 T7		●											
		150604	●	●	●										
		150606			●										
		150608	●	●	●		●		●						
		150612	●	●	●				●						
		150616		●	●										
	**DNGN**	**150408**		●	●										
		150704			●										
		150708			●	●									
		150712				●									
		150712 U2			●										
		150716		●											
		150716 U2			●										
	**DNGX**	**120708 T7-CH**							●						
		120712 T7-CH							●						
		150708 T7-CH							●						
		150712 CH						●	●						
		150712 T7-CH					●		●						
		150716 CH						●	●						
		150716 T7-CH							●						
	**DNMG**	**150608 CE**			●										



A68, A69, A76, A104, A116, A126, A134, A148, A177, A205, A216

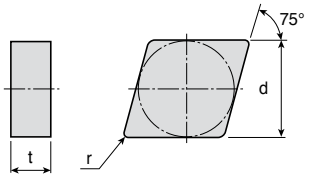
● : Standard items

TaeguTec

ENGN

T-TURN

Negative 75° rhombic inserts



Size	Dimension (mm)		
	d	t	r
13	12.7	7.94	0.8-1.6

Insert	Designation		Ceramic											
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20			
	**ENGN**	**130708**	●	●	●									
		130712		●										
		130716		●	●									
		130716 U2			●									

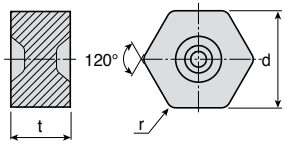


● : Standard items

HNGX

T-TURN

Negative 120° hexagonal inserts

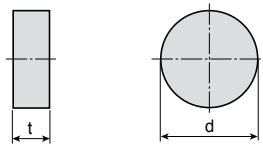


Size	Dimension (mm)		
	d	t	r
05	12.7	7.94	1.2-1.6

Insert	Designation		Ceramic											
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20			
	**HNGX**	**050712 CH**							●					
		050712 T7-CH					●							
		050716 CH							●					
		050716 T7-CH					●							

● : Standard items

Negative round inserts



Size	Dimension (mm)	
	d	t
09	9.52	3.18-4.76
12	12.7	4.76-7.94
15	15.88	6.35-7.94
19	19.05	7.94

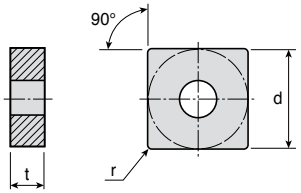
Insert	Designation		Ceramic										
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20	CT3020	CT3030
	**RNGN**	**090300**		●	●								
		090300 T6								●			
		090400 T6								●			
		120400	●	●	●								
		120400 E									●		
		120400 T6								●	●		
		120700	●	●	●								
		120700 E									●	●	●
		120700 T6								●	●		
		150600 T6								●			
		150700		●	●								
		150700 T6								●			
		190700		●	●								
		190700 E									●		
		190700 T6								●	●		
		190700 U2			●								
	**RNGN**	**120700 E-CH**										●	●



● : Standard items

SNGA SNGN

Negative square inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	4.76	1.2
12	12.7	4.76-7.94	0.4-2.5
15	15.88	6.35-7.94	1.2-1.6
19	19.05	6.35-7.94	0.8-1.6
25	25.4	9.52	2.4

Insert	Designation		Ceramic															
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20							
	**SNGA**	**120404**	●	●	●													
		120408	●	●	●				●									
		120408 E									●							
		120412	●	●	●			●	●									
		120412 T6									●							
		120412 T7							●									
		120416		●				●	●									
		150616						●										
		190608			●													
		190612			●													
		190616			●													
	**SNGN**	**090412**			●													
		120404	●	●	●													
		120408	●	●	●				●									
		120408 E									●							
		120408 T6								●								
		120412	●	●	●	●	●	●										
		120412 T6								●								
		120412 T7					●		●									
		120416	●	●	●		●	●										
		120416 T6									●							
		120704		●	●													
		120708	●	●	●	●		●	●									
		120708 T6								●								
		120712	●	●	●	●		●	●									
		120712 T6			●					●								
		120712 U2			●													
		120716	●		●	●		●	●									
		120720 U2			●													
		120725						●										
		150612		●														
		150712 T6								●								
		150716			●				●									
		190716			●													
		190716 U3			●													
		250924			●													
		250924 U3			●													

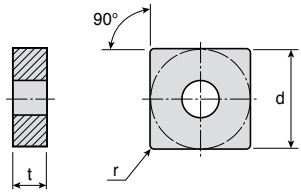


A80, A81, A107, A108,
A119, A120, A149,
A178, A208, A235

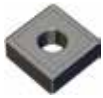
● : Standard items

SNGX SNMX SNMG

Negative square inserts



Size	Dimension (mm)		
	d	t	r
12	12.7	4.76-7.94	0.8-1.6
15	15.88	7.94	1.6

Insert	Designation		Ceramic												
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20				
	**SNGX**	**120712 CH**						●	●						
		120712 T7-CH					●		●						
		120712 T7-CHX ✱					●								
		120716 CH						●	●						
		120716 T7-CH					●		●						
		120716 T7-CHX ✱					●		●						
		150716 T7-CH							●						
	**SNMX**	**120716 CH**						●	●						
	**SNMG**	**120408 CE**			●										



A80, A81, A107, A108, A127, A149, A178, A208, A235

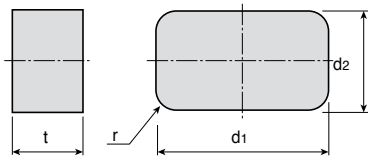
• ✱ Marked: Marked insert is applied only to DCL S-4D clamp

● : Standard items

TaeguTec
Member IMC Group

LNU T32-

Negative square inserts



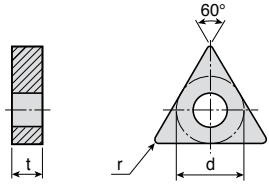
Size	Dimension (mm)		
	d_1	d_2	r
LNU	38.1	19.05	3.2
T32	31.75	19.05	2

Insert	Designation	Ceramic												
		AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20				
	**LNU 6688 T**		●	●					●					
	**T32- 32-R2**		●					●						

● : Standard items

TNGA TNGN TNMG

Negative triangular inserts



Size	Dimension (mm)		
	d	t	r
11	6.35	3.18	0.8-1.2
16	9.52	3.18-7.94	0.4-1.6
22	12.7	4.76-7.94	0.4-1.6
27	15.88	6.35	1.6

Insert	Designation		Ceramic													
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20					
	**TNGA**	**160304**			●											
		160308			●											
		160404	●	●	●											
		160408	●	●	●			●	●							
		160408 E									●					
		160412	●	●				●	●							
		160416		●												
		220404		●	●											
		220408	●		●											
		220412		●	●											
		220416		●	●											
	**TNGN**	**110308**			●											
		110312							●							
		160404		●	●											
		160408	●	●	●			●	●							
		160408 E									●					
		160408 T6								●						
		160412		●	●	●	●	●	●							
		160412 T7					●									
		160416			●											
		160704			●											
		160708			●											
		160712			●				●							
		220408		●												
		220412			●											
		220712 T6								●						
		270616			●											
	**TNMG**	**160408 CE**			●											



A70, A82, A83, A109,
A113, A114, A121, A150,
A179, A217, A236, A237

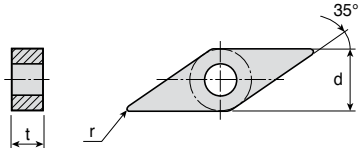
● : Standard items

TaeguTec
Member IMC Group

VNGA VNGX

T-TURN

Negative 35° rhombic inserts



Size	Dimension (mm)		
	d	t	r
16	9.52	4.76-7.94	0.4-1.6
22	12.7	4.76	1.2

Insert	Designation		Ceramic									
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20	
	**VNGA**	**160404**	●	●	●			●				
		160408	●	●	●				●			
		160408 E									●	
		160412		●	●							
		220412			●							
	**VNGX**	**160712 CH**										
		160712 T7-CH							●			
		160716 CH										



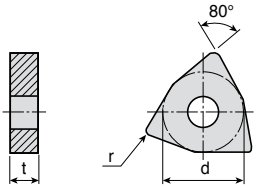
A71, A72, A96, A110, A111

● : Standard items

WNGA

T-TURN

Negative 80° trigon inserts



Size	Dimension (mm)		
	d	t	r
08	12.7	4.76	0.8-1.6

Insert	Designation		Ceramic									
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20	
	**WNGA**	**080408**	●	●	●			●	●			
		080412	●	●	●			●	●			
		080412 T7					●					
		080416		●	●			●				

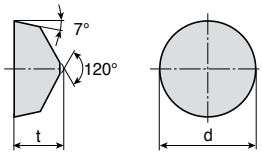


A73, A112, A137, A151, A175, A211, A212

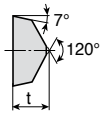
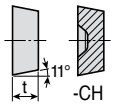
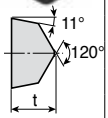
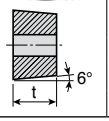
● : Standard items

RCGX RPGN RPGX T11-

Positive round inserts



Size	Dimension (mm)	
	d	t
06	6.35	6.35
09	9.52	3.18-7.94
12	12.7	4.76-7.94
15	15.88	8
19	19.05	10.3
25	25.4	12.3
T11	31.9	19.05

Insert	Designation		Ceramic										
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20	CT3020	CT3030
 	**RCGX**	**060600 T6**								●	●		
		060600 U1			●								
		090700 E										●	●
		090700 T6								●	●		
		090700 U1		●	●								
		120700			●								
		120700 E										●	●
		120700 T6								●	●	●	●
		120700 U2		●	●								
		151000 U2		●	●								
		191000 U2		●	●								
		251200 U3		●	●								
 	**RPGN**	**090300 E**								●			
		120400 E								●		●	●
		120400 T6								●		●	●
		120400 E-CH										●	●
 	**RPGX**	**090700 T6**								●	●		
		120700 T6								●	●		
 	**T11-**	**3219**		●									



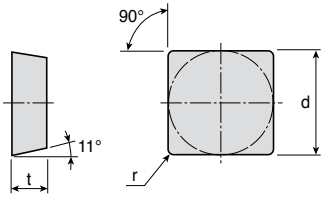
● : Standard items

TaeguTec

SPGN

T-TURN

Positive square inserts



Size	Dimension (mm)		
	d	t	r
12	12.7	3.18-4.76	0.8-1.2

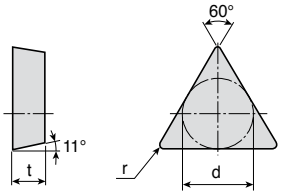
Insert	Designation		Ceramic											
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20			
	**SPGN**	**120308**			●				●					
		120312			●									
		120412			●			●	●					

● : Standard items

TPGN

T-TURN

Positive triangular inserts



Size	Dimension (mm)		
	d	t	r
11	6.35	3.18	0.2-0.8
16	9.52	3.18	0.4-1.2
22	12.7	4.76	0.4-1.2

Insert	Designation		Ceramic											
			AB2010	AB20	AB30	AW120	AS500	SC10	AS10	TC430	AS20			
	**TPGN**	**110302**		●	●									
		110304	●	●	●									
		110308	●	●	●									
		160304	●	●	●									
		160308	●	●	●				●					
		160308 T6								●				
		160312		●	●									
		220404		●										
		220408			●									
		220412		●	●									



A55, A166, A227, A228

● : Standard items

TaeguTec Member IMC Group

Edge preparation for CBN inserts

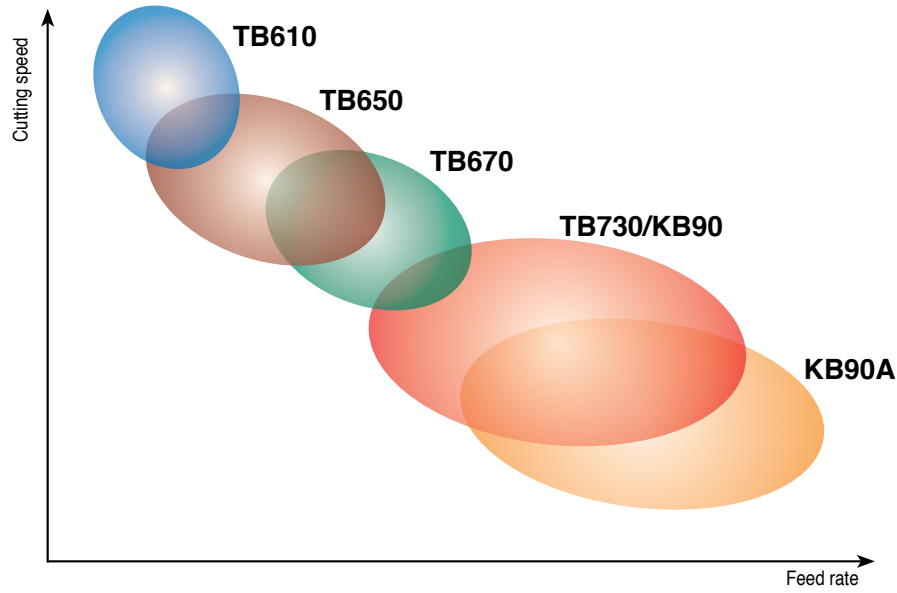
Common style (no designation)

Grade	Land specification		
	Width (mm)	Angle (°)	Honing (mm)
TB610, TB650, TB670	0.13	20	0.015
TB730, KB90	0.13	20	-
KB90A	0.2	20	0.015

Technical information for CBN inserts

CNMA 120408 **LN** : Regular size CBN tip
CNMA 120408 **LS** : Small size CBN tip
CNMA 120408 **LS2** : Small size CBN tip with two corners
RCGX 090300 **FT** : Full top CBN
CNMN 090308 **SD** : Solid CBN
CNGA 120408 **WZ-LS2**: Wiper geometry

Application map of CBN grades



PCD Inserts

KP500, KP300, KP100

Physical properties

Grade	Feature	PCD(㎛)	TRS (GPa)
KP100	Hardness (High PCD) ↑ / Toughness (High Co) ↓	2	1.5-1.6
KP300		10	1.3-1.4
TD810		2, 30	1.2-1.3
KP500		25	1.0-1.2

KP500

- Super abrasion resistant grade
- Designed for fine finishing cuts with little or no interruptions
- For high Si aluminum alloy(Si >12.2%), metal matrix composite and sintered tungsten carbide

TD810

- Highly densified grade with mixed coarse and fine grains
- Combination of wear resistance and toughness
- For MMC, high Si-Al alloys, high strength cast irons, bi-metal applications, etc

KP300

- This KP300 is for general machining
- Well combined wear resistance and toughness
- For low to medium Si aluminum alloy (Si ≤ 12.2%), copper alloy and non-ferrous metal

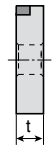
KP100

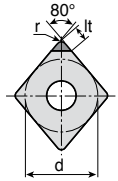
- Low content poly-crystalline diamond with fine grain
- High edge strength and good surface finish
- For plastic, wood and pure aluminum



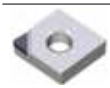
CNGA CNMA CNMN

Negative 80° rhombic inserts





Size	Dimension (mm)		
	d	t	r
09	9.52	3.18	0.8-1.6
12	12.7	4.76	0.4-1.6

Insert	Designation		lt (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
	**CNGA**	**120404 WZ-LS**	2.1		●								
		120404 WZ-LS2	2.1	●	●	●							
		120404 WZ-LS4	2.1			●							
		120408 WZ-LS	2.1		●			●					
		120408 WZ-LS2	2.1	●	●	●	●						
		120408 WZ-LS4	2.1	●		●							
		120412 WZ-LS	2.5		●			●					
		120412 WZ-LS2	2.5		●	●	●	●					
		120412 WZ-LS4	2.5			●							
	**CNMA**	**120404 LN**	4.2	●	●	●		●					
		120404 LS	2.2		●			●					
		120404 LS2	2.2	●	●	●	●	●					
		120404 LS4	2.2		●	●							
		120408 LN	4.0	●	●	●	●	●					
		120408 LS	2.1		●			●					
		120408 LS2	2.1	●	●	●	●	●					
		120408 LS4	2.1	●	●	●	●	●					
		120412 LN	3.9	●	●	●		●					
		120412 LS	2.5		●			●					
		120412 LS2	2.5		●	●	●	●					
		120412 LS4	2.5			●	●						
	**CNMN**	**090308 SD**	-						●				
		090312 SD	-						●				
		090316 SD	-						●				
		120416 SD	-						●				
 	**CNMA**	**120404 LN-10**	4.0								●	●	
		120408 LN-10	3.9								●	●	
		120412 LN-10	3.8									●	



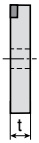
A74, A75, A102, A103, A115, A133, A148, A176, A204, A216, A234

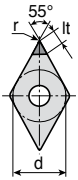
● : Standard items

TaeguTec
Member IMC Group

DNMA

Negative 55° rhombic inserts





Size	Dimension (mm)		
	d	t	r
15	12.7	4.76-6.35	0.4-1.2

Insert	Designation		lt (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
	**DNMA**	**150404 LN**	4.2	●	●	●							
		150404 LS	2.6		●			●					
		150404 LS2	2.6	●	●	●	●						
		150404 LS4	2.6	●	●	●							
		150408 LN	3.9	●	●	●		●					
		150408 LS	2.3		●			●					
		150408 LS2	2.3	●	●	●	●						
		150408 LS4	2.3			●							
		150412 LN	3.5		●	●		●					
		150412 LS2	2.2			●	●						
		150412 LS4	2.2			●							
		150604 LN	4.2	●	●	●	●	●					
		150604 LS	2.6		●								
		150604 LS2	2.6	●	●	●	●						
		150608 LN	3.9	●	●	●	●	●					
		150608 LS2	2.3	●	●	●	●	●					
		150608 LS4	2.3			●							
		150612 LN	3.4					●					
		150612 LS2	2.2			●							
 	**DNMA**	**150404 LN-10**	4.0								●	●	
		150408 LN-10	3.7								●	●	
		150412 LN-10	3.47									●	
		150604 LN-10	4.0								●	●	
		150608 LN-10	3.7								●	●	



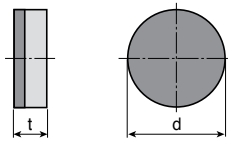
A68, A69, A76,
A104, A134, A148,
A177, A205, A216

● : Standard items

TaeguTec

RNMN

Negative round inserts



Size	Dimension (mm)	
	d	t
09	9.52	3.18
12	12.7	3.18-4.76

Insert	Designation		It (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
	**RNMN**	**090300 FT**	-		●	●		●					
		120300 FT	-					●					
		120400 FT	-					●					
	**RNMN**	**090300 SD**	-						●				
		120300 SD	-						●				
		120400 SD	-						●				

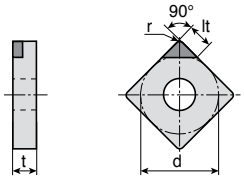


● : Standard items

TaeguTec
Member IMC Group

SNMA SNMN

Negative square inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	3.18	0.8-1.6
12	12.7	3.18-4.76	0.4-1.6

Insert	Designation		lt (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
	**SNMA**	**120404 LN**	4.2		●	●							
		120404 LS	2.5		●			●					
		120404 LS2	2.5			●	●						
		120404 LS4	2.5			●							
		120408 LN	4.2	●	●	●	●	●					
		120408 LS	2.5		●			●					
		120408 LS2	2.5	●		●	●	●					
		120408 LS4	2.5			●							
		120408 LS8	2.5			●							
		120412 LS	2.7		●								
	**SNMN**	**090308 SD**	-						●				
		090312 SD	-						●				
		090316 SD	-						●				
		120312 SD	-						●				
		120316 SD	-						●				
 	**SNMA**	**120408 LN-10**	4.0									●	
		120412 LN-10	4.0									●	



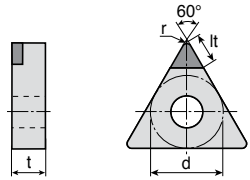
A80, A81, A107, A108,
A119, A120, A149,
A178, A208, A235

● : Standard items

TaeguTec

TNMA

Negative triangular inserts



Size	Dimension (mm)		
	d	t	r
16	9.52	4.76	0.4-1.6
22	12.7	4.76	0.4-0.8

Insert	Designation		lt (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
	**TNMA**	**160404 LN**	4.3		●	●		●					
		160404 LS	2.2		●			●					
		160404 LS3	2.2	●		●	●	●					
		160404 LS6	2.2		●	●							
		160408 LN	4		●	●		●					
		160408 LS	2.1		●			●					
		160408 LS3	2.1	●	●	●	●	●					
		160408 LS6	2.1			●							
		160412 LN	3.4					●					
		160412 LS	2.5		●								
		160412 LS3	2.5			●	●						
		160416 LN	3.1		●								
		160416 LS	2.4		●			●					
		220404 LN	4.1		●								
		220408 LS	2.6		●								
 	**TNMA**	**160404 LN-10**	4.3								●	●	
		160408 LN-10	4.0									●	



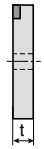
A70, A82, A83, A109, A113, A114, A150, A179, A217, A236, A237

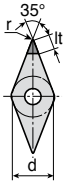
● : Standard items

TaeguTec

VNGA

Negative 35° rhombic inserts





Size	Dimension (mm)		
	d	t	r
16	9.52	4.76	0.4-1.2

Insert	Designation		lt (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
	**VNGA**	**160404 LN**	5.0		●	●							
		160404 LS	3.2		●			●					
		160404 LS2	3.2	●		●	●						
		160408 LN	4.1		●	●		●					
		160408 LS	2.4		●			●					
		160408 LS2	2.4	●	●	●	●						
		160408 LS4	2.4			●		●					
 	**VNGA**	**160404 LN-10**	5.0								●	●	
		160408 LN-10	4.1								●	●	
		160412 LN-10	3.7									●	



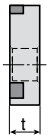
A71, A72, A96, A110, A111

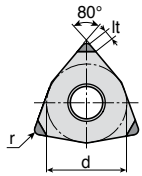
● : Standard items

TaeguTec

WNGA WNMA

Negative 80° trigon inserts





Size	Dimension (mm)		
	d	t	r
06	9.52	4.76	0.8
08	12.7	4.76	0.8-1.2

Insert	Designation		lt (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
	**WNGA**	**060408 WZ-LS6**	2.1			●							
		080408 WZ-LS3	2.1	●	●	●							
		080408 WZ-LS6	2.1			●							
		080412 WZ-LS3	2.1			●							
	**WNMA**	**080408 LS3**	2.1			●							
		080408 LS6	2.1			●							



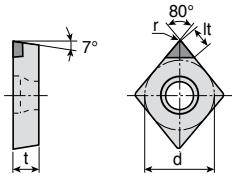
A73, A112, A137, A151, A175, A211, A212

● : Standard items

TaeguTec

CCGW CCGT

Positive 80° rhombic inserts



Size	Dimension (mm)		
	d	t	r
06	6.35	2.38	0.2-0.8
09	9.52	3.97	0.2-0.8
12	12.7	4.76	0.4-0.8

Insert	Designation		lt (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
	**CCGW**	**060202 LS**	2.4		●			●					
		060202 LS2	2.2			●	●						
		060204 LS	2.4		●			●					
		060204 LS2	2.1	●		●	●						
		060208 LS2	2.1	●		●	●						
		09T304 LS	2.4		●			●					
		09T304 LS2	2.4	●	●	●	●	●					
		09T304 WZ-LS	2.8		●								
		09T304 WZ-LS2	2.4	●	●	●	●						
		09T308 LS	2.3		●			●					
		09T308 LS2	2.3	●		●	●						
		09T308 WZ-LS	2.3		●			●					
		09T308 WZ-LS2	2.3		●	●	●						
		120404 LS	2.6					●					
		120404 LS2	2.1				●						
		120408 LS	2.5					●					
		120408 LS2	2.1				●						
	**CCGT**	**060204 CB**	3.1									●	
		09T302 CB	4.15									●	
		09T304 CB	4.1									●	
		09T308 CB	4.0									●	
		120404 CB	4.1									●	
		120408 CB	4.0									●	
 PCD chip breaker													
 	**CCGW**	**060202 LN-7**	3.1								●	●	
		060204 LN-7	3.1								●	●	
		060208 LN-7	3.0								●		
		09T304 LN-7	4.0								●	●	
		09T308 LN-7	3.9								●	●	
		120404 LN-7	4.0								●	●	
		120408 LN-7	3.9								●	●	

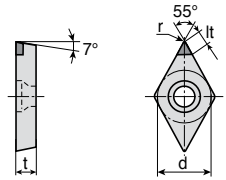


A47, A84, A85,
A138, A152, A180,
A181, A218

● : Standard items

DCGW DCGT

Positive 55° rhombic inserts



Size	Dimension (mm)		
	d	t	r
07	6.35	2.38	0.2-0.8
11	9.52	3.97	0.2-0.8

Insert	Designation		lt (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
	**DCGW**	**070202 LS**	2.6		●			●					
		070202 LS2	2.6	●		●	●						
		070204 LS	2.4		●			●					
		070204 LS2	2.4	●		●	●						
		070208 LS	2.1					●					
		070208 LS2	2.6				●						
		11T304 LS	2.6		●			●					
		11T304 LS2	3.4	●		●	●						
		11T308 LS	2.2		●			●					
		11T308 LS2	2.2	●		●	●						
  PCD chip breaker	**DCGT**	**070202 CB**	3.4									●	
		070204 CB	3.3									●	
		11T302 CB	4.9									●	
		11T304 CB	4.7									●	
		11T308 CB	4.4									●	
 	**DCGW**	**070202 LN-7**	3.4								●	●	
		070204 LN-7	3.3								●	●	
		11T302 LN-7	3.9								●	●	
		11T304 LN-7	3.7								●	●	
		11T308 LN-7	3.3								●	●	



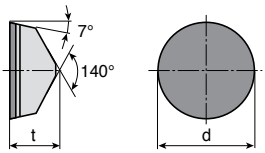
A48, A49, A86, A88, A139, A152, A185, A186, A187, A218, A219

● : Standard items

TaeguTec

RCGX

Positive round inserts



Size	Dimension (mm)		
	d	t	
06	6.35	3.18	
09	9.52	3.18	
12	12.7	4.76	

Insert	Designation		It (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
	**RCGX**	**060300 FT**	-					●					
		090300 FT	-					●					
		120400 FT	-				●	●					

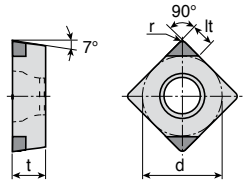
A122, A123

● : Standard items

TaeguTec

SCGW SPGN

Positive square inserts



Size	Dimension (mm)		
	d	t	r
09	9.52	3.18-3.97	0.4-0.8
12	12.7	3.18	0.8

Insert	Designation		lt (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
	**SCGW**	**09T304 LS2**	2.7				●						
		09T308 LS2	2.7				●						
 	**SPGN**	**090308 LN-7**	3.9									●	
		120308 LN-7	3.9									●	



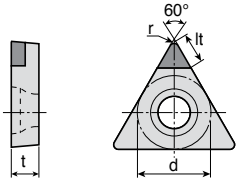
A54, A91, A165, A188, A226, A238

● : Standard items

TaeguTec
Member IMC Group

TCGW TPGN TPGW

Positive triangular inserts



Size	Dimension (mm)		
	d	t	r
08	4.76	2.38	0.4
09	5.56	2.38	0.4-0.8
11	6.35	2.38-3.18	0.2-0.8
16	9.52	3.18-4.76	0.4-0.8
22	12.7	4.76	0.8

Insert	Designation		lt (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
	**TCGW**	**090204 LS3**	2.3	●		●	●						
		090208 LS3	2.1			●							
		110204 LS	2.3		●			●					
		110204 LS3	2.3	●		●	●						
		110208 LS	2.1		●			●					
		110208 LS3	2.1		●	●	●						
		16T304 LS	2.8		●			●					
		16T304 LS3	2.8	●		●	●						
		16T308 LS	2.5		●			●					
		16T308 LS3	2.5	●		●	●	●					
	**TPGN**	**090204 LS3**	2.3	●									
		110302 LS3	2.8				●						
		110304 LS	2.6		●			●					
		110304 LS3	2.6	●		●	●						
		110308 LS	2.3		●			●					
		110308 LS3	2.3	●		●	●						
		160304 LS	2.8		●			●					
		160304 LS3	2.8	●		●	●						
		160308 LS	2.5		●			●					
		160308 LS3	2.5	●		●	●						
		220408 LS	2.6		●			●					
	**TPGW**	**080204 LS3**	2.1			●							
		090204 LS3	2.3			●	●						
		090208 LS3	2			●							
		110302 LS3	2.8	●			●						
		110304 LS	2.6		●	●							
		110304 LS3	2.6	●			●						
		110308 LS3	2.3	●		●	●						
		160404 LS3	2.8			●							
		160408 LS3	2.5			●							

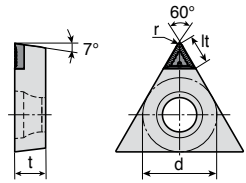


A55, A56, A92, A93, A94, A140, A153, A166, A189, A191, A192, A227, A228, A239, A240

● : Standard items

TCGT TCGW TPGN

Positive triangular inserts



Size	Dimension (mm)		
	d	t	r
09	5.56	2.38	0.4-0.8
11	6.35	2.38-3.18	0.4-0.8
16	9.52	3.18-3.97	0.2-0.8

Insert	Designation		lt (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
 PCD chip breaker	**TCGT**	**090204 CB**	2.8									●	
		110204 CB	3.8									●	
		16T304 CB	3.9									●	
		16T308 CB	3.6									●	
	**TCGW**	**090204 LN-7**	3.3								●	●	
		090208 LN-7	3.0								●	●	
		110204 LN-7	3.8								●	●	
		110208 LN-7	3.5									●	
		16T304 LN-7	3.8								●	●	
		16T308 LN-7	3.5								●	●	
	**TPGN**	**110302 LN-7**	3.9									●	
		110304 LN-7	3.8									●	
		110308 LN-7	3.5									●	
		160302 LN-7	4.4									●	
		160304 LN-7	4.3									●	
		160308 LN-7	4.0									●	



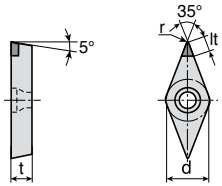
A55, A92, A93, A140, A153, A166, A189, A227, A228, A239, A240

● : Standard items

TaeguTec

VBGW VCGT VCGW

Positive 35° rhombic inserts



Size	Dimension (mm)		
	d	t	r
11	6.35	3.18	0.2-0.8
16	9.52	4.76	0.2-1.2
22	12.7	5.56	3

Insert	Designation		lt (mm)	CBN						PCD			
				TB610	TB650	TB670	TB730	KB90	KB90A	KP500	TD810	KP300	KP100
	**VBGW**	**110304 LS2**	3.2			●							
		110308 LS2	2.4			●							
		160402 LS2	3.6			●							
		160404 LS	3.2		●			●					
		160404 LS2	3.2	●		●	●						
		160408 LS	2.3		●			●					
		160408 LS2	2.3	●		●	●						
	**VBGW**	**160402 LN-7**	5.2								●	●	
		160404 LN-7	5.0								●	●	
		160408 LN-7	4.2								●	●	
  PCD chip breaker	**VCGT**	**110302 CB**	4.7									●	
		110304 CB	5.0									●	
		160404 CB	7.3									●	
		160408 CB	6.4									●	
		160412 CB	6.2									●	
		220530 CB	6.4									●	
	**VCGW**	**110304 LN-7**	5.0								●		
		110308 LN-7	4.1								●		
		160404 LN-7	5.0								●	●	
		160408 LN-7	4.1								●	●	



A50, A95, A96, A98, A100, A101, A136, A140, A141, A154, A196, A198, A200, A201, A219

● : Standard items

Recommended Cutting Conditions

Machining data for turning grades

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1
		>=0.25%C	Annealed	650	190	2
		<0.55%C	Quenched and tempered	850	250	3
		>=0.55%C	Annealed	750	220	4
			Quenched and tempered	1000	300	5
	Low alloy steel and cast steel (less than 5% of alloying elements)		Annealed	600	200	6
			Quenched and tempered	930	275	7
				1000	300	8
				1200	350	9
	High alloy steel, cast steel and tool steel		Annealed	680	200	10
			Quenched and tempered	1100	325	11
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12
			Martensitic	820	240	13
			Austenitic	600	180	14
K	Gray cast iron (GG)		Ferritic		160	15
			Pearlitic		250	16
	Cast iron nodular (GGG)		Ferritic		180	17
			Pearlitic		260	18
	Malleable cast iron		Ferritic		130	19
			Pearlitic		230	20
N	Aluminum - wrought alloy		Not cureable		60	21
			Cured		100	22
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23
			Cured		90	24
		>12% Si	High temp.		130	25
	Copper alloys	>1% Pb	Free cutting		110	26
			Brass		90	27
			Electrolitic copper		100	28
	Non-metallic		Duroplastics, fiber plastics			29
			Hard rubber			30
S	High temp. alloys	Fe based	Annealed		200	31
			Cured		280	32
		Ni or Co based	Annealed		250	33
			Cured		350	34
			Cast		320	35
	Titanium, Ti alloys			Rm 400		36
			Alpha+beta alloys cured	Rm 1050		37
H	Hardened steel		Hardened		55HRC	38
			Hardened		60HRC	39
	Chilled cast iron		Cast		400	40
	Cast iron nodular		Hardened		55HRC	41

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

Machining data for turning grades

Cutting speed Vc(m/min)							
Coated							
TT7005	TT7015	TT8105	TT8115	TT8125	TT8135	TT9215	TT9225
		310-580	280-530	230-480	190-400		
		270-530	240-480	200-420	170-360		
		230-490	200-440	160-380	130-320		
		250-500	220-450	190-400	160-340		
		210-470	180-420	150-350	120-300		
		230-550	200-500	170-400	130-280		
		180-330	150-280	140-250	80-170		
		160-300	130-250	120-230	70-150		
		150-280	120-230	110-200	60-140		
		210-420	190-380	140-280	100-220		
		100-200	90-180	70-130	45-100		
						160-250	120-200
						150-230	110-180
						130-220	100-170
160-400	150-350						
140-350	130-300						
300-550	290-450						
300-430	250-360						
200-460	250-390						
180-350	200-320						
						40-80	30-70
						30-70	20-60
						35-70	25-60
						30-70	20-60
						30-70	20-60

Recommended Cutting Conditions

Machining data for turning grades

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1
		>=0.25%C	Annealed	650	190	2
		<0.55%C	Quenched and tempered	850	250	3
		>=0.55%C	Annealed	750	220	4
			Quenched and tempered	1000	300	5
	Low alloy steel and cast steel (less than 5% of alloying elements)		Annealed	600	200	6
			Quenched and tempered	930	275	7
				1000	300	8
				1200	350	9
	High alloy steel, cast steel and tool steel		Annealed	680	200	10
			Quenched and tempered	1100	325	11
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12
			Martensitic	820	240	13
			Austenitic	600	180	14
K	Gray cast iron (GG)		Ferritic		160	15
			Pearlitic		250	16
	Cast iron nodular (GGG)		Ferritic		180	17
			Pearlitic		260	18
	Malleable cast iron		Ferritic		130	19
			Pearlitic		230	20
N	Aluminum - wrought alloy		Not cureable		60	21
			Cured		100	22
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23
			Cured		90	24
		>12% Si	High temp.		130	25
	Copper alloys	>1% Pb	Free cutting		110	26
			Brass		90	27
			Electrolitic copper		100	28
	Non-metallic		Duroplastics, fiber plastics			29
			Hard rubber			30
S	High temp. alloys	Fe based	Annealed		200	31
			Cured		280	32
		Ni or Co based	Annealed		250	33
			Cured		350	34
			Cast		320	35
	Titanium, Ti alloys			Rm 400		36
			Alpha+beta alloys cured	Rm 1050		37
H	Hardened steel		Hardened		55HRC	38
			Hardened		60HRC	39
	Chilled cast iron		Cast		400	40
	Cast iron nodular		Hardened		55HRC	41

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

Machining data for turning grades

Cutting speed Vc(m/min)						
Coated						
TT9235	TT5100	TT7100	TT5080	TT9080	TT9020	TT8020
	200-450	170-380			150-350	100-300
	170-390	150-340			150-320	100-270
	130-350	110-300			130-250	80-200
	160-370	140-320			140-260	90-210
	120-320	100-280			130-230	80-180
	140-370	110-260			130-250	80-200
	110-220	60-150			50-130	40-120
	90-200	50-120			40-100	40-90
	80-170	40-120			30-100	30-90
	110-250	80-200			60-180	60-160
	40-100	40-90			40-80	40-80
110-170			160-390	120-290	120-270	100-250
100-150			160-280	120-270	120-250	100-230
90-150			100-250	90-240	90-220	80-200
30-60			50-180	40-160		20-70
20-50			40-160	30-130		10-50
25-50			45-100	35-80		10-40
20-50			35-90	30-70		10-30
20-50			30-80	30-60		10-20
			110-200	90-180		70-150
			50-100	40-80		20-40

Recommended Cutting Conditions

Machining data for turning grades

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1
		>=0.25%C	Annealed	650	190	2
		<0.55%C	Quenched and tempered	850	250	3
		>=0.55%C	Annealed	750	220	4
			Quenched and tempered	1000	300	5
	Low alloy steel and cast steel (less than 5% of alloying elements)		Annealed	600	200	6
			Quenched and tempered	930	275	7
				1000	300	8
				1200	350	9
	High alloy steel, cast steel and tool steel		Annealed	680	200	10
			Quenched and tempered	1100	325	11
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12
			Martensitic	820	240	13
			Austenitic	600	180	14
K	Gray cast iron (GG)		Ferritic		160	15
			Pearlitic		250	16
	Cast iron nodular (GGG)		Ferritic		180	17
			Pearlitic		260	18
	Malleable cast iron		Ferritic		130	19
			Pearlitic		230	20
N	Aluminum - wrought alloy		Not cureable		60	21
			Cured		100	22
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23
			Cured		90	24
		>12% Si	High temp.		130	25
	Copper alloys	>1% Pb	Free cutting		110	26
			Brass		90	27
			Electrolitic copper		100	28
	Non-metallic		Duroplastics, fiber plastics			29
			Hard rubber			30
S	High temp. alloys	Fe based	Annealed		200	31
			Cured		280	32
		Ni or Co based	Annealed		250	33
			Cured		350	34
			Cast		320	35
	Titanium, Ti alloys			Rm 400		36
			Alpha+beta alloys cured	Rm 1050		37
H	Hardened steel		Hardened		55HRC	38
			Hardened		60HRC	39
	Chilled cast iron		Cast		400	40
	Cast iron nodular		Hardened		55HRC	41

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

Machining data for turning grades

Cutting speed Vc(m/min)						
Cermet		Uncoated	Ceramic			
PV3010	CT3000	K10	AW120	AB2010	AB20	AB30
350-650	300-570					
270-520	250-500					
240-480	220-460					
260-500	240-470					
240-460	220-440					
240-540	220-520					
190-330	170-300					
170-300	150-270					
140-270	130-250					
260-405	250-395					
140-205	130-195					
200-300	180-270					
200-270	170-250					
170-260	150-240					
230-330	220-320	110-180	600-1200			600-1200
215-290	205-280	95-140	500-900			500-900
170-265	160-255	95-135				450-610
180-240	170-230	90-125				350-510
145-220	135-200	110-140	600-800			600-800
105-150	95-140	90-125	500-700			500-700
		200-1000				
		200-1000				
		50-400				
		50-500				
		40-350				
		50-500				
		50-500				
		30-300				
		50-300				
		50-150				
		55-85				
		40-65				
		32-55				
		21-40				
		16-26				
		50-75				
		45-70				
				95-145	90-140	50-100
						60-120
						50-100

Recommended Cutting Conditions

Machining data for turning grades

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1
		>=0.25%C	Annealed	650	190	2
		<0.55%C	Quenched and tempered	850	250	3
		>=0.55%C	Annealed	750	220	4
			Quenched and tempered	1000	300	5
	Low alloy steel and cast steel (less than 5% of alloying elements)		Annealed	600	200	6
			Quenched and tempered	930	275	7
				1000	300	8
				1200	350	9
	High alloy steel, cast steel and tool steel		Annealed	680	200	10
			Quenched and tempered	1100	325	11
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12
			Martensitic	820	240	13
			Austenitic	600	180	14
K	Gray cast iron (GG)		Ferritic		160	15
			Pearlitic		250	16
	Cast iron nodular (GGG)		Ferritic		180	17
			Pearlitic		260	18
	Malleable cast iron		Ferritic		130	19
			Pearlitic		230	20
N	Aluminum - wrought alloy		Not cureable		60	21
			Cured		100	22
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23
			Cured		90	24
		>12% Si	High temp.		130	25
	Copper alloys	>1% Pb	Free cutting		110	26
			Brass		90	27
			Electrolitic copper		100	28
	Non-metallic		Duroplastics, fiber plastics			29
			Hard rubber			30
S	High temp. alloys	Fe based	Annealed		200	31
			Cured		280	32
		Ni or Co based	Annealed		250	33
			Cured		350	34
			Cast		320	35
	Titanium, Ti alloys			Rm 400		36
			Alpha+beta alloys cured	Rm 1050		37
H	Hardened steel		Hardened		55HRC	38
			Hardened		60HRC	39
	Chilled cast iron		Cast		400	40
	Cast iron nodular		Hardened		55HRC	41

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

Machining data for turning grades

Cutting speed Vc(m/min)						
Ceramic					PCD	
TC430	AS500	SC10	AS10	AS20	TD810	KP300
	600-1000	500-900	500-900			
	550-900	450-800	450-800			
	400-650	345-580	345-580			
	300-550	250-480	250-480			
	550-800	500-740	500-740			
	450-750	400-640	400-640			
					250-2500	250-2500
					250-2500	250-2500
					500-1500	400-140
					95-960	95-900
					300-1000	200-800
					65-630	65-630
					65-630	65-630
					38-375	38-375
					100-1000	100-1000
					100-500	100-500
270-400				200-330		
230-330				130-240		
210-300				150-215		

Recommended Cutting Conditions

Machining data for turning grades

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1
		>=0.25%C	Annealed	650	190	2
		<0.55%C	Quenched and tempered	850	250	3
		>=0.55%C	Annealed	750	220	4
			Quenched and tempered	1000	300	5
	Low alloy steel and cast steel (less than 5% of alloying elements)		Annealed	600	200	6
			Quenched and tempered	930	275	7
				1000	300	8
				1200	350	9
	High alloy steel, cast steel and tool steel		Annealed	680	200	10
			Quenched and tempered	1100	325	11
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12
			Martensitic	820	240	13
			Austenitic	600	180	14
K	Gray cast iron (GG)		Ferritic		160	15
			Pearlitic		250	16
	Cast iron nodular (GGG)		Ferritic		180	17
			Pearlitic		260	18
	Malleable cast iron		Ferritic		130	19
			Pearlitic		230	20
N	Aluminum - wrought alloy		Not cureable		60	21
			Cured		100	22
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23
			Cured		90	24
		>12% Si	High temp.		130	25
	Copper alloys	>1% Pb	Free cutting		110	26
			Brass		90	27
			Electrolitic copper		100	28
	Non-metallic		Duroplastics, fiber plastics			29
			Hard rubber			30
S	High temp. alloys	Fe based	Annealed		200	31
			Cured		280	32
		Ni or Co based	Annealed		250	33
			Cured		350	34
			Cast		320	35
	Titanium, Ti alloys			Rm 400		36
			Alpha+beta alloys cured	Rm 1050		37
H	Hardened steel		Hardened		55HRC	38
			Hardened		60HRC	39
	Chilled cast iron		Cast		400	40
	Cast iron nodular		Hardened		55HRC	41

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

Machining data for turning grades

Cutting speed Vc(m/min)						
CBN						
TB610	TB650	TB670	TB730	KB90A		
			1200-1700	1200-1700		
			1050-1450	1050-1450		
	500-700	450-610				
	400-600	350-510				
110-220	90-180	90-160	80-130			
100-200	80-160	80-150	60-120			
		120-180	120-180	120-180		
			100-140	100-140		

PARTING & GROOVING



PARTING & GROOVING

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TaeguTec Member IMC Group

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Tool Selection Guide

Parting and grooving holder

Series				T-CLAMP ULTRA PLUS			
				TGB	TGB-MS	TGBR/L TGBR/L-D..R/L TGBR/L-TI-D..R/L	TGBFR/L
							
Pages				B20	B21	B22	B25
Application	External	Parting		●	●	●	
		Grooving		●	●	●	
		Turning					
	Facing	Grooving					●
		Turning					
	Internal	Grooving					
		Turning					
	Profiling						
	Threading						
	Undercut						

Tool Selection Guide

Parting and grooving holder

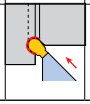
T-CLAMP ULTRA PLUS			QUAD-RUSH	T-CLAMP ULTRA PLUS	
TGER/L	**TCER/L**	**TCFR/L**	**TQCR/L**	**C-ADAPTER**	**TTER/L-SH**
					
B26	B29	B30	B31	B34	B37
●	●		●	●	●
●	●		●	●	●
	●		○	●	●
		●		●	
		●		●	
	●		○	●	●
	●		○	●	●
				●	

● Recommended, ○ Suitable

TaeguTec Member IMC Group

Tool Selection Guide

Parting and grooving holder

Series				T-CLAMP ULTRA PLUS			
				T-BURST HIGH PRESSURE TTER/L-3SH-TB	TTER/L-D	TTER/L	T-BURST HIGH PRESSURE TTER/L-TB
							
Pages				B38	B39	B41	B43
Application	External	Parting		●	●	●	●
		Grooving		●	●	●	●
		Turning		●	●	●	●
	Facing	Grooving					
		Turning					
	Internal	Grooving					
		Turning					
	Profiling			●	●	●	●
	Threading			●	●	●	●
	Undercut						

Tool Selection Guide

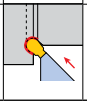
Parting and grooving holder

T-CLAMP ULTRA PLUS					
TTSER/L	**TGSFR/L**	**TGFR/L**	**TTFR/L**	**TTFR/L-RN**	**TGFPR/L**
					
B44	B45	B46	B47	B48	B50
○					
●	●	●			●
●	●	○			○
	○	●	●	●	●
	○	●	●	●	●
○					
○					

● Recommended, ○ Suitable

Tool Selection Guide

Parting and grooving holder

Series				T-CLAMP ULTRA PLUS			
				TTFPR/L	TGIFR/L	TTFIR/L	TTIR/L
							
Pages				B51	B52	B53	B54
Application	External	Parting					
		Grooving					
		Turning					
	Facing	Grooving		●	●	●	
		Turning		●	●	●	
	Internal	Grooving					●
		Turning					●
	Profiling						
	Threading						
	Undercut						

Tool Selection Guide

Parting and grooving holder

T-CLAMP ULTRA PLUS

TTSIR/L	TGSIR/L	TGEUR/L	TGIUR/L	TTER/L-15A	TGIUR/L-15A
					
B56	B57	B58	B59	B60	B61
				●	●
●	●				
●	●		○		
				●	●
		●	●		

● Recommended, ○ Suitable

TaeguTec Member IMC Group

Tool Selection Guide

Parting and grooving holder

Series				T-GROOVE	TOPCUT	QUAD-RUSH		
				TTLEN	TTVER/L TTVBR/L	TQBR	TQHR/L TQHPR/L	T-BURST HIGH PRESSURE TQHR/L-TB
								
Pages				B62	B63	B65	B66, B68	B67
Application	External	Parting			●	●	●	●
		Grooving		●	●	●	●	●
		Turning			●	○	○	○
	Facing	Grooving						
		Turning						
	Internal	Grooving						
		Turning						
	Profiling					○	○	○
	Threading				●	○	○	○
	Undercut							

● Recommended, ○ Suitable

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Tool Selection Guide

Internal application by diameter

Internal diameter (mm)	TOPMICRO	TOPCAP	TTSIR/L	TTIR/L
				
0				
0.6				
1				
2				
3				
4				
5				
6				
7				
8				
9				
10				
11				
12				
12.5				
13				
14				
15				
16				
17				
18				
19				
20				
21				
22				
23				
24				
25				
26				

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Tool Selection Guide

Parting and grooving insert

Series				T-CLAMP ULTRA PLUS			
				TDC	TSC	TDJ	TSJ
							
Pages				B74	B75	B76	B77
Application	External	Parting		●	●	●	●
		Grooving		●	●	●	●
		Turning					
	Facing	Grooving		○	○	○	○
		Turning					
	Internal	Grooving		○	○	○	○
		Turning					
	Profiling						
	Threading						
	Undercut						

Tool Selection Guide

Parting and grooving insert

T-CLAMP ULTRA PLUS					
TDXU	**TDXT**	**TDT**	**TDT - RU**	**TDT**	**TDFT**
					
B78	B78	B79	B81	B82	B83
○	○				○
●	●	●			○
●	●	●	●	●	○
●	●	○			●
●	●	○			●
●	●	○			
●	●	○			
			●	●	
		○			
		○			

● Recommended, ○ Suitable

TaeguTec Member IMC Group

Parting and grooving insert

Series				T-CLAMP ULTRA PLUS			
				TDIT	TDIM	TDIP	TDA
							
Pages				B83	B85	B86	B87
Application	External	Parting		○	○	○	
		Grooving		○	●	●	
		Turning		○	●	●	●
	Facing	Grooving			○	○	
		Turning			○	○	
	Internal	Grooving		●	●	●	
		Turning		●	●	●	
	Profiling						●
	Threading						
	Undercut			○			

Parting and grooving insert

T-CLAMP ULTRA PLUS	T-GROOVE	TOPMICRO	TOPCUT	QUAD•RUSH		
TSA	TGUX	MIN.	TV..	TQJ	TQC	TQS
						
B87	B88	B92	B103	B107	B111	B113
			●	●	●	●
	●		●	●	●	●
●			●	●	●	●
		●				
		●				
●		●		○	○	○
		●	●	●	●	●

● Recommended, ○ Suitable

Grades

Parting and grooving grades

Grades	ISO	Characteristics & applications
TT7505 CVD coated	K01 – K15	• High speed turning & grooving of cast iron • Excellent wear resistent coated grade assures outstanding performance in high speed continue machining of cast iron
TT6080 PVD coated	K05 – K25 H05 – H25	• General machining for gray and ductile cast iron • Finish and medium machining of hardened steel
TT8125 CVD coated	P15 – P30	• For a wide range of turning and grooving • Very good combination of wear resistance and toughness • For general use on steels
TT5100 CVD coated	P20 – P35 M20 – M35	• Medium turning of low carbon steel and alloy steel • Medium & low speed machining of stainless steel
TT9080 PVD coated	P20 – P40 M20 – M40 S20 – S40	• General machining of steel • General machining of stainless steel • General machining of heat-resistant alloy
TT7220 PVD coated	P25 – P45 M25 – M45	• Parting, grooving and turn grooving of steel • Parting, grooving and turn grooving of stainless steel
TT8020 PVD coated	P30 – P50 M30 – M50 S30 – S50	• Interrupted and rough machining of steel • Interrupted and rough machining of stainless steel • Low speed and interrupted machining of heat-resistant alloy
PV3030 PVD coated cermet	P05 – P20 M05 – M20 K05 – K20	• High speed finish machining of carbon steel, alloy steel, mild steel, mold steel and free-cutting steel • High speed finish and medium machining of austenite and maltensite stainless steel • High speed finish & medium machining of gray cast iron, nodular and ductile cast iron
CT3000 Cermet	P10 – P20 M10 – M20 K10 – K20	• Finish machining of carbon steel, alloy steel, mild steel and mold steel. Good surface roughness • Finish machining of stainless steel. Good surface roughness • Finish machining of cast iron
K10 Carbide	K05 – K15 N05 – N15 S05 – S15	• General machining of cast iron • General machining of aluminum alloys and non-ferrous materials • General machining of heat-resistant alloy
AB30 Ceramic	K05 – K15 H05 – H15	• Continuous to light interrupted turning of cast iron without coolant • High speed turning of hardened steel (HRc 40-50)
KP300 PCD	N10 – N20	• General turning and grooving of non-ferrous materials • Excellent combination of wear resistance and toughness

Parting & Grooving Toolholders



Blade Designation System

T	G	B	F	R	32	-	3	S
1	2	3	4	5	6		7	8

1 TaeguTec

2 Application type

G	Grooving
T	Turning

3 Holder type



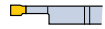
B

Blade type

4 Machining type

F	Face grooving

5 Hand of holder



L

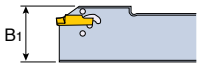
Left-hand



R

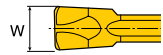
Right-hand

6 Blade height



26 = 26.0 mm
32 = 32.0 mm
45 = 45.0 mm
52 = 52.0 mm

7 Insert size



2 = 2.0 mm
3 = 3.0 mm
4 = 4.0 mm
5 = 5.0 mm
6 = 6.0 mm

8 Special code

S	Single type blade
MS	Blade for multi spindle machine
CL	Screw clamping

Holder Designation System

					6					
T	G	E	U	R	20		-	3		
1	2	3	4	5	25	25	-	3		10
					7	8		9		

1 TaeguTec

2 Application type

G	Grooving
T	Turning

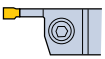
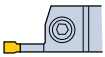
3 Machining type

E	External machining
I	Internal machining
F	Face machining

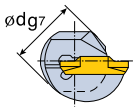
4 Holder shape

U	Undercutting
P	Perpendicular type

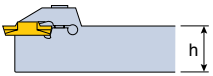
5 Hand of holder

	
L	**R**
Left-hand	Right-hand

6 Shank diameter

	10, 12, 16, 20, 25 32, 40, 50, etc

7 Shank height

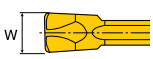
	10, 12, 16, 20, 25 32, 40, etc

8 Shank width



10, 12, 16, 20, 25, 32, 40, etc

9 Insert size



2, 3, 4, 5, 6, 8, 10

10 Special code

C	With coolant hole
T□□	Overhang length
SH	Holder for swiss automatics
RN	Renewed type holder

TaeguTec Member IMC Group

TGB

T-CLAMP ULTRA PLUS

Blades for parting and deep grooving



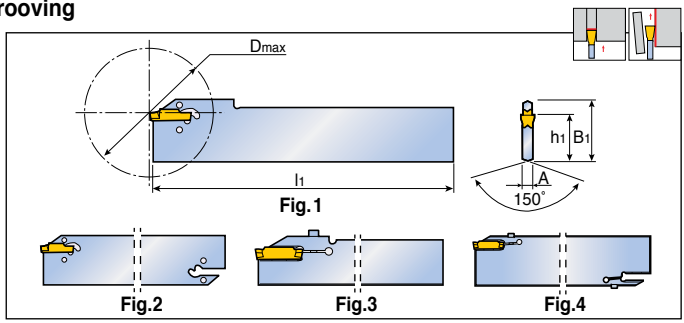


Fig.1

Fig.2

Fig.3

Fig.4

Designation	Insert seat size	Dimension (mm)						Block	Insert
		B1	l1	h1	A	Dmax	Fig.		
TGB 26-1.4S(1)	1	26	150	21.4	1.0(2)	26	1	TTBN/U..-26	TDC / J / T
26-2S(1)	2	26	150	21.4	1.8(2)	40	1	TTBN/U..-26	TDXU / XT
26-3S(1)	3	26	150	21.4	2.4	50	1	TTBN/U..-26	TSC / J
26-4S(1)	4	26	150	21.4	3.2	80	1	TTBN/U..-26	B74-B83
32-1.4	1	32	150	24.9	1.0(2)	26	2	TTBN/U..-32	
32-2	2	32	150	24.9	1.8(2)	50	2	TTBN/U..-32	
32-3	3	32	150	24.9	2.4	100	2	TTBN/U..-32	
32-4	4	32	150	24.9	3.2	100	2	TTBN/U..-32	
32-5	5	32	150	24.9	4.0	120	2	TTBN/U..-32	
32-6	6	32	150	24.9	5.2	120	2	TTBN/U..-32	
45-4	4	45	150	38.1	3.2	120	2	TTBN/U..-45	
32-8S-CL(1)	8	32	150	24.9	6.2	80	3	TTBN/U..-32	
52-8-CL	8	52	250	45.2	6.8	200	4	TTBN/U..-52	

- (1) Single ended blade
- (2) Thickness at DOC area only. Overall thickness is 2.4mm

Spare parts

Designation	Extractor	Screw	Wrench	
				
TGB 26-1.4S / 32-1.4	EDG-23B	-	-	
TGB 26 / 32 / 45	EDG-33B	-	-	
TGB 32-8S-CL	-	SH M4x0.7x20-MO	L-W3	
TGB 52-8-CL	-	SH M4x0.7x20-MO	L-W3	

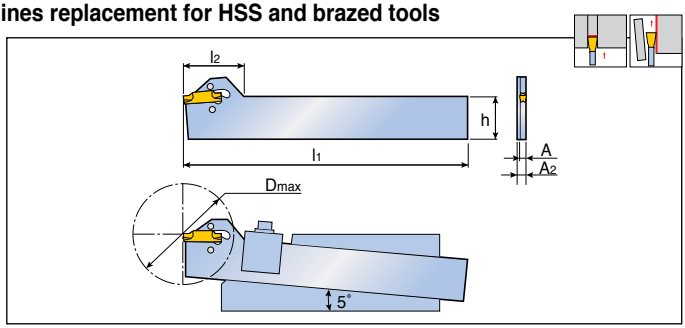
- Extractor should be ordered separately

TGB-MS

T-CLAMP ULTRA PLUS

Blades for multi-spindle machines replacement for HSS and brazed tools





Designation	Insert seat size	Dimension (mm)						Insert
		h	l_1	l_2	A	A_2	D_{max}	
TGB 5-22-2-MS	2	22.2	150	32	1.8	3.2	42	TDC / J / T
5-22-3-MS	3	22.2	150	32	2.4	3.2	60	TDXU / XT
5-22-4-MS	4	22.2	150	32	3.2	3.2	80	TSC / J
								B74-B83

Spare parts

Designation	Extractor			
				
TGB-MS	EDG-33B			

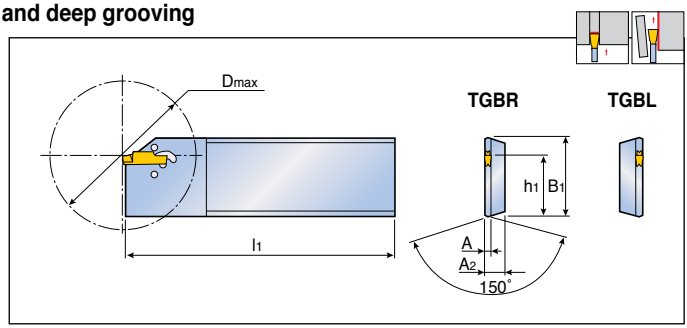
• Extractor should be ordered separately

TGBR/L

T-CLAMP ULTRA PLUS

Reinforced blades for parting and deep grooving





Designation	Insert seat size	Dimension (mm)						Block	Insert
		B_1	l_1	h_1	A	A_2	D_{max}		
TGBR/L 32T24-2	2	32	110	24.9	1.8	8.0	42	TTBN/U..-32	TDC / J / T
32T33-3	3	32	110	24.9	2.4	8.0	60	TTBN/U..-32	TDXU / XT
32T41-4	4	32	110	24.9	3.2	10.0	80	TTBN/U..-32	TSC / J
									B74-B83

Spare parts

Designation	Extractor			
				
TGBR/L	EDG-33B			

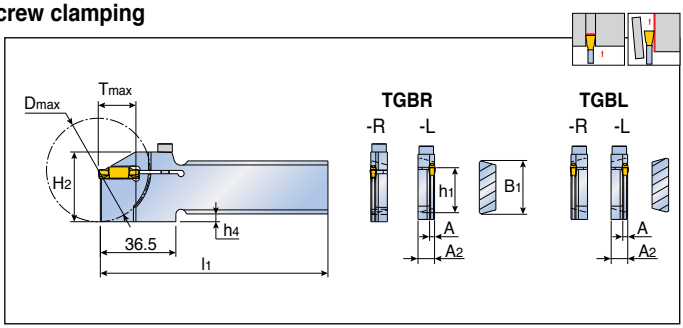
• Extractor should be ordered separately

TGBR/L -D..R/L

T-CLAMP ULTRA PLUS

Reinforced type blades with screw clamping





Designation		Insert seat size	Dimension (mm)									Block	Insert
			B_1	A	A_2	l_1	h_1	H_2	h_4	T_{max}	D_{max}		
TGBR	**26-2-D50R** (1)	2	26	1.8	8	110	21.4	33.7	3.6	18	50	TTBN/U..-26	TDC / J / T
	26-2-D50L (2)	2	26	1.8	8	110	21.4	33.7	3.6	18	50	TTBN/U..-26	TDXU / XT
TGBL	**26-2-D50R** (2)	2	26	1.8	8	110	21.4	33.7	3.6	18	50	TTBN/U..-26	TSC / J
	26-2-D50L (1)	2	26	1.8	8	110	21.4	33.7	3.6	18	50	TTBN/U..-26	B74-B83
TGBR	**26-3-D50R** (1)	3	26	2.4	8	110	21.4	33.7	3.6	18	50	TTBN/U..-26	
	26-3-D50L (2)	3	26	2.4	8	110	21.4	33.7	3.6	18	50	TTBN/U..-26	
TGBL	**26-3-D50R** (2)	3	26	2.4	8	110	21.4	33.7	3.6	18	50	TTBN/U..-26	
	26-3-D50L (1)	3	26	2.4	8	110	21.4	33.7	3.6	18	50	TTBN/U..-26	
TGBR	**32-2-D50R** (3)	2	32	1.8	8	120	24.9	33.7	-	18	50	TTBN/U..-32	
	32-2-D50L (2)	2	32	1.8	8	120	24.9	33.7	-	18	50	TTBN/U..-32	
TGBL	**32-2-D50R** (2)	2	32	1.8	8	120	24.9	33.7	-	18	50	TTBN/U..-32	
	32-2-D50L (3)	2	32	1.8	8	120	24.9	33.7	-	18	50	TTBN/U..-32	
TGBR	**32-3-D50R** (3)	3	32	2.4	8	120	24.9	33.7	-	18	50	TTBN/U..-32	
	32-3-D50L (2)	3	32	2.4	8	120	24.9	33.7	-	18	50	TTBN/U..-32	
TGBL	**32-3-D50R** (2)	3	32	2.4	8	120	24.9	33.7	-	18	50	TTBN/U..-32	
	32-3-D50L (3)	3	32	2.4	8	120	24.9	33.7	-	18	50	TTBN/U..-32	

- (1) for Traub machines, model TNC 30, TNM 28, TNS 26/30/42/112, TNA 300, TNK 260
- (2) for Tornos Bechler, model Emco 2000/20, 2000/26
- (3) for Traub machines, model TNC 42/65, TNM 42/65, TNS 42/60/65, TNA 300/400

Spare parts

Designation	Screw	Wrench		
TGBR/L -DR/L	SH M4x0.7x16	L-W3		

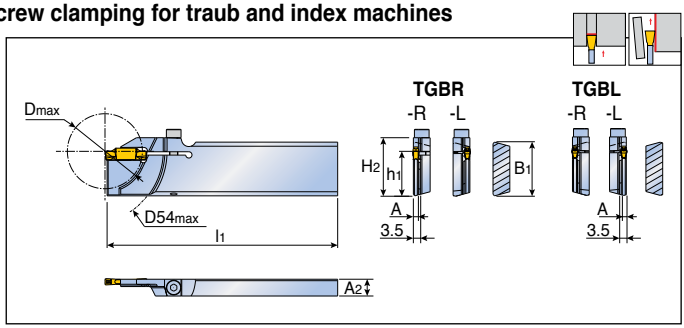
TaeguTec Member IMC Group

TGBR/L -TI-D..R/L

T-CLAMP ULTRA PLUS

Reinforced type blades with screw clamping for traub and index machines





Designation		Insert seat size	Dimension (mm)							Block	Insert
			B_1	A	A_2	l_1	h_1	H_2	D_{max}		
TGBR/L	**26-2TI-D36R**	2	26	1.6	8	110	21.4	27.9	36	TTBN/U..-26	TDC / J / T
	26-2TI-D36L	2	26	1.6	8	110	21.4	27.9	36	TTBN/U..-26	TDXU / XT
	26-3TI-D36R	3	26	2.4	8	110	21.4	27.9	36	TTBN/U..-26	TSC / J
	26-3TI-D36L	3	26	2.4	8	110	21.4	27.9	36	TTBN/U..-26	B74-B83

Spare parts

Designation	Screw	Wrench		
TGBR/L -TI-DR/L	SH M4x0.7x16	L-W3		

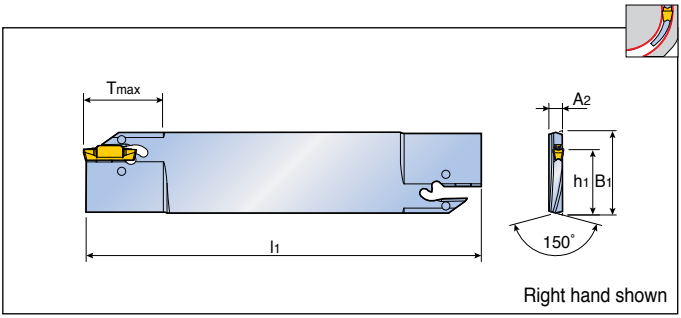
TaeguTec Member IMC Group

TGBFR/L

T-CLAMP ULTRA PLUS

Blades for face grooving





Right hand shown

Designation		Insert seat size	Dimension (mm)							Block	Insert
			B1	l1	h1	A2	Tmax	Dmin	Dmax		
TGBFR/L	**32T20-40-60-3**	3	32	150	24.9	5.2	20	40	60	TTBN/U..-32	TDC / J / T
	32T20-54-80-3	3	32	150	24.9	5.2	20	54	80	TTBN/U..-32	TDXU / XT / FT
	32T25-74-120-3	3	32	150	24.9	5.2	25	74	120	TTBN/U..-32	TSC / J
	32T25-114-180-3	3	32	150	24.9	5.2	25	114	180	TTBN/U..-32	B74-B83
	32T25-40-60-4	4	32	150	24.9	5.2	25	40	60	TTBN/U..-32	
	32T25-50-80-4	4	32	150	24.9	5.2	25	50	80	TTBN/U..-32	
	32T30-70-130-4	4	32	150	24.9	5.2	30	70	130	TTBN/U..-32	
	32T30-120-200-4	4	32	150	24.9	5.2	30	120	200	TTBN/U..-32	
	32T30-200-4	4	32	150	24.9	5.2	30	200	∞	TTBN/U..-32	
	32T32-60-95-5	5	32	150	24.9	5.2	32	60	95	TTBN/U..-32	
	32T35-85-140-5	5	32	150	24.9	5.2	35	85	140	TTBN/U..-32	
	32T35-130-250-5	5	32	150	24.9	5.2	35	130	250	TTBN/U..-32	
	32T35-250-5	5	32	150	24.9	5.2	35	250	∞	TTBN/U..-32	
	32T32-80-180-6	6	32	150	24.9	5.2	32	80	180	TTBN/U..-32	
	32T38-168-300-6	6	32	150	24.9	5.2	38	168	300	TTBN/U..-32	
	32T38-300-6	6	32	150	24.9	5.2	38	300	∞	TTBN/U..-32	

• Please check insert min. dia for face grooving B49 page

Spare parts

Designation	Extractor			
				
TGBFR/L	EDG-33B			

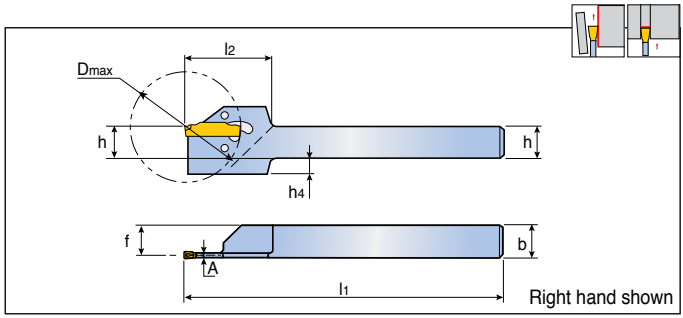
• Extractor should be ordered separately

TaeguTec Member IMC Group

TGER/L

Parting and deep grooving





Designation		Insert seat size	Dimension (mm)							Dmax		Insert
			h	b	l1	f	l2	A	h4	TDJ/C	TSJ/C	
TGER/L	**2020-1.4T10**	1	20	20	125	19.5	31	1.0	-	20	20	TDC / J / T
	1010-2	2	10	10	150	9.1	31	1.8	8	33	33	TDXU / XT
	1212-2	2	12	12	150	11.1	31	1.8	6	35	35	TSC / J
	1616-2	2	16	16	150	15.1	31	1.8	2	35	35	B74-B83
	2012-2	2	20	12	150	11.1	31	1.8	-	35	35	
	2020-2	2	20	20	150	19.1	31	1.8	-	35	35	
	1212-3	3	12	12	150	10.8	31	2.4	6	38	40	
	1616-3	3	16	16	150	14.8	31	2.4	2	38	45	
	2020-3	3	20	20	125	18.8	31	2.4	-	38	45	
	2525-3	3	25	25	150	23.8	31	2.4	-	38	45	
	2020-4	4	20	20	125	18.4	33	3.2	-	38	55	
	2525-4	4	25	25	150	23.4	33	3.2	-	38	55	

Spare parts

Designation	Extractor			
				
TGER/L....-1.4T10	EDG-23B			
TGER/L....-2	EDG-33B			
TGER/L....-3	EDG-33B			
TGER/L....-4	EDG-33B			

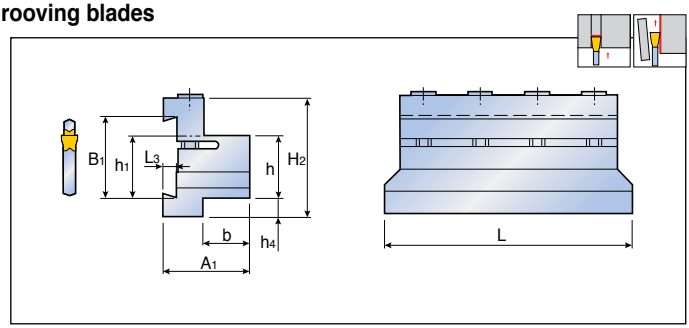
• Extractor should be ordered separately

TTBN

T-CLAMP ULTRA PLUS

Blocks for parting and deep grooving blades





Designation	Dimension (mm)								
	B1	h1	h	h4	H2	L3	L	b	A1
TTBN 16-26	26	21.0	16	12	38	4.0	87	15	29
20-26	26	21.4	20	8	38	4.0	87	19	33
25-26	26	21.4	25	3	38	4.0	110	20	34
20-32	32	24.8	20	13	48	5.5	100	19	35
25-32	32	24.8	25	8	48	5.5	110	20	36
32-32	32	24.8	32	3	48	5.5	120	28	44
25-45	45	38.1	25	25	66	5.5	110	22	40
32-45	45	38.1	32	18	66	5.5	120	28	45
40-52	52	45.2	40	21	82	8.0	160	40	65

Spare parts

Designation	Screw	Wrench		
				
TTBN...26	SH M6x1.0x25	L-W5		
TTBN...32	SH M6x1.0x30	L-W5		
TTBN...45	SH M6x1.0x40	L-W5		
TTBN...52	SH M8x1.25x45	L-W6		

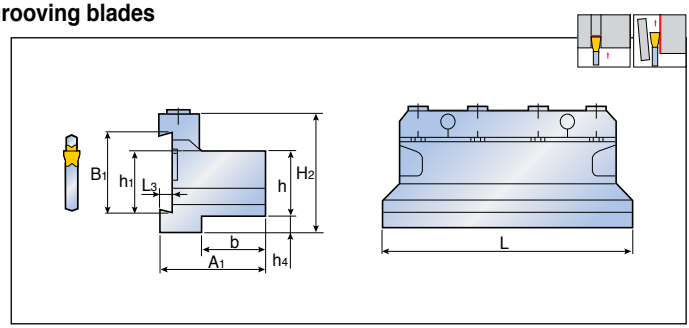


TTBU

T-CLAMP ULTRA PLUS

Blocks for parting and deep grooving blades





Designation	Dimension (mm)								
	B1	h1	h	h4	H2	L3	L	b	A1
TTBU 20-26	26	21.4	20	9	43	4.0	86	21	38
25-26	26	21.4	25	5	45	4.0	110	23	42
20-32	32	24.8	20	13	50	5.3	100	19	38
25-32	32	24.8	25	8	50	5.3	110	23	42
32-32	32	24.8	32	5	54	5.3	110	29	48
25-45	45	38.1	25	27	70	5.3	110	23	42
32-45	45	38.1	32	20	70	5.3	110	29	48

Spare parts

Designation	Screw	Clamp	Wrench	
TTBU 20-26	SR-M6x30	BKU- 86	L-W5	
TTBU 25-26	SR-M6x30	BKU-105	L-W5	
TTBU 20-32	SR-M6x30 DIN 912	BKU-100	L-W5	
TTBU 25/32-32/45	SR-M6x30	BKU-110	L-W5	



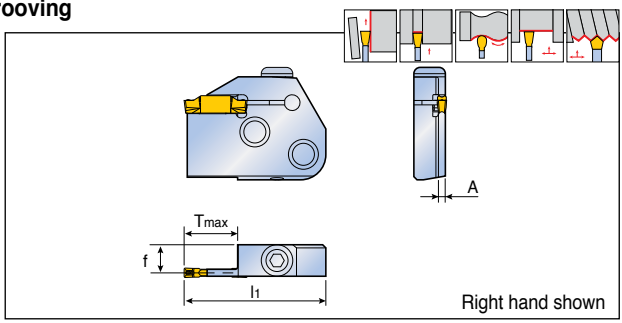
TaeguTec Member IMC Group

TCER/L

T-CLAMP ULTRA PLUS

Cartridge for external turning and grooving





Designation		Insert seat size	Dimension (mm)				Insert	Holder
			l_1	A	f	T_{max}		
TCER/L	**1.4T12**	1	41	1.0	9.5	12	TDJ 1.4	C..-TCHN C..-TCHPN TCHR/L TCHPR/L B32-B35
	2T16	2	45	1.8	9.1	16	TDC(1) / J(1) / T TDXU / XT TSC(1) / J(1) B74-B83	
	2T22	2	51	1.8	9.1	22		
	3T16	3	45	2.4	8.8	16		
	3T22	3	51	2.4	8.8	22		
	4T16	4	45	3.0	8.5	16		
	4T22	4	51	3.0	8.5	22		
	5T20	5	49	4.0	8.0	20		
	5T25	5	54	4.0	8.0	25		
	6T20	6	49	5.0	7.5	20		
	6T25	6	54	5.0	7.5	25		

- (1) Insert for grooving only
- Ordering example: 2 pcs. TCER 3T16

Spare parts

Designation	Screw	Wrench		
				
TCER/L	BH M6x1x20	L-W4		

TaeguTec Member IMC Group

TCFR/L

T-CLAMP ULTRA PLUS

Cartridge for external face grooving and turning



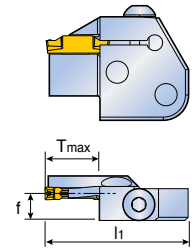


Fig.1

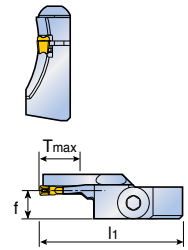
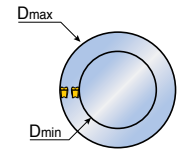


Fig.2



Right hand shown

Designation		Insert seat size	Dimension (mm) l1	f	Tmax	Dmin	Dmax	Fig.	Insert	Holder
TCFR/L	**3T12-40-55 RN**	3	45	8.9	12	40	55	2	TDC(1) / J(1) / T TDXU / XT TSC(1) / J(1) B74-B83	C..-TCHN C..-TCHPN TCHR/L TCHPR/L B32-B35
	3T12-55-75 RN	3	45	8.9	12	55	75	2		
	3T12-75-100 RN	3	45	8.9	12	75	100	2		
	3T12-100-140 RN	3	45	8.9	12	100	140	2		
	3T12-140-200 RN	3	45	8.9	12	140	200	2		
	4T16-50-70 RN	4	45	8.5	16	50	70	1		
	4T16-70-100 RN	4	45	8.5	16	70	100	1		
	4T16-100-150 RN	4	45	8.5	16	100	150	1		
	4T16-150-250 RN	4	45	8.5	16	150	250	1		
	4T16-250 RN	4	45	8.5	16	250	∞	1		
	5T20-55-80 RN	5	49	8.0	20	55	80	1		
	5T20-80-120 RN	5	49	8.0	20	80	120	1		
	5T20-120-180 RN	5	49	8.0	20	120	180	1		
	5T20-180-300 RN	5	49	8.0	20	180	300	1		
	5T20-300 RN	5	49	8.0	20	300	∞	1		
	6T25-60-90 RN	6	55	7.5	25	60	90	1		
	6T25-90-150 RN	6	55	7.5	25	90	150	1		
	6T25-150-250 RN	6	55	7.5	25	150	250	1		
	6T25-250-400 RN	6	55	7.5	25	250	400	1		
	6T25-400 RN	6	55	7.5	25	400	∞	1		

- (1) Insert for grooving only
- Ordering example: 5 pcs. TCFR 3T12-40-55RN
- Please check insert min. dia for face grooving B49 page

Spare parts

Designation	Screw	Wrench		
TCFR/L	BH M6x1x20	L-W4		

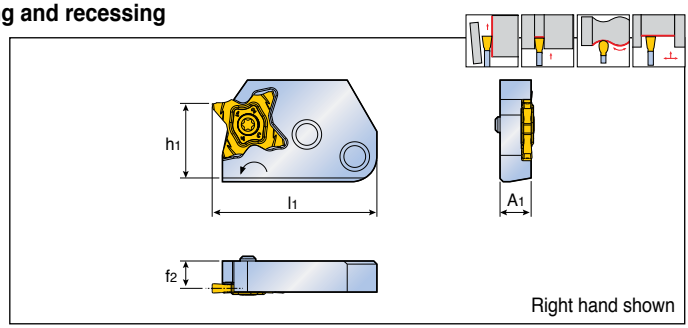
TaeguTec Member IMC Group

TQCR/L

QUAD•RUSH

Cartridge for grooving, parting and recessing





Designation	Dimension (mm)					Insert	Holder
	f_2[(1)]	l_1	W_{range}	h_1	A_1		
TQCR 27	8.8	53	0.5 ≤ W < 5.3	24	10	TQ..27…	C..-TCHN
TQCL 27	8.8	53	0.5 ≤ W < 5.3	24	10	B107-B116	C..-TCHPN
							TCHR/L
							TCHPR/L
							B32-B35

• [(1)] "f_2" value is based on TQ.. 27 standard insert

Spare parts

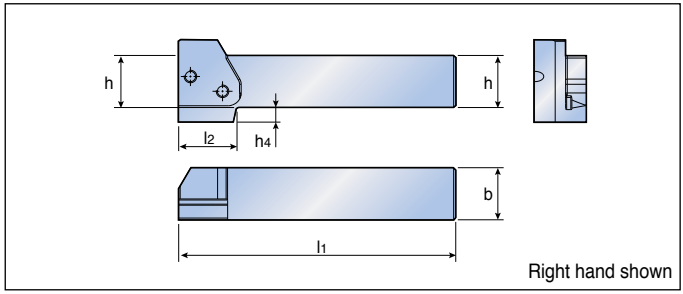
Designation	Screw	Wrench		
				
TQCR 27	TS 50125IL	T 10 / 20		
TQCL 27	TS 50125I	T 10 / 20		

TCHR/L

T-CLAMP ULTRA PLUS

Parallel holders





Designation	Dimension (mm)					Cartridge
	h	b	l_1	l_2	h_4	
TCHR/L 2020	20	20	133	35	12	TCER/L / TCFR/L
2525	25	25	133	28	7	TQCR/L
3232	32	32	153	28	-	B29-B31

• Ordering example: 2 pcs. TCHR 2525

Spare parts

Designation	Clamp screw	Wrench		
				
TCHR/L	TS 60190I	L-W4		

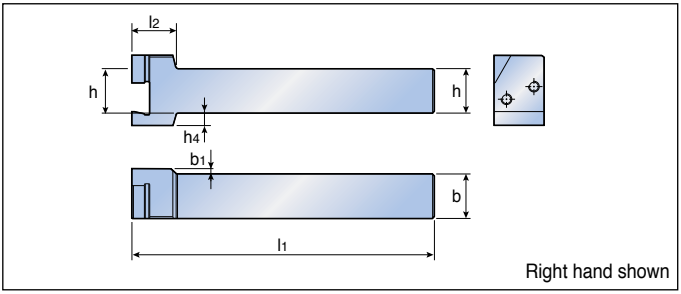
TaeguTec Member IMC Group

TCHPR/L

T-CLAMP ULTRA PLUS

Perpendicular holders





Right hand shown

Designation		Dimension (mm)						Cartridge
		h	b	l_1	l_2	b_1	h_4	
TCHPR/L	**2020**	20	20	150	25	8	12	TCER/L / TCFR/L
	2525	25	25	150	25	3	7	TQCR/L
	3232	32	32	170	25	-	-	B29-B31

• Ordering example: 2 pcs. TCHPR 2525

Spare parts

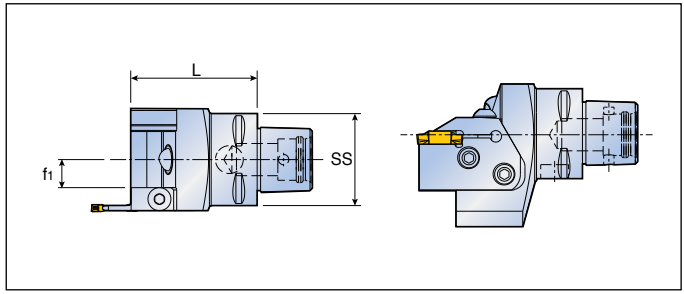
Designation	Clamp screw	Wrench		
				
TCHPR/L	TS 60190I	L-W4		

C-ADAPTER

T-CLAMP ULTRA PLUS

Parallel type





Designation	Dimension (mm)			Cartridge
	SS	L	f1	
C4-TCHN	40	55	12.2	TCER/L / TCFR/L TQCR/L B29-B31
C5-TCHN	50	58	17.2	
C6-TCHN	63	60	22.2	

• Cartridge should be ordered separately

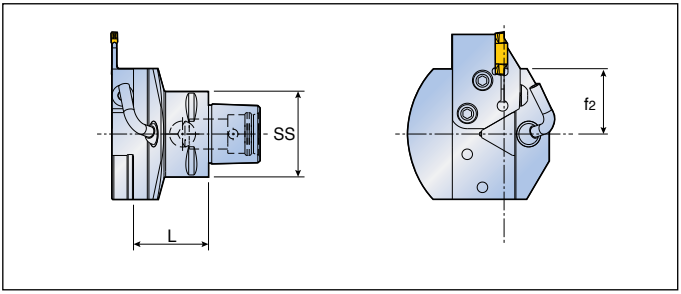
Spare parts

Designation	Screw	Nozzle	Wrench	
TCHN	TS 60190I	NZ-125	L-W4	

C-ADAPTER

Perpendicular type





Designation	Dimension (mm)			Cartridge
	SS	L	f2	
C4-TCHPN	40	35	30.5	TCER/L / TCFR/L
C5-TCHPN	50	40	35.5	TQCR/L
C6-TCHPN	63	42	35.5	B29-B31

• Cartridge should be ordered separately

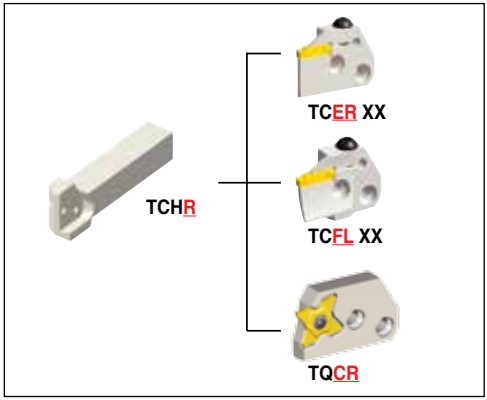
Spare parts

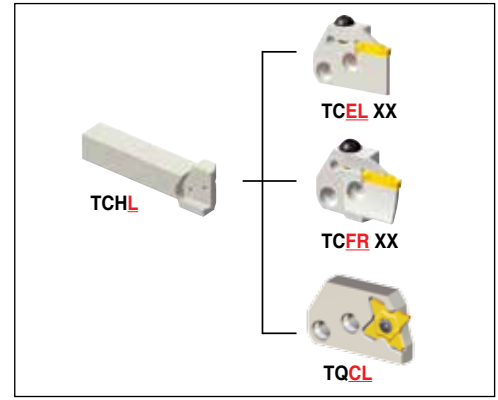
Designation	Screw	Nozzle	Wrench	Pipe
				
TCHPN	TS 60190I	NZ-125	L-W4	NZP 5

Cartridge and Holder Selection

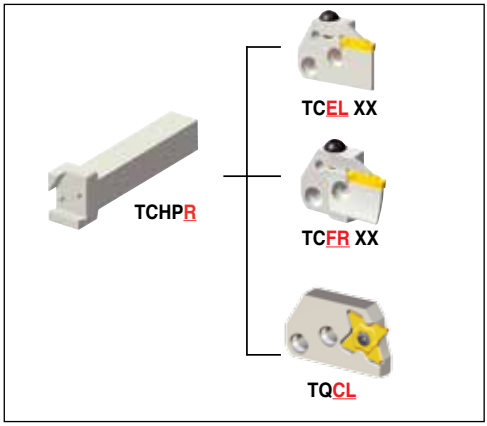
T-CLAMP ULTRA PLUS

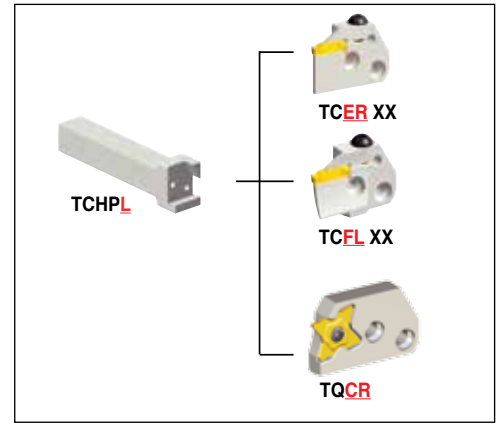
Parallel type



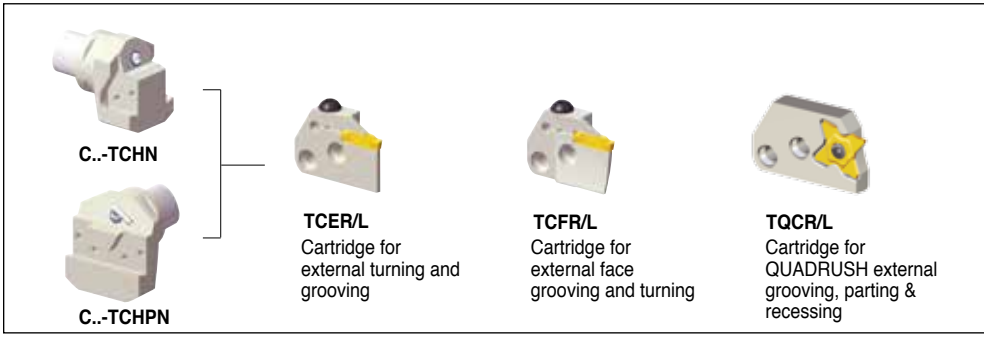


Perpendicular type





C-ADAPTER

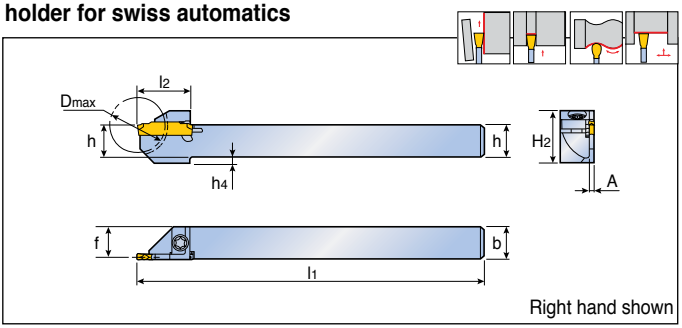


TTER/L-SH

T-CLAMP ULTRA PLUS

External turning and grooving holder for swiss automatics





Right hand shown

Designation		Insert seat size	Dimension (mm)									Insert
			h	b	l1	f	l2	A	h4	H2	Dmax	
TTER/L	**10-20-1.4SH**	1	10	10	125	9.5	18	1.0	-	13.7	20	TDC / J / T
	12-24-1.4SH	1	12	12	125	11.5	19.5	1.0	-	15.7	24	TDXU / XT
	14-24-1.4SH	1	14	14	125	13.5	19.5	1.0	-	17.7	24	TSC / J
	16-32-1.4SH	1	16	16	125	15.5	24	1.0	-	19.7	32	B74-B83
	10-20-2SH	2	10	10	125	9.1	19	1.8	2	17.5	20	
	12-24-2SH	2	12	12	125	11.1	19	1.8	2	19.0	24	
	14-24-2SH	2	14	14	125	13.1	19	1.8	-	19.0	24	
	16-32-2SH	2	16	16	125	15.1	24	1.8	-	21.0	32	
	12-24-3SH	3	12	12	125	10.8	19	2.4	2	19.0	24	
	16-32-3SH	3	16	16	125	14.8	24	2.4	-	21.0	32	

Spare parts

Designation	Screw	Wrench		
				
TTER/L- SH	TS 40A115I	T15		

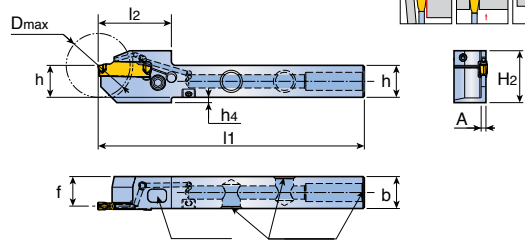
TTER/L-3SH-TB

T-CLAMP ULTRA PLUS

Side lock holders with channels for high pressure coolant on Swiss type automatic machines



T-BURST HIGH PRESSURE



Right hand shown

Designation	Insert seat size	Dimension (mm)									Coolant inlet	Insert
		h	b	l1	f	l2	A	h4	H2	Dmax		
TTER/L 12-24-3SH-TB	3	12	12	125	10.8	27.5	2.4	2	19.5	24	UNF 5/16	TDC / J / T / A
16-32-3SH-TB	3	16	16	125	14.8	31.5	2.4	2	21.5	32	UNF 5/16	TDXU / XT
												TSC / J
												B74-B83

	70 bar flow rate (ℓ/min)	100 bar flow rate (ℓ/min)	140 bar flow rate (ℓ/min)
TTER/L -3SH-TB	6.4	9.7	11.9

Spare parts

Designation	Clamping pin	Clamping screw	Pin plug	Wrench for clamping screw & pin plug	Inlet plug	Wrench for inlet plug
						
TTER/L 12-24-3SH-TB	PIN-SH-TB	SS M5-24145	SS M5x3.5 ULTEM 2300	L-W 2.5F	PLG 5/16 UNF	L-W 5/32"
TTER/L 16-32-3SH-TB	PIN-SH-TB	SS M5-24145	SS M5x3.5 ULTEM 2300	L-W 2.5F	PLG 5/16 UNF	L-W 5/32"

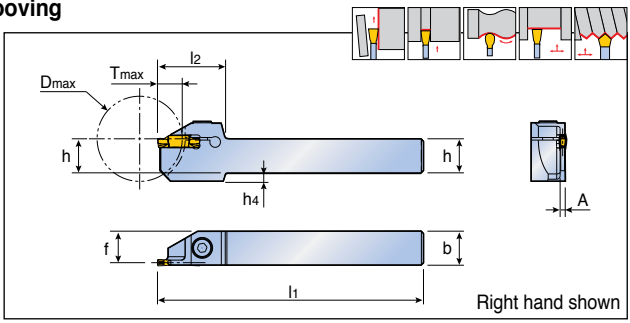
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TTER/L-D

T-CLAMP ULTRA PLUS

Reinforced external turning and grooving



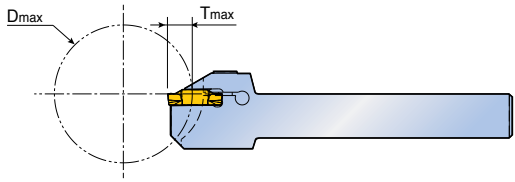


Designation	Insert seat size	Dimension (mm)									Insert
		h	b	l1	f	l2	h4	A	Tmax	Dmax	
TTER/L 1010-1.4T15-D40	1	10	10	125	9.5	32	6	1.0	15	40	TDC / J / T
1212-1.4T15-D40	1	12	12	125	11.5	32	4	1.0	15	40	TDXU / XT
1616-1.4T20-D45	1	16	16	125	15.5	38	4	1.0	20	45	TSC / J
2020-1.4T20-D45	1	20	20	125	19.5	38	-	1.0	20	45	B74-B83
1010-2T15-D40	2	10	10	125	9.1	32	6	1.8	15	40	
1212-2T15-D40	2	12	12	125	11.1	32	4	1.8	15	40	
1616-2T20-D45	2	16	16	125	15.1	38	4	1.8	20	45	
2020-2T20-D45	2	20	20	125	19.1	38	-	1.8	20	45	
2525-2T20-D45	2	25	25	150	24.1	38	-	1.8	20	45	
1212-3T15-D40	3	12	12	125	10.8	32	4	2.4	15	40	
1616-3T20-D45	3	16	16	125	14.8	38	4	2.4	20	45	
2020-3T20-D45	3	20	20	125	18.8	38	-	2.4	20	45	
2525-3T20-D45	3	25	25	150	23.8	38	-	2.4	20	45	
2525-3T25-D60	3	25	25	150	23.8	43	-	2.4	25	60	

Spare parts

Designation	Screw	Wrench		
				
TTER/L-D	SH M5x0.8x16	L-W 4		

Machining depth for diameter of workpiece



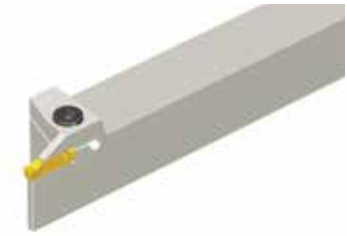
Designation		Tmax												
		1	2	3	4	5	6	7	8	9	10	11	12	13
TTER/L 1010-1.4T15-D40	Dmax					∞						269	120	79
1212-1.4T15-D40						∞						269	120	79
1616-1.4T20-D45						∞								432
2020-1.4T20-D45						∞								432
1010-2T15-D40						∞						269	120	79
1212-2T15-D40						∞						269	120	79
1616-2T20-D45						∞								432
2020-2T20-D45						∞								432
2525-2T20-D45						∞				1468	339	193	136	106
1212-3T15-D40						∞						269	120	79
1616-3T20-D45						∞								432
2020-3T20-D45						∞								432
2525-3T20-D45						∞				1468	339	193	136	106
2525-3T25-D60						∞								

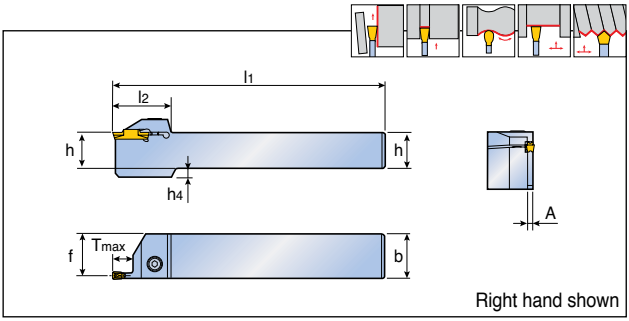
Designation		Tmax												
		14	15	16	17	18	19	20	21	22	23	24	25	
TTER/L 1010-1.4T15-D40	Dmax	59	40											
1212-1.4T15-D40		59	40											
1616-1.4T20-D45		193	125	94	76	64	57	45						
2020-1.4T20-D45		193	125	94	76	64	57	45						
1010-2T15-D40		59	40											
1212-2T15-D40		59	40											
1616-2T20-D45		193	125	94	76	64	57	45						
2020-2T20-D45		193	125	94	76	64	57	45						
2525-2T20-D45		87	75	67	60	56	52	45						
1212-3T15-D40		59	40											
1616-3T20-D45		193	125	94	76	64	57	45						
2020-3T20-D45		193	125	94	76	64	57	45						
2525-3T20-D45		87	75	67	60	56	52	45						
2525-3T25-D60				1810	418	237	167	130	107	91	81	73	60	

TTER/L

T-CLAMP ULTRA PLUS

External turning and grooving





Right hand shown

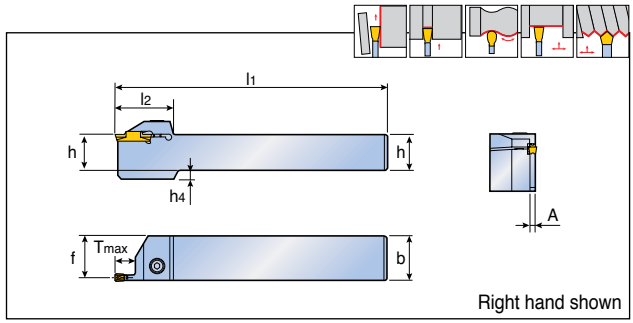
Designation	Insert seat size	Dimension (mm)								Insert
		h	b	l1	f	l2	A	h4	Tmax	
TTER/L 1616-2T08	2	16	16	110	15.1	33.0	1.8	4	8	TDC / J / T / A
2020-2T08	2	20	20	125	19.1	33.0	1.8	-	8	TDXU / XT
2525-2T08	2	25	25	150	24.1	33.0	1.8	-	8	TSC / J / A
1616-2	2	16	16	110	15.1	32.0	1.8	4	12	B74-B87
2020-2	2	20	20	125	19.1	32.0	1.8	-	12	
2525-2	2	25	25	150	24.1	32.0	1.8	-	12	
1616-2T17	2	16	16	110	15.1	37.0	1.8	4	17	
2020-2T17	2	20	20	125	19.1	37.0	1.8	-	17	
2525-2T17	2	25	25	150	24.1	37.0	1.8	-	17	
TTER/L 1616-3T09	3	16	16	110	14.8	32.0	2.4	4	9	
2020-3T09	3	20	20	125	18.8	32.0	2.4	-	9	
2525-3T09	3	25	25	150	23.8	32.0	2.4	-	9	
1616-3	3	16	16	110	14.8	32.0	2.4	4	12	
2020-3	3	20	20	125	18.8	32.0	2.4	-	12	
2525-3	3	25	25	150	23.8	32.0	2.4	-	12	
1616-3T20	3	16	16	110	14.8	38.5	2.4	-	20	
2020-3T20	3	20	20	125	18.8	38.5	2.4	-	20	
2525-3T20	3	25	25	150	23.8	38.5	2.4	-	20	
2525-3T25	3	25	25	150	23.8	44.5	2.4	-	25	
3232-3T20	3	32	32	170	30.8	38.5	2.4	-	20	
TTER/L 1616-4T10	4	16	16	110	14.5	32.0	3.0	4	10	
2020-4T10	4	20	20	125	18.5	32.0	3.0	-	10	
2525-4T10	4	25	25	150	23.5	32.0	3.0	-	10	
1616-4	4	16	16	110	14.5	33.0	3.0	4	15	
2020-4	4	20	20	125	18.5	33.0	3.0	-	15	
2525-4	4	25	25	150	23.5	33.0	3.0	-	15	
1616-4T25	4	16	16	110	14.5	45.0	3.0	-	25	
2020-4T25	4	20	20	125	18.5	45.0	3.0	-	25	
2525-4T25	4	25	25	150	23.5	45.0	3.0	-	25	
3232-4T25	4	32	32	170	30.5	45.0	3.0	-	25	
TTER/L 2020-5T12	5	20	20	125	18.1	37.0	4.0	-	12	
2525-5T12	5	25	25	150	23.1	37.0	4.0	-	12	
2020-5	5	20	20	125	18.1	37.0	4.0	-	20	
2525-5	5	25	25	150	23.1	37.0	4.0	-	20	
2525-5T32	5	25	25	150	23.0	56.0	4.0	-	32	
3232-5T20	5	32	32	170	30.0	39.0	4.0	-	20	
3232-5T32	5	32	32	170	30.0	56.0	4.0	-	32	

TTER/L

T-CLAMP ULTRA PLUS

External turning and grooving





Right hand shown

Designation	Insert seat size	Dimension (mm)								Insert
		h	b	l1	f	l2	A	h4	Tmax	
TTER/L 2020-6T12	6	20	20	125	17.6	37	5.0	-	12	TDC / J / T / A
2525-6T12	6	25	25	150	22.6	37	5.0	7	12	TDXU / XT
2020-6	6	20	20	125	17.6	41	5.0	-	20	TSC / J / A
2525-6	6	25	25	150	22.6	41	5.0	7	20	B74-B87
2525-6T32	6	25	25	150	22.5	56	5.0	7	32	
3232-6T20	6	32	32	170	29.5	41	5.0	-	20	
3232-6T25	6	32	32	170	29.5	46	5.0	-	25	
3232-6T32	6	32	32	170	29.5	56	5.0	-	32	
TTER/L 2525-8T16	8	25	25	150	22.1	47	6.0	7	16	
2525-8	8	25	25	150	22.1	47	6.0	7	25	
3232-8	8	32	32	170	29.1	47	6.0	-	25	
2525-8T36	8	25	25	150	22.1	60	6.0	7	36	
3232-8T36	8	32	32	170	29.1	60	6.0	-	36	
TTER/L 2525-10T25	10	25	25	150	21.1	50	7.85	7	25	
3232-10T25	10	32	32	170	28.1	50	7.85	-	25	
4040-10T25	10	40	40	200	36.1	50	7.85	-	25	

Spare parts

Designation	Screw	Wrench		
				
TTER/L 1616-2/3	SH M5x0.8x16	L-W 4		
TTER/L 2020-2/3	SH M5x0.8x20	L-W 4		
TTER/L 2525-2/3	SH M5x0.8x25	L-W 4		
TTER/L 3232-3	SH M5x0.8x25	L-W 4		
TTER/L 1616-4/5	SH M6x1x16	L-W 5		
TTER/L 2020-4/5	SH M6x1x20	L-W 5		
TTER/L 2525-4/5	SH M6x1x25	L-W 5		
TTER/L 3232-4/5	SH M6x1x25	L-W 5		
TTER/L 2020-6	SH M8x1.25x20	L-W 6		
TTER/L 2525-6/8	SH M8x1.25x25	L-W 6		
TTER/L 3232-6/8/10	SH M8x1.25x25	L-W 6		
TTER/L 4040-10	SH M8x1.25x25	L-W 6		

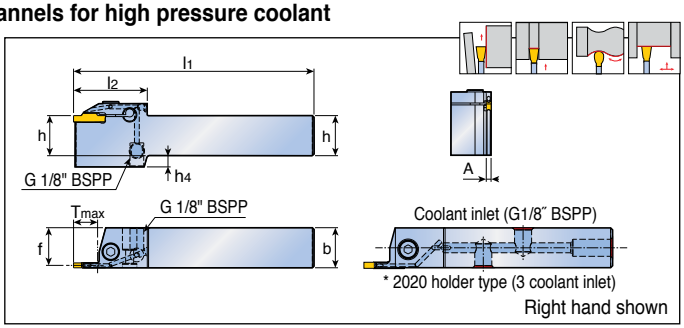
TTER/L-TB

T-CLAMP ULTRA PLUS

Grooving and turning with channels for high pressure coolant



T-BURST HIGH PRESSURE



Designation		Insert seat size	Dimension (mm)								Torque (N.m)	Insert
			h	b	l1	f	l2	A	h4	Tmax		
TTER/L	2020-3-TB	3	20	20	125	18.8	43	2.4	-	12	5.5	TDC / J / T / A
	2020-4-TB	4	20	20	125	18.5	46	3.0	-	15	8.0	TDXU / XT
	2525-3-TB	3	25	25	150	23.8	43	2.4	-	12	5.5	TSC / J / A
	2525-4-TB	4	25	25	150	23.5	46	3.0	-	15	8.0	B74-B87
	2525-5-TB	5	25	25	150	23.1	49	4.0	-	20	8.0	
	2525-6-TB	6	25	25	150	22.6	52	5.0	7	20	12.0	
	2525-8-TB	8	25	25	150	22.1	58	6.0	7	25	12.0	

		70 bar flow rate (ℓ/min)	100 bar flow rate (ℓ/min)	140 bar flow rate (ℓ/min)
TTER/L	2020-3-TB	5-7	7-9	9-11
	2020-4-TB	6-8	10-12	12-14
	2525-3-TB	6-8	8-10	10-12
	2525-4-TB	10-12	14-16	16-18
	2525-5-TB	13-16	19-21	22-24
	2525-6-TB	13-16	19-21	22-24
	2525-8-TB	13-16	19-21	22-24

Spare parts

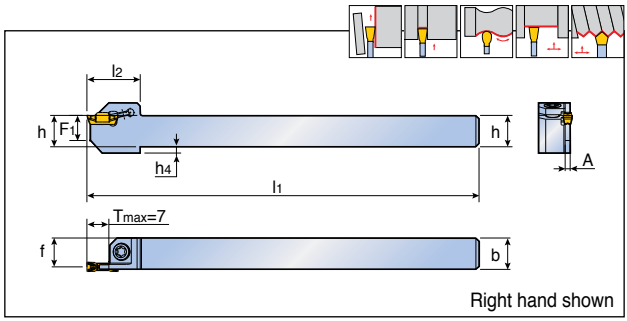
Designation	Screw	Wrench	Plug	Wrench for plug
TTER/L 2020-3-TB	SH M5x0.8x20	L-W4	PLG G1/8-L6.5	L-W5
TTER/L 2020-4-TB	SH M6x1.0x20	L-W5	PLG G1/8-L6.5	L-W5
TTER/L 2525-3-TB	SH M5x0.8x20	L-W4	PLG G1/8-T8.0-L12.3	L-W5
TTER/L 2525-4 / 5-TB	SH M6x1.0x20	L-W5	PLG G1/8-T8.0-L12.3	L-W5
TTER/L 2525-6 / 7-TB	SH M8x1.25x20	L-W6	PLG G1/8-T8.0-L12.3	L-W5

TTSER/L

T-CLAMP ULTRA PLUS

External turning and grooving





Right hand shown

Designation		Insert seat size	Dimension (mm)								Insert
			h	b	l1	f	F1	l2	A	h4	
TTSER/L	**1010-2T7**	2	10	10	125	9.2	8	17	1.6	2	TDIM / IP
	1212-2T7	2	12	12	125	11.2	8	17	1.6	-	B85-B86
	1616-2T7	2	16	16	125	15.2	11	20	1.6	-	
	2020-2T7	2	20	20	125	19.2	14	20	1.6	-	
	2525-2T7	2	25	25	125	24.2	18	20	1.6	-	
	1010-3T7	3	10	10	125	8.8	8	17	2.4	2	
	1212-3T7	3	12	12	125	10.8	8	17	2.4	-	
	1616-3T7	3	16	16	125	14.8	11	20	2.4	-	
	2020-3T7	3	20	20	125	18.8	14	20	2.4	-	
	2525-3T7	3	25	25	125	23.8	18	20	2.4	-	

Spare parts

Designation	Screw	Wrench		
				
TTSER/L	TS 40097I	T 15		

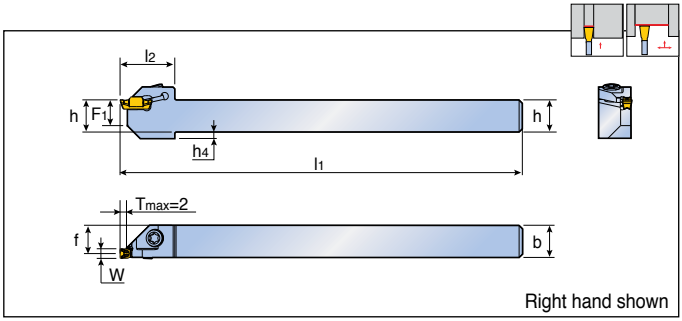
TaeguTec Member IMC Group

TGSFR/L

T-CLAMP ULTRA PLUS

Shallow turning and grooving





Right hand shown

Designation		Insert seat size	Dimension (mm)								Insert
			h	b	l_1	f	F_1	l_2	h_4	W	
TGSFR/L	**1010-3T2**	2, 3	10	10	125	8.8	8	17	2	≤ 3	TDIM / IP
	1212-3T2	2, 3	12	12	125	10.8	8	17	-	≤ 3	B85-B86
	1616-3T2	2, 3	16	16	125	14.8	11	20	-	≤ 3	

Spare parts

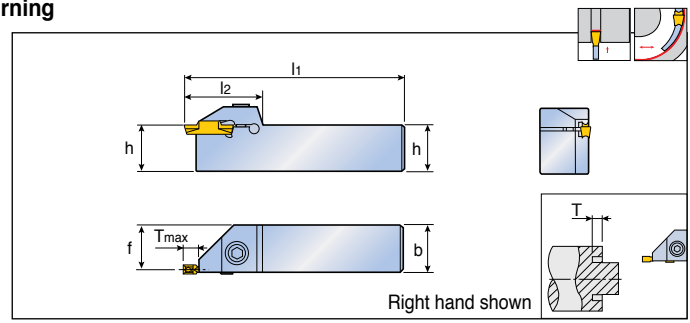
Designation	Screw	Wrench		
TGSFR/L	TS 40097I	T 15		

TGFR/L

T-CLAMP ULTRA PLUS

External face grooving and turning





Designation	Insert seat size	Dimension (mm)						Insert
		h	b	l1	f	l2	Tmax	
TGFR/L 1616-4	2, 3, 4	16	16	110	14.5	33	4.8	TDC(1) / J(1) / T
2020-4	2, 3, 4	20	20	125	18.5	33	4.8	TDXU / XT / FT
2525-4	2, 3, 4	25	25	150	23.5	33	4.8	TSC(1) / J(1)
2020-6	5, 6	20	20	125	17.6	37	4.8	B74-B83
2525-6	5, 6	25	25	150	22.6	37	4.8	

- (1) Insert for grooving only
- External turning & grooving is available depending on the insert type
- Please check insert min. dia for face grooving B49 page

Spare parts

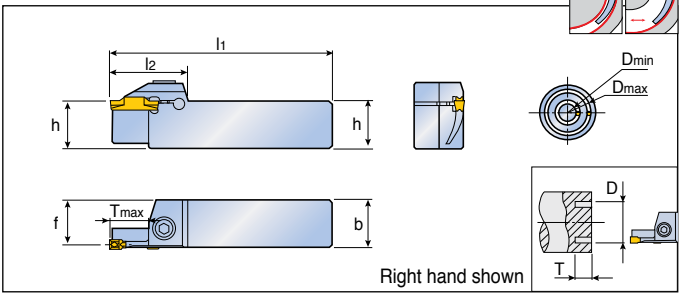
Designation	Screw	Wrench		
				
TGFR/L 1616	SH M6x1x16	L-W5		
TGFR/L 2020	SH M6x1x20	L-W5		
TGFR/L 2525	SH M6x1x25	L-W5		

TTFR/L

T-CLAMP ULTRA PLUS

Deep face grooving and turning





Designation		Insert seat size	Dimension (mm)								Insert
			h	b	l1	f	l2	Tmax	Dmin	Dmax	
TTFR/L	**25-30-3**	3	25	25	150	24.0	32	10	24	35	TDC(1) / J(1) / T TDXU / XT / FT TSC(1) / J(1) B74-B83
	25-35-3	3	25	25	150	24.0	32	10	29	40	
	25-40-3	3	25	25	150	24.0	32	10	34	50	
	25-50-3	3	25	25	150	24.0	32	15	44	60	
	25-60-3	3	25	25	150	24.0	32	15	54	85	
	25-30-4	4	25	25	150	23.6	33	12	22	40	
	25-40-4	4	25	25	150	23.6	33	15	32	50	
	25-50-4	4	25	25	150	23.6	33	15	42	60	
	25-60-4	4	25	25	150	23.6	33	15	52	85	
	25-60-5	5	25	25	150	23.5	41	20	50	80	
	25-80-5	5	25	25	150	23.5	41	20	70	110	
	25-110-5	5	25	25	150	23.5	41	20	110	150	
	25-150-5	5	25	25	150	23.5	41	20	140	200	
	25-60-6	6	25	25	150	22.6	41	20	48	85	
	25-85-6	6	25	25	150	22.6	41	20	73	150	
	25-150-6	6	25	25	150	22.6	41	20	138	250	
	25-250-6	6	25	25	150	22.6	41	20	250	∞	

- (1) Insert for grooving only
- Please check insert min. dia for face grooving B49 page

Spare parts

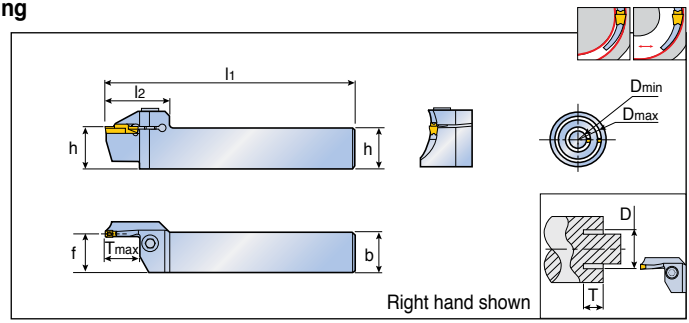
Designation	Screw	Wrench		
				
TTFR/L...-3	SH M5x0.8x25	L-W 4		
TTFR/L...-4	SH M6x1x25	L-W 5		
TTFR/L...-5	SH M8X1.25X25	L-W 5		
TTFR/L...-6	SH M8X1.25X25	L-W 5		

TTFR/L-RN (Renewed Type)

T-CLAMP ULTRA PLUS

Deep face grooving and turning





Designation	Insert seat size	Dimension (mm)								Insert
		h	b	l1	f	l2	Tmax	Dmin	Dmax	
TTFR/L 20-21-30-3T10 RN	3	20	20	140	19.0	31	10	21	30	TDC(1) / J(1) / T
20-24-35-3T10 RN	3	20	20	140	19.0	31	10	24	35	TDXU / XT / FT
20-29-40-3T10 RN	3	20	20	140	19.0	31	10	29	40	TSC(1) / J(1)
20-34-50-3T10 RN	3	20	20	140	19.0	31	10	34	50	B74-B83
20-44-70-3T15 RN	3	20	20	140	19.0	35	15	44	70	
20-64-100-3T15 RN	3	20	20	140	19.0	35	15	64	100	
25-30-3 RN	3	25	25	150	24.0	38	10	24	35	
25-35-3 RN	3	25	25	150	24.0	38	10	29	40	
25-40-3 RN	3	25	25	150	24.0	38	10	34	50	
25-50-3 RN	3	25	25	150	24.0	38	15	44	70	
25-70-3 RN	3	25	25	150	24.0	38	15	64	100	
20-19-30-4T10 RN	4	20	20	140	18.6	31	10	19	30	
20-22-36-4T10 RN	4	20	20	140	18.6	31	10	22	36	
20-28-42-4T16 RN	4	20	20	140	18.6	36	16	28	42	
20-34-50-4T16 RN	4	20	20	140	18.6	36	16	34	50	
20-42-70-4T16 RN	4	20	20	140	18.6	36	16	42	70	
20-62-120-4T16 RN	4	20	20	140	18.6	36	16	62	120	
20-112-200-4T16 RN	4	20	20	140	18.6	36	16	112	200	
25-30-4 RN	4	25	25	150	23.6	39	10	22	36	
25-36-4 RN	4	25	25	150	23.6	39	20	28	42	
25-42-4 RN	4	25	25	150	23.6	39	20	34	50	
25-50-4 RN	4	25	25	150	23.6	39	20	42	70	
25-70-4 RN	4	25	25	150	23.6	39	20	62	120	
25-120-4 RN	4	25	25	150	23.6	39	20	112	200	
25-200-4 RN	4	25	25	150	23.6	39	20	200	∞	
25-60-5T15 RN	5	25	25	150	23.1	41	15	50	80	
25-60-5 RN	5	25	25	150	23.1	49	25	50	80	
25-80-5T15 RN	5	25	25	150	23.1	41	15	70	110	
25-80-5 RN	5	25	25	150	23.1	49	25	70	110	
25-110-5 RN	5	25	25	150	23.1	49	25	100	150	
25-150-5 RN	5	25	25	150	23.1	49	25	140	200	
25-200-5 RN	5	25	25	150	23.1	49	25	200	∞	

- (1) Insert for grooving only
- Please check insert min. dia for face grooving B49 page

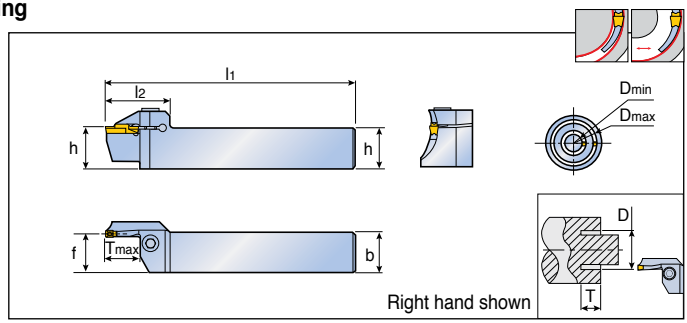
TaeguTec Member IMC Group

TTFR/L-RN (Renewed Type)

T-CLAMP ULTRA PLUS

Deep face grooving and turning





Designation	Insert seat size	Dimension (mm)								Insert
		h	b	l1	f	l2	Tmax	Dmin	Dmax	
TTFR/L 25-60-6 RN	6	25	25	150	22.6	49	25	48	70	TDC(1) / J(1) / T
25-70-6 RN	6	25	25	150	22.6	49	25	58	100	TDXU / XT / FT
25-100-6 RN	6	25	25	150	22.6	49	25	88	180	TSC(1) / J(1)
25-180-6 RN	6	25	25	150	22.6	49	25	168	400	B74-B83
25-400-6 RN	6	25	25	150	22.6	49	25	400	∞	

- (1) Insert for grooving only
- Please check insert min. dia for face grooving B49 page

Insert initial min.Dia (Dmin) for face grooving

Machining	Insert	Size (mm)	Min. dia. (mm)	Insert	Size (mm)	Min. dia. (mm)
Facing Min. dia. of face machining	TDJ/C	3	54	TDT RU	3	41
		4	34		4	36
		5	49		5	54
		6	46		6	54
	TDT	3	44	TDXU	3	18
		4	42		4	18
		5	50		5	20
		6	48		6	18

Spare parts

Designation	Screw	Wrench		
				
TTFR/L 20...RN	SH M6x1x20	L-W 5		
TTFR/L 25...3/4 RN	SH M6x1x25	L-W 5		
TTFR/L 25...5/6 RN	SH M8x1.25x25	L-W 6		

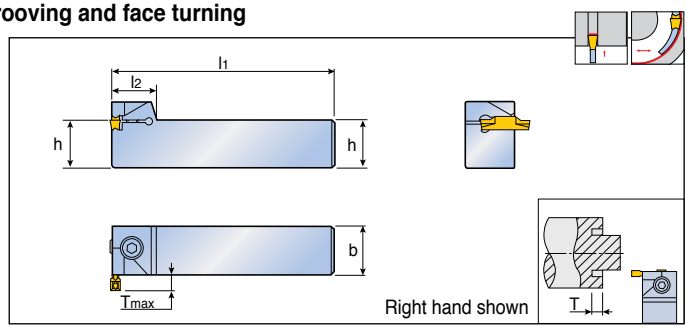
TaeguTec Member IMC Group

TGFPR/L

T-CLAMP ULTRA PLUS

Shallow face perpendicular grooving and face turning





Designation		Insert seat size	Dimension (mm)					Insert
			h	b	l_1	l_2	T_{max}	
TGFPR/L	**2020-4**	2, 3, 4	20	20	125	18	4.8	TDC(1) / J(1) / T
	2525-4	2, 3, 4	25	25	150	18	4.8	TDXU / XT / FT
	2525-6	5, 6	25	25	150	22	4.8	TSC(1) / J(1)
								B74-B83

- (1) Insert for grooving only
- External Turning & Grooving is available depending on the insert
- Please check insert min. dia for face grooving B49 page

Spare parts

Designation	Screw	Wrench		
TGFPR/L 2020	SH M6x1x20	L-W5		
TGFPR/L 2525	SH M6x1x25	L-W5		
TGFPR/L 2525	SH M6x1x25	L-W5		

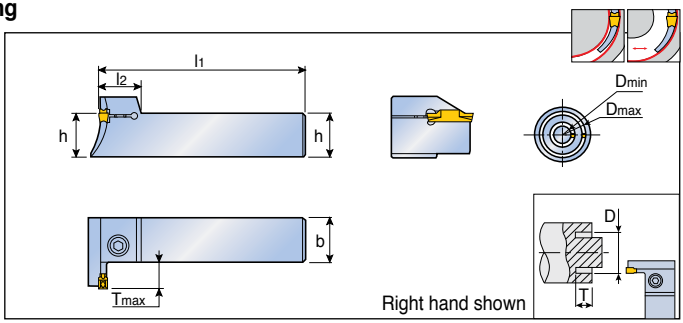
TaeguTec Member IMC Group

TTFPR/L

T-CLAMP ULTRA PLUS

Deep face grooving and turning





Designation		Insert seat size	Dimension (mm)							Insert
			h	b	l1	l2	Tmax	Dmin	Dmax	
TTFPR/L	**25-30-3**	3	25	25	150	18.0	10	24	35	TDC(1) / J(1) / T TDXU / XT / FT TSC(1) / J(1) B74-B83
	25-35-3	3	25	25	150	18.0	10	29	40	
	25-40-3	3	25	25	150	18.0	10	34	50	
	25-50-3	3	25	25	150	18.0	15	44	60	
	25-60-3	3	25	25	150	18.0	15	54	85	
	25-30-4	4	25	25	150	18.5	12	22	40	
	25-40-4	4	25	25	150	18.5	15	32	50	
	25-50-4	4	25	25	150	18.5	15	42	60	
	25-60-4	4	25	25	150	18.5	15	52	85	
	25-60-5	5	25	25	150	22.0	20	50	80	
	25-80-5	5	25	25	150	22.0	20	70	110	
	25-110-5	5	25	25	150	22.0	20	100	150	
	25-150-5	5	25	25	150	22.0	20	140	200	
	25-200-5	5	25	25	150	22.0	20	200	∞	
	25-60-6	6	25	25	150	22.0	20	48	85	
	25-85-6	6	25	25	150	22.0	20	73	150	
	25-150-6	6	25	25	150	22.0	20	138	250	
	25-250-6	6	25	25	150	22.0	20	250	∞	

- (1) Insert for grooving only
- Please check insert min. dia for face grooving B49 page

Spare parts

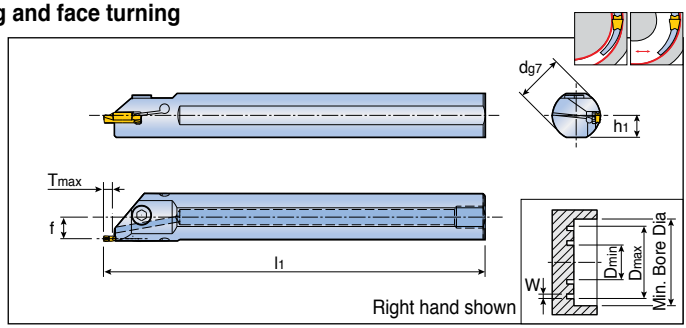
Designation	Screw	Wrench		
				
TTFPR/L...-3	SH M5x0.8x25	L-W 4		
TTFPR/L...-4	SH M6x1x25	L-W 5		
TTFPR/L...-5	SH M8x1.25x25	L-W 6		
TTFPR/L...-6	SH M8x1.25x25	L-W 6		

TGIFR/L

T-CLAMP ULTRA PLUS

Shallow internal face grooving and face turning



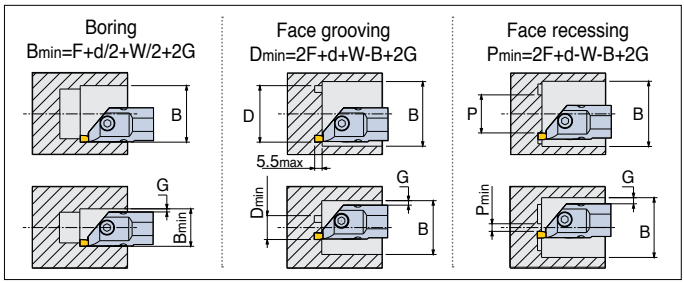


Designation	Insert seat size	Dimension (mm)					Insert
		d	l1	f	h1	Tmax	
TGIFR/L 25-4C-T5.5	3, 4	25	200	11.3	11.5	5.5	TDC(1) / J(1) / T
32-4C-T5.5	3, 4	32	250	14.8	15.0	5.5	TDXU / XT / FT
25-6C-T5.5	5, 6	25	200	10.3	11.5	5.5	TSC(1) / J(1)
32-6C-T5.5	5, 6	32	250	13.8	15.0	5.5	B74-B83

- (1) Insert for grooving only
- Please check insert min. dia for face grooving B49 page

W	Min. bore dia		Dmin		Dmax
	d=25	d=32	TDFT / TDXU	TDT / TDC / TDJ	
3	26.3	33.3	20	44	∞
4	26.8	33.8	18	42	
5	26.3	33.3	20	50	
6	26.8	33.8	18	48	

TGIFR/L Application



Spare parts

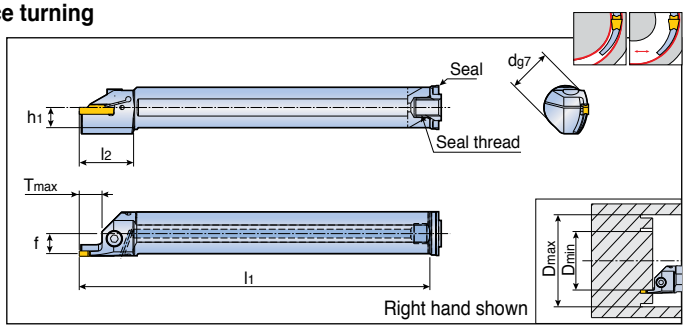
Designation	Screw	Wrench	Seal	
				
TGIFR/L 25	SH M6x1x16	L-W5	PL 25 (R1/8")	
TGIFR/L 32	SH M6x1x16	L-W5	PL 32 (R1/8")	

TTFIR/L

T-CLAMP ULTRA PLUS

Internal face grooving and face turning





Designation	Insert seat size	Dimension (mm)								Insert
		d	l1	l2	f	h1	Tmax	Dmin	Dmax	
TTFIR/L 25-3T12 20-33	3	25	200	31	11.5	11.5	12	20	33	TDC(1) / J(1) / T TDXU / XT / FT TSC(1) / J(1) B74-B83
25-3T12 26-39	3	25	200	31	11.5	11.5	12	26	39	
25-3T12 33-48	3	25	200	31	11.5	11.5	12	33	48	
25-3T12 42-60	3	25	200	31	11.5	11.5	12	42	60	
25-3T12 54-85	3	25	200	31	11.5	11.5	12	54	85	
25-3T12 79-150	3	25	200	31	11.5	11.5	12	79	150	
25-4T12 18-34	4	25	200	31	11.0	11.5	12	18	34	
25-4T12 26-42	4	25	200	31	11.0	11.5	12	26	42	
25-4T12 34-55	4	25	200	31	11.0	11.5	12	34	55	
32-4T12 47-70	4	32	250	31	14.5	15.0	12	47	70	
32-4T12 62-100	4	32	250	31	14.5	15.0	12	62	100	
32-4T12 92-180	4	32	250	31	14.5	15.0	12	92	180	

- (1) Insert for grooving only
- Please check insert min. dia for face grooving B49 page

Spare parts

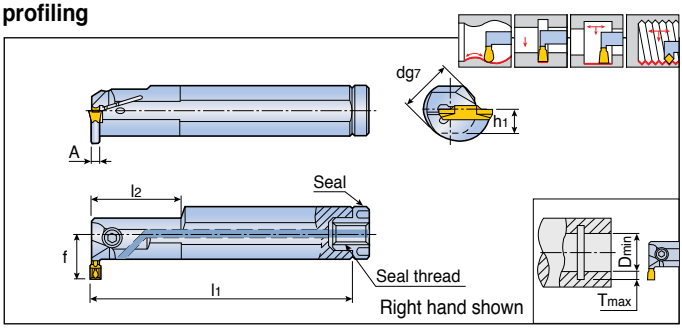
Designation	Screw	Wrench	Seal	
				
TTFIR/L 25	SH M5x0.8x16	L-W 4	PL 25 (R1/8")	
TTFIR/L 32	SH M5x0.8x16	L-W 4	PL 32 (R1/8")	

TTIR/L

T-CLAMP ULTRA PLUS

Internal turning, grooving and profiling





Designation		Insert seat size	Dimension (mm)								Insert
			d	l_1	l_2	f	h_1	A	Tmax	Dmin	
TTIR/L	**16-2C**	2	16	125	-	16.5	7.5	1.8	8.5	25	TDC(1) / J(1) / T TDXU / XT / FT / IT TSC(1) / J(1) B74-B84
	20-2C	2	20	160	40	15.8	9.0	1.6	6.0	25	
	25-2C	2	25	200	40	17.5	11.5	1.6	5.0	25	
	32-2C-T8	2	32	250	40	24.8	14.0	1.8	8.0	36	
	20-3C	3	20	160	40	15.8	9.0	2.1	6.0	25	
	25-3C	3	25	200	40	17.5	11.5	2.1	5.1	25	
	25-3C-T8	3	25	200	40	21.5	11.5	2.4	8	32	
	32-3C	3	32	250	60	20.8	14.0	2.1	4.7	31	
	32-3C-T10	3	32	250	60	27.0	15.0	2.4	10	40	
	40-3C-T12	3	40	300	65	33.0	19.0	2.4	12	50	
	20-4C	4	20	160	40	15.8	9.0	2.9	6.0	25	
	25-4C	4	25	200	40	17.5	11.5	2.9	5.2	25	
	25-4C-T8	4	25	200	40	21.5	11.5	3.0	8	32	
	32-4C	4	32	250	60	20.8	14.0	2.9	4.7	31	
	32-4C-T10	4	32	250	60	27.0	15.0	3.0	10	40	
	40-4C-T12	4	40	300	65	33.0	19.0	3.0	12	50	
	50-4C-T14	4	50	350	70	40.0	23.5	3.0	14	60	
	25-5C	5	25	200	40	17.3	11.5	3.9	5.2	31	
	32-5C	5	32	250	60	20.8	14.0	3.9	4.7	31	
	32-5C-T10	5	32	250	60	27.0	15.0	3.85	10	40	
	40-5C-T12	5	40	300	65	33.0	19.0	3.85	12	50	
	50-5C-T14	5	50	350	70	40.0	23.5	3.85	14	60	
	32-6C	6	32	250	60	20.8	14.0	4.9	4.7	31	
	32-6C-T10	6	32	250	60	27.0	15.0	4.85	10	40	
	40-6C-T12	6	40	300	65	33.0	19.0	4.85	12	50	
	50-6C-T14	6	50	350	70	40.0	23.5	4.85	14	60	
	32-8C	8	32	250	60	21.3	14.5	5.9	5.5	37	
	40-8C	8	40	300	65	25.8	19.0	5.9	5.8	42	

- (1) Insert for grooving only
- Please check insert min. dia for internal grooving B55 page

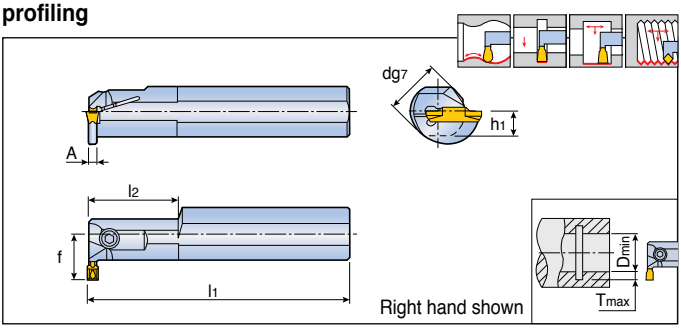
TaeguTec Member IMC Group

TTIR/L

T-CLAMP ULTRA PLUS

Internal turning, grooving and profiling

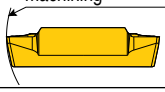




Designation	Insert seat size	Dimension (mm)								Insert
		d	l1	l2	f	h1	A	Tmax	Dmin	
TTIR/L 16-2	2	16	125	-	16.5	7.5	1.8	8.5	25	TDC(1) / J(1) / T
20-2	2	20	160	40	15.8	9.0	1.6	6.0	25	TDXU / XT /
25-2	2	25	200	40	17.5	11.5	1.6	5.0	25	FT / IT
32-2	2	32	250	60	20.8	14.0	1.5	4.7	31	TSC(1) / J(1)
20-3	3	20	160	40	15.8	9.0	2.1	6.0	25	B74-B84
25-3	3	25	200	40	17.5	11.5	2.1	5.1	25	
32-3	3	32	250	60	20.8	14.0	2.1	4.7	31	
20-4	4	20	160	40	15.8	9.0	2.9	6.0	25	
25-4	4	25	200	40	17.5	11.5	2.9	5.2	25	
32-4	4	32	250	60	20.8	14.0	2.9	4.7	31	

• (1) Insert for grooving only • Without "C" on the description: non-coolant hole type
• Please check insert min. dia for internal grooving B55 page

Machining	TDJ/C		TDT		TDT RU		TDXU	
	Size (mm)	Min. dia. (mm)	Size (mm)	Min. dia. (mm)	Size (mm)	Min. dia. (mm)	Size (mm)	Min. dia. (mm)
Internal grooving	2	40	3	40	2	41	2	24
Min. dia. of internal machining	3	50	4	40	3	38	3	24
	4	50	5	50	4	38	4	21
	5	60	6	50	5	43	5	30
	6	60	8	62	6	46	6	31
	8	70			8	56	8	33



Spare parts

Designation	Screw	Wrench	Seal *	
				
TTIR/L 16-2	SH M5x0.8x10	L-W 4	PL 16 (M6)	
TTIR/L 20-2/3/4	SH M5x0.8x12	L-W 4	PL 20 (M6)	
TTIR/L 25-2/3/4	SH M5x0.8x16	L-W 4	PL 25 (R1/8")	
TTIR/L 32-2/3/4	SH M5x0.8x16	L-W 4	PL 32 (R1/8")	
TTIR/L 40-3/4	SH M5x0.8x16	L-W 4	PL 40 (R1/8")	
TTIR/L 50-4	SH M5x0.8x20	L-W 4	PL 40 (R1/8")	
TTIR/L 25-5/6	SH M6x1x16	L-W 5	PL 25 (R1/8")	
TTIR/L 32-5/6	SH M6x1x20	L-W 5	PL 32 (R1/8")	
TTIR/L 40/50-5/6	SH M6x1x25	L-W 5	PL 40 (R1/8")	

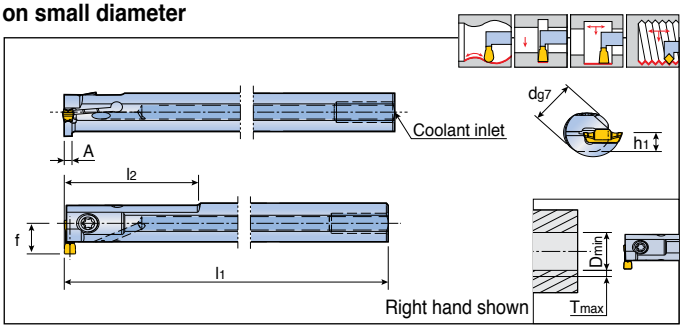
* For through coolant type only

TTSIR/L

T-CLAMP ULTRA PLUS

Internal, grooving and turning on small diameter





Designation		Insert seat size	Dimension (mm)								Coolant inlet	Insert
			d	l1	l2	f	h1	A	Tmax	Dmin		
TTSIR/L	**10-12.5-2**	2	10	125	25	7.5	4.5	1.6	2.4	12.5	Ø3.5	TDIM / TDIP
	12-14-2	2	12	125	35	9.1	5.5	1.6	2.6	14.0	Ø6	B85-B86
	16-12.5-2	2	16	150	20	10.5	7.5	1.6	2.4	12.5	-	
	16-14-2	2	16	150	25	11.0	7.5	1.6	2.6	14.0	-	
	16-16-2	2	16	150	40	11.0	7.5	1.6	3.0	16.0	-	
	12-14-3	3	12	125	35	9.1	5.5	2.0	2.6	14.0	Ø6	
	16-12.5-3	3	16	150	20	10.5	7.5	2.0	2.4	12.5	-	
	16-14-3	3	16	150	25	11.0	7.5	2.0	2.6	14.0	-	
	16-16-3	3	16	150	40	11.0	7.5	2.0	3.0	16.0	-	
	20-20-3	3	20	150	40	14.0	9.0	2.0	4.0	20.0	-	

Spare parts

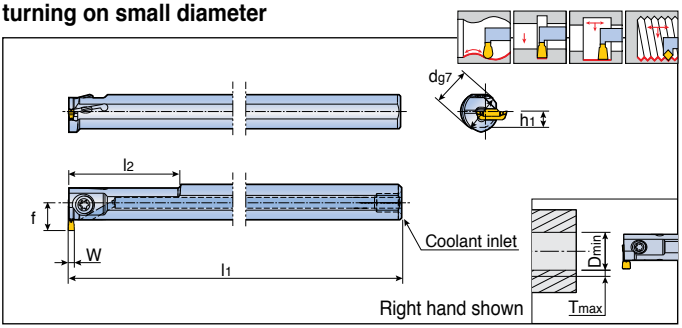
Designation	Screw	Wrench	Seal	
				
TTSIR/L 10/12	TS 40093I	T 15	-	
TTSIR/L 16-12/14	TS 40093I	T 15	PL 16 (M6)	
TTSIR/L 16-16	TS 50125I	T 20	PL 16 (M6)	
TTSIR/L 20	TS 50125I	T 20	PL 20 (M6)	

TGSIR/L

T-CLAMP ULTRA PLUS

Internal shallow grooving and turning on small diameter





Designation		Insert seat size	Dimension (mm)								Coolant inlet	Insert
			d	l1	l2	f	h1	Tmax	Dmin	W		
TGSIR/L	**10-13-2**	2, 3	10	125	25	7.6	5	2.5	12.5	< 2	Ø3.5	TDIM / TDIP
	12-14-2	2, 3	12	125	32	9.0	6	2.5	14.0	< 2	Ø6	B85-B86
	16-13-2	2, 3	16	150	20	10.6	8	2.5	13.0	< 2	-	
	16-14-2	2, 3	16	150	25	10.9	8	2.5	14.0	< 2	-	
	16-16-2	2, 3	16	150	40	10.5	8	2.5	16.0	< 2	-	

Spare parts

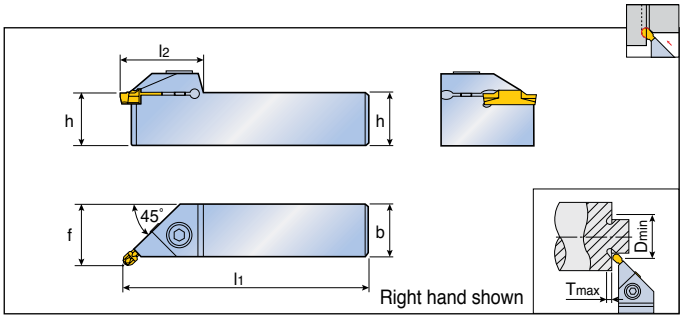
Designation	Screw	Wrench	Seal	
				
TGSIR/L 10/12	TS 40093I	T 15	-	
TGSIR/L 16	TS 40093I	T 15	PL 16 (M6)	

TGEUR/L

T-CLAMP ULTRA PLUS

External undercutting





Designation	Insert seat size	Dimension (mm)							Insert
		h	b	l1	f	l2	Tmax	Dmin	
TGEUR/L 1616-3	2, 3	16	16	110	19.3	30	2.8	32	TDT / TDIT
2020-3	2, 3	20	20	125	23.3	30	2.8	32	B79-B83
2525-3	2, 3	25	25	150	28.3	30	2.8	32	
1616-4	4	16	16	110	19.5	31	2.8	32	
2020-4	4	20	20	125	23.5	31	2.8	32	
2525-4	4	25	25	150	28.5	31	2.8	32	
2525-6	5, 6	25	25	150	28.9	35	3.4	34	

Spare parts

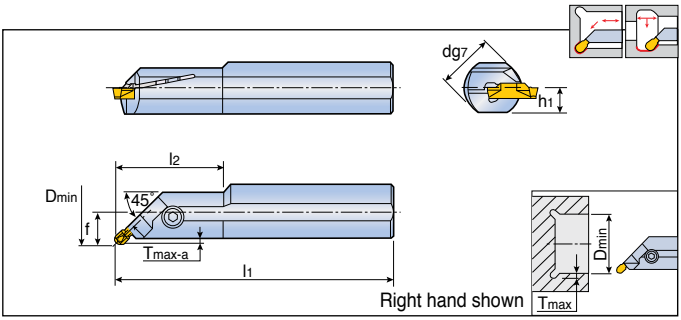
Designation	Screw	Wrench		
				
TGEUR/L 1616-3	SH M5x0.8x16	L-W4		
TGEUR/L 2020-3	SH M5x0.8x20	L-W4		
TGEUR/L 2525-3	SH M5x0.8x25	L-W4		
TGEUR/L 1616-4	SH M6x1x16	L-W5		
TGEUR/L 2020-4	SH M6x1x20	L-W5		
TGEUR/L 2525-4/6	SH M6x1x25	L-W5		

TGIUR/L

T-CLAMP ULTRA PLUS

Internal undercutting





Designation		Insert seat size	Dimension (mm)							Insert
			d	l1	l2	f	h1	Tmax-a	Dmin	
TGIUR/L	**20-3**	2, 3	20	160	-	12.8	9.5	2.8	38	TDT / TDIT
	25-3	2, 3	25	200	40	14.8	11.5	2.8	38	B79-B83
	20-4	4	20	160	-	12.9	9.5	2.8	38	
	25-4	4	25	200	40	14.9	11.5	2.8	46	
	25-6	5, 6	25	200	-	15.2	11.5	2.8	46	

Spare parts

Designation	Screw	Wrench		
				
TGIUR/L 20-3	SH M5x0.8x12	L-W4		
TGIUR/L 20-4	SH M5x0.8x16	L-W4		
TGIUR/L 25-3/4	SH M5x0.8x16	L-W4		
TGIUR/L 25-6	SH M6x1x16	L-W5		

TTER/L-15A

T-CLAMP ULTRA PLUS

Aluminum wheel machining



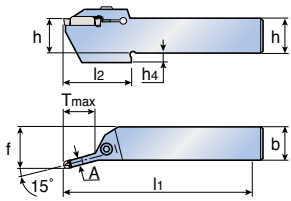


Fig.1

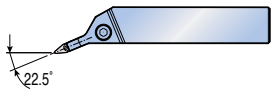


Fig.2

Right hand shown

Designation	Insert seat size	Dimension (mm)								Fig.	Insert
		h	b	l_1	f	l_2	A	h_4	T_{max}		
TTER/L 2525-6-15A	6	25	25	150	30	51	4.90	7	25.0	1	TDA / TSA
2525-8-15A	8	25	25	150	30	55	5.90	7	30.0	1	B87
2525-8V-22.5A*	8	25	25	150	31.7	45	5.85	7	22.0	2	

• * For TDA-35V insert

Spare parts

Designation	Screw	Wrench		
				
TTER/L	SH M6x1x25	L-W5		

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TGIUR/L-15A

T-CLAMP ULTRA PLUS

Aluminum wheel machining



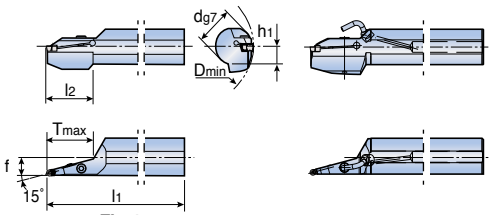


Fig.1 Fig.2 Fig.3

Right hand shown

Designation	Insert seat size	Dimension (mm)							Fig.	Coolant	Insert
		d	l1	l2	f	h1	Tmax	Dmin			
TGIUR/L40-6-15A	6	40	320	60	19.8	19.0	50.00	160	1	External	TDA / TSA
40-6C-15A	6	40	320	60	19.8	19.0	50.00	160	2	Internal	B87
50-6C-15A	6	50	350	85	25.2	23.5	85.00	200	2	Internal	
40-8-15A	8	40	320	65	20.2	19.0	81.35	160	1	External	
40-8C-15A	8	40	320	85	20.2	19.0	83.00	160	2	Internal	
50-8C-15A	8	50	350	85	25.9	23.5	85.00	200	2	Internal	
40-8VC-22.5A*	8	40	320	85	19.3	19.0	35.00	160	3	Internal	

• * For TDA-35V insert

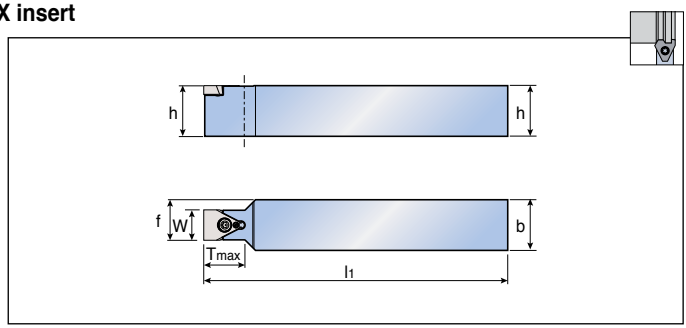
Spare parts

Designation	Screw	Wrench	Seal	Coolant pipe	Coolant nozzle
TGIUR/L	SH M6x1x25	L-W5	PL 40 (R1/8″)	NZP5	NZ125

TTLEN

Semi finished holder for TGUX insert





Designation	Dimension (mm)						Insert (1)
	h	b	f	Tmax	l1	W	
TTLEN 1212 K10	12	12	11.0	20	125	10	TGUX
1616 K10	16	16	13.0	20	125	10	B88
2020 M10	20	20	15.0	20	150	10	
2525 M10	25	25	17.5	20	150	10	
1616 K15	16	16	15.5	20	125	15	
2020 M15	20	20	17.5	20	150	15	
2525 M15	25	25	20.0	20	150	15	
2020 K20	20	20	20.0	35	125	20	
2525 M20	25	25	22.5	35	150	20	
3232 P20	32	32	26.0	35	170	20	
2020 K25	20	20	22.5	35	125	25	
2525 M25	25	25	25.0	35	150	25	
3232 P25	32	32	28.5	35	170	25	

• (1) Designation of final insert will be different to the semi finished blank

Spare parts

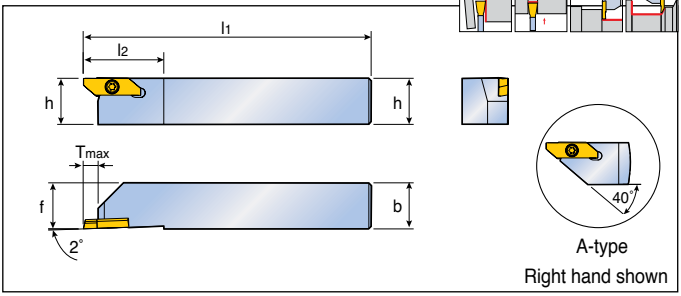
Designation	Screw	Wrench		
				
TTLEN ...K10/K15/M10/M15	TS 40B100I	T15		
TTLEN ...K20/M20/P20	TS 45120I	T20		
TTLEN ...K25/M25/P25	TS 45120I	T20		

TTVER/L

TOPCUT

Holders for grooving, parting, turning & reverse turning





Designation		Dimension (mm)						Insert
		h	b	l1	l2	Tmax	f	
TTVER/L	**1010-4-A**	10	10	125	29	6.7	9.9	TVER/L
	1212-4-A	12	12	125	29	6.7	11.9	TVRR/L
	1616-4	16	16	125	29	6.5	15.9	TVPR/L
	2020-4	20	20	125	29	6.5	19.9	B103,B105
	2525-4	25	25	125	29	6.5	24.9	

• Please keep in your mind selecting right insert

Spare parts

Designation	Screw	Wrench		
				
TTVER/L	CSTB-4SD	T 8		

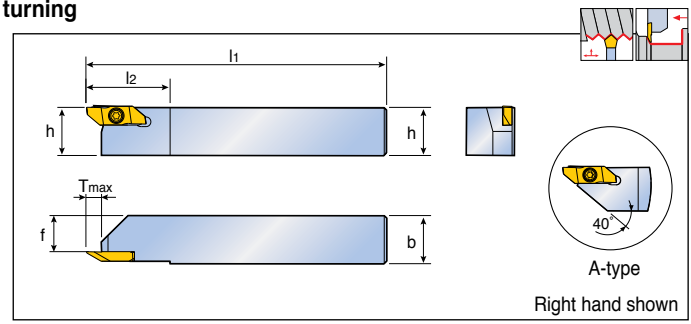
TaeguTec Member IMC Group

TTVBR/L

TOPCUT

Holders for threading & back turning





Designation		Dimension (mm)						Insert
		h	b	l1	l2	Tmax	f	
TTVBR/L	**1010-4-A**	10	10	125	29	6.7	5.7	TVBR/L
	1212-4-A	12	12	125	29	6.7	7.7	TVTR/L
	1616-4	16	16	125	29	6.4	11.7	B104
	2020-4	20	20	125	29	6.4	15.7	
	2525-4	25	25	125	29	6.4	20.7	

• Please keep in your mind selecting right insert

Spare parts

Designation	Screw	Wrench		
				
TTVBR/L	CSTB-4SD	T 8		

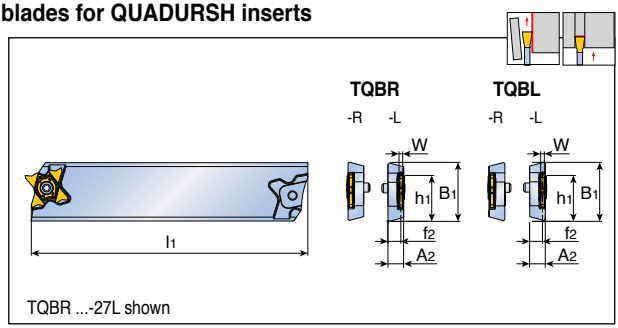
TaeguTec
Member IMC Group

TQBR/L

QUAD•RUSH

Double ended parting and grooving blades for QUADURSH inserts





TQBR ...-27L shown

Designation		Dimension (mm)						Block	Insert
		B_1	W_{range}	l_1	h_1	A_2	f_2 *		
TQBR/L	**26-27R**	26	0.5 ≤ W < 5.3	150	21.4	8.5	7	TTBN/U..-26	TQ.. 27
	26-27L	26	0.5 ≤ W < 5.3	150	21.4	8.5	7	TTBN/U..-26	B107-B116
	32-27R	32	0.5 ≤ W < 5.3	150	24.9	8.5	7	TTBN/U..-32	
	32-27L	32	0.5 ≤ W < 5.3	150	24.9	8.5	7	TTBN/U..-32	

- * : To the center of inserts up to 3.2mm width

Spare parts

Designation	Screw	Wrench		
				
TQBR/L 26-27R	TS 50125I	T 10/20		
TQBR/L 26-27L	TS 50125IL	T 10/20		
TQBR/L 32-27R	TS 50125I	T 10/20		
TQBR/L 32-27L	TS 50125IL	T 10/20		

Cutting Condition B128

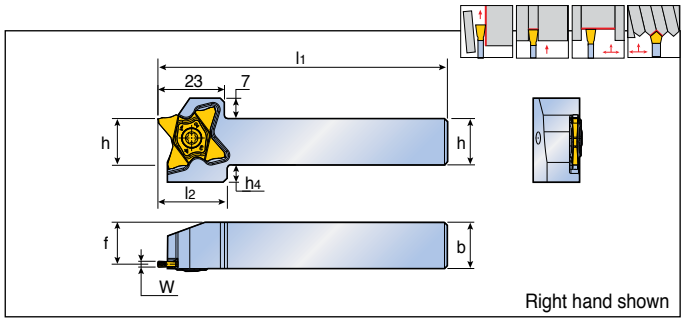
TaeguTec Member IMC Group

TQHR/L

QUAD•RUSH

Integral shank toolholders





Designation		Dimension (mm)							Insert
		h	b	Wrange	f(2)	l1	l2	h4	
TQHR/L	**10-27**	10	10	0.5 ≤ W < 5.3	8.5	120	24	9	TQ.. 27
	12-27	12	12	0.5 ≤ W < 5.3	10.5	120	24	8	B107-B116
	16-27	16	16	0.5 ≤ W < 5.3	14.5	120	24	6	
	20-27	20	20	0.5 ≤ W < 5.3	18.5	120	24	2	
	25-27	25	25	0.5 ≤ W < 5.3	23.5	135	-	-	
	16-27-8 (1)	16	16	5.3 ≤ W ≤ 8.2	14.0	120	24	6	TQS 27
	20-27-8 (1)	20	20	5.3 ≤ W ≤ 8.2	18.0	120	24	2	
	25-27-8 (1)	25	25	5.3 ≤ W ≤ 8.2	23.0	135	-	-	B113-B116

- (1) Only for TQS wider inserts from 5.3mm-8.2mm width
- (2) " f " value is based on TQ.. 27 standard insert

Spare parts

Designation	Screw	Wrench		
				
TQHR/L 10/12/16/20/25	TS 50125I (1)	T 10/20		
	TS 50125IL(2)	T 10/20		
TQHR/L 16/20/25-27-8	TS 501701I-IC (3)	T 15		
	TS 501701IL-IC (4)	T 15		

Cutting Condition B128

- (1)(3) For left holder
- (2)(4) For right holder

TaeguTec

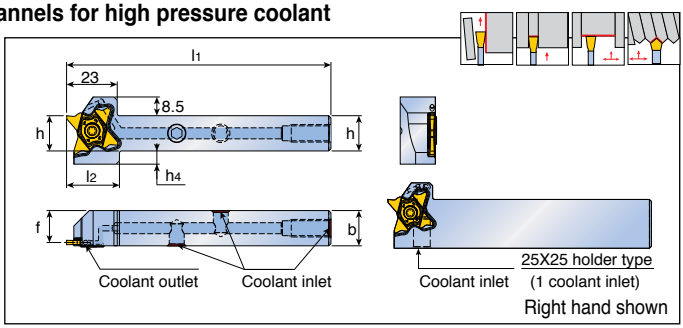
TQHR/L-TB

QUAD•RUSH

Grooving and turning with channels for high pressure coolant



T-BURST HIGH PRESSURE



Designation		Dimension (mm)						Coolant inlet	Insert
		h	b	l1	f	l2	h4		
TQHR/L	**12-27-TB**	12	12	120	10.5	24	8	UNF 5/16	TQ.. 27 B107-B116
	16-27-TB	16	16	120	14.5	24	6	UNF 5/16	
	20-27-TB	20	20	120	18.5	24	2	G1/8 BSPP	
	25-27-TB	25	25	135	23.5	-	-	G1/8 BSPP	

		70 bar flow rate (ℓ/min)	100 bar flow rate (ℓ/min)	140 bar flow rate (ℓ/min)
TQHR/L-	**TB**	9-11	11-13	12-14

Spare parts

Designation	Screw	Wrench	Inlet plug	Wrench for inlet plug
TQHR/L 12-27-TB	TS 50125I (1) TS 50125IL (2)	T 10/20	PLG 5/16 UNF	L-W 5/32″
TQHR/L 16-27-TB		T 10/20	PLG 5/16 UNF	L-W 5/32″
TQHR/L 20-27-TB		T 10/20	PLG G1/8-L6.5	L-W 5
TQHR/L 25-27-TB		T 10/20	-	-

Cutting Condition B128

• (1) For TQHL • (2) For TQHR

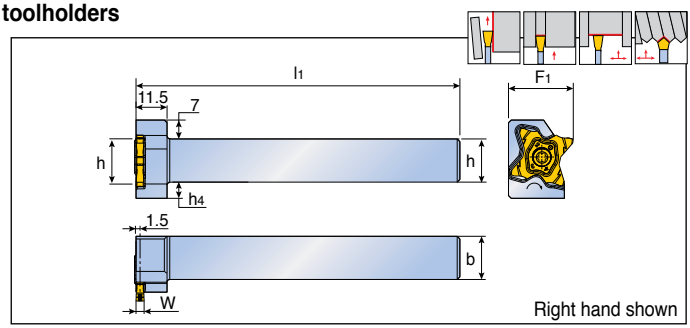
TaeguTec Member IMC Group

TQHPR/L

QUAD•RUSH

Perpendicular integral shank toolholders





Designation		Dimension (mm)						Insert
		h	b	Wrange	F1	l1	h4	
TQHPR/L	**16-27**	16	16	0.5 ≤ W < 5.3	24	120	6	TQ.. 27 B107-B116
	20-27	20	20	0.5 ≤ W < 5.3	28	120	2	
	25-27	25	25	0.5 ≤ W < 5.3	33	135	-	
	16-27-8 (1)	16	16	5.3 ≤ W ≤ 8.2	24	120	6	TQS 27 B113-B116
	20-27-8 (1)	20	20	5.3 ≤ W ≤ 8.2	28	120	2	
	25-27-8 (1)	25	25	5.3 ≤ W ≤ 8.2	33	135	-	

• (1) Only for TQS wider inserts from 5.3mm-8.2mm width

Spare parts

Designation	Screw	Wrench		
				
TQHPR/L 16/20/25	TS 50125I (1)	T 20		
	TS 50125IL(2)	T 20		
TQHPR/L 16/20/25-8	TS 501701I-IC (3)	T 15		
	TS 501701IL-IC (4)	T 15		

Cutting Condition B128

• (1)(3) For right holder • (2)(4) For left holder

TaeguTec Member IMC Group

Hose

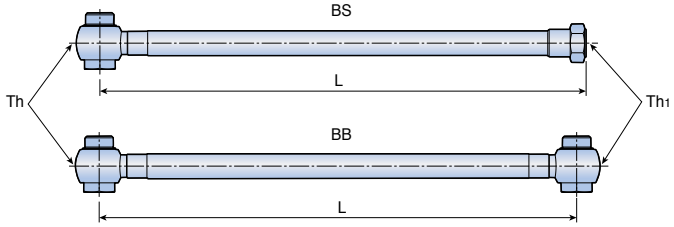


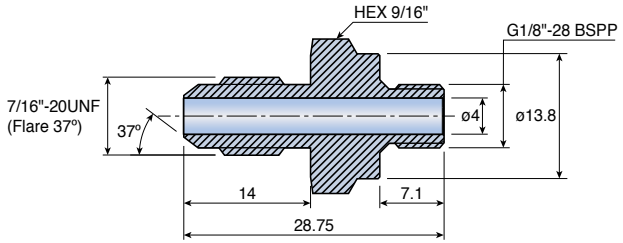
Fig.1

Fig.2

Designation		Dimension				Fig.
		L(mm)	Th	Th1	Max. pressure(Bar)	
TB HOSE	**G1/8-7-16-200BS**	200	G1/8"-28 BSPP	7/16"-20 UNF (Flare 37°)	260	1
	G1/8-7/16-250BS	250	G1/8"-28 BSPP	7/16"-20 UNF (Flare 37°)	260	1
	G1/8-G1/8-200BB	200	G1/8"-28 BSPP	G1/8"-28 BSPP	260	2
	G1/8-G1/8-250BB	250	G1/8"-28 BSPP	G1/8"-28 BSPP	260	2
	5/16-7/16-200BS	200	5/16"-24 UNF	7/16"-20 UNF (Flare 37°)	200	1
	5/16-G1/8-200BS	200	5/16"-24 UNF	G1/8"-28 BSPP	200	1

• Hose is ordered separately

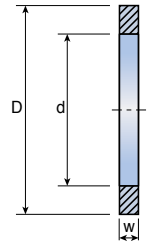
Adapter



Designation
TB NIPPLE G1/8-7/16 UNF

• Adapter is ordered separately

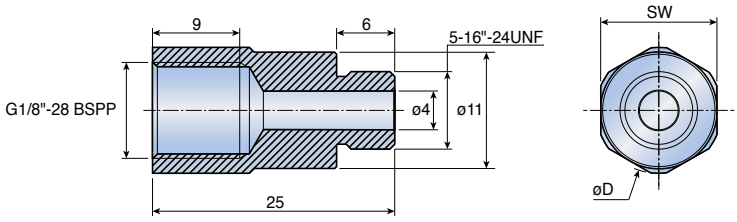
Seal washer



Designation		Dimension (mm)		
		D	d	w
TB COPPER	**SEAL 1/8"**	15	10	1
	SEAL 5/16"	12	8	1

• Seal washer is ordered separately

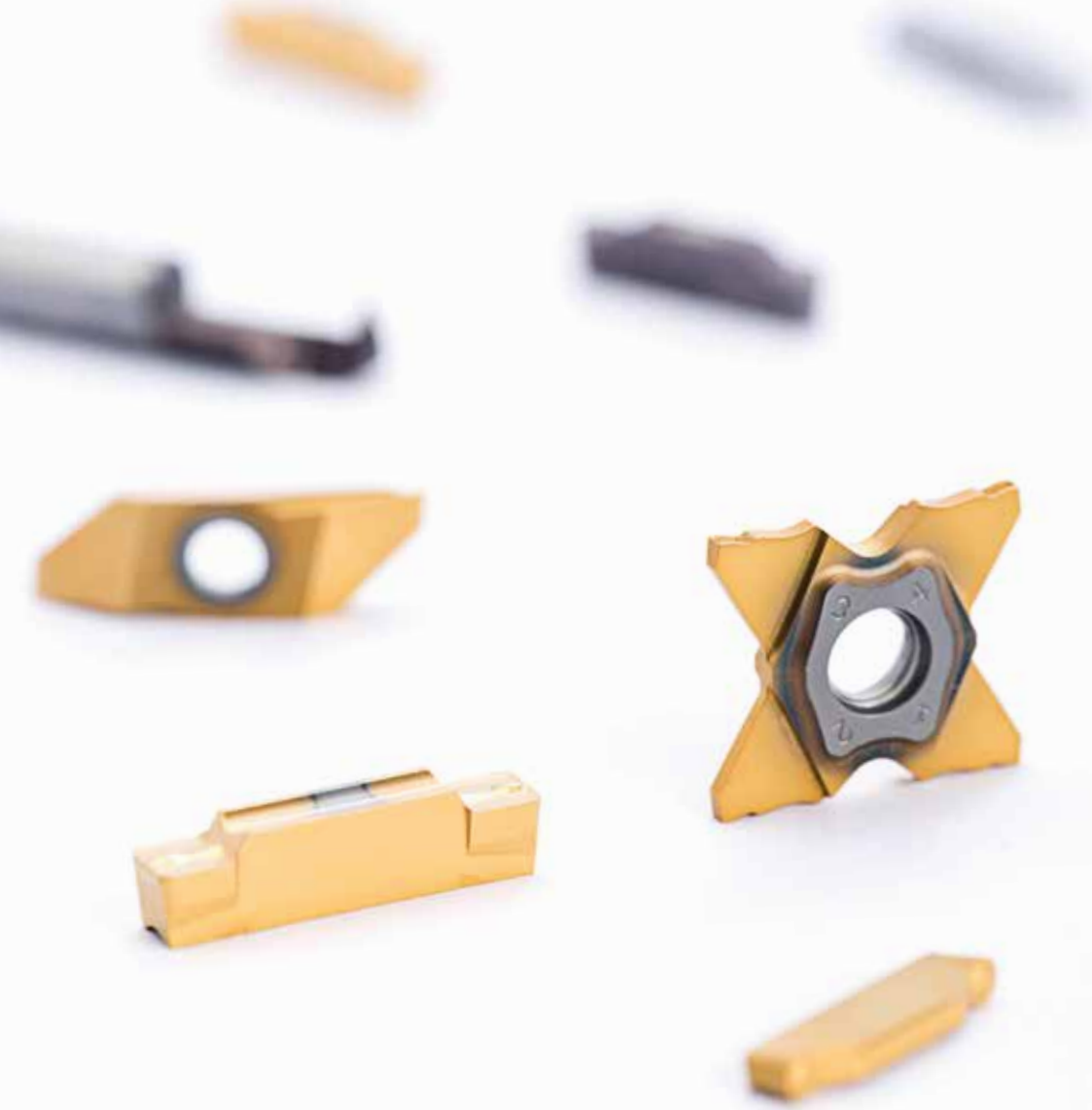
Connector



Designation		Dimension (mm)	
		D	SW
TB CONECTOR	**5/16"-G1/8"**	13	12
	5/16"-G1/8"-12	12	11

• Connector is ordered separately

Parting & Grooving Inserts and Solid Bars



Insert Designation System

Parting and grooving

Only for handed insert

T	D	C	3	-	6	R	S
1	2	3	4		5	6	7

1 TaeguTec

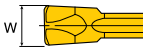
2 Cutting edge type

 S	 D
Single ended insert	Double ended insert

3 Chip breaker type

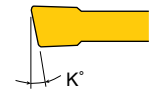
 C	 J
For medium	For light

4 Width of insert



2 = 2.0 mm
3 = 3.0 mm
4 = 4.0 mm
5 = 5.0 mm
6 = 6.0 mm

5 Lead angle



6 Hand of insert

 L	 R
Left hand	Right hand

7 Corner type

 S	
Sharp corner	Standard corner radius

TaeguTec
Member IMC Group

Insert Designation System

Turning, grooving and face machining

T	D	(F)	T	3.00	E	-	0.40	R
1	2	3	4	5	6		7	8

1 TaeguTec

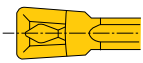
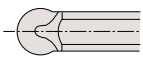
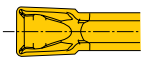
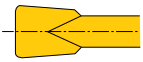
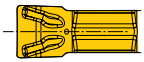
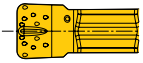
2 Cutting edge type

 S	 D
Single ended insert	Double ended insert

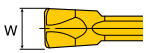
3 Application type

F	Face turning and grooving
I	Internal turning and grooving
X	Universal

4 Chip breaker type

 T	 A	 U	 G	 M	 P
For steel, high-temp. alloy and cast iron	For aluminum	Universal chip breaker	Without chip breaker	Pressed for small diameter	Ground for small diameter

5 Width of insert (mm)

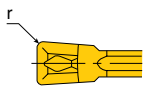


□.□□	Precision insert
□	Pressed insert

6 Application type

E	For turning and grooving
No designation	For precision grooving

7 Corner radius (mm)



□.□□	Precision insert
□.□	Pressed insert

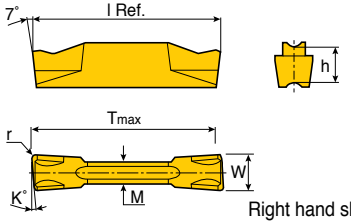
8 Hand of insert - For face machining

 L	 R
Left hand insert on left hand holder	Right hand insert on right hand holder

TaeguTec Member IMC Group

TDC

Double ended inserts for parting and grooving with "C" type chip breaker

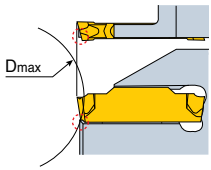


Right hand shown

Size	Dimension (mm)						
	W±0.05	r	M	l	K	h	Tmax
2 (..R/L)	2.0	0.20	1.7	20.0	0-15	4.7	19
2 RS/LS	2.0	0.02	1.7	19.6	15	4.7	19
3 (..R/L)	3.0	0.20	2.4	20.0	0-15	4.7	19
3 RS/LS	3.0	0.02	2.4	19.6	6-15	4.7	19
4 (..R/L)	4.0	0.30	3.0	20.0	0-15	4.7	19
5 (..R/L)	5.0	0.30	4.0	25.0	0-4	5.2	24
6	6.0	0.30	5.0	25.0	-	5.2	24
8	8.0	0.40	6.0	30.0	-	6.4	29

Insert	Designation	Insert seat size	Feed (mm/rev)	Cermet		Coated						Uncoated
				PV3030	CT3000	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10
	**TDC 2**	2	0.05-0.18	●	●				●	●	●	●
	2-6R/L	2	0.04-0.14						●	●	●	●
	2-8R/L	2	0.04-0.14							●	●	
	2-15R/L	2	0.04-0.12						●	●	●	
	2-15RS/LS	2	0.02-0.12						●	●	●	
	3	3	0.07-0.25	●	●				●	●	●	●
	3-6R/L	3	0.06-0.18						●	●	●	●
	3-6RS/LS	3	0.03-0.18						●	●		
	3-15R/L	3	0.06-0.16						●	●	●	
	3-15RS/LS	3	0.03-0.16							●	●	
	4	4	0.08-0.30		●				●	●	●	●
	4-4R/L	4	0.06-0.24						●	●	●	●
	4-15R/L	4	0.06-0.22							●	●	
	5	5	0.09-0.35		●				●	●	●	●
	5-4R/L	5	0.07-0.28						●	●	●	
	6	6	0.12-0.40		●				●	●	●	●
	8	8	0.14-0.43						●		●	

●: Standard item



Dmax (mm) for parting & grooving

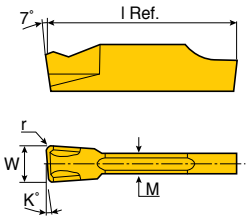
Insert	Dmax (mm)
TDC 2-15 RS/LS	28
TDC 3-15 RS/LS	29
TDC 4-5 R/L	30

- Standard holders (except TGFR xxxx) will be damaged if workpiece diameter goes over the dimension of each insert in the table.

Technical Data
B130

TSC

Single ended inserts for deep grooving and parting with "C" type chip breaker

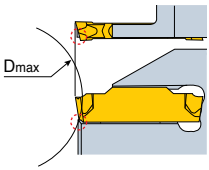


Right hand shown

Size	Dimension (mm)					
	W±0.05	r	M	l	K	h
2 (..R/L)	2.0	0.20	1.7	20.0	0-15	4.7
2 RS/LS	2.0	0.02	1.7	19.6	15	4.7
3 (..R/L)	3.0	0.20	2.4	20.0	0-15	4.7
3 RS/LS	3.0	0.02	2.4	19.6	15	4.7
4 (..R/L)	4.0	0.30	3.0	20.0	0-15	4.7
5 (..R/L)	5.0	0.30	4.0	25.0	0-4	5.2
6	6.0	0.30	5.0	25.0	-	5.2
8	8.0	0.40	6.0	30.0	-	6.4

Insert	Designation	Insert seat size	Feed (mm/rev)	Cermet		Coated						Uncoated
				PV3030	CT3000	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10
	**TSC 2**	2	0.05-0.18						●	●	●	●
	2-6R/L	2	0.04-0.14						●	●	●	●
	2-8R/L	2	0.04-0.14							●	●	
	2-15R/L	2	0.04-0.12							●	●	
	2-15RS/LS	2	0.02-0.12							●	●	
	3	3	0.07-0.25						●	●	●	●
	3-6R/L	3	0.06-0.18						●	●	●	●
	3-15R/L	3	0.06-0.16							●	●	
	3-15RS/LS	3	0.03-0.16							●	●	
	4	4	0.08-0.30						●	●	●	
	4-4R/L	4	0.06-0.24						●	●	●	●
	4-6R/L	4	0.06-0.23							●		●
	4-15R/L	4	0.06-0.22							●	●	
	5	5	0.09-0.35						●	●	●	●
	5-4R/L	5	0.07-0.28							●	●	
	6	6	0.12-0.40						●	●	●	●
	8	8	0.14-0.43						●		●	

●: Standard item



Dmax (mm) for parting & grooving

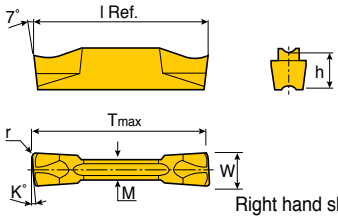
Insert	Dmax (mm)
TSC 3-15 R/L	96

- Standard holders (except TGFR xxxx) will be damaged if workpiece diameter goes over the dimension of each insert in the table.

Technical Data
B130

TDJ

Double ended inserts for parting and grooving with "J" type chip breaker



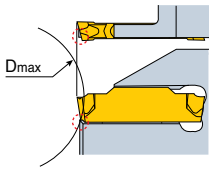
Right hand shown

Size	Dimension (mm)						
	W±0.05	r	M	l	K	h	Tmax
1.4	1.4	0.16	1.0	16.0	-	4.0	15
2 (..R/L)	2.0	0.20	1.7	20.0	0-15	4.7	19
2 RS/LS	2.0	0.02	1.7	19.6	6-15	4.7	19
3 (..R/L)	3.0	0.20	2.4	20.0	0-15	4.7	19
3 RS/LS	3.0	0.02	2.4	19.6	6-15	4.7	19
4 (..R/L)	4.0	0.30	3.0	20.0	0-15	4.7	19
5 (..R/L)	5.0	0.30	4.0	25.0	0-4	5.2	24
6	6.0	0.30	5.0	25.0	-	5.2	24



Insert	Designation	Insert seat size	Feed (mm/rev)	Cermet		Coated						Uncoated	
				PV3030	CT3000	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10	
	TDJ 1.4	1	0.02-0.10						●		●		
	2	2	0.04-0.12						●	●	●	●	
	2-6R/L	2	0.03-0.08						●	●	●	●	
	2-6RS/LS	2	0.03-0.07						●	●	●		
	2-8R/L	2	0.03-0.08						●	●	●		
	2-15R/L	2	0.03-0.08						●	●	●		
	2-15RS/LS	2	0.03-0.07						●	●	●		
	3	3	0.04-0.16		●				●	●	●	●	
	3-6R/L	3	0.03-0.12						●	●	●	●	
	3-6RS/LS	3	0.03-0.10							●	●		
	3-15R/L	3	0.03-0.12						●	●	●		
	3-15RS/LS	3	0.03-0.10							●	●		
	4	4	0.05-0.18						●	●	●	●	
	4-4R/L	4	0.05-0.14						●	●	●	●	
	4-15R/L	4	0.05-0.12							●	●	●	
	5	5	0.05-0.20						●	●	●	●	
	5-4R/L	5	0.05-0.16							●	●	●	
	6	6	0.05-0.22						●	●	●	●	

●: Standard item



Dmax (mm) for parting & grooving

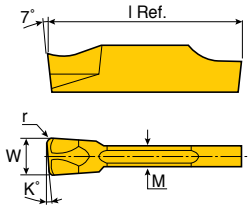
Insert	Dmax (mm)
TDJ 2-15 RS/LS	28
TDJ 3-15 RS/LS	29
TDJ 4-15 R/L	30

- Standard holders (except TGFR xxxx) will be damaged if workpiece diameter goes over the dimension of each insert in the table.

Technical Data
B130

TSJ

Single ended inserts for deep grooving and parting with "J" type chip breaker

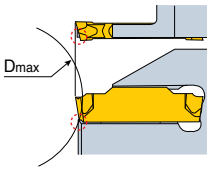


Right hand shown

Size	Dimension (mm)					
	W±0.05	r	M	l	K	h
2 (..R/L)	2.0	0.20	1.7	20.0	0-15	4.7
2 RS/LS	2.0	0.02	1.7	19.8	15	4.7
3 (..R/L)	3.0	0.20	2.4	20.0	0-15	4.7
3 RS/LS	3.0	0.02	2.4	19.8	6-15	4.7
4 (..R/L)	4.0	0.30	3.0	20.0	0-6	4.7
5 (..R/L)	5.0	0.30	4.0	25.0	0-4	5.2
6	6.0	0.30	5.0	25.0	-	5.2

Insert	Designation	Insert seat size	Feed (mm/rev)	Cermet		Coated						Uncoated
				PV3030	CT3000	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10
	**TSJ 2**	2	0.04-0.12						●	●	●	●
	2-6R/L	2	0.03-0.08							●	●	●
	2-15R/L	2	0.03-0.08							●	●	
	2-15RS/LS	2	0.03-0.08							●	●	
	2-8R/L	2	0.03-0.07								●	
	3	3	0.04-0.16						●	●	●	●
	3-6R/L	3	0.03-0.12						●	●	●	●
	3-6RS/LS	3	0.03-0.10						●	●	●	
	3-15R/L	3	0.03-0.12							●	●	
	3-15RS/LS	3	0.03-0.10							●	●	
	4	4	0.05-0.18						●	●	●	●
	4-4R/L	4	0.05-0.14							●	●	
	4-6R/L	4	0.05-0.12							●		
	5	5	0.05-0.20						●	●	●	●
	5-4R/L	5	0.05-0.16							●	●	
	6	6	0.05-0.22						●	●	●	●

●: Standard item



Dmax (mm) for parting & grooving

Insert	Dmax (mm)
TSJ 3-15 R/L	103
TSJ 3-15 RS/LS	34

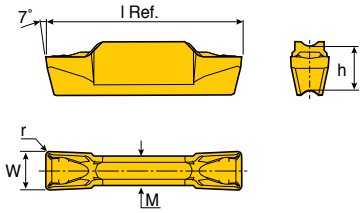
- Standard holders (except TGFR xxxx) will be damaged if workpiece diameter goes over the dimension of each insert in the table.

Technical Data B130

TDXU-E

T-CLAMP ULTRA PLUS

Pressed inserts for external, internal, face turning, grooving and parting



Size	Dimension (mm)				
	W±0.05	r	M	l	h
2E-0.3	2.0	0.3	1.7	20.0	4.7
3E-0.3	3.0	0.3	2.2	20.0	4.7
4E-0.4	4.0	0.4	3.0	20.0	4.7
4E-0.8	4.0	0.8	3.0	20.0	4.7
5E-0.4	5.0	0.4	4.0	25.0	5.2
5E-0.8	5.0	0.8	4.0	25.0	5.2
6E-0.4	6.0	0.4	5.0	25.0	5.2
6E-0.8	6.0	0.8	5.0	25.0	5.2
8E-0.8	8.0	0.8	6.0	30.0	6.4

Insert	Designation	Insert seat size	Turning		Grooving	Cermet		Coated							Uncoated
			Feed (mm/rev)	ap (mm)	Feed (mm/rev)	PV3030	CT3000	TT7505	TT6080	TT8125	TT5100	TT9080	TT7220	TT8020	K10
	**TDXU 2E-0.3**	2	0.12-0.18	0.4-1.2	0.03-0.18			●	●		●	●		●	●
	3E-0.3	3	0.15-0.19	0.4-1.8	0.07-0.11	●	●	●	●	●	●	●	●	●	●
	4E-0.4	4	0.18-0.24	0.5-2.4	0.09-0.15	●	●	●	●	●	●	●	●	●	●
	4E-0.8	4	0.18-0.24	1.0-2.4	0.09-0.15		●	●	●	●	●	●	●	●	●
	5E-0.4	5	0.20-0.30	0.5-3.0	0.11-0.20		●	●	●		●	●	●	●	●
	5E-0.8	5	0.23-0.35	1.0-3.0	0.11-0.21		●	●	●		●	●	●	●	
	6E-0.4	6	0.22-0.36	0.5-3.6	0.13-0.23			●	●		●	●	●	●	
	6E-0.8	6	0.24-0.42	1.0-3.6	0.13-0.25			●	●		●	●	●	●	
	8E-0.8	8	0.30-0.56	1.0-4.8	0.15-0.34			●	●		●	●	●	●	

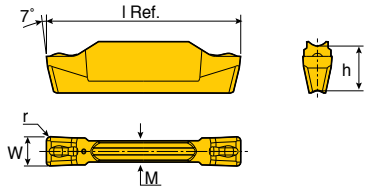
Technical Data B132

●: Standard item

TDXT-E

T-CLAMP ULTRA PLUS

Pressed inserts for external, internal, face turning and grooving



Size	Dimension (mm)				
	W±0.05	r	M	l	h
3E-0.4	3.0	0.4	2.2	20.0	4.7
4E-0.4	4.0	0.4	3.0	20.0	4.7
5E-0.4	5.0	0.4	4.0	25.0	5.2
6E-0.8	6.0	0.8	5.0	25.0	5.2
8E-0.8	8.0	0.8	6.0	30.0	6.4

Insert	Designation	Insert seat size	Turning		Grooving	Cermet		Coated						Uncoated
			Feed (mm/rev)	ap (mm)	Feed (mm/rev)	PV3030	CT3000	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10
	**TDXT 3E-0.4**	3	0.15-0.22	0.5-1.8	0.07-0.15		●	●	●	●	●			●
	4E-0.4	4	0.18-0.30	0.5-2.4	0.09-0.18		●	●	●	●	●			●
	5E-0.4	5	0.20-0.35	0.5-3.0	0.11-0.20		●	●	●	●	●			●
	6E-0.8	6	0.24-0.42	1.0-3.6	0.13-0.30			●	●	●	●			●
	8E-0.8	8	0.30-0.56	1.0-4.8	0.15-0.40			●	●	●	●			●

Technical Data B131

• Non-standard grade production available at the customer's request

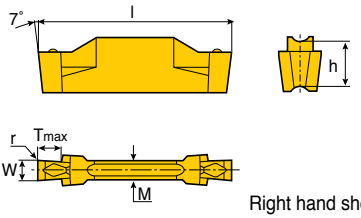
●: Standard item

TaeguTec Member IMC Group

TDT

T-CLAMP ULTRA PLUS

Precision inserts for external grooving only



Right hand shown

Size	Dimension (mm)					
	W±0.02	r ±0.05	M	l	Tmax	h
1.00	1.00	0.00	2.2	20.0	2.5	4.7
1.30	1.30	0.00	2.2	20.0	2.5	4.7
1.60	1.60	0.10	2.2	20.0	2.5	4.7
1.85	1.85	0.10	2.2	20.0	3.5	4.7
2.15	2.15	0.15	2.2	20.0	3.5	4.7

Insert	Designation	Insert seat size	Grooving	Cermet		Coated						Uncoated
			Feed (mm/rev)	PV3030	CT3000	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10
	**TDT 1.00-0.00***	2	0.02-0.04						●	●		●
	1.30-0.00*	2	0.02-0.05						●	●		●
	1.60-0.10*	2	0.03-0.07						●	●		●
	1.85-0.10*	2	0.03-0.09						●	●		●
	2.15-0.15	2	0.03-0.10						●	●		●

Technical Data B131 B46

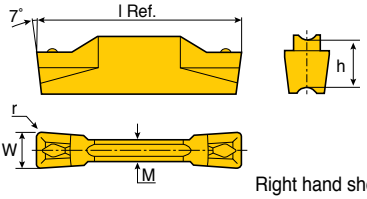
• *: Only for grooving. Please use TGFR/L ...-4 holder

●: Standard item

TDT-E

T-CLAMP ULTRA PLUS

Pressed inserts for external turning and grooving



Right hand shown

Size	Dimension (mm)				
	W±0.05	r	M	l	h
3	3.0	0.4	2.2	20.0	4.7
4	4.0	0.4	3.0	20.0	4.7
6	6.0	0.8	5.0	25.0	5.2

Insert	Designation	Insert seat size	Turning		Grooving	Cermet		Ceramic	Coated							Uncoated
			Feed (mm/rev)	ap (mm)	Feed (mm/rev)	PV3030	CT3000	AB30	TT7505	TT6080	TT8125	TT5100	TT9080	TT7220	TT8020	K10
 CE type	**TDT 3E-0.4**	3	0.15-0.22	0.5-1.8	0.07-0.15		●		●	●	●	●	●	●		●
	4E-0.4	4	0.18-0.30	0.5-2.4	0.09-0.18		●		●	●		●	●	●		●
	4E-0.4T CE(1)	4	0.18-0.30	0.5-2.4	0.09-0.35			●								
	6E-0.8T CE(1)	6	0.24-0.42	1.0-3.6	0.13-0.40			●								

Technical Data B131

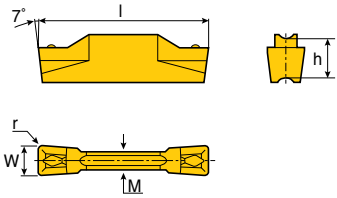
• (1)This insert is a pressed ceramic insert

●: Standard item

TaeguTec Member IMC Group

TDT-E

Precision inserts for external turning and grooving



Size	Dimension (mm)				
	W±0.02	r	M	l	h
2.65 / 3.00 / 3.15	2.65-3.15	0.15-0.40	2.2	20.0	4.7
4.00 / 4.15	4.00-4.15	0.15-0.80	3.0	20.0	4.7
4.78 / 5.00 / 5.15	4.78-5.15	0.15-0.80	4.0	25.0	5.2
6.00	6.00	0.80-1.20	5.0	25.0	5.2
8.00	8.00	0.80-1.20	6.0	30.0	6.4
10.00	10.00	0.80-2.00	8.0	30.0	6.4

Insert	Designation	Insert seat size	Turning		Grooving	Cermet		Coated						Uncoated
			Feed (mm/rev)	ap (mm)	Feed (mm/rev)	PV3030	CT3000	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10
	**TDT 2.65E-0.15**	3	0.10-0.18	0.2-1.8	0.05-0.12				●		●	●		●
	3.00E-0.20	3	0.12-0.20	0.3-2.0	0.07-0.13				●		●	●		●
	3.00E-0.40	3	0.15-0.22	0.5-2.0	0.07-0.15				●		●	●		●
	3.15E-0.15	3	0.15-0.22	0.2-2.0	0.07-0.15				●		●	●		●
	4.00E-0.40	4	0.18-0.30	0.5-2.4	0.09-0.18				●		●	●		●
	4.00E-0.80	4	0.18-0.30	1.0-2.4	0.09-0.18				●		●	●	●	●
	4.15E-0.15	4	0.18-0.30	0.5-2.4	0.09-0.18				●		●	●		●
	4.78E-0.55	5	0.20-0.35	0.7-2.8	0.10-0.20				●		●	●		●
	5.00E-0.40	5	0.20-0.35	0.5-2.3	0.11-0.20				●		●	●		
	5.00E-0.80	5	0.23-0.35	1.0-3.0	0.11-0.21				●		●	●		●
	5.15E-0.15	5	0.23-0.35	0.2-3.0	0.11-0.21				●		●	●		●
	6.00E-0.80	6	0.24-0.42	1.0-3.6	0.13-0.30				●		●	●		●
	6.00E-1.20	6	0.24-0.42	1.3-3.6	0.13-0.30				●		●	●		●
	8.00E-0.80	8	0.30-0.56	1.0-4.8	0.15-0.40				●		●	●		●
	8.00E-1.20	8	0.30-0.56	1.3-4.8	0.15-0.40				●		●	●		●
	10.00E-0.80	10	0.35-0.65	1.0-6.0	0.20-0.45				●					
	10.00E-1.20	10	0.40-0.80	1.0-6.0	0.20-0.45				●		●			
	10.00E-2.00	10	0.35-0.80	1.0-6.0	0.20-0.45				●		●			

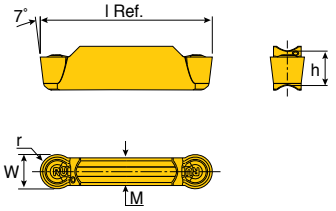
●: Standard item

Technical Data B131

TDT-RU (Full-Radius)

T-CLAMP ULTRA PLUS

Pressed inserts for external turning, grooving and profiling



Size	Dimension (mm)				
	W±0.05	r	M	l	h
2	2.0	1.0	1.7	20.0	4.7
3	3.0	1.5	2.2	20.0	4.7
4	4.0	2.0	3.0	20.0	4.7
5	5.0	2.5	4.0	25.0	5.2
6	6.0	3.0	5.0	25.0	5.2
8	8.0	4.0	6.0	30.0	6.4

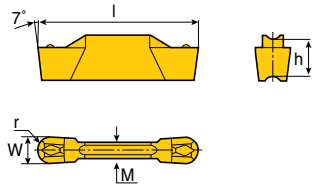
Insert	Designation	Insert seat size	Turning		Grooving	Cermet		Coated							Uncoated
			Feed (mm/rev)	ap (mm)	Feed (mm/rev)	PV3030	CT3000	TT7505	TT6080	TT8125	TT5100	TT9080	TT7220	TT8020	K10
	**TDT 2E-1.0-RU**	2	0.10-0.25	0.0-1.0	0.05-0.15			●	●		●	●	●		●
	3E-1.5-RU	3	0.15-0.28	0.0-1.5	0.08-0.18	●	●	●	●	●	●	●	●		●
	4E-2.0-RU	4	0.18-0.35	0.0-2.0	0.10-0.20	●	●	●	●		●	●	●		●
	5E-2.5-RU	5	0.20-0.42	0.0-2.5	0.12-0.23	●	●	●	●		●	●	●		●
	6E-3.0-RU	6	0.25-054	0.0-3.0	0.15-0.27	●	●	●	●	●	●	●	●		●
	8E-4.0-RU	8	0.30-0.67	0.0-4.0	0.18-0.35	●	●	●	●		●	●	●		●

●: Standard item

TDT-E (Full-Radius)

T-CLAMP ULTRA PLUS

Precision inserts for external turning, grooving and profiling



Size	Dimension (mm)				
	W±0.02	r ±0.05	M	l	h
3	3.00	1.50	2.2	20.0	4.7
4	4.00	2.00	3.0	20.0	4.7
4.78	4.78	2.39	4.0	25.0	5.2
5	5.00	2.50	4.0	25.0	5.2
6	6.00	3.00	5.0	25.0	5.2
8	8.00	4.00	6.0	30.0	6.4
10	10.00	5.00	8.0	30.0	6.4

Insert	Designation	Insert seat size	Turning		Grooving	Cermet		Coated						Uncoated
			Feed (mm/rev)	ap (mm)	Feed (mm/rev)	PV3030	CT3000	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10
	**TDT 3.00E-1.50**	3	0.15-0.28	0.0-1.5	0.08-0.18					●	●	●		●
	4.00E-2.00	4	0.18-0.35	0.0-2.0	0.10-0.20					●	●	●	●	●
	4.78E-2.39	5	0.20-0.42	0.0-2.4	0.12-0.23					●	●	●		
	5.00E-2.50	5	0.20-0.42	0.0-2.5	0.12-0.23					●	●	●		●
	6.00E-3.00	6	0.25-0.54	0.0-3.0	0.15-0.27					●	●	●		●
	8.00E-4.00	8	0.30-0.67	0.0-4.0	0.18-0.35					●	●	●		
	10.00E-5.00	10	0.35-0.80	0.0-5.0	0.22-0.40						●	●		

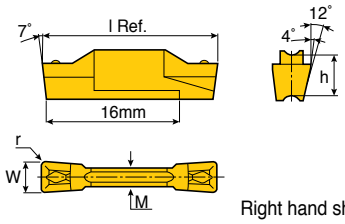
●: Standard item

Technical Data
B131

TDFT-E

T-CLAMP ULTRA PLUS

Pressed inserts for face grooving and turning



Right hand shown

Size	Dimension (mm)				
	W±0.05	r	M	l	h
3E	3.0	0.40	2.2	20.0	4.7
4E	4.0	0.40	3.0	20.0	4.7
4E... CE	4.0	0.40	3.0	20.0	4.7

Insert	Designation	Insert seat size	Turning		Grooving	Cermet		Ceramic	Coated						Uncoated
			Feed (mm/rev)	ap (mm)	Feed (mm/rev)	PV3030	CT3000	AB30	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10
 CE type	**TDFT 3E-0.4R/L**	3	0.15-0.22	0.5-2.0	0.07-0.15						●		●		●
	4E-0.4R/L	4	0.18-0.30	0.5-2.4	0.09-0.18						●		●		●
	4E-0.4TR/L CE(1)	4	0.18-0.30	0.5-2.4	0.09-0.35			●							

Technical Data B131

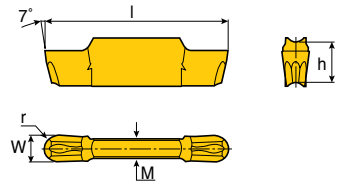
- Apply R insert on R tool and L insert on L tool
- (1) This insert is a pressed ceramic insert

●: Standard item

TDIT-E (Full-Radius)

T-CLAMP ULTRA PLUS

Precision inserts for internal turning, grooving, profiling and undercutting



Size	Dimension (mm)				
	W±0.02	r ±0.05	M	l	h
3	3.00	1.50	2.2	20.0	4.7
4	4.00	2.00	3.0	20.0	4.7
5	5.00	2.50	4.0	25.0	5.2
6	6.00	3.00	5.0	25.0	5.2

Insert	Designation	Insert seat size	Turning		Grooving	Cermet		Coated						Uncoated
			Feed (mm/rev)	ap (mm)	Feed (mm/rev)	PV3030	CT3000	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10
	**TDIT 3.00E-1.50**	3	0.15-0.28	0.0-1.5	0.08-0.18					●		●		●
	4.00E-2.00	4	0.18-0.35	0.0-2.0	0.10-0.20					●		●		●
	5.00E-2.50	5	0.20-0.42	0.0-2.5	0.12-0.23					●		●		●
	6.00E-3.00	6	0.25-0.54	0.0-3.0	0.15-0.27					●		●		●

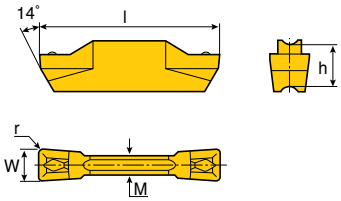
Technical Data B131

●: Standard item

TaeguTec Member IMC Group

TDIT-E

Precision inserts for internal turning and grooving



Size	Dimension (mm)				
	W±0.02	r ±0.05	M	l	h
3	3.00	0.40	2.2	20.0	4.7
4	4.00	0.40-0.80	3.0	20.0	4.7
5	5.00	0.40-0.80	4.0	25.0	5.2
6	6.00	0.80-1.20	5.0	25.0	5.2
8	8.00	1.20	6.0	30.0	6.4

Insert	Designation	Insert seat size	Turning		Grooving	Cermet		Ceramic	Coated						Uncoated
			Feed (mm/rev)	ap (mm)	Feed (mm/rev)	PV3030	CT3000	AB30	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10
 CE type	**TDIT 3.00E-0.40**	3	0.15-0.22	0.5-1.8	0.07-0.15						●		●		●
	4.00E-0.40	4	0.18-0.30	0.5-2.4	0.09-0.18						●		●		●
	4.00E-0.80	4	0.18-0.30	1.0-2.4	0.09-0.18						●		●		●
	5.00E-0.40	5	0.20-0.35	0.5-2.3	0.11-0.20						●		●		●
	5.00E-0.80	5	0.23-0.35	1.0-3.0	0.11-0.21						●		●		●
	6.00E-0.80	6	0.24-0.42	1.0-3.6	0.13-0.30						●		●		●
	6.00E-1.20	6	0.24-0.42	1.3-3.6	0.13-0.30						●		●		●
	8.00E-0.80	8	0.30-0.56	1.0-4.8	0.15-0.40						●		●		●
	8.00E-1.20	8	0.30-0.56	1.3-4.8	0.15-0.40						●		●		
	4E-0.4T CE(1)	4	0.18-0.30	0.5-2.4	0.09-0.35			●							
	6E-0.8T CE(1)	6	0.24-0.42	1.0-3.6	0.13-0.40			●							

Technical Data B131

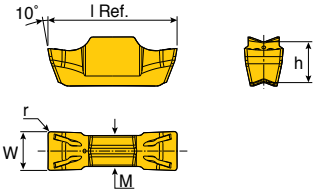
• (1) This insert is a pressed ceramic insert (W±0.05)

●: Standard item

TaeguTec Member IMC Group

TDIM

Pressed inserts for turning and grooving



Size	Dimension (mm)				
	W±0.05	r	M	l	h
2	2.0	0.15	1.6	10	3.2
3	3.0	0.20	2.4	10	3.2

Insert	Designation	Insert seat size	Turning		Grooving	Cermet		Coated						Uncoated
			Feed (mm/rev)	ap (mm)	Feed (mm/rev)	PV3030	CT3000	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10
	TDIM **2E-0.15**	2	0.05-0.08	0.2-0.6	0.03-0.05						●			
	3E-0.2	3	0.10-0.14	0.3-1.3	0.05-0.09						●			

B44-B45
B56-B57
Technical Data
B133

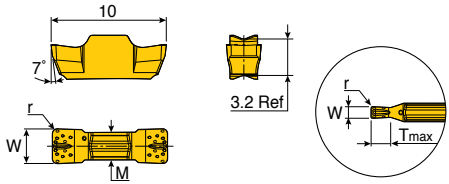
• Used holder TTSER/L, TGSFR/L, TTSIR/L, TGSIR/L

●: Standard item

TaeguTec Member IMC Group

TDIP

Precision inserts for turning and grooving



Size	Dimension (mm)			
	W±0.02	r	M	Tmax
1.00	1.00	0.10-0.50	1.6	1.6
1.20	1.20	0.00	1.6	1.8
1.40	1.40	0.00	1.6	2.0
1.50	1.50	0.10	1.6	2.0
2.00	2.00	0.10-1.00	1.6	-
2.15	2.15	0.15	1.6	-
2.50	2.50	0.20	2.4	-
3.00	3.00	0.20-1.50	2.4	-

Insert	Designation	Insert seat size	Turning		Grooving	Cermet		Coated						Uncoated
			Feed (mm/rev)	ap (mm)	Feed (mm/rev)	PV3030	CT3000	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10
	**TDIP 1.00-0.10***	2	-	-	0.01-0.03						●			
	1.00-0.50*	2	-	-	0.01-0.04						●			
	1.20-0.00*	2	-	-	0.01-0.03						●			
	1.40-0.00*	2	-	-	0.02-0.04						●			
	1.50-0.10*	2	-	-	0.02-0.04						●			
	2.00E-0.10	2	0.05-0.07	0.2-0.6	0.03-0.05						●			
	2.00E-0.20	2	0.05-0.07	0.2-0.6	0.03-0.05						●			
	2.00E-1.00	2	0.08-0.12	0.0-0.6	0.04-0.07						●			
	2.15E-0.15	2	0.06-0.08	0.2-0.6	0.04-0.06						●			
	2.50E-0.20	3	0.07-0.09	0.2-1.1	0.04-0.07						●			
	3.00E-0.20	3	0.11-0.14	0.3-1.3	0.05-0.09						●			
	3.00E-1.50	3	0.13-0.20	0.0-1.5	0.05-0.11						●			

B44-B45
B56-B57
Technical Data
B133

• * Only for grooving: Please use TGSFR/L, TGSIR/L holder

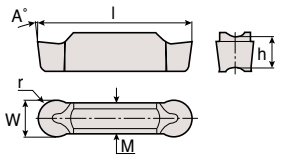
●: Standard item

TaeguTec Member IMC Group

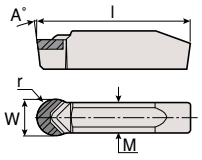
TDA/TSA

T-CLAMP ULTRA PLUS

Inserts for aluminum wheel machining



K10



PCD

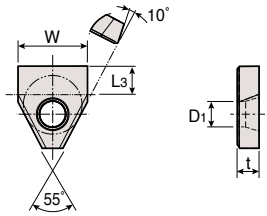
Size	Dimension (mm)					
	W±0.02	r ±0.05	M	l	h	A
3	3.00	1.5	2.4	20.0	4.7	7
4	4.00	2.0	3.0	20.0	4.7	7
5	5.00	2.5	4.0	25.0	5.2	7
6	6.00	3.0	5.0	25.0	5.2	7
8	8.00	0.8-4.0	6.0	30.0	6.4	10

Insert	Designation	Insert seat size	Turning		Grooving	PCD	Coated						Uncoated
			Feed (mm/rev)	ap (mm)	Feed (mm/rev)	KP300	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10
K10  TDA TDA-35V	**TDA 3.00-1.50**	3	0.15-0.30	0.0-1.5	0.08-0.16								●
	4.00-2.00	4	0.20-0.43	0.0-2.0	0.10-0.22								●
	5.00-2.50	5	0.20-0.48	0.0-2.5	0.10-0.25								●
	6.00-3.00	6	0.21-0.58	0.0-3.0	0.11-0.29								●
	8.00-4.00	8	0.24-0.67	0.0-4.0	0.14-0.38								●
	8.00-0.80-35V	8	0.24-0.56	1.0-4.8	-								●
	8.00-1.2-35V	8	0.24-0.62	1.5-4.8	-								●
PCD  TSA	**TSA 6.00-3.00**	6	0.26-0.72	0.0-3.0	0.13-0.36	●							
	8.00-4.00	8	0.24-0.67	0.0-4.0	0.14-0.38	●							
PCD-CB  TSA-CB	**TSA 6.00-3.00 CB**	6	0.21-0.58	0.0-3.0	0.11-0.29	○							
	8.00-4.00 CB	8	0.24-0.67	0.0-4.0	-	○							

●: Standard item ○: Semi standard

TGUX

Semi finished blank for external profiles



Size	Dimension (mm)			
	W	t	D_1	L_3
10	10.2	4.76	5.5	5.85
15	15.2	4.76	5.5	5.85
20	20.2	6.35	6.0	9.35
25	25.2	6.35	6.0	9.25

Insert	Designation	PCD	Cermet		Coated						Uncoated		
		KP300	PV3030	CT3000	TT7505	TT6080	TT5100	TT9080	TT7220	TT8020	K10	P40	UF10
	**TGUX 1004**										●	●	●
	1504										●	●	●
	2006										●	●	●
	2506										●	●	●

●: Standard item



TaeguTec
Member IMC Group

Designation System

MIN	T	R	04	040	005	D010
1	7	2	3	4	5	6

1 TOPMICRO series



2 Hand of tool

R Right-hand
L Left-hand

3 Shank dia.

04 4.0mm
07 7.0mm

4 Max. depth

050 5.0mm
140 14.0mm

5 Corner radius

010 0.10mm
020 0.20mm

6 Min. bore. dia.

D010 1.0mm

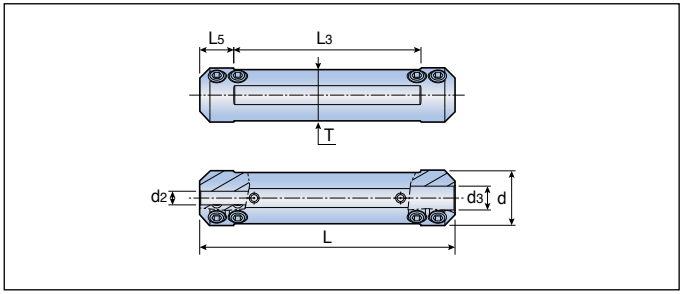
7 Application type

T	Turning and chamfering
B	Back turning
P	Turning and profiling
U	Undercutting and chamfering
C	Turning and 45°chamfering
G	Grooving and turning
A	Grooving along shaft
F	Face grooving
R	Full radius for internal boring and profiling
N	ISO full profile internal threading
SL	Sleeve for MINS

MINSL

Sleeves





Designation		Dimension (mm)						
		d	d2	d3	L	L5	L3	T
MINSL	**12-4-4**	12.00	4.00	4.00	75.00	10.00	55.00	10.30
	14-4-4	14.00	4.00	4.00	75.00	10.00	55.00	12.00
	16-4-7	16.00	4.00	7.00	75.00	10.00	55.00	15.00
	20-4-7	20.00	4.00	7.00	90.00	10.00	70.00	18.00
	22-4-7	22.00	4.00	7.00	90.00	10.00	70.00	20.00
	25-4-7	25.00	4.00	7.00	100.00	10.00	80.00	23.00

Spare parts

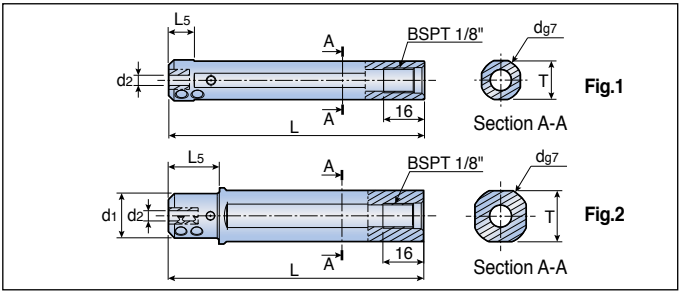
Designation	Set screw	Wrench		
				
MINSL 12	SS M5x0.8x4-MG	L-W 2.5		
MINSL 14/16/20/22/25	SS M5x0.8x6-MG	L-W 2.5		

MINS ...-L100C

TOPMICRO

Sleeves for direct connection for coolant





Designation		Dimension (mm)						Fig.
		d	d1	d2	L	L5	T	
MINS	16-4-L100C	16.00	-	4.00	100.00	10.00	15.00	1
	16-7-L100C	16.00	-	7.00	100.00	10.00	15.00	1
	20-4-L100C	20.00	17.50	4.00	100.00	20.00	18.00	2
	20-7-L100C	20.00	17.50	7.00	100.00	20.00	18.00	2
	22-4-L100C	22.00	17.50	4.00	100.00	20.00	20.00	2
	22-7-L100C	22.00	17.50	7.00	100.00	20.00	20.00	2
	25-4-L100C	25.00	18.00	4.00	100.00	23.00	23.00	2
	25-7-L100C	25.00	18.00	7.00	100.00	23.00	23.00	2

• All sleeves applicable for Citizen Swiss type machine

Spare parts

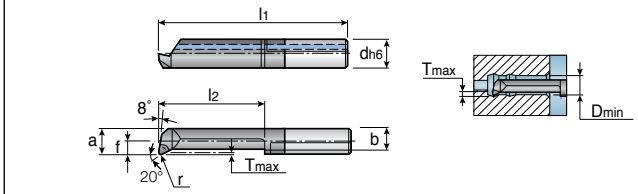
Designation	Set screw	Wrench		
				
MINS ...-L100C	SS M5x0.8x6-MG	L-W 2.5		

MINT R/L 04

TOPMICRO

Mini carbide bars for internal turning and chamfering





Right hand shown

Designation	Dimension (mm)									R/L	Grade
	d	f	a	b	l1	l2	r ±0.05	Tmax	Dmin		TT9030
MINTR04-020004D006*	4.00	-	0.50	0.35	18.50	3.50	0.04	0.08	0.60	R	●
030004D006*	4.00	-	0.50	0.35	19.50	4.50	0.04	0.08	0.60	R	●
045005D010	4.00	-	0.90	0.70	21.00	6.00	0.05	0.10	1.00	R	●
065005D010	4.00	-	0.90	0.70	23.00	8.00	0.05	0.10	1.00	R	●
040005D020	4.00	-	1.70	1.45	20.50	5.50	0.05	0.10	2.00	R	●
090005D020	4.00	-	1.70	1.45	25.50	10.50	0.05	0.10	2.00	R	●
140005D020	4.00	-	1.70	1.45	30.50	15.50	0.05	0.10	2.00	R	●
090010D028	4.00	0.90	2.60	2.20	25.50	10.50	0.10	0.20	2.80	R	●
150010D028	4.00	0.90	2.60	2.20	31.50	16.50	0.10	0.20	2.80	R	●
190010D028	4.00	0.90	2.60	2.20	35.50	20.50	0.10	0.20	2.80	R	●
090010D040	4.00	1.50	3.50	2.90	25.50	10.50	0.10	0.30	4.00	R	●
150010D040	4.00	1.50	3.50	2.90	31.50	16.50	0.10	0.30	4.00	R	●
190010D040	4.00	1.50	3.50	2.90	35.50	20.50	0.10	0.30	4.00	R	●
230010D040	4.00	1.50	3.50	2.90	39.50	24.50	0.10	0.30	4.00	R	●
270010D040	4.00	1.50	3.50	2.90	43.50	28.50	0.10	0.30	4.00	R	●
MINTL04-090010D028	4.00	0.90	2.60	2.20	25.50	10.50	0.10	0.20	2.80	L	●
150010D028	4.00	0.90	2.60	2.20	31.50	16.50	0.10	0.20	2.80	L	●
190010D028	4.00	0.90	2.60	2.20	35.50	20.50	0.10	0.20	2.80	L	●
090010D040	4.00	1.50	3.50	2.90	25.50	10.50	0.10	0.30	4.00	L	●
150010D040	4.00	1.50	3.50	2.90	31.50	16.50	0.10	0.30	4.00	L	●
190010D040	4.00	1.50	3.50	2.90	35.50	20.50	0.10	0.30	4.00	L	●

B90-B91

Cutting Condition

B129

• * Max D.O.C: 0.01 - 0.03, max feed 0.01mm/rev

●: Standard item

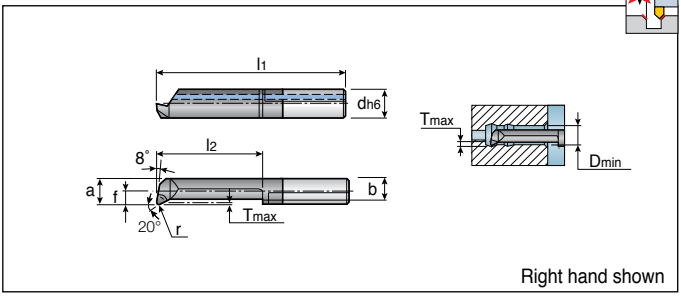
TaeguTec
Member IMC Group

MINT R/L 07

TOPMICRO

Mini carbide bars for internal turning and chamfering





Right hand shown

Designation	Dimension (mm)									R/L	Grade
	d	f	a	b	l1	l2	r ±0.05	Tmax	Dmin		TT9030
MINTR07-090015D050	7.00	0.90	4.40	3.65	25.00	10.00	0.15	0.50	5.00	R	●
140015D050	7.00	0.90	4.40	3.65	30.00	15.00	0.15	0.50	5.00	R	●
190015D050	7.00	0.90	4.40	3.65	35.00	20.00	0.15	0.50	5.00	R	●
240015D050	7.00	0.90	4.40	3.65	40.00	25.00	0.15	0.50	5.00	R	●
290015D050	7.00	0.90	4.40	3.65	45.00	30.00	0.15	0.50	5.00	R	●
340015D050	7.00	0.90	4.40	3.65	50.00	35.00	0.15	0.50	5.00	R	●
140015D060	7.00	1.80	5.30	4.40	30.00	15.00	0.15	0.50	6.00	R	●
210015D060	7.00	1.80	5.30	4.40	37.00	22.00	0.15	0.50	6.00	R	●
240015D060	7.00	1.80	5.30	4.40	40.00	25.00	0.15	0.50	6.00	R	●
290015D060	7.00	1.80	5.30	4.40	45.00	30.00	0.15	0.50	6.00	R	●
340015D060	7.00	1.80	5.30	4.40	50.00	35.00	0.15	0.50	6.00	R	●
410015D060	7.00	1.80	5.30	4.40	57.00	42.00	0.15	0.50	6.00	R	●
190015D068	7.00	2.80	6.30	5.40	35.00	20.00	0.15	0.60	6.80	R	●
240015D068	7.00	2.80	6.30	5.40	40.00	25.00	0.15	0.60	6.80	R	●
290015D068	7.00	2.80	6.30	5.40	45.00	30.00	0.15	0.60	6.80	R	●
340015D070	7.00	2.80	6.30	5.40	50.00	35.00	0.15	0.60	7.00	R	●
390015D070	7.00	2.80	6.30	5.40	55.00	40.00	0.15	0.60	7.00	R	●
440015D070	7.00	2.80	6.30	5.40	60.00	45.00	0.15	0.60	7.00	R	●
490015D070	7.00	2.80	6.30	5.40	65.00	50.00	0.15	0.60	7.00	R	●
MINTL07-090015D050	7.00	0.90	4.40	3.65	25.00	10.00	0.15	0.50	5.00	L	●
140015D050	7.00	0.90	4.40	3.65	30.00	15.00	0.15	0.50	5.00	L	●
190015D050	7.00	0.90	4.40	3.65	35.00	20.00	0.15	0.50	5.00	L	●
240015D050	7.00	0.90	4.40	3.65	40.00	25.00	0.15	0.50	5.00	L	●
290015D050	7.00	0.90	4.40	3.65	45.00	30.00	0.15	0.50	5.00	L	●
140015D060	7.00	1.80	5.30	4.40	30.00	15.00	0.15	0.50	6.00	L	●
210015D060	7.00	1.80	5.30	4.40	37.00	22.00	0.15	0.50	6.00	L	●
240015D060	7.00	1.80	5.30	4.40	40.00	25.00	0.15	0.50	6.00	L	●
290015D060	7.00	1.80	5.30	4.40	45.00	30.00	0.15	0.50	6.00	L	●
190015D068	7.00	2.80	6.30	5.40	35.00	20.00	0.15	0.60	6.80	L	●
290015D068	7.00	2.80	6.30	5.40	45.00	30.00	0.15	0.60	6.80	L	●
340015D070	7.00	2.80	6.30	5.40	50.00	35.00	0.15	0.60	7.00	L	●

B90-B91 Cutting Condition B129

●: Standard item

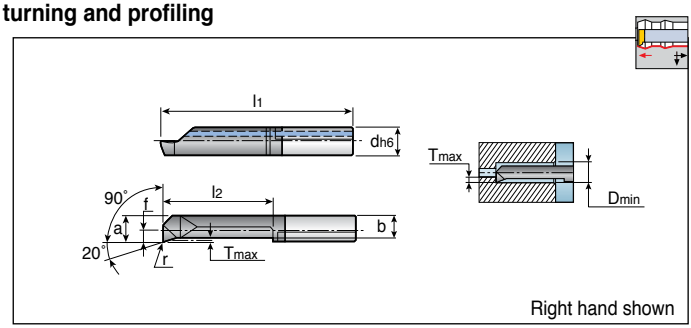
TaeguTec Member IMC Group

MINP R 04/07

TOPMICRO

Mini carbide bars for internal turning and profiling





Right hand shown

Designation	Dimension (mm)									R/L	Grade
	d	f	a	b	l1	l2	r ±0.05	Tmax	Dmin		TT9030
MINPR04- 090010D028	4.00	0.90	2.60	2.20	25.50	10.50	0.10	0.20	2.80	R	●
150010D028	4.00	0.90	2.60	2.20	31.50	16.50	0.10	0.20	2.80	R	●
090010D040	4.00	1.50	3.50	2.90	25.50	10.50	0.10	0.30	4.00	R	●
150010D040	4.00	1.50	3.50	2.90	31.50	16.50	0.10	0.30	4.00	R	●
MINPR07- 140015D050	7.00	0.90	4.40	3.65	30.00	15.00	0.15	0.50	5.00	R	●
190015D050	7.00	0.90	4.40	3.65	35.00	20.00	0.15	0.50	5.00	R	●

B90-B91 Cutting Condition B129

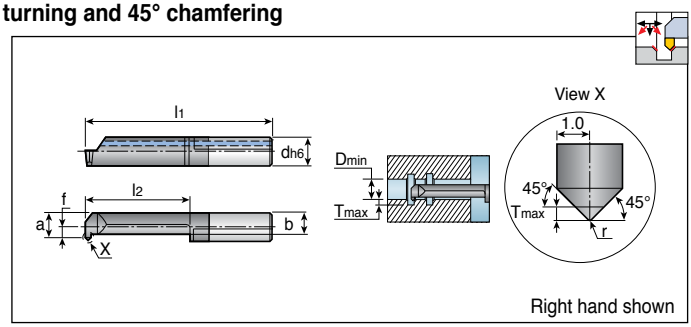
●: Standard item

MINC R 07

TOPMICRO

Mini carbide bars for internal turning and 45° chamfering





Right hand shown

Designation	Dimension (mm)									R/L	Grade
	d	f	a	b	l1	l2	r ±0.04	Tmax	Dmin		TT9030
MINCR07- 140020D050	7.00	0.90	4.40	3.20	30.00	15.00	0.20	0.70	5.00	R	●
190020D050	7.00	0.90	4.40	3.20	35.00	20.00	0.20	0.70	5.00	R	●
190020D068	7.00	2.80	6.30	3.80	35.00	20.00	0.20	0.70	6.80	R	●

B90-B91 Cutting Condition B129

●: Standard item

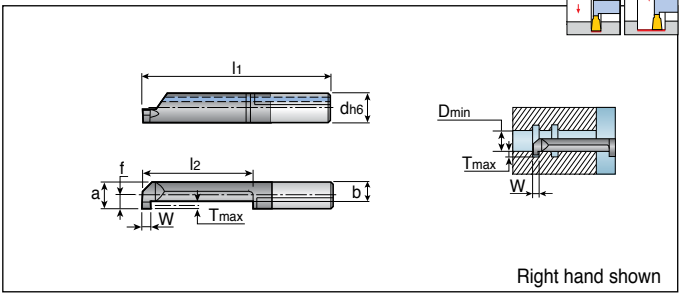
TaeguTec Member IMC Group

MING R 04

TOPMICRO

Mini carbide bars for grooving and turning





Right hand shown

Designation	Dimension (mm)									R/L	Grade
	d	W±0.05	f	a	b	l1	l2	Tmax	Dmin		TT9030
MINGR04-050050D020	4.00	0.50	0.20	1.80	1.15	21.00	6.00	0.40	2.00	R	●
100050D020	4.00	0.50	0.20	1.80	1.15	26.00	11.00	0.40	2.00	R	●
050070D030	4.00	0.70	0.70	2.70	1.85	21.00	6.00	0.60	3.00	R	●
100070D030	4.00	0.70	0.70	2.70	1.85	26.00	11.00	0.60	3.00	R	●
090100D040	4.00	1.00	1.50	3.50	2.30	25.50	10.50	0.80	4.00	R	●
150100D040	4.00	1.00	1.50	3.50	2.30	31.50	16.50	0.80	4.00	R	●

B90-B91

Cutting Condition

B129

●: Standard item

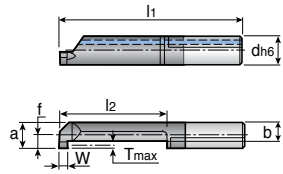
TaeguTec
Member IMC Group

MING R/L 07

TOPMICRO

Mini carbide bars for grooving and turning





Right hand shown

Designation	Dimension (mm)									R/L	Grade
	d	W±0.05	f	a	b	l1	l2	Tmax	Dmin		TT9030
MINGR07-090100D050	7.00	1.00	0.90	4.40	3.00	25.00	10.00	1.00	5.00	R	●
140100D050	7.00	1.00	0.90	4.40	3.00	30.00	15.00	1.00	5.00	R	●
090150D050	7.00	1.50	0.90	4.40	3.00	25.00	10.00	1.00	5.00	R	●
140150D050	7.00	1.50	0.90	4.40	3.00	30.00	15.00	1.00	5.00	R	●
090200D050	7.00	2.00	0.90	4.40	3.00	25.00	10.00	1.00	5.00	R	●
190200D050	7.00	2.00	0.90	4.40	3.00	35.00	20.00	1.00	5.00	R	●
090100D060	7.00	1.00	1.80	5.30	3.10	25.00	10.00	1.80	6.00	R	●
140100D060	7.00	1.00	1.80	5.30	3.10	30.00	15.00	1.80	6.00	R	●
210100D060	7.00	1.00	1.80	5.30	3.10	37.00	22.00	1.80	6.00	R	●
290100D060	7.00	1.00	1.80	5.30	3.10	45.00	30.00	1.80	6.00	R	●
090150D060	7.00	1.50	1.80	5.30	3.10	25.00	10.00	1.80	6.00	R	●
140150D060	7.00	1.50	1.80	5.30	3.10	30.00	15.00	1.80	6.00	R	●
210150D060	7.00	1.50	1.80	5.30	3.10	37.00	22.00	1.80	6.00	R	●
240150D060	7.00	1.50	1.80	5.30	3.10	40.00	25.00	1.80	6.00	R	●
290150D060	7.00	1.50	1.80	5.30	3.10	45.00	30.00	1.80	6.00	R	●
090200D060	7.00	2.00	1.80	5.30	3.10	25.00	10.00	1.80	6.00	R	●
140200D060	7.00	2.00	1.80	5.30	3.10	30.00	15.00	1.80	6.00	R	●
210200D060	7.00	2.00	1.80	5.30	3.10	37.00	22.00	1.80	6.00	R	●
240200D060	7.00	2.00	1.80	5.30	3.10	40.00	25.00	1.80	6.00	R	●
290200D060	7.00	2.00	1.80	5.30	3.10	45.00	30.00	1.80	6.00	R	●
090100D068	7.00	1.00	2.70	6.20	3.30	25.00	10.00	2.50	6.80	R	●
140100D068	7.00	1.00	2.70	6.20	3.30	30.00	15.00	2.50	6.80	R	●
210100D068	7.00	1.00	2.70	6.20	3.30	37.00	22.00	2.50	6.80	R	●
090150D068	7.00	1.50	2.70	6.20	3.30	25.00	10.00	2.50	6.80	R	●
140150D068	7.00	1.50	2.70	6.20	3.30	30.00	15.00	2.50	6.80	R	●
210150D068	7.00	1.50	2.70	6.20	3.30	37.00	22.00	2.50	6.80	R	●
290150D068	7.00	1.50	2.70	6.20	3.30	45.00	30.00	2.50	6.80	R	●
090200D068	7.00	2.00	2.70	6.20	3.30	25.00	10.00	2.50	6.80	R	●
140200D068	7.00	2.00	2.70	6.20	3.30	30.00	15.00	2.50	6.80	R	●
210200D068	7.00	2.00	2.70	6.20	3.30	37.00	22.00	2.50	6.80	R	●
290200D068	7.00	2.00	2.70	6.20	3.30	45.00	29.00	2.50	6.80	R	●
MINGL07-090100D060	7.00	1.00	1.80	5.30	3.10	25.00	10.00	1.80	6.00	L	●
090150D060	7.00	1.50	1.80	5.30	3.10	25.00	10.00	1.80	6.00	L	●
140200D068	7.00	2.00	2.70	6.20	3.30	30.00	15.00	2.50	6.80	L	●

●: Standard item


B90-B91

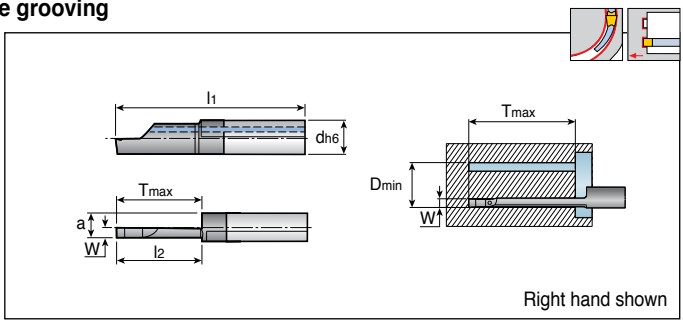
Cutting Condition


B129

MINF R 07

Mini carbide bars for deep face grooving





Right hand shown

Designation	Dimension (mm)							R/L	Grade
	d	W	a	l_1	l_2	Tmax	Dmin		TT9030
MINFR07 200250D150	7.00	2.50	5.90	36.00	21.00	20.00	15.00	R	●
200300D150	7.00	3.00	5.90	36.00	21.00	20.00	15.00	R	●
300300D150	7.00	3.00	5.90	46.00	31.00	30.00	15.00	R	●

B90-B91

Cutting Condition

B129

●: Standard item

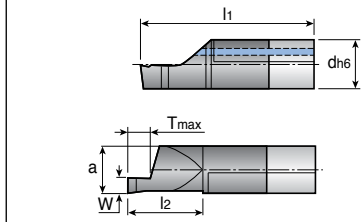
TaeguTec
Member IMC Group

MINF R/L 07

TOPMICRO

Mini carbide bars for deep face grooving





Right hand shown

Designation		Dimension (mm)							R/L	Grade
		d	W	a	l_1	l_2	Tmax	Dmin		TT9030
MINFR07-	**110100D060**	7.00	1.00	5.20	26.00	11.00	1.50	6.00	R	●
	110100D080	7.00	1.00	5.90	27.00	12.00	1.50	8.00	R	●
	110150D060	7.00	1.50	5.20	26.00	11.00	2.00	6.00	R	●
	110150D080	7.00	1.50	5.90	27.00	12.00	2.50	8.00	R	●
	110200D060	7.00	2.00	5.20	26.00	11.00	3.00	6.00	R	●
	200200D080	7.00	2.00	5.90	36.00	21.00	3.00	8.00	R	●
	210150D080	7.00	1.50	5.90	36.00	22.00	2.50	8.00	R	●
	110200D080	7.00	2.00	5.90	27.00	12.00	3.00	8.00	R	●
	210200D080	7.00	2.00	5.90	36.00	22.00	3.00	8.00	R	●
	110250D080	7.00	2.50	5.90	27.00	12.00	3.50	8.00	R	●
	210250D080	7.00	2.50	5.90	36.00	22.00	3.50	8.00	R	●
	110300D080	7.00	3.00	5.90	27.00	12.00	3.50	8.00	R	●
	210300D080	7.00	3.00	5.90	36.00	22.00	3.50	8.00	R	●
	300300D080	7.00	3.00	5.90	46.00	31.00	3.50	8.00	R	●
MINFL07-	**210150D080**	7.00	1.50	5.90	36.00	22.00	2.50	8.00	L	●
	300200D080	7.00	2.00	5.90	46.00	31.00	3.00	8.00	L	●

B90-B91

Cutting Condition B129

●: Standard item

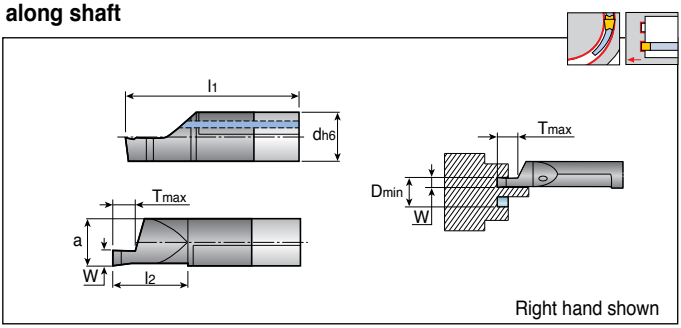
TaeguTec
Member IMC Group

MINA R 07

TOPMICRO

Mini carbide bars for grooving along shaft





Designation	Dimension (mm)							R/L	Grade
	d	W	a	l1	l2	Tmax	Dmin		TT9030
MINAR07 -200200D060	7.00	2.00	5.20	36.00	21.00	4.00	6.00	R	●

B90-B91 | Cutting Condition B129

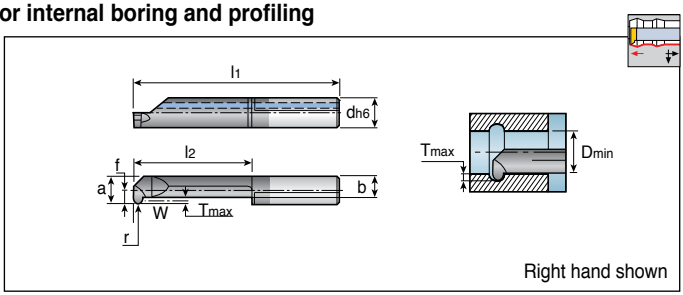
●: Standard item

MINR R 07

TOPMICRO

Mini carbide bars, full radius for internal boring and profiling





Designation	Dimension (mm)										R/L	Grade
	d	W±0.05	f	a	b	r	l1	l2	Tmax	Dmin		TT9030
MINRR07- 190050D050	7.00	1.00	0.90	4.40	3.10	0.50	35.00	20.00	1.00	5.00	R	●
240050D060	7.00	1.00	1.80	5.30	3.20	0.50	40.00	25.00	1.80	6.00	R	●
290050D068	7.00	1.00	2.80	6.30	3.55	0.50	45.00	30.00	2.50	6.80	R	●

B90-B91 | Cutting Condition B129

●: Standard item

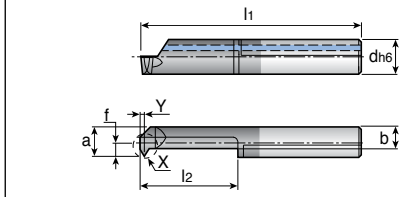
TaeguTec Member IMC Group

MINN R 04/07

TOPMICRO

Mini carbide bars for ISO internal thread turning





Right hand shown

Designation	Dimension (mm)											Grade
	d	Pitch	te	W	Y	f	a	b	l_1	l_2	Dmin	TT9030
MINNR04-140050D040	4.00	0.50	0.30	0.06	0.35	1.50	3.50	2.40	30.00	15.00	4.00	●
MINNR07-140050D050	7.00	0.50	0.30	0.06	0.35	0.90	4.40	3.30	30.00	15.00	5.00	●
140075D050	7.00	0.75	0.40	0.90	0.45	0.90	4.40	3.30	30.00	15.00	5.00	●
140100D048	7.00	1.00	0.60	0.12	0.55	0.90	4.40	3.30	30.00	15.00	4.80	●
140100D060	7.00	1.00	0.60	0.12	0.55	1.80	5.30	3.40	30.00	15.00	6.00	●
140125D060	7.00	1.25	0.70	0.15	0.65	1.80	5.30	3.40	30.00	15.00	6.00	●
140150D060	7.00	1.50	0.80	0.18	0.75	1.80	5.30	3.40	30.00	15.00	6.00	●
140150D070	7.00	1.50	0.80	0.18	0.75	2.80	6.30	3.80	30.00	15.00	7.00	●

B90-B91

Cutting Condition

B129

●: Standard item

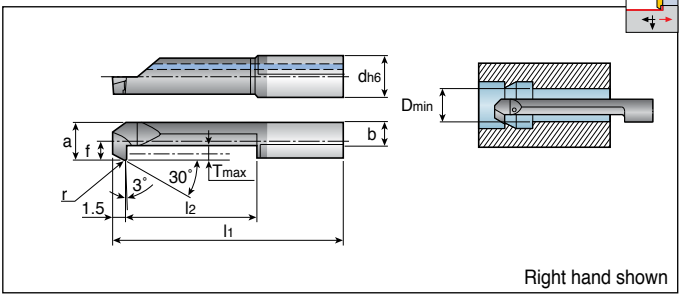
TaeguTec
Member IMC Group

MINBR 04/07

TOPMICRO

Mini carbide bars for internal back turning





Right hand shown

Designation	Dimension (mm)									R/L	Grade
	d	f	a	b	l_1	l_2	r ±0.05	Tmax	Dmin		TT9030
MINBR04- 140020D030	4.00	0.60	2.60	1.80	30.00	15.00	0.20	0.50	3.00	R	●
190020D030	4.00	0.60	2.60	1.80	35.00	20.00	0.20	0.50	3.00	R	●
140015D040	4.00	1.50	3.50	2.40	30.00	15.00	0.15	0.80	4.00	R	●
240015D040	4.00	1.50	3.50	2.40	40.00	25.00	0.15	0.80	4.00	R	●
MINBR07- 190020D050	7.00	0.90	4.40	3.10	35.00	20.00	0.20	1.00	5.00	R	●
290020D050	7.00	0.90	4.40	3.10	45.00	30.00	0.20	1.00	5.00	R	●
190020D060	7.00	1.80	5.30	3.20	35.00	20.00	0.20	1.80	6.00	R	●
290020D060	7.00	1.80	5.30	3.20	45.00	30.00	0.20	1.80	6.00	R	●
190020D070	7.00	2.80	6.30	3.50	35.00	20.00	0.20	2.50	7.00	R	●
290020D070	7.00	2.80	6.30	3.50	45.00	30.00	0.20	2.50	7.00	R	●

B90-B91

Cutting Condition

B129

●: Standard item

TaeguTec Member IMC Group

Designation System

TV	E	R	4	07	010	45
1	2	3	4	5	6	7

1 TaeguTec TOPCUT series

2 Applciation type

E	External turning
R	Reverse turning
B	Back turning
T	Threading
P	Parting

3 Hand of tool

R	Right-hand
L	Left-hand

4 Insert thickness

4	3.97mm

5 Width of insert

07	0.7mm
10	1.0mm
12	1.2mm
15	1.5mm
18	1.8mm
20	2.0mm

6 Corner radius

000	0mm
003	0.03mm
005	0.05mm
010	0.10mm
015	0.15mm

7 Tmax (TVPR/L only)

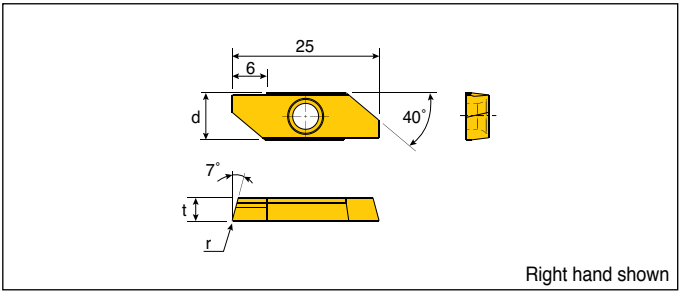
45	4.5mm
50	5.0mm
60	6.0mm

TVER/L

TOPCUT

General turning





Right hand shown

Designation		Feed (mm/rev)	ap (mm)	Dimension (mm)				Grade (TT9010)	
				d	t	r	Tmax	R	L
TVER/L	**40003**	0.01-0.15	0.1-5.5	8	3.97	0.03	5.5	●	
	40010	0.01-0.15	0.1-5.5	8	3.97	0.10	5.5	●	

●: Standard item

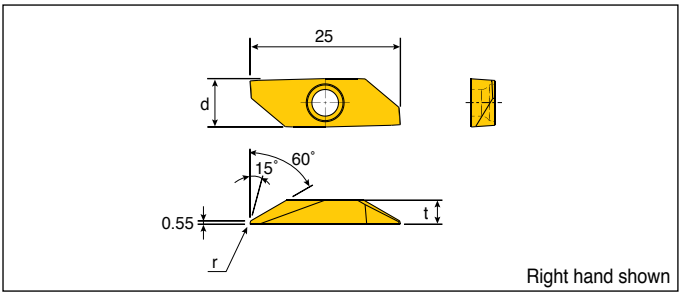
B63

TVRR/L

TOPCUT

Reverse turning





Right hand shown

Designation		Feed (mm/rev)	ap (mm)	Dimension (mm)				Grade (TT9010)	
				d	t	r	Tmax	R	L
TVRR/L	**40003-60**	0.01-0.15	0.1-5.5	8	3.97	0.03	5.5	●	
	40010-60	0.01-0.15	0.1-5.5	8	3.97	0.10	5.5	●	

●: Standard item

B63

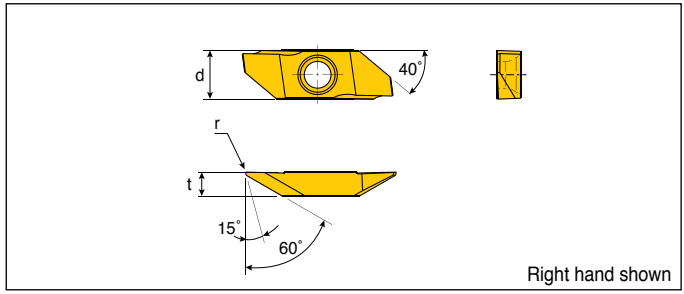
TaeguTec
Member IMC Group

TVBR/L

TOPCUT

Back turning





Right hand shown

Designation		Feed (mm/rev)	ap (mm)	Dimension (mm)				Grade (TT9010)	
				d	t	r	Tmax	R	L
TVBR/L	**40003**	0.01-0.15	0.1-5.5	8	3.97	0.03	5.5	●	●
	40005	0.01-0.15	0.1-5.5	8	3.97	0.05	5.5	●	●
	40010	0.01-0.15	0.1-5.5	8	3.97	0.10	5.5	●	●
	40015	0.01-0.15	0.1-5.5	8	3.97	0.15	5.5	●	●
	40005-H(1)	0.01-0.15	0.1-5.5	8	3.97	0.05	5.5	●	●
	40010-H(1)	0.01-0.15	0.1-5.5	8	3.97	0.10	5.5	●	●
	40015-H(1)	0.01-0.15	0.1-5.5	8	3.97	0.15	5.5	●	●



• (1) With honed egdes

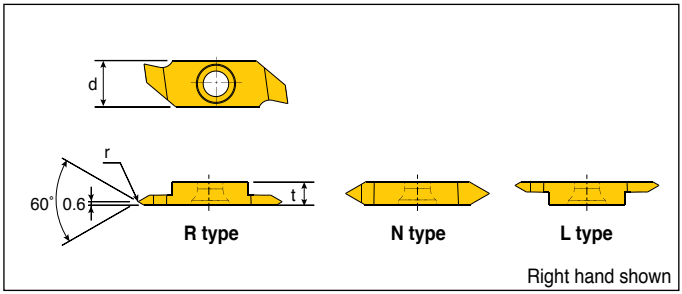
●: Standard item

TVTR/L

TOPCUT

Threading





Right hand shown

Designation		Dimension (mm)			Grade (TT9010)	
		d	t	r	R	L
TVTR/L	**41203-R**	8	3.97	0.03	●	
	40003-N	8	3.97	0.03	●	
	41203-L	8	3.97	0.03		



• TVTR 41203-R/L ➡ pitch range: 0.5 - 1.0mm
• TVTR 40003-N ➡ pitch range: 0.5 - 2.0mm

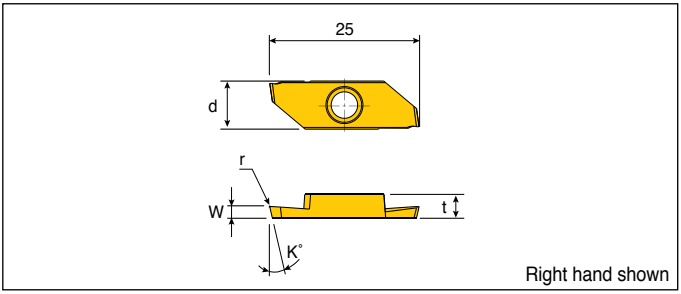
●: Standard item

TaeguTec
Member IMC Group

TVPR/L

Grooving / Parting





Right hand shown

Designation		Feed (mm/rev)	ap (mm)	Dimension (mm)						Grade (TT9010)	
				d	t	r	$W^{+0.05}_{0}$	K°	Tmax	R	L
TVPR/L	40700-45	0.02-0.04	0.7	8	3.97	0.00	0.7	15°	4.5	●	●
	40705-45	0.02-0.04	0.7	8	3.97	0.05	0.7	15°	4.5	●	
	41000-60	0.02-0.04	1.0	8	3.97	0.00	1.0	15°	6.0	●	●
	41005-60	0.02-0.04	1.0	8	3.97	0.05	1.0	15°	6.0	●	
	41000-45	0.02-0.04	1.0	8	3.97	0.00	1.0	15°	4.5	●	
	41005-45	0.02-0.04	1.0	8	3.97	0.05	1.0	15°	4.5	●	
	41200-60	0.02-0.05	1.2	8	3.97	0.00	1.2	15°	6.0		
	41500-60	0.02-0.07	1.5	8	3.97	0.00	1.5	15°	6.0	●	●
	41505-60	0.02-0.07	1.5	8	3.97	0.05	1.5	15°	6.0	●	
	41500-50	0.02-0.07	1.5	8	3.97	0.00	1.5	15°	5.0	●	
	41505-50	0.02-0.07	1.5	8	3.97	0.05	1.5	15°	5.0	●	
	41800-60	0.02-0.07	1.8	8	3.97	0.00	1.8	15°	6.0	●	
	41805-60	0.02-0.07	1.8	8	3.97	0.05	1.8	15°	6.0	●	
	42000-60	0.02-0.07	2.0	8	3.97	0.00	2.0	15°	6.0	●	●
	42005-60	0.02-0.07	2.0	8	3.97	0.05	2.0	15°	6.0	●	
	42000N-60	0.02-0.09	2.0	8	3.97	0.00	2.0	0°	6.0	●	●
	42005N-60	0.02-0.09	2.0	8	3.97	0.05	2.0	0°	6.0	●	

●: Standard item

B64

Designation System

Only for handed insert

T	Q	J	-	27	-	3	-	0.2	-	6	-	R
1	2	3		4		5		6		7		8

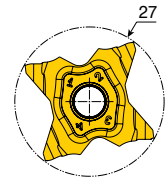
1 TaeguTec

2 QUADRUSH

3 Chip breaker type

		
C	**J**	**S**
For medium	For light	For light & tailor made

4 Circular circumference of the insert

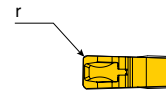


5 Width of insert



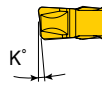
1.00 = 1.0 mm
1.50 = 1.5mm
2.53 = 2.53mm
3.18 = 3.18mm

6 Conrer radius



0.10 = 0.1mm
0.20 = 0.2mm
0.30 = 0.3mm
0.40 = 0.4mm

7 Lead angle



8 Hand of insert

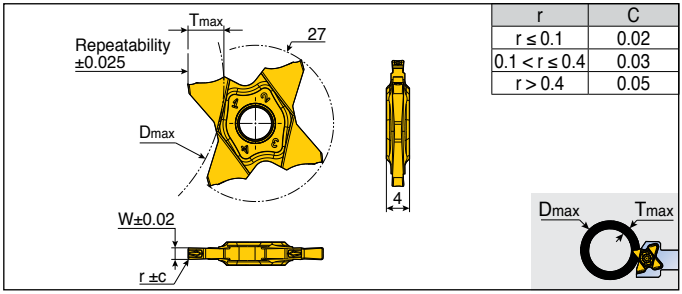
	
L	**R**
Left-hand	Right-hand

TQJ 27

QUAD•RUSH

Precision grooving, parting and recessing insert





r	C
r ≤ 0.1	0.02
0.1 < r ≤ 0.4	0.03
r > 0.4	0.05

Designation	Feed (mm/rev)	W±0.02	r	Tmax	Dmax										Grade
					T≤3.0	T≤3.5	T≤4.0	T≤4.5	T≤5.0	T≤5.5	T≤5.7	T≤6.0	T≤6.2	T≤6.4	TT9080
TQJ 27-0.50-0.00	0.02-0.04	0.50	0.00	1.0	-	-	-	-	-	-	-	-	-	-	●
27-0.50-0.04	0.02-0.04	0.50	0.04	2.5	-	-	-	-	-	-	-	-	-	-	●
27-0.75-0.10	0.02-0.05	0.75	0.10	2.5	-	-	-	-	-	-	-	-	-	-	●
27-0.80-0.00	0.02-0.05	0.80	0.00	1.6	-	-	-	-	-	-	-	-	-	-	●
27-1.00-0.06	0.03-0.07	1.00	0.06	3.5	N.L.	600	-	-	-	-	-	-	-	-	●
27-1.00-0.10	0.03-0.07	1.00	0.10	3.5	N.L.	600	-	-	-	-	-	-	-	-	●
27-1.04-0.00	0.03-0.07	1.04	0.00	2.0	-	-	-	-	-	-	-	-	-	-	●
27-1.20-0.00	0.03-0.07	1.20	0.00	2.0	-	-	-	-	-	-	-	-	-	-	●
27-1.25-0.10	0.03-0.07	1.25	0.10	3.5	N.L.	600	-	-	-	-	-	-	-	-	●
27-1.25-0.20	0.03-0.07	1.25	0.20	3.5	N.L.	600	-	-	-	-	-	-	-	-	●
27-1.40-0.00	0.03-0.08	1.40	0.00	2.0	-	-	-	-	-	-	-	-	-	-	●
27-1.47-0.00	0.03-0.08	1.47	0.00	2.5	-	-	-	-	-	-	-	-	-	-	●
27-1.50-0.10	0.03-0.08	1.50	0.10	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
27-1.50-0.20	0.03-0.08	1.50	0.20	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
27-1.57-0.10	0.03-0.08	1.57	0.10	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-1.57-0.15	0.03-0.08	1.57	0.15	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-1.70-0.10	0.03-0.08	1.70	0.10	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-1.75-0.10	0.03-0.08	1.75	0.10	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-1.75-0.20	0.03-0.08	1.75	0.20	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-1.78-0.18	0.04-0.10	1.78	0.18	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-1.85-0.20	0.04-0.10	1.85	0.20	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-1.96-0.15	0.04-0.10	1.96	0.15	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-2.00-0.10	0.04-0.10	2.00	0.10	6.4	N.L.	600	280	180	130	105	85	60	50	30	●
27-2.00-0.20	0.04-0.10	2.00	0.20	6.4	N.L.	600	280	180	130	105	85	60	50	30	●
27-2.22-0.15	0.04-0.10	2.22	0.15	3.5	N.L.	600	-	-	-	-	-	-	-	-	●
27-2.30-0.20	0.04-0.10	2.30	0.20	3.5	N.L.	600	-	-	-	-	-	-	-	-	●
27-2.39-0.15	0.04-0.10	2.39	0.15	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
27-2.47-0.20	0.04-0.10	2.47	0.20	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
27-2.50-0.10	0.04-0.10	2.50	0.10	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
27-2.50-0.30	0.05-0.12	2.50	0.30	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
27-2.70-0.10	0.05-0.12	2.70	0.10	6.2	N.L.	600	280	180	135	105	95	85	78	-	●
27-2.87-0.20	0.05-0.12	2.87	0.20	6.2	N.L.	600	280	180	135	105	95	85	78	-	●

B65-B68

• N.L = No limit

●: Standard item

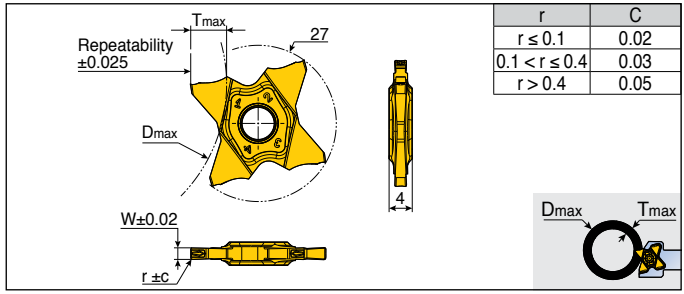
TaeguTec Member IMC Group

TQJ 27

QUAD•RUSH

Precision grooving, parting and recessing insert





r	C
r ≤ 0.1	0.02
0.1 < r ≤ 0.4	0.03
r > 0.4	0.05

Designation	Feed (mm/rev)	W±0.02	r	Tmax	Dmax										Grade
					T≤3.0	T≤3.5	T≤4.0	T≤4.5	T≤5.0	T≤5.5	T≤5.7	T≤6.0	T≤6.2	T≤6.4	TT9080
TQJ 27-3.00-0.00	0.05-0.12	3.00	0.00	6.4	N.L.	600	280	180	135	105	95	85	78	55	●
27-3.00-0.20	0.05-0.12	3.00	0.20	6.4	N.L.	600	280	180	135	105	95	85	78	55	●
27-3.00-0.30	0.05-0.12	3.00	0.30	6.4	N.L.	600	280	180	135	105	95	85	78	55	●
27-3.00-0.40	0.05-0.12	3.00	0.40	6.4	N.L.	600	280	180	135	105	95	85	78	55	●
27-3.15-0.15	0.05-0.12	3.15	0.15	6.4	N.L.	600	280	180	135	105	95	85	78	68	●
27-3.18-0.20	0.05-0.12	3.18	0.20	6.4	N.L.	600	280	180	135	105	95	85	78	68	●



• N.L = No limit

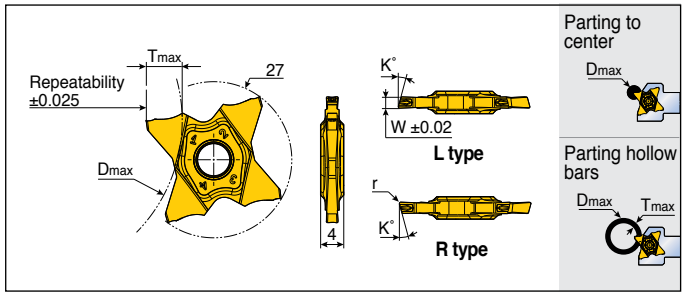
●: Standard item

TQJ 27

QUAD•RUSH

Parting insert





Designation	Feed (mm/rev)	W±0.02	r	K°	Parting to center	Parting hollow bars		Grade
					Dmax	Tmax	Dmax	TT9080
TQJ 27-1.00-15R/L	0.02-0.06	1.00	0.06	15	7.0	3.5	600	●
27-1.50-6R/L	0.02-0.06	1.50	0.06	6	12.0	5.7	35	●
27-1.50-15R/L	0.02-0.06	1.50	0.06	15	12.0	5.7	35	●
27-2.00-6R/L	0.03-0.08	2.00	0.10	6	13.0	6.4	30	●
27-2.00-15R/L	0.03-0.08	2.00	0.10	15	13.0	6.4	30	●



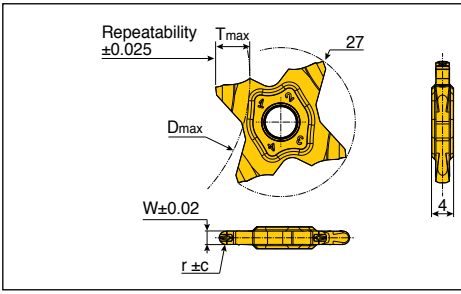
●: Standard item

TaeguTec
Member IMC Group

TQJ 27

Full radius





r	C
r ≤ 0.1	0.02
0.1 < r ≤ 0.4	0.03
r > 0.4	0.05

Designation	Feed (mm/rev)	W±0.02	r	Tmax	Dmax										Grade
					T≤3.0	T≤3.5	T≤4.0	T≤4.5	T≤5.0	T≤5.5	T≤5.7	T≤6.0	T≤6.2	T≤6.4	TT9080
TQJ 27-1.57-0.79	0.05-0.08	1.57	0.79	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-2.00-1.00	0.05-0.11	2.00	1.00	3.5	N.L.	600	-	-	-	-	-	-	-	-	●
27-2.39-1.20	0.05-0.11	2.39	1.20	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
27-3.00-1.50	0.06-0.12	3.00	1.50	6.4	N.L.	600	280	180	135	105	95	85	78	55	●

B65-B68

• N.L = No limit

●: Standard item

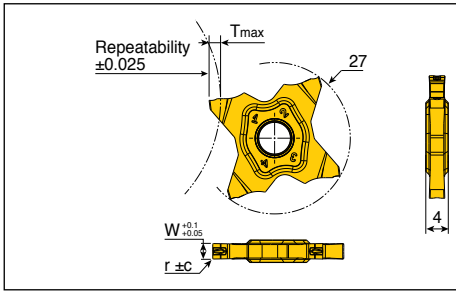
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Member IMC Group

TQJ 27

QUAD•RUSH

DIN 471 circlip grooving and shallow grooves





r	C
r ≤ 0.1	0.02
0.1 < r ≤ 0.4	0.03
r > 0.4	0.05

For circlip width



Designation		Feed (mm/rev)	W +0.1 +0.05	r	Tmax	For circlip width	Grade TT9080
TQJ	**27-1.10-0.08-CG**	0.03-0.07	1.10	0.08	1.50	1.10	●
	27-1.30-0.08-CG	0.03-0.07	1.30	0.08	1.50	1.30	●
	27-1.60-0.08-CG	0.03-0.08	1.60	0.08	2.00	1.60	●
	27-1.85-0.08-CG	0.03-0.08	1.85	0.08	2.00	1.85	●
	27-2.15-0.08-CG	0.04-0.10	2.15	0.08	2.50	2.15	●
	27-2.65-0.15-CG	0.05-0.12	2.65	0.15	2.50	2.65	●

B65-B68

• When selecting insert, please keep in your mind insert tolerance

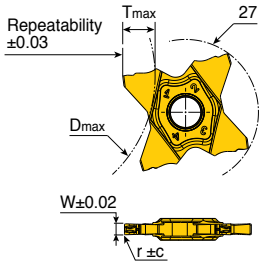
●: Standard item

TQC 27

QUAD•RUSH

Parting and grooving insert





r	C
r ≤ 0.1	0.02
0.1 < r ≤ 0.4	0.03
r > 0.4	0.05



Designation	Feed (mm/rev)	W±0.02	r	Tmax	Dmax										Grade
					T ≤ 3.0	T ≤ 3.5	T ≤ 4.0	T ≤ 4.5	T ≤ 5.0	T ≤ 5.5	T ≤ 5.7	T ≤ 6.0	T ≤ 6.2	T ≤ 6.4	TT9080
TQC 27-1.50-0.10	0.05-0.08	1.50	0.10	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
27-1.50-0.20	0.05-0.06	1.50	0.20	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
27-1.57-0.15	0.05-0.08	1.57	0.15	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-1.70-0.10	0.05-0.09	1.70	0.10	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-1.75-0.10	0.05-0.10	1.75	0.10	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-1.75-0.20	0.05-0.09	1.75	0.20	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-1.78-0.18	0.05-0.11	1.78	0.18	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-1.85-0.20	0.05-0.11	1.85	0.20	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-1.96-0.15	0.05-0.11	1.96	0.15	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
27-2.00-0.10	0.05-0.17	2.00	0.10	6.4	N.L.	600	280	180	130	105	85	60	50	30	●
27-2.00-0.20	0.05-0.15	2.00	0.20	6.4	N.L.	600	280	180	130	105	85	60	50	30	●
27-2.22-0.15	0.05-0.15	2.22	0.15	3.5	N.L.	600	-	-	-	-	-	-	-	-	●
27-2.30-0.20	0.05-0.16	2.30	0.20	3.5	N.L.	600	-	-	-	-	-	-	-	-	●
27-2.39-0.15	0.05-0.16	2.39	0.15	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
27-2.47-0.20	0.05-0.19	2.47	0.20	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
27-2.50-0.10	0.05-0.20	2.50	0.10	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
27-2.50-0.30	0.05-0.17	2.50	0.30	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
27-2.70-0.10	0.05-0.19	2.70	0.10	6.2	N.L.	600	280	180	135	105	95	85	78	-	●
27-2.87-0.20	0.05-0.19	2.87	0.20	6.2	N.L.	600	280	180	135	105	95	85	78	-	●
27-3.00-0.00	0.05-0.11	3.00	0	6.4	N.L.	600	280	180	135	105	95	85	78	55	●
27-3.00-0.20	0.06-0.23	3.00	0.20	6.4	N.L.	600	280	180	135	105	95	85	78	55	●
27-3.00-0.30	0.06-0.25	3.00	0.30	6.4	N.L.	600	280	180	135	105	95	85	78	55	●
27-3.00-0.40	0.06-0.25	3.00	0.40	6.4	N.L.	600	280	180	135	105	95	85	78	55	●
27-3.15-0.15	0.06-0.21	3.15	0.15	6.4	N.L.	600	280	180	135	105	95	85	78	68	●
27-3.18-0.20	0.06-0.23	3.18	0.20	6.4	N.L.	600	280	180	135	105	95	85	78	68	●

B65-B68

• N.L = No limit

●: Standard item

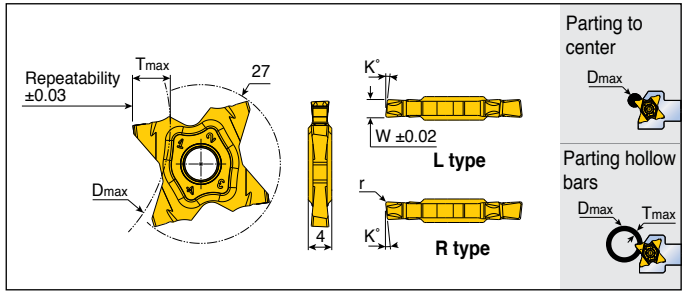
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TQC 27

QUAD•RUSH

Parting insert





Designation		Feed (mm/rev)	W±0.02	r	K°	Parting to center	Parting hollow bars		Grade
						Dmax	Tmax	Dmax	TT9080
TQC	**27-1.50-6R/L**	0.03-0.07	1.50	0.06	6	12.0	5.7	35	●
	27-1.50-15R/L	0.03-0.07	1.50	0.06	15	12.0	5.7	35	●
	27-2.00-6R/L	0.04-0.14	2.00	0.10	6	13.0	6.4	30	●
	27-2.00-15R/L	0.04-0.14	2.00	0.10	15	13.0	6.4	30	●

●: Standard item

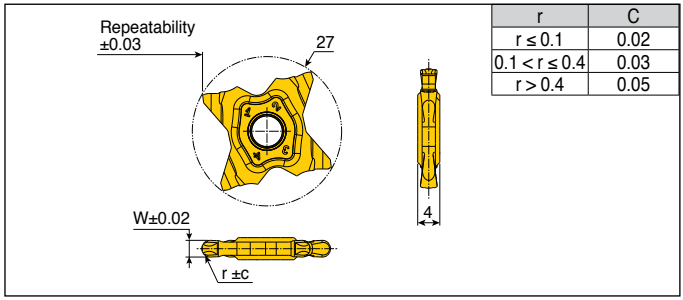
B65-B68

TQC 27

QUAD•RUSH

Full radius





r	C
r ≤ 0.1	0.02
0.1 < r ≤ 0.4	0.03
r > 0.4	0.05

Designation		Feed (mm/rev)	W±0.02	r	Tmax	Dmax									Grade
						T ≤ 3.0	T ≤ 3.5	T ≤ 4.0	T ≤ 4.5	T ≤ 5.0	T ≤ 5.5	T ≤ 5.7	T ≤ 6.0	T ≤ 6.2	T ≤ 6.4	TT9080
TQC	**27-1.57-0.79**	0.05-0.09	1.57	0.79	3.0	N.L.	-	-	-	-	-	-	-	-	-	●
	27-2.00-1.00	0.05-0.13	2.00	1.00	3.5	N.L.	600	-	-	-	-	-	-	-	-	●
	27-2.39-1.20	0.06-0.17	2.39	1.20	5.7	N.L.	600	280	180	130	50	35	-	-	-	●
	27-3.00-1.50	0.06-0.20	3.00	1.50	6.4	N.L.	600	280	180	135	105	95	85	78	55	●

• N.L = No limit

●: Standard item

B65-B68

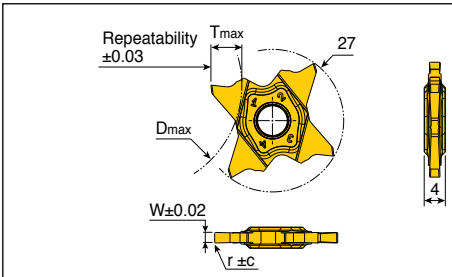
TaeguTec
Member IMC Group

TQS 27

QUAD•RUSH

Precision parting and grooving insert





r	C
r ≤ 0.1	0.02
0.1 < r ≤ 0.4	0.03
r > 0.4	0.05

Designation		Feed (mm/rev)	W(1)±0.02	r	Tmax	Dmax										Grade	
						T ≤ 3.0	T ≤ 3.5	T ≤ 4.0	T ≤ 4.5	T ≤ 5.0	T ≤ 5.5	T ≤ 5.7	T ≤ 6.0	T ≤ 6.2	T ≤ 6.4	TT9080	CT3000
TQS	**27-1.00-0.10**	0.03-0.07	1.00	0.10	3.5	N.L.	600	-	-	-	-	-	-	-	-	●	●
	27-1.50-0.20	0.03-0.10	1.50	0.20	5.7	N.L.	600	280	180	130	50	35	-	-	-	●	●
	27-2.00-0.20	0.04-0.10	2.00	0.20	6.4	N.L.	600	280	180	130	105	85	60	50	30	●	●
	27-2.39-0.15	0.04-0.15	2.39	0.15	5.7	N.L.	600	280	180	130	50	35	-	-	-	●	●
	27-2.47-0.20	0.04-0.15	2.47	0.20	5.7	N.L.	600	280	180	130	-	-	-	-	-	●	
	27-2.50-0.20	0.04-0.15	2.50	0.20	5.7	N.L.	600	280	180	130	50	35	-	-	-	●	●
	27-3.00-0.20	0.04-0.15	3.00	0.20	6.4	N.L.	600	280	180	135	105	95	85	78	55	●	●
	27-3.18 -0.20	0.05-0.16	3.18	0.20	6.9	N.L.	600	280	180	135	105	95	85	78	68	●	

B65-B68

- (1) Other size of width from 0.5mm up to 8.2mm can be supplied as special
- N.L = No limit

●: Standard item

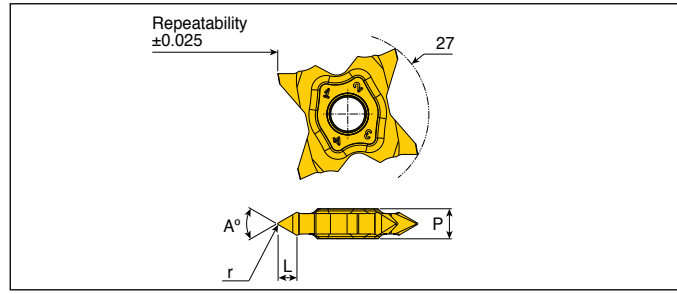
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TQS 27-MT

QUAD•RUSH

Partial profile 60˚





	Designation	r	A°	P	L	Pitch min. (mm)	TPI max.	Grade TT9080
TQS	**27-4MT-0.05**	0.05	60	4	2.8	0.45	56	●
	27-4MT-0.14	0.14	60	4	2.7	1.11	23	●
	27-5MT-0.15	0.15	60	5	3.1	1.25	20	●
	27-5MT-0.20	0.20	60	5	3.1	1.63	16	●
	27-6MT-0.25	0.25	60	6	3.6	1.94	13	●

B65-B68

- Pitch max=0.175XD, TPI min=5.7/D
- D: Diameter of thread
- TPI: Thread / Inch

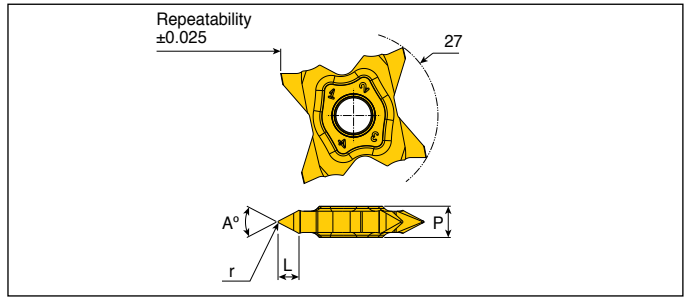
●: Standard item

TQS 27-WT

QUAD•RUSH

Partial profile 55˚





	Designation	r	A°	P	L	TPI max.	TPI min.	Grade TT9080
TQS	**27-4WT-0.05**	0.05	55	4	2.9	54	6.4 / D	●
	27-5WT-0.15	0.15	55	5	3.3	19	6.4 / D	●
	27-6WT-0.25	0.25	55	6	3.9	12	6.4 / D	●

B65-B68

- D: Diameter of thread
- TPI: Thread / Inch

●: Standard item

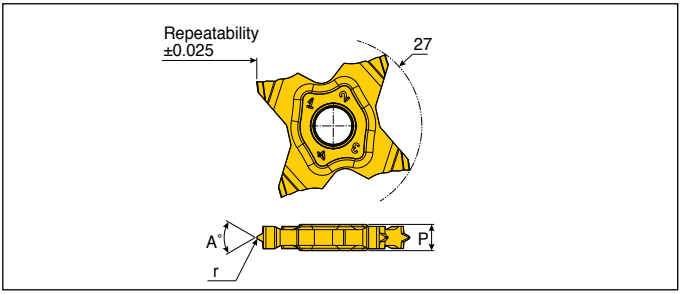
TaeguTec
Member IMC Group

TQS 27-ISO

QUAD•RUSH

ISO metric full profile, external threading





Designation		r	A°	P	Pitch	Grade TT9080
TQS	27-0.5-ISO	0.08	60	4	0.50	●
	27-0.75-ISO	0.11	60	4	0.75	●
	27-0.8-ISO	0.12	60	4	0.80	●
	27-1.0-ISO	0.14	60	4	1.00	●
	27-1.25-ISO	0.18	60	4	1.25	●
	27-1.5-ISO	0.22	60	4	1.50	●
	27-1.75-ISO	0.25	60	4	1.75	●
	27-2.0-ISO	0.28	60	4	2.00	●

B65-B68

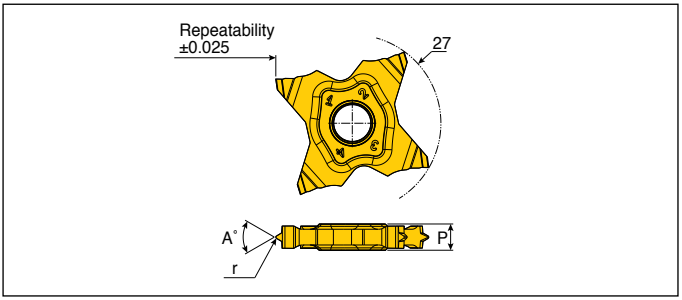
●: Standard item

TQS 27-UN

QUAD•RUSH

American UN (UNC, UNF, UNEF) full profile, external threading





Designation		r	A°	P	TPI	Grade TT9080
TQS	27-24-UN	0.13	60	4	24	●
	27-20-UN	0.16	60	4	20	●
	27-18-UN	0.16	60	4	18	●
	27-16-UN	0.21	60	4	16	●
	27-14-UN	0.23	60	4	14	●
	27-12-UN	0.27	60	4	12	●

B65-B68

• TPI: Thread / Inch

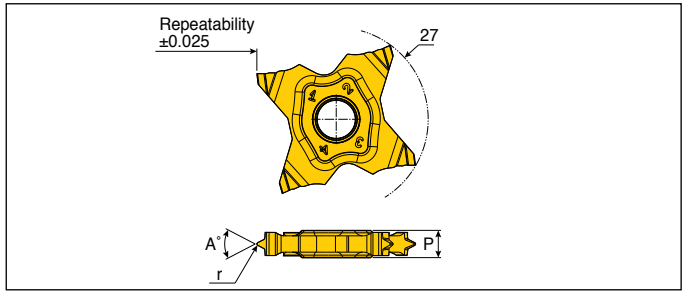
●: Standard item

TQS 27-W

QUAD•RUSH

Whitworth (BSW, BSF, BSP) full profile, external threading





Designation		r	A°	P	TPI	Grade TT9080
TQS	**27-28-W**	0.09	55	4	28	●
	27-19-W	0.15	55	4	19	●
	27-18-W	0.16	55	4	18	●
	27-16-W	0.19	55	4	16	●
	27-14-W	0.21	55	4	14	●
	27-12-W	0.25	55	4	12	●

B65-B68

• TPI: Thread / Inch

●: Standard item

TaeguTec
Member IMC Group

Tailor-made Designation System

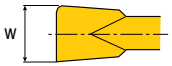
T-CLAMP ULTRA PLUS

TDIT	3.20	- 0.00	- 0.25	-	- TT8020
1	2	3	4	5	6

1 Main style of insert

T type: Chip breaker
G type: Non-chip breaker

2 Insert width



3 Corner radius



Left hand side or both sides

4 Corner radius

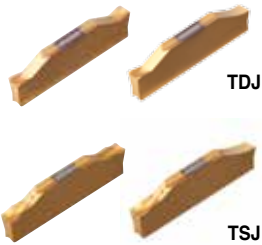


Right hand side, if different

5 Additional codes

6 Grades

Parting & Grooving



TDJ / TDC

TSJ / TSC

Turning & Grooving



TDT

TDA

TDG



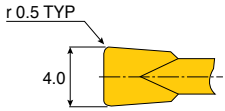
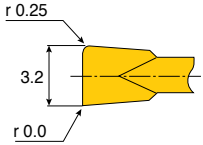
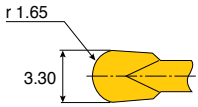
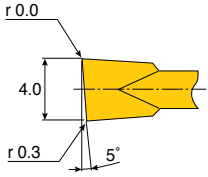
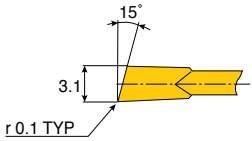
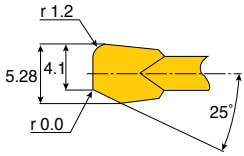
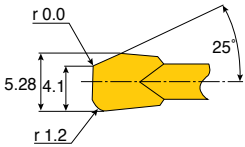
TDIT
Internal

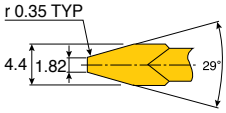
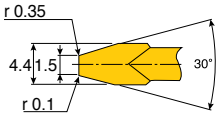
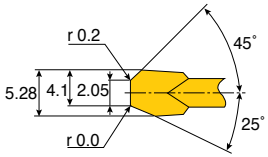
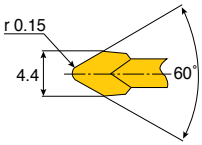
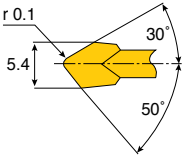
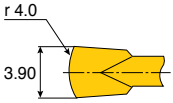
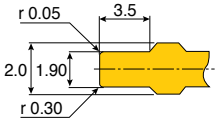
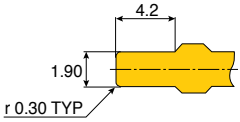
TDFT
Face

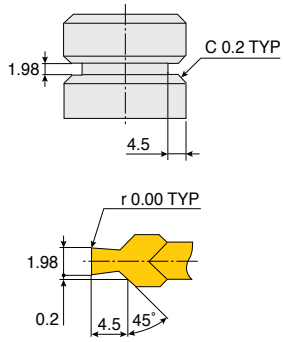
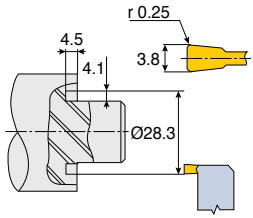
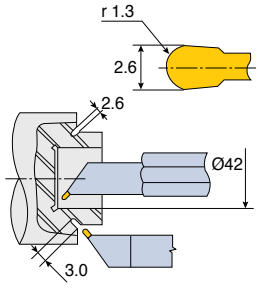
Special profile inserts

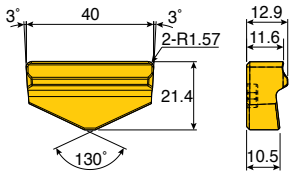
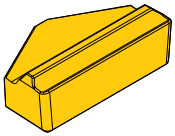
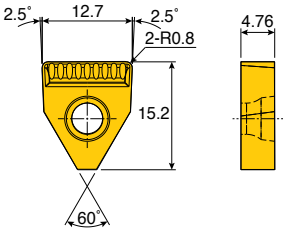
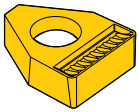


Tailor-made inserts are available upon request.

Shape	Designation	Remarks
	TDT 4.00-0.50	Symmetrical type
	TDIT 3.20-0.00-0.25	Non-symmetrical type
	TDT 3.30-1.65	Full-R type
	TDT 4.00-0.30-5RA	L: Chamfer on left hand side R: Chamfer on right hand side
	TDT 3.10-0.10-15LA	
	TDG 5.28-1.20-R25A	
	TDT 5.28-1.20-L25A	

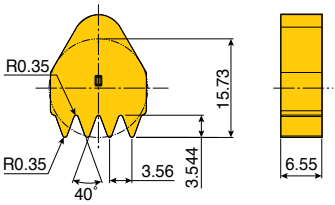
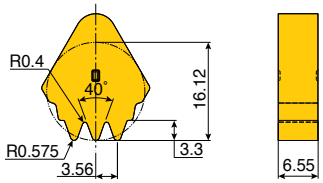
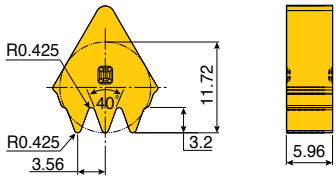
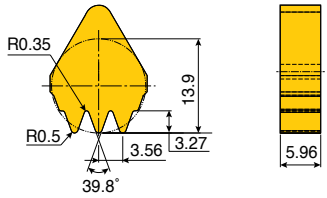
Shape	Designation	Remarks
	TDG 4.40-1.82-29A	L: Chamfer on left hand side R: Chamfer on right hand side
	TDT 4.40-1.50-30A	
	TDT 5.28-2.05-45R25L	
	TDG 4.40-0.15-60A	
	TDG 5.40-0.10-30R50L	
	TDT 3.90-4.00	
	TDT 1.90-T3.5C	
	TDT 1.90-0.30-4.20T	

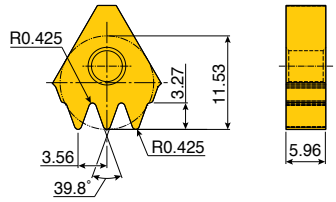
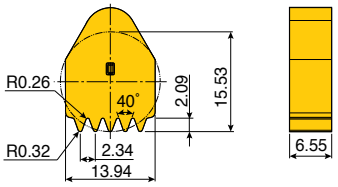
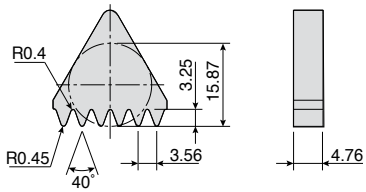
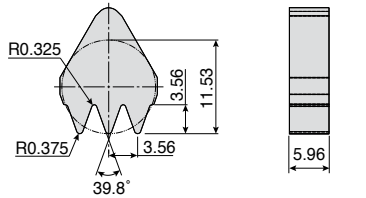
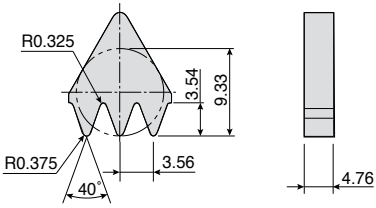
Shape	Designation	Remarks
	TDG 1.98-T4.5C	
	TDFT 3.80E-0.25	
	TDIT 2.60-1.30	
The others	Available upon customer's request	

Designation	Dimension (mm)	Remarks
XNMR 401416-HD		
XNGT 332-GV		



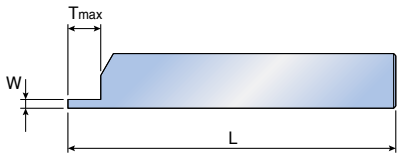


Shape	Designation	Grade	Pitch	Z
	B ZT 2706035-N4	Carbide	3.56	4
	B ZT 2706043-N3	Carbide	3.56	3
	B ZT 22-5.76-0.425-N3	Carbide	3.56	3
	B ZT 13.5-5.76-N3	Carbide	3.56	3

Shape	Designation	Grade	Pitch	Z
	B ZT 22-5.76-N3-A20	Carbide	3.56	3
	B ZT1215-NO	Carbide	2.34	5
	B ZT 5030-ITX	Ceramic	3.56	6
	B ZT 22-5.76-N3-CE-P	Ceramic	3.56	3
	D INMN 09A111	Ceramic	3.56	3

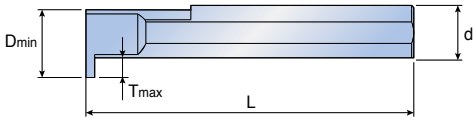
Specific dimensions

External holder



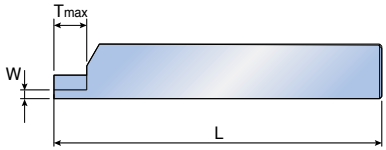
Right handed shown

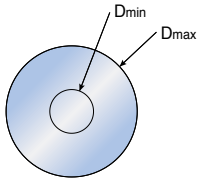
Internal holder



Right handed shown

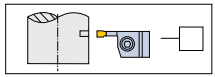
Facing holder



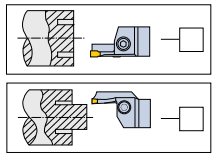


Right handed shown

External holder

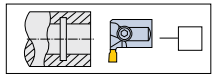


Facing holder



RN type

Internal holder



Holder handed

- Right handed
- Light handed

Insert

- Grade:
- Chip breaker type:

Quantity

- pcs

Workpieces

- Part:
- Material:
- Hardness:

Comment

- Customer: _____
- Contact: _____
- Address : _____
- Telephone : _____
- Fax : _____
- E-mail : _____

Recommended Cutting Conditions

T-CLAMP ULTRA PLUS

Parting and grooving

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc(m/min)		
							TT9080 TT7220	TT8020	K10
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	140-250	80-120	
		>=0.25%C	Annealed	650	190	2	130-220	80-110	
		<0.55%C	Quenched and tempered	850	250	3	90-200	70-90	
		>=0.55%C	Annealed	750	220	4	100-220	70-100	
			Quenched and tempered	1000	300	5	70-170	40-70	
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	90-120	70-100	
			Quenched and tempered	930	275	7	80-170	50-70	
				1000	300	8	70-130	40-60	
				1200	350	9	50-120	30-50	
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	60-140	50-80	
			Quenched and tempered	1100	325	11	50-70	30-60	
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	70-170	80-120	
			Martensitic	820	240	13	60-150	60-90	
			Austenitic	600	180	14	90-180	60-90	
K	Gray cast iron (GG)		Ferritic		160	15	100-230		60-80
			Pearlitic		250	16	90-180		50-70
	Cast iron nodular (GGG)		Ferritic		180	17	190-300		70-100
			Pearlitic		260	18	120-220		70-90
	Malleable cast iron		Ferritic		130	19	120-250		60-85
			Pearlitic		230	20	100-210		45-75
N	Aluminum - Wrought alloy		Not cureable		60	21			
			Cured		100	22			
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23			
			Cured		90	24			
		>12% Si	High temp.		130	25			
	Copper alloys	>1% Pb	Free cutting		110	26			
			Brass		90	27			
			Electrolitic copper		100	28			
	Non-metallic		Duroplastics, fiber plastics			29			
			Hard rubber			30			
S	High temp. alloys	Fe based	Annealed		200	31	40-70		35-50
			Cured		280	32	30-50		25-40
		Ni or Co based	Annealed		250	33	30-40		20-30
			Cured		350	34	15-25		15-20
			Cast		320	35	15-30		15-20
	Titanium, Ti alloys			Rm 400		36	90-190		150-200
			Alpha+beta alloys cured	Rm 1050		37	30-60		50-80
H	Hardened steel		Hardened		55HRC	38			
			Hardened		60HRC	39			
	Chilled cast iron		Cast		400	40			
	Cast iron nodular		Hardened		55HRC	41			

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

T-CLAMP ULTRA PLUS

Turning and grooving

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Groove-turn, profiling, undercutting cutting speed Vc(m/min)	
							KP300	TB650
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1		
		>=0.25%C	Annealed	650	190	2		
		<0.55%C	Quenched and tempered	850	250	3		
		>=0.55%C	Annealed	750	220	4		
			Quenched and tempered	1000	300	5		
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6		
			Quenched and tempered	930	275	7		
				1000	300	8		
				1200	350	9		
	High alloy steel, cast steel and tool steel		Annealed	680	200	10		
			Quenched and tempered	1100	325	11		
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12		
			Martensitic	820	240	13		
			Austenitic	600	180	14		
K	Gray cast iron (GG)		Ferritic		160	15		
			Pearlitic		250	16		
	Cast iron nodular (GGG)		Ferritic		180	17		
			Pearlitic		260	18		
	Malleable cast iron		Ferritic		130	19		
			Pearlitic		230	20		
N	Aluminum - Wrought alloy		Not cureable		60	21	150-2500	
			Cured		100	22	150-2500	
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	150-2500	
			Cured		90	24	150-2500	
		>12% Si	High temp.		130	25	330-800	
	Copper alloys	>1% Pb	Free cutting		110	26		
			Brass		90	27	330-800	
			Electrolitic copper		100	28	190-400	
	Non-metallic		Duroplastics, fiber plastics			29		
			Hard rubber			30		
S	High temp. alloys	Fe based	Annealed		200	31		
			Cured		280	32		
		Ni or Co based	Annealed		250	33		
			Cured		350	34		
			Cast		320	35		
	Titanium, Ti alloys			Rm 400		36		
			Alpha+beta alloys cured	Rm 1050		37		
H	Hardened steel		Hardened		55HRC	38		90-110
			Hardened		60HRC	39		80-100
	Chilled cast iron		Cast		400	40		180-200
	Cast iron nodular		Hardened		55HRC	41		90-110

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

Turning and grooving

Groove-turn, profiling, undercutting cutting speed Vc(m/min)						Internal grooving, face grooving cutting speed Vc(m/min)				
CT3000	TT7505	TT6080	TT9080 TT7220	TT8020	K10	TT7505	TT6080	TT9080 TT7220	TT8020	K10
100-210			100-200	100-180				100-150	80-110	
100-200			100-180	100-150				60-100	60-90	
80-180			80-160	80-130						
80-180			80-160	80-130				60-110	50-90	
70-150			70-130	70-120						
100-180			100-160	10-150				60-110	40-70	
90-180			80-160	80-150				70-110	40-60	
80-170			80-150	80-130						
80-150			80-130	80-120				60-90	30-50	
90-130			90-130	90-110				60-90	30-50	
50-80			50-80	50-70				50-80	30-40	
80-170			80-170	80-170				50-130	40-80	
80-150			80-150	80-150						
80-170			80-170	80-170				40-130	30-80	
	150-270	110-250			70-100	90-140	70-120			40-60
	120-170	90-140			50-90	80-120	60-100			40-60
	150-250	120-230			70-100	90-130	70-110			40-60
	120-200	90-180			60-90	80-110	60-90			30-50
	120-200	90-180			60-120	80-130	60-110			20-40
	100-180	80-150			50-80	60-100	50-90			20-40
					300-800					100-300
					230-310					100-300
					280-830					100-300
					200-510					100-300
					130-300					80-200
					120-200					80-150
					90-150					60-100
			30-50	20-30	30-40			20-40	20-30	
			20-40	15-20	20-40			15-30	15-20	
			20-30	15-20	20-30			15-20	15-20	
			15-20	15-20	15-20			15-20	15-20	
			15-20	15-20	15-20			15-20	15-20	
			130-170	80-100	100-130			90-120	60-80	
			40-70	15-30	20-50			20-50	15-30	
	30-50				20-40	15-25				15-20
	30-50				20-30	15-25				15-20
	30-50				20-50	15-25				15-25
	30-50				20-40	15-25				15-25

Recommended Cutting Conditions

QUAD•RUSH

QUADRUSH

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc(m/min) TT9080
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	110-200
		>=0.25%C	Annealed	650	190	2	100-180
		<0.55%C	Quenched and tempered	850	250	3	70-160
		>=0.55%C	Annealed	750	220	4	80-180
			Quenched and tempered	1000	300	5	60-140
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	80-180
			Quenched and tempered	930	275	7	70-140
				1000	300	8	60-110
				1200	350	9	40-100
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	50-110
			Quenched and tempered	1100	325	11	40-100
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	60-140
			Martensitic	820	240	13	120-180
			Austenitic	600	180	14	70-140
K	Gray cast iron (GG)		Ferritic		160	15	120-180
			Pearlitic		250	16	70-140
	Cast iron nodular (GGG)		Ferritic		180	17	70-130
			Pearlitic		260	18	60-115
	Malleable cast iron		Ferritic		130	19	60-70
			Pearlitic		230	20	80-170
N	Aluminum - Wrought alloy		Not cureable		60	21	100-365
			Cured		100	22	80-220
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	200-400
			Cured		90	24	200-280
		>12% Si	High temp.		130	25	200-280
	Copper alloys	>1% Pb	Free cutting		110	26	80-255
			Brass		90	27	80-255
			Electrolitic copper		100	28	80-255
	Non-metallic		Duroplastics, fiber plastics			29	80-250
			Hard rubber			30	80-250
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	25-40
		Ni or Co based	Annealed		250	33	25-35
			Cured		350	34	15-25
			Cast		320	35	15-30
	Titanium, Ti alloys			Rm 400		36	70-150
			Alpha+beta alloys cured	Rm 1050		37	25-50
H	Hardened steel		Hardened		55HRC	38	45-60
			Hardened		60HRC	39	45-60
	Chilled cast iron		Cast		400	40	45-60
	Cast iron nodular		Hardened		55HRC	41	45-60

• For more information of material groups, see the materials & grades "material conversion table"

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

• **Feed rate:** Neutral: 0.05-0.18 mm/rev, Handed: Reduce 20% feed rate

Recommended Cutting Conditions

T-CLAMP ULTRA PLUS

Ceramic T-CLAMP ULTRA PLUS insert

Material			Grooving	Turning
P	High hardened steel	Vc (m/min)	Not recommended	250-350
		F (mm/rev)		0.08-0.20
K	Cast iron	Vc (m/min)	600-800	600-800
		F (mm/rev)	0.1-0.2	0.1-0.24

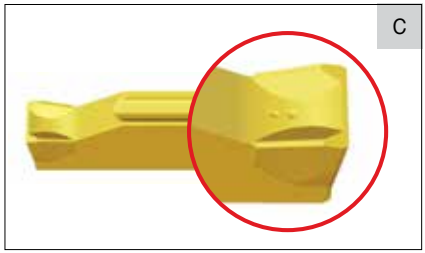
• Above condition is adapted to TDT 4E-0.4T CE AB30

TOPMICRO

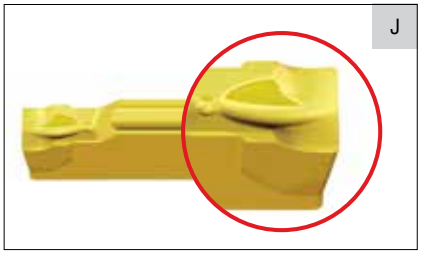
TOPMICRO

Cutting speed Vc(m/min)		Feed (mm/rev)		
		Turning / Back turning	Grooving	Face grooving
P	30-150	0.01-0.08	0.01-0.05	0.01-0.04
M	30-130			
K	30-150			
N	50-200			
S	10-50			

Selection of chip breakers



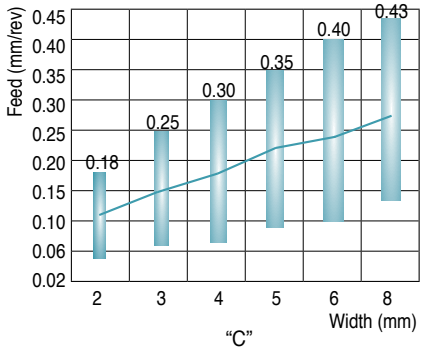
- For hard materials and tough applications
- For general applications on steel, alloy steel and stainless steel
- Medium-to-high feeds

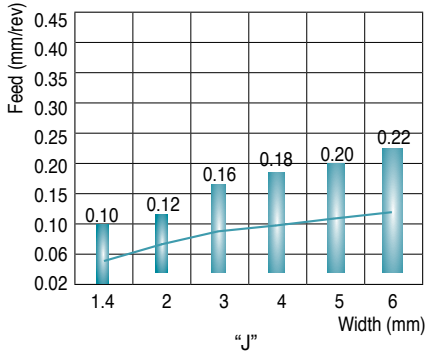


- For soft materials, parting of tubes, small diameters and thin-walled parts
- Low forces and smaller burrs
- Improved straightness
- Low-to-medium feeds

■ Recommended feed range as a function of insert width

Material; SAE4140 (HB240)
Recommendations are for neutral inserts - for R/L inserts reduce feeds by 20 - 40%



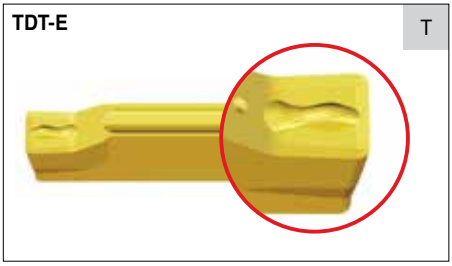


Workpiece materials					
	Alloy steel	Austenitic stainless	High - Temp alloys	Nonferrous materials	Cast iron
High ↑ Feed ↓ Low	C	C	C	C Brass	C
	J	J	J Titanium	J Aluminum	

Chip breaker style: “T” chip breaker

- The “T” chip breaker is available for turning and grooving of steel, alloy steel and stainless steel
- Inserts with “T” style chip breaker contain a central chipbreaking island for multi-direction chip control
- TDXT insert has the same chip breaker as “T” insert but it has more front & side clearance angle to use in nternal and face application. This insert will cover existing grounded TDIT/TDFT insert

TDT-E T

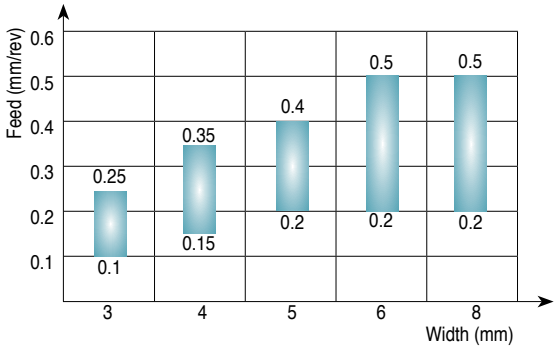


TDXT

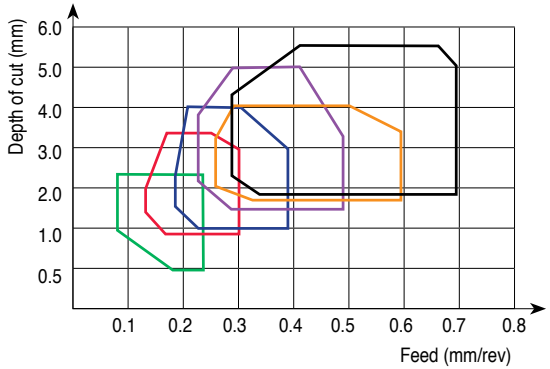


TDT/TDXT cutting condition table

■ Grooving



■ Turning

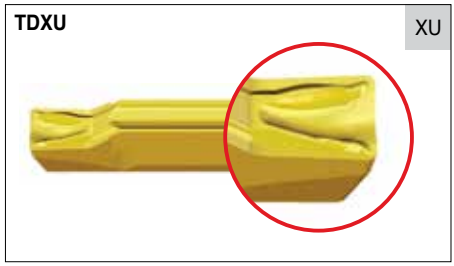


- Workpiece: SAE 1045 (C45)
- Cutting speed: Vc=100 - 180 m/min

TDT 10.00E-0.80
TDT 5.00E-0.80
TDT 8.00E-0.80
TDT 4.00E-0.80
TDT 6.00E-0.80
TDT 3.00E-0.40

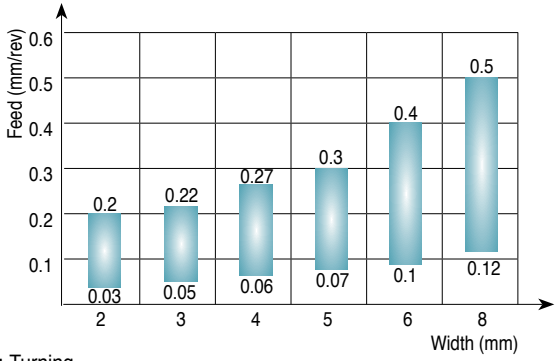
Chip breaker style: “XU” chip breaker

- First choice on general use in grooving & turning application
- Excellent chip-control ability
- Low to medium feeds in grooving & turning
- Multipurpose for external, internal & face grooving and turning machining is possible

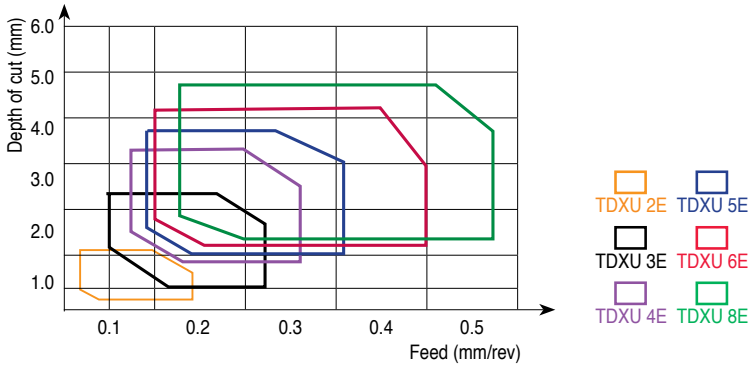


TDXU cutting condition table

■ Grooving



■ Turning



TDIM, TDIP chip breaker

- Economical double-ended insert
- Multiple applications
  - TDIM: pressed insert with efficient chip breaker for boring and grooving operations
  - TDIP: ground insert for precise machining

TDIM

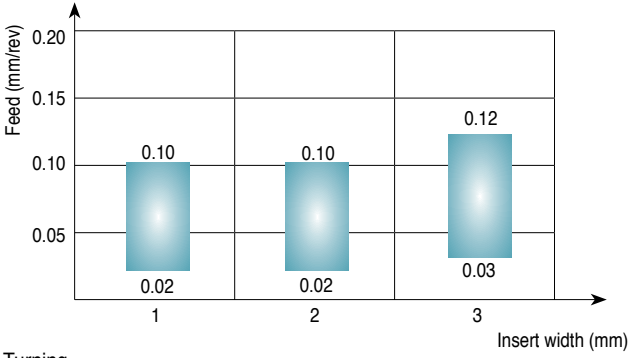


TDIP

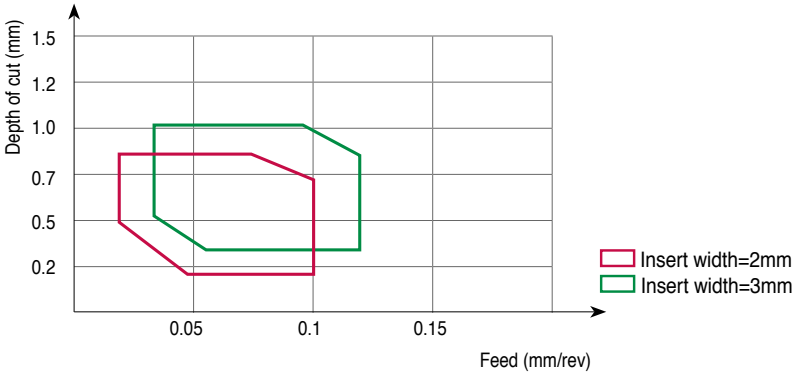


TDIM, TDIP cutting conditions

▪ Grooving



▪ Turning



THREAD MAKING



THREAD MAKING

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TaeguTec Member IMC Group

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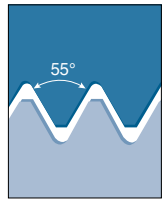
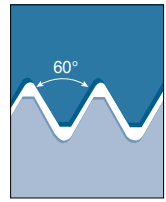
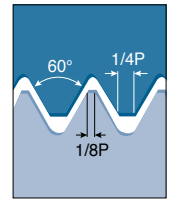
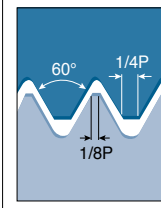
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T-THREAD (Thread Turning)	
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Insert Designation System	C18
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Tool Selection Guide

Threading inserts

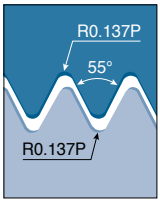
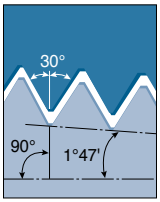
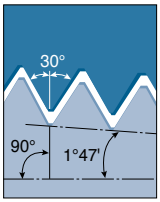
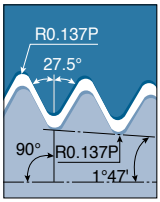
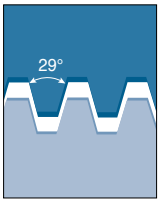
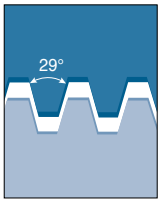
Thread		T-THREAD			
		55° thread	60° thread	Metric ISO	American UN
					
Pages		C19	C20	C21 - C25	C26 - C30
Type of threading		Partial profile	Partial profile	Full profile	Full profile
Application		General use for 55° thread forms for wide range of pitches	General use for 60° thread forms for wide range of pitches	General usage for all industries	General usage for all industries
 M - type	ER	●	●	●	●
	IR	●	●	●	●
 Regular type	ER/IR	●	●	●	●
	EL/IL	●	●	●	●
 B - type	ER	●	●	●	●
	IR	●	●	●	●
 U - type	IRL	●	●	●	●
	EIRL	●	●		
	ERL			●	●
 Multi-tooth type	ER			●	●
	IR			●	●

ER: External right hand **EL**: External left hand **IR**: Internal right hand **IL**: Internal left hand
ERL: External right / left hand **IRL**: Internal Right / left hand **EIRL**: External / internal right / left hand

TaeguTec Member IMC Group

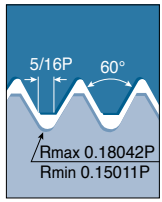
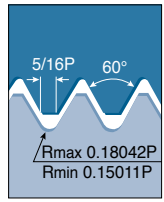
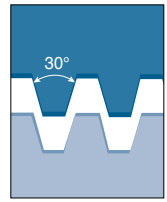
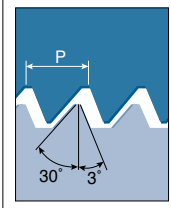
Tool Selection Guide

Threading inserts

T-THREAD					
Whitworth	**NPT**	**NPTF**	**BSPT**	**STUB ACME**	**ACME**
					
C31 - C35	C36 - C37	C38	C39	C40	C41
Full profile	Full profile	Full profile	Full profile	Partial profile	Partial profile
General industries. Pipe fittings and couplings	Steam, gas and water pipes	Steam, gas and water pipes. Dry seal	55° form for steam, gas and water pipes	Shallow ACME profile for motion transmission	Motion transmission. Feed screws
●	●		●		
●	●		●		
●	●	●	●	●	●
●	●	●	●	●	●
●	●		●		
●	●		●		
					●
●					
					●
●	●				
●	●				

Tool Selection Guide

Threading inserts

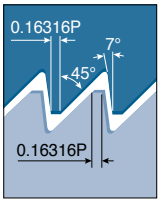
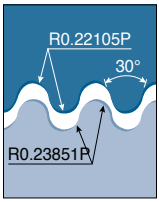
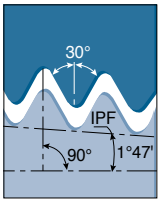
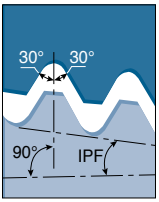
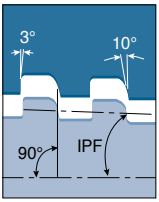
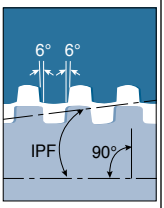
Thread		T-THREAD			
		UNJ	MJ	Trapez DIN 103	Sagengenwinde DIN 513
					
Pages		C42 - C43	C44	C45	C47
Type of threading		Full profile	Full profile	Partial profile	Full profile
Application		Aviation and aerospace industry	Aviation and aerospace industry	Motion transmission. Feed screws	For high force in one direction
 M - type	ER				
	IR				
 Regular type	ER/IR	●	●	●	●
	EL/IL	●		●	●
 B - type	ER				
	IR				
 U - type	ER/IR				●
	EL/IL				●
	ERL/IRL			●	
 Multi-tooth type	ER				
	IR				

ER: External right hand **EL**: External left hand **IR**: Internal right hand **IL**: Internal left hand
ERL: External right / left hand **IRL**: Internal Right / left hand **EIRL**: External / internal right / left hand

TaeguTec Member IMC Group

Tool Selection Guide

Threading inserts

T-THREAD					
American buttress	**Round DIN 405**	**API round**	**API**	**Buttress casing**	**Extreme line casing**
					
C48	C49	C50 - C51	C52	C53	C53
Full profile	Full profile	Full profile	Full profile	Full profile	Full profile
For high force in one direction	Pipe coupling in fire fighting, chemical and food industries	60˚ thread with large radius in the oil and gas industry	60˚ thread form for pipe connections in the oil and gas industry	Tube and casings in the oil and gas industry	Tube and casings in the oil and gas industry
	●				
	●				
●	●	●	●	●	●
●	●				
●					
●					

Grades

Thread making grades

Grades	ISO	Characteristics & applications
TT7010 PVD coated	P05 – P25 K05 – K25	• General machining of steel and cast iron
TT8010 PVD coated	P30 – P50 M30 – M50 S30 – S50	• Toughest grade in threading product line • For a wide range of threading on low carbon steel & low carbon alloy steel • Medium to low speed threading of stainless steel and exotic materials
TT9030 PVD coated	P20 – P40 M20 – M40 S20 – S40	• General machining of steel • General machining of stainless steel • General machining of heat-resistant alloy
P30 Carbide	P25 – P35	• General machining of steel

T-THREAD

Thread Turning



Holder Designation System

S	E	R	2020	K	16	□
1	2	3	4	5	6	7

1 Clamping system

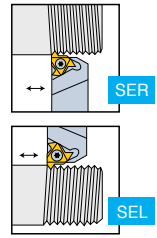
S - Screw clamping

2 Application

E - External
I - Internal

3 Hand of tool

R - Right-hand
L - Left-hand



4 Shank size

External toolholders
Shank: h×b

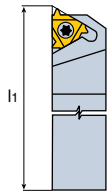
2020: 20×20 mm

Internal toolholders
Neck diameter

0025: Neck diameter 25 mm

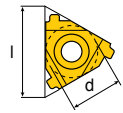
5 Tool length

		mm
D	-	60
F	-	80
H	-	100
K	-	125
L	-	140
M	-	150
P	-	170
R	-	200
S	-	250
T	-	300
U	-	350
V	-	400



6 Insert size

l (mm)	d
06	3.968 mm = 5/32″
08	4.762 mm = 3/16″
08U	4.762 mm = 3/16″
11	6.350 mm = 1/4″
16	9.525 mm = 3/8″
22	12.700 mm = 1/2″
22U	12.700 mm = 1/2″
27	15.875 mm = 5/8″
27U	15.875 mm = 5/8″



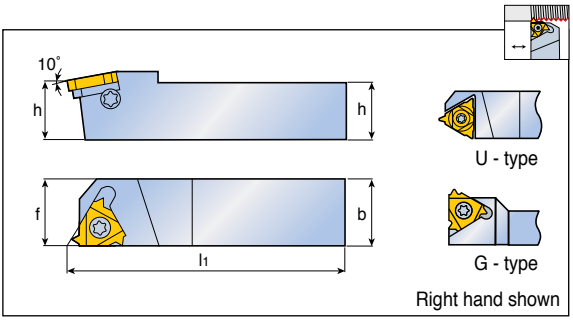
7 Optional specifications

U - For U-type inserts
B - Bore for coolant
C - Carbide shank
D - Drop head
G - Gang tool
AD - Short type
SP - Special

SER/L

External threading toolholders



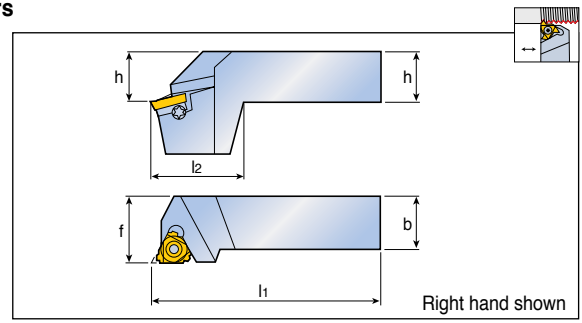


	Designation	Dimension (mm)				Insert [2]
		h	b	l1	f	
SER	0808 H11 [1]	8	8	100	11	11 ER...
	1616 K16G	16	16	125	21.7	16 ER...
	4040 R27	40	40	200	40	27 ER...
SER/L	1010 H11 [1]	10	10	100	11	11 ER/L...
	1212 F16	12	12	80	16	16 ER/L...
	1616 H16	16	16	100	16	16 ER/L...
	2020-16-AD	20	20	67	25	16 ER/L...
	2020 K16	20	20	125	20	16 ER/L...
	2525 M16	25	25	150	25	16 ER/L...
	3232 P16	32	32	170	32	16 ER/L...
	2525 M22	25	25	150	25	22 ER/L...
	3232 P22	32	32	170	32	22 ER/L...
	4040 R22	40	40	200	40	22 ER/L...
	2525 M22U	25	25	150	28	22 UERL...
	3232 P22U	32	32	170	32	22 UERL...
	4040 R22U	40	40	200	40	22 UERL...
	2525 M27	25	25	150	25	27 ER/L...
	3232 P27	32	32	170	32	27 ER/L...
	2525 M27U	25	25	150	32	27 UERL...
	3232 P27U	32	32	170	32	27 UERL...
	4040 R27U	40	40	200	40	27 UERL...

- [1] Toolholders without anvil
- [2] Right hand inserts (ER) for right hand tools (SER)
- All Toolholders are made with 1.5° helix angle
- For multi-tooth inserts, use anvils AE16M or AI16M
- Please check for spare parts C15 page

External threading drophead toolholders





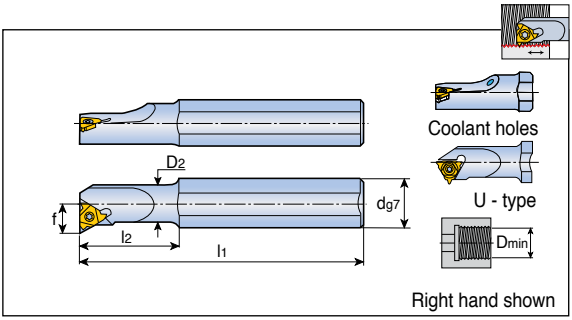
Designation		Dimension (mm)					Insert
		h	b	l_1	f	l_2	
SER	**2020 K16D**	20	20	125	25	38	16 ER...
	2525 M16D	25	25	150	32	38	16 ER...
	2525 M22D	25	25	150	32	38	22 ER...

- All Toolholders are made with 1.5° helix angle
- Please check for spare parts C15 page

SIR/L

Internal threading toolholders





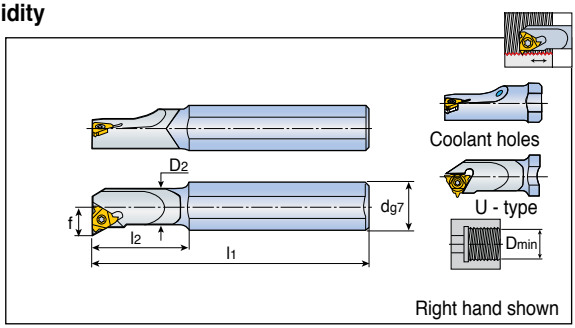
	Designation	Dimension (mm)						Coolant	Insert [2]
		d	D2	l1	l2	Dmin	f		
SIR/L	**0005 H06** [1]	12	5.1	100	12	6.4	4.3	X	06 IR/L...
	0007 K08 [1]	16	6.6	125	18	7.8	5.3	X	08 IR/L...
	0008 K08U [1]	16	7.4	125	21	9.0	6.4	X	08 UIRL...
	0010 H11 [1]	10	10	100	-	12	7.4	X	11 IR/L...
SIR	**0010 H11B** [1]	10	10	100	-	12	7.4	●	11 IR...
SIR/L	**0010 K11** [1]	16	10	125	25	12	6.5	X	11 IR/L...
	0010 K11B [1]	16	10	125	25	12	7.4	●	11 IR/L...
	0013 L11 [1]	16	13	140	32	15	8.9	X	11 IR/L...
	0013 M16 [1]	16	13	150	32	16	10.0	X	16 IR/L...
	0013 M16B [1]	16	13	150	32	16	10.2	●	16 IR/L...
	0016 P16 [1]	20	16	170	40	19	11.4	X	16 IR/L...
	0016 P16B [1]	20	16	170	40	19	11.7	●	16 IR/L...
	0020-16-AD	20	20	80	-	24	13.7	X	16 IR/L...
	0020 P16	20	20	170	-	24	13.4	X	16 IR/L...
	0020 P16B	20	20	170	-	24	13.7	●	16 IR/L...
	0025-16-AD	25	25	120	-	29	16.3	X	16 IR/L...
	0025 R16	25	25	200	-	29	16.3	X	16 IR/L...
	0025 R16B	25	25	200	-	29	16.2	●	16 IR/L...
	0032 S16	32	32	250	-	36	19.6	X	16 IR/L...
	0040 T16	40	40	300	-	44	23.8	X	16 IR/L...
	0050 U16	50	50	350	-	54	28.7	X	16 IR/L...
	0020 P22 [1]	20	20	170	-	24	15.6	X	22 IR/L...
	0025 R22	25	25	200	-	29	17.2	X	22 IR/L...
	0025 R22B	25	25	200	-	29	18.1	●	22 IR/L...
	0032 S22	32	32	250	-	38	21.5	X	22 IR/L...
	0040 T22	40	40	300	-	46	25.8	X	22 IR/L...
	0050 U22	50	50	350	-	56	30.6	X	22 IR/L...
	0032 S22U	32	32	250	-	38	25.5	X	22 UIRL...
	0040 T22U	40	40	300	-	46	29.5	X	22 UIRL...
	0032 S27	32	32	250	-	40	22.4	X	27 IR/L...
	0040 T27	40	40	300	-	48	26.4	X	27 IR/L...
	0050 U27	50	50	350	-	58	31.4	X	27 IR/L...
	0060 V27	60	60	400	-	68	36.4	X	27 IR/L...
	0032 S27U	32	32	250	-	40	24.7	X	27 UIRL...
	0040 T27U	40	40	300	-	48	29.4	X	27 UIRL...
	0050 U27U	50	50	350	-	58	34.3	X	27 UIRL...
	0060 V27U	60	60	400	-	68	39.3	X	27 UIRL...

- [1] Toolholders without anvil
- [2] Right hand inserts (IR) for right hand tools (SIR)
- All Toolholders are made with 1.5° helix angle
- Please check for spare parts C16 page

SIR/L...CB

Solid carbide threading bars for high rigidity





	Designation	Dimension (mm)						Coolant	Insert (2)
		d	D2	l1	l2	Dmin	f		
SIR/L	**0005 H06CB** (1)	6	5.1	100	25	6.4	4.3	●	06 IR/L...
	0007 K08CB (1)	8	6.6	125	30	7.8	5.3	●	08 IR/L...
	0008 K08UCB (1)	8	7.3	125	35	9.0	6.4	●	08 UIRL...
	0010 M11CB (1)	10	10	150	-	12	7.4	●	11 IR/L...
	0012 P11CB (1)	12	12	170	-	15	8.4	●	11 IR/L...
	0016 R16CB (1)	16	16	200	-	19	11.7	●	16 IR/L...
	0020 S16CB	20	20	250	-	28	13.7	●	16 IR/L...
	0025 S16CB	25	25	250	-	28	16.2	●	16 IR/L...

- (1) Toolholders without anvil
- All Toolholders are made with 1.5° helix angle
- Please check for spare parts C16 page
- (2) Right hand inserts (IR) for right hand tools (SIR)
- All carbide shank Toolholders are coolant through type

Spare Parts

SER/L

Designation	Insert screw	Anvil screw	Anvil int./ext. right	Anvil int./ext. left	Torx wrench
					
SER 0808 H11	S11				T-8/5
SER/L 1010 H11	S11				T-8/5
SEL 1212 F16	S16	A16		AI16	T-10/5
SER 1212 F16	S16	A16	AE16		T-10/5
SEL 1616 H16	S16	A16		AI16	T-10/5
SER 1616 H16	S16	A16	AE16		T-10/5
SER 1616 K16G	S16	A16	AE16		T-10/5
SEL 2020-16-AD	S16	A16		AI16	T-10/5
SER 2020-16-AD	S16	A16	AE16		T-10/5
SEL 2020 K16	S16	A16		AI16	T-10/5
SER 2020 K16	S16	A16	AE16		T-10/5
SEL 2525 M16	S16	A16		AI16	T-10/5
SER 2525 M16	S16	A16	AE16		T-10/5
SEL 3232 P16	S16	A16		AI16	T-10/5
SER 3232 P16	S16	A16	AE16		T-10/5
SEL 2525 M22	S22	A22		AI22	T-20/5
SER 2525 M22	S22	A22	AE22		T-20/5
SEL 3232 P22	S22	A22		AI22	T-20/5
SER 3232 P22	S22	A22	AE22		T-20/5
SEL 4040 R22	S22	A22		AI22	T-20/5
SER 4040 R22	S22	A22	AE22		T-20/5
SEL 2525 M22U	S22	A22		AI22U	T-20/5
SER 2525 M22U	S22	A22	AE22U		T-20/5
SEL 3232 P22U	S22	A22		AI22U	T-20/5
SER 3232 P22U	S22	A22	AE22U		T-20/5
SEL 4040 R22U	S22	A22		AI22U	T-20/5
SEL 2525 M27	TS40	A27		AI27	TK40
SER 2525 M27	TS40	A27	AE27		TK40
SEL 3232 P27	TS40	A27		AI27	TK40
SER 3232 P27	TS40	A27	AE27		TK40
SER 4040 R27	TS40	A27	AE27		TK40
SEL 2525 M27U	TS40	A27		AI27U	TK40
SEL 3232 P27U	TS40	A27		AI27U	TK40
SER 3232 P27U	TS40	A27	AE27U		TK40
SEL 4040 R27U	TS40	A27		AI27U	TK40

SER-D

Designation	Insert screw	Anvil screw	Anvil int./ext. right	Anvil int./ext. left	Torx wrench
					
SER 2525 M16D	S16	A16	AE16	-	T-10/5
SER 2525 M22D	S22	A22	AE22	-	T-20/5

Spare Parts

SIR/L

Designation	Insert screw	Anvil screw	Anvil int./ext. right	Anvil int./ext. left	Torx wrench
					
SIR/L 0005 H06	TS 20038I				T-6/5
SIR/L 0005 H06CB	TS 20038I				T-6/5
SIR 0005 H06-W	TS 20038I				T-6/5
SIR/L 0007 K08	TS 20054I				T-6/5
SIR/L 0007 K08CB	TS 20054I				T-6/5
SIR/L 0008 K08U	TS 20054I				T-6/5
SIR 0008 K08UCB	TS 20054I				T-6/5
SIR/L 0010 H11	S11				T-8/5
SIR 0010 H11B	S11				T-8/5
SIR/L 0010 K11	S11				T-8/5
SIR/L 0010 K11B	S11				T-8/5
SIR/L 0010 M11CB	S11				T-8/5
SIR/L 0012 P11CB	S11				T-8/5
SIR/L 0013 L11	S11				T-8/5
SIR/L 0013 M16	S16S				T-10/5
SIR/L 0013 M16B	S16S				T-10/5
SIR/L 0016 P16	S16S				T-10/5
SIR/L 0016 P16B	S16S				T-10/5
SIR 0016 R16CB	S16S				T-10/5
SIL 0020-16-AD	S16	A16	AE16		T-10/5
SIR 0020-16-AD	S16	A16		AI16	T-10/5
SIL 0020 P16	S16	A16	AE16		T-10/5
SIR 0020 P16	S16	A16		AI16	T-10/5
SIL 0020 P16B	S16	A16	AE16		T-10/5
SIR 0020 P16B	S16	A16		AI16	T-10/5
SIR 0020 S16CB	S16	A16		AI16	T-10/5
SIL 0025-16-AD	S16	A16	AE16		T-10/5
SIR 0025-16-AD	S16	A16		AI16	T-10/5
SIL 0025 R16	S16	A16	AE16		T-10/5
SIR 0025 R16	S16	A16		AI16	T-10/5
SIL 0025 R16B	S16	A16	AE16		T-10/5
SIR 0025 R16B	S16	A16		AI16	T-10/5
SIR 0025 S16CB	S16	A16		AI16	T-10/5
SIL 0032 S16	S16	A16	AE16		T-10/5
SIR 0032 S16	S16	A16		AI16	T-10/5
SIL 0040 T16	S16	A16	AE16		T-10/5
SIR 0040 T16	S16	A16		AI16	T-10/5
SIL 0050 U16	S16	A16	AE16		T-10/5
SIR 0050 U16	S16	A16		AI16	T-10/5

Spare Parts

SIR/L

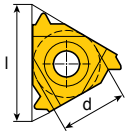
Designation	Insert screw	Anvil screw	Anvil int./ext. right	Anvil int./ext. left	Torx wrench
					
SIL 0020 P22	S22S				T-20/5
SIR 0020 P22	S22S				T-20/5
SIL 0025 R22	S22	A22	AE22		T-20/5
SIR 0025 R22	S22	A22		AI22	T-20/5
SIL 0025 R22B	S22	A22	AE22		T-20/5
SIR 0025 R22B	S22	A22		AI22	T-20/5
SIL 0032 S22	S22	A22	AE22		T-20/5
SIR 0032 S22	S22	A22		AI22	T-20/5
SIL 0040 T22	S22	A22	AE22		T-20/5
SIR 0040 T22	S22	A22		AI22	T-20/5
SIL 0050 U22	S22	A22	AE22		T-20/5
SIR 0050 U22	S22	A22		AI22	T-20/5
SIL 0032 S22U	S22	A22	AE22U		T-20/5
SIR 0032 S22U	S22	A22		AI22U	T-20/5
SIR 0040 T22U	S22	A22		AI22U	T-20/5
SIL 0032 S27	TS40	A27	AE27		TK40
SIR 0032 S27	TS40	A27		AI27	TK40
SIL 0040 T27	TS40	A27	AE27		TK40
SIR 0040 T27	TS40	A27		AI27	TK40
SIL 0050 U27	TS40	A27	AE27		TK40
SIR 0050 U27	TS40	A27		AI27	TK40
SIL 0060 V27	TS40	A27	AE27		TK40
SIR 0060 V27	TS40	A27		AI27	TK40
SIL 0032 S27U	TS40	A27	AE27U		TK40
SIR 0032 S27U	TS40	A27		AI27U	TK40
SIR 0040 T27U	TS40	A27		AI27U	TK40
SIL 0050 U27U	TS40	A27	AE27U		TK40
SIR 0050 U27U	TS40	A27		AI27U	TK40
SIL 0060 V27U	TS40	A27	AE27U		TK40
SIR 0060 V27U	TS40	A27		AI27U	TK40

Insert Designation System

16	E	R	M	1.50	ISO	2M	TT9030
1	2	3	4	5	6	7	8

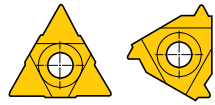
1 Insert size

l (mm)	d
06	3.968 mm = 5/32″
08	4.762 mm = 3/16″
11	6.350 mm = 1/4″
16	9.525 mm = 3/8″
22	12.700 mm = 1/2″
27	15.875 mm = 5/8″



2 Application

E - External
I - Internal
UE - U-type, external
UI - U-type, Internal
UEI - U-type, external and internal



U-type Regular type

3 Hand of tool

R - Right-hand
L - Left-hand
RL - Right and left-hand

4 Type

M - With a chip breaker
B - Peripherally ground & chip breaker
☐ - No indication regular type

5 Pitch

Full profile
Value by number
0.35 - 9.0 **mm**
72 - 2 **TPI**

Partial profile
Range by letter

	mm	TPI
A	0.5 - 1.5	48 - 16
AG	0.5 - 3.0	48 - 8
G	1.75 - 3.0	14 - 8
N	3.5 - 5.0	7 - 5
U	5.5 - 6.0	4.5 - 4
Q	5.5 - 9.0	4.5 - 2.75

6 Thread standard

60 - Partial profile 60°
55 - Partial profile 55°
ISO - ISO metric
UN - American UN
W - Whitworth
BSPT - British BSPT
RND - Round DIN 405
TR - Trapeze DIN 103
ACME - ACME
STACME - Stub ACME
ABUT - American buttress
UNJ - UNJ
MJ - MJ
NPT - NPT
API RD - API round
BUT - API buttress casing
API - API
EL - Extreme line casing
SAGE - Segengewinde DIN 513

7 No. of teeth (Optional)

2M - 2 teeth
3M - 3 teeth

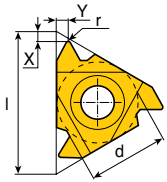
8 Grades

Coated
TT7010
TT8010
TT9030

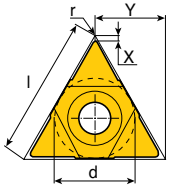
Uncoated
P30

Partial Profile 55°

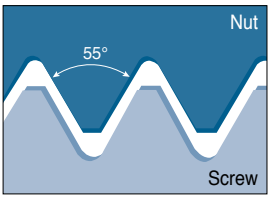
External & internal



External right hand shown
(Internal left hand)



U-type



• Application: General industry

Insert	Designation	Pitch		Dimension (mm)					Coated			Uncoated
		mm	TPI	d	l	r	X	Y	TT7010	TT9030	TT8010	P30
External	**11ER/L A 55**	0.5-1.5	48-16	1/4″	11	0.05	0.8	0.9	●	●		●
	16ER/L A 55	0.5-1.5	48-16	3/8″	16	0.05	0.8	0.9	●	●		●
	16ER/L AG 55	0.5-3.0	48-8	3/8″	16	0.05	1.2	1.7	●	●	●	●
	16ERB AG 55	0.5-3.0	48-8	3/8″	16	0.05	1.2	1.7		●		
Regular	**16ERM AG 55**	0.5-3.0	48-8	3/8″	16	0.07	1.2	1.7	●	●		●
	16ER/L G 55	1.75-3.0	14-8	3/8″	16	0.20	1.2	1.7	●	●		●
	16ERB G 55	1.75-3.0	14-8	3/8″	16	0.20	1.2	1.7		●		
B/M	**16ERM G 55**	1.75-3.0	14-8	3/8″	16	0.23	1.2	1.7	●	●		●
	22ER/L N 55	3.5-5.0	7-5	1/2″	22	0.42	1.7	2.5	●	●		●
	27ER Q 55	5.5-6.0	4.5-4	5/8″	27	0.60	2.0	2.9	●	●		
Internal	**06IR/L A 55**	0.5-1.25	48-20	5/32″	6	0.05	0.5	0.6			●	
	08IR/L A 55	0.5-1.5	48-16	3/16″	8	0.05	0.6	0.7			●	
	11IR/L A 55	0.5-1.5	48-16	1/4″	11	0.05	0.8	0.9	●	●	●	●
	16IR A 55	0.5-1.5	48-16	3/8″	16	0.05	0.8	0.9	●	●		●
Regular	**16IR/L AG 55**	0.5-3.0	48-8	3/8″	16	0.05	1.2	1.7	●	●	●	●
	16IRB AG 55	0.5-3.0	48-8	3/8″	16	0.05	1.2	1.7		●		
	16IRM AG 55	0.5-3.0	48-8	3/8″	16	0.05	1.2	1.7	●	●		●
B/M	**16IR/L G 55**	1.75-3.0	14-8	3/8″	16	0.20	1.2	1.7	●	●		●
	16IRB G 55	1.75-3.0	14-8	3/8″	16	0.20	1.2	1.7		●		
	16IRM G 55	1.75-3.0	14-8	3/8″	16	0.20	1.2	1.7	●	●		●
	22IR/L N 55	3.5-5.0	7-5	1/2″	22	0.42	1.7	2.5	●	●		●
	27IR/L Q 55	5.5-6.0	4.5-4	5/8″	27	0.60	2.0	2.9	●	●		●
U	**08UIRL U 55**	1.75-2.0	14-11	3/16″	8	0.10	0.9	4.0			●	
	22UEIRL U 55	5.5-8.0	4.5-3.25	1/2″	22	0.60	0.9	11.0	●			●
	27UEIRL U 55	6.5-9.0	4-2.75	5/8″	27	0.81	1.2	13.7	●			





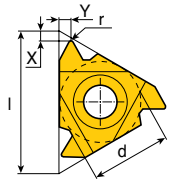
• ERB / ERM / IRB / IRM with pressed chip breaker

●: Standard item

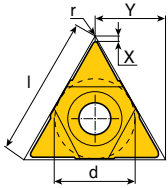
TaeguTec

Partial Profile 60°

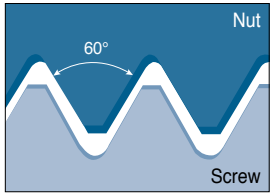
External & internal



External right hand shown
(Internal left hand)



U-type



• Application: General industry

Insert	Designation	Pitch		Dimension (mm)					Coated			Uncoated
		mm	TPI	d	l	r	X	Y	TT7010	TT9030	TT8010	P30
External Regular	**11ER/L A 60**	0.5-1.5	48-16	1/4″	11	0.05	0.8	0.9	●	●		●
	16ER/L A 60	0.5-1.5	48-16	3/8″	16	0.05	0.8	0.9	●	●	●	●
	16ERB A 60	0.5-1.5	48-16	3/8″	16	0.05	0.8	0.9		●		
	16ERM A 60	0.5-1.5	48-16	3/8″	16	0.05	0.8	0.9	●	●		●
	16ER/L AG 60	0.5-3.0	48-8	3/8″	16	0.05	1.2	1.7	●	●	●	●
B/M	**16ERB AG 60**	0.5-3.0	48-8	3/8″	16	0.05	1.2	1.7		●		
	16ERM AG 60	0.5-3.0	48-8	3/8″	16	0.06	1.2	1.7	●	●		●
	16ER/L G 60	1.75-3.0	14-8	3/8″	16	0.17	1.2	1.7	●	●	●	●
	16ERB G 60	1.75-3.0	14-8	3/8″	16	0.17	1.2	1.7		●		
	16ERM G 60	1.75-3.0	14-8	3/8″	16	0.17	1.2	1.7	●	●		●
	22ER/L N 60	3.5-5.0	7-5	1/2″	22	0.32	1.7	2.5	●	●	●	●
	22ERM N 60	3.5-5.0	7-5	1/2″	22	0.32	1.7	2.5	●	●		●
	27ER/L Q 60	5.5-6.0	4.5-4	5/8″	27	0.63	2.1	3.1	●		●	●
Internal Regular	**06IR/L A 60**	0.5-1.25	48-20	5/32″	6	0.05	0.6	0.6			●	
	06IRM A 60	0.5-1.25	48-20	5/32″	6	0.05	0.5	0.6			●	
	08IR/L A 60	0.5-1.5	48-16	3/16″	8	0.05	0.6	0.7			●	
	08IRM A 60	0.5-1.5	48-16	3/16″	8	0.05	0.6	0.7		●	●	
	11IR/L A 60	0.5-1.5	48-16	1/4″	11	0.05	0.8	0.9	●	●	●	●
	11IRM A 60	0.5-1.5	48-16	1/4″	11	0.05	0.7	0.9	●	●		●
	16IR/L A 60	0.5-1.5	48-16	3/8″	16	0.05	0.8	0.9	●	●	●	●
	16IRB A 60	0.5-1.5	48-16	3/8″	16	0.05	0.8	0.9		●		
	16IRM A 60	0.5-1.5	48-16	3/8″	16	0.05	0.8	0.9	●	●		●
B/M	**16IR/L AG 60**	0.5-3.0	48-8	3/8″	16	0.05	1.2	1.7	●	●	●	●
	16IRB AG 60	0.5-3.0	48-8	3/8″	16	0.05	1.2	1.7			●	
	16IRM AG 60	0.5-3.0	48-8	3/8″	16	0.05	1.2	1.7	●	●		●
	16IR/L G 60	1.75-3.0	14-8	3/8″	16	0.12	1.2	1.7	●	●	●	●
	16IRB G 60	1.75-3.0	14-8	3/8″	16	0.12	1.2	1.7		●		
	16IRM G 60	1.75-3.0	14-8	3/8″	16	0.10	1.2	1.7	●	●		●
	22IR/L N 60	3.5-5.0	7-5	1/2″	22	0.22	1.7	2.5	●	●	●	●
	22IRM N 60	3.5-5.0	7-5	1/2″	22	0.19	1.7	2.5	●	●		●
	27IR/L Q 60	5.5- 6.0	4.5-4	5/8″	27	0.31	2.1	3.1	●	●		●
U	**08UIRL U 60**	1.75-2.0	14-11	3/16″	8	0.10	0.8	4.0			●	
	22UEIRL U 60	5.5-8.0	4.5-3.25	1/2″	22	0.28	0.6	11.0	●			●
	27UEIRL U 60	6.5-9.0	4-2.75	5/8″	27	0.28	1.0	13.7	●			●





• ERB / ERM / IRB / IRM with pressed chip breaker

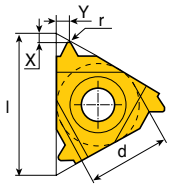
●: Standard item

TaeguTec

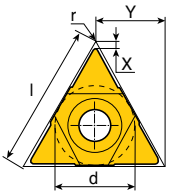
External ISO Metric

T-THREAD

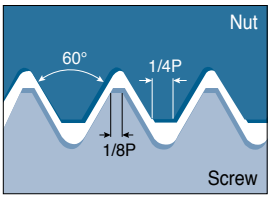
Full profile (DIN13 12-1986 class: 6G)



External right hand shown
(Internal left hand)



U-type



• Application: General industry

Insert	Designation	Pitch (mm)	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
External	**11ER/L 0.35 ISO**	0.35	1/4″	11	0.04	0.8	0.4		●		●
 Regular	**11ER 0.40 ISO**	0.40	1/4″	11	0.04	0.7	0.4		●		
	11ER 0.45 ISO	0.45	1/4″	11	0.05	0.7	0.4			●	
	11ER/L 0.50 ISO	0.50	1/4″	11	0.05	0.6	0.6	●	●	●	●
	11ER 0.60 ISO	0.60	1/4″	11	0.07	0.6	0.6		●		●
	11ER 0.70 ISO	0.70	1/4″	11	0.07	0.6	0.6	●	●		●
	11ER/L 0.75 ISO	0.75	1/4″	11	0.08	0.6	0.6	●	●		●
	11ER 0.80 ISO	0.80	1/4″	11	0.09	0.6	0.6	●	●		●
	11ER/L 1.00 ISO	1.00	1/4″	11	0.12	0.7	0.7	●	●		●
	11ER 1.25 ISO	1.25	1/4″	11	0.15	0.8	0.9	●	●		●
	11ER/L 1.50 ISO	1.50	1/4″	11	0.18	0.8	1.0	●	●		●
	11ER 1.75 ISO	1.75	1/4″	11	0.21	0.8	1.1	●			
	16ER/L 0.35 ISO	0.35	3/8″	16	0.04	0.8	0.4	●	●		
	16ER/L 0.40 ISO	0.40	3/8″	16	0.04	0.7	0.4		●		●
	16ER 0.45 ISO	0.45	3/8″	16	0.05	0.7	0.4	●	●		
	16ER/L 0.50 ISO	0.50	3/8″	16	0.04	0.6	0.6	●	●		●
	16ER 0.60 ISO	0.60	3/8″	16	0.07	0.6	0.6	●	●		●
	16ER/L 0.70 ISO	0.70	3/8″	16	0.07	0.6	0.6	●	●		●
	16ER/L 0.75 ISO	0.75	3/8″	16	0.08	0.6	0.6	●	●		●
	16ERM 0.75 ISO	0.75	3/8″	16	0.08	0.6	0.6		●		
	16ER/L 0.80 ISO	0.80	3/8″	16	0.09	0.6	0.6	●	●		●
	16ERB 0.80 ISO	0.80	3/8″	16	0.09	0.6	0.6		●		
	16ER/L 1.00 ISO	1.00	3/8″	16	0.12	0.7	0.7	●	●	●	●
	16ERB 1.00 ISO	1.00	3/8″	16	0.12	0.7	0.7		●		
	16ERM 1.00 ISO	1.00	3/8″	16	0.11	0.7	0.7	●	●		●
	16ER/L 1.25 ISO	1.25	3/8″	16	0.15	0.8	0.9	●	●		●
	16ERB 1.25 ISO	1.25	3/8″	16	0.15	0.8	0.9		●		
	16ERM 1.25 ISO	1.25	3/8″	16	0.14	0.8	0.9	●	●		●
	16ER/L 1.50 ISO	1.50	3/8″	16	0.18	0.8	1.0	●	●	●	●
	16ERB 1.50 ISO	1.50	3/8″	16	0.18	0.8	1.0		●		
	16ERM 1.50 ISO	1.50	3/8″	16	0.19	0.8	1.0	●	●		●
	16ER/L 1.75 ISO	1.75	3/8″	16	0.21	0.9	1.2	●	●	●	●
	16ERB 1.75 ISO	1.75	3/8″	16	0.21	0.9	1.2		●		
	16ERM 1.75 ISO	1.75	3/8″	16	0.20	0.9	1.2	●	●		●



• ERB / ERM with pressed chip breaker

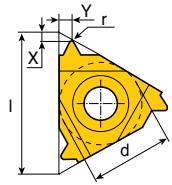
●: Standard item

TaeguTec Member IMC Group

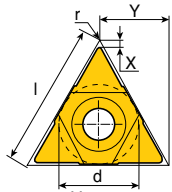
External ISO Metric

T-THREAD

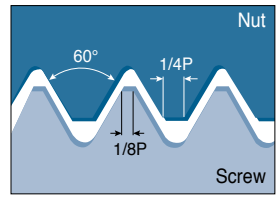
Full profile (DIN13 12-1986 class: 6G)



External right hand shown
(Internal left hand)



U-type



- Application: General industry

Insert	Designation	Pitch (mm)	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
External	**16ER/L 2.00 ISO**	2.00	3/8″	16	0.25	1.0	1.3	●	●	●	●
 Regular	**16ERB 2.00 ISO**	2.00	3/8″	16	0.25	1.0	1.3		●		
	16ERM 2.00 ISO	2.00	3/8″	16	0.24	1.0	1.3	●	●		●
	16ER/L 2.50 ISO	2.50	3/8″	16	0.31	1.1	1.5	●	●		●
	16ERB 2.50 ISO	2.50	3/8″	16	0.31	1.1	1.5		●		
 B/M	**16ERM 2.50 ISO**	2.50	3/8″	16	0.30	1.1	1.5	●	●		●
	16ER/L 3.00 ISO	3.00	3/8″	16	0.38	1.2	1.6	●	●	●	●
	16ERB 3.00 ISO	3.00	3/8″	16	0.38	1.2	1.6		●		
	16ERM 3.00 ISO	3.00	3/8″	16	0.38	1.2	1.6	●	●		●
	22ER/L 3.50 ISO	3.50	1/2″	22	0.44	1.6	2.3	●	●	●	●
	22ERM 3.50 ISO	3.50	1/2″	22	0.44	1.6	2.3		●		
	22ER/L 4.00 ISO	4.00	1/2″	22	0.52	1.6	2.3	●	●		●
	22ERM 4.00 ISO	4.00	1/2″	22	0.52	1.6	2.3		●		
	22ER/L 4.50 ISO	4.50	1/2″	22	0.58	1.7	2.4	●	●		●
	22ER/L 5.00 ISO	5.00	1/2″	22	0.64	1.7	2.5	●	●		●
	22ER/L 6.00 ISO	6.00	1/2″	22	0.78	2.0	2.7	●			
	27ER/L 5.50 ISO	5.50	5/8″	27	0.70	1.9	2.7	●	●		
	27ER/L 6.00 ISO	6.00	5/8″	27	0.78	2.0	2.9	●	●	●	●
 U	**22UERL 5.50 ISO**	5.50	1/2″	22	0.70	2.3	11.0	●		●	
	22UERL 6.00 ISO	6.00	1/2″	22	0.78	2.6	11.0	●	●	●	
	27UERL 8.00 ISO	8.00	5/8″	27	1.08	2.4	13.7	●	●		



- ERB / ERM with pressed chip breaker

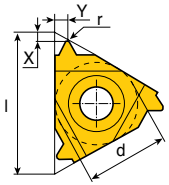
●: Standard item

TaeguTec
Member IMC Group

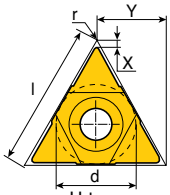
Internal ISO Metric

T-THREAD

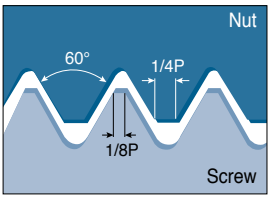
Full profile (DIN13 12-1986 class: 6H)



External right hand shown
(Internal left hand)



U-type



• Application: General industry

Insert	Designation	Pitch (mm)	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
Internal	**06IR/L 0.50 ISO**	0.50	5/32″	6	0.03	0.9	0.5			●	
 Regular	**06IR/L 0.75 ISO**	0.75	5/32″	6	0.04	0.8	0.5			●	
	06IR/L 1.00 ISO	1.00	5/32″	6	0.05	0.7	0.6			●	
	06IR/L 1.25 ISO	1.25	5/32″	6	0.07	0.6	0.6			●	
	08IR/L 0.50 ISO	0.50	3/16″	8	0.05	0.6	0.5			●	
 B/M	**08IR 0.75 ISO**	0.75	3/16″	8	0.04	0.6	0.5			●	
	08IR/L 1.00 ISO	1.00	3/16″	8	0.05	0.6	0.6		●	●	
	08IR/L 1.25 ISO	1.25	3/16″	8	0.07	0.6	0.7			●	
	08IR/L 1.50 ISO	1.50	3/16″	8	0.08	0.6	0.7			●	
	08IR/L 1.75 ISO	1.75	3/16″	8	0.10	0.6	0.8			●	
	11IR/L 0.35 ISO	0.35	1/4″	11	0.02	0.8	0.3		●		
	11IR 0.40 ISO	0.40	1/4″	11	0.02	0.8	0.4		●		
	11IR/L 0.50 ISO	0.50	1/4″	11	0.03	0.6	0.6	●	●		●
	11IR 0.70 ISO	0.70	1/4″	11	0.04	0.6	0.6		●		
	11IR/L 0.75 ISO	0.75	1/4″	11	0.08	0.6	0.6	●	●		●
	11IR 0.80 ISO	0.80	1/4″	11	0.04	0.6	0.6	●		●	
	11IR/L 1.00 ISO	1.00	1/4″	11	0.05	0.6	0.7	●	●	●	●
	11IRM 1.00 ISO	1.00	1/4″	11	0.05	0.6	0.7		●		
	11IR/L 1.25 ISO	1.25	1/4″	11	0.07	0.8	0.8	●	●		●
	11IR/L 1.50 ISO	1.50	1/4″	11	0.08	0.8	1.0	●	●	●	●
	11IRM 1.50 ISO	1.50	1/4″	11	0.08	0.8	1.0	●	●		
	11IR/L 1.75 ISO	1.75	1/4″	11	0.10	0.8	1.1	●	●		●
	11IR/L 2.00 ISO	2.00	1/4″	11	0.12	0.8	0.9	●	●	●	
	16IR 0.35 ISO	0.35	3/8″	16	0.02	0.8	0.3		●		
	16IR/L 0.40 ISO	0.40	3/8″	16	0.02	0.8	0.4		●		
	16IL 0.45 ISO	0.45	3/8″	16	0.02	0.8	0.4		●		
	16IR/L 0.50 ISO	0.50	3/8″	16	0.03	0.6	0.6	●	●		●
	16IR/L 0.60 ISO	0.60	3/8″	16	0.03	0.6	0.6		●		●
	16IR/L 0.70 ISO	0.70	3/8″	16	0.04	0.6	0.6	●	●		●
	16IR/L 0.75 ISO	0.75	3/8″	16	0.04	0.6	0.6	●	●	●	●
	16IR/L 0.80 ISO	0.80	3/8″	16	0.04	0.6	0.6	●			●
	16IR/L 1.00 ISO	1.00	3/8″	16	0.05	0.6	0.7	●	●		●
	16IRB 1.00 ISO	1.00	3/8″	16	0.05	0.6	0.7		●		
	16IRM 1.00 ISO	1.00	3/8″	16	0.05	0.6	0.7	●	●		●



• IRB / IRM with pressed chip breaker

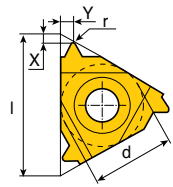
●: Standard item

TaeguTec Member IMC Group

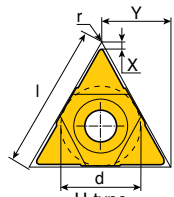
Internal ISO Metric

T-THREAD

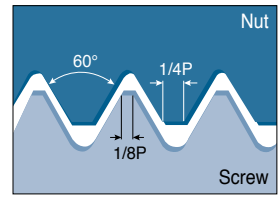
Full profile (DIN13 12-1986 class: 6H)



External right hand shown
(Internal left hand)



U-type



• Application: General industry

Insert	Designation	Pitch (mm)	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
Internal Regular	**16IR/L 1.25 ISO**	1.25	3/8″	16	0.07	0.8	0.9	●	●	●	●
	16IRB 1.25 ISO	1.25	3/8″	16	0.07	0.8	0.9		●		
	16IRM 1.25 ISO	1.25	3/8″	16	0.06	0.8	0.9	●	●		●
	16IR/L 1.50 ISO	1.50	3/8″	16	0.08	0.8	1.0	●	●	●	●
	16IRB 1.50 ISO	1.50	3/8″	16	0.08	0.8	1.0		●		
	16IRM 1.50 ISO	1.50	3/8″	16	0.08	0.8	1.0	●	●		●
	16IR/L 1.75 ISO	1.75	3/8″	16	0.10	0.9	1.2	●	●		●
	16IRB 1.75 ISO	1.75	3/8″	16	0.10	0.9	1.2		●		
	16IRM 1.75 ISO	1.75	3/8″	16	0.10	0.9	1.2	●	●		●
	16IR/L 2.00 ISO	2.00	3/8″	16	0.12	1.0	1.3	●	●	●	●
	16IRB 2.00 ISO	2.00	3/8″	16	0.12	1.0	1.3		●		
	16IRM 2.00 ISO	2.00	3/8″	16	0.11	1.0	1.3	●	●		●
	16IR/L 2.50 ISO	2.50	3/8″	16	0.15	1.1	1.5	●	●	●	●
	16IRB 2.50 ISO	2.50	3/8″	16	0.15	1.1	1.5		●		
	16IRM 2.50 ISO	2.50	3/8″	16	0.14	1.1	1.5	●	●		●
	16IR/L 3.00 ISO	3.00	3/8″	16	0.18	1.1	1.5	●	●	●	●
	16IRB 3.00 ISO	3.00	3/8″	16	0.18	1.1	1.5		●		
	16IRM 3.00 ISO	3.00	3/8″	16	0.17	1.1	1.5	●	●		●
	22IL 3.00 ISO	3.00	1/2″	22	0.17	1.1	1.5			●	
	22IR/L 3.50 ISO	3.50	1/2″	22	0.22	1.6	2.3	●	●		●
	22IR/L 4.00 ISO	4.00	1/2″	22	0.25	1.6	2.3	●	●		●
	22IR/L 4.50 ISO	4.50	1/2″	22	0.29	1.6	2.4	●	●		●
	22IR/L 5.00 ISO	5.00	1/2″	22	0.32	1.6	2.3	●	●		●
	27IR/L 5.50 ISO	5.50	5/8″	27	0.35	1.6	2.3	●	●	●	
	27IR/L 6.00 ISO	6.00	5/8″	27	0.39	1.8	2.5	●	●		●
U	**08UIRL 2.00 ISO**	2.00	3/16″	8	0.12	0.9	4.0			●	
	22UIRL 5.50 ISO	5.50	1/2″	22	0.35	2.4	11.0	●			●
	22UIRL 6.00 ISO	6.00	1/2″	22	0.39	2.1	11.0	●			●
	27UIRL 8.00 ISO	8.00	5/8″	27	0.53	2.4	13.7		●		



• IRB / IRM with pressed chip breaker

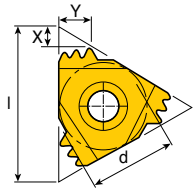
●: Standard item

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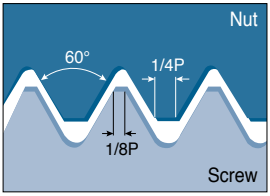
External & Internal ISO Metric

T-THREAD

Full profile, multi-tooth



External right hand shown
(Internal left hand)



- Application: General industry

Insert	Designation	Pitch (mm)	Dimension (mm)				No. of Teeth	Coated			Uncoated	
			d	l	X	Y		TT7010	TT9030	TT8010	P30	
Internal / External 	**16ER 0.75 ISO 3M**	0.75	3/8″	16	1.3	1.9	3		●			
	16ER/IR 1.00 ISO 3M	1.0	3/8″	16	1.7	2.5	3		●			
	16ER/IR 1.50 ISO 2M	1.5	3/8″	16	1.5	2.3	2	●	●			
	16ER/IR 2.00 ISO 2M	2.00	3/8″	16	2.0	3.0	2		●			
	22ER/IR 1.50 ISO 3M	1.5	1/2″	22	2.3	3.7	3	●	●			
	22ER/IR 2.00 ISO 2M	2.0	1/2″	22	2.0	3.0	2		●			
	22ER/IR 2.00 ISO 3M	2.0	1/2″	22	3.1	5.0	3	●	●			
	27ER/IR 3.00 ISO 2M	3.0	5/8″	27	2.9	4.6	2		●			

●: Standard item

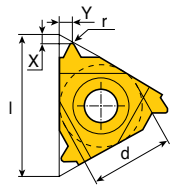




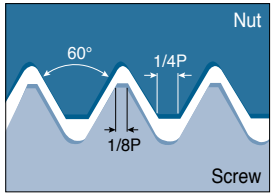
External American UN

T-THREAD

Full profile, UN, UNC, UNF, UNEF



External right hand shown
(Internal left hand)



• Application: General industry

Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
External	**11ER 44 UN**	44	1/4″	11	0.05	0.6	0.6		●		
	**11ER 36 UN**	36	1/4″	11	0.07	0.6	0.6		●		
	11ER 32 UN	32	1/4″	11	0.09	0.6	0.6		●		
Regular	**11ER/L 28 UN**	28	1/4″	11	0.10	0.6	0.7		●		●
	11ER/L 24 UN	24	1/4″	11	0.12	0.7	0.8		●		
	**11ER/L 20 UN**	20	1/4″	11	0.15	0.8	0.9	●	●		
	11ER 18 UN	18	1/4″	11	0.17	0.8	1.0		●		
B/M	**11ER 16 UN**	16	1/4″	11	0.18	0.9	1.1	●	●		●
	16ER 72 UN	72	3/8″	16	-	0.8	0.4		●		
	16ER 56 UN	56	3/8″	16	0.04	0.7	0.4		●		
	16ER 48 UN	48	3/8″	16	0.05	0.6	0.6		●	●	
	16ER/L 40 UN	40	3/8″	16	0.06	0.6	0.6		●	●	
	16ER/L 36 UN	36	3/8″	16	0.07	0.6	0.6		●		●
	16ER/L 32 UN	32	3/8″	16	0.09	0.6	0.6	●	●		●
	16ER/L 28 UN	28	3/8″	16	0.10	0.6	0.7	●	●		●
	16ER/L 24 UN	24	3/8″	16	0.12	0.7	0.8	●	●	●	●
	16ERB 24 UN	24	3/8″	16	0.12	0.7	0.8		●		
	16ERM 24 UN	24	3/8″	16	0.11	0.7	0.8	●	●		●
	16ER/L 20 UN	20	3/8″	16	0.15	0.8	0.9	●	●		●
	16ERB 20 UN	20	3/8″	16	0.15	0.8	0.9		●		
	16ERM 20 UN	20	3/8″	16	0.14	0.8	0.9	●	●		●
	16ER/L 18 UN	18	3/8″	16	0.17	0.8	1.0	●	●		●
	16ERB 18 UN	18	3/8″	16	0.17	0.8	1.0		●		
	16ERM 18 UN	18	3/8″	16	0.15	0.8	1.0	●	●	●	●
	16ER/L 16 UN	16	3/8″	16	0.18	0.9	1.1	●	●	●	●
	16ERB 16 UN	16	3/8″	16	0.18	0.9	1.1		●		
	16ERM 16 UN	16	3/8″	16	0.19	0.9	1.1	●	●		●
	16ER/L 14 UN	14	3/8″	16	0.22	1.0	1.2	●	●		●
	16ERB 14 UN	14	3/8″	16	0.22	1.0	1.2		●		
	16ERM 14 UN	14	3/8″	16	0.22	1.0	1.2	●	●		●
	16ER/L 13 UN	13	3/8″	16	0.24	1.0	1.3	●	●		●
	16ERB 13 UN	13	3/8″	16	0.24	1.0	1.3		●		
	16ERM 13 UN	13	3/8″	16	0.24	1.0	1.3		●		



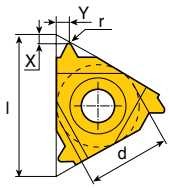
• ERB / ERM with pressed chip breaker
• Tolerance: Class 2A

●: Standard item

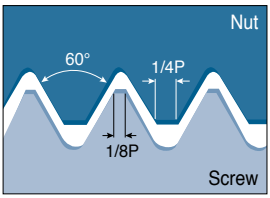
TaeguTec
Member IMC Group

External American UN

Full profile, UN, UNC, UNF, UNEF



External right hand shown
(Internal left hand)



• Application: General industry

Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
External	**16ER/L 12 UN**	12	3/8″	16	0.26	1.1	1.4	●	●		●
 Regular	**16ERB 12 UN**	12	3/8″	16	0.26	1.1	1.4		●		
	16ERM 12 UN	12	3/8″	16	0.25	1.1	1.4	●	●		●
	16ER 11.5 UN	11.5	3/8″	16	0.27	1.1	1.5	●	●		●
	16ER/L 11 UN	11	3/8″	16	0.28	1.1	1.5	●	●		●
 B/M	**16ERB 11 UN**	11	3/8″	16	0.28	1.1	1.5		●		
	16ER/L 10 UN	10	3/8″	16	0.32	1.1	1.5	●	●		●
	16ERB 10 UN	10	3/8″	16	0.32	1.1	1.5		●		
	16ER/L 9 UN	9	3/8″	16	0.36	1.2	1.7		●		●
	16ERB 9 UN	9	3/8″	16	0.36	1.2	1.7		●		
	16ER/L 8 UN	8	3/8″	16	0.41	1.2	1.6	●	●		●
	16ERB 8 UN	8	3/8″	16	0.41	1.2	1.6		●		
	16ERM 8 UN	8	3/8″	16	0.41	1.2	1.6	●	●		●
	22ER 7 UN	7	1/2″	22	0.47	1.6	2.3	●			●
	22ER/L 6 UN	6	1/2″	22	0.67	1.6	2.3	●	●		●
	22ER 5 UN	5	1/2″	22	0.67	1.7	2.5	●	●		●
	27ER 4.5 UN	4.5	5/8″	27	0.75	1.9	2.7		●		●
	27ER/L 4 UN	4	5/8″	27	0.85	2.1	3.0	●			●





• ERB / ERM with pressed chip breaker
• Tolerance: Class 2A

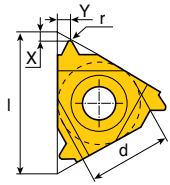
●: Standard item

TaeguTec Member IMC Group

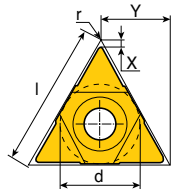
Internal American UN

T-THREAD

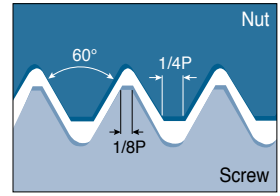
Full profile, UN, UNC, UNF, UNEF



External right hand shown
(Internal left hand)



U-type



• Application: General industry

Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
Internal  Regular  B/M	**06IR 32 UN**	32	5/32″	6	0.04	0.8	0.5			●	
	06IL 28 UN	28	5/32″	6	0.04	0.8	0.6			●	
	06IR/L 24 UN	24	5/32″	6	0.05	0.7	0.6			●	
	06IR/L 20 UN	20	5/32″	6	0.06	0.6	0.6			●	
	06IR/L 18 UN	18	5/32″	6	0.07	0.6	0.7			●	
	08IR 32 UN	32	3/16″	8	0.04	0.6	0.5			●	
	08IR/L 28 UN	28	3/16″	8	0.04	0.6	0.6			●	
	08IR/L 24 UN	24	3/16″	8	0.05	0.6	0.6			●	
	08IR/L 20 UN	20	3/16″	8	0.06	0.6	0.7			●	
	08IR 18 UN	18	3/16″	8	0.07	0.6	0.7			●	
	08IR/L 16 UN	16	3/16″	8	0.09	0.6	0.7			●	
	08IR 14 UN	14	3/16″	8	0.10	0.6	0.8		●	●	
	11IR 64 UN	64	1/4″	11	0.02	0.8	0.4		●		
	11IR 36 UN	36	1/4″	11	0.04	0.6	0.6		●		
	11IR/L 32 UN	32	1/4″	11	0.04	0.6	0.6		●		●
	11IR/L 28 UN	28	1/4″	11	0.04	0.6	0.7		●		
	11IR/L 24 UN	24	1/4″	11	0.05	0.7	0.8	●	●		●
	11IR/L 20 UN	20	1/4″	11	0.06	0.8	0.9		●		●
	11IR/L 18 UN	18	1/4″	11	0.07	0.8	1.0	●	●		●
	11IR/L 16 UN	16	1/4″	11	0.09	0.9	1.1	●	●	●	●
	11IR/L 14 UN	14	1/4″	11	0.10	0.9	1.1	●	●		●
	11IR 12 UN	12	1/4″	11	0.12	0.9	1.1	●			
	11IR 11 UN	11	1/4″	11	0.14	0.8	1.1	●			
	16IR 44 UN	44	3/8″	16	0.03	0.6	0.6		●		
	16IR 32 UN	32	3/8″	16	0.04	0.6	0.6	●	●		●
	16IR 27 UN	27	3/8″	16	0.04	0.7	0.8				●
	16IR/L 28 UN	28	3/8″	16	0.04	0.6	0.7		●		●
	16IR 24 UN	24	3/8″	16	0.05	0.7	0.8	●	●		●
	16IRB 24 UN	24	3/8″	16	0.05	0.7	0.8		●		
	16IR/L 20 UN	20	3/8″	16	0.06	0.8	0.9	●	●		●
	16IRB 20 UN	20	3/8″	16	0.06	0.8	0.9		●		
	16IRM 20 UN	20	3/8″	16	0.06	0.8	0.9	●	●		●
	16IR/L 18 UN	18	3/8″	16	0.07	0.8	1.0	●	●		●
	16IRB 18 UN	18	3/8″	16	0.07	0.8	1.0		●		
	16IRM 18 UN	18	3/8″	16	0.08	0.8	1.0	●	●		●



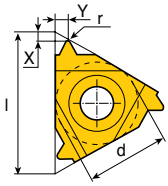
• IRB / IRM with pressed chip breaker
• Tolerance: Class 2B, ANSI B1, 3M-1986

●: Standard item

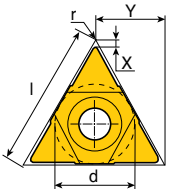
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Internal American UN

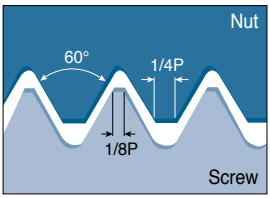
Full profile, UN, UNC, UNF, UNEF



External right hand shown
(Internal left hand)



U-type



- Application: General industry

Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
Internal Regular	**16IR/L 16 UN**	16	3/8″	16	0.09	0.9	1.1	●	●		●
	16IRB 16 UN	16	3/8″	16	0.09	0.9	1.1		●		
	16IRM 16 UN	16	3/8″	16	0.09	0.9	1.1	●	●		●
	16IR/L 14 UN	14	3/8″	16	0.10	0.9	1.2	●	●		●
	16IRB 14 UN	14	3/8″	16	0.10	0.9	1.2		●		
	16IRM 14 UN	14	3/8″	16	0.11	0.9	1.2	●	●		●
	16IR/L 13 UN	13	3/8″	16	0.11	1.0	1.3		●		●
	16IR/L 12 UN	12	3/8″	16	0.12	1.1	1.4	●	●	●	●
	16IRM 12 UN	12	3/8″	16	0.12	1.1	1.4	●	●		●
	16IR 11.5 UN	11.5	3/8″	16	0.13	1.1	1.5		●		●
	16IR 11 UN	11	3/8″	16	0.14	1.1	1.5	●	●		●
	16IR/L 10 UN	10	3/8″	16	0.15	1.1	1.5	●	●		●
	16IRB 10 UN	10	3/8″	16	0.15	1.1	1.5		●		
	16IR 9 UN	9	3/8″	16	0.17	1.2	1.7		●		
	16IR/L 8 UN	8	3/8″	16	0.19	1.1	1.5	●	●		●
	16IRB 8 UN	8	3/8″	16	0.19	1.1	1.5		●		
	16IRM 8 UN	8	3/8″	16	0.20	1.1	1.5	●	●		●
	22IR/L 7 UN	7	1/2″	22	0.22	1.6	2.3	●	●	●	
	22IR/L 6 UN	6	1/2″	22	0.26	1.6	2.3	●	●		●
	22IR 5 UN	5	1/2″	22	0.32	1.6	2.3	●			●
	27IR 4.5 UN	4.5	5/8″	27	0.36	1.7	2.4	●			
	27IR/L 4 UN	4	5/8″	27	0.41	1.8	2.7	●	●		●
Internal U	**08UIRL 13 UN**	13	3/16″	8	0.10	1.0	4.0		●		
	08UIRL 12 UN	12	3/16″	8	0.10	0.9	4.0	●			
	08UIRL 11 UN	11	3/16″	8	0.10	0.9	4.0	●			
	22UIRL 4.5 UN	4.5	1/2″	22	0.36	2.4	11.0	●			
	22UIRL 4 UN	4	1/2″	22	0.41	2.4	11.0		●		

C11-C14

Cutting Condition C54-C60

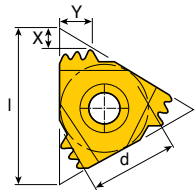
- IRB / IRM with pressed chip breaker
- Tolerance: Class 2B, ANSI B1, 3M-1986

●: Standard item

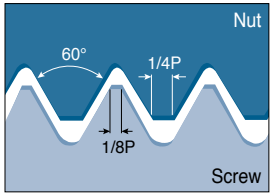
TaeguTec Member IMC Group

External & Internal American UN

Full profile, multi-tooth, UN, UNC, UNF, UNEF



External right hand shown
(Internal left hand)



- Application: General industry

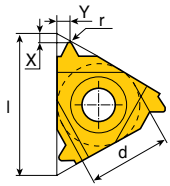
Insert	Designation	TPI	Dimension (mm)				No. of Teeth	Coated			Uncoated
			d	l	X	Y		TT7010	TT9030	TT8010	P30
Internal / External 	**16ER/IR 16 UN 2M**	16	3/8″	16	1.5	2.3	2		●		
	16ER 12 UN 2M	12	3/8″	16	2.2	3.4	2		●		
	22ER/IR 16 UN 3M	16	3/8″	22	2.5	4.0	3		●		
	22ER/IR 12 UN 2M	12	1/2″	22	2.2	3.4	2		●		
	22ER/IR 12 UN 3M	12	1/2″	22	3.3	5.3	3		●		●
	27ER/IR 8 UN 2M	8	5/8″	27	3.1	4.9	2		●		

●: Standard item

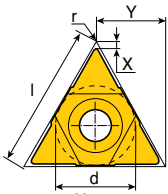
Cutting Condition
C11-C14
C54-C60

External Whitworth

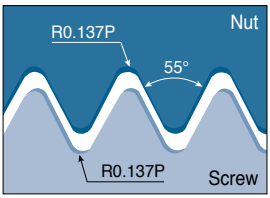
Full profile, BSW, BSF, BSP (B.S. 84-1956 DIN 259)



External right hand shown
(Internal left hand)



U-type



- Application: General industry, fittings and pipe coupings

Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
External	**11ER 36 W**	36	1/4″	11	0.07	0.6	0.6		●		
	11ER 20 W	20	1/4″	11	0.14	0.8	0.9				●
	11ER/L 19 W	19	1/4″	11	0.15	0.8	1.0		●		
	11ER 18 W	18	1/4″	11	0.16	0.8	1.0	●			
Regular	**11ER 16 W**	16	1/4″	11	0.18	0.9	1.1				●
	11ER 14 W	14	1/4″	11	0.21	0.9	1.1	●			●
	16ER/L 32 W	32	3/8″	16	0.09	0.6	0.6		●		●
B/M	**16ER/L 28 W**	28	3/8″	16	0.09	0.6	0.7	●	●		●
	16ER 26 W	26	3/8″	16	0.10	0.7	0.7	●	●		●
	16ER/L 24 W	24	3/8″	16	0.11	0.7	0.8	●	●		●
	16ER/L 22 W	22	3/8″	16	0.13	0.8	0.9	●	●		●
	16ER 20 W	20	3/8″	16	0.14	0.8	0.9	●	●	●	●
	16ER/L 19 W	19	3/8″	16	0.15	0.8	1.0	●	●	●	●
	16ERB 19 W	19	3/8″	16	0.15	0.8	1.0		●		
	16ERM 19 W	19	3/8″	16	0.16	0.8	1.0	●	●		●
	16ER/L 18 W	18	3/8″	16	0.16	0.8	1.0	●	●		●
	16ER/L 16 W	16	3/8″	16	0.18	0.9	1.1	●	●		●
	16ERB 16 W	16	3/8″	16	0.18	0.9	1.1		●		
	16ERM 16 W	16	3/8″	16	0.20	0.9	1.1	●	●		●
	16ER/L 14 W	14	3/8″	16	0.21	1.0	1.2	●	●	●	●
	16ERB 14 W	14	3/8″	16	0.21	1.0	1.2		●		
	16ERM 14 W	14	3/8″	16	0.24	1.0	1.2	●	●		●
	16ER/L 12 W	12	3/8″	16	0.25	1.1	1.4	●	●		●
	16ER/L 11 W	11	3/8″	16	0.27	1.1	1.5	●	●	●	●
	16ERB 11 W	11	3/8″	16	0.27	1.1	1.5		●		
	16ERM 11 W	11	3/8″	16	0.27	1.1	1.5	●	●		●
	16ER/L 10 W	10	3/8″	16	0.31	1.1	1.5	●	●		●
	16ERB 10 W	10	3/8″	16	0.31	1.1	1.5		●		
	16ER 9 W	9	3/8″	16	0.34	1.2	1.7	●			●
	16ER/L 8 W	8	3/8″	16	0.39	1.2	1.5	●	●		●
	22ER 7 W	7	1/2″	22	0.45	1.6	2.3		●		●
	22ER 6 W	6	1/2″	22	0.52	1.6	2.3	●	●		●
	22ER 5 W	5	1/2″	22	0.65	1.7	2.4	●			●
	27ER 4.5 W	4.5	5/8″	27	0.73	1.8	2.6				●
	27ER 4 W	4	5/8″	27	0.82	2.0	2.9		●		●





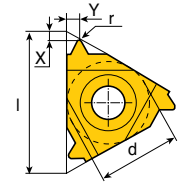
- ERB / ERM with pressed chip breaker
- Tolerance: Medium class

●: Standard item

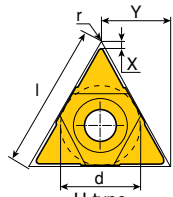
Internal Whitworth

T-THREAD

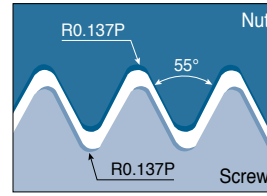
Full profile, BSW, BSF, BSP (B.S. 84-1956 DIN 259)



External right hand shown
(Internal left hand)



U-type



• Application: General industry, fittings and pipe coupings

Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
Internal  Regular  B/M	**06IR 26 W**	26	5/32″	6	0.10	0.7	0.6			●	
	06IR 20 W	20	5/32″	6	0.14	0.6	0.7			●	
	08IR 28 W	28	3/16″	8	0.09	0.6	0.6			●	
	08IR 24 W	24	3/16″	8	0.11	0.6	0.6			●	
	08IR 20 W	20	3/16″	8	0.14	0.6	0.7			●	
	08IR/L 19 W	19	3/16″	8	0.15	0.6	0.7			●	
	08IR 18 W	18	3/16″	8	0.16	0.6	0.7			●	
	08IR 16 W	16	3/16″	8	0.18	0.6	0.7			●	
	11IR 36 W	36	1/4″	11	0.07	0.6	0.6				
	11IR 28 W	28	1/4″	11	0.10	0.6	0.7	●			
	11IR 26 W	26	1/4″	11	0.10	0.7	0.7			●	●
	11IR/L 24 W	24	1/4″	11	0.11	0.7	0.8	●	●		
	11IR 20 W	20	1/4″	11	0.14	0.8	0.9	●	●		●
	11IR 19 W	19	1/4″	11	0.15	0.8	1.0	●	●		●
	11IR/L 18 W	18	1/4″	11	0.16	0.8	1.0	●	●		●
	11IR 16 W	16	1/4″	11	0.18	0.9	1.1	●			●
	11IR/L 14 W	14	1/4″	11	0.21	0.9	1.1	●	●	●	●
	11IL 12 W	12	1/4″	11	0.27	1.0	1.1		●		



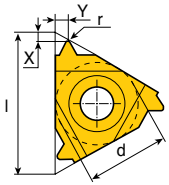
• Tolerance: Medium class

●: Standard item

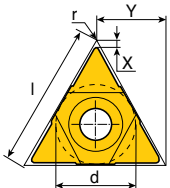
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Internal Whitworth

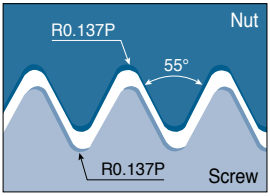
Full profile, BSW, BSF, BSP (B.S. 84-1956 DIN 259)



External right hand shown
(Internal left hand)



U-type



- Application: General industry, fittings and pipe coupings

Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
Internal Regular B/M	**16IR 40 W**	40	3/8″	16	0.06	0.6	0.6				●
	16IR/L 32 W	32	3/8″	16	0.09	0.6	0.6				●
	16IR/L 28 W	28	3/8″	16	0.09	0.6	0.7	●			●
	16IR 26 W	26	3/8″	16	0.10	0.7	0.7	●	●		●
	16IR/L 24 W	24	3/8″	16	0.11	0.7	0.8	●	●		●
	16IR/L 22 W	22	3/8″	16	0.13	0.8	0.9	●	●		●
	16IR/L 20 W	20	3/8″	16	0.14	0.8	0.9	●	●		●
	16IRM 20 W	20	3/8″	16	0.14	0.8	0.9		●		
	16IR/L 19 W	19	3/8″	16	0.15	0.8	1.0	●	●		●
	16IRB 19 W	19	3/8″	16	0.15	0.8	1.0		●		
	16IRM 19 W	19	3/8″	16	0.15	0.8	1.0	●			●
	16IR/L 18 W	18	3/8″	16	0.16	0.8	1.0	●	●		●
	16IR/L 16 W	16	3/8″	16	0.18	0.9	1.1				●
	16IRB 16 W	16	3/8″	16	0.18	0.9	1.1		●		
	16IRM 16 W	16	3/8″	16	0.18	0.9	1.1	●	●		
	16IR/L 14 W	14	3/8″	16	0.21	1.0	1.2	●	●	●	●
	16IRB 14 W	14	3/8″	16	0.21	1.0	1.2		●		
	16IRM 14 W	14	3/8″	16	0.21	1.0	1.2	●	●		●
	16IR/L 12 W	12	3/8″	16	0.25	1.1	1.4	●	●		●
	16IR/L 11 W	11	3/8″	16	0.27	1.1	1.5	●	●	●	●
	16IRB 11 W	11	3/8″	16	0.27	1.1	1.5		●		
	16IRM 11 W	11	3/8″	16	0.27	1.1	1.5	●	●		●
	16IR/L 10 W	10	3/8″	16	0.31	1.1	1.5	●	●		●
	16IRB 10 W	10	3/8″	16	0.31	1.1	1.5		●		
	16IR/L 9 W	9	3/8″	16	0.34	1.2	1.7	●			●
	16IR/L 8 W	8	3/8″	16	0.39	1.2	1.5	●	●		●
	22IR 7 W	7	1/2″	22	0.45	1.6	2.3		●		●
	22IR 6 W	6	1/2″	22	0.52	1.6	2.3	●			●
	22IR/L 5 W	5	1/2″	22	0.65	1.7	2.4	●			●
	27IR 4.5 W	4.5	5/8″	27	0.73	1.8	2.6	●			
	27IR 4 W	4	5/8″	27	0.82	2.0	2.9		●		

C11-C14

Cutting Condition C54-C60

- IRB / IRM with pressed chip breaker
- Tolerance: Medium class

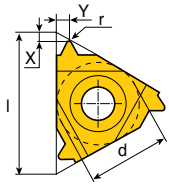
●: Standard item

TaeguTec Member IMC Group

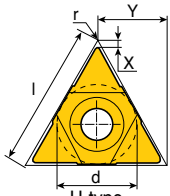
Internal Whitworth

T-THREAD

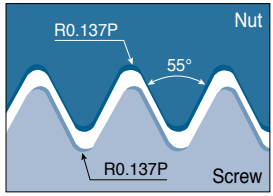
Full profile, BSW, BSF, BSP (B.S. 84-1956 DIN 259)



External right hand shown
(Internal left hand)



U-type



• Application: General industry, fittings and pipe coupings

Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
Internal / External  U	**08UIRL 12 W**	12	3/16″	8	0.25	0.9	4.0			●	
	22UEIRL 4.5 W	4.5	1/2″	22	0.73	2.3	11.0				●
	22UEIRL 4 W	4	1/2″	22	0.73	1.8	11.0				●
	27UEIRL 3.5 W	3.5	5/8″	27	0.95	2.1	13.7	●	●		
	27UEIRL 3 W	3	5/8″	27	1.12	2.3	13.7	●			
	27UEIRL 2.75 W	2.75	5/8″	27	1.21	2.4	13.7				●



• Tolerance: Medium class

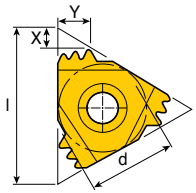
●: Standard item

TaeguTec
Member IMC Group

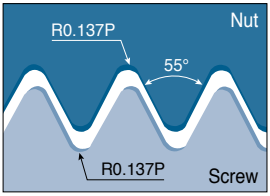
External & Internal Whitworth

T-THREAD

Full profile, multi-tooth, BSW, BSF, BSP



External right hand shown
(Internal left hand)



- Application: General industry, fittings and pipe coupings

Insert	Designation	TPI	Dimension (mm)				No. of teeth	Coated			Uncoated
			d	l	X	Y		TT7010	TT9030	TT8010	P30
Internal / External 	**16ER/IR 14 W 2M**	14	3/8″	16	1.7	2.7	2		●		
	22ER/IR 14 W 3M	14	1/2″	22	2.8	4.5	3		●		
	22ER/IR 11 W 2M	11	1/2″	22	2.3	3.4	2		●		

●: Standard item

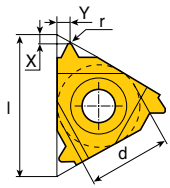
C11-C14

Cutting Condition
C54-C60

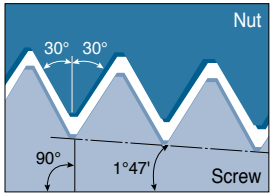
External & Internal NPT

T-THREAD

Full profile, national pipe threads (ANSI/ASME B1.20.1-1983)



External right hand shown
(Internal left hand)



- Application: Steam, gas and water pipes

Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
External Regular	**16ER 27 NPT**	27	3/8″	16	0.04	0.7	0.8	●	●		●
	16ER/L 18 NPT	18	3/8″	16	0.06	0.8	1.0	●	●		●
	16ERB 18 NPT	18	3/8″	16	0.06	0.8	1.0		●		
	16ERM 18 NPT	18	3/8″	16	0.05	0.8	1.0	●	●		
	16ER/L 14 NPT	14	3/8″	16	0.07	0.9	1.2	●	●	●	●
	16ERB 14 NPT	14	3/8″	16	0.07	0.9	1.2		●		
	16ERM 14 NPT	14	3/8″	16	0.05	0.9	1.2	●	●		●
B/M	**16ER/L 11.5 NPT**	11.5	3/8″	16	0.09	1.1	1.5	●	●		●
	16ERB 11.5 NPT	11.5	3/8″	16	0.09	1.1	1.5		●		
	16ERM 11.5 NPT	11.5	3/8″	16	0.09	1.1	1.5	●	●		●
	16ER 8 NPT	8	3/8″	16	0.12	1.3	1.8	●	●		●
	16ERB 8 NPT	8	3/8″	16	0.12	1.3	1.8		●		
	16ERM 8 NPT	8	3/8″	16	0.15	1.3	1.8	●	●		●
Internal Regular	**06IR 27 NPT**	27	5/32″	6	0.04	0.6	0.6			●	●
	08IR 27 NPT	27	3/16″	8	0.04	0.6	0.6			●	
	08IR/L 18 NPT	18	3/16″	8	0.06	0.6	0.6			●	●
	11IR 27 NPT	27	1/4″	11	0.04	0.7	0.8	●			
	11IR/L 18 NPT	18	1/4″	11	0.06	0.8	1.0	●	●	●	
	11IR/L 14 NPT	14	1/4″	11	0.07	0.8	1.0	●		●	
	16IR 27 NPT	27	3/8″	16	0.04	0.7	0.8		●		●
B/M	**16IR 18 NPT**	18	3/8″	16	0.06	0.8	1.0	●	●		●
	16IR/L 14 NPT	14	3/8″	16	0.07	0.9	1.2	●	●	●	●
	16IRB 14 NPT	14	3/8″	16	0.07	0.9	1.2		●		
	16IRM 14 NPT	14	3/8″	16	0.05	0.9	1.2	●	●		●
	16IR/L 11.5 NPT	11.5	3/8″	16	0.09	1.1	1.5	●	●	●	●
	16IRB 11.5 NPT	11.5	3/8″	16	0.09	1.1	1.5		●		
	16IRM 11.5 NPT	11.5	3/8″	16	0.09	1.1	1.5	●	●		●
	16IR/L 8 NPT	8	3/8″	16	0.12	1.3	1.8	●	●		●
	16IRB 8 NPT	8	3/8″	16	0.12	1.3	1.8		●		
	16IRM 8 NPT	8	3/8″	16	0.12	1.3	1.8		●		



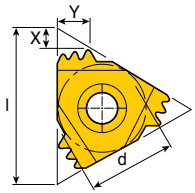
- ERB / ERM / IRB / IRM with pressed chip breaker

●: Standard item

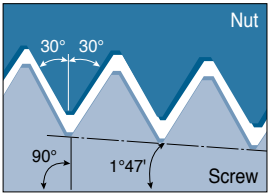
TaeguTec
Member IMC Group

External & Internal NPT

Full profile, multi-tooth, national pipe threads



External right hand shown
(Internal left hand)



- Application: Steam, gas and water pipes

Insert	Designation	TPI	Dimension (mm)				No. of teeth	Coated			Uncoated	
			d	l	X	Y		TT7010	TT9030	TT8010	P30	
Internal / External 	**22ER/IR 11.5 NPT 2M**	11.5	1/2″	22	2.3	3.5	2		●			
	27ER/IR 11.5 NPT 3M	11.5	5/8″	27	3.3	5.5	3		●			
	27ER/IR 8 NPT 2M	8	5/8″	27	3.1	5.0	2		●			

C11-C14
Cutting Condition
C54-C60

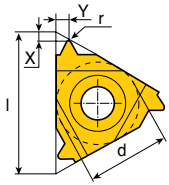
●: Standard item

TaeguTec
Member IMC Group

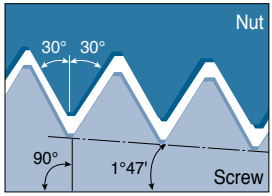
External & Internal NPTF

T-THREAD

Full profile, national pipe threads-dryseal (ANSI / ASME B1.20.1-1976)



External right hand shown
(Internal left hand)



- Application: Steam, gas and water pipes

Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
External  Regular	**11ER 18 NPTF**	18	1/4″	11	0.05	0.8	1.0	●			
	11ER 14 NPTF	14	1/4″	11	0.07	0.8	1.0		●		
	16ER 27 NPTF	27	3/8″	16	0.04	0.7	0.7		●		●
	16ER 18 NPTF	18	3/8″	16	0.06	0.8	1.0		●		
	16ER 14 NPTF	14	3/8″	16	0.07	0.9	1.2	●	●		●
	16ER 11.5NPTF	11.5	3/8″	16	0.09	1.1	1.5		●		●
Internal  Regular	**06IR 27 NPTF**	27	5/32″	6	0.04	0.7	0.6			●	
	08IR 27 NPTF	27	3/16″	8	0.04	0.6	0.6			●	
	08IR 18 NPTF	18	3/16″	8	0.06	0.6	0.6			●	
	11IR 18 NPTF	18	1/4″	11	0.06	0.8	1.0		●		
	11IR 14 NPTF	14	1/4″	11	0.07	0.8	1.0		●		
	16IR 18 NPTF	18	3/8″	16	0.06	0.8	1.0		●		
	16IR/L 14 NPTF	14	3/8″	16	0.07	0.9	1.2	●	●		
	16IR 11.5NPTF	11.5	3/8″	16	0.09	1.1	1.5	●	●		
	16IR 8 NPTF	8	3/8″	16	0.10	1.3	1.8		●		

●: Standard item

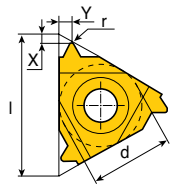


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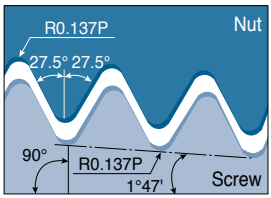
External & Internal BSPT

T-THREAD

Full profile, british standard pipe (B.S. 21-1957)



External right hand shown
(Internal left hand)



- Application: Steam, gas and water pipes

Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
External	**16ER 28 BSPT**	28	3/8″	16	0.11	0.6	0.6	●	●		
 Regular	**16ER/L 19 BSPT**	19	3/8″	16	0.16	0.8	0.9	●	●		●
	16ER/L 14 BSPT	14	3/8″	16	0.21	1.0	1.2	●	●		●
	16ERB 14 BSPT	14	3/8″	16	0.21	1.0	1.2		●		
	16ERM 14 BSPT	14	3/8″	16	0.21	1.0	1.2		●		
 B/M	**16ER/L 11 BSPT**	11	3/8″	16	0.28	1.1	1.5	●	●		●
	16ERB 11 BSPT	11	3/8″	16	0.28	1.1	1.5		●		
	16ERM 11 BSPT	11	3/8″	16	0.28	1.1	1.5		●		
Internal	**06IR 28 BSPT**	28	5/32″	6	0.11	0.7	0.6			●	
 Regular	**08IR 28 BSPT**	28	3/16″	8	0.11	0.6	0.6			●	
	08IR 19 BSPT	19	3/16″	8	0.16	0.6	0.6			●	
	11IR 19 BSPT	19	1/4″	11	0.16	0.8	0.9	●	●		
	11IR/L 14 BSPT	14	1/4″	11	0.21	0.9	1.0	●	●		
 B/M	**16IR 28 BSPT**	28	3/8″	16	0.11	0.6	0.6	●			
	16IR 19 BSPT	19	3/8″	16	0.16	0.8	0.9	●			●
	16IR/L 14 BSPT	14	3/8″	16	0.21	1.0	1.2	●	●		●
	16IRB 14 BSPT	14	3/8″	16	0.21	1.0	1.2		●		
	16IRM 14 BSPT	14	3/8″	16	0.21	1.0	1.2		●		
	16IR/L 11 BSPT	11	3/8″	16	0.28	1.1	1.5	●	●	●	●
	16IRB 11 BSPT	11	3/8″	16	0.28	1.1	1.5		●		
	16IRM 11 BSPT	11	3/8″	16	0.28	1.1	1.5		●		





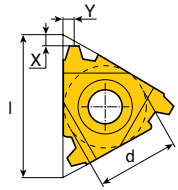
- ERB / ERM / IRB / IRM with pressed chip breaker

●: Standard item

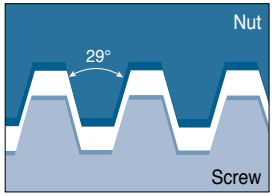
TaeguTec Member IMC Group

External & Internal STUB ACME

ASME / ANSI B.1.8-1988 class: 2G



External right hand shown
(Internal left hand)



- Application: Control valves and modified ACME thread forms

Insert	Designation	TPI	Dimension (mm)				Coated			Uncoated
			d	l	X	Y	TT7010	TT9030	TT8010	P30
External  Regular	**16ER/L 16 STACME**	16	3/8″	16	1.0	1.0	●	●		●
	16ER/L 14 STACME	14	3/8″	16	1.1	1.1				●
	16ER/L 12 STACME	12	3/8″	16	1.2	1.2	●	●		●
	16ER/L 10 STACME	10	3/8″	16	1.3	1.3				●
	16ER/L 8 STACME	8	3/8″	16	1.5	1.5	●	●		●
	16ER/L 6 STACME	6	3/8″	16	1.8	1.8	●	●		
	22ER/L 5 STACME	5	1/2″	22	2.0	2.3	●	●		●
	27ER/L 4 STACME	4	5/8″	27	2.3	2.4	●			●
	27ER/L 3 STACME	3	5/8″	27	2.8	2.9	●	●	●	
Internal  Regular	**16IR/L 16 STACME**	16	3/8″	16	1.0	1.0				●
	16IR/L 14 STACME	14	3/8″	16	1.1	1.1				●
	16IR/L 12 STACME	12	3/8″	16	1.2	1.2	●	●		●
	16IR/L 10 STACME	10	3/8″	16	1.3	1.3				●
	16IR/L 8 STACME	8	3/8″	16	1.5	1.5				●
	16IR/L 6 STACME	6	3/8″	16	1.8	1.8	●	●		
	22IR/L 5 STACME	5	1/2″	22	2.0	2.3	●			●
	22UIR 3 STACME	3	1/2″	22	3.3	11.0	●			
	27IR/L 4 STACME	4	5/8″	27	2.3	2.4	●	●		●
	27IR/L 3 STACME	3	5/8″	27	2.8	2.9	●			

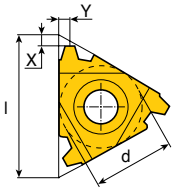
●: Standard item



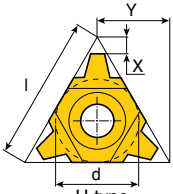
TaeguTec

External & Internal ACME

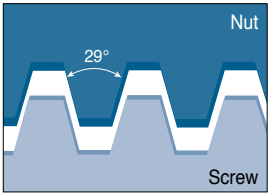
ASME / ANSI B.1.8-1988 class: 3G



External right hand shown
(Internal left hand)



U-type



• Application: Feed screws

Insert	Designation	TPI	Dimension (mm)				Coated			Uncoated
			d	l	X	Y	TT7010	TT9030	TT8010	P30
External  Regular	**11ER 16 ACME**	16	1/4″	11	0.9	1.0		●		
	16ER/L 16 ACME	16	3/8″	16	0.9	1.0		●		●
	16ER/L 14 ACME	14	3/8″	16	1.0	1.2				●
	16ER/L 12 ACME	12	3/8″	16	1.1	1.2	●	●		●
	16ER/L 10 ACME	10	3/8″	16	1.3	1.3	●			●
	16ER/L 8 ACME	8	3/8″	16	1.5	1.5	●	●		●
	22ER/L 6 ACME	6	1/2″	22	1.8	2.1	●	●		●
	22ER/L 5 ACME	5	1/2″	22	2.0	2.3	●	●		●
	22ER/L 4 ACME	4	1/2″	22	2.1	2.2		●		
	27ER/L 4 ACME	4	5/8″	27	2.3	2.7	●	●	●	●
Internal  Regular	**16IR/L 16 ACME**	16	3/8″	16	0.9	1.0	●			●
	16IR/L 14 ACME	14	3/8″	16	1.0	1.2				●
	16IR/L 12 ACME	12	3/8″	16	1.1	1.2	●	●		●
	16IR/L 10 ACME	10	3/8″	16	1.3	1.3	●			●
	16IR/L 8 ACME	8	3/8″	16	1.5	1.5	●	●		●
	22IR/L 6 ACME	6	1/2″	22	1.8	2.1	●	●		●
	22IR/L 5 ACME	5	1/2″	22	2.0	2.3	●	●		●
	22IR 4 ACME	4	1/2″	22	2.1	2.2		●		
	27IR/L 4 ACME	4	5/8″	27	2.3	2.7	●	●	●	●
Internal / External  U	**22UERL 4 ACME**	4	1/2″	22	2.3	11		●		●
	27UERL 3 ACME	3	5/8″	27	2.8	13.7	●	●		
	22UIRL 4 ACME	4	1/2″	22	2.3	11				●
	27UIRL 3 ACME	3	5/8″	27	2.8	13.7	●	●		

●: Standard item

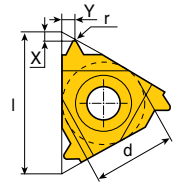
C11-C14
Cutting Condition
C54-C60

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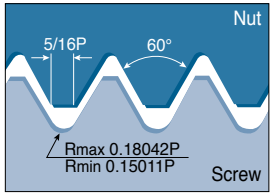
External UNJ

T-THREAD

Full profile (MIL-S-8879C 9-1992 class: 3A)



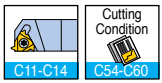
External right hand shown
(Internal left hand)



- Application: Aircraft and aerospace industry

Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
External	**11ER 28 UNJ**	28	1/4″	11	0.04	0.6	0.6		●		
	**11ER 24 UNJ**	24	1/4″	11	0.05	0.7	0.8		●		
	11ER/L 20 UNJ	20	1/4″	11	0.06	0.8	0.9		●		
	11EL 18 UNJ	18	1/4″	11	0.07	0.8	1.0		●		
Regular	**16ER 48 UNJ**	48	3/8″	16	0.03	0.6	0.6		●		
	16ER 44 UNJ	44	3/8″	16	0.03	0.6	0.6		●		
	16ER 40 UNJ	40	3/8″	16	0.03	0.6	0.6		●		
	16ER 36 UNJ	36	3/8″	16	0.04	0.6	0.6		●		
	16ER/L 32 UNJ	32	3/8″	16	0.04	0.6	0.6		●		●
	16ER 28 UNJ	28	3/8″	16	0.04	0.6	0.6	●	●		●
	16ER/L 24 UNJ	24	3/8″	16	0.05	0.7	0.8	●	●		●
	16ER/L 20 UNJ	20	3/8″	16	0.06	0.8	0.9	●	●		●
	16ER/L 18 UNJ	18	3/8″	16	0.07	0.8	1.0	●	●		●
	16ER/L 16 UNJ	16	3/8″	16	0.09	0.8	1.0	●	●		●
	16ER/L 14 UNJ	14	3/8″	16	0.10	1.0	1.2	●	●		●
	16ER 13 UNJ	13	3/8″	16	0.12	1.1	1.3		●		
	16ER/L 12 UNJ	12	3/8″	16	0.12	1.1	1.4	●	●		●
	16ER 11 UNJ	11	3/8″	16	0.13	1.1	1.5		●		
	16ER 10 UNJ	10	3/8″	16	0.15	1.1	1.5		●		●
	16ER/L 8 UNJ	8	3/8″	16	0.15	1.2	1.6	●			●

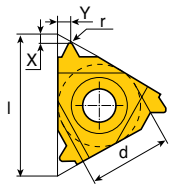
●: Standard item



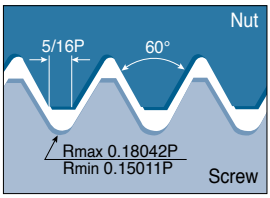
TaeguTec

Internal UNJ

Full profile



External right hand shown
(Internal left hand)



• Application: Aircraft and aerospace industry

Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
Internal	**08IR 20 UNJ**	20	3/16″	8	0.06	0.8	0.9			●	
	08IR 18 UNJ	18	3/16″	8	0.07	0.8	1.0			●	
	11IR 32 UNJ	32	1/4″	11	0.04	0.6	0.6		●		
	11IR 28 UNJ	28	1/4″	11	0.04	0.6	0.6		●		
	11IR 24 UNJ	24	1/4″	11	0.05	0.7	0.8		●		
	11IR 20 UNJ	20	1/4″	11	0.06	0.8	0.9		●		
	11IR 18 UNJ	18	1/4″	11	0.07	0.8	1.0		●		
	11IR 16 UNJ	16	1/4″	11	0.09	0.8	1.0		●		
	16IR 28 UNJ	28	3/8″	16	0.04	0.6	0.6				●
	16IR 24 UNJ	24	3/8″	16	0.05	0.7	0.8				●
	16IR 20 UNJ	20	3/8″	16	0.06	0.8	0.9		●		●
	16IR 18 UNJ	18	3/8″	16	0.07	0.8	1.0				●
	16IR/L 16 UNJ	16	3/8″	16	0.09	0.8	1.0	●	●		●
	16IR 14 UNJ	14	3/8″	16	0.10	1.0	1.2		●		●
	16IR/L 12 UNJ	12	3/8″	16	0.12	1.1	1.4	●	●		●
	16IR/L 8 UNJ	8	3/8″	16	0.19	1.2	1.6		●		●

Regular

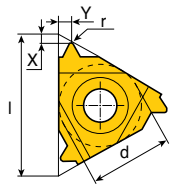
●: Standard item

C11-C14 Cutting Condition C54-C60

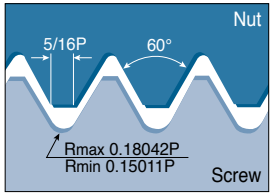
External & Internal MJ

T-THREAD

Full profile (ISO 5855)



External right hand shown
(Internal left hand)



- Application: Aircraft and aerospace industry

Insert	Designation	Pitch (mm)	Dimension (mm)					Coated			Uncoated
			d	l	r	X	Y	TT7010	TT9030	TT8010	P30
External  Regular	**16ER 1.00 MJ**	1.00	3/8"	16	0.16	0.7	0.8		●		
	16ER 1.25 MJ	1.25	3/8"	16	0.20	0.8	0.9		●		
	16ER 1.50 MJ	1.50	3/8"	16	0.23	0.8	1.0	●			
	16ER 2.00 MJ	2.00	3/8"	16	0.32	1.0	1.3		●		
Internal  Regular	**11IR 1.00 MJ**	1.00	1/4"	11	0.05	0.7	0.8		●		
	11IR 1.25 MJ	1.25	1/4"	11	0.07	0.8	0.9		●		
	11IR 1.50 MJ	1.50	1/4"	11	0.08	0.8	1.0		●		
	11IR 2.00 MJ	2.00	1/4"	11	0.12	0.9	1.0		●		
	16IR 1.00 MJ	1.00	3/8"	16	0.05	0.7	0.8		●		
	16IR 1.25 MJ	1.25	3/8"	16	0.07	0.8	0.9		●		
	16IR 1.50 MJ	1.50	3/8"	16	0.08	0.8	1.0		●		

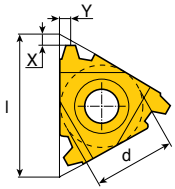
●: Standard item



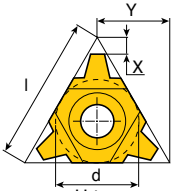
External & Internal Trapez

T-THREAD

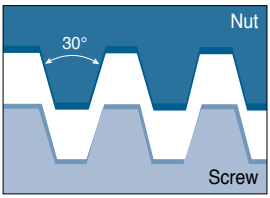
DIN 103



External right hand shown
(Internal left hand)



U-type



- Application: Feed screws

Insert	Designation	Pitch (mm)	Dimension (mm)				Coated			Uncoated
			d	l	X	Y	TT7010	TT9030	TT8010	P30
External  Regular	**16ER/L 1.5 TR**	1.5	3/8″	16	1.0	1.1	●	●		●
	16ER/L 2 TR	2.0	3/8″	16	1.0	1.3	●	●		●
	16ER/L 3 TR	3.0	3/8″	16	1.3	1.5	●	●	●	●
	22ER/L 4 TR	4.0	1/2″	22	1.8	1.9	●	●		●
	22ER/L 5 TR	5.0	1/2″	22	2.0	2.4	●	●	●	●
	22ER/L 6 TR	6.0	1/2″	22	2.0	2.4		●		
	27ER/L 6 TR	6.0	5/8″	27	2.3	2.7	●	●		
	27ER/L 7 TR	7.0	5/8″	27	2.2	2.6	●	●		
Internal  Regular	**08IR/L 1.5 TR**(1)	1.5	3/16″	8	0.6	0.6			●	
	16IR 1.5 TR	1.5	3/8″	16	1.0	1.1			●	
	16IR/L 2 TR	2.0	3/8″	16	1.0	1.3	●	●		●
	16IR/L 3 TR	3.0	3/8″	16	1.3	1.5	●	●	●	●
	22IR/L 4 TR	4.0	1/2″	22	1.8	1.9	●	●		●
	22IR/L 5 TR	5.0	1/2″	22	2.0	2.4	●	●	●	●
	22IR/L 6 TR	6.0	1/2″	22	2.0	2.4	●	●	●	●
	27IR/L 6 TR	6.0	5/8″	27	2.3	2.7	●	●		
	27IR/L 7 TR	7.0	5/8″	27	2.2	2.6	●			
Internal / External  U	**22UERL 6 TR**	6.0	1/2″	22	2.0	11.0	●	●	●	●
	22UERL 7 TR	7.0	1/2″	22	2.3	11.0	●			●
	22UERL 8 TR	8.0	1/2″	22	2.5	11.0	●			●
	27UERL 8 TR	8.0	5/8″	27	2.5	13.7	●	●	●	
	27UERL 9 TR	9.0	5/8″	27	3.0	13.7	●	●		
	27UERL 10 TR(1)	10.0	5/8″	27	3.2	13.7	●	●		
	08UIRL 2 TR	2.0	3/16″	8	0.9	4.0			●	
	22UIRL 6 TR	6.0	1/2″	22	2.0	11.0	●	●		●
	22UIRL 7 TR	7.0	1/2″	22	2.3	11.0	●			●
	27UIRL 8 TR	8.0	5/8″	27	2.5	13.7	●	●	●	●
	27UIRL 9 TR	9.0	5/8″	27	3.0	13.7	●	●		
	27UIRL 10 TR(1)	10.0	5/8″	27	3.2	13.7		●		

C11-C14

Cutting Condition C54-C60

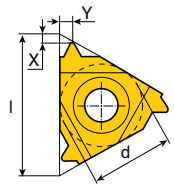
- (1) One cutting edge only
- DIN 103 04 / 1977, 150 2901 / 1977 Class 7H (7E)

●: Standard item

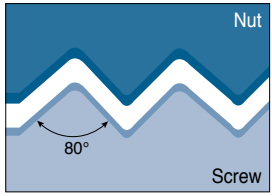
TaeguTec Member IMC Group

External & Internal PG

Full profile (DIN 40430)



External right hand shown
(Internal left hand)



- Application: Electrical industry

Insert	Designation	Pitch (mm)	Dimension (mm)				Coated			Uncoated
			d	l	X	Y	TT7010	TT9030	TT8010	P30
External  Regular	**16ER 16 PG**	16	3/8"	16	0.8	1.0		●		●
	16ER 18 PG	18	3/8"	16	0.8	0.9		●		
	16ER 20 PG	20	3/8"	16	0.7	0.8		●		
Internal  Regular	**11IR 18 PG**	18	1/4"	11	0.8	0.9	●	●		
	16IR/L 16 PG	16	3/8"	16	0.8	1.0		●		●
	16IR 18 PG	18	3/8"	16	0.8	0.9		●		
	16IL 20 PG	20	3/8"	16	0.8	1.0		●		

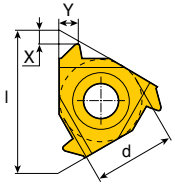
●: Standard item

Cutting Condition
C11-C14
C54-C60

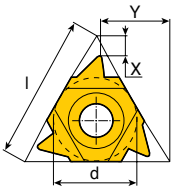
External & Internal Sagengenwinde

T-THREAD

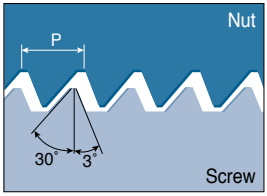
DIN 513



External right hand shown
(Internal left hand)



U-type



• Application: For high forces in one direction

Insert	Designation	Pitch (mm)	Dimension (mm)				Coated			Uncoated	
			d	l	X	Y	TT7010	TT9030	TT8010	P30	
External  Regular	**16ER/L 2 SAGE**	2.0	3/8″	16	1.1	1.6		●			
	22ER/L 3 SAGE	3.0	1/2″	22	1.5	2.4		●			
	22ER/L 4 SAGE	4.0	1/2″	22	1.9	3.1	●	●			
External  U	**22UER/L 5 SAGE**	5.0(1)	1/2″	22	1.2	11.6	●	●			
	22UER/L 6 SAGE	6.0(1)	1/2″	22	1.2	11.7		●			
Internal  Regular	**16IR/L 2 SAGE**	2.0	3/8″	16	1.2	1.7		●			
	22IR/L 3 SAGE	3.0	1/2″	22	1.9	2.9	●	●			
	22IR 4 SAGE	4.0	1/2″	22	2.3	3.5		●			
Internal  U	**22UIR 5 SAGE**	5.0(1)	1/2″	22	1.9	11.7	●	●			
	22UIR 6 SAGE	6.0(1)	1/2″	22	2.1	11.9		●			





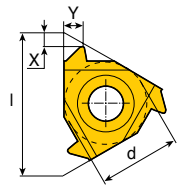
• (1) Requires special anvil

●: Standard item

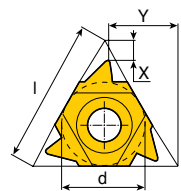
TaeguTec
Member IMC Group

External & Internal American Buttress

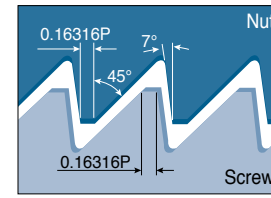
T-THREAD



External right hand shown
(Internal left hand)



U-type



• Application: For high forces in one direction

Insert	Designation	TPI	Dimension (mm)				Coated			Uncoated
			d	l	X	Y	TT7010	TT9030	TT8010	P30
External  Regular	**11ER 20 ABUT**	20	1/4″	11	1.0	1.3	●	●		
	11ER 16 ABUT	16	1/4″	11	1.0	1.5				
	16ER 20 ABUT	20	3/8″	16	1.0	1.3		●		
	16ER/L 16 ABUT	16	3/8″	16	1.1	1.5	●	●		
	16ER/L 12 ABUT	12	3/8″	16	1.4	2.0	●	●		●
	16ER/L 10 ABUT	10	3/8″	16	1.5	2.3		●		●
	22ER 8 ABUT	8	1/2″	22	2.1	3.3	●			
	22ER 6 ABUT	6	1/2″	22	2.1	3.4		●		
External  U	**22UER 4 ABUT**	4	1/2″	22	2.3	9.5	●			●
	27UER/L 3 ABUT	3	5/8″	27	3.1	11.7	●			
Internal  Regular	**11IR 20 ABUT**	20	1/4″	11	1.0	1.3		●		
	11IR/L 16 ABUT	16	1/4″	11	1.0	1.5	●	●	●	
	16IR 20 ABUT	20	3/8″	16	1.0	1.3	●	●		
	16IR/L 16 ABUT	16	3/8″	16	1.0	1.5	●	●		
	16IR/L 12 ABUT	12	3/8″	16	1.4	2.0	●	●		●
	16IR/L 10 ABUT	10	3/8″	16	1.5	2.3	●	●		●
	22IR 8 ABUT	8	1/2″	22	2.1	3.3		●		
	22IR/L 6 ABUT	6	1/2″	22	2.1	3.4		●		●
Internal  U	**22UIR 4 ABUT**	4	1/2″	22	2.3	9.5				●
	27UIR/L 3 ABUT	3	5/8″	27	3.1	11.7		●		



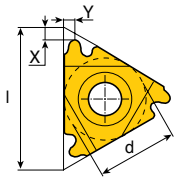
• ANSI B1.9-1973 class 2

●: Standard item

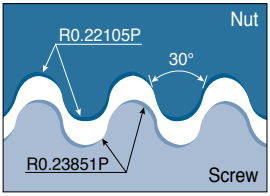
TaeguTec
Member IMC Group

External & Internal Round

DIN 405



External right hand shown
(Internal left hand)



• Application: Pipe coupings in fire fighting and food industries

Insert	Designation	TPI	Dimension (mm)				Coated			Uncoated
			d	l	X	Y	TT7010	TT9030	TT8010	P30
External	**16ER/L10 RND**	10	3/8″	16	1.1	1.2	●	●		●
	16ER/L 8 RND	8	3/8″	16	1.4	1.3	●	●		●
	16ERM 8 RND	8	3/8″	16	1.4	1.3		●		
	16ER/L 6 RND	6	3/8″	16	1.5	1.7	●	●		●
Regular	**16ERM 6 RND**	6	3/8″	16	1.5	1.7		●		
	22ER/L 6 RND	6	1/2″	22	1.5	1.7	●	●	●	●
	22ER/L 4 RND	4	1/2″	22	2.2	2.3	●	●		●
	27ER 4 RND	4	5/8″	27	2.2	2.3	●			●
Internal	**16IR 10 RND**	10	3/8″	16	1.1	1.2	●	●		●
	16IR/L 8 RND	8	3/8″	16	1.4	1.4	●	●		●
	16IR/L 6 RND	6	3/8″	16	1.4	1.5	●	●	●	
	16IRM 6 RND	6	3/8″	16	1.4	1.5	●	●		●
Regular	**22IR 6 RND**	6	1/2″	22	1.5	1.7	●	●		●
	22IR/L 4 RND	4	1/2″	22	2.2	2.3	●	●		●
	27IR/L 4 RND	4	5/8″	27	2.2	2.3	●	●		●

C11-C14 | Cutting Condition C54-C60

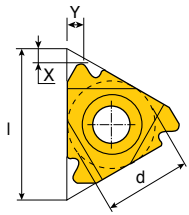
• ERM / IRM with pressed chip breaker
• Tolerance class 7H

●: Standard item

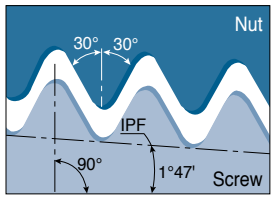
TaeguTec Member IMC Group

API - Oil Threads

Round profile



External right hand shown
(Internal left hand)



- Application: Oil & gas industry

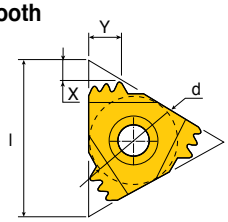
Insert	Designation	TPI	Dimension (mm)					Coated			Uncoated
			d	l	IPF	X	Y	TT7010	TT9030	TT8010	P30
External  Regular	**16ER 10 API RD**	10	3/8"	16	0.75	1.5	1.4	●	●		●
	16ER/L 8 API RD	8	3/8"	16	0.75	1.3	1.6	●	●		●
Internal  Regular	**16IR/L 10 API RD**	10	3/8"	16	0.75	1.5	1.4	●	●	●	●
	16IR/L 8 API RD	8	3/8"	16	0.75	1.3	1.6	●			●

●: Standard item

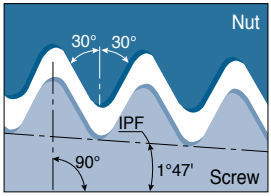
API - Oil Threads

T-THREAD

Round profile, multi-tooth



External right hand shown
(Internal left hand)



- Application: Oil & gas industry

Insert	Designation	TPI	Dimension (mm)					No. of Teeth	Coated			Uncoated
			d	l	IPF	X	Y		TT7010	TT9030	TT8010	P30
Internal / External 	**22ER/IR 10 API RD 2M**	10	1/2"	22	0.75	2.4	3.7	2		●		
	27ER/IR 10 API RD 3M	10	5/8"	27	0.75	3.8	6.2	3		●		
	27ER/IR 8 API RD 2M	8	5/8"	27	0.75	3.0	4.5	2		●		

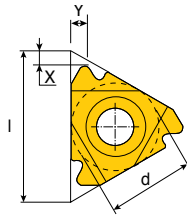
C11-C14
Cutting Condition
C54-C60

- API Spec 5B8-1996

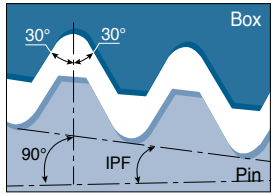
●: Standard item

TaeguTec
Member IMC Group

API - Oil Thread Profile



External right hand shown
(Internal left hand)



• Application: Oil & gas industry

Insert	Designation	TPI	Dimension (mm)					Connection No. or size	Coated			Uncoated
			d	l	IPF	X	Y		TT7010	TT9030	TT8010	P30
External  Regular	**22ER/L 5 API 403**(1)	5	1/2"	22	3	1.8	2.5	2.375"-4.5"REG	●	●		●
	27ER/L 4 API 382(2)	4	5/8"	27	2	2.1	2.8	NC23-NC50	●	●		
	27ER 4 API 383(2)	4	5/8"	27	3	2.1	2.8	NC56-NC77	●	●		
	27ER/L 4 API 502(3)	4	5/8"	27	2	2.0	3.0	6-5/8"REG	●	●		●
	27ER 4 API 503(3)	4	5/8"	27	3	2.0	3.0	5-1/2, 7-5/8, 8-5/8"REG	●	●		●
Internal  Regular	**22IR/L 5 API 403**(1)	5	1/2"	22	3	1.8	2.5	2.375"-4.5"REG	●	●		●
	27IR/L 4 API 382(2)	4	5/8"	27	2	2.1	2.8	NC23-NC50	●	●		●
	27IR 4 API 383(2)	4	5/8"	27	3	2.1	2.8	NC56-NC77		●		
	27IR/L 4 API 502(3)	4	5/8"	27	2	2.0	3.0	6-5/8"REG	●			●
	27IR/L 4 API 503(3)	4	5/8"	27	3	2.0	3.0	5-1/2, 7-5/8, 8-5/8"REG	●			●



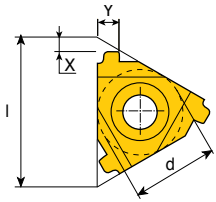
• (1) V-0.040 (2) V-0.038R (3) V-0.050
• 0.050, API spec 74-1994

●: Standard item

TaeguTec
Member IMC Group

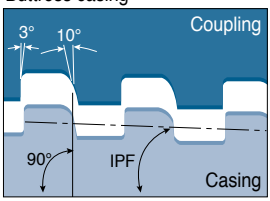
Buttress Casing / Extreme Line Casing

T-THREAD

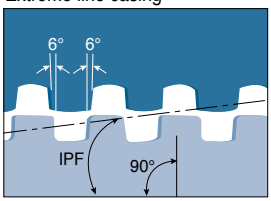


External right hand shown
(Internal left hand)

Buttress casing



Extreme line casing



• Application: Oil & gas industry

Insert	Designation	TPI	Dimension (mm)					Connection No. or size	Coated			Uncoated
			d	l	IPF	X	Y		TT7010	TT9030	TT8010	P30
 Buttress	**22ER/IR 5 BUT 0.75**	5	1/2″	22	0.75	2.2	2.4	4-1/2″ - 13-3/8″	●	●		●
	22ER/IR 5 BUT 1.0	5	1/2″	22	1.0	2.3	2.4	16″ - 20″	●			
 Extreme line casing	**22ER 6 EL 1.5**	6	1/2″	22	1.5	1.9	1.9	5″ - 7-5/8″	●	●		
	22IR 6 EL 1.5	6	1/2″	22	1.5	1.9	1.9	5″ - 7-5/8″		●		
	22ER 5 EL 1.25	5	1/2″	22	1.25	2.4	2.3	8-5/8″ - 10-3/4″	●	●		
	22IR 5 EL 1.25	5	1/2″	22	1.25	2.4	2.3	8-5/8″ - 10-3/4″	●			





• ANSI B1.9-1973 class 2

●: Standard item

TaeguTec

Recommended Cutting Conditions

T-THREAD

Machining data for thread turning insert

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1
		>=0.25%C	Annealed	650	190	2
		<0.55%C	Quenched and tempered	850	250	3
		>=0.55%C	Annealed	750	220	4
			Quenched and tempered	1000	300	5
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6
			Quenched and tempered	930	275	7
				1000	300	8
				1200	350	9
	High alloy steel, cast steel and tool steel		Annealed	680	200	10
			Quenched and tempered	1100	325	11
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12
			Martensitic	820	240	13
			Austenitic	600	180	14
K	Gray cast iron (GG)		Ferritic		160	15
			Pearlitic		250	16
	Cast iron nodular (GGG)		Ferritic		180	17
			Pearlitic		260	18
	Malleable cast iron		Ferritic		130	19
			Pearlitic		230	20
N	Aluminum - Wrought alloy		Not cureable		60	21
			Cured		100	22
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23
			Cured		90	24
		>12% Si	High temp.		130	25
	Copper alloys	>1% Pb	Free cutting		110	26
			Brass		90	27
			Electrolitic copper		100	28
	Non-metallic		Duroplastics, fiber plastics			29
			Hard rubber			30
S	High temp. alloys	Fe based	Annealed		200	31
			Cured		280	32
		Ni or Co based	Annealed		250	33
			Cured		350	34
			Cast		320	35
	Titanium, Ti alloys			Rm 400		36
			Alpha+beta alloys cured	Rm 1050		37
H	Hardened steel		Hardened		55HRC	38
			Hardened		60HRC	39
	Chilled cast iron		Cast		400	40
	Cast iron nodular		Hardened		55HRC	41

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

Machining data for thread turning insert

Cutting speed (m/min)					
Coated			Uncoated		
TT7010	TT9030	TT8010	P30		
120-200	140-220	85-125	80-120		
120-200	140-220	85-125	80-120		
110-190	130-210	80-120	70-110		
110-190	130-210	80-120	70-110		
90-170	110-190	70-100	65-95		
70-120	70-120	50-70	70-110		
90-170	110-190	70-100	65-95		
80-120	100-140	60-100	70-110		
70-120	90-140	40-80	40-80		
70-100	70-100	40-70	40-70		
40-80	40-80	40-70	40-70		
85-125	90-130	40-70	40-70		
120-180	130-190	80-120	80-120		
50-100	60-110	40-60	40-60		
	100-140	80-120			
	110-150	80-120			
	110-150	80-120			
	80-120	80-120			
	110-150	60-100			
	80-120	55-95			
	1300-1500	700-900			
	400-600	330-430			
	500-800	350-450			
	370-470	300-360			
	200-280	150-210			
	260-340	160-240			
	350-450	250-310			
	100-140	80-120			
	250-350	160-200			
	250-350	150-210			
	50-70	20-50			
	30-50	20-50			
	30-50	20-40			
	20-40	15-30			
	20-40	15-30			
	120-140	90-110			
	40-60	20-50			
	30-60	20-35			
	20-40	20-30			
	20-40	20-30			
	20-30	15-25			

Maximum depth of first cut for CNC control / external threading - M-type inserts

Full profile	Pitch		Insert designation	No. of passes		Max. depth for first pass (D_1) mm	
						Low carbon steel	
	mm	TPI		Min.	Max.	Eq.(2)	Dim.(3)
ISO metric	1.00		**16 ERM 1.00 ISO**	5	9	0.34	0.51
	1.25		**16 ERM 1.25 ISO**	6	11	0.42	0.63
	1.50		**16 ERM 1.50 ISO**	6	12	0.46	0.69
	1.75		**16 ERM 1.75 ISO**	8	13	0.48	0.72
	2.00		**16 ERM 2.00 ISO**	8	14	0.50	0.75
	2.50		**16 ERM 2.50 ISO**	10	15	0.53	0.80
	3.00		**16 ERM 3.00 ISO**	12	17	0.56	0.84
American UN		24	**16 ERM 24 UN**	5	9	0.34	0.51
		20	**16 ERM 20 UN**	6	10	0.42	0.63
		18	**16 ERM 18 UN**	6	11	0.46	0.69
		16	**16 ERM 16 UN**	7	12	0.47	0.71
		14	**16 ERM 14 UN**	6	13	0.46	0.69
		12	**16 ERM 12 UN**	8	14	0.50	0.75
		8	**16 ERM 8 UN**	12	17	0.56	0.84
British BSW		19	**16 ERM 19 W**	6	11	0.35	0.52
		16	**16 ERM 16 W**	7	12	0.47	0.71
		14	**16 ERM 14 W**	8	13	0.50	0.75
		11	**16 ERM 11 W**	9	14	0.44	0.66
NPT		18	**16 ERM 18 NPT**	10	20	0.24	0.36
		14	**16 ERM 14 NPT**	13	26	0.24	0.36
		11.5	**16 ERM 11.5 NPT**	15	24	0.27	0.40
		8	**16 ERM 8 NPT**	17	30	0.31	0.46
Round		6	**16 ERM 6 RND**	9	20	0.42	0.63
Partial profile 60°		48-16	**16 ERM A 60**	(1)		0.22	0.33
		14-8	**16 ERM G 60**			0.50	0.75
		48-8	**16 ERM AG 60**			0.24	0.36
		7-5	**16 ERM N 60**			0.41	0.62
Partial profile 55°		14-8	**16 ERM G 55**			0.50	0.75
		48-8	**16 ERM AG 55**			0.22	0.33

- (1) As per the number of passes for the relevant pitch
  (2) Equal depth of cut method
  (3) Diminished depth of cut for each pass method

Max. depth for first pass (D_1) mm							
High carbon steel		Alloy steel		Stainless steel		Nonferrous aluminum	
Eq.[2]	Dim.[3]	Eq.[2]	Dim.[3]	Eq.[2]	Dim.[3]	Eq.[2]	Dim.[3]
0.31	0.46	0.27	0.41	0.22	0.33	0.48	0.71
0.38	0.57	0.34	0.50	0.27	0.41	0.59	0.88
0.41	0.62	0.37	0.55	0.30	0.45	0.64	0.97
0.43	0.65	0.38	0.58	0.31	0.47	0.67	1.01
0.45	0.68	0.40	0.60	0.33	0.49	0.70	1.05
0.48	0.72	0.42	0.64	0.34	0.52	0.74	1.12
0.50	0.76	0.45	0.67	0.36	0.55	0.78	1.18
0.31	0.46	0.27	0.41	0.22	0.33	0.48	0.71
0.38	0.57	0.34	0.50	0.27	0.41	0.59	0.88
0.41	0.62	0.37	0.55	0.30	0.45	0.64	0.97
0.42	0.64	0.38	0.57	0.31	0.46	0.66	0.99
0.41	0.62	0.37	0.55	0.28	0.41	0.64	0.97
0.45	0.68	0.40	0.60	0.33	0.49	0.70	1.05
0.50	0.76	0.45	0.67	0.36	0.55	0.78	1.18
0.32	0.47	0.28	0.42	0.21	0.31	0.49	0.73
0.42	0.64	0.38	0.57	0.31	0.46	0.66	0.99
0.45	0.68	0.40	0.60	0.33	0.49	0.70	1.05
0.40	0.59	0.35	0.53	0.29	0.43	0.62	0.92
0.22	0.32	0.19	0.29	0.16	0.23	0.34	0.50
0.22	0.32	0.19	0.29	0.14	0.22	0.34	0.50
0.24	0.36	0.22	0.32	0.18	0.26	0.38	0.56
0.28	0.41	0.25	0.37	0.20	0.30	0.43	0.64
0.38	0.57	0.34	0.50	0.27	0.41	0.59	0.88
0.20	0.30	0.18	0.26	0.14	0.21	0.31	0.46
0.45	0.68	0.40	0.60	0.33	0.49	0.70	1.05
0.22	0.32	0.19	0.29	0.16	0.23	0.34	0.50
0.37	0.56	0.33	0.50	0.27	0.40	0.57	0.87
0.45	0.68	0.40	0.60	0.33	0.49	0.70	1.05
0.20	0.30	0.18	0.26	0.14	0.21	0.31	0.46

Maximum depth of first cut for CNC control / internal threading - M-type inserts

Full profile	Pitch		Insert designation	No. of passes		Max. depth for first pass (D_1) mm	
						Low carbon steel	
	mm	TPI		Min.	Max.	Eq.[2]	Dim.[3]
ISO metric	1.50		**11 IRM 1.50 ISO**	10	20	0.20	0.30
	1.00		**16 IRM 1.00 ISO**	9	16	0.14	0.20
	1.25		**16 IRM 1.25 ISO**	9	16	0.19	0.28
	1.50		**16 IRM 1.50 ISO**	10	20	0.20	0.30
	1.75		**16 IRM 1.75 ISO**	11	18	0.21	0.32
	2.00		**16 IRM 2.00 ISO**	12	21	0.22	0.33
	2.50		**16 IRM 2.50 ISO**	14	21	0.23	0.34
	3.00		**16 IRM 3.00 ISO**	16	22	0.24	0.35
American UN		20	**16 IRM 20 UN**	7	13	0.20	0.30
		18	**16 IRM 18 UN**	8	15	0.20	0.30
		16	**16 IRM 16 UN**	11	19	0.20	0.30
		14	**16 IRM 14 UN**	11	20	0.21	0.31
		12	**16 IRM 12 UN**	12	21	0.23	0.34
		8	**16 IRM 8 UN**	14	20	0.24	0.36
British BSW		19	**16 IRM 19 W**	7	12	0.28	0.42
		16	**16 IRM 16 W**	9	14	0.26	0.39
		14	**16 IRM 14 W**	10	16	0.27	0.41
		11	**16 IRM 11 W**	12	19	0.31	0.46
NPT		14	**16 IRM 14 NPT**	21	35	0.13	0.20
		11.5	**16 IRM 11.5 NPT**	21	33	0.17	0.25
		8	**16 IRM 8 NPT**	20	34	0.23	0.34
Round		6	**16 IRM 6 RND**	12	24	0.30	0.46
Partial profile 60°		48-16	**06 IRM A 60**	(1)		0.22	0.33
		48-16	**08 IRM A 60**			0.13	0.20
		48-16	**11 IRM A 60**			0.13	0.20
		48-16	**16 IRM A 60**			0.13	0.20
		14-8	**16 IRM G 60**			0.22	0.33
		48-8	**16 IRM AG 60**			0.14	0.21
		7-5	**22 IRM N 60**			0.23	0.34
Partial profile 55°		14-8	**16 IRM G 55**			0.34	0.50
		48-8	**16 IRM AG 55**			0.14	0.20

- [1] As per the number of passes for the relevant pitch
  [2] Equal depth of cut method
  [3] Diminished depth of cut for each pass method

Number of cutting passes for regular type inserts

Pitch	mm	0.5	1.0	1.5	2.0	2.5	3.0	4.0	6.0
	TPI	48	24	16	12	10	8	6	4
Number of passes		4-6	5-9	5-12	6-14	7-15	8-17	10-20	11-22

- For mini-tools (06IR or 08IR) add 1-3 passes. Increase for hard materials

Max. depth for first pass (D_1) mm							
High carbon steel		Alloy steel		Stainless steel		Nonferrous aluminum	
Eq.[2]	Dim.[3]	Eq.[2]	Dim.[3]	Eq.[2]	Dim.[3]	Eq.[2]	Dim.[3]
0.18	0.27	0.16	0.24	0.12	0.18	0.28	0.42
0.13	0.18	0.11	0.16	0.09	0.13	0.20	0.28
0.17	0.25	0.15	0.22	0.12	0.18	0.27	0.39
0.18	0.27	0.16	0.24	0.12	0.18	0.28	0.42
0.19	0.29	0.17	0.26	0.14	0.21	0.29	0.45
0.20	0.30	0.18	0.26	0.14	0.21	0.31	0.46
0.21	0.31	0.18	0.27	0.15	0.22	0.32	0.48
0.22	0.32	0.19	0.29	0.16	0.23	0.34	0.50
0.18	0.27	0.16	0.24	0.12	0.18	0.28	0.42
0.18	0.27	0.16	0.24	0.12	0.18	0.28	0.42
0.18	0.27	0.16	0.24	0.13	0.20	0.28	0.42
0.19	0.28	0.17	0.25	0.13	0.19	0.29	0.43
0.21	0.31	0.18	0.27	0.15	0.22	0.32	0.48
0.22	0.32	0.19	0.29	0.16	0.23	0.34	0.50
0.25	0.38	0.22	0.34	0.17	0.25	0.39	0.59
0.23	0.35	0.21	0.31	0.17	0.25	0.36	0.55
0.24	0.37	0.22	0.33	0.18	0.27	0.38	0.57
0.28	0.41	0.25	0.37	0.20	0.30	0.43	0.64
0.12	0.18	0.10	0.16	0.08	0.12	0.18	0.28
0.15	0.23	0.14	0.20	0.11	0.16	0.24	0.35
0.21	0.31	0.18	0.27	0.14	0.20	0.32	0.48
0.27	0.41	0.24	0.37	0.20	0.30	0.42	0.64
0.20	0.30	0.18	0.26	0.14	0.21	0.31	0.46
0.12	0.18	0.10	0.16	0.08	0.13	0.18	0.28
0.12	0.18	0.10	0.16	0.08	0.13	0.18	0.28
0.12	0.18	0.10	0.16	0.08	0.13	0.18	0.28
0.20	0.30	0.18	0.26	0.14	0.21	0.31	0.46
0.13	0.19	0.11	0.17	0.09	0.14	0.20	0.29
0.21	0.31	0.18	0.27	0.15	0.22	0.32	0.48
0.31	0.45	0.27	0.40	0.22	0.33	0.48	0.70
0.13	0.18	0.11	0.16	0.09	0.13	0.20	0.28

Recommended number of passes for multi-tooth insert

Full profile	Insert description	No. of passes	1st pass	2nd pass	3rd pass	4th pass	External / internal
ISO metric	**16 ER 1.0 ISO 3M**	2	0.39	0.24	-	-	External
	16 ER 1.5 ISO 2M	3	0.40	0.31	0.21	-	External
	22 ER 1.5 ISO 3M	2	0.54	0.38	-	-	External
	22 ER 2.0 ISO 2M	3	0.56	0.42	0.27	-	External
	22 ER 2.0 ISO 3M	2	0.75	0.50	-	-	External
	27 ER 3.0 ISO 2M	4	0.60	0.52	0.44	0.30	External
	16 IR 1.0 ISO 3M	2	0.32	0.26	-	-	Internal
	16 IR 1.5 ISO 2M	3	0.36	0.29	0.22	-	Internal
	22 IR 1.5 ISO 3M	2	0.49	0.38	-	-	Internal
	22 IR 2.0 ISO 2M	3	0.50	0.40	0.25	-	Internal
	22 IR 2.0 ISO 3M	2	0.72	0.43	-	-	Internal
	27 IR 3.0 ISO 2M	4	0.57	0.45	0.38	0.33	Internal
UN	**16 ER 16 UN 2M**	3	0.45	0.32	0.20	-	External
	22 ER 16 UN 3M	2	0.60	0.37	-	-	External
	22 ER 12 UN 2M	3	0.60	0.39	0.31	-	External
	22 ER 12 UN 3M	2	0.80	0.50	-	-	External
	27 ER 8 UN 2M	4	0.63	0.55	0.42	0.36	External
	16 IR 16 UN 2M	3	0.40	0.29	0.23	-	Internal
	22 IR 16 UN 3M	2	0.57	0.35	-	-	Internal
	22 IR 12 UN 2M	3	0.55	0.39	0.28	-	Internal
	22 IR 12 UN 3M	2	0.75	0.47	-	-	Internal
	27 IR 8 UN 2M	4	0.65	0.49	0.42	0.27	Internal
NPT	**22 ER 11.5 NPT 2M**	4	0.55	0.46	0.35	0.32	External
	27 ER 11.5 NPT 3M	3	0.75	0.57	0.36	-	External
	27 ER 8 NPT 2M	4	0.80	0.62	0.54	0.45	External
	22 IR 11.5 NPT 2M	4	0.55	0.46	0.35	0.32	Internal
	27 IR 11.5 NPT 3M	3	0.75	0.57	0.36	-	Internal
	27 IR 8 NPT 2M	4	0.80	0.62	0.54	0.45	Internal
Whitworth	**16 ER 14 W 2M**	3	0.51	0.39	0.26	-	External
	22 ER 14 W 3M	2	0.72	0.44	-	-	External
	22 ER 11 W 2M	3	0.65	0.46	0.37	-	External
	16 IR 14 W 2M	3	0.51	0.39	0.26	-	Internal
	22 IR 14 W 3M	2	0.72	0.44	-	-	Internal
	22 IR 11 W 2M	3	0.65	0.46	0.37	-	Internal
API round	**22 ER 10 API RD 2M**	3	0.58	0.53	0.30	-	External
	27 ER 10 API RD 3M	2	0.98	0.43	-	-	External
	27 ER 8 API RD 2M	3	0.82	0.59	0.40	-	External
	22 IR 10 API RD 2M	3	0.58	0.53	0.30	-	Internal
	27 IR 10 API RD 3M	2	0.98	0.43	-	-	Internal
	27 IR 8 API RD 2M	3	0.82	0.59	0.40	-	Internal

HOLEMAKING



HOLEMAKING

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Guide to Icons


External Coolant

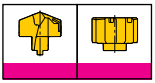

Internal Coolant


Through Hole


Blind Hole



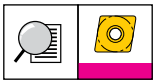
Tube Page

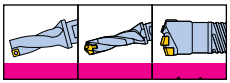

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Tool Selection Guide

Drilling

Series			Indexable drill			
			TOPDRILL	T-DRILL		T-DEEP
			TOP 2/3/4/5 	TDR 2/3/4/5 	TDR 2.5/3.5 	HFD 
Pages			D16 - D27	D28 - D40	D41 - D44	D128 - D129
Dc(mm)			Ø14.0 - Ø50.0	Ø12.5 - Ø50.0	Ø51.0 - Ø80.0	Ø30.0 - Ø69.0
Drill depth(L/D)			2, 3, 4, 5 x Dc	2, 3, 4, 5 x Dc	2.5, 3.5 x Dc	6-14 x Dc
Hole tolerance			IT 11-13	IT 12-13	IT 12-13	IT 10-11
Application	General drilling		●	●	●	●
	Cross hole drilling		●	●	●	
	Irregular surface drilling		○	○	○	
	Interrupted drilling		○	○	○	
	Chamfering					
Coolant supply			Internal	Internal	Internal	Internal

Tool Selection Guide

Drilling

Indexable drill	Head changeable drill			
T-DEEP	DRILL•RUSH		TWIN•RUSH	SPADE•RUSH
TRGD	**TCD**	**TCD... -M**	**TND...T2-5D**	**LCD**
				
D130 - D135	D50 - D58	D59	D61	D62 - D63
Ø16.0 - Ø28.0	Ø6.0 - Ø25.9	M8 - M24 (ISO)	Ø26.0 - Ø45.0	Ø26.0 - Ø41.0
10-25 x Dc	1.5, 3, 5, 8, 12 x Dc		5 x Dc	3, 5 x Dc
IT 10-11	IT 9-10	IT 9-10	IT 10-12	IT 9-10
●	●	●	●	●
○	●		●	●
		●		
Internal	Internal	Internal	Internal	Internal

● Recommended, ○ Suitable

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Tool Selection Guide

Drilling

Series			Solid carbide drill				Multi-function tool
			H-DRILL				TOPCAP
			NHD...PE/PI	SHO 10/15/20	SHO...-M	CDF	TCAP
							
Pages			D64 - D71	D73	D74	D75	D78 - D79
Dc(mm)			Ø3.0 - Ø12.0	Ø4.0 - Ø10.0	M4 - M10 (ISO)	Ø3.0 - Ø12.7	Ø8.0 - Ø32.0
Drill depth(L/D)			3, 5 x Dc	10, 15, 20 x Dc			2.25, 3 x Dc
Hole tolerance			IT 8-10	IT 8-10	IT 8-10	IT 8-10	IT 10-12
Application	General drilling		●	●	●	●	●
	Cross hole drilling		●	○			
	Irregular surface drilling						●
	Interrupted drilling						
	Chamfering				●		
Coolant supply			Internal / External	Internal	Internal	External	Internal

Tool Selection Guide

Deep drilling

Series		Indexable deep drill head				
		T-DEEP				
		TBTA3 	TBTA5 	TBTA7 	TBTA9 	TBTA-FB 
Pages		D84 - D89	D90 - D93	D94 - D96	D97 - D99	D100 - D104
Dc(mm)		Ø38.00 - Ø106.99	Ø107.00 - Ø168.99	Ø169.00 - Ø232.99	Ø233.00 - Ø291.99	Ø25.00 - Ø65.00
Drill depth(L/D)		100 x Dc	100 x Dc	100 x Dc	100 x Dc	100 x Dc
Hole tolerance		IT 10	IT 10	IT 10	IT 10	IT 10
Surface finish		3μm	3μm	3μm	3μm	3μm
Single tube	Outer four thread	●	●	●	●	●
	Inner single thread	●	●	● ★	●	●
Double tube	Outer four thread	●	●			●

★ In case of inner single thread connection TBTA7 series can cover up to dia. 245.99mm

Series		Indexable deep drill head		Brazed deep drill head	
		T-DEEP			
		TBTA-R 	TBTA-TR 	BTA-SE4/DE4 	BTS-SE1/SE4 
Pages		D105 - D110	D111 - D114	D115 - D117	D118
Dc(mm)		Ø25.00 - Ø110.99	Ø16.00 - Ø28.00	Ø12.60 - Ø65.00	Ø8.00 - Ø20.00
Drill depth(L/D)		100 x Dc	100 x Dc	100 x Dc	100 x Dc
Hole tolerance		IT 7 - IT 9	IT 10	IT 9	IT 9
Surface finish		1-2μm	3μm	2μm	2μm
Single tube	Outer four thread	●	●	●	● ★
	Inner single thread	●	●		
Double tube	Outer four thread		●	●	

★ Two start thread: Diameter 12.60 to 15.59mm

● Recommended, ○ Suitable

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Tool Selection Guide

Reaming

Series				Reamer		
				TS-REAM	TM-REAM	TB-REAM
				TS 	TM 	TB 
Pages				D191 - D192	D193 - D194	D195 - D197
Dc(mm)				Ø3.000 - Ø16.000	Ø11.501 - Ø32.000	Ø8.000 - Ø32.000
Depth(L/D)				7.5-10 x Dc	3, 5, 8 x Dc	5-9 x Dc
Hole tolerance				IT 7	IT 7★	IT 6★★
Application		**Through**	**Blind**			
	General reaming			●	●	●
	Cross hole reaming			●		●
	Irregular surface reaming			●		●
	Interrupted reaming			●	●	●
Coolant supply				External	Internal	Internal

★ Up to IT 6 tolerance ★★ Up to IT 5 tolerance ● Recommended

TaeguTec

Tool Selection Guide

Drill insert

Series			TOPDRILL	T-DRILL	DRILL-RUSH	
			SOMT	SPMG	TCD-P/M/K	TCD-F
						
Pages			D137 - D138	D138 - D139	D140 - D142	D143
Size			05/06/07/08/09 11/13/15	05/06/07/09/11/14	Ø6.0 - Ø25.9(0.1)	Ø8.0 - Ø25.5(0.5)
Chip former			DP, DK, DA	DG, DK, DA	P/M/K	F
Grades			TT9080, TT9300, TT8020, TT6080, K10	TT9030, TT8020 TT7400, TT6030, K10	TT9080	TT9080
Application	General drilling		●	●	●	●
	Cross hole drilling		●	●	●	●
	Irregular surface drilling		○	○	○	○
	Interrupted drilling		○	○		
	Chamfering					

Tool Selection Guide

Drill insert

Series			DRILL-RUSH		TWIN-RUSH	
			TCD...P2	AOMT	TCD...P-CO	SPGX...DW
						
Pages			D144	D145	D146	D146
Size			Ø8.0 - Ø19.5(0.5)	06-C45	Ø15.9 - Ø24.9	06/07/09/11/14
Chip former			P2	-	P	DW
Grades			TT9080	TT9080	TT9080	TT9080
Application	General drilling		●		●	●
	Cross hole drilling		●		●	●
	Irregular surface drilling		○		○	○
	Interrupted drilling					
	Chamfering			●		

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Tool Selection Guide

Drill insert

SPADE-RUSH	CFR	T-CHAMFER	TOPCAP
LCD...-P	**CRNG**	**XCGT**	**XCGT** **XCMT**
			
D147	D145	D148	D149 - D150
Ø26.0 - Ø41.0	08-45CD	06/09	04/05/06/07/08 10/13/17
P	-	C30/C45/C60	TA/GV/TC
TT9080	TT9080	TT9050	TT9080, TT8020, TT9030, K10
●			●
●			
○			
	●	●	

● Recommended, ○ Suitable

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Tool Selection Guide

Drill insert

Series			T-DEEP			
			NPHT NPMT	NPMX TPMX	TOGT	TPMX XPMT
						
Pages			D151 - D152	D152 - D153	D153	D154
Size			05/06/07/08/09 /11/12/13	08/14/17/24/28	08/09/10/11/12	14/16/17/24
Chip former			RG/LG	RB/RG	RS	LG/-45
Grades			TT9030, TT6020, TT8125	TT9030, TT8125, TT7400, TT9300, TT7100, TT3500	TT9030	TT9030
Application	General drilling		●	●	●	●
	Cross hole drilling		○	○		○
	Irregular surface drilling					
	Interrupted drilling					
	Chamfering					

Tool Selection Guide

Reamer head & blade

Series				TM-REAM	TB-REAM
				TM	TB
					
Pages				D198 - D199	D200
Size				Ø11.501 - Ø32.000	1/2/3/4
Chip former				BL/AS	A06/B06/B12
Grades				TT9030	TT5030, TT5050
Application		**Through**	**Blind**		
	General reaming			●	●
	Cross hole reaming				
	Irregular surface reaming				
	Interrupted reaming				

● Recommended, ○ Suitable

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Grades

Holemaking

Grades	ISO	Characteristics & applications
TT6080 PVD carbide	K05 – K25 H05 – H25	• General machining for gray and ductile cast iron • Finish and medium machining of hardened steel
TT9300 CVD carbide	P10 – P25	• High speed drilling of carbon & alloy steel
TT9080 PVD carbide	P20 – P40 M20 – M40 S20 – S40	• General machining of steel • General machining of stainless steel • General machining of heat-resistant alloy
TT9030 PVD carbide	P20 – P40 M20 – M40 S20 – S40	• General machining of steel • General machining of stainless steel • General machining of heat-resistant alloy
TT8020 PVD carbide	P30 – P50 M30 – M50 S30 – S50	• Interrupted and rough machining of steel • Interrupted and rough machining of stainless steel • Low speed and interrupted machining of heat-resistant alloy
K10 Uncoated	K05 – K15 N05 – N15 S05 – S15	• General machining of cast iron • General machining of aluminum alloys and non-ferrous materials • General machining of heat-resistant alloy
UF1A/UF10 Uncoated	N10 – N25 S10 – S30	• General machining of aluminum alloys and non-ferrous materials • General machining of heat-resistant alloy

Holemaking Toolholders



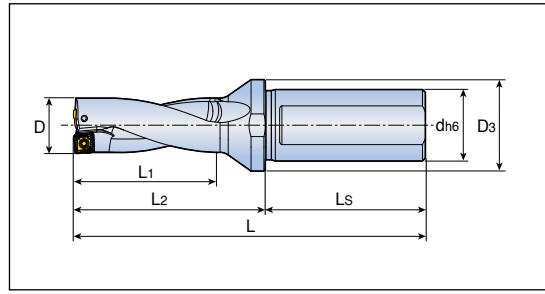
TOP 2...-T2

Indexable drill holder



• Drilling depth: 2xdiameter





Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
TOP 2140-20T2-05	14.0	20	25	96	28	46	50	SOMT 05...DA/DK/DP D137
2145-20T2-05	14.5	20	25	99	30	49	50	
2150-20T2-05	15.0	20	25	99	30	49	50	
2155-20T2-05	15.5	20	25	102	32	52	50	
2160-20T2-05	16.0	20	25	102	32	52	50	
2165-25T2-06	16.5	25	32	110	34	54	56	SOMT 06...DA/DK/DP D137
2170-25T2-06	17.0	25	32	110	34	54	56	
2175-25T2-06	17.5	25	32	113	36	57	56	
2180-25T2-06	18.0	25	32	113	36	57	56	
2185-25T2-06	18.5	25	32	115	38	59	56	
2190-25T2-06	19.0	25	32	115	38	59	56	
2195-25T2-07	19.5	25	32	119	40	63	56	SOMT 07...DA/DK/DP D137
2200-25T2-07	20.0	25	32	119	40	63	56	
2205-25T2-07	20.5	25	32	121	42	65	56	
2210-25T2-07	21.0	25	32	121	42	65	56	
2215-25T2-07	21.5	25	32	123	44	67	56	
2220-25T2-07	22.0	25	32	123	44	67	56	
2225-25T2-08	22.5	25	32	124	46	68	56	SOMT 08...DA/DK/DP D137
2230-25T2-08	23.0	25	32	124	46	68	56	
2230-32T2-08	23.0	32	40	128	46	68	60	
2235-25T2-08	23.5	25	32	126	48	70	56	
2235-32T2-08	23.5	32	40	130	48	70	60	
2240-25T2-08	24.0	25	32	126	48	70	56	
2240-32T2-08	24.0	32	40	130	48	70	60	
2245-25T2-08	24.5	25	32	128	50	72	56	
2245-32T2-08	24.5	32	40	132	50	72	60	
2250-25T2-08	25.0	25	32	128	50	72	56	
2250-32T2-08	25.0	32	40	132	50	72	60	
2255-25T2-08	25.5	25	32	129	52	73	56	
2255-32T2-08	25.5	32	40	133	52	73	60	
2260-25T2-08	26.0	25	32	129	52	73	56	
2260-32T2-08	26.0	32	40	133	52	73	60	
2265-32T2-09	26.5	32	40	137	54	77	60	SOMT 09...DA/DK/DP D137
2270-25T2-09	27.0	25	40	133	54	77	56	
2270-32T2-09	27.0	32	40	137	54	77	60	

Cutting Condition D160

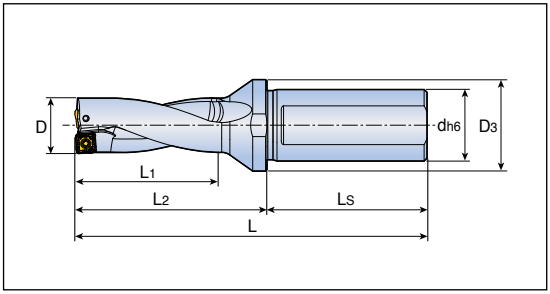
TOP 2...-T2

Indexable drill holder



• Drilling depth: 2xdiameter





Designation		Dimension (mm)							Insert
		D	d	D3	L	L1	L2	LS	
TOP	2275-32T2-09	27.5	32	40	139	56	79	60	SOMT 09...DA/DK/DP
	2280-25T2-09	28.0	25	40	135	56	79	56	D137
	2280-32T2-09	28.0	32	40	139	56	79	60	
	2285-32T2-09	28.5	32	40	141	58	81	60	
	2290-25T2-09	29.0	25	40	137	58	81	56	
	2290-32T2-09	29.0	32	40	141	58	81	60	
	2295-32T2-09	29.5	32	40	143	60	83	60	
	2300-32T2-09	30.0	32	40	143	60	83	60	
	2305-32T2-09	30.5	32	40	145	62	85	60	
	2310-32T2-09	31.0	32	40	145	62	85	60	
	2320-32T2-11	32.0	32	40	147	64	87	60	SOMT 11...DA/DK/DP
	2320-40T2-11	32.0	40	50	157	64	87	70	D137
	2330-32T2-11	33.0	32	40	149	66	89	60	
	2330-40T2-11	33.0	40	50	159	66	89	70	
	2340-32T2-11	34.0	32	40	151	68	91	60	
	2340-40T2-11	34.0	40	50	161	68	91	70	
	2350-32T2-11	35.0	32	40	153	70	93	60	
	2350-40T2-11	35.0	40	50	163	70	93	70	
	2360-32T2-11	36.0	32	40	155	72	95	60	
	2360-40T2-11	36.0	40	50	165	72	95	70	
	2370-32T2-13	37.0	32	50	162	74	102	60	SOMT 13...DA/DK/DP
	2370-40T2-13	37.0	40	50	172	74	102	70	D137
	2380-32T2-13	38.0	32	50	164	76	104	60	
	2380-40T2-13	38.0	40	50	174	76	104	70	
	2390-32T2-13	39.0	32	50	166	78	106	60	
	2390-40T2-13	39.0	40	50	176	78	106	70	
	2400-32T2-13	40.0	32	50	168	80	108	60	
	2400-40T2-13	40.0	40	50	178	80	108	70	
	2410-40T2-13	41.0	40	50	180	82	110	70	
	2420-40T2-13	42.0	40	50	182	84	112	70	
	2430-40T2-13	43.0	40	50	184	86	114	70	

Cutting Condition D160

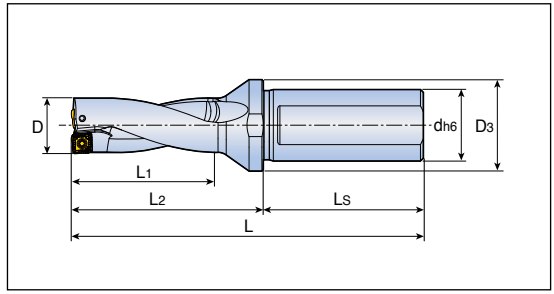
TOP 2...-T2

Indexable drill holder



• Drilling depth: 2xdiameter





Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
TOP 2440-40T2-15	44.0	40	60	193	88	123	70	SOMT 15...DA/DK/DP
2450-40T2-15	45.0	40	60	195	90	125	70	D137
2460-40T2-15	46.0	40	60	197	92	127	70	
2470-40T2-15	47.0	40	60	199	94	129	70	
2480-40T2-15	48.0	40	60	201	96	131	70	
2490-40T2-15	49.0	40	60	203	98	133	70	
2500-40T2-15	50.0	40	60	205	100	135	70	

Spare parts

Designation	Screw	Wrench	Plug*	
TOP 2140 - 2160	TS 20043I/HG-P	TD 6P	SL 20M	
TOP 2165 - 2220	TS 22052I/HG-P	TD 7P	SL 25M	
TOP 2225 - 2260	SO 25065I	TD 7	SL 25M / SL 32M	
TOP 2265 - 2360	TS 35088I	TD 10	SL 25M / SL 32M	
TOP 2370 - 2430	TS 40093I	TD 15	SL 32M / SL 40M	
TOP 2440 - 2550	TS 50115I	TD 20	SL 32M / SL 40M	

Cutting Condition D160

• *Notice: Cooling hole plug for lathe should be ordered separately
Order example) Plug for shank diameter 25.0mm : SL 25M

TOP 3...-T2

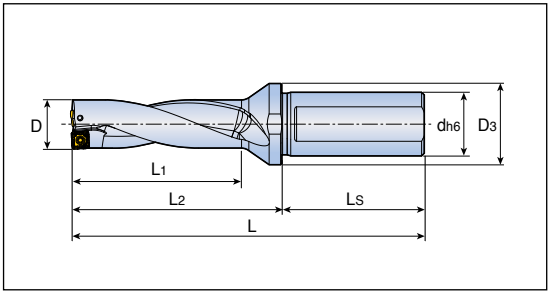
TOPDRILL

Indexable drill holder



• Drilling depth: 3xdiameter





Designation		Dimension (mm)							Insert
		D	d	D3	L	L1	L2	LS	
TOP	3140-20T2-05	14.0	20	25	110	42	60	50	SOMT 05...DA/DK/DP D137
	3145-20T2-05	14.5	20	25	114	45	64	50	
	3150-20T2-05	15.0	20	25	114	45	64	50	
	3155-20T2-05	15.5	20	25	118	48	68	50	
	3160-20T2-05	16.0	20	25	118	48	68	50	
	3165-25T2-06	16.5	25	32	127	51	71	56	SOMT 06...DA/DK/DP D137
	3167-25T2-06 *	16.7	25	32	127	50.1	71	56	
	3170-25T2-06	17.0	25	32	127	51	71	56	
	3175-25T2-06	17.5	25	32	131	54	75	56	
	3180-25T2-06	18.0	25	32	131	54	75	56	
	3185-25T2-06	18.5	25	32	134	57	78	56	
	3190-25T2-06	19.0	25	32	134	57	78	56	
	3195-25T2-07	19.5	25	32	139	60	83	56	SOMT 07...DA/DK/DP D137
	3200-25T2-07	20.0	25	32	139	60	83	56	
	3205-25T2-07	20.5	25	32	142	63	86	56	
	3210-25T2-07	21.0	25	32	142	63	86	56	
	3215-25T2-07	21.5	25	32	145	66	89	56	
	3220-25T2-07	22.0	25	32	145	66	89	56	
	3222-25T2-07 *	22.2	25	32	145	66.6	89	56	
	3225-25T2-08	22.5	25	32	147	69	91	56	SOMT 08...DA/DK/DP D137
	3230-25T2-08	23.0	25	32	147	69	91	56	
	3230-32T2-08	23.0	32	40	151	69	91	60	
	3235-25T2-08	23.5	25	32	150	72	94	56	
	3235-32T2-08	23.5	32	40	154	72	94	60	
	3240-25T2-08	24.0	25	32	150	72	94	56	
	3240-32T2-08	24.0	32	40	154	72	94	60	
	3245-25T2-08	24.5	25	32	153	75	97	56	
	3245-32T2-08	24.5	32	40	157	75	97	60	
	3250-25T2-08	25.0	25	32	153	75	97	56	
	3250-32T2-08	25.0	32	40	157	75	97	60	
	3254-25T2-08 *	25.4	25	32	153	76.2	97	56	
	3255-25T2-08	25.5	25	32	155	78	99	56	
	3255-32T2-08	25.5	32	40	159	78	99	60	
	3260-25T2-08	26.0	25	32	155	78	99	56	
	3260-32T2-08	26.0	32	32	159	78	99	60	

Cutting Condition D160

• '*' Marked items are for inch sized hole

TaeguTec Member IMC Group

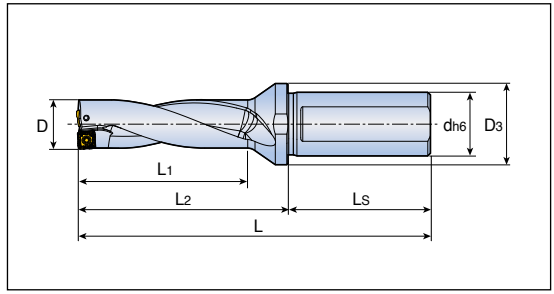
TOP 3...-T2

Indexable drill holder



• Drilling depth: 3xdiameter





Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
TOP 3265-25T2-09	26.5	25	40	160	81	104	56	SOMT 09...DA/DK/DP D137
3265-32T2-09	26.5	32	40	164	81	104	60	
3270-25T2-09	27.0	25	40	160	81	104	56	
3270-32T2-09	27.0	32	40	164	81	104	60	
3275-25T2-09	27.5	25	40	163	84	107	56	
3275-32T2-09	27.5	32	40	167	84	107	60	
3280-25T2-09	28.0	25	40	163	84	107	56	
3280-32T2-09	28.0	32	40	167	84	107	60	
3285-25T2-09	28.5	25	40	166	87	110	56	
3285-32T2-09	28.5	32	40	170	87	110	60	
3290-25T2-09	29.0	25	40	166	87	110	56	
3290-32T2-09	29.0	32	40	170	87	110	60	
3295-32T2-09	29.5	32	40	173	90	113	60	
3300-32T2-09	30.0	32	40	173	90	113	60	
3305-32T2-09	30.5	32	40	176	93	116	60	
3310-32T2-09	31.0	32	40	176	93	116	60	
3320-32T2-11	32.0	32	40	179	96	119	60	SOMT 11...DA/DK/DP D137
3320-40T2-11	32.0	40	50	189	96	119	70	
3330-32T2-11	33.0	32	40	182	99	122	60	
3330-40T2-11	33.0	40	50	192	99	122	70	
3340-32T2-11	34.0	32	40	185	102	125	60	
3340-40T2-11	34.0	40	50	195	102	125	70	
3350-32T2-11	35.0	32	40	188	105	128	60	
3350-40T2-11	35.0	40	50	198	105	128	70	
3360-32T2-11	36.0	32	40	191	108	131	60	
3360-40T2-11	36.0	40	50	201	108	131	70	
3370-32T2-13	37.0	32	50	199	111	139	60	SOMT 13...DA/DK/DP D137
3370-40T2-13	37.0	40	50	209	111	139	70	
3380-32T2-13	38.0	32	50	202	114	142	60	
3380-40T2-13	38.0	40	50	212	114	142	70	
3390-32T2-13	39.0	32	50	205	117	145	60	
3390-40T2-13	39.0	40	50	215	117	145	70	
3400-32T2-13	40.0	32	50	208	120	148	60	
3400-40T2-13	40.0	40	40	218	120	148	70	

Cutting Condition D160

TOP 3...-T2

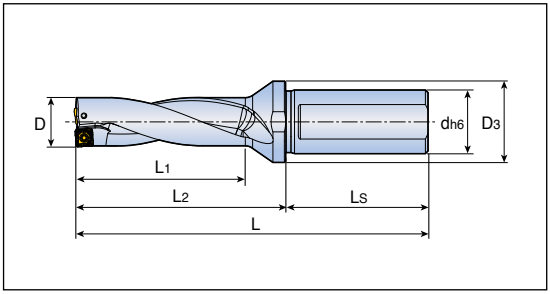
TOPDRILL

Indexable drill holder



• Drilling depth: 3xdiameter





Designation		Dimension (mm)							Insert
		D	d	D3	L	L1	L2	LS	
TOP	3410-40T2-13	41.0	40	50	221	123	151	70	SOMT 13...DA/DK/DP D137
	3420-40T2-13	42.0	40	50	224	126	154	70	
	3430-40T2-13	43.0	40	50	227	129	157	70	
	3440-40T2-15	44.0	40	60	237	132	167	70	SOMT 15...DA/DK/DP D137
	3450-40T2-15	45.0	40	60	240	135	170	70	
	3460-40T2-15	46.0	40	60	243	138	173	70	
	3470-40T2-15	47.0	40	60	246	141	176	70	
	3480-40T2-15	48.0	40	60	249	144	179	70	
	3490-40T2-15	49.0	40	60	252	147	182	70	
	3500-40T2-15	50.0	40	60	255	150	185	70	

Spare parts

Designation	Screw	Wrench	Plug*	
				
TOP 3140 - 3160	TS 20043I/HG-P	TD 6P	SL 20M	
TOP 3165 - 3220	TS 22052I/HG-P	TD 7P	SL 25M	
TOP 3225 - 3260	SO 25065I	TD 7	SL 25M / SL 32M	
TOP 3265 - 3360	TS 35088I	TD 10	SL 25M / SL 32M	
TOP 3370 - 3430	TS 40093I	TD 15	SL 32M / SL 40M	
TOP 3440 - 3500	TS 50115I	TD 20	SL 32M / SL 40M	

Cutting Condition D160

• *Notice: Cooling hole plug for lathe should be ordered separately
Order example) Plug for shank diameter 25.0mm : SL 25M

TaeguTec Member IMC Group

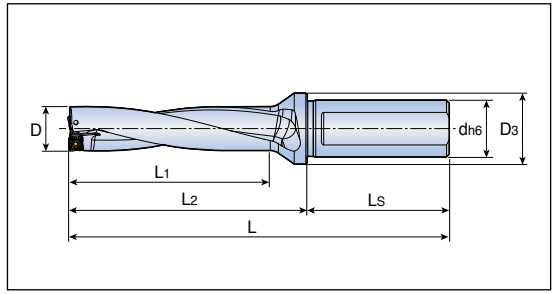
TOP 4...-T2

Indexable drill holder



• Drilling depth: 4xdiameter





Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
TOP 4140-20T2-05	14.0	20	25	124	56	74	50	SOMT 05...DA/DK/DP D137
4145-20T2-05	14.5	20	25	129	60	79	50	
4150-20T2-05	15.0	20	25	129	60	79	50	
4155-20T2-05	15.5	20	25	134	64	84	50	
4160-20T2-05	16.0	20	25	134	64	84	50	
4165-25T2-06	16.5	25	32	144	68	88	56	SOMT 06...DA/DK/DP D137
4170-25T2-06	17.0	25	32	144	68	88	56	
4175-25T2-06	17.5	25	32	149	72	93	56	
4180-25T2-06	18.0	25	32	149	72	93	56	
4185-25T2-06	18.5	25	32	153	76	97	56	
4190-25T2-06	19.0	25	32	153	76	97	56	
4195-25T2-07	19.5	25	32	159	80	103	56	SOMT 07...DA/DK/DP D137
4200-25T2-07	20.0	25	32	159	80	103	56	
4205-25T2-07	20.5	25	32	163	84	107	56	
4210-25T2-07	21.0	25	32	163	84	107	56	
4215-25T2-07	21.5	25	32	167	88	111	56	
4220-25T2-07	22.0	25	32	167	88	111	56	
4225-25T2-08	22.5	25	32	170	92	114	56	SOMT 08...DA/DK/DP D137
4230-25T2-08	23.0	25	32	170	92	114	56	
4230-32T2-08	23.0	32	40	174	92	114	60	
4235-25T2-08	23.5	25	32	174	96	118	56	
4235-25T2-08	23.5	32	40	178	96	118	60	
4240-25T2-08	24.0	25	32	174	96	118	56	
4240-32T2-08	24.0	32	40	178	96	118	60	
4245-25T2-08	24.5	25	32	178	100	122	56	
4245-32T2-08	24.5	32	40	182	100	122	60	
4250-25T2-08	25.0	25	32	178	100	122	56	
4250-32T2-08	25.0	32	40	182	100	122	60	
4254-25T2-08 *	25.4	25	32	178	101.6	122	56	
4255-25T2-08	25.5	25	32	181	104	125	56	
4255-32T2-08	25.5	32	40	185	104	125	60	
4260-25T2-08	26.0	25	32	181	104	125	56	
4260-32T2-08	26.0	32	40	185	104	125	60	

Cutting Condition D160

• '*' Marked items are for inch sized hole

TaeguTec

TOP 4...-T2

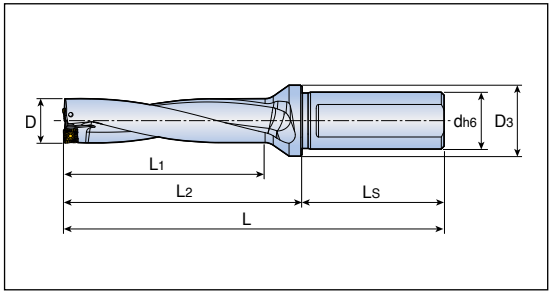
TOPDRILL

Indexable drill holder



• Drilling depth: 4xdiameter





Designation		Dimension (mm)							Insert
		D	d	D3	L	L1	L2	Ls	
TOP	4265-25T2-09	26.5	25	40	187	108	131	56	SOMT 09...DA/DK/DP
	4265-32T2-09	26.5	32	40	191	108	131	60	D137
	4270-25T2-09	27.0	25	40	187	108	131	56	
	4270-32T2-09	27.0	32	40	191	108	131	60	
	4275-25T2-09	27.5	25	40	191	112	135	56	
	4275-32T2-09	27.5	32	40	195	112	135	60	
	4280-25T2-09	28.0	25	40	191	112	135	56	
	4280-32T2-09	28.0	32	40	195	112	135	60	
	4285-25T2-09	28.5	25	40	195	116	139	56	
	4285-32T2-09	28.5	32	40	199	116	139	60	
	4286-32T2-09 *	28.6	32	40	199	116	139	60	
	4290-25T2-09	29.0	25	40	195	116	139	56	
	4290-32T2-09	29.0	32	40	199	116	139	60	
	4295-32T2-09	29.5	32	40	203	120	143	60	
	4300-32T2-09	30.0	32	40	203	120	143	60	
	4305-32T2-09	30.5	32	40	207	124	147	60	
	4310-32T2-09	31.0	32	40	207	124	147	60	
	4318-32T2-11 *	31.8	32	40	211	127.2	151	60	SOMT 11...DA/DK/DP
	4320-32T2-11	32.0	32	40	211	128	151	60	D137
	4320-40T2-11	32.0	40	50	221	128	151	70	
	4330-32T2-11	33.0	32	40	215	132	155	60	
	4330-40T2-11	33.0	40	50	225	132	155	70	
	4340-32T2-11	34.0	32	40	219	136	159	60	
	4340-40T2-11	34.0	40	50	229	136	159	70	
	4349-40T2-11 *	34.9	40	50	233	139.6	163	70	
	4350-32T2-11	35.0	32	40	223	140	163	60	
	4350-40T2-11	35.0	40	50	233	140	163	70	
	4360-32T2-11	36.0	32	40	227	144	167	60	
	4360-40T2-11	36.0	40	50	237	144	167	70	
	4370-32T2-13	37.0	32	50	236	148	176	60	SOMT 13...DA/DK/DP
	4370-40T2-13	37.0	40	50	246	148	176	70	D137
	4371-40T2-13 *	37.1	40	50	246	148.4	176	70	
	4380-32T2-13	38.0	32	50	240	152	180	60	
	4380-40T2-13	38.0	40	50	250	152	180	70	
	4381-40T2-13 *	38.1	40	50	250	152.4	180	70	

Cutting Condition D160

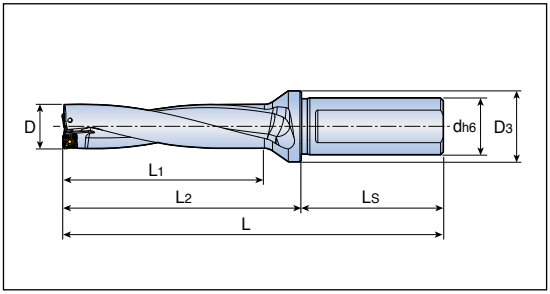
• '*' Marked items are for inch sized hole

TOP 4...-T2

TOPDRILL

Indexable drill holder





• Drilling depth: 4xdiameter

Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
TOP 4390-32T2-13	39.0	32	50	244	156	184	60	SOMT 13...DA/DK/DP
4390-40T2-13	39.0	40	50	254	156	184	70	D137
4400-32T2-13	40.0	32	50	248	160	188	60	
4400-40T2-13	40.0	40	50	258	160	188	70	
4410-40T2-13	41.0	40	50	262	164	192	70	
4413-40T2-13 *	41.3	40	50	262	165.2	192	70	
4420-40T2-13	42.0	40	50	266	168	196	70	
4429-40T2-13 *	42.9	40	50	270	171.6	200	70	
4430-40T2-13	43.0	40	50	270	172	200	70	
4440-40T2-15	44.0	40	60	281	176	211	70	SOMT 15...DA/DK/DP
4445-40T2-15 *	44.5	40	60	285	178	215	70	D137
4450-40T2-15	45.0	40	60	285	180	215	70	
4460-40T2-15	46.0	40	60	289	184	219	70	
4470-40T2-15	47.0	40	60	293	188	223	70	
4476-40T2-15 *	47.6	40	60	297	190.4	227	70	
4480-40T2-15	48.0	40	60	297	192	227	70	
4490-40T2-15	49.0	40	60	301	196	231	70	
4500-40T2-15	50.0	40	60	305	200	235	70	
4508-40T2-15 *	50.8	40	60	309	203.2	239	70	

• '*' Marked items are for inch sized hole

Spare parts

Designation	Screw	Wrench	Plug*	
TOP 4140 - 4160	TS 20043I/HG-P	TD 6P	SL 20M	
TOP 4165 - 4220	TS 22052I/HG-P	TD 7P	SL 25M	
TOP 4225 - 4260	SO 25065I	TD 7	SL 25M / SL 32M	
TOP 4265 - 4360	TS 35088I	TD 10	SL 25M / SL 32M	
TOP 4370 - 4430	TS 40093I	TD 15	SL 32M / SL 40M	
TOP 4440 - 4508	TS 50115I	TD 20	SL 32M / SL 40M	

Cutting Condition D160

• *Notice: Cooling hole plug for lathe should be ordered separately
Order example) Plug for shank diameter 25.0mm : SL 25M

TaeguTec Member IMC Group

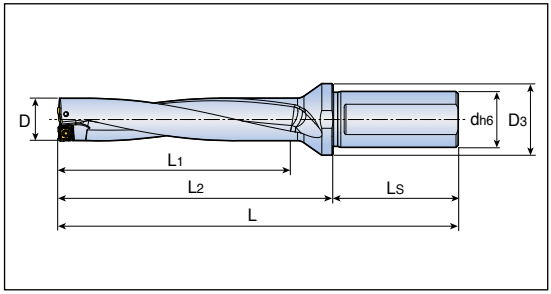
TOP 5...-T2

TOPDRILL

Indexable drill holder



• Drilling depth: 5xdiameter



Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	LS	
TOP 5140-20T2-05	14.0	20	25	138	70	88	50	SOMT 05...DA/DK/DP D137
5145-20T2-05	14.5	20	25	144	75	94	50	
5150-20T2-05	15.0	20	25	144	75	94	50	
5155-20T2-05	15.5	20	25	150	80	100	50	
5160-20T2-05	16.0	20	25	150	80	100	50	
5165-25T2-06	16.5	25	32	161	85	105	56	SOMT 06...DA/DK/DP D137
5170-25T2-06	17.0	25	32	161	85	105	56	
5175-25T2-06	17.5	25	32	167	90	111	56	
5180-25T2-06	18.0	25	32	167	90	111	56	
5185-25T2-06	18.5	25	32	172	95	116	56	
5190-25T2-06	19.0	25	32	172	95	116	56	
5195-25T2-07	19.5	25	32	179	100	123	56	SOMT 07...DA/DK/DP D137
5200-25T2-07	20.0	25	32	179	100	123	56	
5205-25T2-07	20.5	25	32	184	105	128	56	
5210-25T2-07	21.0	25	32	184	105	128	56	
5215-25T2-07	21.5	25	32	189	110	133	56	
5220-25T2-07	22.0	25	32	189	110	133	56	
5222-25T2-07 *	22.2	25	32	189	111	133	56	
5225-25T2-08	22.5	25	32	193	115	137	56	SOMT 08...DA/DK/DP D137
5230-25T2-08	23.0	25	32	193	115	137	56	
5230-32T2-08	23.0	32	40	197	115	137	60	
5235-25T2-08	23.5	25	32	198	120	142	56	
5235-32T2-08	23.5	32	40	202	120	142	60	
5240-25T2-08	24.0	25	32	198	120	142	56	
5240-32T2-08	24.0	32	40	202	120	142	60	
5245-25T2-08	24.5	25	32	203	125	147	56	
5245-32T2-08	24.5	32	40	207	125	147	60	
5250-25T2-08	25.0	25	32	203	125	147	56	
5250-32T2-08	25.0	32	40	207	125	147	60	
5255-25T2-08	25.5	25	32	207	130	151	56	
5255-32T2-08	25.5	32	40	211	130	151	60	
5260-25T2-08	26.0	25	32	207	130	151	56	
5260-32T2-08	26.0	32	40	211	130	151	60	

Cutting Condition D162

• '*' Marked items are for inch sized hole

TaeguTec Member IMC Group

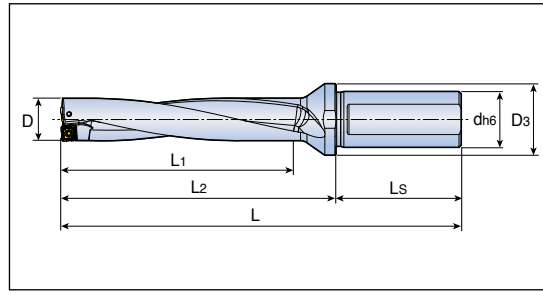
TOP 5...-T2

Indexable drill holder



• Drilling depth: 5xdiameter





Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	LS	
TOP 5265-32T2-09	26.5	32	40	218	135	158	60	SOMT 09...DA/DK/DP
5270-25T2-09	27.0	25	40	214	135	158	56	D137
5270-32T2-09	27.0	32	40	218	135	158	60	
5275-32T2-09	27.5	32	40	223	140	163	60	
5280-25T2-09	28.0	25	40	219	140	163	56	
5280-32T2-09	28.0	32	40	223	140	163	60	
5282-32T2-09 *	28.2	32	40	223	141	163	60	
5285-32T2-09	28.5	32	40	228	145	168	60	
5290-25T2-09	29.0	25	40	224	145	168	56	
5290-32T2-09	29.0	32	40	228	145	168	60	
5395-32T2-09	39.5	32	40	233	150	173	60	
5300-32T2-09	30.0	32	40	233	150	173	60	
5305-32T2-09	30.5	32	40	238	155	178	60	
5310-32T2-09	31.0	32	40	238	155	178	60	
5320-32T2-11	32.0	32	40	243	160	183	60	SOMT 11...DA/DK/DP
5320-40T2-11	32.0	40	50	253	160	183	70	D137
5330-32T2-11	33.0	32	40	248	165	188	60	
5330-40T2-11	33.0	40	50	258	165	188	70	
5340-32T2-11	34.0	32	40	253	170	193	60	
5340-40T2-11	34.0	40	50	263	170	193	70	
5350-32T2-11	35.0	32	40	258	175	198	60	
5350-40T2-11	35.0	40	50	268	175	198	70	
5360-32T2-11	36.0	32	40	263	180	203	60	
5360-40T2-11	36.0	40	50	273	180	203	70	
5370-32T2-13	37.0	32	50	273	185	213	60	SOMT 13...DA/DK/DP
5370-40T2-13	37.0	40	50	283	185	213	70	D137
5380-32T2-13	38.0	32	50	278	190	218	60	
5380-40T2-13	38.0	40	50	288	190	218	70	
5390-32T2-13	39.0	32	50	283	195	223	60	
5390-40T2-13	39.0	40	50	293	195	223	70	
5400-32T2-13	40.0	32	50	288	200	228	60	
5400-40T2-13	40.0	40	50	298	200	228	70	
5410-40T2-13	41.0	40	50	303	205	233	70	
5420-40T2-13	42.0	40	50	308	210	238	70	
5430-40T2-13	43.0	40	50	313	215	243	70	

Cutting Condition D162

• '*' Marked items are for inch sized hole

TaeguTec

TOP 5...-T2

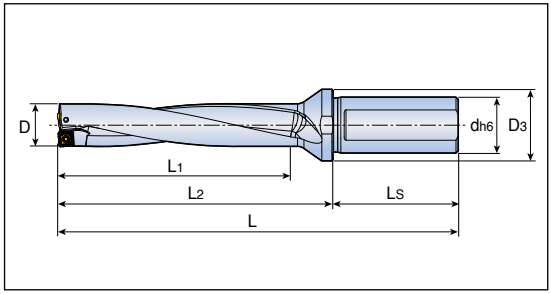
TOPDRILL

Indexable drill holder



• Drilling depth: 5xdiameter





Designation		Dimension (mm)							Insert
		D	d	D3	L	L1	L2	Ls	
TOP	5440-40T2-15	44.0	40	60	325	220	255	70	SOMT 15...DA/DK/DP
	5450-40T2-15	45.0	40	60	330	225	260	70	D137
	5460-40T2-15	46.0	40	60	335	230	265	70	
	5470-40T2-15	47.0	40	60	340	235	270	70	
	5480-40T2-15	48.0	40	60	345	240	275	70	
	5490-40T2-15	49.0	40	60	350	245	280	70	
	5500-40T2-15	50.0	40	60	355	250	285	70	

Spare parts

Designation	Screw	Wrench	Plug*	
				
TOP 5140 - 5160	TS 20043I/HG-P	TD 6P	SL 20M	
TOP 5165 - 5220	TS 22052I/HG-P	TD 7P	SL 25M	
TOP 5225 - 5260	SO 25065I	TD 7	SL 25M / SL 32M	
TOP 5265 - 5360	TS 35088I	TD 10	SL 25M / SL 32M	
TOP 5370 - 5430	TS 40093I	TD 15	SL 32M / SL 40M	
TOP 5440 - 5500	TS 50115I	TD 20	SL 32M / SL 40M	

Cutting Condition D162

• *Notice: Cooling hole plug for lathe should be ordered separately
Order example) Plug for shank diameter 25.0mm : SL 25M

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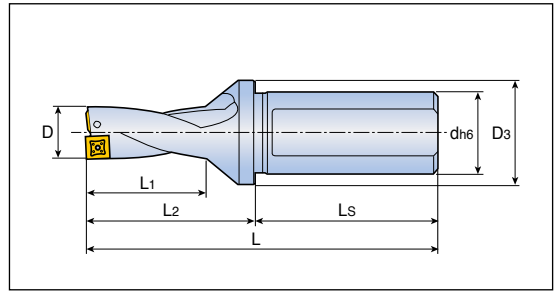
TDR 2...-T2

Indexable drill holder



• Drilling depth: 2xdiameter





Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
TDR 2125-20T2-05	12.5	20	25	94	26	44	50	SPMG 05...
2130-20T2-05	13.0	20	25	94	26	44	50	DG/DK/DA
2135-20T2-05	13.5	20	25	96	28	46	50	D138
2140-20T2-05	14.0	20	25	96	28	46	50	
2145-20T2-05	14.5	20	25	99	30	49	50	
2150-20T2-05	15.0	20	25	99	30	49	50	
2155-25T2-06	15.5	25	32	108	32	52	56	SPMG 06...
2160-25T2-06	16.0	25	32	108	32	52	56	DG/DK/DA
2165-25T2-06	16.5	25	32	110	34	54	56	D138
2170-25T2-06	17.0	25	32	110	34	54	56	
2175-25T2-06	17.5	25	32	113	36	57	56	
2180-25T2-06	18.0	25	32	113	36	57	56	
2185-25T2-06	18.5	25	32	115	38	59	56	
2190-25T2-06	19.0	25	32	115	38	59	56	
2195-25T2-06	19.5	25	32	119	40	63	56	
2200-25T2-06	20.0	25	32	119	40	63	56	
2205-25T2-06	20.5	25	32	121	42	65	56	
2210-25T2-06	21.0	25	32	121	42	65	56	
2215-25T2-06	21.5	25	32	123	44	67	56	
2220-25T2-07	22.0	25	32	123	44	67	56	SPMG 07...
2225-25T2-07	22.5	25	45	127	46	71	56	DG/DK/DA
2225-32T2-07	22.5	32	45	131	46	71	60	D138
2230-25T2-07	23.0	25	45	127	46	71	56	
2230-32T2-07	23.0	32	45	131	46	71	60	
2235-25T2-07	23.5	25	45	130	48	74	56	
2235-32T2-07	23.5	32	45	134	48	74	60	
2240-25T2-07	24.0	25	45	130	48	74	56	
2240-32T2-07	24.0	32	45	134	48	74	60	
2245-25T2-07	24.5	25	45	133	50	77	56	
2245-32T2-07	24.5	32	45	137	50	77	60	
2250-25T2-07	25.0	25	45	133	50	77	56	
2250-32T2-07	25.0	32	45	137	50	77	60	
2255-25T2-07	25.5	25	45	135	52	79	56	
2255-32T2-07	25.5	32	45	139	52	79	60	
2260-25T2-07	26.0	25	45	135	52	79	56	

Cutting Condition D164

TDR 2...-T2

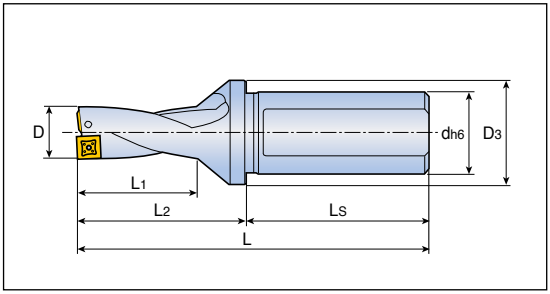
T-DRILL

Indexable drill holder



• Drilling depth: 2xdiameter





Designation		Dimension (mm)							Insert
		D	d	D3	L	L1	L2	Ls	
TDR	2260-32T2-07	26.0	32	45	139	52	79	60	SPMG 07... DG/DK/DA D138
	2265-25T2-07	26.5	25	45	137	54	81	56	
	2265-32T2-07	26.5	32	45	141	54	81	60	
	2270-25T2-07	27.0	25	45	137	54	81	56	
	2270-32T2-07	27.0	32	45	141	54	81	60	
	2275-25T2-07	27.5	25	45	140	56	84	56	
	2275-32T2-07	27.5	32	45	144	56	84	60	
	2280-25T2-09	28.0	25	45	140	56	84	56	SPMG 09... DG/DK/DA D138
	2280-32T2-09	28.0	32	45	144	56	84	60	
	2285-25T2-09	28.5	25	45	142	58	86	56	
	2285-32T2-09	28.5	32	45	146	58	86	60	
	2290-25T2-09	29.0	25	45	142	58	86	56	
	2290-32T2-09	29.0	32	45	146	58	86	60	
	2295-32T2-09	29.5	32	55	151	60	91	60	
	2295-40T2-09	29.5	40	55	161	60	91	70	
	2300-32T2-09	30.0	32	55	151	60	91	60	
	2300-40T2-09	30.0	40	55	161	60	91	70	
	2305-32T2-09	30.5	32	55	154	62	94	60	
	2305-40T2-09	30.5	40	55	164	62	94	70	
	2310-32T2-09	31.0	32	55	154	62	94	60	
	2310-40T2-09	31.0	40	55	164	62	94	70	
	2315-32T2-09	31.5	32	55	156	64	96	60	
	2315-40T2-09	31.5	40	55	166	64	96	70	
	2320-32T2-09	32.0	32	55	156	64	96	60	
	2320-40T2-09	32.0	40	55	166	64	96	70	
	2325-32T2-09	32.5	32	55	159	66	99	60	
	2325-40T2-09	32.5	40	55	169	66	99	70	
	2330-32T2-09	33.0	32	55	159	66	99	60	
	2330-40T2-09	33.0	40	55	169	66	99	70	
	2340-32T2-11	34.0	32	55	161	68	101	60	SPMG 11... DG/DA/DK D138
	2340-40T2-11	34.0	40	55	171	68	101	70	
	2350-32T2-11	35.0	32	55	164	70	104	60	
	2350-40T2-11	35.0	40	55	174	70	104	70	
	2360-32T2-11	36.0	32	55	167	72	107	60	
	2360-40T2-11	36.0	40	55	177	72	107	70	

Cutting Condition D164

TDR 2...-T2

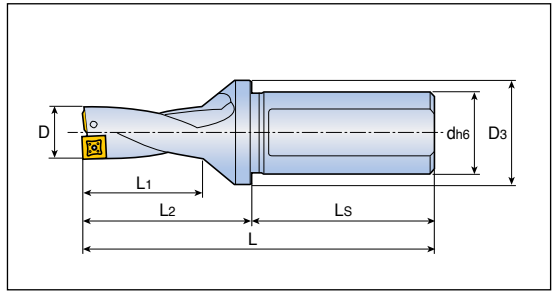
T-DRILL

Indexable drill holder



• Drilling depth: 2xdiameter





Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
TDR 2370-32T2-11	37.0	32	55	170	74	110	60	SPMG 11... DG/DK/DA D138
2370-40T2-11	37.0	40	55	180	74	110	70	
2380-32T2-11	38.0	32	55	173	76	113	60	
2380-40T2-11	38.0	40	55	183	76	113	70	
2390-32T2-11	39.0	32	55	175	78	115	60	
2390-40T2-11	39.0	40	55	185	78	115	70	
2400-32T2-11	40.0	32	60	178	80	118	60	
2400-40T2-11	40.0	40	60	188	80	118	70	
2410-40T2-11	41.0	40	60	191	82	121	70	
2420-40T2-14	42.0	40	60	193	84	123	70	SPMG 14... DG/DK/DA D138
2430-40T2-14	43.0	40	60	196	86	126	70	
2440-40T2-14	44.0	40	60	198	88	128	70	
2450-40T2-14	45.0	40	60	202	90	132	70	
2460-40T2-14	46.0	40	60	205	92	135	70	
2470-40T2-14	47.0	40	60	207	94	137	70	
2480-40T2-14	48.0	40	60	210	96	140	70	
2490-40T2-14	49.0	40	60	212	98	142	70	
2500-40T2-14	50.0	40	60	215	100	145	70	

Spare parts

Designation	Screw	Wrench	Plug	Set screw
TDR 2125 - 2150	TS 20043I/HG-P	TD 6P	SL 20 M	-
TDR 2155 - 2215	TS 22052I/HG	TD 7	SL 25 M	-
TDR 2220 - 2270	TS 25064I	TD 8	SL 25 M / SL 32 M	-
TDR 2275	TS 25064I	TD 8	-	SS M6x1x6
TDR 2280 - 2330	TS 35088I	TD 10	-	SS M6x1x6
TDR 2340 - 2390	TS 40093I	TD 15	-	SS M6x1x6
TDR 2400 - 2410	TS 40093I	TD 15	-	SS M8x1.25x8
TDR 2420 - 2500	SO 50090I	TD 20	-	SS M8x1.25x8

Cutting Condition D164

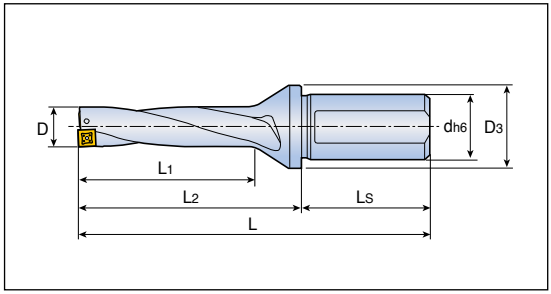
TaeguTec

TDR 3...-T2

Indexable drill holder



• Drilling depth: 3xdiameter



Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
TDR 3125-20T2-05	12.5	20	25	107	39	57	50	SPMG 05... DG/DK/DA D138
3130-20T2-05	13.0	20	25	107	39	57	50	
3135-20T2-05	13.5	20	25	110	42	60	50	
3140-20T2-05	14.0	20	25	110	42	60	50	
3145-20T2-05	14.5	20	25	114	45	64	50	
3150-20T2-05	15.0	20	25	114	45	64	50	
3155-25T2-06	15.5	25	32	124	48	68	56	SPMG 06... DG/DK/DA D138
3160-25T2-06	16.0	25	32	124	48	68	56	
3165-25T2-06	16.5	25	32	127	51	71	56	
3170-25T2-06	17.0	25	32	127	51	71	56	
3175-25T2-06	17.5	25	32	131	54	75	56	
3180-25T2-06	18.0	25	32	131	54	75	56	
3185-25T2-06	18.5	25	32	134	57	78	56	
3190-25T2-06	19.0	25	32	134	57	78	56	
3195-25T2-06	19.5	25	32	139	60	83	56	
3200-25T2-06 *	20.0	25	32	139	60	83	56	
3205-25T2-06	20.5	25	32	142	63	86	56	
3209-25T2-06 *	20.9	25	32	142	63	86	56	
3210-25T2-06	21.0	25	32	142	63	86	56	
3215-25T2-06	21.5	25	32	145	66	89	56	
3220-25T2-07	22.0	25	32	145	66	89	56	SPMG 07... DG/DK/DA D138
3225-25T2-07	22.5	25	45	150	69	94	56	
3225-32T2-07	22.5	32	45	154	69	94	60	
3230-25T2-07	23.0	25	45	150	69	94	56	
3230-32T2-07	23.0	32	45	154	69	94	60	
3235-25T2-07	23.5	25	45	154	72	98	56	
3235-32T2-07	23.5	32	45	158	72	98	60	
3239-25T2-07 *	23.9	25	32	154	72	98	56	
3239-32T2-07 *	23.9	32	45	158	72	98	60	
3240-25T2-07	24.0	25	45	154	72	98	56	
3240-32T2-07	24.0	32	45	158	72	98	60	
3245-25T2-07	24.5	25	45	158	75	102	56	
3245-32T2-07	24.5	32	45	162	75	102	60	
3250-25T2-07	25.0	25	45	158	75	102	56	
3250-32T2-07	25.0	32	45	162	75	102	60	

Cutting Condition D164

• '*' Marked items are for pre-thread hole making

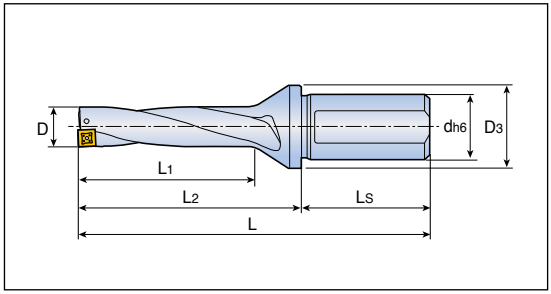
TDR 3...-T2

Indexable drill holder



• Drilling depth: 3xdiameter





Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	LS	
TDR 3255-25T2-07	25.5	25	45	161	78	105	56	SPMG 07... DG/DK/DA D138
3255-32T2-07	25.5	32	45	165	78	105	60	
3260-25T2-07	26.0	25	45	161	78	105	56	
3260-32T2-07	26.0	32	45	165	78	105	60	
3264-25T2-07 *	26.4	25	45	164	81	108	56	
3264-32T2-07 *	26.4	32	45	168	81	108	60	
3265-25T2-07	26.5	25	45	164	81	108	56	
3265-32T2-07	26.5	32	45	168	81	108	60	
3270-25T2-07	27.0	25	45	164	81	108	56	
3270-32T2-07	27.0	32	45	168	81	108	60	
3275-25T2-07	27.5	25	45	168	84	112	56	
3275-32T2-07	27.5	32	45	172	84	112	60	
3280-25T2-09	28.0	25	45	168	84	112	56	SPMG 09... DG/DK/DA D138
3280-32T2-09	28.0	32	45	172	84	112	60	
3285-25T2-09	28.5	25	45	171	87	115	56	
3285-32T2-09	28.5	32	45	171	87	115	56	
3290-25T2-09	29.0	25	45	171	87	115	56	
3290-32T2-09	29.0	32	45	175	87	115	60	
3294-32T2-09 *	29.4	32	55	181	90	121	60	
3294-40T2-09 *	29.4	40	55	191	90	121	70	
3295-32T2-09	29.5	32	55	181	90	121	60	
3295-40T2-09	29.5	40	55	191	90	121	70	
3300-32T2-09	30.0	32	55	181	90	121	60	
3300-40T2-09	30.0	40	55	191	90	121	70	
3305-32T2-09	30.5	32	55	185	93	125	60	
3305-40T2-09	30.5	40	55	195	93	125	70	
3310-32T2-09	31.0	32	55	185	93	125	60	
3310-40T2-09	31.0	40	55	195	93	125	70	
3315-32T2-09	31.5	32	55	188	96	128	60	
3315-40T2-09	31.5	40	55	198	96	128	70	
3320-32T2-09	32.0	32	55	188	96	128	60	
3320-40T2-09	32.0	40	55	198	96	128	70	

Cutting Condition D164

• '*' Marked items are for pre-thread hole making

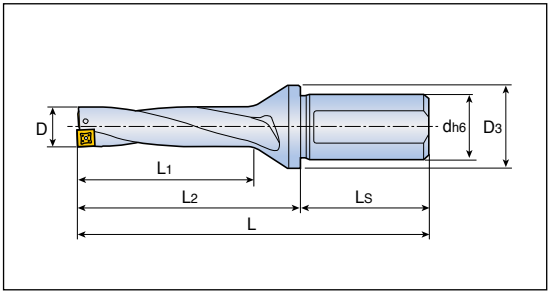
TDR 3...-T2

Indexable drill holder



• Drilling depth: 3xdiameter





Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	LS	
TDR 3320-32T2-09	32.0	32	55	188	96	128	60	SPMG 09... DG/DK/DA D138
3320-40T2-09	32.0	40	55	198	96	128	70	
3325-32T2-09	32.5	32	55	192	99	132	60	
3325-40T2-09	32.5	40	55	202	99	132	70	
3330-32T2-09	33.0	32	55	192	99	132	60	
3330-40T2-09	33.0	40	55	202	99	132	70	
3340-32T2-11	34.0	32	55	195	102	135	60	SPMG 11... DG/DK/DA D138
3340-40T2-11	34.0	40	55	205	102	135	70	
3350-32T2-11	35.0	32	55	199	105	139	60	
3350-40T2-11	35.0	40	55	209	105	139	70	
3360-32T2-11	36.0	32	55	203	108	143	60	
3360-40T2-11	36.0	40	55	213	108	143	70	
3370-32T2-11	37.0	32	55	207	111	147	60	
3370-40T2-11	37.0	40	55	217	111	147	70	
3375-32T2-11 *	37.5	32	55	211	114	151	60	
3375-40T2-11 *	37.5	40	55	221	114	151	70	
3380-32T2-11	38.0	32	55	211	114	151	60	
3380-40T2-11	38.0	40	55	221	114	151	70	
3390-32T2-11	39.0	32	55	214	117	154	60	
3390-40T2-11	39.0	40	55	224	117	154	70	
3400-32T2-11	40.0	32	60	218	120	158	60	
3400-40T2-11	40.0	40	60	228	120	158	70	
3405-40T2-11 *	40.5	40	60	232	123	162	70	
3410-40T2-11	41.0	40	60	232	123	162	70	

Cutting Condition D164

• '*' Marked items are for pre-thread hole making

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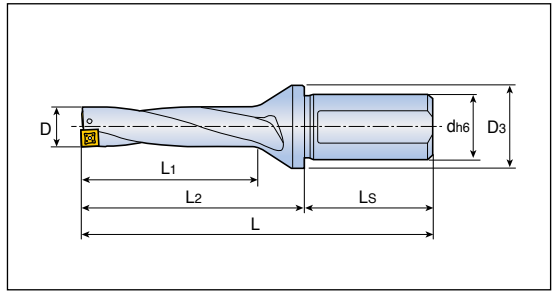
TDR 3...-T2

Indexable drill holder



• Drilling depth: 3xdiameter





Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	LS	
TDR 3420-40T2-14	42.0	40	60	235	126	165	70	SPMG 14... DG/DK/DA D138
3430-40T2-14	43.0	40	60	239	129	169	70	
3440-40T2-14	44.0	40	60	242	132	172	70	
3450-40T2-14	45.0	40	60	247	135	177	70	
3460-40T2-14	46.0	40	60	251	138	181	70	
3470-40T2-14	47.0	40	60	254	141	184	70	
3480-40T2-14	48.0	40	60	258	144	188	70	
3490-40T2-14	49.0	40	60	261	147	191	70	
3500-40T2-14	50.0	40	60	265	150	195	70	

• '*' Marked items are for pre-thread hole making

Spare parts

Designation	Screw	Wrench	Plug	Set screw
TDR 3125 - 3150	TS 20043I/HG-P	TD 6P	SL 20 M	-
TDR 3155 - 3215	TS 22052I/HG	TD 7	SL 25 M	-
TDR 3220 - 3270	TS 25064I	TD 8	SL 25 M / SL 32 M	-
TDR 3275	TS 25064I	TD 8	-	SS M6x1x6
TDR 3280 - 3330	TS 35088I	TD 10	-	SS M6x1x6
TDR 3340 - 3390	TS 40093I	TD 15	-	SS M6x1x6
TDR 3400 - 3410	TS 40093I	TD 15	-	SS M8x1.25x8
TDR 3420 - 3500	SO 50090I	TD 20	-	SS M8x1.25x8

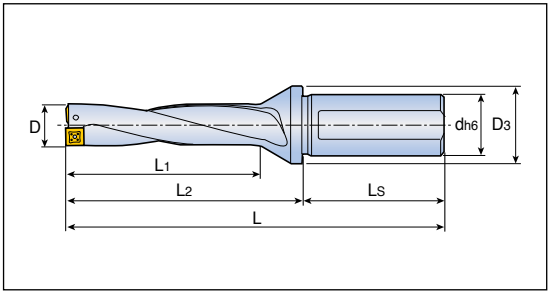
Cutting Condition D164

TDR 4...-T2

Indexable drill holder



• Drilling depth: 4xdiameter



Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	LS	
TDR 4125-20T2-05	12.5	20	25	120	52	70	50	SPMG 05... DG/DK/DA D138
4130-20T2-05	13.0	20	25	120	52	70	50	
4135-20T2-05	13.5	20	25	124	56	74	50	
4140-20T2-05	14.0	20	25	124	56	74	50	
4145-20T2-05	14.5	20	25	129	60	79	50	
4150-20T2-05	15.0	20	25	129	60	79	50	
4155-25T2-06	15.5	25	32	140	64	84	56	SPMG 06... DG/DK/DA D138
4160-25T2-06	16.0	25	32	140	64	84	56	
4165-25T2-06	16.5	25	32	144	68	88	56	
4170-25T2-06	17.0	25	32	144	68	88	56	
4175-25T2-06	17.5	25	32	149	72	93	56	
4180-25T2-06	18.0	25	32	149	72	93	56	
4185-25T2-06	18.5	25	32	153	76	97	56	
4190-25T2-06	19.0	25	32	153	76	97	56	
4195-25T2-06	19.5	25	32	159	80	103	56	
4200-25T2-06	20.0	25	32	159	80	103	56	
4205-25T2-06	20.5	25	32	163	84	107	56	
4210-25T2-06	21.0	25	32	163	84	107	56	
4215-25T2-06	21.5	25	32	167	88	111	56	
4220-25T2-07	22.0	25	32	167	88	111	56	SPMG 07... DG/DK/DA D138
4225-25T2-07	22.5	25	45	173	92	117	56	
4225-32T2-07	22.5	32	45	177	92	117	60	
4230-25T2-07	23.0	25	45	173	92	117	56	
4230-32T2-07	23.0	32	45	177	92	117	60	
4235-25T2-07	23.5	25	45	178	96	122	56	
4235-32T2-07	23.5	32	45	182	96	122	60	
4240-25T2-07	24.0	25	45	178	96	122	56	
4240-32T2-07	24.0	32	45	182	96	122	60	
4245-25T2-07	24.5	25	45	183	100	127	56	
4245-32T2-07	24.5	32	45	187	100	127	60	
4250-25T2-07	25.0	25	45	183	100	127	56	
4250-32T2-07	25.0	32	45	187	100	127	60	
4255-25T2-07	25.5	25	45	187	104	131	56	
4255-32T2-07	25.5	32	45	191	104	131	60	
4260-25T2-07	26.0	25	45	187	104	131	56	

Cutting Condition D164

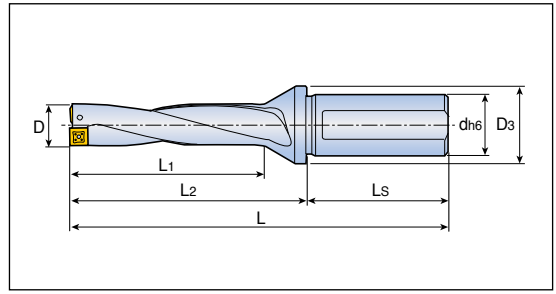
TDR 4...-T2

Indexable drill holder



• Drilling depth: 4xdiameter





Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
TDR 4260-32T2-07	26.0	32	45	191	104	131	60	SPMG 07... DG/DK/DA D138
4265-25T2-07	26.5	25	45	191	108	135	56	
4265-32T2-07	26.5	32	45	195	108	135	60	
4270-25T2-07	27.0	25	45	191	108	135	56	
4270-32T2-07	27.0	32	45	195	108	135	60	
4275-25T2-07	27.5	25	45	196	112	140	56	
4275-32T2-07	27.5	32	45	200	112	140	60	
4280-25T2-09	28.0	25	45	196	112	140	56	SPMG 09... DG/DK/DA D138
4280-32T2-09	28.0	32	45	200	112	140	60	
4285-25T2-09	28.5	25	45	200	116	144	56	
4285-32T2-09	28.5	32	45	204	116	144	60	
4290-25T2-09	29.0	25	45	200	116	144	56	
4290-32T2-09	29.0	32	45	204	116	144	60	
4295-32T2-09	29.5	32	55	211	120	151	60	
4295-40T2-09	29.5	40	55	221	120	151	70	
4300-32T2-09	30.0	32	55	211	120	151	60	
4300-40T2-09	30.0	40	55	221	120	151	70	
4305-32T2-09	30.5	32	55	216	124	156	60	
4305-40T2-09	30.5	40	55	226	124	156	70	
4310-32T2-09	31.0	32	55	216	124	156	60	
4310-40T2-09	31.0	40	55	226	124	156	70	
4315-32T2-09	31.5	32	55	220	128	160	60	
4315-40T2-09	31.5	40	55	230	128	160	70	
4320-32T2-09	32.0	32	55	220	128	160	60	
4320-40T2-09	32.0	40	55	230	128	160	70	
4325-32T2-09	32.5	32	55	225	132	165	60	
4325-40T2-09	32.5	40	55	235	132	165	70	
4330-32T2-09	33.0	32	55	225	132	165	60	
4330-40T2-09	33.0	40	55	235	132	165	70	
4340-32T2-11	34.0	32	55	229	136	169	60	SPMG 11... DG/DK/DA D138
4340-40T2-11	34.0	40	55	239	136	169	70	
4350-32T2-11	35.0	32	55	234	140	174	60	
4350-40T2-11	35.0	40	55	244	140	174	70	
4360-32T2-11	36.0	32	55	239	144	179	60	
4360-40T2-11	36.0	40	55	249	144	179	70	

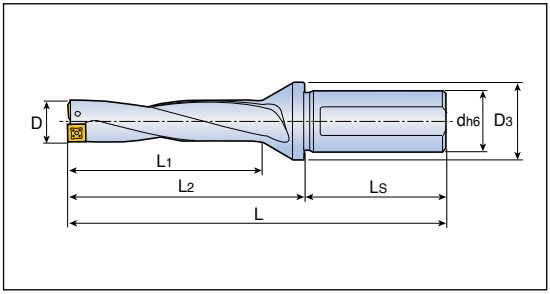
Cutting Condition D164

TDR 4...-T2

T-DRILL

Indexable drill holder





• Drilling depth: 4xdiameter



Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	LS	
TDR 4370-32T2-11	37.0	32	55	244	148	184	60	SPMG 11... DG/DK/DA D138
4370-40T2-11	37.0	40	55	254	148	184	70	
4380-32T2-11	38.0	32	55	249	152	189	60	
4380-40T2-11	38.0	40	55	259	152	189	70	
4390-32T2-11	39.0	32	55	253	156	193	60	
4390-40T2-11	39.0	40	55	263	156	193	70	
4400-32T2-11	40.0	32	60	258	160	198	60	
4400-40T2-11	40.0	40	60	268	160	198	70	
4410-40T2-11	41.0	40	60	273	164	203	70	
4420-40T2-14	42.0	40	60	277	168	207	70	SPMG 14... DG/DK/DA D138
4430-40T2-14	43.0	40	60	282	172	212	70	
4440-40T2-14	44.0	40	60	286	176	216	70	
4450-40T2-14	45.0	40	60	292	180	222	70	
4460-40T2-14	46.0	40	60	297	184	227	70	
4470-40T2-14	47.0	40	60	301	188	231	70	
4480-40T2-14	48.0	40	60	306	192	236	70	
4490-40T2-14	49.0	40	60	310	196	240	70	
4500-40T2-14	50.0	40	60	315	200	245	70	

Spare parts

Designation	Screw	Wrench	Plug	Set screw
TDR 4125 - 4150	TS 20043I/HG-P	TD 6P	SL 20 M	-
TDR 4155 - 4215	TS 22052I/HG	TD 7	SL 25 M	-
TDR 4220 - 4270	TS 25064I	TD 8	SL 25 M / SL 32 M	-
TDR 4275	TS 25064I	TD 8	-	SS M6x1x6
TDR 4280 - 4330	TS 35088I	TD 10	-	SS M6x1x6
TDR 4340 - 4390	TS 40093I	TD 15	-	SS M6x1x6
TDR 4400 - 4410	TS 40093I	TD 15	-	SS M8x1.25x8
TDR 4420 - 4500	SO 50090I	TD 20	-	SS M8x1.25x8

Cutting Condition D164

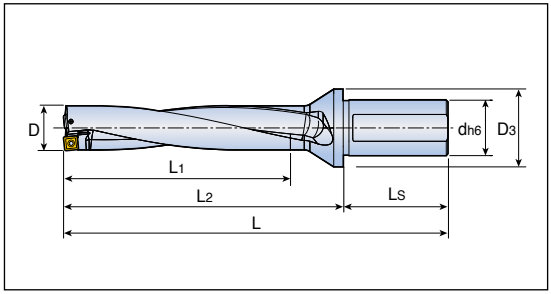
TDR 5...-T2

Indexable drill holder



• Drilling depth: 5xdiameter





Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
TDR 5125-20T2-05	12.5	20	25	133	65	83	50	SPMG 05... DG/DK/DA D138
5130-20T2-05	13.0	20	25	133	65	83	50	
5135-20T2-05	13.5	20	25	138	70	88	50	
5140-20T2-05	14.0	20	25	138	70	88	50	
5145-20T2-05	14.5	20	25	144	75	94	50	
5150-20T2-05	15.0	20	25	144	75	94	50	
5155-25T2-06	15.5	25	32	156	80	100	56	SPMG 06... DG/DK/DA D138
5160-25T2-06	16.0	25	32	156	80	100	56	
5165-25T2-06	16.5	25	32	161	85	105	56	
5170-25T2-06	17.0	25	32	161	85	105	56	
5175-25T2-06	17.5	25	32	167	90	111	56	
5180-25T2-06	18.0	25	32	167	90	111	56	
5185-25T2-06	18.5	25	32	172	95	116	56	
5190-25T2-06	19.0	25	32	172	95	116	56	
5195-25T2-06	19.5	25	32	179	100	123	56	
5200-25T2-06	20.0	25	32	179	100	123	56	
5205-25T2-06	20.5	25	32	184	105	128	56	
5210-25T2-06	21.0	25	32	184	105	128	56	
5215-25T2-06	21.5	25	32	189	110	133	56	
5220-25T2-07	22.0	25	32	189	110	133	56	SPMG 07... DG/DK/DA D138
5225-32T2-07	22.5	32	45	200	115	140	60	
5230-32T2-07	23.0	32	45	200	115	140	60	
5235-32T2-07	23.5	32	45	206	120	146	60	
5240-32T2-07	24.0	32	45	206	120	146	60	
5245-32T2-07	24.5	32	45	212	125	152	60	
5250-32T2-07	25.0	32	45	212	125	152	60	
5255-32T2-07	25.5	32	45	217	130	157	60	
5260-32T2-07	26.0	32	45	217	130	157	60	
5265-32T2-07	26.5	32	45	222	135	162	60	
5270-32T2-07	27.0	32	45	222	135	162	60	
5275-32T2-07	27.5	32	45	228	140	168	60	

Cutting Condition D166

TDR 5...-T2

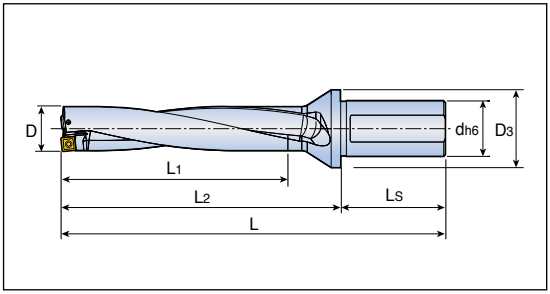
T-DRILL

Indexable drill holder



• Drilling depth: 5xdiameter





Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	LS	
TDR 5280-32T2-09	28.0	32	45	228	140	168	60	SPMG 09... DG/DK/DA D138
5285-32T2-09	28.5	32	45	233	145	173	60	
5290-32T2-09	29.0	32	45	233	145	173	60	
5295-32T2-09	29.5	32	55	241	150	181	60	
5300-32T2-09	30.0	32	55	241	150	181	60	
5300-40T2-09	30.0	40	55	251	150	181	70	
5310-32T2-09	31.0	32	55	247	155	187	60	
5310-40T2-09	31.0	40	55	257	155	187	70	
5320-32T2-09	32.0	32	55	252	160	192	60	
5320-40T2-09	32.0	40	55	262	160	192	70	
5330-32T2-09	33.0	32	55	258	165	198	60	
5330-40T2-09	33.0	40	55	268	165	198	70	
5340-32T2-11	34.0	32	55	263	170	203	60	SPMG 11... DG/DK/DA D138
5340-40T2-11	34.0	40	55	273	170	203	70	
5350-32T2-11	35.0	32	55	269	175	209	60	
5350-40T2-11	35.0	40	55	279	175	209	70	
5360-32T2-11	36.0	32	55	275	180	215	60	
5360-40T2-11	36.0	40	55	285	180	215	70	
5370-32T2-11	37.0	32	55	281	185	221	60	
5370-40T2-11	37.0	40	55	291	185	221	70	
5380-32T2-11	38.0	32	55	287	190	227	60	
5380-40T2-11	38.0	40	55	297	190	227	70	
5390-32T2-11	39.0	32	55	292	195	232	60	
5390-40T2-11	39.0	40	55	302	195	232	70	
5400-32T2-11	40.0	32	60	298	200	238	60	
5400-40T2-11	40.0	40	60	308	200	238	70	
5410-40T2-11	41.0	40	60	314	205	244	70	

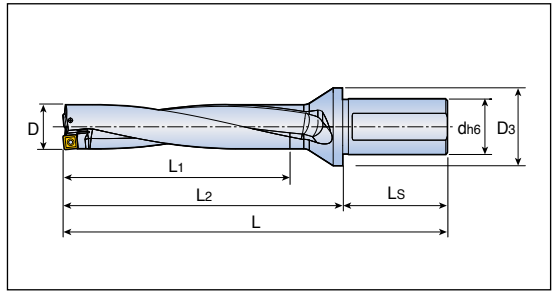
Cutting Condition D166

TDR 5...-T2

T-DRILL

Indexable drill holder





• Drilling depth: 5xdiameter

Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	LS	
TDR 5420-40T2-14	42.0	40	60	319	210	249	70	SPMG 14... DG/DK/DA D138
5430-40T2-14	43.0	40	60	325	215	255	70	
5440-40T2-14	44.0	40	60	330	220	260	70	
5450-40T2-14	45.0	40	60	337	225	267	70	
5460-40T2-14	46.0	40	60	343	230	273	70	
5470-40T2-14	47.0	40	60	348	235	278	70	
5480-40T2-14	48.0	40	60	354	240	284	70	
5490-40T2-14	49.0	40	60	359	245	289	70	
5500-40T2-14	50.0	40	60	365	250	295	70	

Spare parts

Designation	Screw	Wrench	Plug	Set screw
TDR 5125 - 5150	TS 20043I/HG-P	TD 6P	SL 20 M	-
TDR 5155 - 5215	TS 22052I/HG	TD 7	SL 25 M	-
TDR 5220 - 5270	TS 25064I	TD 8	SL 25 M / SL 32 M	-
TDR 5275	TS 25064I	TD 8	-	SS M6x1x6
TDR 5280 - 5330	TS 35088I	TD 10	-	SS M6x1x6
TDR 5340 - 5390	TS 40093I	TD 15	-	SS M6x1x6
TDR 5400 - 5410	TS 40093I	TD 15	-	SS M8x1.25x8
TDR 5420 - 5500	SO 50090I	TD 20	-	SS M8x1.25x8

Cutting Condition D166

TaeguTec

TDR 25...CA-T

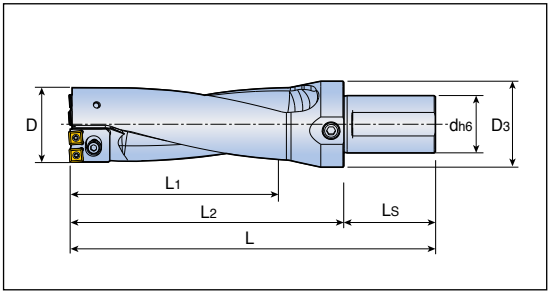
T-DRILL

Indexable cartridge drill holder



• Drilling depth: 2.5xdiameter





Designation		Dimension (mm)							Setting plate	Insert
		D	d	D3	L	L1	L2	Ls		
TDR	2551-53-50T2-07CA-T	51	50	75	250	133	170	80	-	SPMG 07...
		52	50	75	250	133	170	80	TDP-0701	DG/DK/DA
		53	50	75	250	133	170	80	TDP-0702	D138
	2554-56-50T2-07CA-T	54	50	75	260	140	180	80	-	SPMG 07...
		55	50	75	260	140	180	80	TDP-0701	DG/DK/DA
		56	50	75	260	140	180	80	TDP-0702	D138
	2557-62-50T2-09CA-T	57	50	75	281	155	201	80	-	SPMG 09...
		58	50	75	281	155	201	80	TDP-0901	DG/DK/DA
		59	50	75	281	155	201	80	TDP-0902	D138
		60	50	75	281	155	201	80	TDP-0903	
		61	50	75	281	155	201	80	TDP-0904	
		62	50	75	281	155	201	80	TDP-0905	
	2563-66-50T2-09CA-T	63	50	75	295	165	215	80	-	SPMG 09...
		64	50	75	295	165	215	80	TDP-0901	DG/DK/DA
		65	50	75	295	165	215	80	TDP-0902	D138
		66	50	75	295	165	215	80	TDP-0903	
	2567-73-50T2-11CA-T	67	50	75	320	183	240	80	-	SPMG 11...
		68	50	75	320	183	240	80	TDP-1101	DG/DK/DA
		69	50	75	320	183	240	80	TDP-1102	D138
		70	50	75	320	183	240	80	TDP-1103	
		71	50	75	320	183	240	80	TDP-1104	
		72	50	75	320	183	240	80	TDP-1105	
		73	50	75	320	183	240	80	TDP-1106	

Cutting Condition D164

TaeguTec Member IMC Group

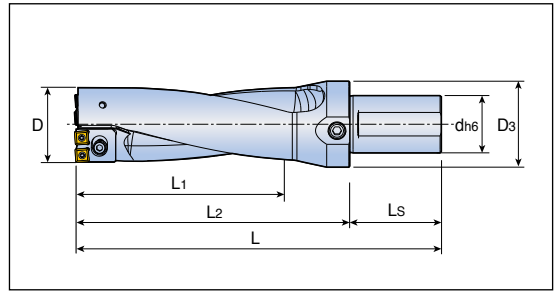
TDR 25...CA-T

Indexable cartridge drill holder



• Drilling depth: 2.5xdiameter





Designation	Dimension (mm)							Setting plate	Insert
	D	d	D3	L	L1	L2	LS		
TDR 2574-80-50T2-12CA-T	74	50	75	330	200	250	80	-	SPMG 12...DG
	75	50	75	330	200	250	80	TDP-1101	D138
	76	50	75	330	200	250	80	TDP-1102	
	77	50	75	330	200	250	80	TDP-1103	
	78	50	75	330	200	250	80	TDP-1104	
	79	50	75	330	200	250	80	TDP-1105	
	80	50	75	330	200	250	80	TDP-1106	

Spare parts

Designation	Screw	Cartridge for peripheral	Cartridge fo center
			
TDR 2551	TS 25064I	TDR 07CA-P1-T	TDR 07CA-C1-T
TDR 2554	TS 25064I	TDR 07CA-P2-T	TDR 07CA-C2-T
TDR 2557	TS 35088I	TDR 09CA-P1-T	TDR 09CA-C1-T
TDR 2563	TS 35088I	TDR 09CA-P2-T	TDR 09CA-C2-T
TDR 2567	TS 40093I	TDR 11CA-P1-T	TDR 11CA-C1-T
TDR 2574	TS 40093I	TDR 12CA-P2-T	TDR 12CA-C2-T

Spare parts for cartridges

Cartridge	Cartridge clamping screw	Washer	Setting plate screw
TDR 07CA-P1-T	SH M4x0.7x16	MW 4.3x8	TS 20043I/HG-P
TDR 07CA-C1-T	SH M4x0.7x16	MW 4.3x8	-
TDR 07CA-P2-T	SH M4x0.7x16	MW 4.3x8	TS 20043I/HG-P
TDR 07CA-C2-T	SH M4x0.7x16	MW 4.3x8	-
TDR 09CA-P1-T	SH M5x0.8x16	MW 5.5x10	SO 30055I
TDR 09CA-C1-T	SH M5x0.8x16	MW 5.5x10	-
TDR 09CA-P2-T	SH M5x0.8x16	MW 5.5x10	SO 30055I
TDR 09CA-C2-T	SH M5x0.8x16	MW 5.5x10	-
TDR 11CA-P1-T	SH M6x1.0x20	MW 6.4x12	SO 30055I
TDR 11CA-C1-T	SH M6x1.0x20	MW 6.4x12	-
TDR 12CA-P2-T	SH M6x1.0x20	MW 6.4x12	SO 30055I
TDR 12CA-C2-T	SH M6x1.0x20	MW 6.4x12	-

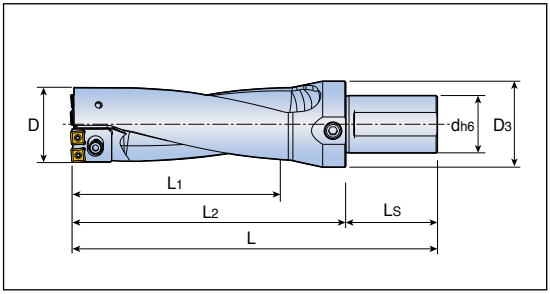
Cutting Condition D164

TDR 35...CA-T

T-DRILL

Indexable cartridge drill holder





• Drilling depth: 3.5xdiameter



Designation	Dimension (mm)							Setting plate	Insert
	D	d	D3	L	L1	L2	LS		
TDR 3551-53-50T2-07CA-T	51	50	75	303	186	223	80	-	SPMG 07...
	52	50	75	303	186	223	80	TDP-0701	DG/DK/DA
	53	50	75	303	186	223	80	TDP-0702	D138
3554-56-50T2-07CA-T	54	50	75	316	196	236	80	-	SPMG 07...
	55	50	75	316	196	236	80	TDP-0701	DG/DK/DA
	56	50	75	316	196	236	80	TDP-0702	D138
3557-62-50T2-09CA-T	57	50	75	343	217	263	80	-	SPMG 09...
	58	50	75	343	217	263	80	TDP-0901	DG/DK/DA
	59	50	75	343	217	263	80	TDP-0902	D138
	60	50	75	343	217	263	80	TDP-0903	
	61	50	75	343	217	263	80	TDP-0904	
	62	50	75	343	217	263	80	TDP-0905	
3563-66-50T2-09CA-T	63	50	75	361	231	281	80	-	SPMG 09...
	64	50	75	361	231	281	80	TDP-0901	DG/DK/DA
	65	50	75	361	231	281	80	TDP-0902	D138
	66	50	75	361	231	281	80	TDP-0903	
3567-73-50T2-11CA-T	67	50	75	393	256	313	80	-	SPMG 11...
	68	50	75	393	256	313	80	TDP-1101	DG/DK/DA
	69	50	75	393	256	313	80	TDP-1102	D138
	70	50	75	393	256	313	80	TDP-1103	
	71	50	75	393	256	313	80	TDP-1104	
	72	50	75	393	256	313	80	TDP-1105	
	73	50	75	393	256	313	80	TDP-1106	

Cutting Condition D164

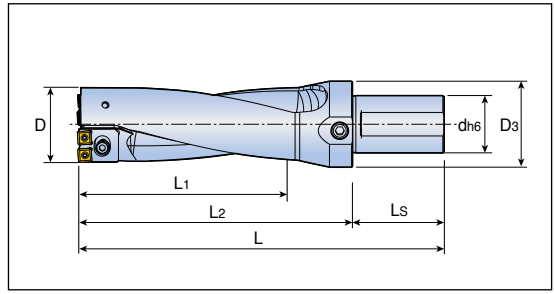
TDR 35...CA-T

Indexable cartridge drill holder



• Drilling depth: 3.5xdiameter





Designation	Dimension (mm)							Setting plate	Insert
	D	d	D3	L	L1	L2	LS		
TDR 3574-80-50T2-12CA-T	74	50	75	410	280	330	80	-	SPMG 12...DG
	75	50	75	410	280	330	80	TDP-1101	D138
	76	50	75	410	280	330	80	TDP-1102	
	77	50	75	410	280	330	80	TDP-1103	
	78	50	75	410	280	330	80	TDP-1104	
	79	50	75	410	280	330	80	TDP-1105	
	80	50	75	410	280	330	80	TDP-1106	

Spare parts

Designation	Screw	Cartridge for peripheral	Cartridge fo center
			
TDR 3551	TS 25064I	TDR 07CA-P1-T	TDR 07CA-C1-T
TDR 3554	TS 25064I	TDR 07CA-P2-T	TDR 07CA-C2-T
TDR 3557	TS 35088I	TDR 09CA-P1-T	TDR 09CA-C1-T
TDR 3563	TS 35088I	TDR 09CA-P2-T	TDR 09CA-C2-T
TDR 3567	TS 40093I	TDR 11CA-P1-T	TDR 11CA-C1-T
TDR 3574	TS 40093I	TDR 12CA-P2-T	TDR 12CA-C2-T

Spare parts for cartridges

Cartridge	Cartridge clamping screw	Washer	Setting plate screw
TDR 07CA-P1-T	SH M4x0.7x16	MW 4.3x8	TS 20043I/HG-P
TDR 07CA-C1-T	SH M4x0.7x16	MW 4.3x8	-
TDR 07CA-P2-T	SH M4x0.7x16	MW 4.3x8	TS 20043I/HG-P
TDR 07CA-C2-T	SH M4x0.7x16	MW 4.3x8	-
TDR 09CA-P1-T	SH M5x0.8x16	MW 5.5x10	SO 30055I
TDR 09CA-C1-T	SH M5x0.8x16	MW 5.5x10	-
TDR 09CA-P2-T	SH M5x0.8x16	MW 5.5x10	SO 30055I
TDR 09CA-C2-T	SH M5x0.8x16	MW 5.5x10	-
TDR 11CA-P1-T	SH M6x1.0x20	MW 6.4x12	SO 30055I
TDR 11CA-C1-T	SH M6x1.0x20	MW 6.4x12	-
TDR 12CA-P2-T	SH M6x1.0x20	MW 6.4x12	SO 30055I
TDR 12CA-C2-T	SH M6x1.0x20	MW 6.4x12	-

Cutting Condition D164

TDR 3...-C4

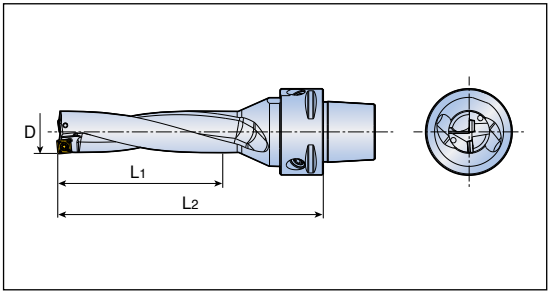
T-DRILL

Indexable drill with C-adapter system (Assembly product)



• Drilling depth: 3xdiameter





Designation	Dimension (mm)			T-DRILL	Adaptation
	D	L1	L2		
TDR 3160-C4-06	16	48	88	TDR 3160-20DT-06	C4-TDR-20DT
3170-C4-06	17	51	91	TDR 3170-20DT-06	
3180-C4-06	18	54	95	TDR 3180-20DT-06	
3190-C4-06	19	57	98	TDR 3190-20DT-06	
3200-C4-06	20	60	103	TDR 3200-20DT-06	

TDR 4...-C4

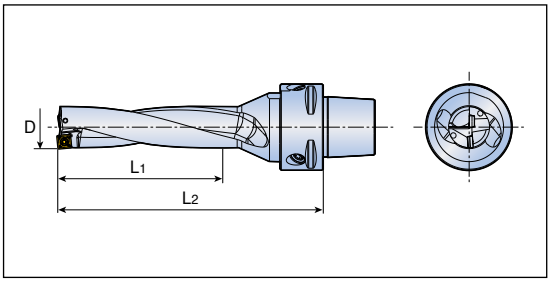
T-DRILL

Indexable drill with C-adapter system (Assembly product)



• Drilling depth: 4xdiameter





Designation	Dimension (mm)			T-DRILL	Adaptation
	D	L1	L2		
TDR 4160-C4-06	16	64	104	TDR 4160-20DT-06	C4-TDR-20DT
4170-C4-06	17	68	108	TDR 4170-20DT-06	
4180-C4-06	18	72	113	TDR 4180-20DT-06	
4190-C4-06	19	76	117	TDR 4190-20DT-06	
4200-C4-06	20	80	123	TDR 4200-20DT-06	

TDR 3...-BBS50

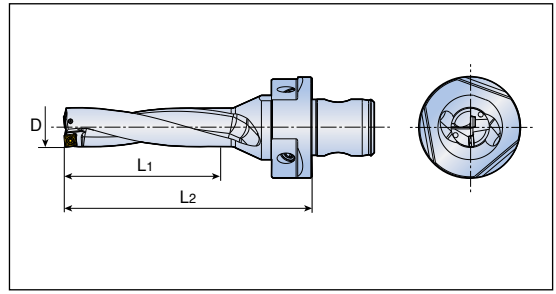
T-DRILL

Indexable drill with BBS system (Assembly product)



• Drilling depth: 3xdiameter





Designation	Dimension (mm)			T-DRILL	Adaptation
	D	L1	L2		
TDR 3160-BBS50-06	16	48	88	TDR 3160-20DT-06	BBS50-TDR-20DT
3170-BBS50-06	17	51	91	TDR 3170-20DT-06	
3180-BBS50-06	18	54	95	TDR 3180-20DT-06	
3190-BBS50-06	19	57	98	TDR 3190-20DT-06	
3200-BBS50-06	20	60	103	TDR 3200-20DT-06	

TDR 4...-BBS50

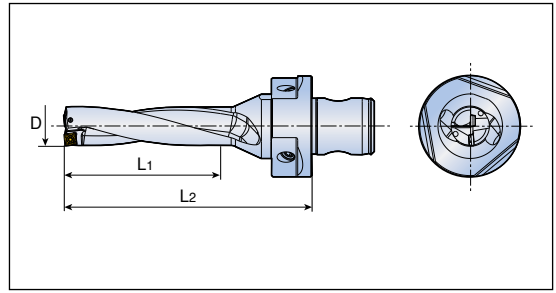
T-DRILL

Indexable drill with BBS system (Assembly product)



• Drilling depth: 4xdiameter





Designation	Dimension (mm)			T-DRILL	Adaptation
	D	L1	L2		
TDR 4160-BBS50-06	16	64	104	TDR 4160-20DT-06	BBS50-TDR-20DT
4170-BBS50-06	17	68	108	TDR 4170-20DT-06	
4180-BBS50-06	18	72	113	TDR 4180-20DT-06	
4190-BBS50-06	19	76	117	TDR 4190-20DT-06	
4200-BBS50-06	20	80	123	TDR 4200-20DT-06	

TDR 3...-20DT

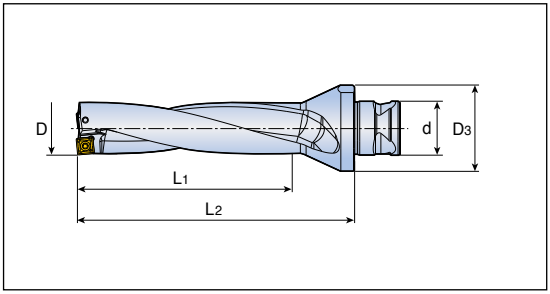
T-DRILL

Indexable drill holder for modular type



• Drilling depth: 3xdiameter





Designation	Dimension (mm)					Screw	Wrench	Insert
	D	d	D3	L2	L1			
TDR 3160-20DT-06	16	20	32	68	48	TS 22052I/HG (M2.2 X 5.2mm)	TD 7	SPMG 06... DG/DK/DA D138
3170-20DT-06	17	20	32	71	51			
3180-20DT-06	18	20	32	75	54			
3190-20DT-06	19	20	32	78	57			
3200-20DT-06	20	20	32	83	60			

TDR 4...-20DT

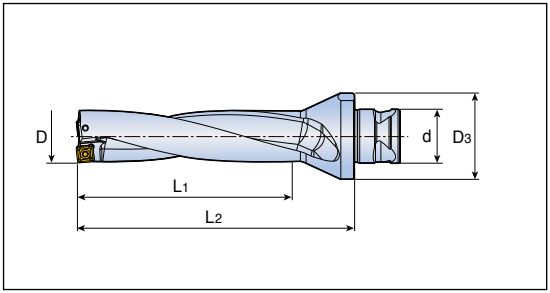
T-DRILL

Indexable drill holder for modular type



• Drilling depth: 4xdiameter





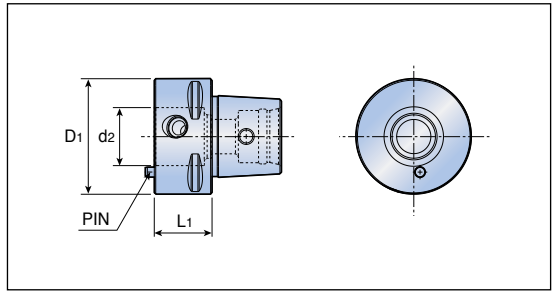
Designation	Dimension (mm)					Screw	Wrench	Insert
	D	d	D3	L2	L1			
TDR 4160-20DT-06	16	20	32	84	64	TS 22052I/HG (M2.2 X 5.2mm)	TD 7	SPMG 06... DG/DK/DA D138
4170-20DT-06	17	20	32	88	68			
4180-20DT-06	18	20	32	93	72			
4190-20DT-06	19	20	32	97	76			
4200-20DT-06	20	20	32	103	80			

C...TDR-20DT

T-DRILL

C-adapter system





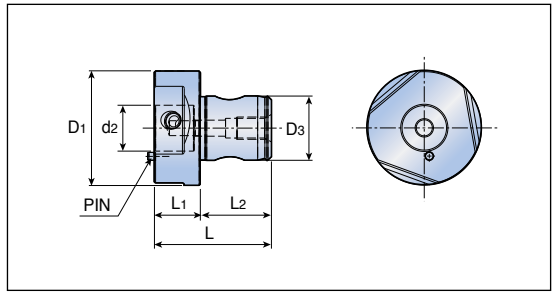
Designation	Dimension (mm)			Screw
	D1	d2	L1	
C4-TDR-20DT	40	20	20	SS M6x1x10-NL
C5-TDR-20DT	50	20	30	
C6-TDR-20DT	63	20	30	

BBS...TDR-20DT

T-DRILL

BBS adapter system



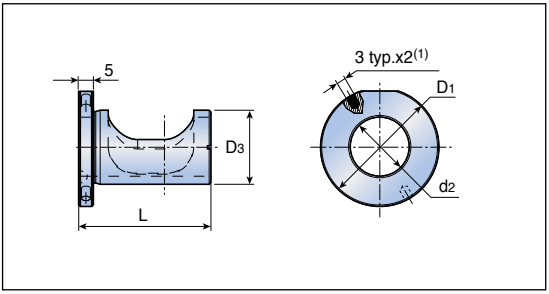


Designation	Dimension (mm)						Screw
	D1	d2	D3	L1	L2	L	
BBS50-TDR-20DT	50	20	28	20	31	51	SS M6x1x10-NL
BBS63-TDR-20DT	63	20	34	39	38	77	

ECCENTER SLLEVE

Drill center adjustment sleeves / eccentric sleeve





Designation		Dimension (mm)			
		d2	D3	D1	L
ECCENTER SLEEVE	**20x25**	20	25	40	44
	25x32	25	32	50	46
	32x40	32	40	65	55
	40x50	40	50	75	62

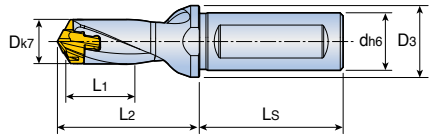
• (1) Holes for inserting a pin are used to facilitate radial adjustment of the sleeve (Pin is not supplied)

TCD...T...-1.5D

DRILL•RUSH

Head changeable drill holder - Weldon type shank





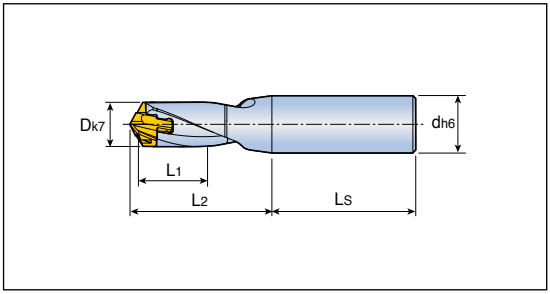
• Drilling depth: 1.5xdiameter

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	K TCD D060-D099
065-069-12T3-1.5D	6.5-6.9	12	16	10	24.1	45	6.5	
070-074-12T3-1.5D	7.0-7.4	12	16	11	25.1	45	7	
075-079-12T3-1.5D	7.5-7.9	12	16	11.3	25.9	45	7	
080-089-12T3-1.5D	8.0-8.9	12	16	12	27.4	45	8	
090-099-12T3-1.5D	9.0-9.9	12	16	14	29.3	45	9	
100-109-16T3-1.5D	10.0-10.9	16	20	15	31.2	48	10	K TCD D100-D199
110-119-16T3-1.5D	11.0-11.9	16	20	17	33.1	48	11	
120-129-16T3-1.5D	12.0-12.9	16	20	18	35.0	48	12	
130-139-16T3-1.5D	13.0-13.9	16	20	20	37.1	48	13	
140-149-16T3-1.5D	14.0-14.9	16	20	21	41.1	48	14	
150-159-20T3-1.5D	15.0-15.9	20	25	23	46.2	50	15	
160-169-20T3-1.5D	16.0-16.9	20	25	24	49.3	50	16	
170-179-20T3-1.5D	17.0-17.9	20	25	26	52.4	50	17	
180-189-25T2-1.5D	18.0-18.9	25	32	27	55.5	56	18	
190-199-25T2-1.5D	19.0-19.9	25	32	29	58.5	56	19	
200-209-25T2-1.5D	20.0-20.9	25	32	30	61.6	56	20	K TCD D200-D269
210-219-25T2-1.5D	21.0-21.9	25	32	32	64.7	56	21	
220-229-25T2-1.5D	22.0-22.9	25	32	33	67.8	56	22	
230-239-32T2-1.5D	23.0-23.9	32	42	35	70.8	60	23	
240-249-32T2-1.5D	24.0-24.9	32	42	36	73.9	60	24	
250-259-32T2-1.5D	25.0-25.9	32	42	38	77.0	60	25	

TCD...S0-1.5D

Head changeable drill holder - Cylindrical type shank





• Drilling depth: 1.5xdiameter

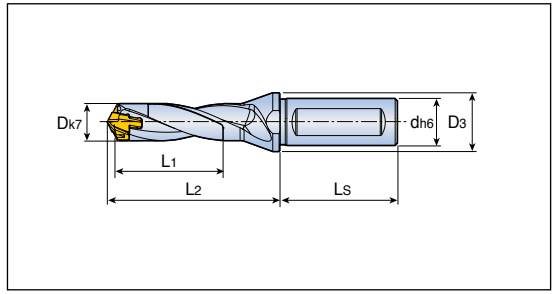
Designation	Dimension (mm)						Clamping key
	D range	d	L1	L2	Ls	Pocket size	
TCD 060-064-12S0-1.5D	6.0-6.4	12	9	23.0	45	6	K TCD D060-D099
065-069-12S0-1.5D	6.5-6.9	12	10	24.1	45	6.5	
070-074-12S0-1.5D	7.0-7.4	12	11	25.1	45	7	
075-079-12S0-1.5D	7.5-7.9	12	11.3	25.9	45	7	
080-089-12S0-1.5D	8.0-8.9	12	12	27.4	45	8	
090-099-12S0-1.5D	9.0-9.9	12	14	29.3	45	9	
100-109-16S0-1.5D	10.0-10.9	16	15	31.2	48	10	K TCD D100-D199
110-119-16S0-1.5D	11.0-11.9	16	17	33.1	48	11	
120-129-16S0-1.5D	12.0-12.9	16	18	35.0	48	12	
130-139-16S0-1.5D	13.0-13.9	16	20	37.1	48	13	
140-149-16S0-1.5D	14.0-14.9	16	21	41.1	48	14	
150-159-20S0-1.5D	15.0-15.9	20	23	46.2	50	15	
160-169-20S0-1.5D	16.0-16.9	20	24	49.3	50	16	
170-179-20S0-1.5D	17.0-17.9	20	26	52.4	50	17	
180-189-25S0-1.5D	18.0-18.9	25	27	55.5	56	18	
190-199-25S0-1.5D	19.0-19.9	25	29	58.5	56	19	
200-209-25S0-1.5D	20.0-20.9	25	30	61.6	56	20	K TCD D200-D269
210-219-25S0-1.5D	21.0-21.9	25	32	64.7	56	21	
220-229-25S0-1.5D	22.0-22.9	25	33	67.8	56	22	
230-239-32S0-1.5D	23.0-23.9	32	35	70.8	60	23	
240-249-32S0-1.5D	24.0-24.9	32	36	73.9	60	24	
250-259-32S0-1.5D	25.0-25.9	32	38	77.0	60	25	

D140
Cutting Condition D168

TCD...T...-3D

Head changeable drill holder - Weldon type shank





• Drilling depth: 3xdiameter



Designation	Dimension (mm)							Clamping key
	D range	d	D3	L1	L2	LS	Pocket size	
TCD 060-064-12T3-3D	6.0-6.4	12	16	18	32.0	45	6	K TCD D060-D099
065-069-12T3-3D	6.5-6.9	12	16	20	33.8	45	6.5	
070-074-12T3-3D	7.0-7.4	12	16	21	35.6	45	7	
075-079-12T3-3D	7.5-7.9	12	16	23	37.1	45	7	
080-084-12T3-3D	8.0-8.4	12	16	24	39.4	45	8	
085-089-12T3-3D	8.5-8.9	12	16	26	40.9	45	8	
090-094-12T3-3D	9.0-9.4	12	16	27	42.8	45	9	
095-099-12T3-3D	9.5-9.9	12	16	29	44.3	45	9	
100-104-16T3-3D	10.0-10.4	16	20	30	46.2	48	10	K TCD D100-D199
105-109-16T3-3D	10.5-10.9	16	20	32	47.7	48	10	
110-114-16T3-3D	11.0-11.4	16	20	33	49.6	48	11	
115-119-16T3-3D	11.5-11.9	16	20	35	51.1	48	11	
120-124-16T3-3D	12.0-12.4	16	20	36	53.0	48	12	
125-129-16T3-3D	12.5-12.9	16	20	37	54.5	48	12	
130-134-16T3-3D	13.0-13.4	16	20	39	56.6	48	13	
135-139-16T3-3D	13.5-13.9	16	20	41	58.1	48	13	
140-144-16T3-3D	14.0-14.4	16	20	42	62.2	48	14	
145-149-16T3-3D	14.5-14.9	16	20	44	63.7	48	14	
150-159-20T3-3D	15.0-15.9	20	25	45	68.7	50	15	
160-169-20T3-3D	16.0-16.9	20	25	48	73.3	50	16	
170-179-20T3-3D	17.0-17.9	20	25	51	77.9	50	17	
180-189-25T2-3D	18.0-18.9	25	32	54	82.5	56	18	
190-199-25T2-3D	19.0-19.9	25	32	57	87.0	56	19	
200-209-25T2-3D	20.0-20.9	25	32	60	91.6	56	20	K TCD D200-D269
210-219-25T2-3D	21.0-21.9	25	32	63	96.2	56	21	
220-229-25T2-3D	22.0-22.9	25	32	66	100.8	56	22	
230-239-32T2-3D	23.0-23.9	32	42	69	105.3	60	23	
240-249-32T2-3D	24.0-24.9	32	42	72	109.9	60	24	
250-259-32T2-3D	25.0-25.9	32	42	75	114.5	60	25	

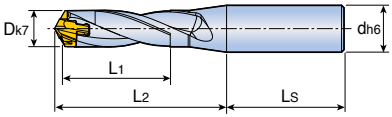
D140 Cutting Condition D168

TCD...S0-3D

DRILL•RUSH

Head changeable drill holder - Cylindrical type shank





• Drilling depth: 3xdiameter

Designation		Dimension (mm)						Clamping key
		D range	d	L1	L2	Ls	Pocket size	
TCD	060-064-12S0-3D	6.0-6.4	12	18	32.0	45	6	K TCD D060-D099
	065-069-12S0-3D	6.5-6.9	12	20	33.8	45	6.5	
	070-074-12S0-3D	7.0-7.4	12	21	35.6	45	7	
	075-079-12S0-3D	7.5-7.9	12	23	37.1	45	7	
	080-084-12S0-3D	8.0-8.4	12	24	39.4	45	8	
	085-089-12S0-3D	8.5-8.9	12	26	40.9	45	8	
	090-094-12S0-3D	9.0-9.4	12	27	42.8	45	9	
	095-099-12S0-3D	9.5-9.9	12	29	44.3	45	9	
	100-104-16S0-3D	10.0-10.4	16	30	46.2	48	10	K TCD D100-D199
	105-109-16S0-3D	10.5-10.9	16	32	47.7	48	10	
	110-114-16S0-3D	11.0-11.4	16	33	49.6	48	11	
	115-119-16S0-3D	11.5-11.9	16	35	51.1	48	11	
	120-124-16S0-3D	12.0-12.4	16	36	53.0	48	12	
	125-129-16S0-3D	12.5-12.9	16	37	54.5	48	12	
	130-134-16S0-3D	13.0-13.4	16	39	56.6	48	13	
	135-139-16S0-3D	13.5-13.9	16	41	58.1	48	13	
	140-144-16S0-3D	14.0-14.4	16	42	62.2	48	14	
	145-149-16S0-3D	14.5-14.9	16	44	63.7	48	14	
	150-159-20S0-3D	15.0-15.9	20	45	68.7	50	15	
	160-169-20S0-3D	16.0-16.9	20	48	73.3	50	16	
	170-179-20S0-3D	17.0-17.9	20	51	77.9	50	17	
	180-189-25S0-3D	18.0-18.9	25	54	82.5	56	18	
	190-199-25S0-3D	19.0-19.9	25	57	87.0	56	19	
	200-209-25S0-3D	20.0-20.9	25	60	91.6	56	20	K TCD D200-D269
	210-219-25S0-3D	21.0-21.9	25	63	96.2	56	21	
	220-229-25S0-3D	22.0-22.9	25	66	100.8	56	22	
	230-239-32S0-3D	23.0-23.9	32	69	105.3	60	23	
	240-249-32S0-3D	24.0-24.9	32	72	109.9	60	24	
	250-259-32S0-3D	25.0-25.9	32	75	114.5	60	25	

D140 Cutting Condition D168

TaeguTec Member IMC Group

TCD...T...-5D

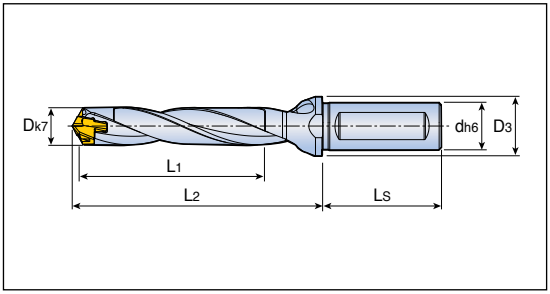
DRILL•RUSH

Head changeable drill holder - Weldon type shank



• Drilling depth: 5xdiameter





Designation	Dimension (mm)							Clamping key
	D range	d	D3	L1	L2	Ls	Pocket size	
TCD 060-064-12T3-5D	6.0-6.4	12	16	30	44.0	45	6	K TCD D060-D099
065-069-12T3-5D	6.5-6.9	12	16	33	46.8	45	6.5	
070-074-12T3-5D	7.0-7.4	12	16	35	49.6	45	7	
075-079-12T3-5D	7.5-7.9	12	16	38	52.1	45	7	
080-084-12T3-5D	8.0-8.4	12	16	40	55.4	45	8	
085-089-12T3-5D	8.5-8.9	12	16	43	57.9	45	8	
090-094-12T3-5D	9.0-9.4	12	16	45	60.8	45	9	
095-099-12T3-5D	9.5-9.9	12	16	48	63.3	45	9	
100-104-16T3-5D	10.0-10.4	16	20	50	66.2	48	10	K TCD D100-D199
105-109-16T3-5D	10.5-10.9	16	20	53	68.7	48	10	
110-114-16T3-5D	11.0-11.4	16	20	55	71.6	48	11	
115-119-16T3-5D	11.5-11.9	16	20	58	74.1	48	11	
120-124-16T3-5D	12.0-12.4	16	20	60	77.0	48	12	
125-129-16T3-5D	12.5-12.9	16	20	62	79.5	48	12	
130-134-16T3-5D	13.0-13.4	16	20	65	82.6	48	13	
135-139-16T3-5D	13.5-13.9	16	20	68	85.1	48	13	
140-144-16T3-5D	14.0-14.4	16	20	70	90.2	48	14	
145-149-16T3-5D	14.5-14.9	16	20	73	92.7	48	14	
150-159-20T3-5D	15.0-15.9	20	25	75	98.7	50	15	
160-169-20T3-5D	16.0-16.9	20	25	80	105.3	50	16	
170-179-20T3-5D	17.0-17.9	20	25	85	111.9	50	17	
180-189-25T2-5D	18.0-18.9	25	32	90	118.5	56	18	
190-199-25T2-5D	19.0-19.9	25	32	95	125.0	56	19	
200-209-25T2-5D	20.0-20.9	25	32	100	131.6	56	20	K TCD D200-D269
210-219-25T2-5D	21.0-21.9	25	32	105	138.2	56	21	
220-229-25T2-5D	22.0-22.9	25	32	110	144.8	56	22	
230-239-32T2-5D	23.0-23.9	32	42	115	151.3	60	23	
240-249-32T2-5D	24.0-24.9	32	42	120	157.9	60	24	
250-259-32T2-5D	25.0-25.9	32	42	125	164.5	60	25	





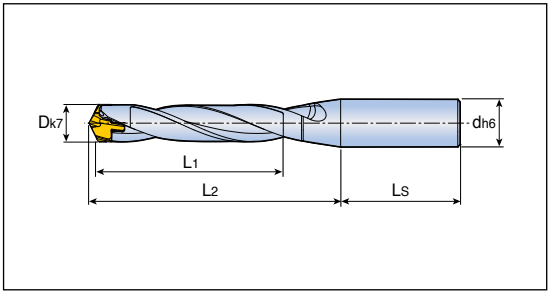
TaeguTec
Member IMC Group

TCD...S0-5D

DRILL•RUSH

Head changeable drill holder - Cylindrical type shank





• Drilling depth: 5xdiameter

Designation		Dimension (mm)						Clamping key
		D range	d	L1	L2	Ls	Pocket size	
TCD	060-064-12S0-5D	6.0-6.4	12	30	44.0	45	6	K TCD D060-D099
	065-069-12S0-5D	6.5-6.9	12	33	46.8	45	6.5	
	070-074-12S0-5D	7.0-7.4	12	35	49.6	45	7	
	075-079-12S0-5D	7.5-7.9	12	38	52.1	45	7	
	080-084-12S0-5D	8.0-8.4	12	40	55.4	45	8	
	085-089-12S0-5D	8.5-8.9	12	43	57.9	45	8	
	090-094-12S0-5D	9.0-9.4	12	45	60.8	45	9	
	095-099-12S0-5D	9.5-9.9	12	48	63.3	45	9	
	100-104-16S0-5D	10.0-10.4	16	50	66.2	48	10	K TCD D100-D199
	105-109-16S0-5D	10.5-10.9	16	53	68.7	48	10	
	110-114-16S0-5D	11.0-11.4	16	55	71.6	48	11	
	115-119-16S0-5D	11.5-11.9	16	58	74.1	48	11	
	120-124-16S0-5D	12.0-12.4	16	60	77.0	48	12	
	125-129-16S0-5D	12.5-12.9	16	62	79.5	48	12	
	130-134-16S0-5D	13.0-13.4	16	65	82.6	48	13	
	135-139-16S0-5D	13.5-13.9	16	68	85.1	48	13	
	140-144-16S0-5D	14.0-14.4	16	70	90.2	48	14	
	145-149-16S0-5D	14.5-14.9	16	73	92.7	48	14	
	150-159-20S0-5D	15.0-15.9	20	75	98.7	50	15	
	160-169-20S0-5D	16.0-16.9	20	80	105.3	50	16	
	170-179-20S0-5D	17.0-17.9	20	85	111.9	50	17	
	180-189-25S0-5D	18.0-18.9	25	90	118.5	56	18	
	190-199-25S0-5D	19.0-19.9	25	95	125.0	56	19	
	200-209-25S0-5D	20.0-20.9	25	100	131.6	56	20	K TCD D200-D269
	210-219-25S0-5D	21.0-21.9	25	105	138.2	56	21	
	220-229-25S0-5D	22.0-22.9	25	110	144.8	56	22	
	230-239-32S0-5D	23.0-23.9	32	115	151.3	60	23	
	240-249-32S0-5D	24.0-24.9	32	120	157.9	60	24	
	250-259-32S0-5D	25.0-25.9	32	125	164.5	60	25	

D140 Cutting Condition D168

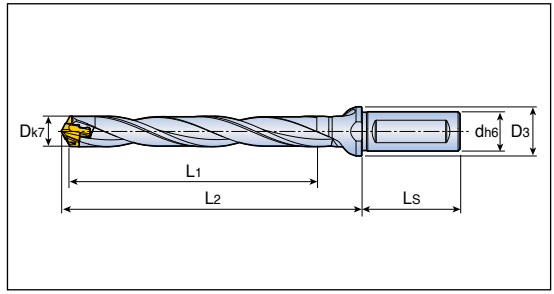
TaeguTec Member IMC Group

TCD...T...-8D

DRILL•RUSH

Head changeable drill holder - Weldon type shank





• Drilling depth: 8xdiameter

Designation	Dimension (mm)							Clamping key
	D range	d	D3	L1	L2	Ls	Pocket size	
TCD 070-074-12T3-8D	7.0-7.4	12	16	56	70.6	45	7	K TCD D060-D099
075-079-12T3-8D	7.5-7.9	12	16	60	74.6	45	7	
080-084-12T3-8D	8.0-8.4	12	16	64	79.4	45	8	
085-089-12T3-8D	8.5-8.9	12	16	68	83.4	45	8	
090-094-12T3-8D	9.0-9.4	12	16	72	87.8	45	9	
095-099-12T3-8D	9.5-9.9	12	16	76	91.8	45	9	
100-104-16T3-8D	10.0-10.4	16	20	80	96.2	48	10	K TCD D100-D199
105-109-16T3-8D	10.5-10.9	16	20	84	100.2	48	10	
110-114-16T3-8D	11.0-11.4	16	20	88	104.6	48	11	
115-119-16T3-8D	11.5-11.9	16	20	92	108.6	48	11	
120-124-16T3-8D	12.0-12.4	16	20	96	113.0	48	12	
125-129-16T3-8D	12.5-12.9	16	20	100	117.0	48	12	
130-134-16T3-8D	13.0-13.4	16	20	104	121.6	48	13	
135-139-16T3-8D	13.5-13.9	16	20	108	125.6	48	13	
140-144-16T3-8D	14.0-14.4	16	20	112	132.2	48	14	
145-149-16T3-8D	14.5-14.9	16	20	116	136.2	48	14	
150-159-20T3-8D	15.0-15.9	20	25	120	143.7	50	15	
160-169-20T3-8D	16.0-16.9	20	25	128	153.3	50	16	
170-179-20T3-8D	17.0-17.9	20	25	136	162.9	50	17	
180-189-25T2-8D	18.0-18.9	25	32	144	172.5	56	18	
190-199-25T2-8D	19.0-19.9	25	32	152	182.0	56	19	
200-209-25T2-8D	20.0-20.9	25	32	160	191.6	56	20	K TCD D200-D269
210-219-25T2-8D	21.0-21.9	25	32	168	201.2	56	21	
220-229-25T2-8D	22.0-22.9	25	32	176	210.8	56	22	
230-239-32T2-8D	23.0-23.9	32	42	184	220.3	60	23	
240-249-32T2-8D	24.0-24.9	32	42	192	229.9	60	24	
250-259-32T2-8D	25.0-25.9	32	42	200	239.5	60	25	

D140 Cutting Condition D168

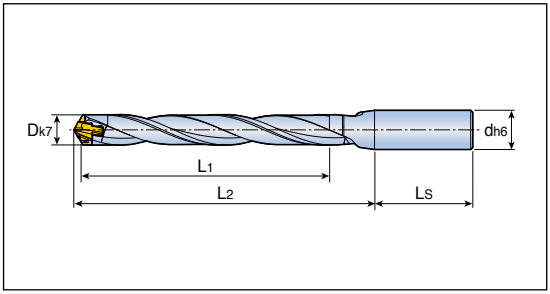
• It is recommended to make the pilot hole with a 1.5D holder

TaeguTec

TCD...S0-8D

Head changeable drill holder - Cylindrical type shank





• Drilling depth: 8xdiameter

Designation		Dimension (mm)						Clamping key
		D range	d	L1	L2	Ls	Pocket size	
TCD	070-074-12S0-8D	7.0-7.4	12	56	70.6	45	7	K TCD D060-D099
	075-079-12S0-8D	7.5-7.9	12	60	74.6	45	7	
	080-084-12S0-8D	8.0-8.4	12	64	79.4	45	8	
	085-089-12S0-8D	8.5-8.9	12	68	83.4	45	8	
	090-094-12S0-8D	9.0-9.4	12	72	91.8	45	9	
	095-099-12S0-8D	9.5-9.9	12	76	92.7	45	9	
	100-104-16S0-8D	10.0-10.4	16	80	96.2	48	10	K TCD D100-D199
	105-109-16S0-8D	10.5-10.9	16	84	100.2	48	10	
	110-114-16S0-8D	11.0-11.4	16	88	104.6	48	11	
	115-119-16S0-8D	11.5-11.9	16	92	108.6	48	11	
	120-124-16S0-8D	12.0-12.4	16	96	113.0	48	12	
	125-129-16S0-8D	12.5-12.9	16	100	117.0	48	12	
	130-134-16S0-8D	13.0-13.4	16	104	121.6	48	13	
	135-139-16S0-8D	13.5-13.9	16	108	125.6	48	13	
	140-144-16S0-8D	14.0-14.4	16	112	132.2	48	14	
	145-149-16S0-8D	14.5-14.9	16	116	136.2	48	14	
	150-159-20S0-8D	15.0-15.9	20	120	143.7	50	15	
	160-169-20S0-8D	16.0-16.9	20	128	153.3	50	16	
	170-179-20S0-8D	17.0-17.9	20	136	162.9	50	17	
	180-189-25S0-8D	18.0-18.9	25	144	172.5	56	18	
	190-199-25S0-8D	19.0-19.9	25	152	182.0	56	19	
	200-209-25S0-8D	20.0-20.9	25	160	191.6	56	20	K TCD D200-D269
	210-219-25S0-8D	21.0-21.9	25	168	201.2	56	21	
	220-229-25S0-8D	22.0-22.9	25	176	210.8	56	22	
	230-239-32S0-8D	23.0-23.9	32	184	220.3	60	23	
	240-249-32S0-8D	24.0-24.9	32	192	229.9	60	24	
	250-259-32S0-8D	25.0-25.9	32	200	239.5	60	25	

D140
Cutting Condition
D168

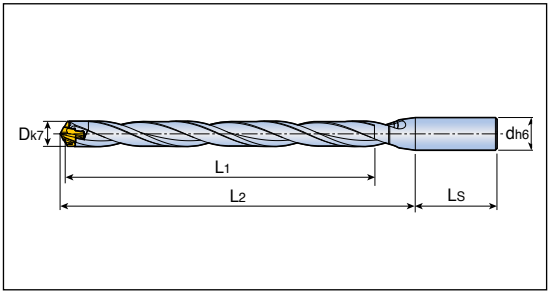
• It is recommended to make the pilot hole with a 1.5D holder

TCD...S0-12D

DRILL•RUSH

Head changeable drill holder - Cylindrical type shank





• Drilling depth: 12xdiameter

Designation		Dimension (mm)						Clamping key
		D range	d	L1	L2	Ls	Pocket size	
TCD	120-124-16S0-12D	12.0-12.4	16	144	161.0	48	12	K TCD D100-D199
	125-129-16S0-12D	12.5-12.9	16	150	167.0	48	12	
	130-134-16S0-12D	13.0-13.4	16	156	173.6	48	13	
	135-139-16S0-12D	13.5-13.9	16	162	179.6	48	13	
	140-144-16S0-12D	14.0-14.4	16	168	188.2	48	14	
	145-149-16S0-12D	14.5-14.9	16	174	194.2	48	14	
	150-159-20S0-12D	15.0-15.9	20	180	203.7	50	15	
	160-169-20S0-12D	16.0-16.9	20	192	217.3	50	16	
	170-179-20S0-12D	17.0-17.9	20	204	230.9	50	17	
	180-189-25S0-12D	18.0-18.9	25	216	244.5	56	18	
	190-199-25S0-12D	19.0-19.9	25	228	258.0	56	19	
	200-209-25S0-12D	20.0-20.9	25	240	271.6	56	20	K TCD D200-D269
	210-219-25S0-12D	21.0-21.9	25	252	285.2	56	21	
	220-229-25S0-12D	22.0-22.9	25	264	298.8	56	22	
	230-239-32S0-12D	23.0-23.9	32	286	312.3	60	23	
	240-249-32S0-12D	24.0-24.9	32	288	325.9	60	24	
	250-259-32S0-12D	25.0-25.9	32	300	339.5	60	25	

D140 Cutting Condition D168

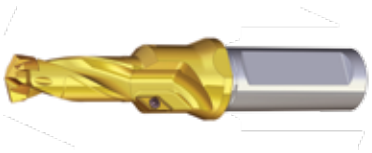
• It is recommended to make the pilot hole with a 1.5D holder

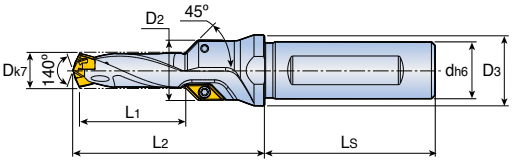
TaeguTec Member IMC Group

TCD...-M

DRILL•RUSH

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 06...-C45
	085x26x12T3-M10	M10	8.5	26	50	45	15.5	12	16	8.5-8.9	D145
	102x30x16T3-M12	M12	10.2	30	54	48	17.0	16	20	10.0-10.4	
	120x35x16T3-M14	M14	12.0	35	61	48	19.0	16	20	12.0-12.4	
	140x39x20T3-M16	M16	14.0	39	69	50	21.0	20	25	14.0-14.4	
	175x42x20T3-M20	M20	17.5	42	72	50	24.5	20	27	17.0-17.9	
	210x48x25T2-M24	M24	21.0	48	80	56	28.0	25	32	21.0-21.9	

Spare parts

Designation	Screw	Wrench	Clamping key	
TCD 068	TS 22046I	TD 7	K TCD D060-D099	
TCD 085	TS 22046I	TD 7	K TCD D060-D099	
TCD 102 - 175	TS 22046I	TD 7	K TCD D100-D199	
TCD 210	TS 22046I	TD 7	K TCD D200-D269	

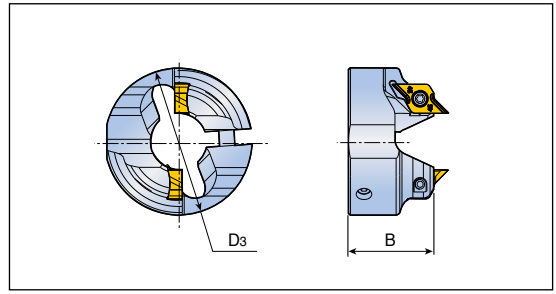
D140 Cutting Condition D168

TaeguTec Member IMC Group

CFR D...-A45

Chamfering ring tool





Designation	Dimension (mm)		Chamfer size	Chamfer insert
	D3	B		
CFR D100-A45	34	20	2.5	CRNG 08...-45CD
D105-A45	34	20	2.5	D145
D110-A45	34	20	2.5	
D115-A45	34	20	2.5	
D120-A45	34	20	2.5	
D125-A45	34	20	2.5	
D130-A45	34	20	2.5	
D135-A45	34	20	2.5	
D140-A45	38	22	2.5	
D145-A45	38	22	2.5	
D150-A45	38	22	2.5	
D160-A45	42	23	2.5	
D170-A45	42	23	2.5	
D180-A45	42	23	2.5	
D190-A45	42	24	2.5	
D200-A45	42	24	2.5	
D210-A45	47	24	2.5	
D220-A45	47	24	2.5	
D230-A45	47	24	2.5	
D240-A45	47	24	2.5	
D250-A45	47	24	2.5	

Spare parts

Designation	Insert screw	Wrench	Clamping screw	L-wrench
CFR D100 - D135	SO 25065I	TD 7	SH M3x0.5x10 (1)	L-W2.5
CFR D140 - D150	SO 25065I	TD 7	SH M4x0.7x12 (2)	L-W3
CFR D160 - D250	SO 25065I	TD 7	SH M5x0.8x16 (3)	L-W4

Cutting Condition D168 | Technical Data D208

• (1) Clamping torque: 2-3 [N•m] (2) Clamping torque: 3.5-4.5 [N•m] (3) Clamping torque: 5-6 [N•m]

TND...T2-5D

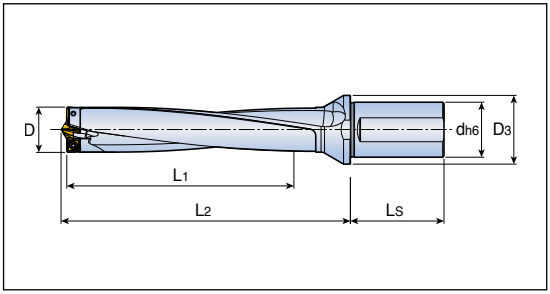
TWIN-RUSH

Head changeable drill holder - Weldon type shank



• Drill depth: 5xdiameter





Designation		Dimension (mm)						Clamping key	Insert	
		D	d	D3	L1	L2	Ls		Center	Outer
TND	260-130-32T2-5D	26	32	40	130	159.0	60	K TCD D15-CO	TCD-159-P-CO	SPGX 06...DW
	270-135-32T2-5D	27	32	40	135	164.5	60	K TCD D16-CO	TCD-169-P-CO	D146
	280-140-32T2-5D	28	32	40	140	170.0	60	K TCD D17-CO	TCD-179-P-CO	
	290-145-32T2-5D	29	32	40	145	175.5	60	K TCD D15-CO	TCD-159-P-CO	SPGX 07... DW
	300-150-32T2-5D	30	32	40	150	181.0	60	K TCD D16-CO	TCD-169-P-CO	D146
	310-155-32T2-5D	31	32	40	155	186.5	60	K TCD D17-CO	TCD-179-P-CO	
	320-160-32T2-5D	32	32	40	160	192.0	60	K TCD D18-CO	TCD-189-P-CO	
	330-165-40T2-5D	33	40	50	165	201.5	68	K TCD D15-CO	TCD-159-P-CO	SPGX 09... DW
	340-170-40T2-5D	34	40	50	170	207.0	68	K TCD D16-CO	TCD-169-P-CO	D146
	350-175-40T2-5D	35	40	50	175	212.5	68	K TCD D17-CO	TCD-179-P-CO	
	360-180-40T2-5D	36	40	50	180	218.0	68	K TCD D18-CO	TCD-189-P-CO	
	370-185-40T2-5D	37	40	50	185	223.5	68	K TCD D16-CO	TCD-169-P-CO	SPGX 11... DW
	380-190-40T2-5D	38	40	50	190	229.0	68	K TCD D17-CO	TCD-179-P-CO	D146
	390-195-40T2-5D	39	40	50	195	234.5	68	K TCD D18-CO	TCD-189-P-CO	
	400-200-40T2-5D	40	40	50	200	240.0	68	K TCD D19-CO	TCD-199-P-CO	
	410-205-40T2-5D	41	40	50	205	245.5	68	K TCD D20-CO	TCD-209-P-CO	
	420-210-40T2-5D	42	40	50	210	251.0	68	K TCD D21-CO	TCD-219-P-CO	
	430-215-40T2-5D	43	40	50	215	256.5	68	K TCD D22-CO	TCD-229-P-CO	
	440-220-40T2-5D	44	40	50	220	262.0	68	K TCD D23-CO	TCD-239-P-CO	
	450-225-40T2-5D	45	40	50	225	267.5	68	K TCD D24-CO	TCD-249-P-CO	

Spare parts

Designation	Screw	Wrench		
				
TND 260-280-5D	TS 22052I/HG	TD 7		
TND 290-320-5D	TS 25064I	TD 8		
TND 330-360-5D	TS 35088I	TD 10		
TND 370-450-5D	TS 40093I	TD 15		



TaeguTec Member IMC Group

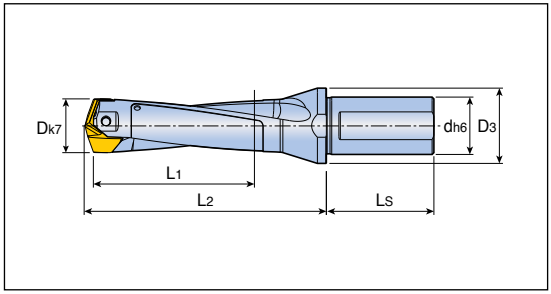
LCD...T2-3D

SPADE•RUSH

Head changeable drill holder - Weldon type shank



• Drill depth: 3xdiameter



Designation		Dimension (mm)						
		D	d	D3	L1	L2	Ls	Pocket size
LCD	260-269-32T2-3D	26.0-26.9	32	40	78	117.0	60	26
	270-279-32T2-3D	27.0-27.9	32	40	81	120.0	60	27
	280-289-32T2-3D	28.0-28.9	32	40	84	128.4	60	28
	290-299-32T2-3D	29.0-29.9	32	40	87	131.4	60	29
	300-309-32T2-3D	30.0-30.9	32	42	90	134.7	60	30
	310-319-32T2-3D	31.0-31.9	32	42	93	137.7	60	31
	320-329-40T2-3D	32.0-32.9	40	48	96	143.0	68	32
	330-339-40T2-3D	33.0-33.9	40	48	99	146.0	68	33
	340-349-40T2-3D	34.0-34.9	40	48	102	149.0	68	34
	350-359-40T2-3D	35.0-35.9	40	48	105	152.4	68	35
	360-369-40T2-3D	36.0-36.9	40	48	108	155.4	68	36
	370-379-40T2-3D	37.0-37.9	40	48	111	158.4	68	37
	380-389-40T2-3D	38.0-38.9	40	50	114	166.9	68	38
	390-399-40T2-3D	39.0-39.9	40	50	117	169.9	68	39
	400-410-40T2-3D	40.0-41.0	40	50	120	172.9	68	40

Spare parts

Designation	Screw	Wrench		
				
LCD 260-270-3D	TS 50230D3	BLD T20/S7, SW6-T-SH		
LCD 280-290-3D	TS 50250D35	BLD T25/S7, SW6-T-SH		
LCD 300-310-3D	TS 60265D4	BLD T25/S7, SW6-T-SH		
LCD 320-340-3D	TS 60285D42	BLD T25/S7, SW6-T-SH		
LCD 350-370-3D	TS 60320D5	BLD T25/S7, SW6-T-SH		
LCD 380-400-3D	TS 80340D6	BLD T25/S7, SW6-T-SH		



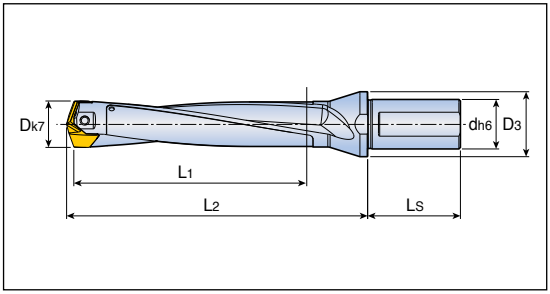
TaeguTec

LCD...T2-5D

SPADE•RUSH

Head changeable drill holder - Weldon type shank





• Drill depth: 5xdiameter

Designation		Dimension (mm)						
		D	d	D3	L1	L2	Ls	Pocket size
LCD	260-269-32T2-5D	26.0-26.9	32	40	130	169.0	60	26
	270-279-32T2-5D	27.0-27.9	32	40	135	174.0	60	27
	280-289-32T2-5D	28.0-28.9	32	40	140	184.4	60	28
	290-299-32T2-5D	29.0-29.9	32	40	145	189.4	60	29
	300-309-32T2-5D	30.0-30.9	32	42	150	194.7	60	30
	310-319-32T2-5D	31.0-31.9	32	42	155	199.7	60	31
	320-329-40T2-5D	32.0-32.9	40	48	160	207.0	68	32
	330-339-40T2-5D	33.0-33.9	40	48	165	212.0	68	33
	340-349-40T2-5D	34.0-34.9	40	48	170	217.0	68	34
	350-359-40T2-5D	35.0-35.9	40	48	175	222.4	68	35
	360-369-40T2-5D	36.0-36.9	40	48	180	227.4	68	36
	370-379-40T2-5D	37.0-37.9	40	48	185	232.4	68	37
	380-389-40T2-5D	38.0-38.9	40	50	190	242.9	68	38
	390-399-40T2-5D	39.0-39.9	40	50	195	247.9	68	39
	400-410-40T2-5D	40.0-41.0	40	50	200	252.9	68	40

Spare parts

Designation	Screw	Wrench		
LCD 260-270-5D	TS 50230D3	BLD T20/S7, SW6-T-SH		
LCD 280-290-5D	TS 50250D35	BLD T25/S7, SW6-T-SH		
LCD 300-310-5D	TS 60265D4	BLD T25/S7, SW6-T-SH		
LCD 320-340-5D	TS 60285D42	BLD T25/S7, SW6-T-SH		
LCD 350-370-5D	TS 60320D5	BLD T25/S7, SW6-T-SH		
LCD 380-400-5D	TS 80340D6	BLD T25/S7, SW6-T-SH		

D147 Cutting Condition D172

TaeguTec Member IMC Group

NHD... PE3

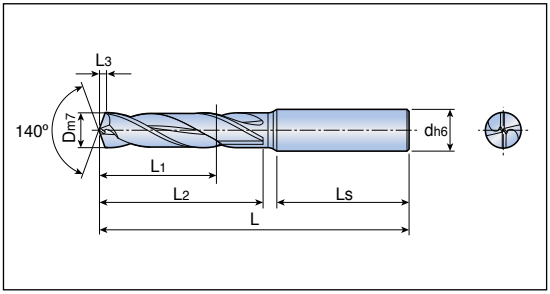
H-DRILL

Solid carbide drill without oil holes



• Drilling depth: 3xdiameter





Designation	Dimension (mm)							Grade	Designation	Dimension (mm)							Grade
	D	d	L	L1	L2	L3	Ls	TT9030		D	d	L	L1	L2	L3	Ls	TT9030
NHD 030-014-06 PE3	3.0	6.0	62	14	20	0.5	34	●	**NHD 065-024-08 PE3**	6.5	8.0	79	24	34	1.0	36	●
031-014-06 PE3	3.1	6.0	62	14	20	0.5	34	●	**066-024-08 PE3**	6.6	8.0	79	24	34	1.0	36	●
032-014-06 PE3	3.2	6.0	62	14	20	0.5	34	●	**067-024-08 PE3**	6.7	8.0	79	24	34	1.1	36	●
033-014-06 PE3	3.3	6.0	62	14	20	0.5	34	●	**068-024-08 PE3**	6.8	8.0	79	24	34	1.1	36	●
034-014-06 PE3	3.4	6.0	62	14	20	0.5	34	●	**069-024-08 PE3**	6.9	8.0	79	24	34	1.1	36	●
035-014-06 PE3	3.5	6.0	62	14	20	0.6	34	●	**070-024-08 PE3**	7.0	8.0	79	24	34	1.1	36	●
036-014-06 PE3	3.6	6.0	62	14	20	0.6	34	●	**071-029-08 PE3**	7.1	8.0	79	29	41	1.1	36	●
037-014-06 PE3	3.7	6.0	62	14	20	0.6	34	●	**072-029-08 PE3**	7.2	8.0	79	29	41	1.1	36	●
038-017-06 PE3	3.8	6.0	66	17	24	0.6	35	●	**073-029-08 PE3**	7.3	8.0	79	29	41	1.1	36	●
039-017-06 PE3	3.9	6.0	66	17	24	0.6	35	●	**074-029-08 PE3**	7.4	8.0	79	29	41	1.2	36	●
040-017-06 PE3	4.0	6.0	66	17	24	0.6	35	●	**075-029-08 PE3**	7.5	8.0	79	29	41	1.2	36	●
041-017-06 PE3	4.1	6.0	66	17	24	0.7	35	●	**076-029-08 PE3**	7.6	8.0	79	29	41	1.2	36	●
042-017-06 PE3	4.2	6.0	66	17	24	0.7	35	●	**077-029-08 PE3**	7.7	8.0	79	29	41	1.2	36	●
043-017-06 PE3	4.3	6.0	66	17	24	0.7	35	●	**078-029-08 PE3**	7.8	8.0	79	29	41	1.2	36	●
044-017-06 PE3	4.4	6.0	66	17	24	0.7	35	●	**079-029-08 PE3**	7.9	8.0	79	29	41	1.3	36	●
045-017-06 PE3	4.5	6.0	66	17	24	0.7	35	●	**080-029-08 PE3**	8.0	8.0	79	29	41	1.3	36	●
046-017-06 PE3	4.6	6.0	66	17	24	0.7	35	●	**081-035-10 PE3**	8.1	10.0	89	35	47	1.3	40	●
047-017-06 PE3	4.7	6.0	66	17	24	0.8	35	●	**082-035-10 PE3**	8.2	10.0	89	35	47	1.3	40	●
048-020-06 PE3	4.8	6.0	66	20	28	0.8	36	●	**083-035-10 PE3**	8.3	10.0	89	35	47	1.3	40	●
049-020-06 PE3	4.9	6.0	66	20	28	0.8	36	●	**084-035-10 PE3**	8.4	10.0	89	35	47	1.3	40	●
050-020-06 PE3	5.0	6.0	66	20	28	0.8	36	●	**085-035-10 PE3**	8.5	10.0	89	35	47	1.3	40	●
051-020-06 PE3	5.1	6.0	66	20	28	0.8	36	●	**086-035-10 PE3**	8.6	10.0	89	35	47	1.4	40	●
052-020-06 PE3	5.2	6.0	66	20	28	0.8	36	●	**087-035-10 PE3**	8.7	10.0	89	35	47	1.4	40	●
053-020-06 PE3	5.3	6.0	66	20	28	0.8	36	●	**088-035-10 PE3**	8.8	10.0	89	35	47	1.4	40	●
054-020-06 PE3	5.4	6.0	66	20	28	0.8	36	●	**089-035-10 PE3**	8.9	10.0	89	35	47	1.4	40	●
055-020-06 PE3	5.5	6.0	66	20	28	0.9	36	●	**090-035-10 PE3**	9.0	10.0	89	35	47	1.4	40	●
056-020-06 PE3	5.6	6.0	66	20	28	0.9	36	●	**091-035-10 PE3**	9.1	10.0	89	35	47	1.4	40	●
057-020-06 PE3	5.7	6.0	66	20	28	0.9	36	●	**092-035-10 PE3**	9.2	10.0	89	35	47	1.4	40	●
058-020-06 PE3	5.8	6.0	66	20	28	0.9	36	●	**093-035-10 PE3**	9.3	10.0	89	35	47	1.5	40	●
059-020-06 PE3	5.9	6.0	66	20	28	0.9	36	●	**094-035-10 PE3**	9.4	10.0	89	35	47	1.5	40	●
060-020-06 PE3	6.0	6.0	66	20	28	0.9	36	●	**095-035-10 PE3**	9.5	10.0	89	35	47	1.5	40	●
061-024-08 PE3	6.1	8.0	79	24	34	1.0	36	●	**096-035-10 PE3**	9.6	10.0	89	35	47	1.5	40	●
062-024-08 PE3	6.2	8.0	79	24	34	1.0	36	●	**097-035-10 PE3**	9.7	10.0	89	35	47	1.5	40	●
063-024-08 PE3	6.3	8.0	79	24	34	1.0	36	●	**098-035-10 PE3**	9.8	10.0	89	35	47	1.6	40	●
064-024-08 PE3	6.4	8.0	79	24	34	1.0	36	●	**099-035-10 PE3**	9.9	10.0	89	35	47	1.6	40	●

●: Standard item

Cutting Condition
D174

TaeguTec
Member IMC Group

NHD... PE3

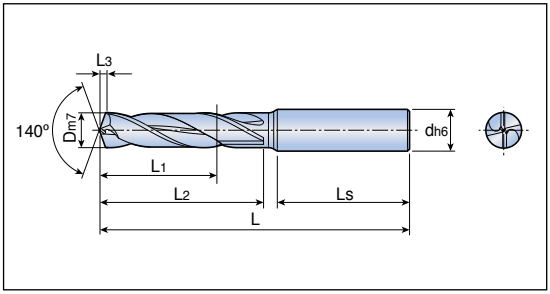
H-DRILL

Solid carbide drill without oil holes



• Drilling depth: 3xdiameter





Designation	Dimension (mm)							Grade	Designation	Dimension (mm)							Grade
	D	d	L	L_1	L_2	L_3	Ls	TT9030		D	d	L	L_1	L_2	L_3	Ls	TT9030
NHD 100-035-10 PE3	10.0	10.0	89	35	47	1.6	40	●									
101-040-12 PE3	10.1	12.0	101	40	55	1.6	45	●									
102-040-12 PE3	10.2	12.0	101	40	55	1.6	45	●									
103-040-12 PE3	10.3	12.0	101	40	55	1.6	45	●									
104-040-12 PE3	10.4	12.0	101	40	55	1.6	45	●									
105-040-12 PE3	10.5	12.0	101	40	55	1.6	45	●									
106-040-12 PE3	10.6	12.0	101	40	55	1.7	45	●									
107-040-12 PE3	10.7	12.0	101	40	55	1.7	45	●									
108-040-12 PE3	10.8	12.0	101	40	55	1.7	45	●									
109-040-12 PE3	10.9	12.0	101	40	55	1.7	45	●									
110-040-12 PE3	11.0	12.0	101	40	55	1.7	45	●									
111-040-12 PE3	11.1	12.0	101	40	55	1.7	45	●									
112-040-12 PE3	11.2	12.0	101	40	55	1.8	45	●									
113-040-12 PE3	11.3	12.0	101	40	55	1.8	45	●									
114-040-12 PE3	11.4	12.0	101	40	55	1.8	45	●									
115-040-12 PE3	11.5	12.0	101	40	55	1.8	45	●									
116-040-12 PE3	11.6	12.0	101	40	55	1.8	45	●									
117-040-12 PE3	11.7	12.0	101	40	55	1.9	45	●									
118-040-12 PE3	11.8	12.0	101	40	55	1.9	45	●									
119-040-12 PE3	11.9	12.0	101	40	55	1.9	45	●									
120-040-12 PE3	12.0	12.0	101	40	55	1.9	45	●									

Cutting Condition D174

●: Standard item

TaeguTec Member IMC Group

NHD... PE5

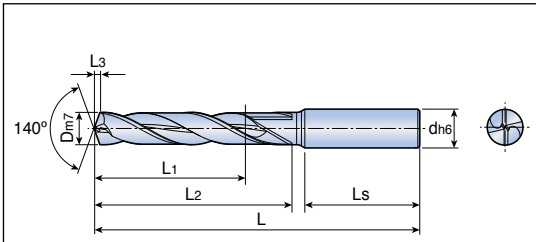
H-DRILL

Solid carbide drill without oil holes



• Drilling depth: 4-5xdiameter





Designation	Dimension (mm)							Grade	Designation	Dimension (mm)							Grade
	D	d	L	L1	L2	L3	Ls	TT9030		D	d	L	L1	L2	L3	Ls	TT9030
NHD 030-023-06 PE5	3.0	6.0	66	23	28	0.5	34	●	NHD 065-043-08 PE5	6.5	8.0	91	43	53	1.0	36	●
031-023-06 PE5	3.1	6.0	66	23	28	0.5	34	●	066-043-08 PE5	6.6	8.0	91	43	53	1.0	36	●
032-023-06 PE5	3.2	6.0	66	23	28	0.5	34	●	067-043-08 PE5	6.7	8.0	91	43	53	1.1	36	●
033-023-06 PE5	3.3	6.0	66	23	28	0.5	34	●	068-043-08 PE5	6.8	8.0	91	43	53	1.1	36	●
034-023-06 PE5	3.4	6.0	66	23	28	0.5	34	●	069-043-08 PE5	6.9	8.0	91	43	53	1.1	36	●
035-023-06 PE5	3.5	6.0	66	23	28	0.6	34	●	070-043-08 PE5	7.0	8.0	91	43	53	1.1	36	●
036-023-06 PE5	3.6	6.0	66	23	28	0.6	34	●	071-043-08 PE5	7.1	8.0	91	43	53	1.1	36	●
037-023-06 PE5	3.7	6.0	66	23	28	0.6	34	●	072-043-08 PE5	7.2	8.0	91	43	53	1.1	36	●
038-029-06 PE5	3.8	6.0	74	29	36	0.6	35	●	073-043-08 PE5	7.3	8.0	91	43	53	1.1	36	●
039-029-06 PE5	3.9	6.0	74	29	36	0.6	35	●	074-043-08 PE5	7.4	8.0	91	43	53	1.2	36	●
040-029-06 PE5	4.0	6.0	74	29	36	0.6	35	●	075-043-08 PE5	7.5	8.0	91	43	53	1.2	36	●
041-029-06 PE5	4.1	6.0	74	29	36	0.7	35	●	076-043-08 PE5	7.6	8.0	91	43	53	1.2	36	●
042-029-06 PE5	4.2	6.0	74	29	36	0.7	35	●	077-043-08 PE5	7.7	8.0	91	43	53	1.2	36	●
043-029-06 PE5	4.3	6.0	74	29	36	0.7	35	●	078-043-08 PE5	7.8	8.0	91	43	53	1.2	36	●
044-029-06 PE5	4.4	6.0	74	29	36	0.7	35	●	079-043-08 PE5	7.9	8.0	91	43	53	1.3	36	●
045-029-06 PE5	4.5	6.0	74	29	36	0.7	35	●	080-043-08 PE5	8.0	8.0	91	43	53	1.3	36	●
046-029-06 PE5	4.6	6.0	74	29	36	0.7	35	●	081-049-10 PE5	8.1	10.0	103	49	61	1.3	40	●
047-029-06 PE5	4.7	6.0	74	29	36	0.8	35	●	082-049-10 PE5	8.2	10.0	103	49	61	1.3	40	●
048-035-06 PE5	4.8	6.0	82	35	44	0.8	36	●	083-049-10 PE5	8.3	10.0	103	49	61	1.3	40	●
049-035-06 PE5	4.9	6.0	82	35	44	0.8	36	●	084-049-10 PE5	8.4	10.0	103	49	61	1.3	40	●
050-035-06 PE5	5.0	6.0	82	35	44	0.8	36	●	085-049-10 PE5	8.5	10.0	103	49	61	1.3	40	●
051-035-06 PE5	5.1	6.0	82	35	44	0.8	36	●	086-049-10 PE5	8.6	10.0	103	49	61	1.4	40	●
052-035-06 PE5	5.2	6.0	82	35	44	0.8	36	●	087-049-10 PE5	8.7	10.0	103	49	61	1.4	40	●
053-035-06 PE5	5.3	6.0	82	35	44	0.8	36	●	088-049-10 PE5	8.8	10.0	103	49	61	1.4	40	●
054-035-06 PE5	5.4	6.0	82	35	44	0.8	36	●	089-049-10 PE5	8.9	10.0	103	49	61	1.4	40	●
055-035-06 PE5	5.5	6.0	82	35	44	0.9	36	●	090-049-10 PE5	9.0	10.0	103	49	61	1.4	40	●
056-035-06 PE5	5.6	6.0	82	35	44	0.9	36	●	091-049-10 PE5	9.1	10.0	103	49	61	1.4	40	●
057-035-06 PE5	5.7	6.0	82	35	44	0.9	36	●	092-049-10 PE5	9.2	10.0	103	49	61	1.4	40	●
058-035-06 PE5	5.8	6.0	82	35	44	0.9	36	●	093-049-10 PE5	9.3	10.0	103	49	61	1.5	40	●
059-035-06 PE5	5.9	6.0	82	35	44	0.9	36	●	094-049-10 PE5	9.4	10.0	103	49	61	1.5	40	●
060-035-06 PE5	6.0	6.0	82	35	44	0.9	36	●	095-049-10 PE5	9.5	10.0	103	49	61	1.5	40	●
061-043-08 PE5	6.1	8.0	91	43	53	1.0	36	●	096-049-10 PE5	9.6	10.0	103	49	61	1.5	40	●
062-043-08 PE5	6.2	8.0	91	43	53	1.0	36	●	097-049-10 PE5	9.7	10.0	103	49	61	1.5	40	●
063-043-08 PE5	6.3	8.0	91	43	53	1.0	36	●	098-049-10 PE5	9.8	10.0	103	49	61	1.6	40	●
064-043-08 PE5	6.4	8.0	91	43	53	1.0	36	●	099-049-10 PE5	9.9	10.0	103	49	61	1.6	40	●

●: Standard item

Cutting Condition D174

TaeguTec

NHD... PE5

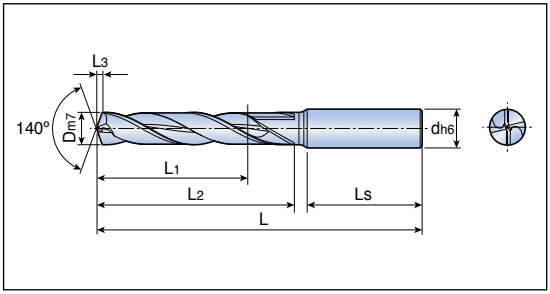
H-DRILL

Solid carbide drill without oil holes



• Drilling depth: 4-5xdiameter





Designation	Dimension (mm)							Grade	Designation	Dimension (mm)							Grade
	D	d	L	L_1	L_2	L_3	Ls	TT9030		D	d	L	L_1	L_2	L_3	Ls	TT9030
NHD 100-049-10 PE5	10.0	10.0	103	49	61	1.6	40	●									
101-056-12 PE5	10.1	12.0	118	56	71	1.6	45	●									
102-056-12 PE5	10.2	12.0	118	56	71	1.6	45	●									
103-056-12 PE5	10.3	12.0	118	56	71	1.6	45	●									
104-056-12 PE5	10.4	12.0	118	56	71	1.6	45	●									
105-056-12 PE5	10.5	12.0	118	56	71	1.6	45	●									
106-056-12 PE5	10.6	12.0	118	56	71	1.7	45	●									
107-056-12 PE5	10.7	12.0	118	56	71	1.7	45	●									
108-056-12 PE5	10.8	12.0	118	56	71	1.7	45	●									
109-056-12 PE5	10.9	12.0	118	56	71	1.7	45	●									
110-056-12 PE5	11.0	12.0	118	56	71	1.7	45	●									
111-056-12 PE5	11.1	12.0	118	56	71	1.7	45	●									
112-056-12 PE5	11.2	12.0	118	56	71	1.8	45	●									
113-056-12 PE5	11.3	12.0	118	56	71	1.8	45	●									
114-056-12 PE5	11.4	12.0	118	56	71	1.8	45	●									
115-056-12 PE5	11.5	12.0	118	56	71	1.8	45	●									
116-056-12 PE5	11.6	12.0	118	56	71	1.8	45	●									
117-056-12 PE5	11.7	12.0	118	56	71	1.9	45	●									
118-056-12 PE5	11.8	12.0	118	56	71	1.9	45	●									
119-056-12 PE5	11.9	12.0	118	56	71	1.9	45	●									
120-056-12 PE5	12.0	12.0	118	56	71	1.9	45	●									

Cutting Condition D174

●: Standard item

TaeguTec Member IMC Group

NHD...PI3

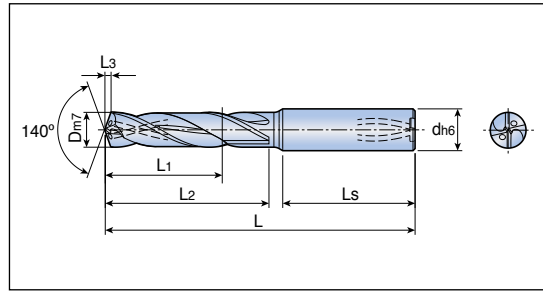
H-DRILL

Solid carbide drill with oil holes



• Drilling depth: 3xdiameter





Designation	Dimension (mm)							Grade	Designation	Dimension (mm)							Grade
	D	d	L	L_1	L_2	L_3	Ls	TT9030		D	d	L	L_1	L_2	L_3	Ls	TT9030
NHD 030-014-06 PI3	3.0	6.0	62	14	20	0.5	34	●	**NHD 065-024-08 PI3**	6.5	8.0	79	24	34	1.0	36	●
031-014-06 PI3	3.1	6.0	62	14	20	0.5	34	●	**066-024-08 PI3**	6.6	8.0	79	24	34	1.0	36	●
032-014-06 PI3	3.2	6.0	62	14	20	0.5	34	●	**067-024-08 PI3**	6.7	8.0	79	24	34	1.1	36	●
033-014-06 PI3	3.3	6.0	62	14	20	0.5	34	●	**068-024-08 PI3**	6.8	8.0	79	24	34	1.1	36	●
034-014-06 PI3	3.4	6.0	62	14	20	0.5	34	●	**069-024-08 PI3**	6.9	8.0	79	24	34	1.1	36	●
035-014-06 PI3	3.5	6.0	62	14	20	0.6	34	●	**070-024-08 PI3**	7.0	8.0	79	24	34	1.1	36	●
036-014-06 PI3	3.6	6.0	62	14	20	0.6	34	●	**071-029-08 PI3**	7.1	8.0	79	29	41	1.1	36	●
037-014-06 PI3	3.7	6.0	62	14	20	0.6	34	●	**072-029-08 PI3**	7.2	8.0	79	29	41	1.1	36	●
038-017-06 PI3	3.8	6.0	66	17	24	0.6	35	●	**073-029-08 PI3**	7.3	8.0	79	29	41	1.1	36	●
039-017-06 PI3	3.9	6.0	66	17	24	0.6	35	●	**074-029-08 PI3**	7.4	8.0	79	29	41	1.2	36	●
040-017-06 PI3	4.0	6.0	66	17	24	0.6	35	●	**075-029-08 PI3**	7.5	8.0	79	29	41	1.2	36	●
041-017-06 PI3	4.1	6.0	66	17	24	0.7	35	●	**076-029-08 PI3**	7.6	8.0	79	29	41	1.2	36	●
042-017-06 PI3	4.2	6.0	66	17	24	0.7	35	●	**077-029-08 PI3**	7.7	8.0	79	29	41	1.2	36	●
043-017-06 PI3	4.3	6.0	66	17	24	0.7	35	●	**078-029-08 PI3**	7.8	8.0	79	29	41	1.2	36	●
044-017-06 PI3	4.4	6.0	66	17	24	0.7	35	●	**079-029-08 PI3**	7.9	8.0	79	29	41	1.3	36	●
045-017-06 PI3	4.5	6.0	66	17	24	0.7	35	●	**080-029-08 PI3**	8.0	8.0	79	29	41	1.3	36	●
046-017-06 PI3	4.6	6.0	66	17	24	0.7	35	●	**081-035-10 PI3**	8.1	10.0	89	35	47	1.3	40	●
047-017-06 PI3	4.7	6.0	66	17	24	0.8	35	●	**082-035-10 PI3**	8.2	10.0	89	35	47	1.3	40	●
048-020-06 PI3	4.8	6.0	66	20	28	0.8	36	●	**083-035-10 PI3**	8.3	10.0	89	35	47	1.3	40	●
049-020-06 PI3	4.9	6.0	66	20	28	0.8	36	●	**084-035-10 PI3**	8.4	10.0	89	35	47	1.3	40	●
050-020-06 PI3	5.0	6.0	66	20	28	0.8	36	●	**085-035-10 PI3**	8.5	10.0	89	35	47	1.3	40	●
051-020-06 PI3	5.1	6.0	66	20	28	0.8	36	●	**086-035-10 PI3**	8.6	10.0	89	35	47	1.4	40	●
052-020-06 PI3	5.2	6.0	66	20	28	0.8	36	●	**087-035-10 PI3**	8.7	10.0	89	35	47	1.4	40	●
053-020-06 PI3	5.3	6.0	66	20	28	0.8	36	●	**088-035-10 PI3**	8.8	10.0	89	35	47	1.4	40	●
054-020-06 PI3	5.4	6.0	66	20	28	0.8	36	●	**089-035-10 PI3**	8.9	10.0	89	35	47	1.4	40	●
055-020-06 PI3	5.5	6.0	66	20	28	0.9	36	●	**090-035-10 PI3**	9.0	10.0	89	35	47	1.4	40	●
056-020-06 PI3	5.6	6.0	66	20	28	0.9	36	●	**091-035-10 PI3**	9.1	10.0	89	35	47	1.4	40	●
057-020-06 PI3	5.7	6.0	66	20	28	0.9	36	●	**092-035-10 PI3**	9.2	10.0	89	35	47	1.4	40	●
058-020-06 PI3	5.8	6.0	66	20	28	0.9	36	●	**093-035-10 PI3**	9.3	10.0	89	35	47	1.5	40	●
059-020-06 PI3	5.9	6.0	66	20	28	0.9	36	●	**094-035-10 PI3**	9.4	10.0	89	35	47	1.5	40	●
060-020-06 PI3	6.0	6.0	66	20	28	0.9	36	●	**095-035-10 PI3**	9.5	10.0	89	35	47	1.5	40	●
061-024-08 PI3	6.1	8.0	79	24	34	1.0	36	●	**096-035-10 PI3**	9.6	10.0	89	35	47	1.5	40	●
062-024-08 PI3	6.2	8.0	79	24	34	1.0	36	●	**097-035-10 PI3**	9.7	10.0	89	35	47	1.5	40	●
063-024-08 PI3	6.3	8.0	79	24	34	1.0	36	●	**098-035-10 PI3**	9.8	10.0	89	35	47	1.6	40	●
064-024-08 PI3	6.4	8.0	79	24	34	1.0	36	●	**099-035-10 PI3**	9.9	10.0	89	35	47	1.6	40	●

●: Standard item

Cutting Condition
D174

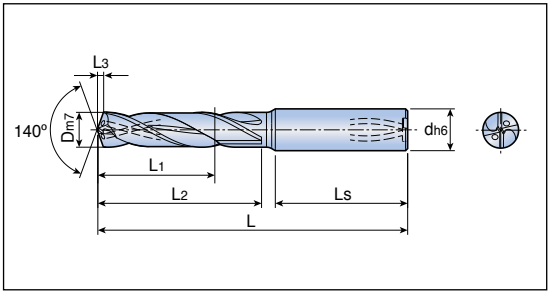
TaeguTec
Member IMC Group

NHD...PI3

H-DRILL

Solid carbide drill with oil holes





• Drilling depth: 3xdiameter

Designation	Dimension (mm)							Grade	Designation	Dimension (mm)							Grade
	D	d	L	L_1	L_2	L_3	Ls	TT9030		D	d	L	L_1	L_2	L_3	Ls	TT9030
NHD 100-035-10 PI3	10.0	10.0	89	35	47	1.6	40	●									
101-040-12 PI3	10.1	12.0	102	40	55	1.6	45	●									
102-040-12 PI3	10.2	12.0	102	40	55	1.6	45	●									
103-040-12 PI3	10.3	12.0	102	40	55	1.6	45	●									
104-040-12 PI3	10.4	12.0	102	40	55	1.6	45	●									
105-040-12 PI3	10.5	12.0	102	40	55	1.6	45	●									
106-040-12 PI3	10.6	12.0	102	40	55	1.7	45	●									
107-040-12 PI3	10.7	12.0	102	40	55	1.7	45	●									
108-040-12 PI3	10.8	12.0	102	40	55	1.7	45	●									
109-040-12 PI3	10.9	12.0	102	40	55	1.7	45	●									
110-040-12 PI3	11.0	12.0	102	40	55	1.7	45	●									
111-040-12 PI3	11.1	12.0	102	40	55	1.7	45	●									
112-040-12 PI3	11.2	12.0	102	40	55	1.8	45	●									
113-040-12 PI3	11.3	12.0	102	40	55	1.8	45	●									
114-040-12 PI3	11.4	12.0	102	40	55	1.8	45	●									
115-040-12 PI3	11.5	12.0	102	40	55	1.8	45	●									
116-040-12 PI3	11.6	12.0	102	40	55	1.8	45	●									
117-040-12 PI3	11.7	12.0	102	40	55	1.9	45	●									
118-040-12 PI3	11.8	12.0	102	40	55	1.9	45	●									
119-040-12 PI3	11.9	12.0	102	40	55	1.9	45	●									
120-040-12 PI3	12.0	12.0	102	40	55	1.9	45	●									

Cutting Condition D174

●: Standard item

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NHD...PI5

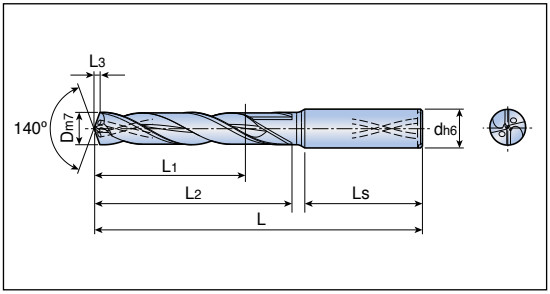
H-DRILL

Solid carbide drill with oil holes



• Drilling depth: 4-5xdiameter





Designation	Dimension (mm)							Grade	Designation	Dimension (mm)							Grade
	D	d	L	L1	L2	L3	Ls	TT9030		D	d	L	L1	L2	L3	Ls	TT9030
NHD 030-023-06 PI5	3.0	6.0	66	23	28	0.5	34	●	NHD 065-043-08 PI5	6.5	8.0	91	43	53	1.0	36	●
031-023-06 PI5	3.1	6.0	66	23	28	0.5	34	●	066-043-08 PI5	6.6	8.0	91	43	53	1.0	36	●
032-023-06 PI5	3.2	6.0	66	23	28	0.5	34	●	067-043-08 PI5	6.7	8.0	91	43	53	1.1	36	●
033-023-06 PI5	3.3	6.0	66	23	28	0.5	34	●	068-043-08 PI5	6.8	8.0	91	43	53	1.1	36	●
034-023-06 PI5	3.4	6.0	66	23	28	0.5	34	●	069-043-08 PI5	6.9	8.0	91	43	53	1.1	36	●
035-023-06 PI5	3.5	6.0	66	23	28	0.6	34	●	070-043-08 PI5	7.0	8.0	91	43	53	1.1	36	●
036-023-06 PI5	3.6	6.0	66	23	28	0.6	34	●	071-043-08 PI5	7.1	8.0	91	43	53	1.1	36	●
037-023-06 PI5	3.7	6.0	66	23	28	0.6	34	●	072-043-08 PI5	7.2	8.0	91	43	53	1.1	36	●
038-029-06 PI5	3.8	6.0	74	29	36	0.6	35	●	073-043-08 PI5	7.3	8.0	91	43	53	1.1	36	●
039-029-06 PI5	3.9	6.0	74	29	36	0.6	35	●	074-043-08 PI5	7.4	8.0	91	43	53	1.2	36	●
040-029-06 PI5	4.0	6.0	74	29	36	0.6	35	●	075-043-08 PI5	7.5	8.0	91	43	53	1.2	36	●
041-029-06 PI5	4.1	6.0	74	29	36	0.7	35	●	076-043-08 PI5	7.6	8.0	91	43	53	1.2	36	●
042-029-06 PI5	4.2	6.0	74	29	36	0.7	35	●	077-043-08 PI5	7.7	8.0	91	43	53	1.2	36	●
043-029-06 PI5	4.3	6.0	74	29	36	0.7	35	●	078-043-08 PI5	7.8	8.0	91	43	53	1.2	36	●
044-029-06 PI5	4.4	6.0	74	29	36	0.7	35	●	079-043-08 PI5	7.9	8.0	91	43	53	1.3	36	●
045-029-06 PI5	4.5	6.0	74	29	36	0.7	35	●	080-043-08 PI5	8.0	8.0	91	43	53	1.3	36	●
046-029-06 PI5	4.6	6.0	74	29	36	0.7	35	●	081-049-10 PI5	8.1	10.0	103	49	61	1.3	40	●
047-029-06 PI5	4.7	6.0	74	29	36	0.8	35	●	082-049-10 PI5	8.2	10.0	103	49	61	1.3	40	●
048-035-06 PI5	4.8	6.0	82	35	44	0.8	36	●	083-049-10 PI5	8.3	10.0	103	49	61	1.3	40	●
049-035-06 PI5	4.9	6.0	82	35	44	0.8	36	●	084-049-10 PI5	8.4	10.0	103	49	61	1.3	40	●
050-035-06 PI5	5.0	6.0	82	35	44	0.8	36	●	085-049-10 PI5	8.5	10.0	103	49	61	1.3	40	●
051-035-06 PI5	5.1	6.0	82	35	44	0.8	36	●	086-049-10 PI5	8.6	10.0	103	49	61	1.4	40	●
052-035-06 PI5	5.2	6.0	82	35	44	0.8	36	●	087-049-10 PI5	8.7	10.0	103	49	61	1.4	40	●
053-035-06 PI5	5.3	6.0	82	35	44	0.8	36	●	088-049-10 PI5	8.8	10.0	103	49	61	1.4	40	●
054-035-06 PI5	5.4	6.0	82	35	44	0.8	36	●	089-049-10 PI5	8.9	10.0	103	49	61	1.4	40	●
055-035-06 PI5	5.5	6.0	82	35	44	0.9	36	●	090-049-10 PI5	9.0	10.0	103	49	61	1.4	40	●
056-035-06 PI5	5.6	6.0	82	35	44	0.9	36	●	091-049-10 PI5	9.1	10.0	103	49	61	1.4	40	●
057-035-06 PI5	5.7	6.0	82	35	44	0.9	36	●	092-049-10 PI5	9.2	10.0	103	49	61	1.4	40	●
058-035-06 PI5	5.8	6.0	82	35	44	0.9	36	●	093-049-10 PI5	9.3	10.0	103	49	61	1.5	40	●
059-035-06 PI5	5.9	6.0	82	35	44	0.9	36	●	094-049-10 PI5	9.4	10.0	103	49	61	1.5	40	●
060-035-06 PI5	6.0	6.0	82	35	44	0.9	36	●	095-049-10 PI5	9.5	10.0	103	49	61	1.5	40	●
061-043-08 PI5	6.1	8.0	91	43	53	1.0	36	●	096-049-10 PI5	9.6	10.0	103	49	61	1.5	40	●
062-043-08 PI5	6.2	8.0	91	43	53	1.0	36	●	097-049-10 PI5	9.7	10.0	103	49	61	1.5	40	●
063-043-08 PI5	6.3	8.0	91	43	53	1.0	36	●	098-049-10 PI5	9.8	10.0	103	49	61	1.6	40	●
064-043-08 PI5	6.4	8.0	91	43	53	1.0	36	●	099-049-10 PI5	9.9	10.0	103	49	61	1.6	40	●

●: Standard item

Cutting Condition
D174

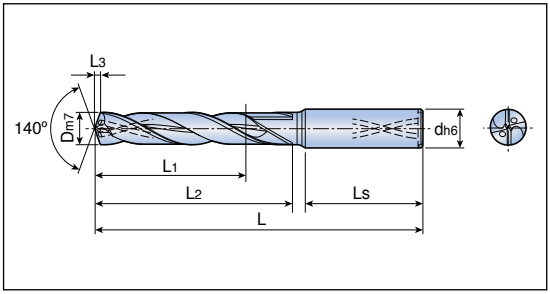
TaeguTec
Member IMC Group

NHD...PI5

H-DRILL

Solid carbide drill with oil holes





• Drilling depth: 4-5xdiameter

Designation	Dimension (mm)							Grade	Designation	Dimension (mm)							Grade
	D	d	L	L1	L2	L3	Ls	TT9030		D	d	L	L1	L2	L3	Ls	TT9030
NHD 100-049-10 PI5	10.0	10.0	103	49	61	1.6	40	●									
101-056-12 PI5	10.1	12.0	118	56	71	1.6	45	●									
102-056-12 PI5	10.2	12.0	118	56	71	1.6	45	●									
103-056-12 PI5	10.3	12.0	118	56	71	1.6	45	●									
104-056-12 PI5	10.4	12.0	118	56	71	1.6	45	●									
105-056-12 PI5	10.5	12.0	118	56	71	1.6	45	●									
106-056-12 PI5	10.6	12.0	118	56	71	1.7	45	●									
107-056-12 PI5	10.7	12.0	118	56	71	1.7	45	●									
108-056-12 PI5	10.8	12.0	118	56	71	1.7	45	●									
109-056-12 PI5	10.9	12.0	118	56	71	1.7	45	●									
110-056-12 PI5	11.0	12.0	118	56	71	1.7	45	●									
111-056-12 PI5	11.1	12.0	118	56	71	1.7	45	●									
112-056-12 PI5	11.2	12.0	118	56	71	1.8	45	●									
113-056-12 PI5	11.3	12.0	118	56	71	1.8	45	●									
114-056-12 PI5	11.4	12.0	118	56	71	1.8	45	●									
115-056-12 PI5	11.5	12.0	118	56	71	1.8	45	●									
116-056-12 PI5	11.6	12.0	118	56	71	1.8	45	●									
117-056-12 PI5	11.7	12.0	118	56	71	1.9	45	●									
118-056-12 PI5	11.8	12.0	118	56	71	1.9	45	●									
119-056-12 PI5	11.9	12.0	118	56	71	1.9	45	●									
120-056-12 PI5	12.0	12.0	118	56	71	1.9	45	●									

Cutting Condition D174

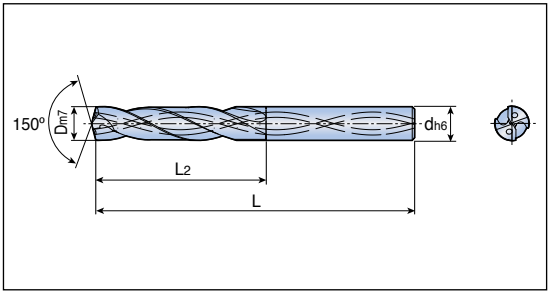
●: Standard item

TaeguTec Member IMC Group

SHO 3...-PH

Solid pilot drill with oil holes





• M.Q.L drilling is available

Designation		Dimension (mm)				Grade
		D	d	L	L2	TT9030
SHO	30403-PH	4.03	4	66	24	●
	30503-PH	5.03	5	68	30	●
	30603-PH	6.03	6	68	30	●
	30703-PH	7.03	7	73	35	●
	30803-PH	8.03	8	79	41	●
	30903-PH	9.03	9	90	48	●
	31003-PH	10.03	10	90	48	●

Cutting Condition D174

●: Standard item

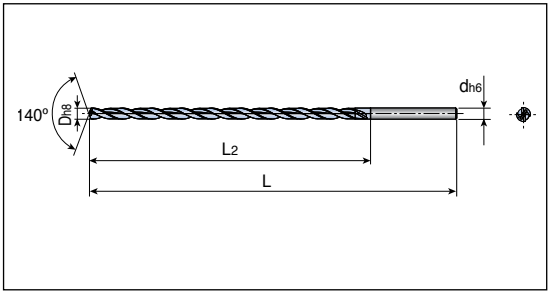
TaeguTec

SHO 10/15/20

H-DRILL

Solid long drill with oil holes





- Drilling depth: 10/15/20xdiameter
- M.Q.L drilling is available

Designation		Dimension (mm)				Grade
		D	d	L	L2	TT9030
SHO	10040	4.0	4	105	55	●
	10050	5.0	5	115	65	●
	10060	6.0	6	130	80	●
	10070	7.0	7	140	90	●
	10080	8.0	8	155	105	●
	10090	9.0	9	170	115	●
	10100	10.0	10	190	130	●
	15040	4.0	4	125	75	●
	15050	5.0	5	140	90	●
	15060	6.0	6	160	110	●
	15070	7.0	7	175	125	●
	15080	8.0	8	195	145	●
	15090	9.0	9	220	160	●
	15100	10.0	10	240	180	●
	20040	4.0	4	140	90	●
	20050	5.0	5	165	115	●
	20060	6.0	6	190	140	●
	20070	7.0	7	210	160	●
	20080	8.0	8	230	180	●
	20090	9.0	9	265	205	●
	20100	10.0	10	285	225	●

Cutting Condition D174

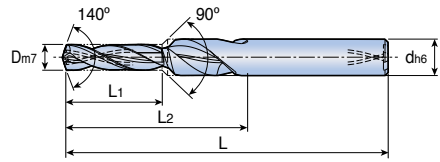
●: Standard item

TaeguTec Member IMC Group

SH0...-M

Solid carbide drill for pre-thread holes





Designation		ISO thread	Dimension (mm)					Grade
			D	L	L_1	L_2	d	TT9030
SH0	033x12x6-M4	M4	3.3	62	12	26	6	●
	042x15x6-M5	M5	4.2	66	15	28	6	●
	050x18x8-M6	M6	5.0	79	18	36	8	●
	068x24x10-M8	M8	6.8	90	24	48	10	●
	085x30x12-M10	M10	8.5	102	30	55	12	●

●: Standard item

Cutting Condition D174

TaeguTec Member IMC Group

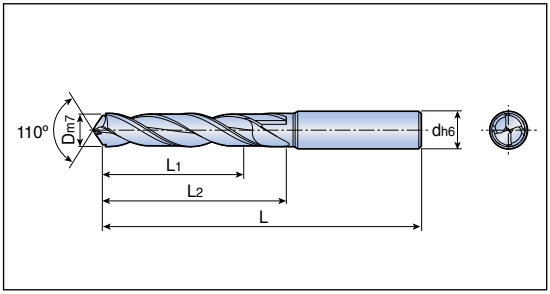
CDF

H-DRILL

Solid carbide drill for composite material







Designation	Dimension (mm)						Grade
	D (Metric)	D (Inch)	d	L	L_1	L_2	TTD610
CDF 030-027-06	3	-	6	72	27	34	●
040-027-06	4	-	6	72	27	34	●
0476-034-06	4.76	3/16	6	80	34	42	●
050-034-06	5	-	6	80	34	42	●
060-034-06	6	-	6	80	34	42	●
0635-040-08	6.35	-	8	88	40	50	●
070-040-08	7	-	8	88	40	50	●
0794-040-08	7.94	5/16	8	88	40	50	●
080-040-08	8	-	8	88	40	50	●
090-045-10	9	-	10	99	45	57	●
0952-045-10	9.52	3/8	10	99	45	57	●
100-045-10	10	-	10	99	45	57	●
110-052-12	11	-	12	114	52	67	●
1111-052-12	11.11	7/16	12	114	52	67	●
120-052-12	12	-	12	114	52	67	●
127-055-14	12.7	1/2	14	119	55	72	●

Cutting Condition D188

●: Standard item

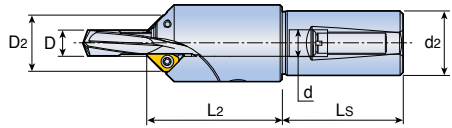
TaeguTec Member IMC Group

T-CHAMFER...T1

Chamfering tool with solid carbide drill







Designation	D range	Dimension (mm)					Insert
		d	D2	L2	Ls	d2	
T-CHAMFER 080-20T1-06	7.1-8.0	8	18.8	47.4	50	20	XCGT 06...-C..
090-20T1-06	8.1-9.0	9	19.8	47.4	50	20	D148
100-32T1-09	9.1-10.0	10	24.9	67.3	60	32	XCGT 09...-C..
110-32T1-09	10.1-11.0	11	25.9	67.3	60	32	D148
120-32T1-09	11.1-12.0	12	26.9	67.3	60	32	
130-32T1-09	12.1-13.0	13	27.9	67.3	60	32	
140-32T1-09	13.1-14.0	14	28.4	67.3	60	32	
150-32T1-09	14.1-15.0	15	29.4	67.3	60	32	
160-32T1-09	15.1-16.0	16	30.4	67.3	60	32	
170-32T1-09	16.1-17.0	17	31.4	67.3	60	32	
180-32T1-09	17.1-18.0	18	32.4	67.3	60	32	
190-32T1-09	18.1-19.0	19	33.4	75.0	60	32	
200-32T1-09	19.1-20.0	20	34.4	75.0	60	32	

Spare parts

Designation	Side screw	Back screw	L-wrench	Insert screw	Wrench
					
T-CHAMFER 080 - 090	SS M6x1x6	M6x1-SP	L-W 3	TS 25064I	TD 8
T-CHAMFER 100 - 200	SS M10x1.5x10	M10x1.5-SP	L-W 5	TS 40093I	TD 15

Assembly



D77

TaeguTec

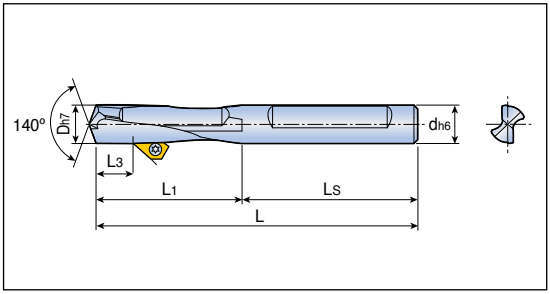
SHD 3...-CF

T-CHAMFER

Solid carbide drill for T-CHAMFER







Designation	Dimension (mm)							Grade
	D	d	L	L_1	L_S	$L_{3\ min}$	$L_{3\ max}$	TT9030
SHD 3080-CF	8.0	8.0	79	36	43	9.5	17.5	●
3090-CF	9.0	9.0	84	41	43	13.0	23.5	●
3100-CF	10.0	10.0	89	46	43	15.5	25.0	●
3110-CF	11.0	11.0	95	52	43	21.5	30.0	●
3120-CF	12.0	12.0	102	59	43	25.5	37.0	●
3130-CF	13.0	13.0	102	59	43	25.5	35.0	●
3140-CF	14.0	14.0	107	61	46	22.5	38.0	●
3150-CF	15.0	15.0	111	63	48	26.5	40.5	●
3160-CF	16.0	16.0	115	67	48	25.0	43.5	●
3170-CF	17.0	17.0	119	69	50	24.5	44.0	●
3180-CF	18.0	18.0	123	73	50	26.5	48.0	●
3190-CF	19.0	19.0	127	73	54	26.5	49.0	●
3200-CF	20.0	20.0	131	77	54	30.5	53.5	●

• 'L_3' is factored with a 45° insert positioned in insert pocket

●: Standard item

• Solid carbide drill with internal coolant holes is available on request

Insert	Chamfer angle (°)	Chamfer size
XCGT 0603-C30	30°	1.5
0603-C45	45°	4.5
0603-C60	60°	2.5
XCGT 0903-C30	30°	1.5
0903-C45	45°	6.0
0903-C60	60°	3.5

• The maximum chamfer size is obtained when using the smallest drill diameter in the drilling range

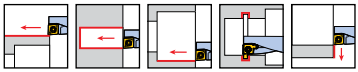
TCAP...-2.25DN

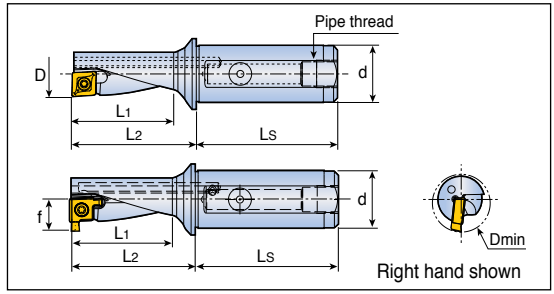
TOPCAP

Multi-function toolholder - 2.25xD



• Internal coolant





Designation		Dimension (mm)							Pipe thread	Insert	
		f	D	d	L1	L2	Ls	Dmin		For drilling, boring, turning	For grooving
TCAP	**08R/L-2.25DN**	-	8	12	18.0	22.5	42	-	G 1/16	XCM(G)T 04...TC/TA	-
	10R/L-2.25DN-GV	7.1	10	12	22.5	27.5	42	12.0	G 1/16	XCM(G)T 05...TC/TA	XCMT 05R...GV
	12R/L-2.25DN-GV	8.5	12	16	27.0	33.0	45	14.5	G 1/8	XCM(G)T 06...TC/TA	XCMT 06R...GV
	14R/L-2.25DN-GV	9.5	14	16	31.5	38.5	45	16.5	G 1/8	XCM(G)T 07...TC/TA	XCMT 07R...GV
	16R/L-2.25DN-GV	11.1	16	20	36.0	44.0	50	19.0	G 1/8	XCM(G)T 08...TC/TA	XCMT 08R...GV
	20R/L-2.25DN-GV	13.2	20	25	45.0	55.0	56	23.5	G 1/8	XCM(G)T 10...TC/TA	XCMT 10R...GV
	25R/L-2.25DN-GV	16.5	25	32	56.5	69.0	61	29.0	G 1/8	XCM(G)T 13...TC/TA	XCMT 13R...GV
	32R/L-2.25DN-GV	20.5	32	40	72.0	86.0	74	36.5	G 1/8	XCM(G)T 17...TC/TA	XCMT 17R...GV
										D150	D149

Spare parts

Designation	Screw	Wrench		
				
TCAP 08	TS 18034I/HG-P	T 6P		
TCAP 10	TS 20038I/HG-P	T 6P		
TCAP 12	TS 22052I/HG-P	T 7P		
TCAP 14	TS 25064I/HG-P	T 8P		
TCAP 16	TS 30100I/HG-P	TD 9P		
TCAP 20	TS 35088I/HG-P	TD10P		
TCAP 25	TS 45A100I/HG	TD 20		
TCAP 32	TS 45A100I/HG	TD 20		

Cutting Condition D176

TaeguTec Member IMC Group

TCAP...-3.0DN

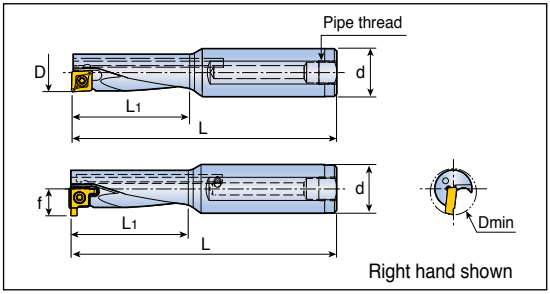
TOPCAP

Multi-function toolholder - 3.0xD



• Internal coolant





Designation		Dimension (mm)						Pipe thread	Insert	
		f	D	d	L1	L	Dmin		For drilling, boring, turning	For grooving
TCAP	08R/L-3.0DN12	-	8	12	24	80	-	G 1/16	XCM(G)T 04...TC/TA	-
	10R/L-3.0DN-GV	7.1	10	12	30	85	12.0	G 1/16	XCM(G)T 05...TC/TA	XCMT 05R...GV
	12R/L-3.0DN-GV	8.5	12	16	36	95	14.5	G 1/8	XCM(G)T 06...TC/TA	XCMT 06R...GV
	14R/L-3.0DN-GV	9.5	14	16	42	100	16.5	G 1/8	XCM(G)T 07...TC/TA	XCMT 07R...GV
	16R/L-3.0DN-GV	11.1	16	20	48	110	19.0	G 1/8	XCM(G)T 08...TC/TA	XCMT 08R...GV
	20R/L-3.0DN-GV	13.2	20	25	60	130	23.5	G 1/8	XCM(G)T 10...TC/TA	XCMT 10R...GV
	25R/L-3.0DN-GV	16.5	25	32	75	150	29.0	G 1/8	XCM(G)T 13...TC/TA	XCMT 13R...GV
	32R/L-3.0DN-GV	20.5	32	40	96	185	36.5	G 1/8	XCM(G)T 17...TC/TA	XCMT 17R...GV
									D150	D149

Spare parts

Designation	Screw	Wrench		
TCAP 08	TS 18034I/HG-P	T 6P		
TCAP 10	TS 20038I/HG-P	T 6P		
TCAP 12	TS 22052I/HG-P	T 7P		
TCAP 14	TS 25064I/HG-P	T 8P		
TCAP 16	TS 30100I/HG-P	TD 9P		
TCAP 20	TS 35088I/HG-P	TD10P		
TCAP 25	TS 45A100I/HG	TD 20		
TCAP 32	TS 45A100I/HG	TD 20		

Cutting Condition D176

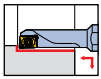
S...SXUCR/L

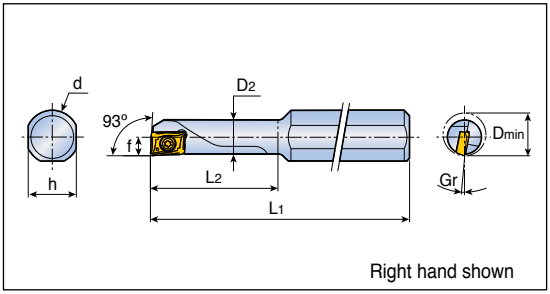
TOPCAP

Boring bars with TOPCAP inserts



- For boring
- External coolant





Right hand shown

Designation	Dimension (mm)								Insert
	d	D2	h	L1	L2	f	Dmin	Gr	
S10H SXUCR/L 04-06 (1)	10	5.4	9	100	20	3.0	6	9°	XCMT 04...R/L TC D150
S10J SXUCR/L 04-07 (1)	10	6.4	9	110	23	3.5	7	5°	
S10J SXUCR/L 04-08 (1)	10	7.4	9	110	27	4.0	8	2°	
S10K SXUCR/L 05-10	10	9.0	9	125	34	5.0	10	2°	XCMT 05..TC D150

- (1) Right hand Insert should be used in right hand boring bar

Spare parts

Designation	Screw	Wrench		
S10H SXUCR/L 04-06	TS 18034I/HG	T 6P		
S10J SXUCR/L 04-07	TS 18034I/HG	T 6P		
S10J SXUCR/L 04-08	TS 18034I/HG	T 6P		
S10K SXUCR/L 05-10	TS 20038I/HG-P	T 6P		

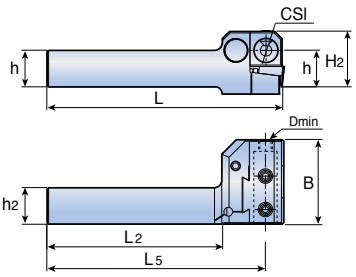
Cutting Condition D176

TaeguTec Member IMC Group

TGHR

Clamping units (Centre alignment system)





Designation		Dimension (mm)								Toolholders
		h	h2	CSI	H2	B	L2	L5	L	
TGHR	**2020-D16**	20	20	16	38	58	120	150	161	TCAP 08R/L...
	2525-D16	25	25	16	38	58	120	150	161	TCAP 10R/L...
										TCAP 12R/L...
										TCAP 14R/L...
	2525-D25	25	25	25	56	75	120	157	174	TCAP 16R/L...
										TCAP 20R/L...

Spare parts

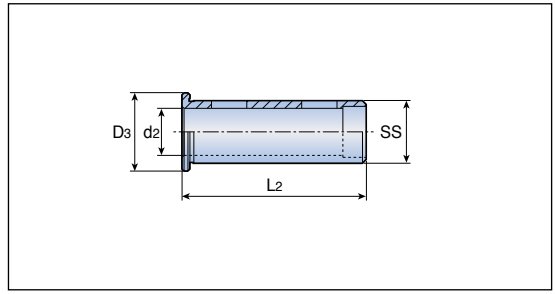
Designation	Block	Wedge	Snap ring	Wedge screw	Mounting pin	Mounting pin screw	Mounting screw		Lock screw	Wrench
										
TGHR 2020-D16	TGHR-D16-BL	TGHR-WD	WSR 4	TGH-WS	TGH-MPI	TGH-MPS	SSxM8 1.25X10-C	SSxM8 x1.25x8	-	L-W 4
TGHR 2525-D16										
TGHR 2525-D25	TGHR-D25-BL	TGHR-WD-25	WSR 4	TGH-WS-25	TGH-MPI-25	TGH-MPS-25	SS M10 x1.5x12-C	SS M101.5x10	SH M6x1x20	L-W 4 L-W 5

TSL

TOPCAP

Sleeves for clamping units





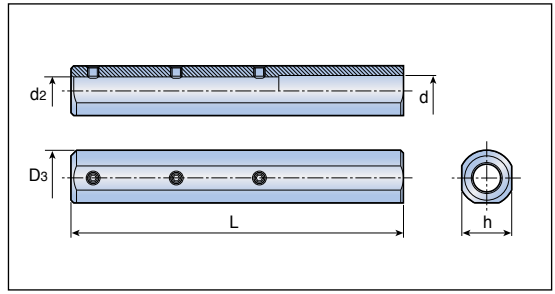
Designation	Dimension (mm)				Toolholders
	SS	d2	D3	L2	
TSL 16-12	16	12	20	47	TCAP 10R/L...
25-20	25	20	32	55	TCAP 16R/L...

TBSL

TOPCAP

Sleeves for boring bar





Designation	Dimension (mm)				
	D3	d2	d	L	h
TBSL 20-10-120	20	10	11	120	18

Spare parts

Designation	Screw	Wrench		
				
TBSL 20-10-120	SS M4x0.7x4	L-W 2		

TaeguTec
Member IMC Group

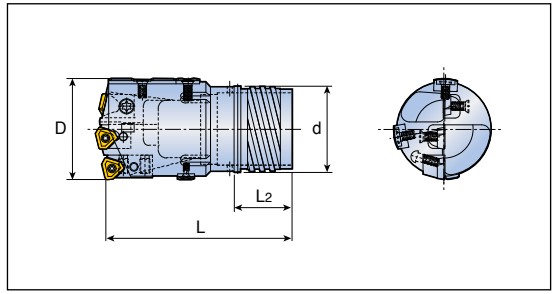
Deep Drilling Holders



TBTA3...SE4

Single tube system





• Outer four start thread

Designation		D range	Dimension (mm)			Tube	
			L	L2	d	Part	Diameter (mm)
TBTA3-	**xxx.xxSE4-33**	38.00-39.60	85	30.5	30	BTSI 033	33
	xxx.xxSE4-36	39.61-43.00	85	30.5	33	BTSI 036	36
	xxx.xxSE4-39	43.01-47.00	95	30.5	36	BTSI 039	39
	xxx.xxSE4-43	47.01-51.70	95	30.5	39	BTSI 043	43
	xxx.xxSE4-47	51.71-56.20	100	34.5	43	BTSI 047	47
	xxx.xxSE4-51	56.21-60.60	110	34.5	47	BTSI 051	51
	xxx.xxSE4-56A	60.61-65.00	110	34.5	51	BTSI 056A	56
	xxx.xxSE4-56B	65.00-66.99	150	62	52	BTSI 056B	56
	xxx.xxSE4-62	67.00-72.99	150	62	58	BTSI 062	62
	xxx.xxSE4-68	73.00-79.99	150	62	63	BTSI 068	68
	xxx.xxSE4-75	80.00-86.99	180	82	70	BTSI 075	75
	xxx.xxSE4-82	87.00-99.99	180	82	77	BTSI 082	82
	xxx.xxSE4-94	100.00-106.99	180	82	89	BTSI 094	94

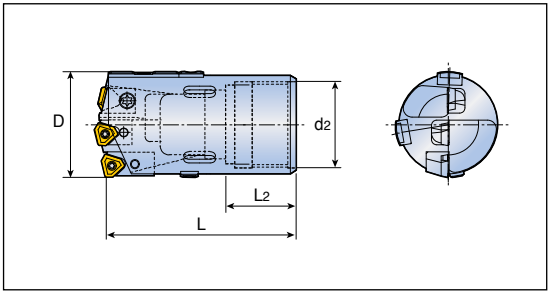
Assembly D87 | Tube D119 | Cutting Condition D178

TaeguTec Member IMC Group

TBTA3...SI1

Single tube system





• Inner single start thread

Designation	D range	Dimension (mm)			Tube	
		L	L2	d2	Part	Diameter (mm)
TBTA3- xxx.xxSI1-33	38.00-39.99	80	40	30	BTSE 033	33
xxx.xxSI1-36	40.00-43.99	80	40	33	BTSE 036	36
xxx.xxSI1-39	44.00-46.99	90	40	37	BTSE 039	39
xxx.xxSI1-43	47.00-51.99	90	40	41	BTSE 043	43
xxx.xxSI1-47	52.00-56.99	100	40	44	BTSE 047	47
xxx.xxSI1-51	57.00-60.99	110	40	49	BTSE 051	51
xxx.xxSI1-56	61.00-67.99	110	40	53	BTSE 056	56
xxx.xxSI1-62	68.00-74.99	120	40	59	BTSE 062	62
xxx.xxSI1-68	75.00-80.99	150	70	65	BTSE 068	68
xxx.xxSI1-75	81.00-90.99	150	70	71	BTSE 075	75
xxx.xxSI1-82	91.00-98.99	150	70	79	BTSE 082	82
xxx.xxSI1-94	99.00-106.99	150	70	90	BTSE 094	94

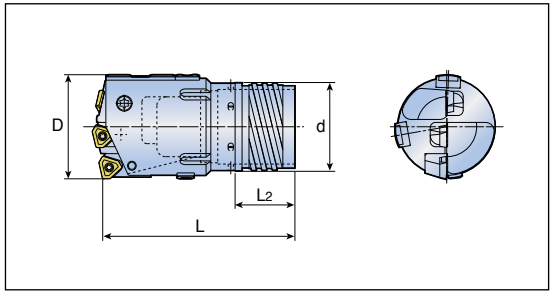
Assembly D87 | Tube D119 | Cutting Condition D178

TaeguTec Member IMC Group

TBTA3...DE4

Double tube system





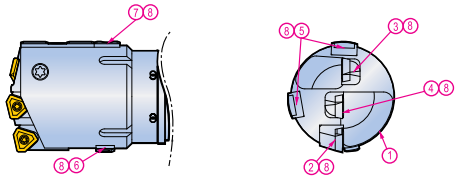
• Outer four start thread

Designation		D range	Dimension (mm)			Tube		
			L	L2	d	Outer tube	Inner tube	Diameter (mm)
TBTA3-	**xxx.xxDE4-35.5**	38.00-39.60	85	30.5	33	BTDO 035.5	BTDI 026	35.5
	xxx.xxDE4-39	39.61-43.00	85	30.5	36	BTDO 039	BTDI 029	39.0
	xxx.xxDE4-42.5	43.01-47.00	95	30.5	39	BTDO 042.5	BTDI 032	42.5
	xxx.xxDE4-46.5	47.01-51.70	95	34.5	43	BTDO 046.5	BTDI 035	46.5
	xxx.xxDE4-51	51.71-56.20	100	34.5	47	BTDO 051	BTDI 039	51.0
	xxx.xxDE4-55.5	56.21-65.00	110	34.5	51	BTDO 055.5	BTDI 043A	55.5
	xxx.xxDE4-56	65.00-66.99	150	62	52	BTDO 056	BTDI 043B	56.0
	xxx.xxDE4-62	67.00-72.99	150	62	58	BTDO 062	BTDI 048	62.0
	xxx.xxDE4-68	73.00-79.99	150	62	63	BTDO 068	BTDI 053	68.0
	xxx.xxDE4-75	80.00-86.99	180	82	70	BTDO 075	BTDI 059	75.0
	xxx.xxDE4-82	87.00-99.99	180	82	77	BTDO 082	BTDI 066	82.0
	xxx.xxDE4-94	100.00-106.99	180	82	89	BTDO 094	BTDI 078	94.0

Assembly D87 | Tube D119 | Cutting Condition D178

TBTA3 Series

Assembly of TBTA3 series



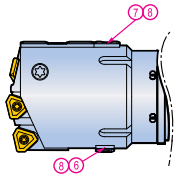
1. Head shank
2. Outer cartridge
3. Inner cartridge
4. Center cartridge
5. Guide pad
6. Sub guide pad
7. Guide pad protector
8. Lock screw

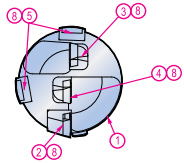
	Parts	Diameter (mm)				
		38.00-39.99	40.00-44.99	45.00-47.99	48.00-51.99	52.00-54.99
Cartridge	Outer	PERC 05R	PERC 402-04	PERC 402-04	PERC 402-04	PERC 402-32
	Adjust screw	AS0003-5	AS0004-8	AS0004-8	AS0004-8	AS0005-10
	Wrench	H1.5	H2	H2	H2	H2.5
	Screw	LS1803RH	LS1803.5RH	LS1803.5RH	LS1803.5RH	LS1805RH
	Wrench	H2	H2.5	H2.5	H2.5	H3
	Inner	CENC 05R	CENC 05R	CENC 05R	CENC 402-04	CENC 402-04
	Screw	CSTB3	CSTB3	CSTB3	CSTB3.5	CSTB3.5
	Wrench	T9	T9	T9	T15	T15
	Center	CENC 05R	CENC 05R	CENC 402-04	CENC 402-04	CENC 402-04
	Screw	CSTB3	CSTB3	CSTB3.5	CSTB3.5	CSTB3.5
	Wrench	T9	T9	T15	T15	T15
Insert	Outer	NPMX 0803RG	TPMX 1403RG	TPMX 1403RG	TPMX 1403RG	TPMX 1704RG
	Screw	CSTB2.2	CSTB2.5	CSTB2.5	CSTB2.5	CSTB3.5D
	Wrench	T7	T8	T8	T8	T9
	Inner	NPMX 0803RG	NPMX 0803RG	NPMX 0803RG	TPMX 1403RG	TPMX 1403RG
	Screw	CSTB2.2	CSTB2.2	CSTB2.2	CSTB2.5	CSTB2.5
	Wrench	T7	T7	T7	T8	T8
	Center	NPMX 0803RG	NPMX 0803RG	TPMX 1403RG	TPMX 1403RG	TPMX 1403RG
	Screw	CSTB2.2	CSTB2.2	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T7	T7	T8	T8	T8
Pad	Guide pad	PAD-GO08CD-SA-FB	PAD-GO08CD-SA-FB	PAD-GC10-SA	PAD-GC10-SA	PAD-GC10-SA
		PAD-GO08CD-SB-FB	PAD-GO08CD-SB-FB	PAD-GC10-SB	PAD-GC10-SB	PAD-GC10-SB
	Screw	CSTB3S	CSTB3S	CSTB4S	CSTB4S	CSTB4S
	Wrench	T9	T9	T15	T15	T15
	Guide pad protector	PAD-P08	PAD-P08	PAD-P10	PAD-P10	PAD-P10
	Screw	CSTB3S	CSTB3S	CSTB4S	CSTB4S	CSTB4S
	Wrench	T9	T9	T15	T15	T15
	Sub guide pad	PAD-S08	PAD-S08	PAD-S08	PAD-S08	PAD-S08
	Screw	CSTB3S	CSTB3S	CSTB3S	CSTB3S	CSTB3S
	Wrench	T9	T9	T9	T9	T9

D152 Guide Pad D155 Cartridge D158

TBTA3 Series

Assembly of TBTA3 series





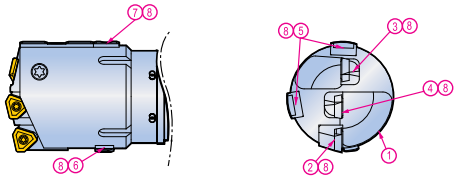
1. Head shank
2. Outer cartridge
3. Inner cartridge
4. Center cartridge
5. Guide pad
6. Sub guide pad
7. Guide pad protector
8. Lock screw

	Parts	Diameter (mm)				
		55.00-57.99	58.00-59.99	60.00-63.99	64.00-67.99	68.00-77.99
Cartridge	Outer	PERC 402-32	PERC 402-32	PERC 402-32	PERC 402-43	PERC 402-32
	Adjust screw	AS0005-10	AS0005-10	AS0005-10	AS0005-15	AS0005-10
	Wrench	H2.5	H2.5	H2.5	H2.5	H2.5
	Screw	LS1805RH	LS1805RH	LS1805RH	LS1806RH	LS1805RH
	Wrench	H3	H3	H3	H4	H3
	Inner	CENC 402-04	CENC 402-32	CENC 402-32	CENC 402-32	CENC 402-43
	Screw	CSTB3.5	CSTA5	CSTA5	CSTA5	LS1206
	Wrench	T15	T15	T15	T15	H3
	Center	CENC 402-32	CENC 402-32	CENC 402-32	CENC 402-32	CENC 402-43
	Screw	CSTA5	CSTA5	CSTA5	CSTA5	LS1206
	Wrench	T15	T15	T15	T15	H3
Insert	Outer	TPMX 1704RG	TPMX 1704RG	TPMX 1704RG	TPMX 2405RG	TPMX 1704RG
	Screw	CSTB3.5D	CSTB3.5D	CSTB3.5D	CSTB4M	CSTB3.5D
	Wrench	T9	T9	T9	T15	T9
	Inner	TPMX 1403RG	TPMX 1704RG	TPMX 1704RG	TPMX 1704RG	TPMX 2405RG
	Screw	CSTB2.5	CSTB3.5D	CSTB3.5D	CSTB3.5D	CSTB4M
	Wrench	T8	T9	T9	T9	T15
	Center	TPMX 1704RG	TPMX 1704RG	TPMX 1704RG	TPMX 1704RG	TPMX 2405RG
	Screw	CSTB3.5D	CSTB3.5D	CSTB3.5D	CSTB3.5D	CSTB4M
	Wrench	T9	T9	T9	T9	T15
Pad	Guide pad	PAD-GC10-SA	PAD-GC10-SA	PAD-GC14-SB	PAD-GC14-SB	PAD-GC14-SB
		PAD-GC10-SB	PAD-GC10-SB	-	-	-
	Screw	CSTB4S	CSTB4S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T15	T15	T15	T15	T15
	Guide pad protector	PAD-P10	PAD-P10	PAD-P14	PAD-P14	PAD-P14
	Screw	CSTB4S	CSTB4S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T15	T15	T15	T15	T15
	Sub guide pad	PAD-S08	PAD-S08	PAD-S08	PAD-S10	PAD-S10
	Screw	CSTB3S	CSTB3S	CSTB3S	CSTB3S	CSTB3S
	Wrench	T9	T9	T9	T9	T9

D152 Guide Pad D155 Cartridge D158

TBTA3 Series

Assembly of TBTA3 series



1. Head shank
2. Outer cartridge
3. Inner cartridge
4. Center cartridge
5. Guide pad
6. Sub guide pad
7. Guide pad protector
8. Lock screw

	Parts	Diameter (mm)			
		78.00-84.99	85.00-91.99	92.00-98.99	99.00-106.99
Cartridge	Outer	PERC 402-43	PERC 402-63	PERC 402-43	PERC 402-63
	Adjust screw	AS0005-15	AS0006-15	AS0005-15	AS0006-15
	Wrench	H2.5	H3	H2.5	H3
	Screw	LS1806RH	LS1806RH	LS1806RH	LS1806RH
	Wrench	H4	H4	H4	H4
	Inner	CENC 402-43	CENC 402-43	CENC 402-63	CENC 402-63
	Screw	LS1206	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3	H3
	Center	CENC 402-43	CENC 402-43	CENC 402-63	CENC 402-63
	Screw	LS1206	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3	H3
Insert	Outer	TPMX 2405RG	TPMX 2807RG	TPMX 2405RG	TPMX 2807RG
	Screw	CSTB4M	CSTB5	CSTB4M	CSTB5
	Wrench	T15	T20	T15	T20
	Inner	TPMX 2405RG	TPMX 2405RG	TPMX 2807RG	TPMX 2807RG
	Screw	CSTB4M	CSTB4M	CSTB5	CSTB5
	Wrench	T15	T15	T20	T20
	Center	TPMX 2405RG	TPMX 2405RG	TPMX 2807RG	TPMX 2807RG
	Screw	CSTB4M	CSTB4M	CSTB5	CSTB5
	Wrench	T15	T15	T20	T20
Pad	Guide pad	PAD-GC14-SB	PAD-GC14-SB	PAD-GC14-SB	PAD-GC18-SB
	Screw	CSTA5S	CSTA5S	CSTA5S	LS1206S
	Wrench	T15	T15	T15	H3
	Guide pad protector	PAD-P14	PAD-P14	PAD-P14	PAD-P18
	Screw	CSTB5S	CSTB5S	CSTA5S	LS1206S
	Wrench	T15	T15	T15	H3
	Sub guide pad	PAD-S10	PAD-S10	PAD-S10	PAD-S14
	Screw	CSTB3S	CSTB3S	CSTB3S	CSTA5S
	Wrench	T9	T9	T9	T15

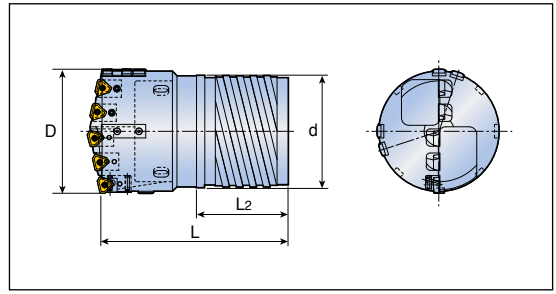
D152 Guide Pad D155 Cartridge D158

TBTA5...SE4

T-DEEP

Single tube system





• Outer four start thread

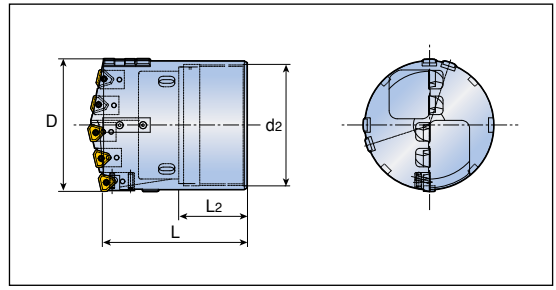
Designation		D range	Dimension (mm)			Tube	
			L	L_2	d	Part	Diameter (mm)
TBTA5-	**xxx.xxSE4-094**	107.00-111.99	180	82	89	BTSI 094	94
	xxx.xxSE4-106	112.00-123.99	205	102	101	BTSI 106	106
	xxx.xxSE4-118	124.00-135.99	205	102	113	BTSI 118	118
	xxx.xxSE4-130	136.00-147.99	205	102	125	BTSI 130	130
	xxx.xxSE4-142	148.00-159.99	225	122	137	BTSI 142	142
	xxx.xxSE4-154	160.00-168.99	225	122	149	BTSI 154	154

TBTA5...SI1

T-DEEP

Single tube system





• Inner single start thread

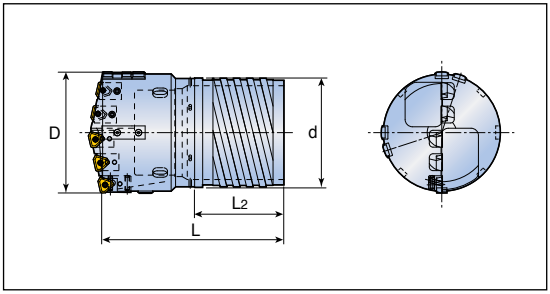
Designation		D range	Dimension (mm)			Tube	
			L	L_2	d_2	Part	Diameter (mm)
TBTA5-	**xxx.xxSI1-094**	107.00-110.99	150	70	90	BTSE 094	94
	xxx.xxSI1-106	111.00-122.99	150	70	102	BTSE 106	106
	xxx.xxSI1-118	123.00-134.99	150	70	114	BTSE 118	118
	xxx.xxSI1-130	135.00-148.99	150	70	126	BTSE 130	130
	xxx.xxSI1-142	149.00-161.99	150	70	139	BTSE 142	142
	xxx.xxSI1-154	162.00-168.99	190	85	151	BTSE 154	154

Assembly D92 | Tube D119 | Cutting Condition D178

TBTA5...DE4

Double tube system





• Outer four start thread

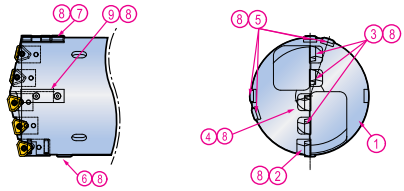
Designation	D Range	Dimension (mm)			Tube		
		L	L2	d	Part		Diameter (mm)
TBTA5- xxx.xxDE4-094	107.00-111.99	180	82	89	BTDO 094	BTDI 078	94
xxx.xxDE4-106	112.00-123.99	205	102	101	BTDO 106	BTDI 090	106
xxx.xxDE4-118	124.00-135.99	205	102	113	BTDO 118	BTDI 092	118
xxx.xxDE4-130	136.00-147.99	205	102	125	BTDO 130	BTDI 093	130
xxx.xxDE4-142	148.00-159.99	225	122	137	BTDO 142	BTDI 094	142
xxx.xxDE4-154	160.00-168.99	225	122	149	BTDO 154	BTDI 095	154

Assembly D92 | Tube D119 | Cutting Condition D178

TaeguTec Member IMC Group

TBTA5 Series

Assembly of TBTA5 series



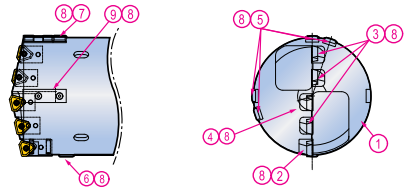
1. Head shank
2. Outer cartridge
3. Inner cartridge
4. Center cartridge
5. Guide pad
6. Sub guide pad
7. Guide pad protector
8. Lock screw
9. Filler

	Parts	Diameter (mm)			
		107.00-117.99	118.00-135.99	136.00-144.99	145.00-150.99
Cartridge	Outer	PERC 402-43	PERC 402-43	PERC 402-43	PERC 402-43
	Adjust screw	AS0005-15	AS0005-15	AS0005-15	AS0005-15
	Wrench	H2.5	H2.5	H2.5	H2.5
	Screw	LS1806RH	LS1806RH	LS1806RH	LS1806RH
	Wrench	H4	H4	H4	H4
	Inner	CENC 402-32	CENC 402-43	CENC 402-43	CENC 402-43
	Screw	CSTA5	LS1206	LS1206	LS1206
	Wrench	T15	H3	H3	H3
	Center	CENC 402-43	CENC 402-43	CENC 402-63	CENC 402-63
	Screw	LS1206	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3	H3
Insert	Outer	TPMX 2405RG	TPMX 2405RG	TPMX 2405RG	TPMX 2405RG
	Screw	CSTB4M	CSTB4M	CSTB4M	CSTB4M
	Wrench	T15	T15	T15	T15
	Inner	TPMX 1704RG	TPMX 2405RG	TPMX 2405RG	TPMX 2405RG
	Screw	CSTB3.5D	CSTB4M	CSTB4M	CSTB4M
	Wrench	T9	T15	T15	T15
	Center	TPMX 2405RG	TPMX 2405RG	TPMX 2807RG	TPMX 2807RG
	Screw	CSTB4M	CSTB4M	CSTB5	CSTB5
	Wrench	T15	T15	T20	T20
Pad	Guide pad	PAD-GC18-SB	PAD-GC18-SB	PAD-GC18-SB	PAD-GC18-SB
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Guide pad protector	PAD-P18	PAD-P18	PAD-P18	PAD-P18
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Sub guide pad	PAD-S14	PAD-S14	PAD-S14	PAD-S14
	Screw	CSTA5S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T15	T15	T15	T15

D153 Guide Pad D155 Cartridge D158

TBTA5 Series

Assembly of TBTA5 series



1. Head shank
2. Outer cartridge
3. Inner cartridge
4. Center cartridge
5. Guide pad
6. Sub guide pad
7. Guide pad protector
8. Lock screw
9. Filler

	Parts	Diameter (mm)		
		151.00-156.99	157.00-162.99	163.00-168.99
Cartridge	Outer	PERC 402-63	PERC 402-63	PERC 402-63
	Adjust screw	AS0006-15	AS0006-15	AS0006-15
	Wrench	H3	H3	H3
	Screw	LS1806RH	LS1806RH	LS1806RH
	Wrench	H4	H4	H4
	Inner	CENC 402-43	CENC 402-43	CENC 402-63
	Screw	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3
	Center	CENC 402-63	CENC 402-63	CENC 402-63
	Screw	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3
Insert	Outer	TPMX 2807RG	TPMX 2807RG	TPMX 2807RG
	Screw	CSTB5	CSTB5	CSTB5
	Wrench	T20	T20	T20
	Inner	TPMX 2405RG	TPMX 2405RG	TPMX 2807RG
	Screw	CSTB4M	CSTB4M	CSTB5
	Wrench	T15	T15	T20
	Center	TPMX 2807RG	TPMX 2807RG	TPMX 2807RG
	Screw	CSTB5	CSTB5	CSTB5
	Wrench	T20	T20	T20
Pad	Guide pad	PAD-GC18-SB	PAD-GC18-SB	PAD-GC18-SB
	Screw	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3
	Guide pad protector	PAD-P18	PAD-P18	PAD-P18
	Screw	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3
	Sub guide pad	PAD-S14	PAD-S14	PAD-S14
	Screw	CSTA5S	CSTA5S	CSTA5S
	Wrench	T15	T15	T15

D153 Guide Pad D155 Cartridge D158

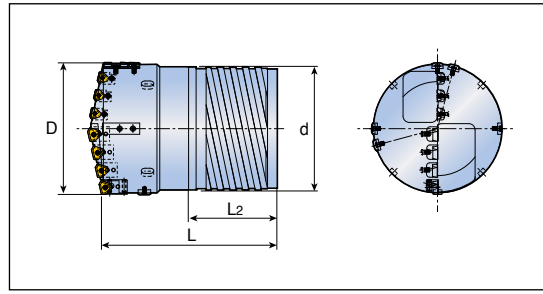
TaeguTec Member IMC Group

TBTA7...SE4

T-DEEP

Single tube system





- Outer four start thread
- Double tube system also available on request

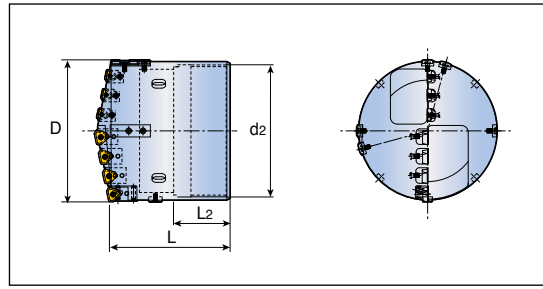
Designation		D range	Dimension (mm)			Tube	
			L	L2	d	Part	Diameter (mm)
TBTA7-	**xxx.xxSE4-154**	169.00-171.99	230	122	149	BTSI 154	154
	xxx.xxSE4-166	172.00-183.99	230	122	161	BTSI 166	166
	xxx.xxSE4-178	184.00-195.99	250	142	173	BTSI 178	178
	xxx.xxSE4-190	196.00-207.99	250	142	185	BTSI 190	190
	xxx.xxSE4-202	208.00-219.99	250	142	197	BTSI 202	202
	xxx.xxSE4-214	220.00-231.99	270	162	208	BTSI 214	214
	xxx.xxSE4-226	232.00-232.99	270	162	220	BTSI 226	226

TBTA7...SI1

T-DEEP

Single tube system





- Inner single start thread

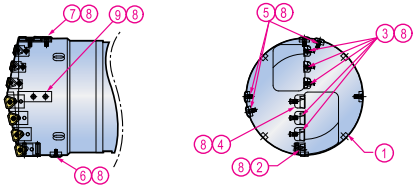
Designation		D range	Dimension (mm)			Tube	
			L	L2	d2	Part	Diameter (mm)
TBTA7-	**xxx.xxSI1-154**	169.00-173.99	190	85	145	BTSE 154	154
	xxx.xxSI1-166	174.00-185.99	190	85	157	BTSE 166	166
	xxx.xxSI1-178	186.00-197.99	190	85	169	BTSE 178	178
	xxx.xxSI1-190	198.00-209.99	190	85	181	BTSE 190	190
	xxx.xxSI1-202	210.00-221.99	190	85	193	BTSE 202	202
	xxx.xxSI1-214	222.00-233.99	190	85	205	BTSE 214	214

Assembly D95 | Tube D119 | Cutting Condition D178

TaeguTec

TBTA7 Series

Assembly of TBTA7 series



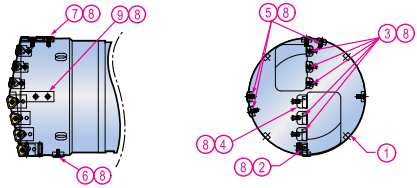
1. Head shank
2. Outer cartridge
3. Inner cartridge
4. Center cartridge
5. Guide pad
6. Sub guide pad
7. Guide pad protector
8. Lock screw
9. Filler

	Parts	Diameter (mm)			
		169.00-188.99	189.00-196.99	197.00-202.99	203.00-208.99
Cartridge	Outer	PERC 402-43	PERC 402-43	PERC 402-43	PERC 402-43
	Adjust screw	AS0005-15	AS0005-15	AS0005-15	AS0005-15
	Wrench	H2.5	H2.5	H2.5	H2.5
	Screw	LS1806RH	LS1806RH	LS1806RH	LS1806RH
	Wrench	H4	H4	H4	H4
	Inner	CENC 402-43	CENC 402-43	CENC 402-43	CENC 402-43
	Screw	LS1206	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3	H3
	Center	CENC 402-43	CENC 402-63	CENC 402-63	CENC 402-63
	Screw	LS1206	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3	H3
Insert	Outer	TPMX 2405RG	TPMX 2405RG	TPMX 2405RG	TPMX 2405RG
	Screw	CSTB4M	CSTB4M	CSTB4M	CSTB4M
	Wrench	T15	T15	T15	T15
	Inner	TPMX 2405RG	TPMX 2405RG	TPMX 2405RG	TPMX 2405RG
	Screw	CSTB4M	CSTB4M	CSTB4M	CSTB4M
	Wrench	T15	T15	T15	T15
	Center	TPMX 2405RG	TPMX 2807RG	TPMX 2807RG	TPMX 2807RG
	Screw	CSTB4M	CSTB5	CSTB5	CSTB5
	Wrench	T15	T20	T20	T20
Pad	Guide pad	PAD-GC18-SB	PAD-GC18-SB	PAD-GC18-SB	PAD-GC18-SB
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Guide pad protector	PAD-P18	PAD-P18	PAD-P18	PAD-P18
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Sub guide pad	PAD-S14	PAD-S14	PAD-S14	PAD-S14
	Screw	CSTA5S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T15	T15	T15	T15

D153 Guide Pad D155 Cartridge D158

TBTA7 Series

Assembly of TBTA7 series



1. Head shank
2. Outer cartridge
3. Inner cartridge
4. Center cartridge
5. Guide pad
6. Sub guide pad
7. Guide pad protector
8. Lock screw
9. Filler

Parts		Diameter (mm)			
		209.00-214.99	215.00-220.99	221.00-226.99	227.00-232.99
Cartridge	Outer	PERC 402-63	PERC 402-63	PERC 402-63	PERC 402-63
	Adjust screw	AS0006-15	AS0006-15	AS0006-15	AS0005-15
	Wrench	H3	H3	H3	H3
	Screw	L1806RH	L1806RH	L1806RH	LS1806RH
	Wrench	H4	H4	H4	H4
	Inner	CENC 402-43	CENC 402-43	CENC 402-43	CENC 402-63
	Screw	LS1206	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3	H3
	Center	CENC 402-63	CENC 402-63	CENC 402-63	CENC 402-63
	Screw	LS1206	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3	H3
Insert	Outer	TPMX 2807RG	TPMX 2807RG	TPMX 2807RG	TPMX 2807RG
	Screw	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T20	T20	T20	T20
	Inner	TPMX 2405RG	TPMX 2405RG	TPMX 2405RG	TPMX 2807RG
	Screw	CSTB4M	CSTB4M	CSTB4M	CSTB4M
	Wrench	T15	T15	T15	T15
	Center	TPMX 2807RG	TPMX 2807RG	TPMX 2807RG	TPMX 2807RG
	Screw	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T20	T20	T20	T20
Pad	Guide pad	PAD-GC18-SB	PAD-GC18-SB	PAD-GC18-SB	PAD-GC18-SB
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Guide pad protector	PAD-P18	PAD-P18	PAD-P18	PAD-P18
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Sub guide pad	PAD-S14	PAD-S14	PAD-S14	PAD-S14
	Screw	CSTA5S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T15	T15	T15	T15

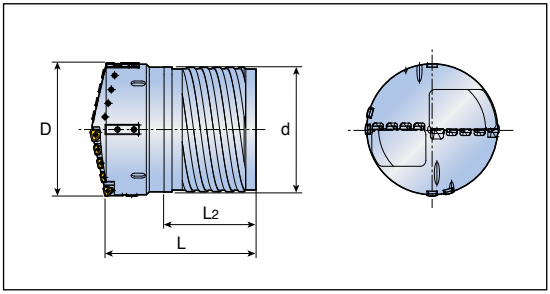
D153 Guide Pad D155 Cartridge D158

TBTA9...SE4

T-DEEP

Single tube system





• Outer four start thread

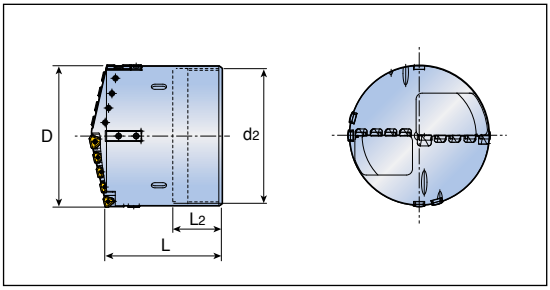
Designation		D range	Dimension (mm)			Tube	
			L	L2	d	Part	Diameter (mm)
TBTA9-	xxx.xxSE4-226	233.00-243.99	294	164	220	BTSI 226	226
	xxx.xxSE4-238	244.00-255.99	294	164	232	BTSI 238	238
	xxx.xxSE4-250	256.00-267.99	322	184	244	BTSI 250	250
	xxx.xxSE4-262	268.00-279.99	323	184	256	BTSI 262	262
	xxx.xxSE4-274	280.00-291.99	325	184	268	BTSI 274	274

TBTA9...SI1

T-DEEP

Single tube system





• Inner single start thread

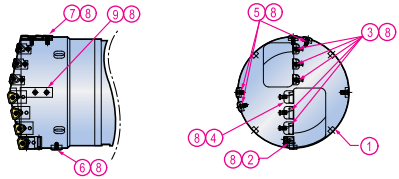
Designation		D range	Dimension (mm)			Tube	
			L	L2	d2	Part	Diameter (mm)
TBTA9-	xxx.xxSI1-214	233.00-233.99	217	86	211	BTSE 214	214
	xxx.xxSI1-226	234.00-245.99	219	86	223	BTSE 226	226
	xxx.xxSI1-238	246.00-257.99	221	86	235	BTSE 238	238
	xxx.xxSI1-250	258.00-269.99	242	121	247	BTSE 250	250
	xxx.xxSI1-262	270.00-281.99	244	121	259	BTSE 262	262
	xxx.xxSI1-274	282.00-293.99	245	121	271	BTSE 274	274

Assembly D98 | Tube D119 | Cutting Condition D178

TaeguTec Member IMC Group

TBTA9 Series

Assembly of TBTA9 series



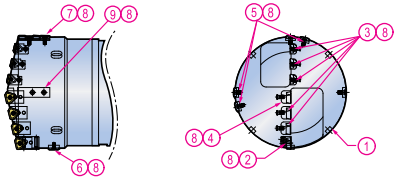
1. Head shank
2. Outer cartridge
3. Inner cartridge
4. Center cartridge
5. Guide pad
6. Sub guide pad
7. Guide pad protector
8. Lock screw
9. Filler

Parts		Diameter (mm)				
		233.00-247.99	248.00-253.99	254.00-258.99	259.00-264.99	265.00-271.99
Cartridge	Outer	PERC 402-43	PERC 402-63	PERC 402-63	PERC 402-63	PERC 402-63
	Adjust screw	AS0005-15	AS0006-15	AS0006-15	AS0006-15	AS0006-15
	Wrench	H2.5	H3	H3	H3	H3
	Screw	LS1806RH	L1806RH	L1806RH	L1806RH	L1806RH
	Wrench	H4	H4	H4	H4	H4
	Inner	CENC 402-43	CENC 402-43	CENC 402-43	CENC 402-43	CENC 402-43
	Screw	LS1206	LS1206	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3	H3	H3
	Center	CENC 402-63	CENC 402-63	CENC 402-63	CENC 402-63	CENC 402-63
	Screw	LS1206	LS1206	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3	H3	H3
Insert	Outer	TPMX 2405 RG	TPMX 2807 RG	TPMX 2807 RG	TPMX 2807 RG	TPMX 2807 RG
	Screw	CSTB4M	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T15	T20	T20	T20	T20
	Inner	TPMX 2405 RG	TPMX 2405 RG	TPMX 2405 RG	TPMX 2405 RG	TPMX 2405 RG
	Screw	CSTB4M	CSTB4M	CSTB4M	CSTB4M	CSTB4M
	Wrench	T15	T15	T15	T15	T15
	Center	TPMX 2807 RG	TPMX 2807 RG	TPMX 2807 RG	TPMX 2807 RG	TPMX 2807 RG
	Screw	CSTB5	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T20	T20	T20	T20	T20
Pad	Guide pad	PAD-GC18-SB	PAD-GC18-SB	PAD-GC18-SB	PAD-GC18-SB	PAD-GC18-SB
	Screw	LS1206S	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3	H3
	Guide pad protector	PAD-P18	PAD-P18	PAD-P18	PAD-P18	PAD-P18
	Screw	LS1206S	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3	H3
	Sub guide pad	PAD-S14	PAD-S14	PAD-S14	PAD-S14	PAD-S14
	Screw	CSTA5S	CSTA5S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T15	T15	T15	T15	T15

D153 Guide Pad D155 Cartridge D158

TBTA9 Series

Assembly of TBTA9 series



1. Head shank
2. Outer cartridge
3. Inner cartridge
4. Center cartridge
5. Guide pad
6. Sub guide pad
7. Guide pad protector
8. Lock screw
9. Filler

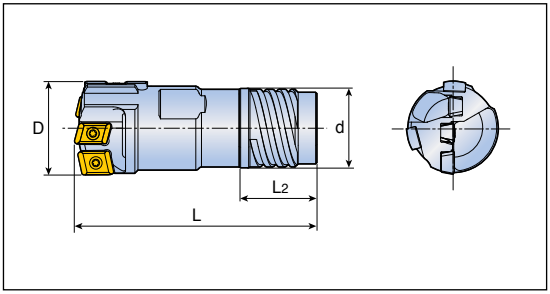
Parts		Diameter (mm)			
		272.00-275.99	276.00-284.99	285.00-289.99	290.00-293.99
Cartridge	Outer	PERC 402-63	PERC 402-63	PERC 402-63	PERC 402-63
	Adjust screw	AS0006-15	AS0006-15	AS0006-15	AS0006-15
	Wrench	H3	H3	H3	H3
	Screw	L1806RH	L1806RH	L1806RH	L1806RH
	Wrench	H4	H4	H4	H4
	Inner	CENC 402-63	CENC 402-63	CENC 402-63	CENC 402-63
	Screw	LS1206	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3	H3
	Center	CENC 402-63	CENC 402-63	CENC 402-63	CENC 402-63
	Screw	LS1206	LS1206	LS1206	LS1206
	Wrench	H3	H3	H3	H3
Insert	Outer	TPMX 2807 RG	TPMX 2807 RG	TPMX 2807 RG	TPMX 2807 RG
	Screw	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T20	T20	T20	T20
	Inner	TPMX 2807 RG	TPMX 2807 RG	TPMX 2807 RG	TPMX 2807 RG
	Screw	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T20	T20	T20	T20
	Center	TPMX 2807 RG	TPMX 2807 RG	TPMX 2807 RG	TPMX 2807 RG
	Screw	CSTB5	CSTB5	CSTB5	CSTB5
	Wrench	T20	T20	T20	T20
Pad	Guide pad	PAD-GC18-SB	PAD-GC18-SB	PAD-GC18-SB	PAD-GC18-SB
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Guide pad protector	PAD-P18	PAD-P18	PAD-P18	PAD-P18
	Screw	LS1206S	LS1206S	LS1206S	LS1206S
	Wrench	H3	H3	H3	H3
	Sub guide pad	PAD-S14	PAD-S14	PAD-S14	PAD-S14
	Screw	CSTA5S	CSTA5S	CSTA5S	CSTA5S
	Wrench	T15	T15	T15	T15

D153 Guide Pad D155 Cartridge D158

TBTA-FB...SE4

Single tube system





• Outer four start thread

Designation		D range	Dimension (mm)			Tube	
			L	L_2	d	Part	Diameter (mm)
TBTA-FB	**xx.xxSE4-22**	25.00-26.40	73	70	19.5	BTSI 022	22
	xx.xxSE4-24	26.41-28.70	73	70	21.0	BTSI 024	24
	xx.xxSE4-26	28.71-31.00	78	75	23.5	BTSI 026	26
	xx.xxSE4-28	31.01-33.30	78	75	25.5	BTSI 028	28
	xx.xxSE4-30	33.31-36.20	83	80	28.0	BTSI 030	30
	xx.xxSE4-33	36.21-39.60	93	90	30.0	BTSI 033	33
	xx.xxSE4-36	39.61-43.00	99	95	33.0	BTSI 036	36
	xx.xxSE4-39	43.01-47.00	104	100	36.0	BTSI 039	39
	xx.xxSE4-43	47.01-51.70	104	100	39.0	BTSI 043	43
	xx.xxSE4-47	51.71-56.20	114	110	43.0	BTSI 047	47
	xx.xxSE4-51	56.21-60.60	120	115	47.0	BTSI 051	51
	xx.xxSE4-56	60.61-65.00	120	115	51.0	BTSI 056A	56

Assembly D103 | Tube D119 | Cutting Condition D180

• **Note**: Insert and guide pads are sold separately from drill body.

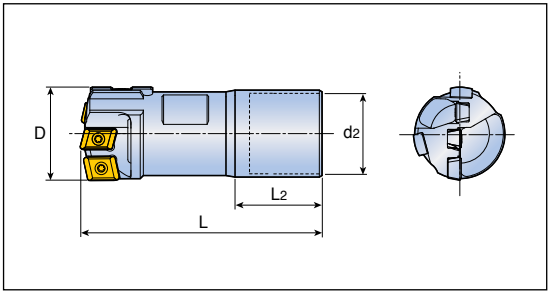
TaeguTec Member IMC Group

TBTA-FB...SI1

T-DEEP

Single tube system





• Inner single start thread

Designation		D range	Dimension (mm)			Tube	
			L	L_2	d_2	Part	Diameter (mm)
TBTA-FB	**xx.xxSI1-22**	25.00-26.99	73	70	20	BTSE 022	22
	xx.xxSI1-24	27.00-29.00	73	70	22	BTSE 024	24
	xx.xxSI1-24	29.01-29.99	73	70	22	BTSE 024	24
	xx.xxSI1-26	30.00-31.99	78	75	24	BTSE 026	26
	xx.xxSI1-28	32.00-33.99	78	75	26	BTSE 028	28
	xx.xxSI1-28	34.00-36.99	93	90	27	BTSE 028	28
	xx.xxSI1-30	37.00-39.99	98	95	30	BTSE 030	30
	xx.xxSI1-30	40.00-43.99	104	100	33	BTSE 030	30
	xx.xxSI1-33	44.00-46.99	109	105	37	BTSE 033	33
	xx.xxSI1-33	47.00-51.99	109	105	41	BTSE 033	33
	xx.xxSI1-36	52.00-56.99	114	110	44	BTSE 036	36
	xx.xxSI1-36	57.00-60.99	120	115	49	BTSE 036	36
	xx.xxSI1-39	61.00-65.00	120	115	53	BTSE 039	39

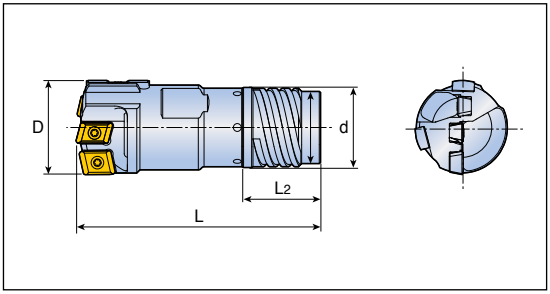
Assembly D103 | Tube D119 | Cutting Condition D180

• **Note**: Insert and guide pads are sold separately from drill body.

TBTA-FB...DE4

Double tube system





• Outer four start thread

Designation		D range	Dimension (mm)			Tube		
			L	L2	d	Outer tube	Inner tube	Diameter (mm)
TBTA-FB	**xx.xxDE4-23.5**	25.00-26.40	73	2	21.0	BTDO 023.5	BTDI 016	23.5
	xx.xxDE4-26	26.41-28.70	78	75	23.5	BTDO 026	BTDI 018	26.0
	xx.xxDE4-28	28.71-31.00	78	75	25.5	BTDO 028	BTDI 020	28.0
	xx.xxDE4-30.5	31.01-33.30	83	80	28.0	BTDO 030.5	BTDI 022	30.5
	xx.xxDE4-33	33.31-36.20	93	90	30.0	BTDO 033	BTDI 024	33.0
	xx.xxDE4-35.5	36.21-39.60	99	95	33.0	BTDO 035.5	BTDI 026	35.5
	xx.xxDE4-39	39.61-43.00	104	100	36.0	BTDO 039	BTDI 029	39.0
	xx.xxDE4-42.5	43.01-47.00	104	100	39.0	BTDO 042.5	BTDI 032	42.5
	xx.xxDE4-46.5	47.01-51.70	114	110	43.0	BTDO 046.5	BTDI 035	46.5
	xx.xxDE4-51	51.71-56.20	120	115	47.5	BTDO 051	BTDI 039	51.0
	xx.xxDE4-55.5	56.21-65.00	120	115	51.0	BTDO 055.5	BTDI 043A	55.5

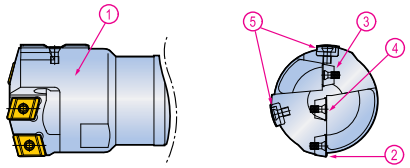
Assembly D103 | Tube D119 | Cutting Condition D180

• **Note**: Insert and guide pads are sold separately from drill body.

TaeguTec
Member IMC Group

TBTA-FB Series

Assembly of TBTA-FB series



1. Head shank
2. Outer insert
3. Inner insert
4. Center insert
5. Guide pad

	Parts	Diameter (mm)			
		25.00-28.00	28.01-29.99	30.00-35.00	35.01-38.00
Insert	PER	NPHT 06003 RG	NPHT 06003 RG	NPHT 07504 RG	NPHT 07504 RG
	Screw	CSTB2.2	CSTB2.2	CSTB2.5	CSTB2.5
	Wrench	T-7F	T-7F	T-8F	T-8F
	INT	NPMT 05503 RG	NPMT 05503 RG	NPMT 06504 RG	NPMT 06504 RG
	Screw	CSTB2.2	CSTB2.2	CSTB2.5	CSTB2.5
	Wrench	T-7F	T-7F	T-8F	T-8F
	CEN	NPMT 05503 LG	NPMT 06504 LG	NPMT 06504 LG	NPMT 08004 LG
	Screw	CSTB2.2	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-7F	T-8F	T-8F	T-8F
Pad	PAD	PAD-GO06CD-SA	PAD-GO06CD-SA	PAD-GO07CD-SA	PAD-GO07CD-SA
		PAD-GO06CD-SB	PAD-GO06CD-SB	PAD-GO07CD-SB	PAD-GO07CD-SB
	Screw	CSTB2.2S	CSTB2.2S	CSTB3S	CSTB3S
	Wrench	T-7F	T-7F	T-9F	T-9F

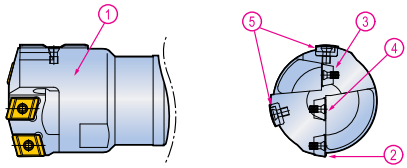
	Parts	Diameter (mm)			
		38.01-39.00	39.01-41.00	41.01-44.00	44.01-45.00
Insert	PER	NPHT 09004 RG	NPHT 09004 RG	NPHT 09004 RG	NPHT 09004 RG
	Screw	CSTB2.5	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-8F	T-8F	T-8F	T-8F
	INT	NPMT 06504 RG	NPMT 06504 RG	NPMT 08004 RG	NPMT 08004 RG
	Screw	CSTB2.5	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-8F	T-8F	T-8F	T-8F
	CEN	NPMT 08004 LG	NPMT 08004 LG	NPMT 08004 LG	NPMT 09504 LG
	Screw	CSTB2.5	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-8F	T-8F	T-8F	T-8F
Pad	PAD	PAD-GO07CD-SA	PAD-GO08CD-SA-FB	PAD-GO08CD-SA-FB	PAD-GO08CD-SA-FB
		PAD-GO07CD-SB	PAD-GO08CD-SB-FB	PAD-GO08CD-SB-FB	PAD-GO08CD-SB-FB
	Screw	CSTB3S	CSTB3S	CSTB3S	CSTB3S
	Wrench	T-9F	T-9F	T-9F	T-9F



• **Note**: Insert and guide pads are sold separately from drill body.

TBTA-FB Series

Assembly of TBTA-FB series



1. Head shank
2. Outer insert
3. Inner insert
4. Center insert
5. Guide pad

	Parts	Diameter (mm)			
		45.01-47.00	47.01-51.00	51.01-54.00	54.01-57.00
Insert	PER	NPHT 09004 RG	NPHT 11004 RG	NPHT 11004 RG	NPHT 11004 RG
	Screw	CSTB2.5	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-8F	T-8F	T-8F	T-8F
	INT	NPMT 08004 RG	NPMT 08004 RG	NPMT 09504 RG	NPMT 09504 RG
	Screw	CSTB2.5	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-8F	T-8F	T-8F	T-8F
	CEN	NPMT 09504 LG	NPMT 09504 LG	NPMT 09504 LG	NPMT 12504 LG
	Screw	CSTB2.5	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-8F	T-8F	T-8F	T-8F
Pad	PAD	PAD-GO10CD-SA	PAD-GO10CD-SA	PAD-GO10CD-SA	PAD-GO10CD-SA
		PAD-GO10CD-SB	PAD-GO10CD-SB	PAD-GO10CD-SB	PAD-GO10CD-SB
	Screw	CSTB3.5	CSTB3.5	CSTB3.5	CSTB3.5
	Wrench	T-15F	T-15F	T-15F	T-15F

	Parts	Diameter (mm)		
		57.01-60.00	60.01-64.00	64.01-65.00
Insert	PER	NPHT 11004 RG	NPHT 13004 RG	NPHT 13004 RG
	Screw	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-8F	T-8F	T-8F
	INT	NPMT 09504 RG	NPMT 09504 RG	NPMT 12504 RG
	Screw	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-8F	T-8F	T-8F
	CEN	NPMT 12504 LG	NPMT 12504 LG	NPMT 12504 LG
	Screw	CSTB2.5	CSTB2.5	CSTB2.5
	Wrench	T-8F	T-8F	T-8F
Pad	PAD	PAD-GO12CD-SA	PAD-GO12CD-SA	PAD-GO12CD-SA
		PAD-GO12CD-SB	PAD-GO12CD-SB	PAD-GO12CD-SB
	Screw	CSTB3.5	CSTB3.5	CSTB3.5
	Wrench	T-15F	T-15F	T-15F

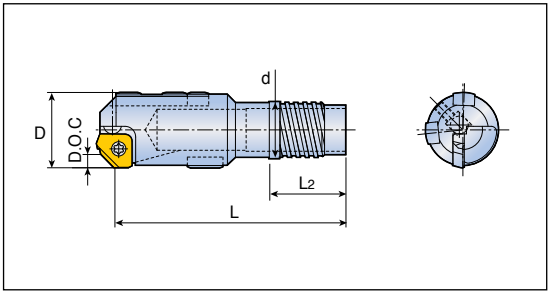
D151 Guide Pad D156

• **Note**: Insert and guide pads are sold separately from drill body.

TBTA-R...SE4

Single tube system





• Outer four start thread

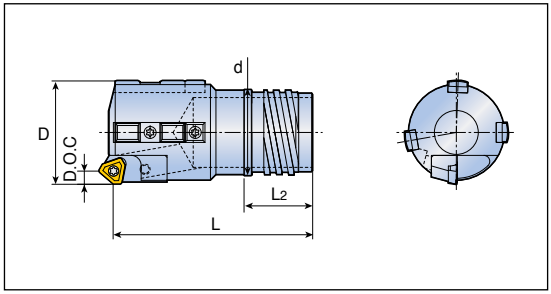
Designation	D range	D.O.C (mm)	Dimension (mm)			Tube	
			L	L_2	d	Part	Diameter (mm)
TBTA-R xxx.xxSE4-22	25.00-26.40	2.8	70	21.5	19.5	BTSI 022	22
xxx.xxSE4-24	26.41-28.70	2.8	70	21.5	21.0	BTSI 024	24
xxx.xxSE4-26	28.71-31.00	2.8	75	24.5	23.5	BTSI 026	26
xxx.xxSE4-28	31.01-33.30	2.8	75	24.5	25.5	BTSI 028	28
xxx.xxSE4-30	33.31-36.20	2.8	75	24.5	28.0	BTSI 030	30
xxx.xxSE4-33	36.21-39.60	2.8	90	30.5	30.0	BTSI 033	33
xxx.xxSE4-36	39.61-39.99	2.8	90	30.5	33.0	BTSI 036	36

Assembly D108 | Tube D119 | Cutting Condition D178

TBTA-R...SE4

Single tube system





• Outer four start thread

Designation	D range	D.O.C (mm)		Dimension (mm)			Tube	
		Standard	Precision	L	L2	d	Part	Diameter (mm)
TBTA-R xxx.xxSE4-36	40.00-43.00	6.4	4	90	30.5	33.0	BTSI 036	36
xxx.xxSE4-39	43.01-47.00	6.4	4	95	30.5	36.0	BTSI 039	39
xxx.xxSE4-43	47.01-51.70	6.4	4	100	30.5	39.0	BTSI 043	43
xxx.xxSE4-47	51.71-56.20	6.4/7.2	4/4.8	100	34.5	43.0	BTSI 047	47
xxx.xxSE4-51	56.21-60.60	7.2	4.8	105	34.5	47.0	BTSI 051	51
xxx.xxSE4-56A	60.61-65.00	7.2	4.8	110	34.5	51.0	BTSI 056A	56
xxx.xxSE4-56B	65.00-66.99	7.2	4.8	150	62.0	52.0	BTSI 056B	56
xxx.xxSE4-62	67.00-72.99	10.4	6.4	150	62.0	58.0	BTSI 062	62
xxx.xxSE4-68	73.00-79.99	10.4	6.4	150	62.0	63.0	BTSI 068	68
xxx.xxSE4-75	80.00-86.99	10.4	6.4	180	82.0	70.0	BTSI 075	75
xxx.xxSE4-82	87.00-99.99	10.4	6.4	180	82.0	77.0	BTSI 082	82

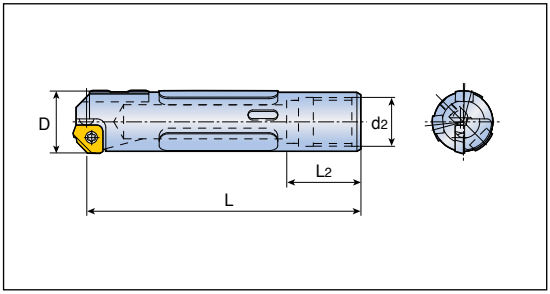
Assembly D108 | Tube D119 | Cutting Condition D178

TBTA-R...SI1

T-DEEP

Single tube system





• Inner single start thread

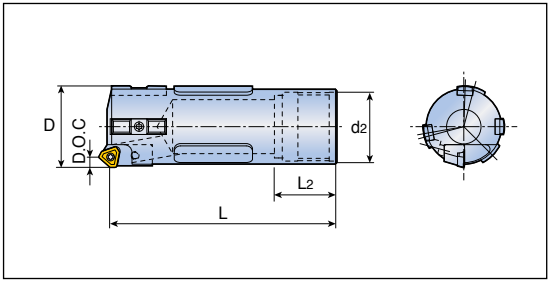
Designation		D range	D.O.C (mm)	Dimension (mm)			Tube	
				L	L2	d2	Part	Diameter (mm)
TBTA-R-	**xxx.xxSI1-22**	25.00-26.99	2.8	110	25	20	BTSE 022	22
	xxx.xxSI1-24	27.00-29.99	2.8	110	25	22	BTSE 024	24
	xxx.xxSI1-26	30.00-31.99	2.8	110	25	24	BTSE 026	26
	xxx.xxSI1-28	32.00-33.99	2.8	110	25	26	BTSE 028	28
	xxx.xxSI1-30	34.00-36.99	2.8	135	40	27	BTSE 030	30
	xxx.xxSI1-33	37.00-39.99	2.8	135	40	30	BTSE 033	33

TBTA-R...SI1

T-DEEP

Single tube system





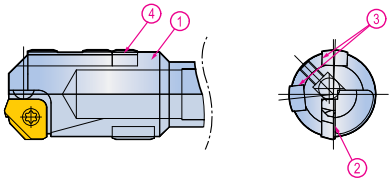
• Inner single start thread

Designation		D range	D.O.C (mm)		Dimension (mm)			Tube	
			Standard	Precision	L	L2	d2	Part	Diameter (mm)
TBTA-R-	**xxx.xxSI1-36**	40.00-43.99	6.4	4	135	40	33	BTSE 036	36
	xxx.xxSI1-39	44.00-46.99	6.4	4	135	40	37	BTSE 039	39
	xxx.xxSI1-43	47.00-51.99	6.4	4	145	40	41	BTSE 043	43
	xxx.xxSI1-47	52.00-56.99	7.2	4.8	145	40	44	BTSE 047	47
	xxx.xxSI1-51	57.00-60.99	7.2	4.8	170	40	49	BTSE 051	51
	xxx.xxSI1-56	61.00-67.99	7.2/10.4	4.8/6.4	170	40	53	BTSE 056	56
	xxx.xxSI1-62	68.00-74.99	10.4	6.4	170	40	59	BTSE 062	62
	xxx.xxSI1-68	75.00-80.99	10.4	6.4	205	70	65	BTSE 068	68
	xxx.xxSI1-75	81.00-90.99	10.4	6.4	205	70	71	BTSE 075	75
	xxx.xxSI1-82	91.00-98.99	10.4	6.4	215	70	79	BTSE 082	82
	xxx.xxSI1-94	99.00-110.99	10.4	6.4	215	70	90	BTSE 094	94

Assembly D108 | Tube D119 | Cutting Condition D178

TBTA-R Series

Assembly of TBTA-R series



1. Head shank
2. Insert
3. Guide pad
4. Guide pad protector

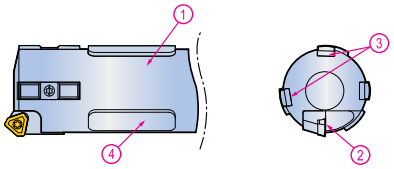
Parts			Diameter (mm)			
			25.00-27.99	28.00-29.99	30.00-36.99	37.00-39.99
Close tolerance	Cartridge	Outer	-	-	-	-
		Adjust screw	-	-	-	-
		Wrench	-	-	-	-
		Screw	-	-	-	-
		Wrench	-	-	-	-
	Insert	Insert	XPMT 16002-45	XPMT 16002-45	XPMT 16002-45	XPMT 16002-45
		Screw	CSTANO3	CSTANO3	CSTANO3	CSTANO3
		Wrench	T9	T9	T9	T9
Normal tolerance	Cartridge	Outer	-	-	-	-
		Adjust screw	-	-	-	-
		Wrench	-	-	-	-
		Screw	-	-	-	-
		Wrench	-	-	-	-
	Insert	Insert	XPMT 16002-45	XPMT 16002-45	XPMT 16002-45	XPMT 16002-45
		Screw	CSTANO3	CSTANO3	CSTANO3	CSTANO3
		Wrench	T9	T9	T9	T9
Pad		Guide pad (A)	PAD-GC08-120	PAD-GC08-120	PAD-GC08-140	PAD-GO08CD-SA-FB
			-	-	-	PAD-GO08CD-SB-FB
		Screw	CSTB3S	CSTB3S	CSTB3S	CSTB3S
		Wrench	T9	T9	T9	T9
		Guide pad protector (B)	PAD-P08-120	PAD-P08-120	PAD-P08-140	PAD-P08
		Screw	CSTB3S	CSTB3S	CSTB3S	CSTB3S
		Wrench	T9	T9	T9	T9
		Resin guide pad (C)	PAD-R10	PAD-R10	PAD-R12	PAD-R15
		Screw	LS0902, 5-6	LS0902, 5-6	LS0903-8	LS0904-10
		Wrench	+	+	+H2	+H2.5

Guide Pad D157
Cartridge D159
D154

- A + B is for outer four start thread connection type
- A + C is for inner single start thread connection type

TBTA-R Series

Assembly of TBTA-R series



1. Head shank
2. Cartridge & lock screw
3. Guide pad
4. Resin guide pad & lock screw

Parts			Diameter (mm)			
			40.00-45.99	46.00-51.99	52.00-56.99	57.00-66.99
Close tolerance	Cartridge	Outer	PERC-P 04R	PERC-P 04R	PERC-P 32R	PERC-P 32R
		Adjust screw	AS0004-8	AS0004-8	AS0005-10	AS0005-10
		Wrench	H2	H2	H2.5	H2.5
		Screw	LS1803.5RH	LS1803.5RH	LS1805RH	LS1805RH
		Wrench	H2.5	H2.5	H3	H3
	Insert	Insert	TPMX 1403LG	TPMX 1403LG	TPMX 1704LG	TPMX 1704LG
		Screw	CSTB2.5	CSTB2.5	CSTB3.5D	CSTB3.5D
		Wrench	T8	T8	T9	T9
Normal tolerance	Cartridge	Outer	PERC 402-04	PERC 402-04	PERC 402-32	PERC 402-32
		Adjust screw	AS0004-8	AS0004-8	AS0005-10	AS0005-10
		Wrench	H2	H2	H2.5	H2.5
		Screw	LS1803.5RH	LS1803.5RH	LS1805RH	LS1805RH
		Wrench	H2.5	H2.5	H3	H3
	Insert	Insert	TPMX 1403RG	TPMX 1403RG	TPMX 1704RG	TPMX 1704RG
		Screw	CSTB2.5	CSTB2.5	CSTB3.5D	CSTB3.5D
		Wrench	T8	T8	T9	T9
Pad		Guide pad (A)	PAD-GO08CD-SA-FB	PAD-GC10-SA	PAD-GC10-SA	PAD-GC14-SB
			PAD-GO08CD-SB-FB	PAD-GC10-SB	PAD-GC10-SB	-
		Screw	CSTB3S	CSTB3S	CSTB3S	CSTA5S
		Wrench	T9	T9	T9	T15
		Guide pad protector (B)	PAD-P08	PAD-P10	PAD-P10	PAD-P14
		Screw	CSTB3S	CSTB4S	CSTB4S	CSTA5S
		Wrench	T9	T15	T15	T15
		Resin guide pad (C)	PAD-R15	PAD-R15	PAD-R15	PAD-R20
		Screw	LS0904-10	LS0904-10	LS0904-10	LS0905-12
		Wrench	+H2.5	+H2.5	+H25	+H3

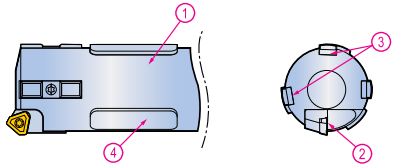
D154 Guide Pad D157 Cartridge D159

- A + B is for outer four start thread connection type
- A + C is for inner single start thread connection type

TaeguTec Member IMC Group

TBTA-R Series

Assembly of TBTA-R series



1. Head shank
2. Cartridge & lock screw
3. Guide pad
4. Resin guide pad & lock screw

Parts			Diameter (mm)			
			67.00-80.99	81.00-90.99	91.00-99.99	100.00-122.99
Close tolerance	Cartridge	Outer	PERC-P 43R	PERC-P 43R	PERC-P 43R	PERC-P 43R
		Adjust screw	AS0005-15	AS0005-15	AS0005-15	AS0005-15
		Wrench	H2.5	H2.5	H2.5	H2.5
		Screw	LS1806RH	LS1806RH	LS1806RH	LS1806RH
		Wrench	H4	H4	H4	H4
	Insert	Insert	TPMX 2405LG	TPMX 2405LG	TPMX 2405LG	TPMX 2405LG
		Screw	CSTB4M	CSTB4M	CSTB4M	CSTB4M
		Wrench	T15	T15	T15	T15
Normal tolerance	Cartridge	Outer	PERC 402-43	PERC 402-43	PERC 402-43	PERC 402-43
		Adjust screw	AS0005-15	AS0005-15	AS0005-15	AS0005-15
		Wrench	H2.5	H2.5	H2.5	H2.5
		Screw	LS1806RH	LS1806RH	LS1806RH	LS1806RH
		Wrench	H4	H4	H4	H4
	Insert	Insert	TPMX 2405RG	TPMX 2405RG	TPMX 2405RG	TPMX 2405RG
		Screw	CSTB4M	CSTB4M	CSTB4M	CSTB4M
		Wrench	T15	T15	T15	T15
Pad		Guide pad (A)	PAD-GC14-SB	PAD-GC14-SB	PAD-GC14-SB	PAD-GC18-SB
		Screw	CSTA5S	CSTA5S	CSTA5S	CSTA5S
		Wrench	T15	T15	T15	T15
		Guide pad protector (B)	PAD-P14	PAD-P14	PAD-P14	PAD-P18
		Screw	CSTA5S	CSTA5S	CSTA5S	LS1206S
		Wrench	T15	T15	T15	H3
		Resin guide pad (C)	PAD-R20	PAD-R30	PAD-R35	PAD-R35
		Screw	LS0905-12	LS0906-15	LS0906-15	LS0906-15
		Wrench	+H3	+H4	+H4	+H4

D154 Guide Pad D157 Cartridge D159

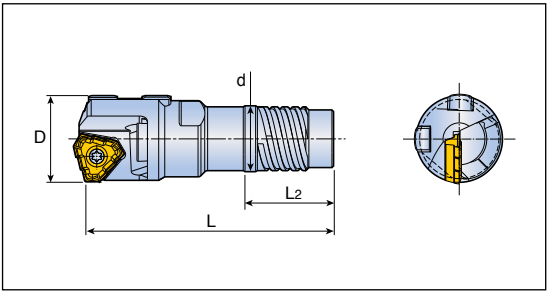
- A + B is for outer four start thread connection type
- A + C is for inner single start thread connection type

TaeguTec Member IMC Group

TBTA-TR…SE4

Single tube system





• Outer four start thread

Designation		D range	Dimension (mm)				Tube	
			L	L_2	d_1	d	Part	Diameter (mm)
TBTA-	**TRxx.xxSE4-14**	16.00-16.70	55.0	20.0	10.8	12.6	BTSI 014	14
	TRxx.xxSE4-15	16.71-17.70	55.0	20.0	11.8	13.6	BTSI 015	15
	TRxx.xxSE4-16	17.71-18.90	56.0	21.5	12.5	14.5	BTSI 016	16
	TRxx.xxSE4-17	18.91-20.00	56.0	21.5	13.5	15.5	BTSI 017	17
	TRxx.xxSE4-18	20.01-21.80	60.0	21.5	14.0	16.0	BTSI 018	18
	TRxx.xxSE4-20	21.81-21.99	63.5	21.5	16.0	18.0	BTSI 020	20
	TRxx.xxSE4-20	22.00-24.10	65.5	21.5	16.0	18.0	BTSI 020	20
	TRxx.xxSE4-22	24.11-26.40	65.5	21.5	17.5	19.5	BTSI 022	22
	TRxx.xxSE4-24	26.41-28.00	65.6	21.5	19.0	21.0	BTSI 024	24

Assembly D114 | Tube D119 | Cutting Condition D186

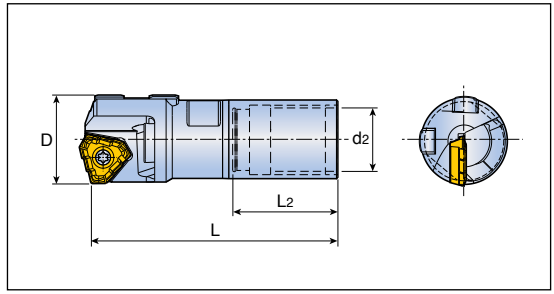
• **Note**: Insert and guide pads are sold separately from drill body.

TaeguTec Member IMC Group

TBTA-TR…SI1

Single tube system





• Inner single start thread

Designation		D range	Dimension (mm)				Tube	
			L	L_2	d_2	d	Part	Diameter (mm)
TBTA-	**TR16.00SI1-13A**	16.00	53.5	22	10.8	12.4	BTSE 013A	13
	TRxx.xxSI1-13B	16.01-16.50	53.5	22	11.1	12.7	BTSE 013B	13
	TRxx.xxSI1-14A	16.51-17.25	53.5	22	11.8	13.4	BTSE 014A	14
	TRxx.xxSI1-14B	17.26-18.00	53.5	22	12.1	13.7	BTSE 014B	14
	TRxx.xxSI1-15	18.01-19.00	53.5	22	12.8	14.4	BTSE 015	15
	TRxx.xxSI1-16.5	19.01-19.99	53.5	22	13.8	15.4	BTSE 016.5	16.5
	TRxx.xxSI1-18	20.00-21.99	58.0	25	14.5	16.5	BTSE 018	18
	TRxx.xxSI1-20	22.00-24.99	60.0	25	16.0	19.0	BTSE 020	20
	TR25.00SI1-22	25.00	60.0	25	17.0	20.0	BTSE 022	22
	TRxx.xxSI1-22	25.01-26.99	65.0	25	17.0	20.0	BTSE 022	22
	TRxx.xxSI1-24	27.00-28.00	65.0	25	19.0	22.0	BTSE 024	24

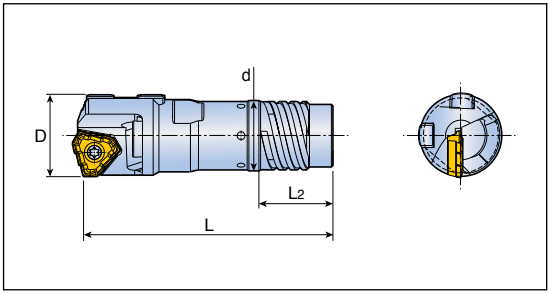
Assembly D114 | Tube D119 | Cutting Condition D186

• **Note**: Insert and guide pads are sold separately from drill body.

TBTA-TR…DE4

Double tube system





• Outer four start thread

Designation		D range	Dimension (mm)			Tube	
			L	L2	d	Part	Diameter (mm)
TBTA-	**TRxx.xxDE4-18**	18.40-20.00	59.0	21.5	16.0	BTDO 018	18
	TRxx.xxDE4-19.5	20.01-21.80	63.5	21.5	18.0	BTDO 019.5	19.5
	TRxx.xxDE4-21.5	21.81-21.99	63.5	21.5	19.5	BTDO 021.5	21.5
	TRxx.xxDE4-21.5	22.00-24.10	65.5	21.5	19.5	BTDO 021.5	21.5
	TRxx.xxDE4-23.5	24.11-25.00	65.5	21.5	21.0	BTDO 023.5	23.5
	TRxx.xxDE4-23.5	25.01-26.40	67.5	21.5	21.0	BTDO 023.5	23.5
	TRxx.xxDE4-26	26.41-28.00	70.5	24.5	23.5	BTDO 026	26

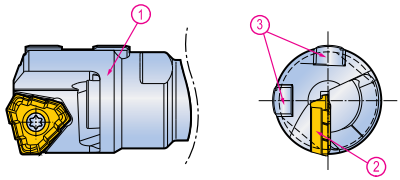
Assembly D114 | Tube D119 | Cutting Condition D186

• **Note**: Insert and guide pads are sold separately from drill body.

TaeguTec Member IMC Group

TBTA-TR Series

Assembly of TBTA-TR series



1. Head shank
2. Insert
3. Guide pad

Parts		Diameter (mm)		
		16.00-18.00	18.01-20.00	20.01-21.00
Insert	Insert	TOGT 080305 RS TT9030	TOGT 090305 RS TT9030	TOGT 100305 RS TT9030
	Screw	CSTB 2.5S	CSTB 2.5S	CSTB 3S
	Wrench	T-8F	T-8F	T-9F
Guide Pad	Guide Pad	PAD-GO06-075CD-SA	PAD-GO06-085CD-SA	PAD-GO06-085CD-SA
		PAD-GO06-075CD-SB	PAD-GO06-085CD-SB	PAD-GO06-085CD-SB
	Screw	CSTB 2.2S	CSTB 2.2S	CSTB 2.2S
	Wrench	T-7F	T-7F	T-7F

Parts		Diameter (mm)		
		21.01-21.99	22.00-25.00	25.01-28.00
Insert	Insert	TOGT 100305 RS TT9030	TOGT 110405 RS TT9030	TOGT 120405 RS TT9030
	Screw	CSTB 3S	CSTB 3.5H	CSTB 4S
	Wrench	T-9F	T-15F	T-15F
Guide Pad	Guide Pad	PAD-GO06-100CD-SA	PAD-GO06-100CD-SA	PAD-GO06CD-SA
		PAD-GO06-100CD-SB	PAD-GO06-100CD-SB	PAD-GO06CD-SB
	Screw	CSTB 2.2S	CSTB 2.2S	CSTB 2.2S
	Wrench	T-7F	T-7F	T-7F

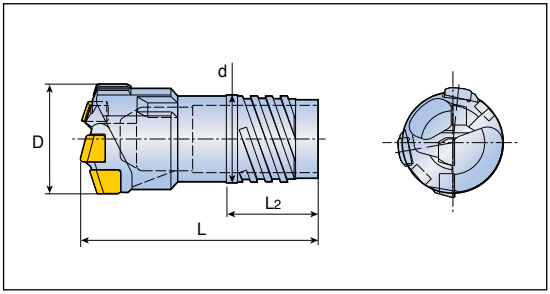
D153 Guide Pad D156

• **Note**: Insert and guide pads are sold separately from drill body.

BTA...SE2/SE4

Single tube system





• Outer four start thread

Designation	D range	Dimension (mm)			Tube	
		L	L2	d	Part	Diameter (mm)
BTA xxx.xx SE2-11*	12.60-13.10	43.0	23.5	9.6	BTSI011	11
xxx.xx SE2-11*	13.11-13.60	43.0	23.5	9.6	BTSI011	11
xxx.xx SE2-12*	13.61-14.10	43.0	23.5	10.6	BTSI012	12
xxx.xx SE2-12*	14.11-14.60	43.0	23.5	10.6	BTSI012	12
xxx.xx SE2-13*	14.61-15.10	43.0	23.5	11.6	BTSI013	13
xxx.xx SE2-13*	15.11-15.59	43.0	23.5	11.6	BTSI013	13
xxx.xx SE4-14	15.60-16.20	43.0	20.0	12.6	BTSI014	14
xxx.xx SE4-14	16.21-16.70	43.0	20.0	12.6	BTSI014	14
xxx.xx SE4-15	16.71-17.20	43.0	20.0	13.6	BTSI015	15
xxx.xx SE4-15	17.21-17.70	43.0	20.0	13.6	BTSI015	15
xxx.xx SE4-16	17.71-18.40	47.0	21.5	14.5	BTSI016	16
xxx.xx SE4-16	18.41-18.90	47.0	21.5	14.5	BTSI016	16
xxx.xx SE4-17	18.91-19.20	47.0	21.5	15.5	BTSI017	17
xxx.xx SE4-17	19.21-20.00	47.0	21.5	15.5	BTSI017	17
xxx.xx SE4-18	20.01-20.90	52.5	21.5	16.0	BTSI018	18
xxx.xx SE4-18	20.91-21.80	52.5	21.5	16.0	BTSI018	18
xxx.xx SE4-20	21.81-22.90	56.0	21.5	18.0	BTSI020	20
xxx.xx SE4-20	22.91-24.10	56.0	21.5	18.0	BTSI020	20
xxx.xx SE4-22	24.11-25.20	57.5	21.5	19.5	BTSI022	22
xxx.xx SE4-22	25.21-26.40	57.5	21.5	19.5	BTSI022	22
xxx.xx SE4-24	26.41-27.50	57.5	21.5	21.0	BTSI024	24
xxx.xx SE4-24	27.51-28.70	57.5	21.5	21.0	BTSI024	24
xxx.xx SE4-26	28.71-29.80	63.5	24.5	23.5	BTSI026	26
xxx.xx SE4-26	29.81-31.00	63.5	24.5	23.5	BTSI026	26
xxx.xx SE4-28	31.01-32.10	63.5	24.5	25.5	BTSI028	28
xxx.xx SE4-28	32.11-33.30	63.5	24.5	25.5	BTSI028	28
xxx.xx SE4-30	33.31-34.80	63.5	24.5	28.0	BTSI030	30
xxx.xx SE4-30	34.81-36.20	63.5	24.5	28.0	BTSI030	30
xxx.xx SE4-33	36.21-37.30	73.5	30.5	30.0	BTSI033	33
xxx.xx SE4-33	37.31-38.40	73.5	30.5	30.0	BTSI033	33
xxx.xx SE4-33	38.41-39.60	73.5	30.5	30.0	BTSI033	33
xxx.xx SE4-36	39.61-40.60	73.5	30.5	33.0	BTSI036	36
xxx.xx SE4-36	40.61-41.80	73.5	30.5	33.0	BTSI036	36
xxx.xx SE4-36	41.81-43.00	73.5	30.5	33.0	BTSI036	36
xxx.xx SE4-39	43.01-44.30	75.0	30.5	36.0	BTSI039	39

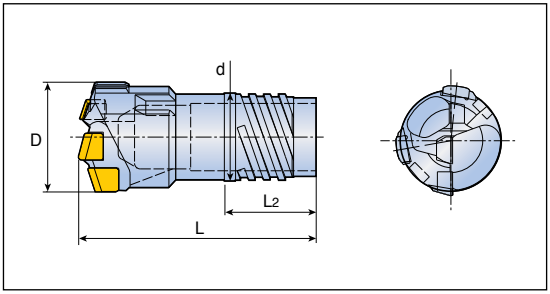
Tube D119 | Cutting Condition D182

• '*' 2 cutting edge head

BTA...SE4

Single tube system





• Outer four start thread

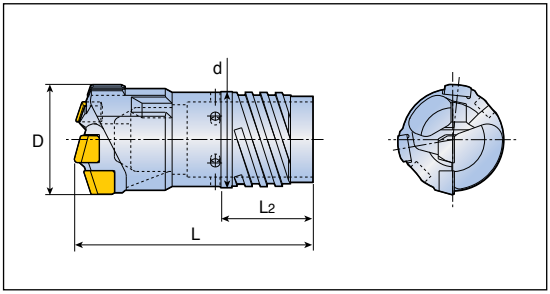
Designation	D range	Dimension (mm)			Tube	
		L	L2	d	Part	Diameter (mm)
BTA xxx.xx SE4-39	44.31-45.60	75.0	30.5	36.0	BTSI039	39
xxx.xx SE4-39	45.61-47.00	75	30.5	36.0	BTSI039	39
xxx.xx SE4-43	47.01-48.50	75	30.5	39.0	BTSI043	43
xxx.xx SE4-43	48.51-50.10	75	30.5	39.0	BTSI043	43
xxx.xx SE4-43	50.11-51.70	75	30.5	39.0	BTSI043	43
xxx.xx SE4-47	51.71-53.20	82	34.5	43.0	BTSI047	47
xxx.xx SE4-47	53.21-54.70	82	34.5	43.0	BTSI047	47
xxx.xx SE4-47	54.71-56.20	82	34.5	43.0	BTSI047	47
xxx.xx SE4-51	56.21-58.40	84	34.5	47.0	BTSI051	51
xxx.xx SE4-51	58.41-60.60	84	34.5	47.0	BTSI051	51
xxx.xx SE4-51	60.61-62.80	84	34.5	47.0	BTSI051	51
xxx.xx SE4-51	62.81-65.00	84	34.5	47.0	BTSI051	51
xxx.xx SE4-56	60.61-62.80	84	34.5	51.0	BTSI056	56
xxx.xx SE4-56	62.81-65.00	84	34.5	51.0	BTSI056	56

Tube D119
Cutting Condition D182

BTA...DE4

Double tube system





• Outer four start thread

Designation	D range	Dimension (mm)			Tube		
		L	L2	d	Outer tube	Inner tube	Diameter (mm)
BTA xxx.xx DE4-18	18.41-19.20	50.0	21.5	16.0	BTDO018	BTDI012	18.0
xxx.xx DE4-18	19.21-20.00	50.0	21.5	16.0	BTDO018	BTDI012	18.0
xxx.xx DE4-19.5	20.01-20.90	56.0	21.5	18.0	BTDO019.5	BTDI014	19.5
xxx.xx DE4-19.5	20.91-21.80	56.0	21.5	18.0	BTDO019.5	BTDI014	19.5
xxx.xx DE4-21.5	21.81-22.90	56.0	21.5	19.5	BTDO021.5	BTDI015	21.5
xxx.xx DE4-21.5	22.91-24.10	56.0	21.5	19.5	BTDO021.5	BTDI015	21.5
xxx.xx DE4-23.5	24.11-25.20	57.5	21.5	21.0	BTDO023.5	BTDI016	23.5
xxx.xx DE4-23.5	25.21-26.40	57.5	21.5	21.0	BTDO023.5	BTDI016	23.5
xxx.xx DE4-26	26.41-27.50	60.5	24.5	23.5	BTDO026	BTDI018	26.0
xxx.xx DE4-26	27.51-28.70	60.5	24.5	23.5	BTDO026	BTDI018	26.0
xxx.xx DE4-28	28.71-29.80	63.5	24.5	25.5	BTDO028	BTDI020	28.0
xxx.xx DE4-28	29.81-31.00	63.5	24.5	25.5	BTDO028	BTDI020	28.0
xxx.xx DE4-30.5	31.01-32.10	63.5	24.5	28.0	BTDO030.5	BTDI022	30.5
xxx.xx DE4-30.5	32.11-33.30	63.5	24.5	28.0	BTDO030.5	BTDI022	30.5
xxx.xx DE4-33	33.31-34.80	70.5	30.5	30.0	BTDO033.0	BTDI024	33.0
xxx.xx DE4-33	34.81-36.20	70.5	30.5	30.0	BTDO033.0	BTDI024	33.0
xxx.xx DE4-35.5	36.21-37.30	73.5	30.5	33.0	BTDO035.5	BTDI026	35.5
xxx.xx DE4-35.5	37.31-38.40	73.5	30.5	33.0	BTDO035.5	BTDI026	35.5
xxx.xx DE4-35.5	38.41-39.60	73.5	30.5	33.0	BTDO035.5	BTDI026	35.5
xxx.xx DE4-39	39.61-40.60	73.5	30.5	36.0	BTDO039	BTDI029	39.0
xxx.xx DE4-39	40.61-41.80	73.5	30.5	36.0	BTDO039	BTDI029	39.0
xxx.xx DE4-39	41.81-43.00	73.5	30.5	36.0	BTDO039	BTDI029	39.0
xxx.xx DE4-42.5	43.01-44.30	75.0	30.5	39.0	BTDO042.5	BTDI032	42.5
xxx.xx DE4-42.5	44.31-45.60	75.0	30.5	39.0	BTDO042.5	BTDI032	42.5
xxx.xx DE4-42.5	45.61-47.00	75.0	30.5	39.0	BTDO042.5	BTDI032	42.5
xxx.xx DE4-46.5	47.01-48.50	79.0	34.5	43.0	BTDO046.5	BTDI035	46.5
xxx.xx DE4-46.5	48.51-50.10	79.0	34.5	43.0	BTDO046.5	BTDI035	46.5
xxx.xx DE4-46.5	50.11-51.70	79.0	34.5	43.0	BTDO046.5	BTDI035	46.5
xxx.xx DE4-51	51.71-53.20	82.0	34.5	47.0	BTDO051	BTDI039	51.0
xxx.xx DE4-51	53.21-54.70	82.0	34.5	47.0	BTDO051	BTDI039	51.0
xxx.xx DE4-51	54.71-56.20	82.0	34.5	47.0	BTDO051	BTDI039	51.0
xxx.xx DE4-55.5	56.21-58.40	84.0	34.5	51.0	BTDO055.5	BTDI043A	55.5
xxx.xx DE4-55.5	58.41-60.60	84.0	34.5	51.0	BTDO055.5	BTDI043A	55.5
xxx.xx DE4-55.5	60.61-62.80	84.0	34.5	51.0	BTDO055.5	BTDI043A	55.5
xxx.xx DE4-55.5	62.81-65.00	84.0	34.5	51.0	BTDO055.5	BTDI043A	55.5

Tube D119
Cutting Condition D182

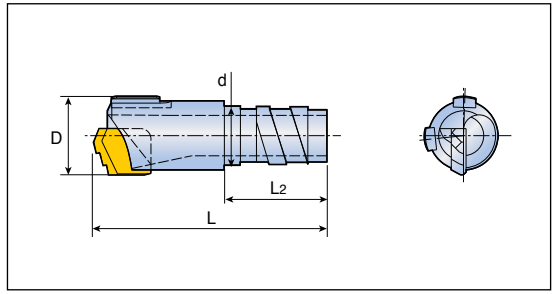
TaeguTec Member IMC Group

BTS...SE1

T-DEEP

Single tube system





• Outer single start thread

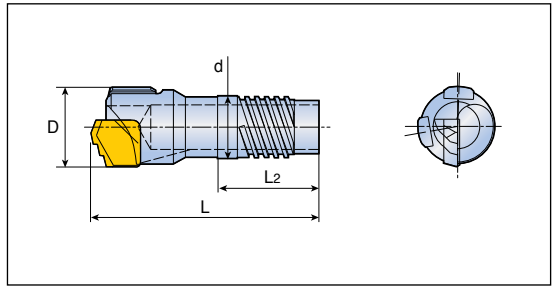
Designation		D range	Dimension (mm)			Tube	
			L	L_2	d	Part	Diameter (mm)
BTS	**xxx.xx SE1-7.1**	8.00-8.99	35.6	16	6.0	BTSO071	7.1
	xxx.xx SE1-8.3	9.00-9.99	35.6	16	7.2	BTSO083	8.3
	xxx.xx SE1-9	10.00-10.99	35.7	16	7.6	BTSO090	9.0
	xxx.xx SE1-10	11.00-11.99	35.7	16	8.6	BTSO100	10.0
	xxx.xx SE1-11	12.00-13.49	35.7	16	9.1	BTSO110	11.0
	xxx.xx SE1-12	13.50-14.79	36.0	16	10.8	BTSO120	12.0

BTS...SE2/SE4

T-DEEP

Single tube system





• Outer four start thread

Designation		D range	Dimension (mm)			Tube	
			L	L_2	d	Part	Diameter (mm)
BTS	**xxx.xx SE2-11***	12.60-13.60	42.6	20.5	9.6	BTSI011	11
	xxx.xx SE2-12*	13.61-14.60	42.7	22.5	10.6	BTSI012	12
	xxx.xx SE2-13*	14.61-15.59	42.7	22.5	11.6	BTSI013	13
	xxx.xx SE4-14	15.60-16.70	43.3	22.5	12.6	BTSI014	14
	xxx.xx SE4-15	16.71-17.70	43.3	22.5	13.6	BTSI015	15
	xxx.xx SE4-16	17.71-18.90	43.6	22.5	14.5	BTSI016	16
	xxx.xx SE4-17	18.91-20.00	43.6	22.5	15.5	BTSI017	17

Tube D119 | Cutting Condition D182

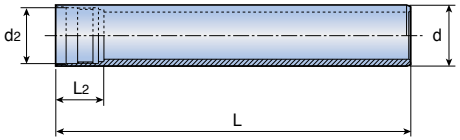
• '*' Designates outer two start thread

TaeguTec

BTSI

Single tube





• Inner four start thread

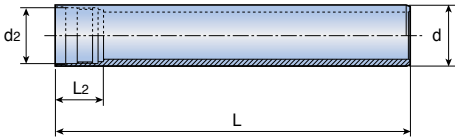
Designation	D range	Dimension (mm)		
		d	d2	L2
BTSI 011 *	12.60-13.60	11.0	9.6	22
012 *	13.61-14.60	12.0	10.6	22
013 *	14.61-15.59	13.0	11.6	22
014	15.60-16.70	14.0	12.6	21
015	16.71-17.70	15.0	13.6	21
016	17.71-18.90	16.0	14.5	22
017	18.91-20.00	17.0	15.5	22
018	20.01-21.80	18.0	16.0	27.5
020	21.81-24.10	20.0	18.0	30
022	24.11-26.40	22.0	19.5	30
024	26.41-28.70	24.0	21.0	30
026	28.71-31.00	26.0	23.5	33
028	31.01-33.30	28.0	25.5	33
030	33.31-36.20	30.0	28.0	33
033	36.21-39.60	33.0	30.0	40
036	39.61-43.00	36.0	33.0	40
039	43.01-47.00	39.0	36.0	40
043	47.01-51.70	43.0	39.0	40
047	51.71-56.20	47.0	43.0	44

• Please indicate overall length (L) when ordering
• '*' Indicates parts are inner two start thread

BTSI

Single tube





• Inner four start thread

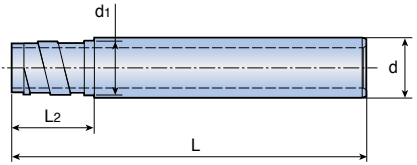
Designation		D range	Dimension (mm)		
			d	d2	L2
BTSI	051	56.21-60.60	51.0	47	44
	056A	60.61-65.00	56.0	51	44
	056B	65.00-66.99	56.0	52	75
	062	67.00-72.99	62.0	58	75
	068	73.00-79.99	68.0	63	75
	075	80.00-86.99	75.0	70	97
	082	87.00-99.99	82.0	77	97
	094	100.00-111.99	94.0	89	97
	106	112.00-123.99	106.0	101	118
	118	124.00-135.99	118.0	113	118
	130	136.00-147.99	130.0	125	118
	142	148.00-159.99	142.0	137	139
	154	160.00-171.99	154.0	149	139
	166	172.00-183.99	166.0	161	139
	178	184.00-195.99	178.0	173	144
	190	196.00-207.99	190.0	185	144
	202	208.00-219.99	202.0	197	144
	214	220.00-231.99	214.0	208	164
	226	232.00-243.99	226.0	220	164
	238	244.00-255.99	238.0	232	164
	250	256.00-269.99	250.0	244	184
	262	268.00-279.99	262.0	256	184
	274	280.00-291.99	274.0	268	184

• Please indicate overall length (L) when ordering

BTSE

Single tube





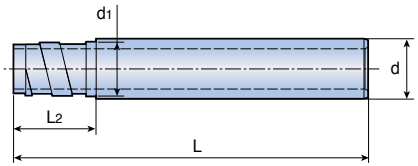
• Outer single start thread

Designation		D range	Dimension (mm)		
			d	d_1	L_2
BTSE	**012A**	14.50-15.00	12.0	11.5	23
	012B	15.01-15.50	12.0	11.8	23
	013A	15.51-16.00	13.0	12.4	23
	013B	16.01-16.50	13.0	12.7	23
	014A	16.51-17.25	14.0	13.4	23
	014B	17.26-18.00	14.0	13.7	23
	015	18.01-19.00	15.0	14.4	23
	016.5	19.01-19.99	16.5	15.4	23
	018	20.00-21.99	18.0	16.5	26
	020	22.00-24.99	20.0	19.0	26
	022	25.00-26.99	22.0	20.0	26
	024	27.00-29.99	24.0	22.0	26
	026	30.00-31.99	26.0	24.0	26
	028	32.00-33.99	28.0	26.0	26
	030	34.00-36.99	30.0	27.0	41
	033	37.00-39.99	33.0	30.0	41
	036	40.00-43.99	36.0	33.0	41
	039	44.00-46.99	39.0	37.0	41
	043	47.00-51.99	43.0	41.0	41

• Please indicate overall length (L) when ordering

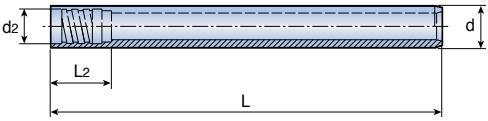
BTSE / BTSO

Single tube



BTSE

Outer single start thread



BTSO

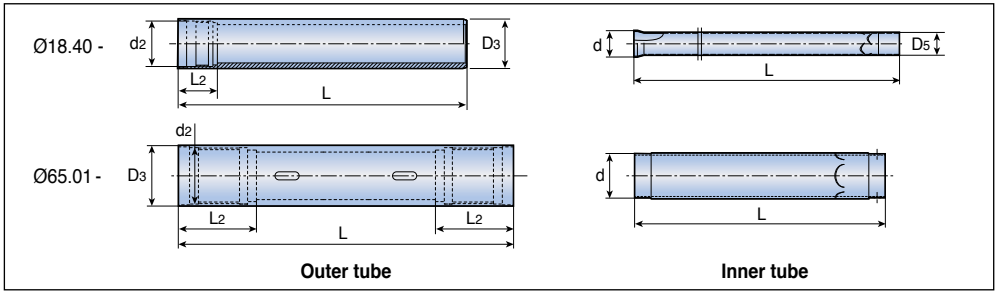
Inner single start thread

Designation		D range	Dimension (mm)			
			d	d1	d2	L2
BTSE	**047**	52.00-56.99	47.0	44	-	41
	051	57.00-60.99	51.0	49	-	41
	056	61.00-67.99	56.0	53	-	41
	062	68.00-74.99	62.0	59	-	41
	068	75.00-80.99	68.0	65	-	71
	075	81.00-90.99	75.0	71	-	71
	082	91.00-98.99	82.0	79	-	71
	094	99.00-110.99	94.0	90	-	71
	106	111.00-122.99	106.0	102	-	71
	118	123.00-134.99	118.0	114	-	71
	130	135.00-148.99	130.0	126	-	71
	142	149.00-161.99	142.0	139	-	71
	154	162.00-173.99	154.0	151	-	86
	166	174.00-185.99	166.0	163	-	86
	178	186.00-197.99	178.0	175	-	86
	190	198.00-209.99	190.0	187	-	86
	202	210.00-221.99	202.0	199	-	86
	214	222.00-233.99	214.0	211	-	86
	226	234.00-245.99	226.0	223	-	86
	238	246.00-257.99	238.0	235	-	86
	250	258.00-269.99	250.0	247	-	121
	262	270.00-281.99	262.0	259	-	121
	274	282.00-293.99	274.0	271	-	121
BTSO	**071**	8.00-8.99	7.1	-	6.0	16
	083	9.00-9.99	8.3	-	7.2	16
	090	10.00-10.99	9.0	-	7.6	16
	100	11.00-11.99	10.0	-	8.6	16
	110	12.00-13.49	11.0	-	9.1	16
	120	13.50-14.79	12.0	-	10.8	16

• Please indicate overall length (L) when ordering

BTDO / BTDI

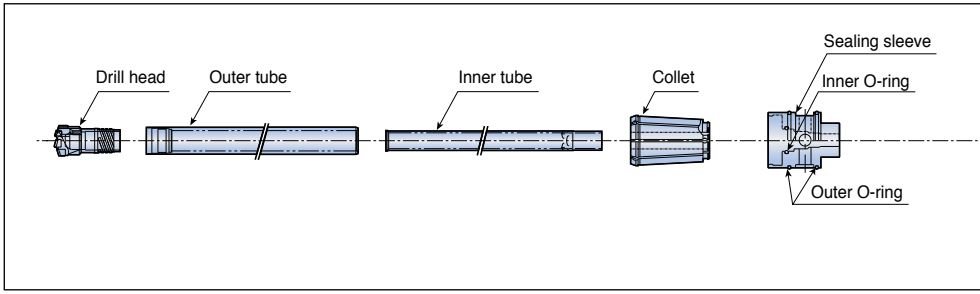
Double tube



D Range	Outer tube	Dimension (mm)			Inner tube	Dimension (mm)	
		D3	d2	L2		d	D5
18.40-20.00	**BTDO 018**	18.0	16	27.5	**BTDI 012**	10	12
20.01-21.80	**019.5**	19.5	18	30	**014**	12	14
21.81-24.10	**021.5**	21.5	19.5	30	**015**	13	15
24.11-26.40	**023.5**	23.5	21	30	**016**	14	16
26.41-28.70	**026**	26.0	23.5	33	**018**	16	18
28.71-31.00	**028**	28.0	25.5	33	**020**	18	20
31.01-33.30	**030.5**	30.5	28	33	**022**	20	22
33.31-36.20	**033**	33.0	30	40	**024**	22	24
36.21-39.60	**035.5**	35.5	33	40	**026**	24	26
39.61-43.00	**039**	39.0	36	40	**029**	27	29
43.01-47.00	**042.5**	42.5	39	40	**032**	30	32
47.01-51.70	**046.5**	46.5	43	44	**035**	32	35
51.71-56.20	**051**	51.0	47	44	**039**	36	39
56.21-65.00	**055.5**	55.5	51	44	**043A**	40	43
65.01-69.99	**056**	56.0	52	75	**043B**	40	-
70.00-72.99	**062**	62.0	58	75	**048**	44	-
73.00-79.99	**068**	68.0	63	75	**053**	48	-
80.00-86.99	**075**	75.0	70	97	**059**	54	-
87.00-99.99	**082**	82.0	77	97	**066**	60	-
100.00-111.99	**094**	94.0	89	97	**078**	70	-
112.00-123.99	**106**	106.0	101	118	**090**	80	-
124.00-135.99	**118**	118.0	113	118	**092**	80	-
136.00-147.99	**130**	130.0	125	118	**104**	95	-
148.00-159.99	**142**	142.0	137	139	**116**	100	-
160.00-171.99	**154**	154.0	149	139	**128**	120	-
172.00-183.99	**166**	166.0	161	139	**138**	130	-

• Please indicate overall length (L) when ordering
- For diameter range 18.40 - 65.00 (BTDO 055.5) the inner tube should be ordered 30mm longer than the outer tube
- For diameter range 65.01 - 123.99 (BTDO 056 - BTDO 106) the inner tube should be ordered 190mm longer than outer tube
- For diameter range 124.00 - 183.99 (BTDO 118 - BTDO 166) the inner tube should be ordered 220mm longer than the outer tube

Assembly of Double Tube System

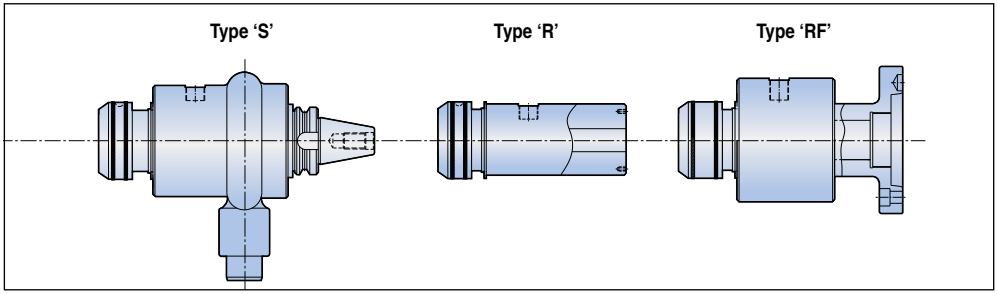


Designation		D range	Collet
BTDO 018	**BTDI 012**	18.40-19.20	COLLET 4-18 *
018	**012**	19.21-20.00	COLLET 4-18 *
019.5	**014**	20.01-20.90	COLLET 4-19.5 *
019.5	**014**	20.91-21.80	COLLET 4-19.5 *
021.5	**015**	21.81-22.90	COLLET 4-21.5 *
021.5	**015**	22.91-24.10	COLLET 4-21.5 *
023.5	**016**	24.11-25.20	COLLET 4-23.5 *
023.5	**016**	25.21-26.40	COLLET 4-23.5 *
026	**018**	26.41-27.50	COLLET 4-26 *
026	**018**	27.51-28.70	COLLET 4-26 *
028	**020**	28.71-29.80	COLLET 4-28 *
028	**020**	29.81-31.00	COLLET 4-28 *
030.5	**022**	31.01-32.10	COLLET 4-30.5 *
030.5	**022**	32.11-33.30	COLLET 4-30.5 *
033	**024**	33.31-34.80	COLLET 4-33 *
033	**024**	34.81-36.20	COLLET 4-33 *
035.5	**026**	36.21-37.30	COLLET 4-35.5
035.5	**026**	37.31-38.40	COLLET 4-35.5
035.5	**026**	38.41-39.60	COLLET 4-35.5
039	**029**	39.61-40.60	COLLET 4-39
039	**029**	40.61-41.80	COLLET 4-39
039	**029**	41.81-43.00	COLLET 4-39
042.5	**032**	43.01-44.30	COLLET 4-42.5
042.5	**032**	44.31-45.60	COLLET 4-42.5
042.5	**032**	45.61-47.00	COLLET 4-42.5
046.5	**035**	47.01-48.50	COLLET 4-46.5
046.5	**035**	48.51-50.10	COLLET 4-46.5
046.5	**035**	50.11-51.70	COLLET 4-46.5
051	**039**	51.71-53.20	COLLET 4-51
051	**039**	53.21-54.70	COLLET 4-51
051	**039**	54.71-56.20	COLLET 4-51
055.5	**043A**	56.21-58.40	COLLET 4-55.5
055.5	**043A**	58.41-60.60	COLLET 4-55.5
055.5	**043A**	60.61-62.80	COLLET 4-55.5
055.5	**043A**	62.81-65.00	COLLET 4-55.5

- '*' For DTC-3S/R/RF, the description of collet & sealing sleeve should be 'COLLET 3-..' and 'SEALING SLEEVE 3-..'.
- Inner tube should be longer than outer tube. Please refer to page D119-D120 for details

Assembly of Double Tube System

Connector



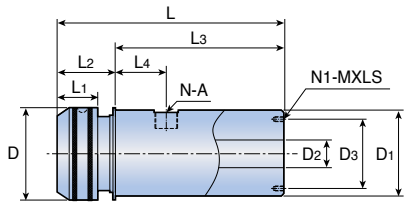
Sealing sleeve	Outer O-ring	Inner O-ring	Connector
SEALING SLEEVE 4R-18 *	OOR 25.24	IOR18	DTC-3S/3R/3RF
SEALING SLEEVE 4R-18 *		IOR18	
SEALING SLEEVE 4R-19.5 *		IOR19.5	
SEALING SLEEVE 4R-19.5 *		IOR19.5	
SEALING SLEEVE 4R-21.5 *		IOR21.5	
SEALING SLEEVE 4R-21.5 *		IOR21.5	
SEALING SLEEVE 4R-23.5 *		IOR23.5	
SEALING SLEEVE 4R-23.5 *		IOR23.5	
SEALING SLEEVE 4R-26 *		IOR26	
SEALING SLEEVE 4R-26 *		IOR26	
SEALING SLEEVE 4R-28 *		IOR28	
SEALING SLEEVE 4R-28 *		IOR28	
SEALING SLEEVE 4R-30.5 *		IOR30.5	
SEALING SLEEVE 4R-30.5 *		IOR30.5	
SEALING SLEEVE 4R-33 *		IOR33	
SEALING SLEEVE 4R-33 *		IOR33	
SEALING SLEEVE 4R-35.5	OOR65	IOR35.5	DTC-4S/4R/4RF
SEALING SLEEVE 4R-35.5		IOR35.5	
SEALING SLEEVE 4R-35.5		IOR35.5	
SEALING SLEEVE 4R-39		IOR39	
SEALING SLEEVE 4R-39		IOR39	
SEALING SLEEVE 4R-39		IOR39	
SEALING SLEEVE 4R-42.5		IOR42.5	
SEALING SLEEVE 4R-42.5		IOR42.5	
SEALING SLEEVE 4R-42.5		IOR42.5	
SEALING SLEEVE 4R-46.5		IOR46.5	
SEALING SLEEVE 4R-46.5		IOR46.5	
SEALING SLEEVE 4R-46.5		IOR46.5	
SEALING SLEEVE 4R-51		IOR51	
SEALING SLEEVE 4R-51		IOR51	
SEALING SLEEVE 4R-51		IOR51	
SEALING SLEEVE 4R-55.5		IOR55.5	
SEALING SLEEVE 4R-55.5		IOR55.5	
SEALING SLEEVE 4R-55.5		IOR55.5	
SEALING SLEEVE 4R-55.5		IOR55.5	

- '*' For DTC-3S/R/RF, the description of collet & sealing sleeve should be 'COLLET 3-..' and 'SEALING SLEEVE 3-..'.
- Inner tube should be longer than outer tube. Please refer to page D119-D120 for details

DTC-S

T-DEEP

'S' type connector

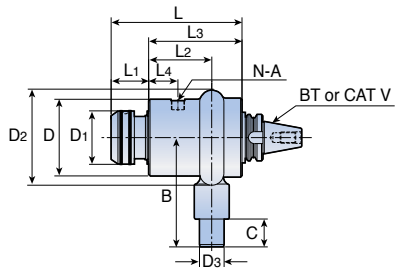


Designation	D range	D	D1	D2	D3	L	L1	L2	L3	L4	N-A	N1-MXLS
DTC 3S	18.4-26.4	62	63	18	50	240	28.5	40	200	65	2-PT1/2"	4-M6x11
4S	18.4-65.0	112	100	40	80	315	50	65	250	80	2-PT3/4"	4-M8x15
5S	65.0-123.9	164	140	81	120	415	47	115	300	130	2-PT1"	6-M8x20

DTC-R

T-DEEP

'R' type connector

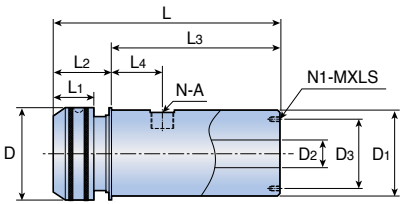


Designation	D range	D	D1	D2	D3	B	C	L	L1	L2	L3	L4	N-A
DTC 3R	18.4-26.4	110	74	150	40	150	50	228	39	130	189	65	2-PT3/4"
4R	18.4-65.0	165	115	206	53	186.5	60	300	72	152	228	75	2-PT1"
5R	65.0-123.9	225	164	312	100	310	100	382	62	201	320	95	2-PT1 1/4"
6R	124.0-183.9	310	214	410	140	300	100	427	62	228	365	103	3-PT1-1/4"

DTC-RF

T-DEEP

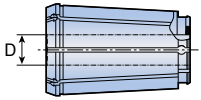
'RF' type connector



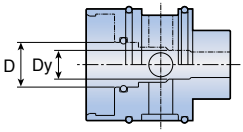
Designation	D range	D	D1	D2	D3	L	L1	L2	L3	L4	N-A	N1-MXLS
DTC 3RF	18.4-26.4	110	74	135	M30x1.5	18	234	39	130	65	2-PT3/4"	A1-5
4RF	18.4-65.0	165	115	210	M62x2	40	293	72	146	63	2-PT1"	A1-8
5RF	65.0-123.9	226	164	280	85	81	335	62	190	95	2-PT1 1/4"	A1-11

Collet / Sealing Sleeve

T-DEEP



Collet



Sealing sleeve

Designation	D range	D	Designation	D range	D	Dy	Outer O-ring	Inner O-ring
COLLET 4-18	18.40-20.00	18.0	**SEALING SLEEVE 4-18**	18.40-20.00	18.0	10		IOR 18
4-19.5	20.01-21.80	19.5	**4-19.5**	20.01-21.80	19.5	12		IOR 19.5
4-21.5	21.81-24.10	21.5	**4-21.5**	21.81-24.10	21.5	13		IOR 21.5
4-23.5	24.11-26.40	23.5	**4-23.5**	24.11-26.40	23.5	14		IOR 23.5
4-26	26.41-28.70	26.0	**4-26**	26.41-28.70	26.0	16		IOR 26
4-28	28.71-31.00	28.0	**4-28**	28.71-31.00	28.0	18		IOR 28
4-30.5	31.01-33.30	30.5	**4-30.5**	31.01-33.30	30.5	20	OOR 65	IOR 30.5
4-33	33.31-36.20	33.0	**4-33**	33.31-36.20	33.0	22		IOR 33
4-35.5	36.21-39.60	35.5	**4-35.5**	36.21-39.60	35.5	24		IOR 35.5
4-39	39.61-43.00	39.0	**4-39**	39.61-43.00	39.0	27		IOR 39
4-42.5	43.01-47.00	42.5	**4-42.5**	43.01-47.00	42.5	30		IOR 42.5
4-46.5	47.01-51.70	46.5	**4-46.5**	47.01-51.70	46.5	32		IOR 46.5
4-51	51.71-56.20	51.0	**4-51**	51.71-56.20	51.0	36		IOR 51
4-55.5	56.21-65.00	55.5	**4-55.5**	56.21-65.00	55.5	40		IOR 55.5

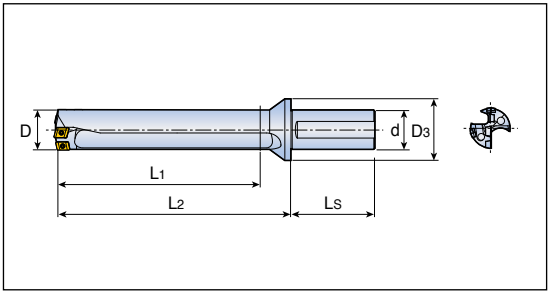
HFD...T2

Indexable deep drill holder



- Deep hole drilling application
- Drilling depth: 6xD - 14xD
- Pilot hole required





Designation	Dimension (mm)						
	D	d	D3	L1	L2	LS	L/D
HFD 300-32T2-14D	30	32	40	420	449	60	14
310-32T2-13D	31	32	40	420	449	60	13
320-40T2-13D	32	40	50	420	449	70	13
330-40T2-12D	33	40	50	420	449	70	12
340-40T2-12D	34	40	50	420	450	70	12
350-40T2-12D	35	40	50	420	450	70	12
360-40T2-11D	36	40	50	420	450	70	11
370-40T2-11D	37	40	50	420	453	70	11
380-40T2-11D	38	40	50	420	453	70	11
390-40T2-10D	39	40	50	420	453	70	10
400-40T2-10D	40	40	50	420	454	70	10
410-40T2-10D	41	40	50	420	454	70	10
420-40T2-10D	42	40	50	420	454	70	10
430-40T2-9D	43	40	50	420	456	70	9
440-40T2-9D	44	40	50	420	456	70	9
450-40T2-9D	45	40	50	420	456	70	9
460-40T2-9D	46	40	50	420	459	70	9
470-40T2-8D	47	40	50	420	459	70	8
480-40T2-8D	48	40	50	420	459	70	8
490-40T2-8D	49	40	50	420	461	70	8
500-40T2-8D	50	40	50	420	461	70	8
510-40T2-8D	51	40	50	420	461	70	8
520-40T2-8D	52	40	-	420	464	70	8
530-40T2-7D	53	40	-	420	464	70	7
540-40T2-7D	54	40	-	420	464	70	7
550-40T2-7D	55	40	-	420	464	70	7
560-40T2-7D	56	40	-	420	464	70	7
570-40T2-7D	57	40	-	420	464	70	7
580-40T2-7D	58	40	-	420	470	70	7
590-40T2-7D	59	40	-	420	470	70	7
600-40T2-7D	60	40	-	420	470	70	7
610-40T2-6D	61	40	-	420	470	70	6
620-40T2-6D	62	40	-	420	470	70	6
630-40T2-6D	63	40	-	420	470	70	6
640-40T2-6D	64	40	-	420	473	70	6

Assembly D129 | Cutting Condition D184

- Available on request

TaeguTec

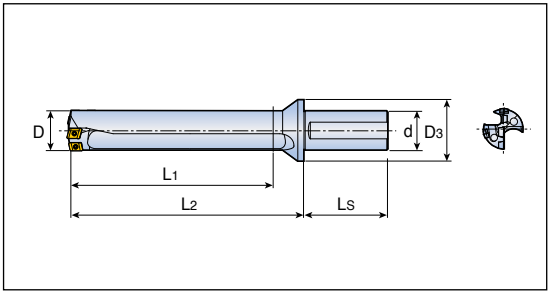
HFD...T2

Indexable deep drill holder



- Deep hole drilling application
- Drilling depth: 6xD - 14xD
- Pilot hole required





Designation	Dimension (mm)						
	D	d	D3	L1	L2	LS	L/D
HFD 650-40T2-6D	65	40	-	420	473	70	6
660-40T2-6D	66	40	-	420	473	70	6
670-40T2-6D	67	40	-	420	473	70	6
680-40T2-6D	68	40	-	420	473	70	6
690-40T2-6D	69	40	-	420	473	70	6

- Available on request

Insert & guide pad

Tool dia. (mm)	Insert			Guide PAD
	Outer	Inner	Center	
30.00-33.00	NPMT 06504 RG	NPMT 06504 RG	NPMT 06504 LG	PAD-GO07CD-SA/SB
33.01-36.00	NPMT 06504 RG	NPMT 06504 RG	NPMT 0804 LG	PAD-GO07CD-SA/SB
36.01-39.00	NPMT 0804 RG	NPMT 06504 RG	NPMT 0804 LG	PAD-GO07CD-SA/SB
39.01-42.00	NPMT 0804 RG	NPMT 0804 RG	NPMT 0804 LG	PAD-GO08CD
42.01-45.00	NPMT 0804 RG	NPMT 0804 RG	NPMT 09504 LG	PAD-GO08CD
45.01-48.00	NPMT 09504 RG	NPMT 0804 RG	NPMT 09504 LG	PAD-GO10CD-SA/SB
48.01-51.00	NPMT 09504 RG	NPMT 09504 RG	NPMT 09504 LG	PAD-GO10CD-SA/SB
51.01-57.00	NPMT 09504 RG	NPMT 09504 RG	NPMT 12504 LG	PAD-GO10CD-SA/SB
57.01-63.00	NPMT 12504 RG	NPMT 09504 RG	NPMT 12504 LG	PAD-GO12CD-SA/SB
63.01-69.00	NPMT 12504 RG	NPMT 12504 RG	NPMT 12504 LG	PAD-GO12CD-SA/SB

Pilot hole size

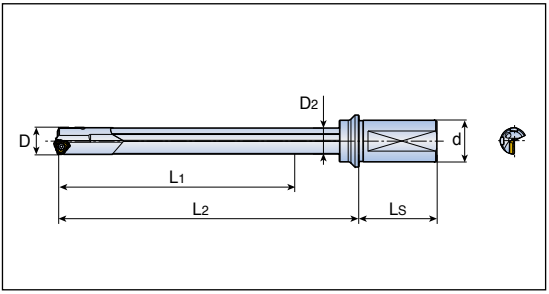
Tool dia. (mm)	Pilot hole tolerance	Pilot hole depth (mm)
30.00-39.00	H8	Min. 10.0
39.01-45.00	H8	Min. 12.5
45.01-57.00	H8	Min. 15.0
57.01-69.00	H8	Min. 17.5

D152 | Guide Pad D156 | Cutting Condition D184

TRGD

Standard gundrill holder





• Drilling depth: 10xD - 25xD



Designation	Dimension (mm)						
	D	D2	L1	L2	Ls	d	L/D
TRGD 16.00xM25-10	16.0	15.5	170	209	56	25	10
16.50xM25-10	16.5	15.5	170	209	56	25	10
17.00xM25-10	17.0	16.2	180	220	56	25	10
18.00xM25-10	18.0	17.2	190	232	56	25	10
19.00xM25-10	19.0	18.2	200	243	56	25	10
20.00xM32-10	20.0	19.0	210	255	60	32	10
16.00xM25-15	16.0	15.5	255	294	56	25	15
16.50xM25-15	16.5	15.5	255	294	56	25	15
17.00xM25-15	17.0	16.2	270	310	56	25	15
17.50xM25-15	17.5	16.2	270	310	56	25	15
18.00xM25-15	18.0	17.2	285	327	56	25	15
18.50xM25-15	18.5	17.2	285	327	56	25	15
19.00xM25-15	19.0	18.2	300	343	56	25	15
19.50xM25-15	19.5	18.2	300	343	56	25	15
20.00xM32-15	20.0	19.0	315	360	60	32	15
21.00xM32-15	21.0	20.0	330	376	60	32	15
22.00xM32-15	22.0	21.0	345	393	60	32	15
23.00xM32-15	23.0	22.0	360	409	60	32	15
24.00xM32-15	24.0	23.0	375	426	60	32	15
25.00xM32-15	25.0	24.0	390	442	60	32	15
26.00xM40-15	26.0	25.0	405	449	70	40	15
27.00xM40-15	27.0	26.0	420	465	70	40	15
28.00xM40-15	28.0	27.0	420	467	70	40	15
16.00xM25-25	16.0	15.5	425	464	56	25	25
16.50xM25-25	16.5	15.5	425	464	56	25	25
17.00xM25-25	17.0	16.2	450	490	56	25	25
17.50xM25-25	17.5	16.2	450	490	56	25	25
18.00xM25-25	18.0	17.2	475	517	56	25	25
18.50xM25-25	18.5	17.2	475	517	56	25	25
19.00xM25-25	19.0	18.2	500	543	56	25	25
19.50xM25-25	19.5	18.2	500	543	56	25	25
20.00xM32-25	20.0	19.0	525	570	60	32	25
21.00xM32-25	21.0	20.0	550	596	60	32	25
22.00xM32-25	22.0	21.0	575	623	60	32	25
23.00xM32-25	23.0	22.0	600	649	60	32	25

Assembly D132
Cutting Condition D186

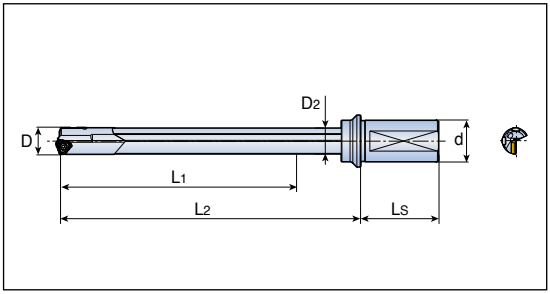
• **Note**: Guide pads are sold separately from drill body.

• Available on request

TRGD

Standard gundrill holder





• Drilling depth: 10xD - 25xD



Designation		Dimension (mm)						
		D	D2	L1	L2	Ls	d	L/D
TRGD	24.00xM32-25	24.0	23.0	625	676	60	32	25
	25.00xM32-25	25.0	24.0	650	702	60	32	25
	26.00xM40-25	26.0	25.0	675	719	70	40	25
	27.00xM40-25	27.0	26.0	700	745	70	40	25
	28.00xM40-25	28.0	27.0	700	747	70	40	25

Assembly D132
Cutting Condition D186

• **Note**: Guide pads are sold separately from drill body.

• Available on request

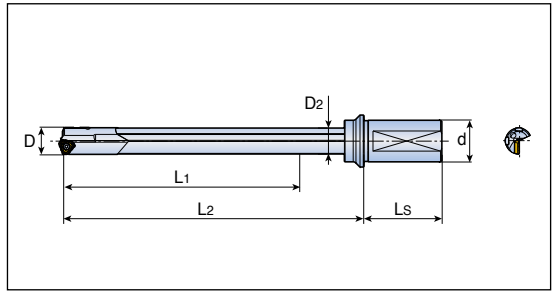
TaeguTec Member IMC Group

TRGD

T-DEEP

Special gundrill holder





• Drilling depth: 10xD - 25xD



Designation	Dimension (mm)					
	D	D2	L1	L2	Ls	d
TRGD □□.□□x□□□-□□	16.00-16.79	15.5	136-425	175-464	56	25
	16.80-17.69	16.2	144-450	184-490	56	25
	17.70-18.69	17.2	152-475	194-517	56	25
	18.70-19.69	18.2	160-500	203-543	56	25
	19.70-20.69	19.0	168-525	213-570	60	32
	20.70-21.69	20.0	176-550	222-596	60	32
	21.70-22.69	21.0	184-575	232-623	60	32
	22.70-23.69	22.0	192-600	241-649	60	32
	23.70-24.69	23.0	200-625	251-676	60	32
	24.70-25.69	24.0	208-650	260-702	60	32
	25.70-26.69	25.0	216-675	270-719	70	40
	26.70-27.69	26.0	224-700	279-745	70	40
	27.70-28.00	27.0	224-700	281-747	70	40

• **Note**: Guide pads are sold separately from drill body.

• Available on request

Insert & guide pad

Tool dia. (mm)	Insert			Guide pad		
	Insert	Screw	Wrench	Guide pad	Screw	Wrench
16.00-18.00	TOGT 080305 RS TT9030	CSTB 2.5S	T-8F	PAD-GO06-075CD-SA PAD-GO06-075CD-SB	CSTB 2.2S	T-7F
18.01-20.00	TOGT 090305 RS TT9030	CSTB 2.5S	T-8F	PAD-GO06-085CD-SA PAD-GO06-085CD-SB	CSTB 2.2S	T-7F
20.01-21.00	TOGT 100305 RS TT9030	CSTB 3S	T-9F			
21.01-21.99	TOGT 100305 RS TT9030	CSTB 3S	T-9F	PAD-GO06-100CD-SA PAD-GO06-100CD-SB	CSTB 2.2S	T-7F
22.00-25.00	TOGT 110405 RS TT9030	CSTB 3.5H	T-15F			
25.01-28.00	TOGT 120405 RS TT9030	CSTB 4S	T-15F	PAD-GO06CD-SA PAD-GO06CD-SB	CSTB 2.2S	T-7F







• Guide pad with "SB" is the first choice in general purpose machining.
"SA" is a supplementary grade used only with oil based coolant.
• Inserts and guide pads must be ordered separately

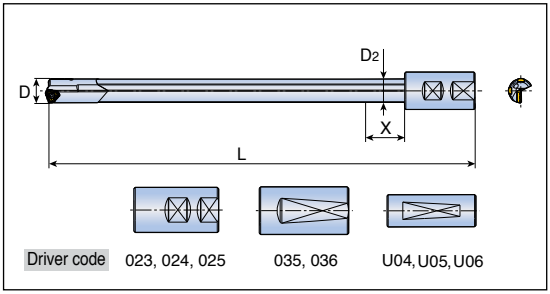
TaeguTec
Member IMC Group

TRGDL

T-DEEP

Standard gundrill holder





- Drilling depth: 10xD - 25xD

Designation		Driver code	Dimension (mm)			
			D	L	D2	X
TRGDL	16.00x800-XXX	U04 023 035	16	800	15.5	24
	16.00x1000-XXX		16	1000	15.5	24
	16.00x1500-XXX		16	1500	15.5	24
	17.00x1000-XXX		17	1000	16.2	25
	17.00x1500-XXX		17	1500	16.2	25
	18.00x800-XXX		18	800	17.2	27
	18.00x1000-XXX		18	1000	17.2	27
	18.00x1500-XXX		18	1500	17.2	27
	19.00x800-XXX		19	800	18.2	28
	19.00x1000-XXX		19	1000	18.2	28
	19.00x1500-XXX		19	1500	18.2	28
	20.00x800-XXX	U05 024 036	20	800	19.0	30
	20.00x1000-XXX		20	1000	19.0	30
	20.00x1500-XXX		20	1500	19.0	30
	21.00x1000-XXX		21	1000	20.0	31
	21.00x1500-XXX		21	1500	20.0	31
	22.00x1000-XXX		22	1000	21.0	33
	22.00x1500-XXX		22	1500	21.0	33
	23.00x1000-XXX		23	1000	22.0	34
	23.00x1500-XXX		23	1500	22.0	34
	24.00x1000-XXX		24	1000	23.0	36
	24.00x1500-XXX		24	1500	23.0	36
	25.00x1000-XXX		25	1000	24.0	37
	25.00x1500-XXX		25	1500	24.0	37
	26.00x1000-XXX	U06 025 026 036	26	1000	25.0	39
	26.00x1500-XXX		26	1500	25.0	39
	27.00x1000-XXX		27	1000	26.0	40
	27.00x1500-XXX		27	1500	26.0	40
	28.00x1000-XXX		28	1000	27.0	42
	28.00x1500-XXX		28	1500	27.0	42

Assembly D134
Cutting Condition D186

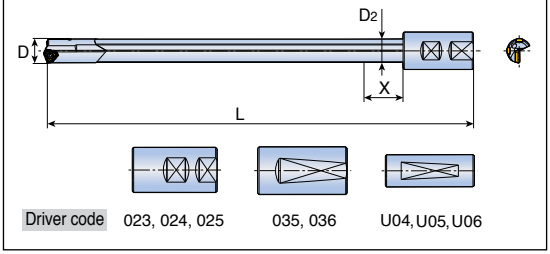
- **Note**: Guide pads are sold separately from drill body.
- Select "XXX" driver code.

TaeguTec Member IMC Group

TRGDL

Special gundrill holder





• Drilling depth: 10xD - 25xD



Designation		Dimension (mm)			
		D	L	d_1	X
TRGDL	**□□.□□x□□□□-XXX**	16.00-16.79	400-2400	15.5	24
		16.80-17.69	400-2400	16.2	25
		17.70-18.69	400-2400	17.2	27
		18.70-19.69	400-2400	18.2	28
		19.70-20.69	400-2400	19.0	30
		20.70-21.69	400-2400	20.0	31
		21.70-22.69	400-2400	21.0	33
		22.70-23.69	400-2400	22.0	34
		23.70-24.69	400-2400	23.0	36
		24.70-25.69	400-2400	24.0	37
		25.70-26.69	400-2400	25.0	39
		26.70-27.69	400-2400	26.0	40
		27.70-28.00	400-2400	27.0	42

• **Note**: Guide pads are sold separately from drill body.

• Available upon request
• Select "XXX" driver code

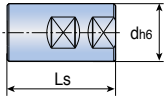
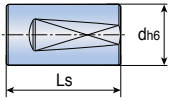
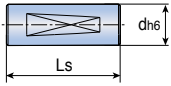
Insert & guide pad

Tool dia. (mm)	Insert			Guide pad		
	Insert	Screw	Wrench	Guide pad	Screw	Wrench
16.00-18.00	TOGT 080305 RS TT9030	CSTB 2.5S	T-8F	PAD-GO06-075CD-SA PAD-GO06-075CD-SB	CSTB 2.2S	T-7F
18.01-20.00	TOGT 090305 RS TT9030	CSTB 2.5S	T-8F	PAD-GO06-085CD-SA PAD-GO06-085CD-SB	CSTB 2.2S	T-7F
20.01-21.00	TOGT 100305 RS TT9030	CSTB 3S	T-9F			
21.01-21.99	TOGT 100305 RS TT9030	CSTB 3S	T-9F	PAD-GO06-100CD-SA PAD-GO06-100CD-SB	CSTB 2.2S	T-7F
22.00-25.00	TOGT 110405 RS TT9030	CSTB 3.5H	T-15F			
25.01-28.00	TOGT 120405 RS TT9030	CSTB 4S	T-15F	PAD-GO06CD-SA PAD-GO06CD-SB	CSTB 2.2S	T-7F

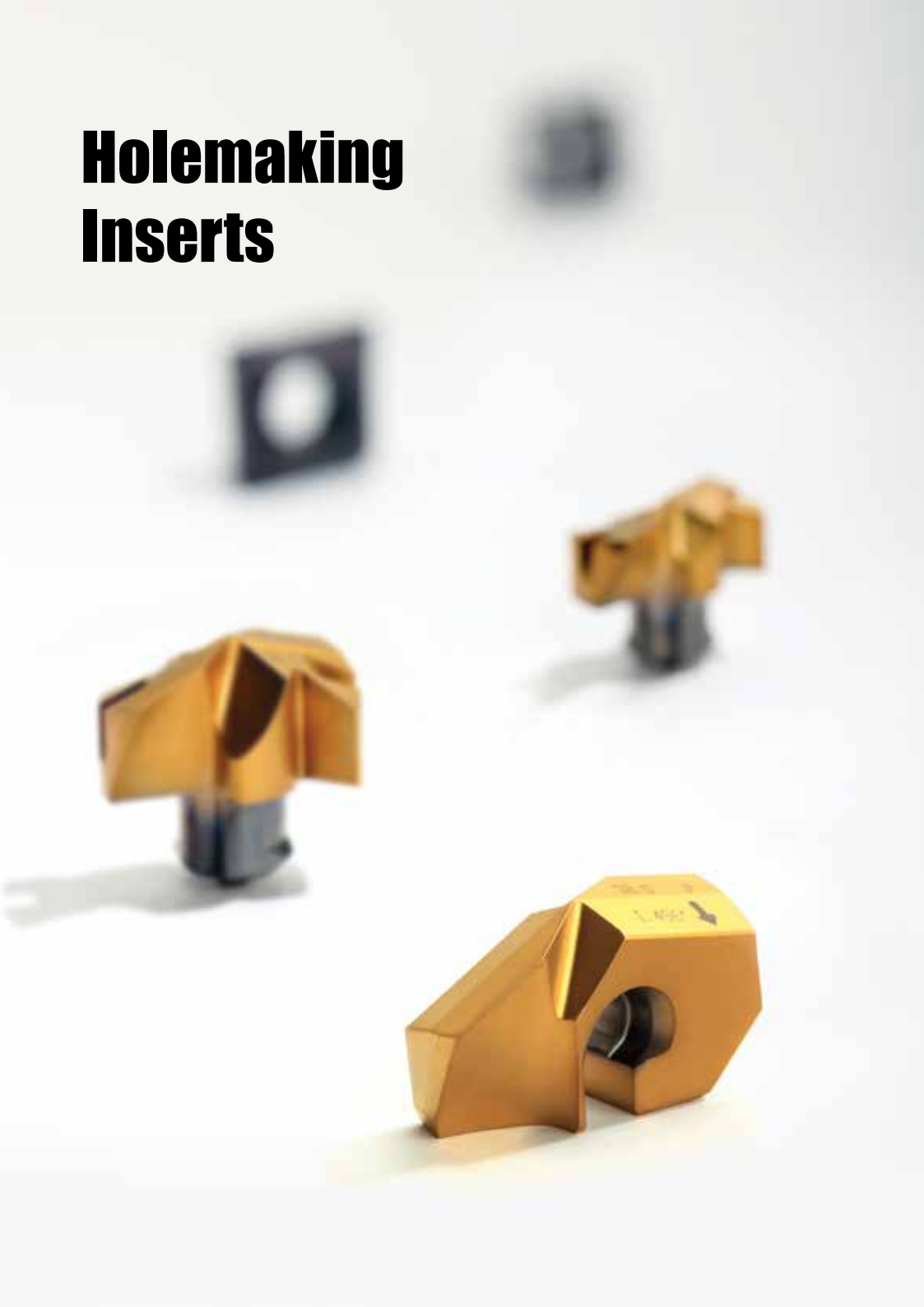


• Guide pad with "SB" is the first choice in general purpose machining.
"SA" is a supplementary grade used only with oil based coolant.
• Inserts and guide pads must be ordered separately

Driver for TRGDL Type

Driver	Tool diameter	Driver code	Dimension (mm)	
			Ls	d
	16.00-19.69	023	56	25.00
	16.00-25.69	024	60	32.00
	16.00-28.00	025	70	40.00
	16.00-28.00	026	80	50.00
	16.00-19.69	035	56	25.00
	16.00-25.69	036	60	32.00
	16.00-19.69	U04	70	25.40
	16.00-25.69	U05	70	31.75
	16.00-28.00	U06	70	38.10

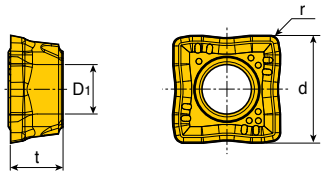
Holemaking Inserts



SOMT...DP

TOPDRILL

Insert



Size	Dimension (mm)			
	d	t	r	D1
05	4.9	2.38	0.4	2.25
06	5.7	2.38	0.4	2.60
07	6.8	2.80	0.6	2.60
08	7.9	3.97	0.6	2.85
09	9.2	3.97	0.8	3.80
11	11.0	3.97	0.8	3.80
13	12.8	4.40	0.8	4.40
15	15.0	4.80	1.0	5.40

Insert	Designation	Coated								Uncoated			
		TT9080	TT8020	TT9300	TT9030	TT6030	TT7400			K10			
	**SOMT 050204 DP**	●	●	●									
	060204 DP	●	●	●									
	070306 DP	●	●	●									
	08T306 DP	●	●	●									
	09T308 DP	●	●	●									
	11T308 DP	●	●	●									
	130408 DP	●	●	●									
	150510 DP	●	●	●									



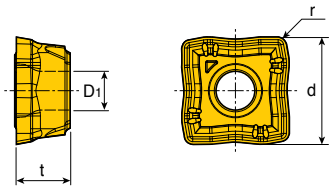
- TT9080: First choice for general purpose
- TT8020: For unstable condition
- TT9300: For high speed machining on a steel application (Peripheral **ONLY**)

●: Standard item

SOMT...DK

TOPDRILL

Insert



Size	Dimension (mm)			
	d	t	r	D1
05	4.9	2.38	0.4	2.25
06	5.7	2.38	0.4	2.60
07	6.8	2.80	0.6	2.60
08	7.9	3.97	0.6	2.85
09	9.2	3.97	0.8	3.80
11	11.0	3.97	0.8	3.80
13	12.8	4.40	0.8	4.40
15	15.0	4.80	1.0	5.40

Insert	Designation	Coated								Uncoated			
		TT9080	TT8020	TT9300	TT9030	TT6030	TT6080	TT7400		K10			
	**SOMT 050204 DK**						●						
	060204 DK						●						
	070306 DK						●						
	08T306 DK						●						
	09T308 DK						●						
	11T308 DK						●						
	130408 DK						●						
	150510 DK						●						



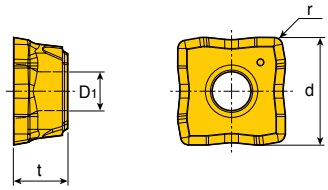
●: Standard item

TaeguTec
Member IMC Group

SOMT...DA

TOPDRILL

Insert



Size	Dimension (mm)			
	d	t	r	D1
05	4.9	2.38	0.4	2.25
06	5.7	2.38	0.4	2.60
07	6.8	2.80	0.6	2.60
08	7.9	3.97	0.6	2.85
09	9.2	3.97	0.8	3.80
11	11.0	3.97	0.8	3.80
13	12.8	4.40	0.8	4.40
15	15.0	4.80	1.0	5.40

Insert	Designation		Coated							Uncoated			
			TT9080	TT8020	TT9300	TT9030	TT6030	TT6080	TT7400		K10		
	**SOMT**	**050204 DA**									●		
		060204 DA									●		
		070306 DA									●		
		08T306 DA									●		
		09T308 DA									●		
		11T308 DA									●		
		130408 DA									●		
		150510 DA									●		

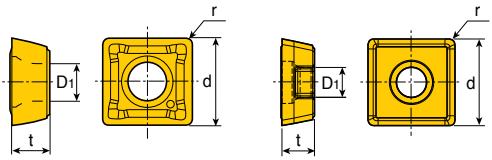
●: Standard item

D16

SPMG...DG

T-DRILL

Insert



SPMG 120408 DG

Size	Dimension (mm)			
	d	t	r	D1
05	5.00	2.38	0.4	2.25
06	6.00	2.38	0.4	2.61
07	7.94	3.97	0.8	2.85
09	9.80	4.30	0.8	4.05
11	11.50	4.80	0.8	4.45
12	12.70	4.76	0.8	4.37
14	14.30	5.20	1.2	5.75

Insert	Designation		Coated							Uncoated			
			TT9080	TT9030	TT8020	TT6030	TT9300	TT7400			K10		
	**SPMG**	**050204 DG**		●	●			●					
		060204 DG		●	●			●					
		07T308 DG		●	●			●					
		090408 DG		●	●			●					
		110408 DG		●	●			●					
		120408 DG		●									
		140512 DG		●	●			●					

●: Standard item

D28

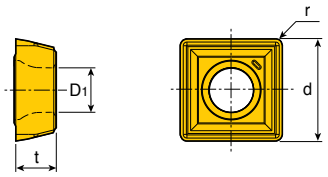
- TT9030: First choice for general purpose
- TT8020: For unstable condition
- TT7400: For high speed machining on a steel application (Peripheral **ONLY**)

TaeguTec

SPMG...DK

T-DRILL

Insert



Size	Dimension (mm)			
	d	t	r	D1
05	5.00	2.38	0.4	2.25
06	6.00	2.38	0.4	2.61
07	7.94	3.97	0.8	2.85
09	9.80	4.30	0.8	4.05
11	11.50	4.80	0.8	4.45
14	14.30	5.20	1.2	5.75

• For cast iron

Insert	Designation	Coated						Uncoated			
		TT9080	TT9030	TT8020	TT6030	TT9300	TT7400	K10			
	**SPMG 050204 DK**				●						
	060204 DK				●						
	07T308 DK				●						
	090408 DK				●						
	110408 DK				●						
	140512 DK				●						

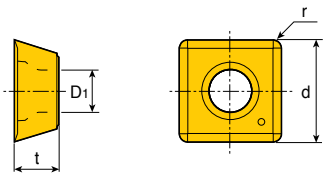
●: Standard item



SPGG...DA

T-DRILL

Insert



Size	Dimension (mm)			
	d	t	r	D1
05	5.00	2.38	0.4	2.25
06	6.00	2.38	0.4	2.61
07	7.94	3.97	0.8	2.85
09	9.80	4.30	0.8	4.05
11	11.50	4.80	0.8	4.45
14	14.30	5.20	1.2	5.75

• For aluminum alloy

Insert	Designation	Coated						Uncoated			
		TT9080	TT9030	TT8020	TT6030	TT9300	TT7400	K10			
	**SPGG 050204 DA**							●			
	060204 DA							●			
	07T308 DA							●			
	090408 DA							●			
	110408 DA							●			
	140512 DA							●			

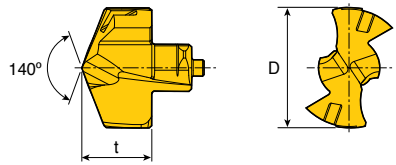
●: Standard item



TCD...P/M/K

Drill head





Designation	Dimension (mm)			Grade	Designation	Dimension (mm)			Grade
	D	t	Pocket size	TT9080		D	t	Pocket size	TT9080
TCD - 060-P/M/K	6.0	4.0	6	●	TCD - 095-P/M/K	9.5	5.8	9	●
061-P/M/K	6.1	4.0	6	●	096-P/M/K	9.6	5.8	9	●
062-P/M/K	6.2	4.0	6	●	097-P/M/K	9.7	5.8	9	●
063-P/M/K	6.3	4.0	6	●	098-P/M/K	9.8	5.8	9	●
064-P/M/K	6.4	4.0	6	●	099-P/M/K	9.9	5.8	9	●
065-P/M/K	6.5	4.3	6.5	●	100-P/M/K	10.0	6.2	10	●
066-P/M/K	6.6	4.3	6.5	●	101-P/M/K	10.1	6.2	10	●
067-P/M/K	6.7	4.3	6.5	●	102-P/M/K	10.2	6.2	10	●
068-P/M/K	6.8	4.3	6.5	●	103-P/M/K	10.3	6.2	10	●
069-P/M/K	6.9	4.3	6.5	●	104-P/M/K	10.4	6.2	10	●
070-P/M/K	7.0	4.6	7	●	105-P/M/K	10.5	6.2	10	●
071-P/M/K	7.1	4.6	7	●	106-P/M/K	10.6	6.2	10	●
072-P/M/K	7.2	4.6	7	●	107-P/M/K	10.7	6.2	10	●
073-P/M/K	7.3	4.6	7	●	108-P/M/K	10.8	6.2	10	●
074-P/M/K	7.4	4.6	7	●	109-P/M/K	10.9	6.2	10	●
075-P/M/K	7.5	4.6	7	●	110-P/M/K	11.0	6.6	11	●
076-P/M/K	7.6	4.6	7	●	111-P/M/K	11.1	6.6	11	●
077-P/M/K	7.7	4.6	7	●	112-P/M/K	11.2	6.6	11	●
078-P/M/K	7.8	4.6	7	●	113-P/M/K	11.3	6.6	11	●
079-P/M/K	7.9	4.6	7	●	114-P/M/K	11.4	6.6	11	●
080-P/M/K	8.0	5.4	8	●	115-P/M/K	11.5	6.6	11	●
081-P/M/K	8.1	5.4	8	●	116-P/M/K	11.6	6.6	11	●
082-P/M/K	8.2	5.4	8	●	117-P/M/K	11.7	6.6	11	●
083-P/M/K	8.3	5.4	8	●	118-P/M/K	11.8	6.6	11	●
084-P/M/K	8.4	5.4	8	●	119-P/M/K	11.9	6.6	11	●
085-P/M/K	8.5	5.4	8	●	120-P/M/K	12.0	7.0	12	●
086-P/M/K	8.6	5.4	8	●	121-P/M/K	12.1	7.0	12	●
087-P/M/K	8.7	5.4	8	●	122-P/M/K	12.2	7.0	12	●
088-P/M/K	8.8	5.4	8	●	123-P/M/K	12.3	7.0	12	●
089-P/M/K	8.9	5.4	8	●	124-P/M/K	12.4	7.0	12	●
090-P/M/K	9.0	5.8	9	●	125-P/M/K	12.5	7.0	12	●
091-P/M/K	9.1	5.8	9	●	126-P/M/K	12.6	7.0	12	●
092-P/M/K	9.2	5.8	9	●	127-P/M/K	12.7	7.0	12	●
093-P/M/K	9.3	5.8	9	●	128-P/M/K	12.8	7.0	12	●
094-P/M/K	9.4	5.8	9	●	129-P/M/K	12.9	7.0	12	●



• Drill head can be ordered by an application
Order example) Diameter 10.0mm drill head for ISO P application: TCD-100-P TT9080

●: Standard item

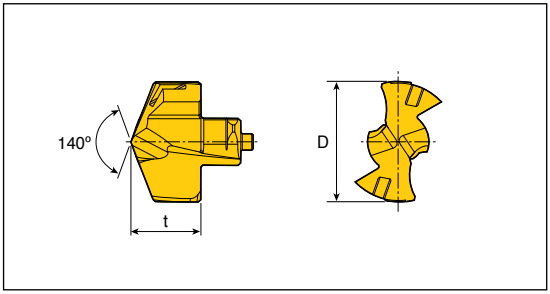
P Steel M Stainless steel K Cast iron

TaeguTec
Member IMC Group

TCD...P/M/K

Drill head





Designation	Dimension (mm)			Grade	Designation	Dimension (mm)			Grade
	D	t	Pocket size	TT9080		D	t	Pocket size	TT9080
TCD - 130-P/M/K	13.0	7.6	13	●	TCD - 165-P/M/K	16.5	9.3	16	●
131-P/M/K	13.1	7.6	13	●	166-P/M/K	16.6	9.3	16	●
132-P/M/K	13.2	7.6	13	●	167-P/M/K	16.7	9.3	16	●
133-P/M/K	13.3	7.6	13	●	168-P/M/K	16.8	9.3	16	●
134-P/M/K	13.4	7.6	13	●	169-P/M/K	16.9	9.3	16	●
135-P/M/K	13.5	7.6	13	●	170-P/M/K	17.0	9.9	17	●
136-P/M/K	13.6	7.6	13	●	171-P/M/K	17.1	9.9	17	●
137-P/M/K	13.7	7.6	13	●	172-P/M/K	17.2	9.9	17	●
138-P/M/K	13.8	7.6	13	●	173-P/M/K	17.3	9.9	17	●
139-P/M/K	13.9	7.6	13	●	174-P/M/K	17.4	9.9	17	●
140-P/M/K	14.0	8.1	14	●	175-P/M/K	17.5	9.9	17	●
141-P/M/K	14.1	8.1	14	●	176-P/M/K	17.6	9.9	17	●
142-P/M/K	14.2	8.1	14	●	177-P/M/K	17.7	9.9	17	●
143-P/M/K	14.3	8.1	14	●	178-P/M/K	17.8	9.9	17	●
144-P/M/K	14.4	8.1	14	●	179-P/M/K	17.9	9.9	17	●
145-P/M/K	14.5	8.1	14	●	180-P/M/K	18.0	10.5	18	●
146-P/M/K	14.6	8.1	14	●	181-P/M/K	18.1	10.5	18	●
147-P/M/K	14.7	8.1	14	●	182-P/M/K	18.2	10.5	18	●
148-P/M/K	14.8	8.1	14	●	183-P/M/K	18.3	10.5	18	●
149-P/M/K	14.9	8.1	14	●	184-P/M/K	18.4	10.5	18	●
150-P/M/K	15.0	8.7	15	●	185-P/M/K	18.5	10.5	18	●
151-P/M/K	15.1	8.7	15	●	186-P/M/K	18.6	10.5	18	●
152-P/M/K	15.2	8.7	15	●	187-P/M/K	18.7	10.5	18	●
153-P/M/K	15.3	8.7	15	●	188-P/M/K	18.8	10.5	18	●
154-P/M/K	15.4	8.7	15	●	189-P/M/K	18.9	10.5	18	●
155-P/M/K	15.5	8.7	15	●	190-P/M/K	19.0	11.0	19	●
156-P/M/K	15.6	8.7	15	●	191-P/M/K	19.1	11.0	19	●
157-P/M/K	15.7	8.7	15	●	192-P/M/K	19.2	11.0	19	●
158-P/M/K	15.8	8.7	15	●	193-P/M/K	19.3	11.0	19	●
159-P/M/K	15.9	8.7	15	●	194-P/M/K	19.4	11.0	19	●
160-P/M/K	16.0	9.3	16	●	195-P/M/K	19.5	11.0	19	●
161-P/M/K	16.1	9.3	16	●	196-P/M/K	19.6	11.0	19	●
162-P/M/K	16.2	9.3	16	●	197-P/M/K	19.7	11.0	19	●
163-P/M/K	16.3	9.3	16	●	198-P/M/K	19.8	11.0	19	●
164-P/M/K	16.4	9.3	16	●	199-P/M/K	19.9	11.0	19	●



• Drill head can be ordered by an application
Order example) Diameter 10.0mm drill head for ISO P application: TCD-100-P TT9080

●: Standard item

P Steel M Stainless steel K Cast iron

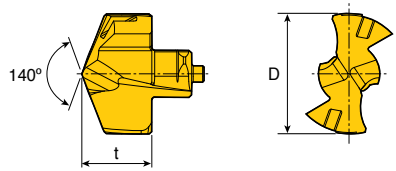
TaeguTec

TCD...P/M/K

DRILL•RUSH

Drill head





Designation	Dimension (mm)			Grade	Designation	Dimension (mm)			Grade
	D	t	Pocket size	TT9080		D	t	Pocket size	TT9080
TCD - 200-P/M/K	20.0	11.6	20	●	TCD - 235-P/M/K	23.5	13.3	23	●
201-P/M/K	20.1	11.6	20	●	236-P/M/K	23.6	13.3	23	●
202-P/M/K	20.2	11.6	20	●	237-P/M/K	23.7	13.3	23	●
203-P/M/K	20.3	11.6	20	●	238-P/M/K	23.8	13.3	23	●
204-P/M/K	20.4	11.6	20	●	239-P/M/K	23.9	13.3	23	●
205-P/M/K	20.5	11.6	20	●	240-P/M/K	24.0	13.9	24	●
206-P/M/K	20.6	11.6	20	●	241-P/M/K	24.1	13.9	24	●
207-P/M/K	20.7	11.6	20	●	242-P/M/K	24.2	13.9	24	●
208-P/M/K	20.8	11.6	20	●	243-P/M/K	24.3	13.9	24	●
209-P/M/K	20.9	11.6	20	●	244-P/M/K	24.4	13.9	24	●
210-P/M/K	21.0	12.1	21	●	245-P/M/K	24.5	13.9	24	●
211-P/M/K	21.1	12.1	21	●	246-P/M/K	24.6	13.9	24	●
212-P/M/K	21.2	12.1	21	●	247-P/M/K	24.7	13.9	24	●
213-P/M/K	21.3	12.1	21	●	248-P/M/K	24.8	13.9	24	●
214-P/M/K	21.4	12.1	21	●	249-P/M/K	24.9	13.9	24	●
215-P/M/K	21.5	12.1	21	●	250-P/M/K	25.0	14.5	25	●
216-P/M/K	21.6	12.1	21	●	251-P/M/K	25.1	14.5	25	●
217-P/M/K	21.7	12.1	21	●	252-P/M/K	25.2	14.5	25	●
218-P/M/K	21.8	12.1	21	●	253-P/M/K	25.3	14.5	25	●
219-P/M/K	21.9	12.1	21	●	254-P/M/K	25.4	14.5	25	●
220-P/M/K	22.0	12.7	22	●	255-P/M/K	25.5	14.5	25	●
221-P/M/K	22.1	12.7	22	●	256-P/M/K	25.6	14.5	25	●
222-P/M/K	22.2	12.7	22	●	257-P/M/K	25.7	14.5	25	●
223-P/M/K	22.3	12.7	22	●	258-P/M/K	25.8	14.5	25	●
224-P/M/K	22.4	12.7	22	●	259-P/M/K	25.9	14.5	25	●
225-P/M/K	22.5	12.7	22	●					
226-P/M/K	22.6	12.7	22	●					
227-P/M/K	22.7	12.7	22	●					
228-P/M/K	22.8	12.7	22	●					
229-P/M/K	22.9	12.7	22	●					
230-P/M/K	23.0	13.3	23	●					
231-P/M/K	23.1	13.3	23	●					
232-P/M/K	23.2	13.3	23	●					
233-P/M/K	23.3	13.3	23	●					
234-P/M/K	23.4	13.3	23	●					



• Drill head can be ordered by an application
Order example) Diameter 10.0mm drill head for ISO P application: TCD-100-P TT9080

●: Standard item

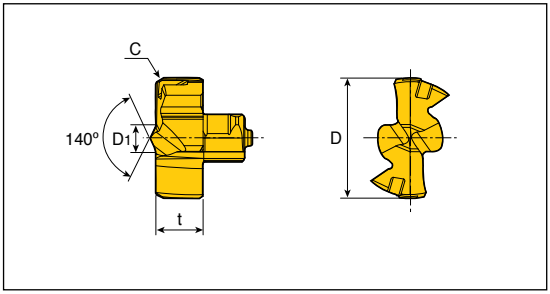
P Steel M Stainless steel K Cast iron

TaeguTec
Member IMC Group

TCD...F

Drill head for flat bottom hole





Designation	Dimension (mm)					Grade	Designation	Dimension (mm)					Grade
	D	D1	t	C	Pocket size	TT9080		D	D1	t	C	Pocket size	TT9080
TCD - 080-F	8.0	1.2	4.0	0.7	8	●	TCD - 254-F	25.4	4.3	10.1	0.7	25	●
085-F	8.5	1.2	4.0	0.7	8	●	255-F	25.5	4.3	10.1	0.7	25	●
090-F	9.0	1.21	4.2	0.7	9	●							
095-F	9.5	1.21	4.2	0.7	9	●							
100-F	10.0	1.27	4.4	0.7	10	●							
105-F	10.5	1.27	4.4	0.7	10	●							
110-F	11.0	1.49	4.5	0.7	11	●							
115-F	11.5	1.49	4.5	0.7	11	●							
120-F	12.0	1.5	4.8	0.7	12	●							
125-F	12.5	1.5	4.8	0.7	12	●							
130-F	13.0	1.64	5.1	0.7	13	●							
135-F	13.5	1.64	5.1	0.7	13	●							
140-F	14.0	1.68	5.5	0.7	14	●							
145-F	14.5	1.68	5.5	0.7	14	●							
150-F	15.0	1.78	5.9	0.7	15	●							
155-F	15.5	1.78	5.9	0.7	15	●							
160-F	16.0	1.89	6.3	0.7	16	●							
165-F	16.5	1.89	6.3	0.7	16	●							
170-F	17.0	1.91	6.6	0.7	17	●							
175-F	17.5	1.91	6.6	0.7	17	●							
180-F	18.0	1.97	6.9	0.7	18	●							
185-F	18.5	1.97	6.9	0.7	18	●							
190-F	19.0	1.96	7.2	0.7	19	●							
195-F	19.5	1.96	7.2	0.7	19	●							
200-F	20.0	3.42	8.2	0.7	20	●							
205-F	20.5	3.42	8.2	0.7	20	●							
210-F	21.0	3.6	8.6	0.7	21	●							
215-F	21.5	3.6	8.6	0.7	21	●							
220-F	22.0	3.8	8.9	0.7	22	●							
225-F	22.5	3.8	8.9	0.7	22	●							
230-F	23.0	3.9	9.3	0.7	23	●							
235-F	23.5	3.9	9.3	0.7	23	●							
240-F	24.0	4.1	9.7	0.7	24	●							
245-F	24.5	4.1	9.7	0.7	24	●							
250-F	25.0	4.3	10.1	0.7	25	●							

●: Standard item

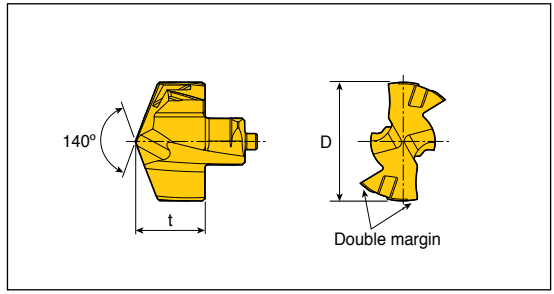


TaeguTec
Member IMC Group

TCD...P2

Double margin drill head





Designation	Dimension (mm)			Grade
	D	t	Pocket size	TT9080
TCD - 080-P2	8.0	5.40	8	●
085-P2	8.5	5.40	8	●
090-P2	9.0	5.80	9	●
095-P2	9.5	5.80	9	●
100-P2	10.0	6.20	10	●
105-P2	10.5	6.20	10	●
110-P2	11.0	6.60	11	●
115-P2	11.5	6.60	11	●
120-P2	12.0	7.00	12	●
125-P2	12.5	7.00	12	●
130-P2	13.0	7.60	13	●
135-P2	13.5	7.60	13	●
140-P2	14.0	8.15	14	●
145-P2	14.5	8.15	14	●
150-P2	15.0	8.73	15	●
155-P2	15.5	8.73	15	●
160-P2	16.0	9.30	16	●
165-P2	16.5	9.30	16	●
170-P2	17.0	9.90	17	●
175-P2	17.5	9.90	17	●
180-P2	18.0	10.50	18	●
185-P2	18.5	10.50	18	●
190-P2	19.0	11.00	19	●
195-P2	19.5	11.00	19	●



• Other diameter is available on request

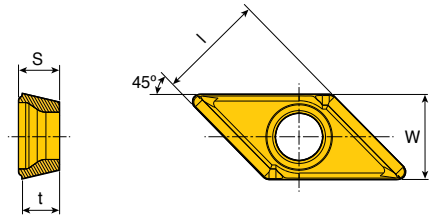
●: Standard item

TaeguTec
Member IMC Group

AOMT 060204-C45

DRILL•RUSH

Chamfering insert for pre-thread hole



Size	Dimension (mm)			
	W	l	S	t
06	4.4	5.66	2.16	1.96

Insert	Designation	Coated						Uncoated			
		TT9080	TT9030	TT8020	TT6030	TT9300	TT7400	K10			
	**AOMT 060204-C45**	●									

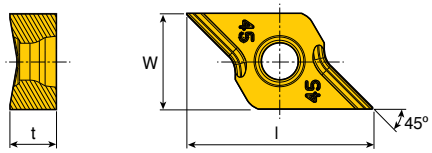
●: Standard item



CRNG 0802-45CD

DRILL•RUSH

Chamfering insert for chamfering ring



Size	Dimension (mm)			
	W	l	t	
08	7.5	14.80	3.65	

Insert	Designation	Coated						Uncoated			
		TT9080	TT9030	TT8020	TT6030	TT9300	TT7400	K10			
	**CRNG 0802-45CD**	●									

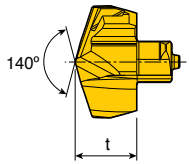
●: Standard item

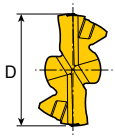


TCD...P-CO

TWIN-RUSH

Drill head for TWINRUSH





Size	Dimension (mm)		Size	Dimension (mm)	
	D	t		D	t
159	15.9	8.7	**209**	20.9	11.6
169	16.9	9.3	**219**	21.9	12.1
179	17.9	9.9	**229**	22.9	12.7
189	18.9	10.5	**239**	23.9	13.3
199	19.9	11.0	**249**	24.9	13.7

Insert	Designation	Pocket size	Coated						Uncoated		
			TT9080	TT9030	TT8020	TT6030	TT9300	TT7400	K10		
	**TCD - 159-P-CO**	15	●								
	169-P-CO	16	●								
	179-P-CO	17	●								
	189-P-CO	18	●								
	199-P-CO	19	●								
	209-P-CO	20	●								
	219-P-CO	21	●								
	229-P-CO	22	●								
	239-P-CO	23	●								
	249-P-CO	24	●								

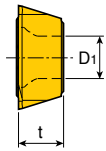
●: Standard item

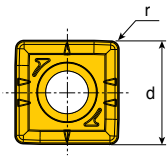


SPGX...DW

TWIN-RUSH

Insert for TWINRUSH





Size	Dimension (mm)			
	d	t	r	D1
06	6.07	2.38	0.4	2.61
07	8.02	3.97	0.8	2.85
09	9.91	4.30	0.8	4.05
11	11.62	4.80	0.8	4.45
14	14.41	5.20	1.2	5.75

Insert	Designation	Coated						Uncoated		
		TT9080	TT8020	TT9300	TT9030	TT6030	TT7400	K10		
	**SPGX 060204 DW**	●								
	07T308 DW	●								
	090408 DW	●								
	110408 DW	●								
	140512 DW	●								

●: Standard item

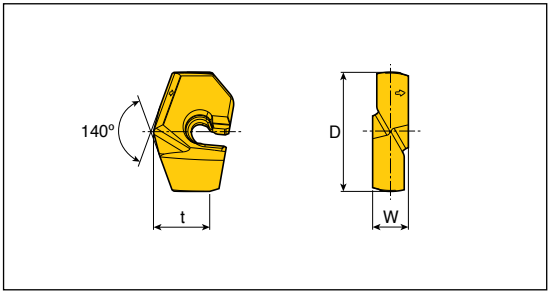


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LCD...-P

Drill head





Designation	Dimension (mm)				Grade
	D	t	W	Pocket size	TT9080
LCD- 260-P	26.0	11.6	8.0	26	●
265-P	26.5	11.6	8.0	26	●
270-P	27.0	11.1	8.0	27	●
275-P	27.5	11.1	8.0	27	●
280-P	28.0	11.7	8.5	28	●
285-P	28.5	11.7	8.5	28	●
290-P	29.0	11.3	8.5	29	●
295-P	29.5	11.3	8.5	29	●
300-P	30.0	14.1	9.0	30	●
305-P	30.5	14.1	9.0	30	●
310-P	31.0	13.7	9.0	31	●
315-P	31.5	13.7	9.0	31	●
320-P	32.0	14.5	9.5	32	●
325-P	32.5	14.5	9.5	32	●
330-P	33.0	14.1	9.5	33	●
335-P	33.5	14.1	9.5	33	●
340-P	34.0	13.7	9.5	34	●
345-P	34.5	13.7	9.5	34	●
350-P	35.0	16.6	10.5	35	●
355-P	35.5	16.6	10.5	35	●
360-P	36.0	16.1	10.5	36	●
365-P	36.5	16.1	10.5	36	●
370-P	37.0	15.7	10.5	37	●
375-P	37.5	15.7	10.5	37	●
380-P	38.0	17.0	11.0	38	●
385-P	38.5	17.0	11.0	38	●
390-P	39.0	16.6	11.0	39	●
395-P	39.5	16.6	11.0	39	●
400-P	40.0	16.2	11.0	40	●
405-P	40.5	16.2	11.0	40	●
410-P	41.0	16.2	11.0	40	●

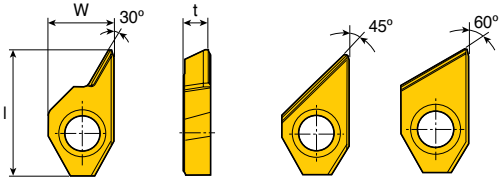
●: Standard item

D62

XCGT ...-C

T-CHAMFER

Chamfering insert for T-CHAMFER holder



-C30 -C45 -C60

Size	Dimension (mm)			
	W	l	t	
06	6.4	12.3	2.8	
09	8.8	16.0	3.3	

Insert	Designation	Coated							Uncoated			
		TT9080	TT9030	TT8020	TT6030	TT9300	TT7400	TT9050		K10		
	**XCGT 0603-C30**							●				
	0903-C30							●				
	**XCGT 0603-C45**							●				
	0903-C45							●				
	**XCGT 0603-C60**							●				
	0903-C60							●				

●: Standard item

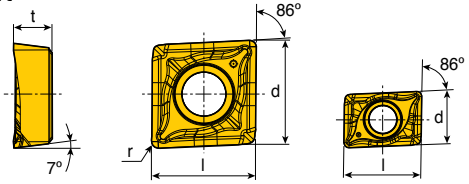
D76

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Member IMC Group

XCGT...TA

TOPCAP

Insert



XCGT 0401

Size	Dimension (mm)			
	d	l	t	r
04	4.4	6.4	1.70	0.4
05	5.6	5.6	2.10	0.4
06	6.4	6.4	2.38	0.4
07	7.5	7.5	3.18	0.4
08	8.4	8.4	3.18	0.4
10	10.5	10.5	3.97	0.4
13	13.4	13.4	4.76	0.4
17	17.5	17.5	5.56	0.8

• For aluminum alloy

Insert	Designation	Turning		Drilling	Coated						Uncoated		
		Feed (mm/rev)	ap (mm)	Feed (mm/rev)	TT9080	TT8020	TT9300	TT9030	TT6030	TT7400	K10		
 Right hand shown (XCGT 0401) 	**XCGT 040104R TA**	0.02-0.15	0.2-1.8	0.02-0.09							●		
	040104L TA	0.02-0.15	0.2-1.8	0.02-0.09							●		
	050204 TA	0.03-0.18	0.2-2.2	0.02-0.11							●		
	060204 TA	0.03-0.20	0.3-2.5	0.03-0.12							●		
	070304 TA	0.05-0.22	0.4-2.8	0.03-0.13							●		
	080304 TA	0.06-0.25	0.4-3.2	0.03-0.13							●		
	10T304 TA	0.06-0.30	0.5-3.5	0.03-0.13							●		
	130404 TA	0.08-0.33	0.6-4.3	0.03-0.13							●		
	170508 TA	0.10-0.38	0.7-5.3	0.03-0.13							●		

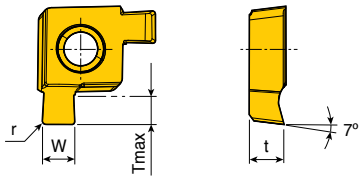


●: Standard item

XCMT..R-GV

TOPCAP

Insert



Size	Dimension (mm)			
	W	Tmax	t	r
05	2.0	1.8	2.28	0.2
06	2.0	2.0	2.65	0.2
07	2.5	2.0	3.41	0.2
08	2.5	2.5	3.50	0.2
10	3.0	3.0	4.34	0.3
13	3.5	3.5	5.18	0.3
17	4.0	4.0	6.00	0.4

• For grooving

Insert	Designation	Coated									Uncoated			
		TT9080	TT8020	TT9300	TT9030	TT6030	TT7400				K10			
	**XCMT 05R-200020GV**	●	●											
	06R-200020GV	●	●											
	07R-250020GV	●	●											
	08R-250020GV	●	●											
	10R-300030GV	●	●											
	13R-350030GV	●	●											
	17R-400040GV	●	●											



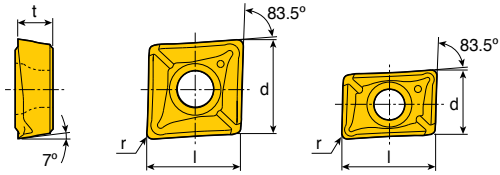
• Grooving insert is available only for right handed type

●: Standard item

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Member IMC Group

XCMT...TC

Insert



XCMT 0401

Size	Dimension (mm)			
	d	l	t	r
04	4.4	6.4	1.70	0.4
05	5.6	5.6	2.10	0.4
06	6.4	6.4	2.38	0.4
07	7.5	7.5	3.18	0.4
08	8.4	8.4	3.18	0.4
10	10.5	10.5	3.97	0.4/0.8
13	13.4	13.4	4.76	0.4/0.8
17	17.4	17.4	5.56	0.8

• For drilling, boring and turning

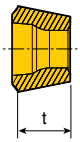
Insert	Designation	Turning		Drilling	Coated						Uncoated
		Feed (mm/rev)	ap (mm)	Feed (mm/rev)	TT9080	TT8020	TT9300	TT9030	TT6030	TT7400	K10
 Right hand shown (XCMT 0401) 	**XCMT 040104R TC**	0.02-0.15	0.2-1.8	0.02-0.09	●	●		●			
	040104L TC	0.02-0.15	0.2-1.8	0.02-0.09	●	●		●			
	050204 TC	0.03-0.18	0.2-2.2	0.02-0.11	●	●		●			
	060204 TC	0.03-0.20	0.3-2.5	0.03-0.12	●	●		●			
	070304 TC	0.05-0.22	0.4-2.8	0.03-0.13	●	●		●			
	080304 TC	0.06-0.25	0.4-3.2	0.03-0.13	●	●		●			
	10T304 TC	0.06-0.30	0.5-3.5	0.03-0.13	●	●		●			
	10T308 TC	0.06-0.30	0.5-3.5	0.03-0.13	●	●		●			
	130404 TC	0.08-0.33	0.6-4.3	0.03-0.13	●	●		●			
	130408 TC	0.08-0.33	0.6-4.3	0.03-0.13	●	●		●			
	170508 TC	0.10-0.38	0.7-5.3	0.03-0.13	●	●		●			

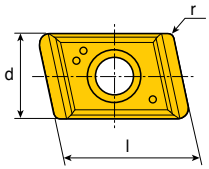
●: Standard item

NPHT...RG

T-DEEP

Insert for TBTA-FB





Size	Dimension (mm)			
	d	t	r	l
06	6.0	3.0	0.8	8.0
07	7.5	4.0	0.8	10.0
09	9.0	4.0	0.8	10.0
11	11.0	4.0	0.8	10.0
13	13.0	4.0	0.8	10.0

Insert	Designation	Pocket			Coated							Uncoated	
		Center	Inner	Outer	TT9030	TT8125	TT7100	TT3500	TT6020	TT9300	TT7400	K10	
	**NPHT 06003RG**			●	●				●				
	07504RG			●	●				●				
	09004RG			●	●				●				
	11004RG			●	●				●				
	13004RG			●	●				●				

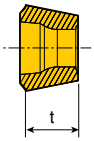


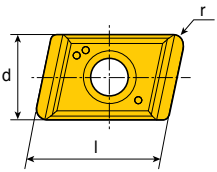
●: Standard item

NPMT...LG

T-DEEP

Insert for TBTA-FB





Size	Dimension (mm)			
	d	t	r	l
05	5.5	3.0	0.8	8
06	6.5	4.0	0.8	10
08	8.0	4.0	0.8	10
09	9.5	4.0	0.8	10
12	12.5	4.0	0.8	10

Insert	Designation	Pocket			Coated							Uncoated	
		Center	Inner	Outer	TT9030	TT8125	TT7100	TT3500	TT6020	TT9300	TT7400	K10	
	**NPMT 05503LG**	●			●	●			●				
	06504LG	●			●	●			●				
	08004LG	●			●	●			●				
	09504LG	●			●	●			●				
	12504LG	●			●	●			●				





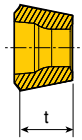
●: Standard item

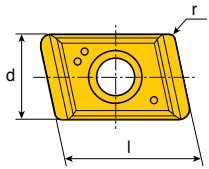
TaeguTec
Member IMC Group

NPMT...RG

T-DEEP

Insert for TBTA-FB





Size	Dimension (mm)			
	d	t	r	l
05	5.5	3.0	0.8	8
06	6.5	4.0	0.8	10
08	8.0	4.0	0.8	10
09	9.5	4.0	0.8	10
12	12.5	4.0	0.8	10

Insert	Designation	Pocket			Coated							Uncoated	
		Center	Inner	Outer	TT9030	TT8125	TT7100	TT3500	TT6020	TT9300	TT7400	K10	
	**NPMT 05503RG**		●		●	●			●				
	06504RG		●		●	●			●				
	08004RG		●		●	●			●				
	09504RG		●		●	●			●				
	12504RG		●		●	●			●				



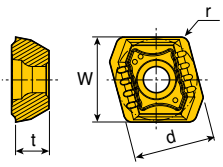


●: Standard item

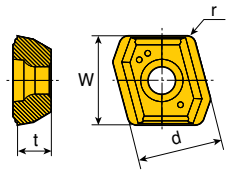
NPMX...RB/RG

T-DEEP

Insert for TBTA...3/5/7/9



RB



RG

Size	Dimension (mm)			
	d	t	r	l
08	8.0	3.18	0.8	8.36

Insert	Designation	Pocket			Coated							Uncoated	
		Center	Inner	Outer	TT9030	TT8125	TT7100	TT3500	TT6020	TT9300	TT7400	K10	
	**NPMX 0803RB**	●	●	●	●								
	0803RG	●	●	●	●						●		



●: Standard item

TaeguTec

TOGT…RS

T-DEEP

Insert for TBTA-TR & TRGD

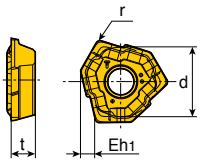


Fig.1

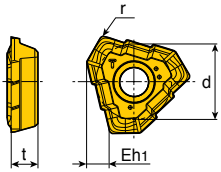


Fig.2

Size	Dimension (mm)			
	d	t	r	Eh1
08	8.32	2.8	0.5	2.2
09	8.55	3.0	0.5	3.0
10	9.23	3.3	0.5	3.2
11	10.40	3.8	0.5	3.4
12	11.59	4.3	0.5	3.6

Insert	Designation	Fig.	Coated							Uncoated		
			TT9030	TT8125	TT7100	TT3500	TT6020	TT9300	TT7400	K10		
	**TOGT 080305 RS**	1	●									
	090305 RS	2	●									
	100305 RS	2	●									
	110405 RS	2	●									
	120405 RS	2	●									



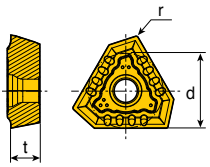


●: Standard item

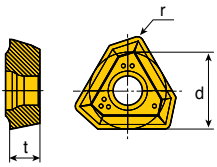
TPMX...RB/RG

T-DEEP

Insert for TBTA...3/5/7/9



RB



RG

Size	Dimension (mm)			
	d	t	r	
1403RB	8.45	3.5	0.4	
1403RG	8.45	3.5	0.8	
1704RB	10.30	4.0	0.4	
1704RG	10.30	4.0	0.8	
2405RB	14.20	5.5	0.4	
2405RG	14.20	5.5	1.2	
2807RB	17.00	7.5	0.8	
2807RG	17.00	7.5	1.6	

Insert	Designation	Pocket			Coated							Uncoated		
		Center	Inner	Outer	TT9030	TT8125	TT7100	TT3500	TT6020	TT9300	TT7400	K10		
	**TPMX 1403RB**	●	●	●	●	●								
	1403RG	●	●	●	●	●								
	1704RB	●	●	●	●									
	1704RG	●	●	●	●		●	●		●				
	2405RB	●	●	●	●									
	2405RG	●	●	●	●					●				
	2807RB	●	●	●	●									
	2807RG	●	●	●	●					●				



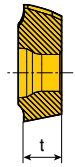
●: Standard item

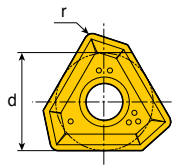
TaeguTec

TPMX...LG

T-DEEP

Insert for TBTA-R





Size	Dimension (mm)			
	d	t	r	
14	8.45	3.5	0.8	
17	10.30	4.0	0.8	
24	14.20	5.5	1.2	

Insert	Designation	Pocket			Coated							Uncoated	
		Center	Inner	Outer	TT9030	TT8125	TT7100	TT3500	TT6020	TT9300	TT7400	K10	
	**TPMX 1403LG**			●	●								
	1704LG			●	●								
	2405LG			●	●								

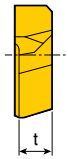


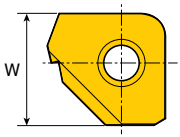
●: Standard item

XPMT...-45

T-DEEP

Insert for TBTA-R





Size	Dimension (mm)			
	t	W		
16	2.70	9.5		

Insert	Designation	Pocket			Coated							Uncoated	
		Center	Inner	Outer	TT9030	TT8125	TT7100	TT3500	TT6020	TT9300	TT7400	K10	
	**XPMT 16002-45**			●	●								

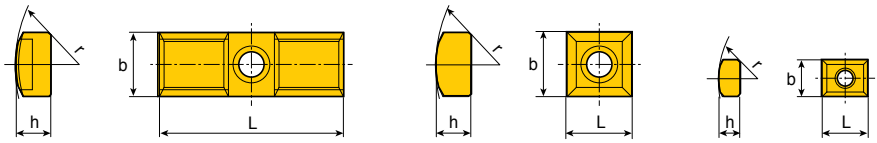


●: Standard item

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Pad for TBTA 3.../5.../7.../9...

T-DEEP



Guide pad | **Guide pad protector** | **Sub guide pad**

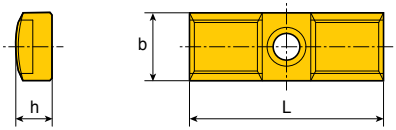
Designation			Dimension (mm)				Screw
			b	h	L	r	
Guide pad	PAD-	GO08CD-SA-FB	8	4.5	25	15.5	CSTB3S
		GO08CD-SB-FB	8	4.5	25	15.5	CSTB3S
		GC10-SA	10	6.0	35	20.0	CSTB4S
		GC10-SB	10	6.0	35	20.0	CSTB4S
		GC14-SB	14	7.5	40	25.0	CSTA5S
		GC18-SB	18	9.0	40	30.0	LS1206S
Guide pad protector	PAD-	P08	8	4.5	8	17.5	CSTB3S
		P10	10	6.0	10	20.0	CSTB4S
		P14	14	7.5	14	25.0	CSTA5S
		P18	18	9.0	18	30.0	LS1206S
Sub guide pad	PAD-	S08	8	4.5	10	17.5	CSTB3S
		S10	10	5.0	10	29.0	CSTB3S
		S14	14	7.0	20	45.0	CCSTA5S



+ Guide Pad for TBTA 3.../5.../7.../9...

T-DEEP





• +Guide pad for diameter enlargement

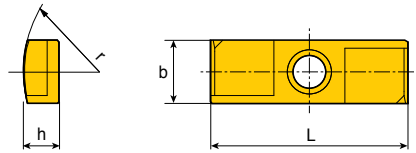
Designation										
D	D+1mm	h	D+2mm	h	D+3mm	h	D+4mm	h	D+5mm	h
PAD-GC08	**PAD-GC08+1**	5.0	**PAD-GC08+2**	5.5	**PAD-GC08+3**	6.0	**-**	-	**-**	-
PAD-GC10	**PAD-GC10+1**	6.5	**PAD-GC10+2**	7.0	**PAD-GC10+3**	7.5	**PAD-GC10+4**	8.0	**-**	-
PAD-GC14	**PAD-GC14+1**	8.0	**PAD-GC14+2**	8.5	**PAD-GC14+3**	9.0	**PAD-GC14+4**	9.5	**PAD-GC14+5**	10.0
PAD-GC18	**PAD-GC18+1**	9.5	**PAD-GC18+2**	10	**PAD-GC18+3**	10.5	**PAD-GC18+4**	11.0	**PAD-GC18+5**	11.5



Pad for TBTA-FB & HFD

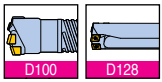
T-DEEP





Guide pad

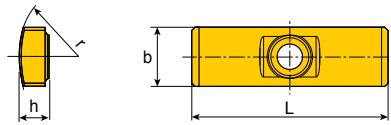
Designation			Dimension (mm)				Screw
			b	h	L	r	
Guide pad	PAD -	**G006CD-SA**	6	3.0	20	12.0	CSTB2.2S
		G006CD-SB	6	3.0	20	12.0	CSTB2.2S
		G007CD-SA	7	3.5	20	12.0	CSTB3.0S
		G007CD-SB	7	3.5	20	12.0	CSTB3.0S
		G008CD-SA-FB	8	4.5	25	15.5	CSTB3.5S
		G008CD-SB-FB	8	4.5	25	15.5	CSTB3.5S
		G010CD-SA	10	4.5	30	20.0	CSTB3.5S
		G010CD-SB	10	4.5	30	20.0	CSTB3.5S
		G012CD-SA	12	5.5	35	25.0	CSTB3.5S
		G012CD-SA	12	5.5	35	25.0	CSTB3.5S



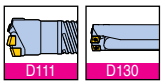
Pad for TBTA-TR & TRGD

T-DEEP

Deep drilling head solid carbide guide pads



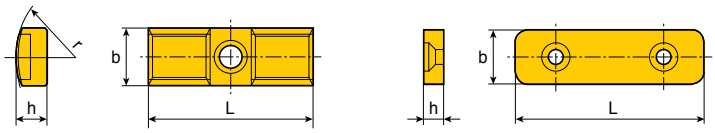
Designation			Dimension (mm)				Screw
			b	h	L	r	
Guide pad	PAD -	**G006CD-SA**	6	3	20	12.0	CSTB2.2S
		G006CD-SB	6	3	20	12.0	CSTB2.2S
		G006-075CD-SA	6	3	20	7.5	CSTB2.2S
		G006-075CD-SB	6	3	20	7.5	CSTB2.2S
		G006-085CD-SA	6	3	20	8.5	CSTB2.2S
		G006-085CD-SB	6	3	20	8.5	CSTB2.2S
		G006-100CD-SA	6	3	20	10.0	CSTB2.2S
		G006-100CD-SB	6	3	20	10.0	CSTB2.2S



- Guide pad with "SB" is the first choice in general purpose machining. "SA" is a supplementary grade used only with oil based coolant.

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Pad for TBTA-R



Guide pad **Resin guide pad**

Designation		Dimension (mm)				Screw
		b	h	L	r	
Guide pad	PAD- **GC08-120**	8	4.4	25	17.5	CSTB3S
	GC08-140	8	3.5	25	17.5	CSTB3S
	GO08CD-SA-FB	8	4.5	25	15.5	CSTB3S
	GO08CD-SB-FB	8	4.5	25	15.5	CSTB3S
	GC10-SA	10	6.0	35	20.0	CSTB4S
	GC10-SB	10	6.0	35	20.0	CSTB4S
	GC14-SB	14	7.5	40	25.0	CSTA5S
	GC18-SB	18	9.0	40	30.0	LS1206S
Resin guide pad	PAD- **R10**	10	4.0	40	-	LS0902.5-6
	R12	12	5.0	45	-	LS0903-8
	R15	15	5.8	50	-	LS0904-10
	R20	20	7.5	70	-	LS0905-12
	R30	30	12.5	80	-	LS0906-15
	R35	35	15.5	100	-	LS0906-15

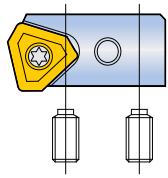
D105

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Cartridge for TBTA 3.../5.../7.../9

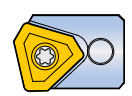
T-DEEP





Outer





Inner & center

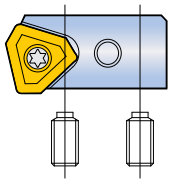
Designation		Adjust screw	Wrench	Lock screw	Wrench	Insert
Outer	**PERC 05R**	AS0003-5	H1.5	LS1803RH	H2	NPMX0803..
	402-04	AS0004-8	H2	LS1803.5RH	H2.5	TPMX1403..
	402-32	AS0005-10	H2.5	LS1805RH	H3	TPMX1704..
	402-43	AS0005-15	H2.5	L1806RH	H4	TPMX2405..
	402-63	AS0006-15	H3	L1806RH	H4	TPMX2807..
Inner & center	**CENC 05R**	-	-	CSTB3	T9	NPMX0803..
	402-04	-	-	CSTB3.5	T15	TPMX1403..
	402-32	-	-	CSTA5	T15	TPMX1704..
	402-43	-	-	LS1206	H3	TPMX2405..
	402-63	-	-	LS1206	H3	TPMX2807..



+ Cartridge for TBTA 3.../5.../7.../9

T-DEEP





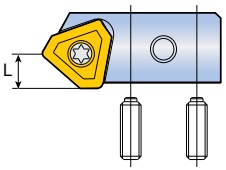
• +Cartridge for diameter enlargement

Designation					
D	D+1mm	D+2mm	D+3mm	D+4mm	D+5mm
PERC 05R	**PERC 05R+1**	**PERC 05R+2**	**-**	**-**	**-**
PERC 402-04	**PERC 402-04+1**	**PERC 402-04+2**	**PERC 402-04+3**	**-**	**-**
PERC 402-32	**PERC 402-32+1**	**PERC 402-32+2**	**PERC 402-32+3**	**PERC 402-32+4**	**-**
PERC 402-43	**PERC 402-43+1**	**PERC 402-43+2**	**PERC 402-43+3**	**PERC 402-43+4**	**PERC 402-43+5**
PERC 402-63	**PERC 402-63+1**	**PERC 402-63+2**	**PERC 402-63+3**	**PERC 402-63+4**	**PERC 402-63+5**

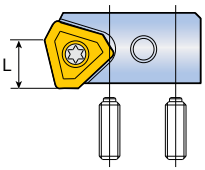


TaeguTec

Cartridge for TBTA-R



Accurate tolerance applications



Open tolerance applications

Designation			L (mm)	Adjust screw	Wrench	Lock screw	Wrench	Insert
Accurate tolerance applications	**PERC**	**P04R**	5	AS0004-8	H2	LS1803.5RH	H2.5	TPMX1403 LG
		P32R	6	AS0005-10	H2.5	LS1805RH	H3	TPMX1704 LG
		P43R	8	AS0005-15	H2.5	LS1806RH	H4	TPMX2405 LG
Open tolerance applications	**PERC**	**402-04**	8	AS0004-8	H2	LS1803.5RH	H2.5	TPMX1403 RG
		402-32	9	AS0005-10	H2.5	LS1805RH	H3	TPMX1704 RG
		402-43	13	AS0005-15	H2.5	LS1806RH	H4	TPMX2405 RG



• PERC-P and PERC 402-□□ cartridges are interchangable in the same pocket

Recommended Cutting Conditions

TOPDRILL

Machining data for TOPDRILL 2,3,4xD

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	220-350
		>=0.25%C	Annealed	650	190	2	180-280
		<0.55%C	Quenched and tempered	850	250	3	140-240
		>=0.55%C	Annealed	750	220	4	140-240
			Quenched and tempered	1000	300	5	140-240
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	140-240
			Quenched and tempered	930	275	7	100-180
				1000	300	8	100-180
				1200	350	9	100-180
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	140-200
			Quenched and tempered	1100	325	11	100-160
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	150-250
			Martensitic	820	240	13	150-250
			Austenitic	600	180	14	150-250
K	Gray cast iron (GG)		Ferritic		160	15	160-260
			Pearlitic		250	16	160-260
	Cast iron nodular (GGG)		Ferritic		180	17	160-260
			Pearlitic		260	18	160-260
	Malleable cast iron		Ferritic		130	19	120-220
			Pearlitic		230	20	120-220
N	Aluminum - Wrought alloy		Not cureable		60	21	200-350
			Cured		100	22	200-350
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	200-350
			Cured		90	24	200-350
		>12% Si	High temp.		130	25	200-350
	Copper alloys	>1% Pb	Free cutting		110	26	150-250
			Brass		90	27	150-250
			Electrolitic copper		100	28	150-250
	Non-metallic		Duroplastics, fiber plastics			29	150-250
			Hard rubber			30	150-250
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	30-60
		Ni or Co based	Annealed		250	33	30-60
			Cured		350	34	30-60
			Cast		320	35	30-60
	Titanium,Ti alloys			Rm 400		36	50-80
			Alpha+beta alloys cured	Rm 1050		37	50-80
H	Hardened steel		Hardened		55HRC	38	30-60
			Hardened		60HRC	39	30-60
	Chilled cast iron		Cast		400	40	30-60
	Cast iron nodular		Hardened		55HRC	41	30-60

• For more information of material groups, see the materials & grades "material conversion table"

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

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Member IMC Group

Recommended Cutting Conditions

TOPDRILL

Machining data for TOPDRILL 2,3,4xD

Feed (mm/rev) vs. drill diameter Drill length 2,3,4xD							
SOMT 05 Ø14 - Ø16	SOMT 06 Ø17 - Ø19	SOMT 07 Ø20 - Ø22	SOMT 08 Ø23 - Ø26	SOMT 09 Ø27 - Ø31	SOMT 11 Ø32 - Ø36	SOMT 13 Ø37 - Ø43	SOMT 15 Ø44 - Ø50
0.04-0.06	0.04-0.06	0.04-0.08	0.04-0.08	0.06-0.10	0.06-0.10	0.08-0.12	0.08-0.12
0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.08-0.14	0.08-0.14	0.08-0.16	0.10-0.16
0.08-0.12	0.08-0.12	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.18	0.10-0.18
0.08-0.12	0.08-0.12	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.18	0.10-0.18
0.08-0.12	0.08-0.12	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.18	0.10-0.18
0.06-0.16	0.06-0.16	0.08-0.20	0.08-0.20	0.08-0.20	0.10-0.22	0.10-0.22	0.10-0.24
0.06-0.16	0.06-0.16	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.22	0.10-0.22	0.10-0.22
0.06-0.16	0.06-0.16	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.22	0.10-0.22	0.10-0.22
0.06-0.16	0.06-0.16	0.08-0.20	0.08-0.20	0.08-0.20	0.08-0.22	0.10-0.22	0.10-0.22
0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.20	0.10-0.20	0.10-0.20
0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.20	0.10-0.20	0.10-0.20
0.06-0.12	0.06-0.12	0.06-0.16	0.06-0.16	0.08-0.18	0.08-0.20	0.10-0.20	0.10-0.20
0.06-0.12	0.06-0.12	0.06-0.16	0.06-0.16	0.08-0.18	0.08-0.20	0.10-0.20	0.10-0.20
0.06-0.12	0.06-0.12	0.06-0.16	0.06-0.16	0.08-0.18	0.08-0.20	0.10-0.20	0.10-0.20
0.08-0.18	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.22	0.10-0.22
0.08-0.18	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.22	0.10-0.22
0.08-0.18	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.22	0.10-0.22
0.08-0.18	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.20	0.10-0.22	0.10-0.22
0.08-0.14	0.08-0.14	0.10-0.16	0.10-0.16	0.10-0.16	0.10-0.18	0.10-0.18	0.10-0.18
0.08-0.14	0.08-0.14	0.10-0.16	0.10-0.16	0.10-0.16	0.10-0.18	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.18	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.18	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.18	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.18	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.18	0.08-0.18	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.17	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.17	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.17	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.10-0.17	0.10-0.17	0.10-0.18	0.10-0.18
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.10-0.17	0.10-0.17	0.10-0.18	0.10-0.18
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12
0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10

Recommended Cutting Conditions

TOPDRILL

Machining data for TOPDRILL 5xD

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	220-350
		>=0.25%C	Annealed	650	190	2	180-280
		<0.55%C	Quenched and tempered	850	250	3	140-240
		>=0.55%C	Annealed	750	220	4	140-240
			Quenched and tempered	1000	300	5	140-240
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	140-240
			Quenched and tempered	930	275	7	100-180
				1000	300	8	100-180
				1200	350	9	100-180
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	140-200
			Quenched and tempered	1100	325	11	100-160
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	150-250
			Martensitic	820	240	13	150-250
			Austenitic	600	180	14	150-250
K	Gray cast iron (GG)		Ferritic		160	15	160-260
			Pearlitic		250	16	160-260
	Cast iron nodular (GGG)		Ferritic		180	17	160-260
			Pearlitic		260	18	160-260
	Malleable cast iron		Ferritic		130	19	120-220
			Pearlitic		230	20	120-220
N	Aluminum - Wrought alloy		Not cureable		60	21	200-350
			Cured		100	22	200-350
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	200-350
			Cured		90	24	200-350
		>12% Si	High temp.		130	25	200-350
	Copper alloys	>1% Pb	Free cutting		110	26	150-250
			Brass		90	27	150-250
			Electrolitic copper		100	28	150-250
	Non-metallic		Duroplastics, fiber plastics			29	150-250
			Hard rubber			30	150-250
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	30-60
		Ni or Co based	Annealed		250	33	30-60
			Cured		350	34	30-60
			Cast		320	35	30-60
	Titanium, Ti alloys			Rm 400		36	50-80
			Alpha+beta alloys cured	Rm 1050		37	50-80
H	Hardened steel		Hardened		55HRC	38	30-60
			Hardened		60HRC	39	30-60
	Chilled cast iron		Cast		400	40	30-60
	Cast iron nodular		Hardened		55HRC	41	30-60

• For more information of material groups, see the materials & grades "material conversion table"

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

TaeguTec
Member IMC Group

Recommended Cutting Conditions

TOPDRILL

Machining data for TOPDRILL 5xD

Feed (mm/rev) vs. drill diameter Drill length 5xD							
SOMT 05 Ø14 - Ø16	SOMT 06 Ø17 - Ø19	SOMT 07 Ø20 - Ø22	SOMT 08 Ø23 - Ø26	SOMT 09 Ø27 - Ø31	SOMT 09 Ø27 - Ø31	SOMT 13 Ø37 - Ø43	SOMT 15 Ø44 - Ø50
0.04-0.05	0.04-0.05	0.04-0.05	0.04-0.06	0.06-0.08	0.06-0.08	0.08-0.10	0.08-0.10
0.06-0.08	0.06-0.08	0.06-0.10	0.06-0.10	0.08-0.12	0.08-0.12	0.08-0.14	0.10-0.14
0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.10-0.15	0.10-0.15	0.10-0.17	0.10-0.17
0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.10-0.15	0.10-0.15	0.10-0.17	0.10-0.17
0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.10-0.15	0.10-0.15	0.10-0.17	0.10-0.17
0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.16	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.22
0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.16	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.22
0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.16	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.22
0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.16	0.08-0.18	0.10-0.20	0.10-0.20	0.10-0.22
0.06-0.10	0.06-0.10	0.08-0.12	0.08-0.12	0.08-0.16	0.08-0.18	0.10-0.18	0.10-0.20
0.06-0.10	0.06-0.10	0.08-0.12	0.08-0.12	0.08-0.16	0.08-0.18	0.10-0.18	0.10-0.20
0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.18	0.10-0.18	0.10-0.20
0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.18	0.10-0.18	0.10-0.20
0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.12	0.08-0.16	0.08-0.18	0.10-0.18	0.10-0.20
0.08-0.14	0.08-0.14	0.08-0.16	0.08-0.16	0.10-0.18	0.10-0.18	0.10-0.20	0.10-0.20
0.08-0.14	0.08-0.14	0.08-0.16	0.08-0.16	0.10-0.18	0.10-0.18	0.10-0.20	0.10-0.20
0.08-0.14	0.08-0.14	0.08-0.16	0.08-0.16	0.10-0.18	0.10-0.18	0.10-0.20	0.10-0.20
0.08-0.14	0.08-0.14	0.08-0.16	0.08-0.16	0.10-0.18	0.10-0.18	0.10-0.20	0.10-0.20
0.08-0.12	0.08-0.14	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.16	0.10-0.16
0.08-0.12	0.08-0.14	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.16	0.10-0.16
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.16	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.15	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.15	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.08-0.15	0.08-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.17	0.10-0.17
0.06-0.15	0.06-0.15	0.08-0.16	0.08-0.16	0.10-0.16	0.10-0.16	0.10-0.17	0.10-0.17
0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10
0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10
0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10
0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10
0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10
0.05-0.08	0.05-0.08	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.05-0.08	0.05-0.08	0.06-0.09	0.06-0.09	0.06-0.10	0.06-0.10	0.06-0.10	0.06-0.10
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10

Recommended Cutting Conditions

Machining data for T-DRILL 2,3,4xD

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	250-350
		>=0.25%C	Annealed	650	190	2	180-250
		<0.55%C	Quenched and tempered	850	250	3	160-220
		>=0.55%C	Annealed	750	220	4	160-220
			Quenched and tempered	1000	300	5	160-220
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	150-220
			Quenched and tempered	930	275	7	120-160
				1000	300	8	120-160
				1200	350	9	120-160
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	140-180
			Quenched and tempered	1100	325	11	130-180
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	170-240
			Martensitic	820	240	13	170-240
			Austenitic	600	180	14	170-240
K	Gray cast iron (GG)		Ferritic		160	15	180-250
			Pearlitic		250	16	180-250
	Cast iron nodular (GGG)		Ferritic		180	17	180-250
			Pearlitic		260	18	180-250
	Malleable cast iron		Ferritic		130	19	130-200
			Pearlitic		230	20	130-200
N	Aluminum - Wrought alloy		Not cureable		60	21	330-380
			Cured		100	22	330-380
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	330-380
			Cured		90	24	330-380
		>12% Si	High temp.		130	25	330-380
	Copper alloys	>1% Pb	Free cutting		110	26	150-230
			Brass		90	27	150-230
			Electrolitic copper		100	28	150-230
	Non-metallic		Duroplastics, fiber plastics			29	150-230
			Hard rubber			30	150-230
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	30-60
		Ni or Co based	Annealed		250	33	30-60
			Cured		350	34	30-60
			Cast		320	35	30-60
	Titanium, Ti alloys			Rm 400		36	30-60
			Alpha+beta alloys cured	Rm 1050		37	30-60
H	Hardened steel		Hardened		55HRC	38	30-60
			Hardened		60HRC	39	30-60
	Chilled cast iron		Cast		400	40	30-60
	Cast iron nodular		Hardened		55HRC	41	30-60

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

Machining data for T-DRILL 2,3,4xD

Feed (mm/rev) vs. drill diameter Drill length 2,3,4xD					
SPMG 05 Ø13 - Ø15	SPMG 06 Ø16 - Ø21	SPMG 07 Ø22 - Ø27	SPMG 09 Ø28 - Ø33	SPMG 11 Ø34 - Ø41	SPMG 14 Ø42 - Ø50
0.04-0.06	0.04-0.06	0.04-0.08	0.04-0.08	0.06-0.10	0.06-0.12
0.05-0.08	0.06-0.10	0.06-0.12	0.07-0.13	0.08-0.15	0.08-0.16
0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.22	0.12-0.24	0.13-0.25
0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.22	0.12-0.24	0.13-0.25
0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.22	0.12-0.24	0.13-0.25
0.06-0.12	0.08-0.14	0.10-0.18	0.12-0.20	0.12-0.20	0.13-0.20
0.06-0.15	0.06-0.15	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.06-0.15	0.06-0.15	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.06-0.15	0.06-0.15	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.06-0.10	0.06-0.10	0.08-0.12	0.08-0.14	0.08-0.14	0.08-0.14
0.06-0.10	0.08-0.12	0.10-0.15	0.12-0.15	0.12-0.18	0.13-0.18
0.05-0.10	0.06-0.12	0.08-0.15	0.09-0.16	0.10-0.17	0.11-0.18
0.05-0.10	0.06-0.12	0.08-0.15	0.09-0.16	0.10-0.17	0.11-0.18
0.05-0.10	0.06-0.12	0.08-0.15	0.09-0.16	0.10-0.17	0.11-0.18
0.06-0.12	0.08-0.16	0.12-0.20	0.15-0.25	0.16-0.28	0.18-0.30
0.06-0.12	0.08-0.16	0.12-0.20	0.15-0.25	0.16-0.28	0.18-0.30
0.06-0.12	0.08-0.16	0.12-0.20	0.15-0.25	0.16-0.28	0.18-0.30
0.06-0.12	0.08-0.16	0.12-0.20	0.15-0.25	0.16-0.28	0.18-0.30
0.06-0.10	0.08-0.15	0.10-0.18	0.12-0.20	0.15-0.23	0.16-0.25
0.06-0.10	0.08-0.15	0.10-0.18	0.12-0.20	0.15-0.23	0.16-0.25
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.10	0.06-0.14	0.08-0.18	0.10-0.22	0.14-0.23	0.15-0.24
0.05-0.10	0.06-0.14	0.08-0.18	0.10-0.22	0.14-0.23	0.15-0.24
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10

Recommended Cutting Conditions

Machining data for T-DRILL 5xD

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	250-350
		>=0.25%C	Annealed	650	190	2	180-250
		<0.55%C	Quenched and tempered	850	250	3	160-220
		>=0.55%C	Annealed	750	220	4	160-220
			Quenched and tempered	1000	300	5	160-220
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	150-220
			Quenched and tempered	930	275	7	120-160
				1000	300	8	120-160
				1200	350	9	120-160
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	140-180
			Quenched and tempered	1100	325	11	130-180
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	170-240
			Martensitic	820	240	13	170-240
			Austenitic	600	180	14	170-240
K	Gray cast iron (GG)		Ferritic		160	15	180-250
			Pearlitic		250	16	180-250
	Cast iron nodular (GGG)		Ferritic		180	17	180-250
			Pearlitic		260	18	180-250
	Malleable cast iron		Ferritic		130	19	130-200
			Pearlitic		230	20	130-200
N	Aluminum - Wrought alloy		Not cureable		60	21	330-380
			Cured		100	22	330-380
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	330-380
			Cured		90	24	330-380
		>12% Si	High temp.		130	25	330-380
	Copper alloys	>1% Pb	Free cutting		110	26	150-230
			Brass		90	27	150-230
			Electrolitic copper		100	28	150-230
	Non-metallic		Duroplastics, fiber plastics			29	150-230
			Hard rubber			30	150-230
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	30-60
		Ni or Co based	Annealed		250	33	30-60
			Cured		350	34	30-60
			Cast		320	35	30-60
	Titanium, Ti alloys			Rm 400		36	30-60
			Alpha+beta alloys cured	Rm 1050		37	30-60
H	Hardened steel		Hardened		55HRC	38	30-60
			Hardened		60HRC	39	30-60
	Chilled cast iron		Cast		400	40	30-60
	Cast iron nodular		Hardened		55HRC	41	30-60

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

Machining data for T-DRILL 5xD

Feed (mm/rev) vs. drill diameter Drill length 5xD					
SPMG 05 Ø1 3 - Ø15	SPMG 06 Ø16 - Ø21	SPMG 07 Ø22 - Ø27	SPMG 09 Ø28 - Ø33	SPMG 11 Ø34 - Ø41	SPMG 14 Ø42 - Ø50
0.04-0.05	0.04-0.05	0.04-0.06	0.04-0.07	0.06-0.08	0.06-0.10
0.06-0.08	0.06-0.08	0.06-0.10	0.07-0.12	0.08-0.13	0.08-0.14
0.06-0.10	0.08-0.13	0.10-0.16	0.12-0.20	0.12-0.22	0.13-0.23
0.06-0.10	0.08-0.13	0.10-0.16	0.12-0.20	0.12-0.22	0.13-0.23
0.06-0.10	0.08-0.13	0.10-0.16	0.12-0.20	0.12-0.22	0.13-0.23
0.06-0.10	0.08-0.12	0.10-0.16	0.12-0.18	0.12-0.18	0.13-0.18
0.06-0.12	0.06-0.13	0.08-0.16	0.08-0.16	0.08-0.17	0.08-0.17
0.06-0.12	0.06-0.13	0.08-0.16	0.08-0.16	0.08-0.17	0.08-0.17
0.06-0.12	0.06-0.13	0.08-0.16	0.08-0.16	0.08-0.17	0.08-0.17
0.06-0.08	0.06-0.08	0.08-0.10	0.08-0.12	0.08-0.12	0.08-0.12
0.06-0.09	0.08-0.10	0.10-0.13	0.12-0.13	0.12-0.15	0.12-0.16
0.05-0.09	0.06-0.10	0.08-0.13	0.09-0.15	0.10-0.15	0.10-0.17
0.05-0.09	0.06-0.10	0.08-0.13	0.09-0.15	0.10-0.15	0.10-0.17
0.05-0.09	0.06-0.10	0.08-0.13	0.09-0.15	0.10-0.15	0.10-0.17
0.06-0.10	0.08-0.15	0.12-0.18	0.15-0.22	0.16-0.25	0.18-0.28
0.06-0.10	0.08-0.15	0.12-0.18	0.15-0.22	0.16-0.25	0.18-0.28
0.06-0.10	0.08-0.15	0.12-0.18	0.15-0.22	0.16-0.25	0.18-0.28
0.06-0.10	0.08-0.15	0.12-0.18	0.15-0.22	0.16-0.25	0.18-0.28
0.06-0.08	0.08-0.12	0.10-0.16	0.12-0.18	0.15-0.22	0.16-0.23
0.06-0.08	0.08-0.12	0.10-0.16	0.12-0.18	0.15-0.22	0.16-0.23
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.09	0.08-0.13	0.08-0.17	0.10-0.20	0.14-0.22	0.14-0.24
0.05-0.09	0.08-0.13	0.08-0.17	0.10-0.20	0.14-0.22	0.14-0.24
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09

Recommended Cutting Conditions

DRILL•RUSH

Machining data for DRILLRUSH

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	80-140
		>=0.25%C	Annealed	650	190	2	80-130
		<0.55%C	Quenched and tempered	850	250	3	80-120
		>=0.55%C	Annealed	750	220	4	70-110
			Quenched and tempered	1000	300	5	50-90
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	70-120
			Quenched and tempered	930	275	7	70-110
				1000	300	8	50-90
				1200	350	9	40-70
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	50-90
			Quenched and tempered	1100	325	11	40-80
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	40-70
			Martensitic	820	240	13	40-70
			Austenitic	600	180	14	30-70
K	Gray cast iron (GG)		Ferritic		160	15	90-160
			Pearlitic		250	16	80-140
	Cast iron nodular (GGG)		Ferritic		180	17	90-180
			Pearlitic		260	18	80-140
	Malleable cast iron		Ferritic		130	19	90-160
			Pearlitic		230	20	80-140
N	Aluminum - Wrought alloy		Not cureable		60	21	90-220
			Cured		100	22	90-220
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	90-220
			Cured		90	24	90-220
		>12% Si	High temp.		130	25	80-160
	Copper alloys	>1% Pb	Free cutting		110	26	90-220
			Brass		90	27	90-220
			Electrolitic copper		100	28	90-220
	Non-metallic		Duroplastics, fiber plastics			29	
			Hard rubber			30	
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	20-50
		Ni or Co based	Annealed		250	33	20-50
			Cured		350	34	20-50
			Cast		320	35	20-50
	Titanium, Ti alloys			Rm 400		36	20-50
			Alpha+beta alloys cured	Rm 1050		37	20-50
H	Hardened steel		Hardened		55HRC	38	20-50
			Hardened		60HRC	39	20-50
	Chilled cast iron		Cast		400	40	
	Cast iron nodular		Hardened		55HRC	41	

• For more information of material groups, see the materials & grades "material conversion table"

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

TaeguTec
Member IMC Group

Recommended Cutting Conditions

DRILL•RUSH

Machining data for DRILLRUSH

Feed (mm/rev) vs. drill diameter						
Ø6 - Ø7.9	Ø8 - Ø9.9	Ø10 - Ø11.9	Ø12 - Ø13.9	Ø14 - Ø15.9	Ø16 - Ø19.9	Ø20 - Ø25.9
0.09-0.13	0.12-0.22	0.15-0.28	0.18-0.30	0.20-0.35	0.25-0.45	0.25-0.45
0.09-0.13	0.12-0.22	0.15-0.28	0.18-0.30	0.20-0.35	0.25-0.45	0.25-0.45
0.09-0.13	0.12-0.22	0.15-0.28	0.18-0.30	0.20-0.35	0.25-0.45	0.25-0.45
0.09-0.13	0.12-0.22	0.15-0.28	0.18-0.30	0.20-0.35	0.25-0.45	0.25-0.45
0.09-0.13	0.12-0.22	0.15-0.28	0.18-0.30	0.20-0.35	0.25-0.45	0.25-0.45
0.09-0.15	0.12-0.25	0.14-0.28	0.16-0.32	0.18-0.35	0.23-0.40	0.25-0.45
0.09-0.15	0.12-0.25	0.14-0.28	0.16-0.32	0.18-0.35	0.23-0.40	0.25-0.45
0.09-0.15	0.12-0.25	0.14-0.28	0.16-0.32	0.18-0.35	0.23-0.40	0.25-0.45
0.09-0.15	0.12-0.25	0.14-0.28	0.16-0.32	0.18-0.35	0.23-0.40	0.25-0.45
0.09-0.12	0.12-0.20	0.12-0.22	0.15-0.25	0.18-0.28	0.20-0.30	0.22-0.33
0.09-0.12	0.12-0.20	0.12-0.22	0.15-0.25	0.18-0.28	0.20-0.30	0.22-0.33
0.08-0.10	0.10-0.15	0.12-0.18	0.14-0.20	0.16-0.24	0.16-0.26	0.18-0.30
0.08-0.10	0.10-0.15	0.12-0.18	0.14-0.20	0.16-0.24	0.16-0.26	0.18-0.30
0.08-0.10	0.10-0.15	0.12-0.18	0.14-0.20	0.16-0.24	0.16-0.26	0.18-0.30
0.12-0.18	0.15-0.30	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.55	0.35-0.60
0.12-0.18	0.15-0.30	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.55	0.35-0.60
0.12-0.18	0.15-0.30	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.55	0.35-0.60
0.12-0.18	0.15-0.30	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.55	0.35-0.60
0.12-0.18	0.15-0.30	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.55	0.35-0.60
0.12-0.18	0.15-0.30	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.55	0.35-0.60
	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
	0.20-0.35	0.25-0.40	0.30-0.45	0.35-0.50	0.40-0.60	0.45-0.70
0.05-0.07	0.06-0.11	0.08-0.13	0.10-0.15	0.12-0.18	0.12-0.20	0.14-0.22
0.05-0.07	0.06-0.11	0.08-0.13	0.10-0.15	0.12-0.18	0.12-0.20	0.14-0.22
0.05-0.07	0.06-0.11	0.08-0.13	0.10-0.15	0.12-0.18	0.12-0.20	0.14-0.22
0.05-0.07	0.06-0.11	0.08-0.13	0.10-0.15	0.12-0.18	0.12-0.20	0.14-0.22
0.05-0.07	0.06-0.11	0.08-0.13	0.10-0.15	0.12-0.18	0.12-0.20	0.14-0.22
0.05-0.07	0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.20	0.14-0.22	0.16-0.25
0.05-0.07	0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.20	0.14-0.22	0.16-0.25
0.05-0.07	0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.20	0.14-0.22	0.16-0.25
0.05-0.07	0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.20	0.14-0.22	0.16-0.25

Recommended Cutting Conditions

TWIN-RUSH

Machining data for TWINRUSH

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	120-200
		>=0.25%C	Annealed	650	190	2	120-200
		<0.55%C	Quenched and tempered	850	250	3	130-190
		>=0.55%C	Annealed	750	220	4	130-190
			Quenched and tempered	1000	300	5	130-190
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	100-200
			Quenched and tempered	930	275	7	100-200
				1000	300	8	100-200
				1200	350	9	100-200
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	100-160
			Quenched and tempered	1100	325	11	100-160
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	80-140
			Martensitic	820	240	13	80-140
			Austenitic	600	180	14	80-140
K	Gray cast iron (GG)		Ferritic		160	15	100-250
			Pearlitic		250	16	100-250
	Cast iron nodular (GGG)		Ferritic		180	17	100-250
			Pearlitic		260	18	100-250
	Malleable cast iron		Ferritic		130	19	100-250
			Pearlitic		230	20	100-250
N	Aluminum - Wrought alloy		Not cureable		60	21	160-260
			Cured		100	22	160-260
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	160-260
			Cured		90	24	160-260
		>12% Si	High temp.		130	25	160-260
	Copper alloys	>1% Pb	Free cutting		110	26	160-260
			Brass		90	27	160-260
			Electrolitic copper		100	28	160-260
	Non-metallic		Duroplastics, fiber plastics			29	
			Hard rubber			30	
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	30-80
		Ni or Co based	Annealed		250	33	30-80
			Cured		350	34	30-80
			Cast		320	35	30-80
	Titanium, Ti alloys			Rm 400		36	30-80
			Alpha+beta alloys cured	Rm 1050		37	30-80
H	Hardened steel		Hardened		55HRC	38	20-50
			Hardened		60HRC	39	20-50
	Chilled cast iron		Cast		400	40	
	Cast iron nodular		Hardened		55HRC	41	

• For more information of material groups, see the materials & grades "material conversion table"

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

TaeguTec
Member IMC Group

Recommended Cutting Conditions

TWIN•RUSH

Machining data for TWINRUSH

Feed (mm/rev) vs. drill diameter				
SPGX 06 Ø26 - Ø28	SPGX 07 Ø29 - Ø32	SPGX 09 Ø33 - Ø36	SPGX 11 Ø37 - Ø43	SPGX 11 Ø44 - Ø45
0.20-0.35	0.25-0.35	0.2-0.4	0.25-0.4	0.28-0.45
0.20-0.35	0.25-0.35	0.2-0.4	0.25-0.4	0.28-0.45
0.20-0.35	0.25-0.35	0.2-0.4	0.25-0.4	0.28-0.45
0.20-0.35	0.25-0.35	0.2-0.4	0.25-0.4	0.28-0.45
0.20-0.35	0.25-0.35	0.2-0.4	0.25-0.4	0.28-0.45
0.20-0.33	0.25-0.33	0.25-0.36	0.25-0.36	0.25-0.40
0.20-0.33	0.25-0.33	0.25-0.36	0.25-0.36	0.25-0.40
0.20-0.33	0.25-0.33	0.25-0.36	0.25-0.36	0.25-0.40
0.20-0.33	0.25-0.33	0.25-0.36	0.25-0.36	0.25-0.40
0.20-0.33	0.25-0.33	0.25-0.36	0.25-0.36	0.25-0.40
0.20-0.33	0.25-0.33	0.25-0.36	0.25-0.36	0.25-0.40
0.12-0.24	0.15-0.24	0.16-0.25	0.18-0.28	0.18-0.30
0.12-0.24	0.15-0.24	0.16-0.25	0.18-0.28	0.18-0.30
0.12-0.24	0.15-0.24	0.16-0.25	0.18-0.28	0.18-0.30
0.25-0.45	0.25-0.45	0.3-0.5	0.3-0.5	0.35-0.55
0.25-0.45	0.25-0.45	0.3-0.5	0.3-0.5	0.35-0.55
0.25-0.45	0.25-0.45	0.3-0.5	0.3-0.5	0.35-0.55
0.25-0.45	0.25-0.45	0.3-0.5	0.3-0.5	0.35-0.55
0.25-0.45	0.25-0.45	0.3-0.5	0.3-0.5	0.35-0.55
0.25-0.45	0.25-0.45	0.3-0.5	0.3-0.5	0.35-0.55
0.3-0.5	0.3-0.5	0.35-0.55	0.05-0.55	0.4-0.6
0.3-0.5	0.3-0.5	0.35-0.55	0.05-0.55	0.4-0.6
0.3-0.5	0.3-0.5	0.35-0.55	0.05-0.55	0.4-0.6
0.3-0.5	0.3-0.5	0.35-0.55	0.05-0.55	0.4-0.6
0.3-0.5	0.3-0.5	0.35-0.55	0.05-0.55	0.4-0.6
0.3-0.5	0.3-0.5	0.35-0.55	0.05-0.55	0.4-0.6
0.3-0.5	0.3-0.5	0.35-0.55	0.05-0.55	0.4-0.6
0.3-0.5	0.3-0.5	0.35-0.55	0.05-0.55	0.4-0.6
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24
0.1-0.16	0.10-0.18	0.15-0.20	0.15-0.22	0.16-0.24
0.1-0.16	0.12-0.18	0.14-0.20	0.14-0.20	0.16-0.22
0.1-0.16	0.12-0.18	0.14-0.20	0.14-0.20	0.16-0.22

Recommended Cutting Conditions

SPADE•RUSH

Machining data for SPADERUSH

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	80-140
		>=0.25%C	Annealed	650	190	2	80-130
		<0.55%C	Quenched and tempered	850	250	3	80-120
		>=0.55%C	Annealed	750	220	4	70-110
			Quenched and tempered	1000	300	5	50-90
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	80-120
			Quenched and tempered	930	275	7	70-110
				1000	300	8	50-90
				1200	350	9	40-70
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	50-90
			Quenched and tempered	1100	325	11	40-80
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	40-70
			Martensitic	820	240	13	40-70
			Austenitic	600	180	14	30-70
K	Gray cast iron (GG)		Ferritic		160	15	90-180
			Pearlitic		250	16	80-140
	Cast iron nodular (GGG)		Ferritic		180	17	90-165
			Pearlitic		260	18	80-140
	Malleable cast iron		Ferritic		130	19	90-160
			Pearlitic		230	20	80-140
N	Aluminum - Wrought alloy		Not cureable		60	21	90-220
			Cured		100	22	90-220
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	90-220
			Cured		90	24	90-220
		>12% Si	High temp.		130	25	80-160
	Copper alloys	>1% Pb	Free cutting		110	26	90-220
			Brass		90	27	90-220
			Electrolitic copper		100	28	90-220
	Non-metallic		Duroplastics, fiber plastics			29	
			Hard rubber			30	
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	20-50
		Ni or Co based	Annealed		250	33	20-50
			Cured		350	34	20-50
			Cast		320	35	20-50
	Titanium, Ti alloys			Rm 400		36	20-50
			Alpha+beta alloys cured	Rm 1050		37	20-50
H	Hardened steel		Hardened		55HRC	38	20-50
			Hardened		60HRC	39	20-50
	Chilled cast iron		Cast		400	40	
	Cast iron nodular		Hardened		55HRC	41	

• For more information of material groups, see the materials & grades "material conversion table"

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

TaeguTec Member IMC Group

Recommended Cutting Conditions

SPADE•RUSH

Machining data for SPADERUSH

Feed (mm/rev) vs. drill diameter		
Ø26-Ø29.9	Ø30-Ø34.9	Ø35-Ø41
0.30-0.50	0.30-0.50	0.35-0.55
0.30-0.50	0.30-0.50	0.35-0.55
0.30-0.50	0.30-0.50	0.35-0.55
0.30-0.50	0.30-0.50	0.35-0.55
0.30-0.50	0.30-0.50	0.35-0.55
0.25-0.45	0.25-0.45	0.30-0.50
0.25-0.45	0.25-0.45	0.30-0.50
0.25-0.45	0.25-0.45	0.30-0.50
0.25-0.45	0.25-0.45	0.30-0.50
0.25-0.35	0.25-0.35	0.30-0.40
0.25-0.35	0.25-0.35	0.30-0.40
0.15-0.30	0.15-0.30	0.20-0.35
0.15-0.30	0.15-0.30	0.20-0.35
0.15-0.30	0.15-0.30	0.20-0.35
0.35-0.55	0.35-0.55	0.40-0.60
0.35-0.55	0.35-0.55	0.40-0.60
0.35-0.55	0.35-0.55	0.40-0.60
0.35-0.55	0.35-0.55	0.40-0.60
0.35-0.55	0.35-0.55	0.40-0.60
0.35-0.55	0.35-0.55	0.40-0.60
0.40-0.60	0.40-0.60	0.50-0.70
0.40-0.60	0.40-0.60	0.50-0.70
0.40-0.60	0.40-0.60	0.50-0.70
0.40-0.60	0.40-0.60	0.50-0.70
0.40-0.60	0.40-0.60	0.50-0.70
0.40-0.60	0.40-0.60	0.50-0.70
0.40-0.60	0.40-0.60	0.50-0.70
0.40-0.60	0.40-0.60	0.50-0.70
0.10-0.20	0.15-0.25	0.15-0.25
0.10-0.20	0.15-0.25	0.15-0.25
0.10-0.20	0.15-0.25	0.15-0.25
0.10-0.20	0.15-0.25	0.15-0.25
0.10-0.20	0.15-0.25	0.15-0.25
0.10-0.20	0.15-0.25	0.15-0.25
0.10-0.20	0.15-0.25	0.15-0.25
0.10-0.20	0.15-0.25	0.15-0.25
0.10-0.20	0.15-0.25	0.15-0.25
0.10-0.20	0.15-0.25	0.15-0.25

Recommended Cutting Conditions

H-DRILL

Machining data for H-DRILL

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	80-120
		>=0.25%C	Annealed	650	190	2	80-110
		<0.55%C	Quenched and tempered	850	250	3	70-100
		>=0.55%C	Annealed	750	220	4	70-100
			Quenched and tempered	1000	300	5	70-100
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	70-90
			Quenched and tempered	930	275	7	70-90
				1000	300	8	50-80
				1200	350	9	40-70
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	50-80
			Quenched and tempered	1100	325	11	40-70
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	30-60
			Martensitic	820	240	13	30-60
			Austenitic	600	180	14	30-60
K	Gray cast iron (GG)		Ferritic		160	15	65-80
			Pearlitic		250	16	65-80
	Cast iron nodular (GGG)		Ferritic		180	17	85-105
			Pearlitic		260	18	75-90
	Malleable cast iron		Ferritic		130	19	65-80
			Pearlitic		230	20	65-80
N	Aluminum - Wrought alloy		Not cureable		60	21	70-200
			Cured		100	22	70-200
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	70-200
			Cured		90	24	70-200
		>12% Si	High temp.		130	25	70-150
	Copper alloys	>1% Pb	Free cutting		110	26	70-200
			Brass		90	27	70-200
			Electrolitic copper		100	28	70-200
	Non-metallic		Duroplastics, fiber plastics			29	
			Hard rubber			30	
S	High temp. alloys	Fe based	Annealed		200	31	15-40
			Cured		280	32	15-40
		Ni or Co based	Annealed		250	33	15-40
			Cured		350	34	15-40
			Cast		320	35	15-40
	Titanium, Ti alloys			Rm 400		36	
			Alpha+beta alloys cured	Rm 1050		37	
H	Hardened steel		Hardened		55HRC	38	10-40
			Hardened		60HRC	39	10-40
	Chilled cast iron		Cast		400	40	
	Cast iron nodular		Hardened		55HRC	41	

• For more information of material groups, see the materials & grades "material conversion table"

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

TaeguTec
Member IMC Group

Recommended Cutting Conditions

H-DRILL

Machining data for H-DRILL

Feed (mm/rev) vs. drill diameter		
Ø3 - Ø5	Ø5.1 - Ø8	Ø8.1 - Ø12
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.08-0.18	0.10-0.20	0.15-0.25
0.08-0.18	0.10-0.20	0.15-0.25
0.06-0.12	0.10-0.15	0.12-0.18
0.06-0.12	0.10-0.15	0.12-0.18
0.06-0.12	0.10-0.15	0.12-0.18
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.20	0.15-0.25	0.20-0.30
0.10-0.25	0.15-0.35	0.25-0.45
0.10-0.25	0.15-0.35	0.25-0.45
0.10-0.25	0.15-0.35	0.25-0.45
0.10-0.25	0.15-0.35	0.25-0.45
0.10-0.25	0.15-0.35	0.25-0.45
0.08-0.18	0.15-0.25	0.20-0.35
0.08-0.18	0.15-0.25	0.20-0.35
0.08-0.18	0.15-0.25	0.20-0.35
0.02-0.08	0.04-0.10	0.06-0.12
0.02-0.08	0.04-0.10	0.06-0.12
0.02-0.08	0.04-0.10	0.06-0.12
0.02-0.08	0.04-0.10	0.06-0.12
0.02-0.08	0.04-0.10	0.06-0.12
0.02-0.08	0.04-0.10	0.06-0.12
0.02-0.08	0.04-0.10	0.06-0.12

Recommended Cutting Conditions

TOPCAP

Machining data for TOPCAP

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1
		>=0.25%C	Annealed	650	190	2
		<0.55%C	Quenched and tempered	850	250	3
		>=0.55%C	Annealed	750	220	4
			Quenched and tempered	1000	300	5
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6
			Quenched and tempered	930	275	7
				1000	300	8
				1200	350	9
	High alloy steel, cast steel and tool steel		Annealed	680	200	10
			Quenched and tempered	1100	325	11
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12
			Martensitic	820	240	13
			Austenitic	600	180	14
K	Gray cast iron (GG)		Ferritic		160	15
			Pearlitic		250	16
	Cast iron nodular (GGG)		Ferritic		180	17
			Pearlitic		260	18
	Malleable cast iron		Ferritic		130	19
			Pearlitic		230	20
N	Aluminum - Wrought alloy		Not cureable		60	21
			Cured		100	22
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23
			Cured		90	24
		>12% Si	High temp.		130	25
	Copper alloys	>1% Pb	Free cutting		110	26
			Brass		90	27
			Electrolitic copper		100	28
	Non-metallic		Duroplastics, fiber plastics			29
			Hard rubber			30
S	High temp. alloys	Fe based	Annealed		200	31
			Cured		280	32
		Ni or Co based	Annealed		250	33
			Cured		350	34
			Cast		320	35
	Titanium, Ti alloys			Rm 400		36
			Alpha+beta alloys cured	Rm 1050		37
H	Hardened steel		Hardened		55HRC	38
			Hardened		60HRC	39
	Chilled cast iron		Cast		400	40
	Cast iron nodular		Hardened		55HRC	41

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

TOPCAP

Machining data for TOPCAP

Drilling		Turning & boring		Grooving	
Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)
120-260	0.05-0.06	140-280	0.04-0.14	120-250	0.04-0.25
80-190	0.05-0.15	90-200	0.04-0.12	80-180	0.04-0.25
100-280	0.06-0.18	100-200	0.04-0.15	80-180	0.04-0.25
100-280	0.06-0.18	100-200	0.04-0.15	80-180	0.04-0.25
100-280	0.06-0.18	100-200	0.04-0.15	80-180	0.04-0.25
100-280	0.06-0.18	100-200	0.04-0.15	80-180	0.04-0.25
60-180	0.04-0.15	80-180	0.07-0.12	60-160	0.04-0.25
60-180	0.04-0.15	80-180	0.07-0.12	60-160	0.04-0.25
60-180	0.04-0.15	80-180	0.07-0.12	60-160	0.04-0.25
80-190	0.05-0.15	80-200	0.04-0.12	80-160	0.04-0.25
50-150	0.04-0.14	60-150	0.04-0.12	50-120	0.04-0.25
50-210	0.04-0.15	60-230	0.07-0.12	50-200	0.04-0.25
50-210	0.04-0.15	60-230	0.07-0.12	50-200	0.04-0.25
50-210	0.04-0.15	60-230	0.07-0.12	50-200	0.04-0.25
100-300	0.06-0.23	120-230	0.07-0.2	100-200	0.04-0.25
100-300	0.06-0.23	120-230	0.07-0.2	100-200	0.04-0.25
100-300	0.06-0.23	120-230	0.07-0.2	100-200	0.04-0.25
100-300	0.06-0.23	120-230	0.07-0.2	100-200	0.04-0.25
100-200	0.06-0.15	120-230	0.04-0.13	100-200	0.04-0.25
100-200	0.06-0.15	120-230	0.04-0.13	100-200	0.04-0.25
120-500	0.05-0.3	120-700	0.04-0.25	100-700	0.04-0.25
120-500	0.05-0.3	120-700	0.04-0.25	100-700	0.04-0.25
120-500	0.05-0.3	120-700	0.04-0.25	100-700	0.04-0.25
120-500	0.05-0.3	120-700	0.04-0.25	100-700	0.04-0.25
120-500	0.05-0.3	120-700	0.04-0.25	100-700	0.04-0.25
80-380	0.05-0.23	80-500	0.04-0.2	80-350	0.04-0.25
80-380	0.05-0.23	80-500	0.04-0.2	80-350	0.04-0.25
80-380	0.05-0.23	80-500	0.04-0.2	80-350	0.04-0.25
50-140	0.04-0.14	50-160	0.04-0.12	50-140	0.04-0.25
50-140	0.04-0.14	50-160	0.04-0.12	50-140	0.04-0.25
20-50	0.04-0.05	20-80	0.04-0.05	20-50	0.04-0.05
20-50	0.04-0.05	20-80	0.04-0.05	20-50	0.04-0.05
20-50	0.04-0.05	20-80	0.04-0.05	20-50	0.04-0.05
20-50	0.04-0.05	20-80	0.04-0.05	20-50	0.04-0.05
20-50	0.04-0.05	20-80	0.04-0.05	20-50	0.04-0.05
30-60	0.04-0.05	30-100	0.04-0.05	30-80	0.04-0.05
30-60	0.04-0.05	30-100	0.04-0.05	30-80	0.04-0.05
20-40	0.04-0.05	20-70	0.04-0.05	20-50	0.04-0.05
20-40	0.04-0.05	20-70	0.04-0.05	20-50	0.04-0.05
20-40	0.04-0.05	20-70	0.04-0.05	20-50	0.04-0.05
20-40	0.04-0.05	20-70	0.04-0.05	20-50	0.04-0.05

Recommended Cutting Conditions

T-DEEP

Machining data for TBTA 3/5/7/9 & TBTA-R

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	60-120
		>=0.25%C	Annealed	650	190	2	60-120
		<0.55%C	Quenched and tempered	850	250	3	60-120
		>=0.55%C	Annealed	750	220	4	60-120
			Quenched and tempered	1000	300	5	50-100
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	50-100
			Quenched and tempered	930	275	7	50-100
				1000	300	8	50-100
				1200	350	9	50-100
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	60-120
			Quenched and tempered	1100	325	11	60-120
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	60-110
			Martensitic	820	240	13	60-110
			Austenitic	600	180	14	60-110
K	Gray cast iron (GG)		Ferritic		160	15	60-100
			Pearlitic		250	16	60-100
	Cast iron nodular (GGG)		Ferritic		180	17	60-100
			Pearlitic		260	18	60-100
	Malleable cast iron		Ferritic		130	19	60-100
			Pearlitic		230	20	60-100
N	Aluminum - Wrought alloy		Not cureable		60	21	60-130
			Cured		100	22	60-130
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	60-130
			Cured		90	24	60-130
		>12% Si	High temp.		130	25	60-130
	Copper alloys	>1% Pb	Free cutting		110	26	60-130
			Brass		90	27	60-130
			Electrolitic copper		100	28	60-130
	Non-metallic		Duroplastics, fiber plastics			29	
			Hard rubber			30	
S	High temp. alloys	Fe based	Annealed		200	31	20-65
			Cured		280	32	20-65
		Ni or Co based	Annealed		250	33	20-65
			Cured		350	34	20-65
			Cast		320	35	20-65
	Titanium, Ti alloys			Rm 400		36	30-100
			Alpha+beta alloys cured	Rm 1050		37	30-100
H	Hardened steel		Hardened		55HRC	38	
			Hardened		60HRC	39	
	Chilled cast iron		Cast		400	40	
	Cast iron nodular		Hardened		55HRC	41	

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

Machining data for TBTA 3/5/7/9 & TBTA-R

Feed (mm/rev) vs. drill diameter				
Ø38.00 - Ø39.99	Ø40.00 - Ø51.99	Ø52.00 - Ø63.99	Ø64.00 - Ø84.99	Ø85.00 -
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.13	0.10-0.15	0.13-0.18	0.15-0.20	0.18-0.23
0.08-0.13	0.10-0.15	0.13-0.18	0.15-0.20	0.18-0.23
0.08-0.13	0.10-0.15	0.13-0.18	0.15-0.20	0.18-0.23
0.08-0.13	0.10-0.15	0.13-0.18	0.15-0.20	0.18-0.23
0.08-0.13	0.10-0.15	0.13-0.18	0.15-0.20	0.18-0.23
0.08-0.13	0.10-0.15	0.13-0.18	0.15-0.20	0.18-0.23
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.20	0.10-0.25	0.13-0.28	0.15-0.30	0.18-0.33
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30
0.08-0.15	0.10-0.20	0.13-0.23	0.15-0.25	0.18-0.30

Recommended Cutting Conditions

T-DEEP

Machining data for TBTA-FB

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	70-130
		>=0.25%C	Annealed	650	190	2	70-130
		<0.55%C	Quenched and tempered	850	250	3	70-130
		>=0.55%C	Annealed	750	220	4	70-130
			Quenched and tempered	1000	300	5	70-130
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	70-120
			Quenched and tempered	930	275	7	60-120
				1000	300	8	60-120
				1200	350	9	60-120
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	70-130
			Quenched and tempered	1100	325	11	70-130
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	70-130
			Martensitic	820	240	13	70-130
			Austenitic	600	180	14	70-130
K	Gray cast iron (GG)		Ferritic		160	15	60-110
			Pearlitic		250	16	60-110
	Cast iron nodular (GGG)		Ferritic		180	17	50-110
			Pearlitic		260	18	50-110
	Malleable cast iron		Ferritic		130	19	70-110
			Pearlitic		230	20	70-110
N	Aluminum - Wrought alloy		Not cureable		60	21	65-130
			Cured		100	22	65-130
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	65-130
			Cured		90	24	65-130
		>12% Si	High temp.		130	25	65-130
	Copper alloys	>1% Pb	Free cutting		110	26	65-130
			Brass		90	27	65-130
			Electrolitic copper		100	28	65-130
	Non-metallic		Duroplastics, fiber plastics			29	
			Hard rubber			30	
S	High temp. alloys	Fe based	Annealed		200	31	20-50
			Cured		280	32	20-50
		Ni or Co based	Annealed		250	33	20-50
			Cured		350	34	20-50
			Cast		320	35	20-50
	Titanium, Ti alloys			Rm 400		36	30-60
			Alpha+beta alloys cured	Rm 1050		37	30-60
H	Hardened steel		Hardened		55HRC	38	
			Hardened		60HRC	39	
	Chilled cast iron		Cast		400	40	
	Cast iron nodular		Hardened		55HRC	41	

• For more information of material groups, see the materials & grades "material conversion table"

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

TaeguTec
Member IMC Group

Recommended Cutting Conditions

Machining data for TBTA-FB

Feed (mm/rev) vs. drill diameter			
Ø25.00 - Ø43.00	Ø43.01 - Ø65.00		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.30	0.12-0.35		
0.10-0.25	0.12-0.35		
0.10-0.25	0.12-0.35		
0.10-0.25	0.12-0.35		
0.10-0.25	0.12-0.35		
0.10-0.25	0.12-0.35		
0.10-0.25	0.12-0.35		
0.10-0.25	0.12-0.35		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		
0.08-0.23	0.12-0.27		

Recommended Cutting Conditions

Machining data for BTA & BTS

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	70-120
		>=0.25%C	Annealed	650	190	2	70-120
		<0.55%C	Quenched and tempered	850	250	3	40-70
		>=0.55%C	Annealed	750	220	4	70-120
			Quenched and tempered	1000	300	5	55-100
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	70-100
			Quenched and tempered	930	275	7	55-100
				1000	300	8	55-100
				1200	350	9	55-100
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	50-85
			Quenched and tempered	1100	325	11	55-100
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	60-100
			Martensitic	820	240	13	60-100
			Austenitic	600	180	14	60-100
K	Gray cast iron (GG)		Ferritic		160	15	60-100
			Pearlitic		250	16	60-100
	Cast iron nodular (GGG)		Ferritic		180	17	80-100
			Pearlitic		260	18	80-100
	Malleable cast iron		Ferritic		130	19	50-100
			Pearlitic		230	20	50-100
N	Aluminum - Wrought alloy		Not cureable		60	21	65-130
			Cured		100	22	65-100
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	65-130
			Cured		90	24	65-130
		>12% Si	High temp.		130	25	65-130
	Copper alloys	>1% Pb	Free cutting		110	26	65-130
			Brass		90	27	65-130
			Electrolitic copper		100	28	65-130
	Non-metallic		Duroplastics, fiber plastics			29	
			Hard rubber			30	
S	High temp. alloys	Fe based	Annealed		200	31	10-50
			Cured		280	32	10-50
		Ni or Co based	Annealed		250	33	10-50
			Cured		350	34	10-50
			Cast		320	35	10-50
	Titanium, Ti alloys			Rm 400		36	30-50
			Alpha+beta alloys cured	Rm 1050		37	30-50
H	Hardened steel		Hardened		55HRC	38	
			Hardened		60HRC	39	
	Chilled cast iron		Cast		400	40	
	Cast iron nodular		Hardened		55HRC	41	

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

Machining data for BTA & BTS

Feed (mm/rev) vs. drill diameter				
Ø8.00 - Ø20.00	Ø15.60 - Ø20.00	Ø20.01 - Ø31.00	Ø31.01 - Ø43.00	Ø43.01 - Ø65.00
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.10	0.08-0.12	0.10-0.15	0.13-0.17	0.15-0.28
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.10	0.08-0.12	0.10-0.15	0.13-0.17	0.15-0.28
0.05-0.10	0.08-0.12	0.10-0.15	0.13-0.17	0.15-0.28
0.05-0.10	0.08-0.12	0.10-0.15	0.13-0.17	0.15-0.28
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.10	0.08-0.12	0.10-0.15	0.13-0.17	0.15-0.28
0.05-0.13	0.08-0.15	0.10-0.28	0.13-0.30	0.16-0.35
0.05-0.13	0.08-0.15	0.10-0.28	0.13-0.30	0.16-0.35
0.05-0.12	0.05-0.12	0.08-0.25	0.10-0.28	0.15-0.33
0.05-0.13	0.06-0.13	0.08-0.18	0.10-0.20	0.15-0.25
0.05-0.13	0.06-0.13	0.08-0.18	0.10-0.20	0.15-0.25
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.17	0.13-0.20	0.16-0.30
0.05-0.13	0.06-0.13	0.08-0.18	0.10-0.20	0.15-0.25
0.05-0.13	0.06-0.13	0.08-0.18	0.10-0.20	0.15-0.25
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.13	0.08-0.15	0.10-0.20	0.15-0.25	0.16-0.30
0.05-0.12	0.06-0.12	0.08-0.15	0.12-0.18	0.15-0.25
0.05-0.12	0.06-0.12	0.08-0.15	0.12-0.18	0.15-0.25
0.05-0.12	0.06-0.12	0.08-0.15	0.12-0.18	0.15-0.25
0.05-0.12	0.06-0.12	0.08-0.15	0.12-0.18	0.15-0.25
0.05-0.12	0.06-0.12	0.08-0.15	0.12-0.18	0.15-0.25
0.05-0.10	0.05-0.10	0.08-0.12	0.10-0.15	0.12-0.20
0.05-0.10	0.05-0.10	0.08-0.12	0.10-0.15	0.12-0.20

Recommended Cutting Conditions

Machining data for HFD

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	60-120
		>=0.25%C	Annealed	650	190	2	60-120
		<0.55%C	Quenched and tempered	850	250	3	60-120
		>=0.55%C	Annealed	750	220	4	60-120
			Quenched and tempered	1000	300	5	50-100
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	50-100
			Quenched and tempered	930	275	7	50-100
				1000	300	8	50-100
				1200	350	9	50-100
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	60-120
			Quenched and tempered	1100	325	11	50-100
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	40-80
			Martensitic	820	240	13	40-80
			Austenitic	600	180	14	30-60
K	Gray cast iron (GG)		Ferritic		160	15	50-90
			Pearlitic		250	16	50-80
	Cast iron nodular (GGG)		Ferritic		180	17	70-100
			Pearlitic		260	18	70-100
	Malleable cast iron		Ferritic		130	19	50-90
			Pearlitic		230	20	50-90
N	Aluminum - Wrought alloy		Not cureable		60	21	60-120
			Cured		100	22	60-90
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	60-120
			Cured		90	24	60-120
		>12% Si	High temp.		130	25	60-120
	Copper alloys	>1% Pb	Free cutting		110	26	60-120
			Brass		90	27	60-120
			Electrolitic copper		100	28	60-120
	Non-metallic		Duroplastics, fiber plastics			29	
			Hard rubber			30	
S	High temp. alloys	Fe based	Annealed		200	31	20-50
			Cured		280	32	20-50
		Ni or Co based	Annealed		250	33	20-50
			Cured		350	34	20-50
			Cast		320	35	20-50
	Titanium, Ti alloys			Rm 400		36	20-50
			Alpha+beta alloys cured	Rm 1050		37	20-50
H	Hardened steel		Hardened		55 HRC	38	
			Hardened		60 HRC	39	
	Chilled cast iron		Cast		400	40	
	Cast iron nodular		Hardened		55 HRC	41	

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

Machining data for HFD

Feed (mm/rev) vs. drill diameter			
Ø30.00 - Ø43.00	Ø43.01 - Ø69.00		
0.08-0.13	0.10-0.15		
0.08-0.13	0.10-0.15		
0.08-0.13	0.10-0.15		
0.08-0.13	0.10-0.15		
0.08-0.11	0.10-0.13		
0.08-0.11	0.10-0.15		
0.08-0.11	0.10-0.13		
0.08-0.11	0.10-0.13		
0.08-0.11	0.10-0.13		
0.08-0.13	0.10-0.15		
0.08-0.11	0.10-0.13		
0.08-0.13	0.10-0.15		
0.08-0.13	0.10-0.15		
0.05-0.11	0.08-0.14		
0.06-0.12	0.08-0.16		
0.06-0.12	0.08-0.16		
0.08-0.13	0.10-0.15		
0.08-0.13	0.10-0.15		
0.06-0.12	0.08-0.16		
0.06-0.12	0.08-0.16		
0.08-0.13	0.10-0.18		
0.08-0.13	0.10-0.18		
0.08-0.13	0.10-0.18		
0.08-0.13	0.10-0.18		
0.08-0.13	0.10-0.18		
0.08-0.13	0.10-0.18		
0.08-0.13	0.10-0.18		
0.08-0.13	0.10-0.18		
0.06-0.11	0.08-0.14		
0.06-0.11	0.08-0.14		
0.06-0.11	0.08-0.14		
0.06-0.11	0.08-0.14		
0.06-0.11	0.08-0.14		
0.05-0.09	0.08-0.11		
0.05-0.09	0.08-0.11		

Recommended Cutting Conditions

T-DEEP

Machining data for TRGD / TRGDL / TBTA-TR

ISO	Material		Condition	Tensile strength (N/mm^2)	Hardness HB	Material No.
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1
		>=0.25%C	Annealed	650	190	2
		<0.55%C	Quenched and tempered	850	250	3
		>=0.55%C	Annealed	750	220	4
			Quenched and tempered	1000	300	5
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6
			Quenched and tempered	930	275	7
				1000	300	8
				1200	350	9
	High alloy steel, cast steel and tool steel		Annealed	680	200	10
			Quenched and tempered	1100	325	11
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12
			Martensitic	820	240	13
			Austenitic	600	180	14
K	Gray cast iron (GG)		Ferritic		160	15
			Pearlitic		250	16
	Cast iron nodular (GGG)		Ferritic		180	17
			Pearlitic		260	18
	Malleable cast iron		Ferritic		130	19
			Pearlitic		230	20
N	Aluminum - Wrought alloy		Not cureable		60	21
			Cured		100	22
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23
			Cured		90	24
		>12% Si	High temp.		130	25
	Copper alloys	>1% Pb	Free cutting		110	26
			Brass		90	27
			Electrolitic copper		100	28
	Non-metallic		Duroplastics, fiber plastics			29
			Hard rubber			30
S	High temp. alloys	Fe based	Annealed		200	31
			Cured		280	32
		Ni or Co based	Annealed		250	33
			Cured		350	34
			Cast		320	35
	Titanium, Ti alloys			Rm 400		36
			Alpha+beta alloys cured	Rm 1050		37
H	Hardened steel		Hardened		55 HRC	38
			Hardened		60 HRC	39
	Chilled cast iron		Cast		400	40
	Cast iron nodular		Hardened		55 HRC	41

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

Machining data for TRGD / TRGDL / TBTA-TR

Feed (mm/rev) vs. drill diameter			
TRGD / TRGDL		TBTA-TR	
Cutting speed Vc (m/min)	Ø16.00-Ø28.00	Cutting speed Vc (m/min)	Ø16.00-Ø28.00
80-140	0.10-0.20	90-130	0.15-0.20
80-140	0.10-0.20	90-130	0.15-0.20
80-140	0.10-0.20	90-130	0.15-0.20
80-140	0.10-0.20	70-130	0.10-0.25
80-140	0.10-0.20	70-130	0.10-0.25
80-120	0.10-0.20	70-120	0.10-0.25
80-120	0.10-0.20	60-120	0.10-0.25
80-120	0.10-0.20	60-120	0.10-0.25
80-120	0.10-0.20	60-120	0.10-0.25
80-120	0.10-0.20	70-130	0.10-0.25
80-120	0.10-0.20	70-130	0.10-0.25
80-140	0.08-0.10	80-130	0.06-0.10
80-140	0.08-0.10	80-130	0.06-0.10
80-140	0.08-0.10	80-130	0.06-0.10
80-140	0.10-0.30	50-110	0.10-0.20
80-140	0.10-0.30	50-110	0.10-0.20
80-140	0.10-0.30	60-110	0.10-0.20
80-140	0.10-0.30	60-110	0.10-0.20
80-140	0.10-0.30	70-110	0.10-0.20
80-140	0.10-0.30	70-110	0.10-0.20
65-130	0.08-0.18	65-130	0.08-0.18
65-130	0.08-0.18	65-130	0.08-0.18
65-130	0.08-0.18	65-130	0.08-0.18
65-130	0.08-0.18	65-130	0.08-0.18
65-130	0.08-0.18	65-130	0.08-0.18
65-130	0.08-0.18	65-130	0.08-0.18
65-130	0.08-0.18	65-130	0.08-0.18
65-130	0.08-0.18	65-130	0.08-0.18
65-130	0.08-0.18	65-130	0.08-0.18
65-130	0.08-0.18	65-130	0.08-0.18
20-50	0.08-0.18	20-50	0.08-0.18
20-50	0.08-0.18	20-50	0.08-0.18
20-50	0.08-0.18	20-50	0.08-0.18
20-50	0.08-0.18	20-50	0.08-0.18
20-50	0.08-0.18	20-50	0.08-0.18
30-60	0.08-0.18	30-60	0.08-0.18
30-60	0.08-0.18	30-60	0.08-0.18

Recommended Cutting Conditions

Machining data for CDF

Material	Tensile strength (N/mm^2)	Hardness HB	Cutting speed Vc (m/min)	Feed (mm/rev) vs. drill diameter			
				Ø3.0 - Ø6.0	Ø6.1- Ø8.0	Ø8.1- Ø10.0	Ø10.1- Ø12.7
CFRP	420	125	50-150	0.02-0.07	0.03-0.08	0.03-0.08	0.04-0.10
GFRP	650	190	40-120	0.02-0.07	0.03-0.08	0.03-0.08	0.04-0.10

Reaming Tools



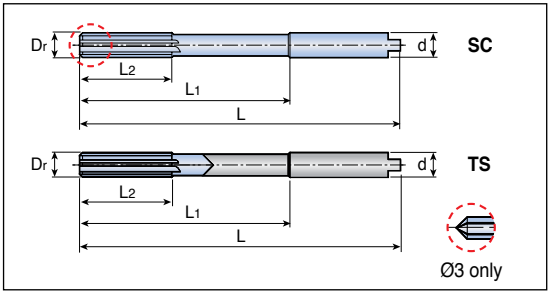
TS-S...-SC/TS

Solid reamer



• Straight flute - DIN8093





Designation	Dimension (mm)					No. of flute	Grade
	Dr	L	L1	L2	d		UF1A
TS- S0300-SC	3	61	30	15	3.0	6	●
S0400-SC	4	75	44	19	4 .0	6	●
S0500-SC	5	86	53	23	5.0	6	●
S0600-SC	6	93	56	26	5.6	6	●
S0700-SC	7	109	69	31	7.1	6	●
S0800-SC	8	117	75	33	8.0	6	●
S0900-TS	9	125	81	36	9.0	6	●
S1000-TS	10	133	87	38	10.0	6	●
S1100-TS	11	142	96	41	10.0	6	●
S1200-TS	12	151	105	44	10.0	6	●
S1300-TS	13	151	105	44	10.0	6	●
S1400-TS	14	160	110	47	12.5	8	●
S1500-TS	15	162	112	50	12.5	8	●
S1600-TS	16	170	120	52	12.5	8	●

Cutting Condition D201

- Reamers above diameter 5mm have a tang back-end design
- TiAlN coated reamer is available on request
- Special diameters are available on request

●: Standard item

TaeguTec Member IMC Group

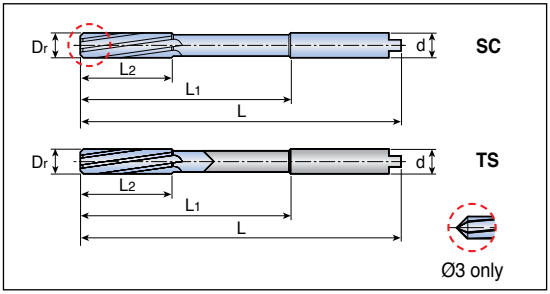
TS-L...-SC/TS

Solid reamer



• Left flute - DIN8093





Designation	Dimension (mm)					No. of flute	Grade
	Dr	L	L1	L2	d		UF1A
TS- L0300-SC	3	61	30	15	3.0	6	●
L0400-SC	4	75	44	19	4 .0	6	●
L0500-SC	5	86	53	23	5.0	6	●
L0600-SC	6	93	56	26	5.6	6	●
L0700-SC	7	109	69	31	7.1	6	●
L0800-SC	8	117	75	33	8.0	6	●
L0900-TS	9	125	81	36	9.0	6	●
L1000-TS	10	133	87	38	10.0	6	●
L1100-TS	11	142	96	41	10.0	6	●
L1200-TS	12	151	105	44	10.0	6	●
L1300-TS	13	151	105	44	10.0	6	●
L1400-TS	14	160	110	47	12.5	8	●
L1500-TS	15	162	112	50	12.5	8	●
L1600-TS	16	170	120	52	12.5	8	●

Cutting Condition D201

- Reamers above diameter 5mm have a tang back-end design
- TiAlN coated reamer is available on request
- Special diameters are available on request

●: Standard item

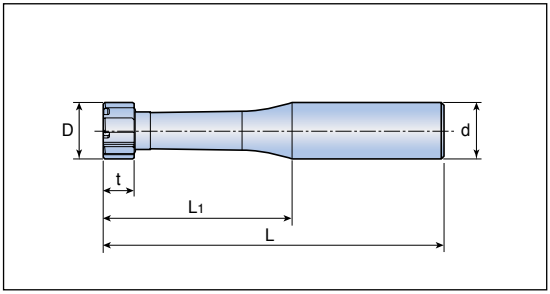
TaeguTec

Head changeable reamer



• Cylindrical shank





Designation	D range	Head size	Dimension (mm)				Overhang
			d	t	L	L1	
TM- 3B5-16T0	11.501-13.500	B5	16	9.3	97.8	49.8	
3B6-16T0	13.501-16.000	B6	16	9.4	105.4	57.4	
3B7-20T0	16.000-20.000	B7	20	10.6	120.6	70.6	3XD
3B8-20T0	20.001-25.400	B8	20	12.8	137.8	87.8	
3B9-32T0	25.401-32.000	B9	32	12.8	167.1	107.1	
5B5-16T0	11.501-13.500	B5	16	9.3	125.0	77.0	
5B6-16T0	13.501-16.000	B6	16	9.4	137.4	89.4	
5B7-20T0	16.000-20.000	B7	20	10.6	160.6	110.6	5XD
5B8-20T0	20.001-25.400	B8	20	12.8	187.8	137.8	
5B9-32T0	25.401-32.000	B9	32	12.8	231.1	171.1	
8B5-16T0	11.501-13.500	B5	16	9.3	165.5	117.5	
8B6-16T0	13.501-16.000	B6	16	9.4	185.4	137.4	
8B7-20T0	16.000-20.000	B7	20	10.6	220.6	170.6	8XD
8B8-20T0	20.001-25.400	B8	20	12.8	262.8	212.8	
8B9-32T0	25.401-32.000	B9	32	12.8	327.1	267.1	

D198

Cutting Condition
D202

• Clamping key & clamping screw are included

TM...KEY

TM-REAM

Clamping key

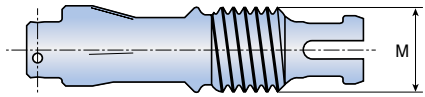


Designation	Clamping key	
	Head diameter range (mm)	Head size
TM - B5-KEY	11.501-13.500	B5
B6-KEY	13.501-16.000	B6
B7-KEY	16.001-20.000	B7
B8-KEY	20.001-25.400	B8
B9-KEY	25.401-32.000	B9

TM...SCR

TM-REAM

Clamping screw

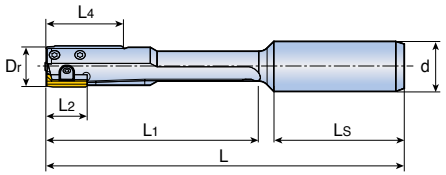


Designation	Clamping screw	
	Head diameter range (mm)	M
TM - B5-SCR	11.501-13.500	M5
B6-SCR	13.501-16.000	M6
B7-SCR	16.001-20.000	M7
B8-SCR	20.001-25.400	M8
B9-SCR	25.401-32.000	M9

TB-T...-T0

Indexable reamer holder





• For through hole



Designation	Dimension (mm)							Blade size
	Dr	L2	Ls	L1	L	L4	d	
TB- T08.000-S-16T0-1B	8	15.5	123.5	75	45	30	16	1
T09.000-S-16T0-1B	9	15.5	123.5	75	45	30	16	1
T10.000-S-16T0-2B	10	15.5	123.5	75	45	30	16	2
T11.000-S-16T0-2B	11	15.5	123.5	75	45	30	16	2
T12.000-S-16T0-3B	12	17.0	135	85	45	30	16	3
T13.000-S-16T0-3B	13	17.0	135	85	45	30	16	3
T14.000-S-16T0-3B	14	17.0	135	85	45	30	16	3
T15.000-S-16T0-3B	15	17.0	135	85	45	30	16	3
T16.000-S-20T0-3B	16	17.0	165	110	50	30	20	3
T17.000-S-20T0-3B	17	17.0	165	110	50	30	20	3
T18.000-S-20T0-3B	18	17.0	165	110	50	30	20	3
T19.000-S-20T0-3B	19	17.0	165	110	50	30	20	3
T20.000-S-25T0-3B	20	17.0	171	110	56	30	25	3
T21.000-S-25T0-3B	21	17.0	171	110	56	30	25	3
T22.000-S-25T0-3B	22	17.0	191	130	56	30	25	3
T23.000-S-25T0-3B	23	17.0	191	130	56	30	25	3
T24.000-S-25T0-3B	24	17.0	191	130	56	30	25	3
T25.000-S-25T0-3B	25	17.0	191	130	56	30	25	3
T26.000-S-25T0-4B	26	22.5	221	160	56	30	25	4
T27.000-S-25T0-4B	27	22.5	221	160	56	30	25	4
T28.000-S-25T0-4B	28	22.5	221	160	56	30	25	4
T29.000-S-25T0-4B	29	22.5	221	160	56	30	25	4
T30.000-S-25T0-4B	30	22.5	221	160	56	30	25	4
T31.000-S-25T0-4B	31	22.5	221	160	56	30	25	4
T32.000-S-25T0-4B	32	22.5	221	160	56	30	25	4

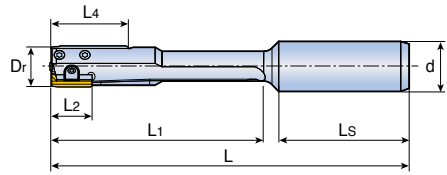
D200 Cutting Condition D206

TaeguTec Member IMC Group

TB-B...-T0

Indexable reamer holder





• For blind hole



Designation	Dimension (mm)							Blade size
	Dr	L2	Ls	L1	L	L4	d	
TB- B08.000-S-16T0-1B	8	15.5	123.5	75	45	30	16	1
B09.000-S-16T0-1B	9	15.5	123.5	75	45	30	16	1
B10.000-S-16T0-2B	10	15.5	123.5	75	45	30	16	2
B11.000-S-16T0-2B	11	15.5	123.5	75	45	30	16	2
B12.000-S-16T0-3B	12	17.0	135	85	45	30	16	3
B13.000-S-16T0-3B	13	17.0	135	85	45	30	16	3
B14.000-S-16T0-3B	14	17.0	135	85	45	30	16	3
B15.000-S-16T0-3B	15	17.0	135	85	45	30	16	3
B16.000-S-20T0-3B	16	17.0	165	110	50	30	20	3
B17.000-S-20T0-3B	17	17.0	165	110	50	30	20	3
B18.000-S-20T0-3B	18	17.0	165	110	50	30	20	3
B19.000-S-20T0-3B	19	17.0	165	110	50	30	20	3
B20.000-S-25T0-3B	20	17.0	171	110	56	30	25	3
B21.000-S-25T0-3B	21	17.0	171	110	56	30	25	3
B22.000-S-25T0-3B	22	17.0	191	130	56	30	25	3
B23.000-S-25T0-3B	23	17.0	191	130	56	30	25	3
B24.000-S-25T0-3B	24	17.0	191	130	56	30	25	3
B25.000-S-25T0-3B	25	17.0	191	130	56	30	25	3
B26.000-S-25T0-4B	26	22.5	221	160	56	30	25	4
B27.000-S-25T0-4B	27	22.5	221	160	56	30	25	4
B28.000-S-25T0-4B	28	22.5	221	160	56	30	25	4
B29.000-S-25T0-4B	29	22.5	221	160	56	30	25	4
B30.000-S-25T0-4B	30	22.5	221	160	56	30	25	4
B31.000-S-25T0-4B	31	22.5	221	160	56	30	25	4
B32.000-S-25T0-4B	32	22.5	221	160	56	30	25	4



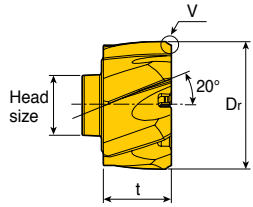


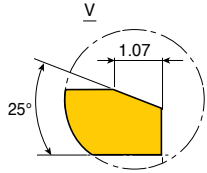
TaeguTec

D (mm)	Clamping wedge	Clamping screw	Adjustment screw	Adjustment pin	Blade size
					
8	WDG-TB-1	SR-CL-TB-1	SR-ADJ-M3x2.5	PIN-ADJ-TB-1	1
9	WDG-TB-1	SR-CL-TB-1	SR-ADJ-M3x3	PIN-ADJ-TB-1	1
10	WDG-TB-1	SR-CL-TB-2	SR-ADJ-M3x3	PIN-ADJ-TB-2	2
11	WDG-TB-1	SR-CL-TB-2	SR-ADJ-M3x4	PIN-ADJ-TB-2	2
12	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x4	PIN-ADJ-TB-3	3
13	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x4	PIN-ADJ-TB-3	3
14	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x4	PIN-ADJ-TB-3	3
15	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x6	PIN-ADJ-TB-3	3
16	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x6	PIN-ADJ-TB-3	3
17	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x8	PIN-ADJ-TB-3	3
18	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x8	PIN-ADJ-TB-3	3
19	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x8	PIN-ADJ-TB-3	3
20	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x10	PIN-ADJ-TB-3	3
21	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x10	PIN-ADJ-TB-3	3
22	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x10	PIN-ADJ-TB-3	3
23	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x10	PIN-ADJ-TB-3	3
24	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x10	PIN-ADJ-TB-3	3
25	WDG-TB-3	SR-CL-TB-3	SR-ADJ-M4x10	PIN-ADJ-TB-3	3
26	WDG-TB-4	SR-CL-TB-4	SR-ADJ-M4x10	PIN-ADJ-TB-4	4
27	WDG-TB-4	SR-CL-TB-4	SR-ADJ-M4x10	PIN-ADJ-TB-4	4
28	WDG-TB-4	SR-CL-TB-4	SR-ADJ-M4x10	PIN-ADJ-TB-4	4
29	WDG-TB-4	SR-CL-TB-4	SR-ADJ-M4x10	PIN-ADJ-TB-4	4
30	WDG-TB-4	SR-CL-TB-4	SR-ADJ-M4x10	PIN-ADJ-TB-4	4
31	WDG-TB-4	SR-CL-TB-4	SR-ADJ-M4x10	PIN-ADJ-TB-4	4
32	WDG-TB-4	SR-CL-TB-4	SR-ADJ-M4x10	PIN-ADJ-TB-4	4

TM...-BL

Head changeable reamer head





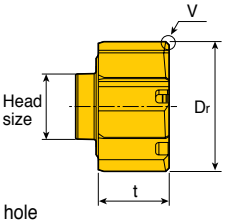
- Left-handed flute for through hole
- For H7 hole tolerance

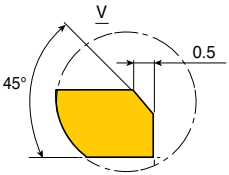
Head	Designation	Dimension (mm)		Flute	Head size	Flute type	Edge type	Grade
		Dr	t					TT9030
	TM - 11.501-BL-B5	11.501	9.3	6	B5	L	B	●
	12.000-BL-B5	12.000	9.3	6	B5	L	B	●
	13.000-BL-B5	13.000	9.3	6	B5	L	B	●
	13.500-BL-B5	13.500	9.3	6	B5	L	B	●
	13.501-BL-B6	13.501	9.4	6	B6	L	B	●
	14.000-BL-B6	14.000	9.4	6	B6	L	B	●
	15.000-BL-B6	15.000	9.4	6	B6	L	B	●
	16.000-BL-B6	16.000	9.4	6	B6	L	B	●
	16.001-BL-B7	16.001	10.6	6	B7	L	B	●
	17.000-BL-B7	17.000	10.6	6	B7	L	B	●
	18.000-BL-B7	18.000	10.6	6	B7	L	B	●
	19.000-BL-B7	19.000	10.6	6	B7	L	B	●
	20.000-BL-B7	20.000	10.6	6	B7	L	B	●
	20.001-BL-B8	20.001	12.8	8	B8	L	B	●
	21.000-BL-B8	21.000	12.8	8	B8	L	B	●
	22.000-BL-B8	22.000	12.8	8	B8	L	B	●
	23.000-BL-B8	23.000	12.8	8	B8	L	B	●
	24.000-BL-B8	24.000	12.8	8	B8	L	B	●
	25.000-BL-B8	25.000	12.8	8	B8	L	B	●
	26.000-BL-B9	26.000	12.8	8	B9	L	B	●
	27.000-BL-B9	27.000	12.8	8	B9	L	B	●
	28.000-BL-B9	28.000	12.8	8	B9	L	B	●
	29.000-BL-B9	29.000	12.8	8	B9	L	B	●
	30.000-BL-B9	30.000	12.8	8	B9	L	B	●
	31.000-BL-B9	31.000	12.8	8	B9	L	B	●
	32.000-BL-B9	32.000	12.8	8	B9	L	B	●

●: Standard item



Head changeable reamer head





- Straight flute for blind hole
- For H7 hole tolerance

Head	Designation	Dimension (mm)		Flute	Head size	Flute type	Edge type	Grade
		Dr	t					TT9030
	TM- 11.501-AS-B5	11.501	9.3	6	B5	S	A	●
	12.000-AS-B5	12.000	9.3	6	B5	S	A	●
	13.000-AS-B5	13.000	9.3	6	B5	S	A	●
	13.500-AS-B5	13.500	9.3	6	B5	S	A	●
	13.501-AS-B6	13.501	9.4	6	B6	S	A	●
	14.000-AS-B6	14.000	9.4	6	B6	S	A	●
	15.000-AS-B6	15.000	9.4	6	B6	S	A	●
	16.000-AS-B6	16.000	9.4	6	B6	S	A	●
	16.001-AS-B7	16.001	10.6	6	B7	S	A	●
	17.000-AS-B7	17.000	10.6	6	B7	S	A	●
	18.000-AS-B7	18.000	10.6	6	B7	S	A	●
	19.000-AS-B7	19.000	10.6	6	B7	S	A	●
	20.000-AS-B7	20.000	10.6	6	B7	S	A	●
	20.001-AS-B8	20.001	12.8	8	B8	S	A	●
	21.000-AS-B8	21.000	12.8	8	B8	S	A	●
	22.000-AS-B8	22.000	12.8	8	B8	S	A	●
	23.000-AS-B8	23.000	12.8	8	B8	S	A	●
	24.000-AS-B8	24.000	12.8	8	B8	S	A	●
	25.000-AS-B8	25.000	12.8	8	B8	S	A	●
	26.000-AS-B9	26.000	12.8	8	B9	S	A	●
	27.000-AS-B9	27.000	12.8	8	B9	S	A	●
	28.000-AS-B9	28.000	12.8	8	B9	S	A	●
	29.000-AS-B9	29.000	12.8	8	B9	S	A	●
	30.000-AS-B9	30.000	12.8	8	B9	S	A	●
	31.000-AS-B9	31.000	12.8	8	B9	S	A	●
	32.000-AS-B9	32.000	12.8	8	B9	S	A	●

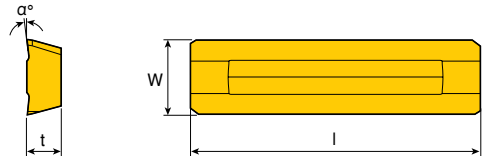
●: Standard item

D193

TaeguTec

TB Blade

Head changeable reamer head



• For H6 hole tolerance

Insert	Designation	Dimension (mm)				Blade size	Lead type	Grades	
		Rake angle (α°)	l	W	t			TT5030	TT5050
	**TB- 1B06**	6	15.5	2.8	1.5	1	B	●	
	1B12	12	15.5	2.8	1.5	1	B	●	
	1A06	6	15.5	2.8	1.5	1	A		●
	1B06	6	15.5	2.8	1.5	1	B		●
	2B06	6	15.5	3.6	1.5	2	B	●	
	2B12	12	15.5	3.6	1.5	2	B	●	
	2A06	6	15.5	3.6	1.5	2	A		●
	2B06	6	15.5	3.6	1.5	2	B		●
	3B06	6	17.0	4.4	2.0	3	B	●	
	3B12	12	17.0	4.4	2.0	3	B	●	
	3A06	6	17.0	4.4	2.0	3	A		●
	3B06	6	17.0	4.4	2.0	3	B		●
	4B06	6	22.5	6.6	3.0	4	B	●	
	4B12	12	22.5	6.6	3.0	4	B	●	
	4A06	6	22.5	6.6	3.0	4	A		●
	4B06	6	22.5	6.6	3.0	4	B		●



• Grades application
-TT5030: TiAlN coating for steel(P) and stainless steel(M)
-TT5050: TiCN + TiN coating for cast iron(K)

●: Standard item

Recommended Cutting Conditions

TS-REAM

Machining data for TS-REAM

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc(m/min)	Feed (mm/rev)	
								3-10	10.1-16
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	10-20	0.15-0.25	0.20-0.40
		>=0.25%C	Annealed	650	190	2	6-15	0.12-0.15	0.15-0.30
		<0.55%C	Quenched and tempered	850	250	3	6-20	0.15-0.25	0.20-0.35
		>=0.55%C	Annealed	750	220	4	6-15	0.15-0.25	0.20-0.35
			Quenched and tempered	1000	300	5	6-15	0.15-0.25	0.20-0.35
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	6-15	0.12-0.20	0.15-0.30
			Quenched and tempered	930	275	7	6-20	0.15-0.25	0.20-0.35
				1000	300	8	6-15	0.15-0.25	0.20-0.35
				1200	350	9	6-15	0.15-0.25	0.20-0.35
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	6-15	0.12-0.20	0.15-0.30
			Quenched and tempered	1100	325	11	6-15	0.12-0.20	0.15-0.30
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12			
			Martensitic	820	240	13			
			Austenitic	600	180	14			
K	Gray cast iron (GG)		Ferritic		160	15	10-25	0.20-0.30	0.30-0.45
			Pearlitic		250	16	10-25	0.20-0.30	0.30-0.45
	Cast iron nodular (GGG)		Ferritic		180	17	10-20	0.15-0.25	0.20-0.35
			Pearlitic		260	18	10-20	0.15-0.25	0.20-0.35
	Malleable cast iron		Ferritic		130	19	8-15	0.15-0.25	0.20-0.40
			Pearlitic		230	20	8-15	0.15-0.25	0.20-0.40
N	Aluminum - Wrought alloy		Not cureable		60	21	10-30	0.20-0.30	0.30-0.50
			Cured		100	22	10-30	0.20-0.30	0.30-0.50
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	10-30	0.20-0.30	0.30-0.50
			Cured		90	24	10-30	0.20-0.30	0.30-0.50
		>12% Si	High temp.		130	25	30-60	0.20-0.30	0.30-0.50
	Copper alloys	>1% Pb	Free cutting		110	26	20-60	0.30-0.60	0.40-0.80
			Brass		90	27	20-60	0.30-0.60	0.40-0.80
			Electrolitic copper		100	28	20-60	0.30-0.60	0.40-0.80
	Non-metallic		Duroplastics, fiber plastics			29	15-30	0.30-0.60	0.40-0.80
			Hard rubber			30	15-30	0.30-0.60	0.40-0.80
S	High temp. alloys	Fe based	Annealed		200	31			
			Cured		280	32			
		Ni or Co based	Annealed		250	33			
			Cured		350	34			
			Cast		320	35			
	Titanium, Ti alloys			Rm 400		36	6-15	0.12-0.20	0.15-0.30
			Alpha+beta alloys cured	Rm 1050		37	6-15	0.12-0.20	0.15-0.30
H	Hardened steel		Hardened		55HRC	38			
			Hardened		60HRC	39			
	Chilled cast iron		Cast		400	40			
	Cast iron nodular		Hardened		55HRC	41			

• For more information of material groups, see the materials & grades "material conversion table"

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

TaeguTec Member IMC Group

Recommended Cutting Conditions

TM-REAM

Machining data for TM-REAM - Through hole

ISO	Material		Condition	Material No.	Through hole		Interrupted through Hole	
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	1	TT9030	BL	TT9030	BL
		>=0.25%C	Annealed	2	Vc = 80 - 200		Vc = 60 - 120	
		<0.55%C	Quenched and tempered	3	B4 - B6	fz = 0.08 - 0.21	B4 - B6	fz = 0.08 - 0.21
		>=0.55%C	Annealed	4				
			Quenched and tempered	5	B7 - B9	fz = 0.12 - 0.27	B7 - B9	fz = 0.09 - 0.21
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	6	TT9030	BL	TT9030	BL
			Quenched and tempered	7	Vc = 80 - 200		Vc = 60 - 120	
				8	B4 - B6	fz = 0.08 - 0.21	B4 - B6	fz = 0.08 - 0.21
				9	B7 - B9	fz = 0.12 - 0.27	B7 - B9	fz = 0.09 - 0.21
	High alloy steel, cast steel and tool steel		Annealed	10	TT9030	BL	TT9030	BL
					Vc = 20 - 60		Vc = 20 - 60	
			Quenched and tempered	11	B4 - B6	fz = 0.05 - 0.13	B4 - B6	fz = 0.04 - 0.11
					B7 - B9	fz = 0.07 - 0.17	B7 - B9	fz = 0.05 - 0.14
M	Stainless steel and cast steel		Ferritic / martensitic	12	TT9030	BL	TT9030	BL
					Vc = 20 - 40		Vc = 20 - 40	
			Martensitic	13	B4 - B6	fz = 0.05 - 0.13	B4 - B6	fz = 0.04 - 0.11
			Austenitic	14	B7 - B9	fz = 0.07 - 0.17	B7 - B9	fz = 0.05 - 0.14
K	Gray cast iron (GG)		Ferritic	15	TT9030	BL	TT9030	BL
					Vc = 120 - 220		Vc = 80 - 200	
			Pearlitic	16	B4 - B6	fz = 0.08 - 0.18	B4 - B6	fz = 0.05 - 0.13
					B7 - B9	fz = 0.10 - 0.24	B7 - B9	fz = 0.07 - 0.17
	Cast iron nodular (GGG)		Ferritic	17	TT9030	AS or BL	TT9030	BL
					Vc = 160 - 280		Vc = 150 - 250	
			Pearlitic	18	B4 - B6	fz = 0.11 - 0.20	B4 - B6	fz = 0.06 - 0.15
					B7 - B9	fz = 0.11 - 0.24	B7 - B9	fz = 0.08 - 0.19
	Malleable cast iron		Ferritic	19	TT9030	AS or BL	TT9030	BL
					Vc = 100 - 220		Vc = 100 - 220	
			Pearlitic	20	B4 - B6	fz = 0.11 - 0.20	B4 - B6	fz = 0.06 - 0.15
					B7 - B9	fz = 0.11 - 0.24	B7 - B9	fz = 0.08 - 0.20

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

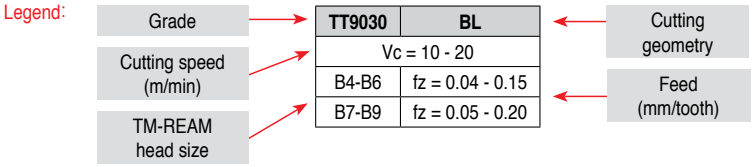
TM-REAM

Machining data for TM-REAM - Through hole

ISO	Material		Condition	Material No.	Through hole		Interrupted through Hole	
N	Aluminum - Wrought alloy		Not cureable	21	B7 - B9	BL or GS	TTAL10	BL
			Cured	22	Vc = 150 - 400		Vc = 150 - 400	
	Aluminum-cast, alloyed	<=12% Si	Not cureable	23	B4 - B6	fz = 0.08 - 0.16	B4 - B6	fz = 0.08 - 0.16
			Cured	24				
		>12% Si	High temp.	25	B7 - B9	fz = 0.10 - 0.20	B7 - B9	fz = 0.10 - 0.20
	Copper alloys	>1% Pb	Free cutting	26	TT9030	BL	TT9030	BL
					Vc = 50 - 200		Vc = 50 - 200	
			Brass	27	B4 - B6	fz = 0.08 - 0.18	B4 - B6	fz = 0.05 - 0.13
			Electrolitic copper	28	B7 - B9	fz = 0.10 - 0.23	B7 - B9	fz = 0.07 - 0.16
	Non-metallic		Duroplastics, fiber plastics	29	TT9030	AS	TT9030	AS
					Vc = 25 - 80		Vc = 25 - 80	
			Hard rubber	30	B4 - B6	fz = 0.05 - 0.10	B4 - B6	fz = 0.05 - 0.10
					B7 - B9	fz = 0.10 - 0.20	B7 - B9	fz = 0.10 - 0.20
S	High temp. alloys	Fe based	Annealed	31	TT9030	L *	TT9030	L *
			Cured	32	Vc = 15 - 50		Vc = 15 - 50	
		Ni or Co based	Annealed	33				
			Cured	34	B4 - B6	fz = 0.04 - 0.10	B4 - B6	fz = 0.03 - 0.08
			Cast	35				
	Titanium, Ti alloys			36	B7 - B9	fz = 0.05 - 0.13	B4 - B6	fz = 0.04 - 0.11
			Alpha+beta alloys cured	37				
H	Hardened steel		Hardened	38	TT9030	BL	TT9030	BL
			Hardened	39	Vc = 25 - 50		Vc = 25 - 50	
	Chilled cast iron		Cast	40	B4 - B6	fz = 0.06 - 0.15	B4 - B6	fz = 0.06 - 0.15
	Cast iron nodular		Hardened	41	B7 - B9	fz = 0.10 - 0.20	B7 - B9	fz = 0.10 - 0.20

* Standard edge geometries are not suitable for reaming titanium and high temperature alloys.
In order to choose a proper geometry, please ask for our recommendations.

- The given cutting data recommendations refer to the short holders (3xD effective reaming overhang). For longer holders, the cutting speed to be reduced proportionally.
- For relatively large leading angles (spot-facing geometries), the feed to be reduced up to 30%.
- All the given cutting data recommendations refer to the machines with spindle through coolant supply.



Recommended Cutting Conditions

TM-REAM

Machining data for TM-REAM - Blind hole

ISO	Material		Condition	Material No.	Blind hole		Interrupted blind hole	
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	1	TT9030	AS	TT9030	AS
		>=0.25%C	Annealed	2	Vc = 60-160		Vc = 60 - 120	
		<0.55%C	Quenched and tempered	3	B4 - B6	fz = 0.06 - 0.18	B4 - B6	fz = 0.05 - 0.15
		>=0.55%C	Annealed	4				
			Quenched and tempered	5	B7 - B9	fz = 0.08 - 0.20	B7 - B9	fz = 0.07 - 0.16
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	6	TT9030	AS	TT9030	AS
			Quenched and tempered	7	Vc = 60-160		Vc = 60 - 120	
				8	B4 - B6	fz = 0.06 - 0.18	B4 - B6	fz = 0.05 - 0.15
				9	B7 - B9	fz = 0.08 - 0.20	B7 - B9	fz = 0.07 - 0.16
	High alloy steel, cast steel and tool steel		Annealed	10	TT9030	AS	TT9030	AS
					Vc = 20 - 60		Vc = 20 - 60	
			Quenched and tempered	11	B4 - B6	fz = 0.04 - 0.10	B4 - B6	fz = 0.03 - 0.08
					B7 - B9	fz = 0.05 - 0.13	B7 - B9	fz = 0.04 - 0.10
M	Stainless steel and cast steel		Ferritic / martensitic	12	TT9030	AS	TT9030	AS
					Vc = 20 - 40		Vc = 20 - 40	
			Martensitic	13	B4 - B6	fz = 0.04 - 0.10	B4 - B6	fz = 0.03 - 0.08
			Austenitic	14	B7 - B9	fz = 0.05 - 0.13	B7 - B9	fz = 0.05 - 0.10
K	Gray cast iron (GG)		Ferritic	15	TT9030	AS	TT9030	AS
					Vc = 80 - 200		Vc = 60 - 120	
			Pearlitic	16	B4 - B6	fz = 0.06 - 0.18	B4 - B6	fz = 0.05 - 0.13
					B7 - B9	fz = 0.08 - 0.23	B7 - B9	fz = 0.08 - 0.18
	Cast iron nodular (GGG)		Ferritic	17	TT9030	AS	TT9030	AS
					Vc = 160 - 280		Vc = 160 - 240	
			Pearlitic	18	B4 - B6	fz = 0.06 - 0.18	B4 - B6	fz = 0.06 - 0.16
					B7 - B9	fz = 0.08 - 0.23	B7 - B9	fz = 0.08 - 0.18
	Malleable cast iron		Ferritic	19	TT9030	AS	TT9030	AS
					Vc = 100 - 220		Vc = 100 - 220	
			Pearlitic	20	B4 - B6	fz = 0.06 - 0.18	B4 - B6	fz = 0.05 - 0.15
					B7 - B9	fz = 0.08 - 0.23	B7 - B9	fz = 0.08 - 0.20

• For more information of material groups, see the materials & grades "material conversion table"

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

Recommended Cutting Conditions

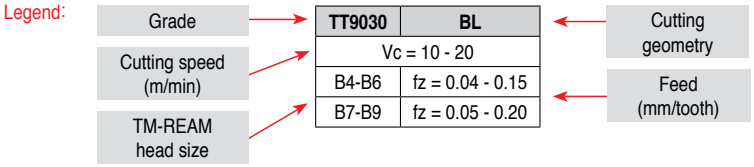
TM-REAM

Machining data for TM-REAM - Blind hole

ISO	Material		Condition	Material No.	Blind hole		Interrupted blind hole	
N	Aluminum - Wrought alloy		Not cureable	21	TTAL10	GS or AS	TTAL10	GS or AS
			Cured	22	Vc = 150 - 400		Vc = 150 - 300	
	Aluminum-cast, alloyed	<=12% Si	Not cureable	23	B4 - B6	fz = 0.08 - 0.16	B4 - B6	fz = 0.07 - 0.15
			Cured	24				
		>12% Si	High temp.	25	B7 - B9	fz = 0.11 - 0.20	B7 - B9	fz = 0.11 - 0.20
	Copper alloys	>1% Pb	Free cutting	26	TT9030	AS	TT9030	AS
					Vc = 50 - 200		Vc = 50 - 200	
			Brass	27	B4 - B6	fz = 0.08 - 0.16	B4 - B6	fz = 0.08 - 0.16
			Electrolitic copper	28	B7 - B9	fz = 0.10 - 0.20	B7 - B9	fz = 0.10 - 0.20
	Non-metallic		Duroplastics, fiber plastics	29	TT9030	AS	TT9030	AS
					Vc = 25 - 80		Vc = 25 - 80	
			Hard rubber	30	B4 - B6	fz = 0.05 - 0.10	B4 - B6	fz = 0.05 - 0.10
					B7 - B9	fz = 0.10 - 0.20	B7 - B9	fz = 0.10 - 0.20
S	High temp. alloys	Fe based	Annealed	31	TT9030	L *	TT9030	L *
			Cured	32	Vc = 15 - 50		Vc = 15 - 50	
		Ni or Co based	Annealed	33				
			Cured	34	B4 - B6	fz = 0.03 - 0.08	B4 - B6	fz = 0.03 - 0.08
			Cast	35				
	Titanium, Ti alloys			36	B7 - B9	fz = 0.04 - 0.11	B7 - B9	fz = 0.04 - 0.11
			Alpha+beta alloys cured	37				
H	Hardened steel		Hardened	38	TT9030	AS	TT9030	AS
			Hardened	39	Vc = 25 - 50		Vc = 25 - 50	
	Chilled cast iron		Cast	40	B4 - B6	fz = 0.05 - 0.13	B4 - B6	fz = 0.05 - 0.13
	Cast iron nodular		Hardened	41	B7 - B9	fz = 0.10 - 0.20	B7 - B9	fz = 0.10 - 0.20

* Standard edge geometries are not suitable for reaming titanium and high temperature alloys.
In order to choose a proper geometry, please ask for our recommendations.

- The given cutting data recommendations refer to the short holders (3xD effective reaming overhang). For longer holders, the cutting speed to be reduced proportionally.
- For relatively large leading angles (spot-facing geometries), the feed to be reduced up to 30%.
- All the given cutting data recommendations refer to the machines with spindle through coolant supply.



Recommended Cutting Conditions

Machining data for TB-REAM

ISO	Material	Material No.	Lead A (15°/3°) (Reaming allowance: 0.1 ~ 0.3) Feed (mm/rev)	Rake (°)	Cutting speed Vc (m/min) Carbide	Coated carbide	Cermet	PCD	CBN
P	Non-alloy steel and cast steel, free cutting steel	1 - 5	0.1-0.4	6	40-60	60-80	110-160		
P	Low alloy steel and cast steel (Less than 5% of alloying elements)	6 - 9	0.1-0.4	6	20-40	40-60	110-160		
P	High alloyed steel, cast steel and tool steel	10 - 11	0.1-0.4	6	20-40	20-60	20-60		
M	Stainless steel, cast steel	12 - 14	0.1-0.3	12	20-40	40-60	20-60		
K	Grey cast iron (GG)	15 - 16	0.1-0.3	0 / 6	40-60	60-100			Please ask
K	Cast iron nodular (GGG)	17 - 18	0.1-0.3	0 / 6	40-60	60-100			
K	Malleable cast iron	19 - 20	0.1-0.3	0 / 6	40-60	60-100			
N	Aluminum wrought alloy	21 - 22						Please ask	
N	Aluminum-cast,alloyed	23 - 25							
N	Copper alloys	26 - 28							
N	Non-metallic	29 - 30							

ISO	Material	Material No.	Lead C (75°) (Reaming allowance: 0.2 ~ 0.4) Feed (mm/rev)	Rake (°)	Cutting speed Vc (m/min) Carbide	Coated carbide	Cermet	PCD	CBN
P	Non-alloy steel and cast steel, free cutting steel	1 - 5							
P	Low alloy steel and cast steel (Less than 5% of alloying elements)	6 - 9							
P	High alloyed steel, cast steel and tool steel	10 - 11							
M	Stainless steel, cast steel	12 - 14							
K	Grey cast iron (GG)	15 - 16							Please ask
K	Cast iron nodular (GGG)	17 - 18							
K	Malleable cast iron	19 - 20							
N	Aluminum wrought alloy	21 - 22	0.15-0.3	12	150-250			Please ask	
N	Aluminum-cast,alloyed	23 - 25	0.15-0.3	12	150-250				
N	Copper alloys	26 - 28							
N	Non-metallic	29 - 30							

- The cutting conditions in the table below should be used to start a new application. Optimal conditions for a specific application should be evaluated by examining the results and changing the machining conditions accordingly.

- For more information of material groups, see the materials & grades "material conversion table"

Steel Stainless steel Cast iron Nonferrous

Recommended Cutting Conditions

TB-REAM

Machining data for TB-REAM

			Lead B (30°/3°) (Reaming allowance: 0.1 ~ 0.3)						
			Feed (mm/rev)	Rake (°)	Cutting speed Vc (m/min)				
ISO	Material	Material No.			Carbide	Coated carbide	Cermet	PCD	CBN
P	Non-alloy steel and cast steel, free cutting steel	1 - 5	0.1-0.4	6	60-80	80-120	110-160		
P	Low alloy steel and cast steel (Less than 5% of alloying elements)	6 - 9	0.1-0.4	6	60-80	80-120	110-160		
P	High alloyed steel, cast steel and tool steel	10 - 11	0.1-0.4	6	40-60	40-80	40-80		
M	Stainless steel, cast steel	12 - 14	0.1-0.3	12	40-60	60-80	60-80		
K	Grey cast iron (GG)	15 - 16	0.1-0.3	0 / 6	60-80	80-120			Please ask
K	Cast iron nodular (GGG)	17 - 18	0.1-0.3	0 / 6	60-80	80-120			
K	Malleable cast iron	19 - 20	0.1-0.3	0 / 6	60-80	80-120			
N	Aluminum wrought alloy	21 - 22		12	160-200			Please ask	
N	Aluminum-cast,alloyed	23 - 25		12	160-200				
N	Copper alloys	26 - 28		0	80-100				
N	Non-metallic	29 - 30		0	10-70				

			Lead D (30°/3°) (Reaming allowance: 0.1 ~ 0.2)						
			Feed (mm/rev)	Rake (°)	Cutting speed Vc (m/min)				
ISO	Material	Material No.			Carbide	Coated carbide	Cermet	PCD	CBN
P	Non-alloy steel and cast steel, free cutting steel	1 - 5	0.1-0.4	6	60-80	80-120	110-160		
P	Low alloy steel and cast steel (Less than 5% of alloying elements)	6 - 9	0.1-0.4	6	60-80	80-120	110-160		
P	High alloyed steel, cast steel and tool steel	10 - 11	0.1-0.4	6	40-60	40-80	40-80		
M	Stainless steel, cast steel	12 - 14	0.1-0.3	12	40-60	60-80	60-80		
K	Grey cast iron (GG)	15 - 16	0.1-0.3	0 / 6	60-80	80-120			Please ask
K	Cast iron nodular (GGG)	17 - 18	0.1-0.3	0 / 6	60-80	80-120			
K	Malleable cast iron	19 - 20	0.1-0.3	0 / 6	60-80	80-120			
N	Aluminum wrought alloy	21 - 22		12	110-200			Please ask	
N	Aluminum-cast,alloyed	23 - 25		12	160-200				
N	Copper alloys	26 - 28		0	80-100				
N	Non-metallic	29 - 30							

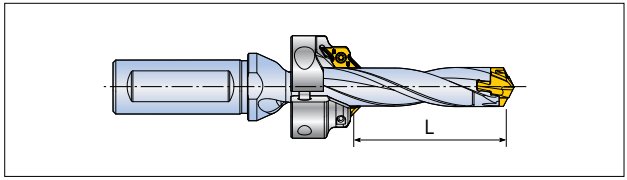
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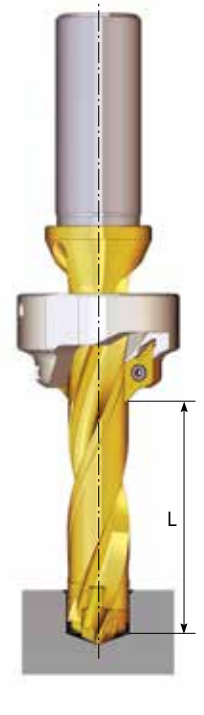
Steel Stainless steel Cast iron Nonferrous

TaeguTec Member IMC Group

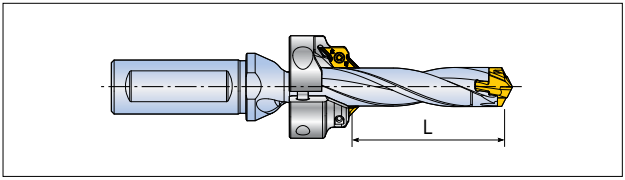
Chamfering ring designation - DRILLRUSH



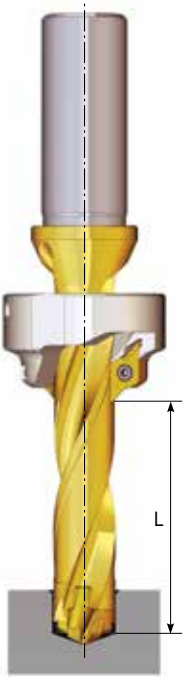
	Designation	CFR designation	L	
			min	max
3D	TCD 130-134-16T3/S0-3D	CFR D130-A45	19	19
	135-139-16T3/S0-3D	CFR D135-A45	19	20
	140-144-16T3/S0-3D	CFR D140-A45	21	22
	145-149-16T3/S0-3D	CFR D145-A45	22	23
	150-159-20T3/S0-3D	CFR D150-A45	23	23
	160-169-20T3/S0-3D	CFR D160-A45	24	25
	170-179-20T3/S0-3D	CFR D170-A45	26	28
	180-189-25T2/S0-3D	CFR D180-A45	27	30
	190-199-25T2/S0-3D	CFR D190-A45	29	33
	200-209-25T2/S0-3D	CFR D200-A45	30	36
	210-219-25T2/S0-3D	CFR D210-A45	32	39
	220-229-25T2/S0-3D	CFR D220-A45	33	42
	230-239-32T2/S0-3D	CFR D230-A45	35	45
	240-249-32T2/S0-3D	CFR D240-A45	36	48
	250-259-32T2/S0-3D	CFR D250-A45	38	51
5D	TCD 100-104-16T3/S0-5D	CFR D100-A45	28	28
	105-109-16T3/S0-5D	CFR D105-A45	29	30
	110-114-16T3/S0-5D	CFR D110-A45	31	33
	115-119-16T3/S0-5D	CFR D115-A45	32	35
	120-124-16T3/S0-5D	CFR D120-A45	33	45
	125-129-16T3/S0-5D	CFR D125-A45	34	40
	130-134-16T3/S0-5D	CFR D130-A45	36	43
	135-139-16T3/S0-5D	CFR D135-A45	37	43
	140-144-16T3/S0-5D	CFR D140-A45	38	48
	145-149-16T3/S0-5D	CFR D145-A45	39	48
	150-159-20T3/S0-5D	CFR D150-A45	41	53
	160-169-20T3/S0-5D	CFR D160-A45	43	58
	170-179-20T3/S0-5D	CFR D170-A45	46	63
	180-189-25T2/S0-5D	CFR D180-A45	48	68
	190-199-25T2/S0-5D	CFR D190-A45	51	73
	200-209-25T2/S0-5D	CFR D200-A45	53	78
	210-219-25T2/S0-5D	CFR D210-A45	56	79
	220-229-25T2/S0-5D	CFR D220-A45	58	84
	230-239-32T2/S0-5D	CFR D230-A45	61	89
	240-249-32T2/S0-5D	CFR D240-A45	63	94
	250-259-32T2/S0-5D	CFR D250-A45	66	99



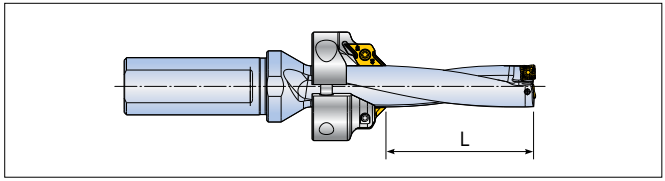
Chamfering ring designation - DRILLRUSH



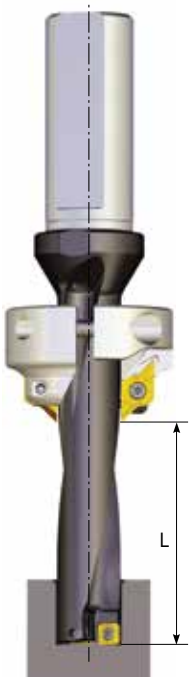
	Designation		CFR designation	L	
				min	max
8D	TCD	100-104-16T3/S0-8D	CFR D100-A45	45	58
		105-109-16T3/S0-8D	CFR D105-A45	49	62
		110-114-16T3/S0-8D	CFR D110-A45	49	66
		115-119-16T3/S0-8D	CFR D115-A45	53	70
		120-124-16T3/S0-8D	CFR D120-A45	53	74
		125-129-16T3/S0-8D	CFR D125-A45	57	78
		130-134-16T3/S0-8D	CFR D130-A45	57	82
		135-139-16T3/S0-8D	CFR D135-A45	61	84
		140-144-16T3/S0-8D	CFR D140-A45	61	88
		145-149-16T3/S0-8D	CFR D145-A45	65	92
		150-159-20T3/S0-8D	CFR D150-A45	65	96
		160-169-20T3/S0-8D	CFR D160-A45	69	103
		170-179-20T3/S0-8D	CFR D170-A45	73	111
		180-189-25T2/S0-8D	CFR D180-A45	77	118
		190-199-25T2/S0-8D	CFR D190-A45	81	126
		200-209-25T2/S0-8D	CFR D200-A45	85	134
		210-219-25T2/S0-8D	CFR D210-A45	89	142
		220-229-25T2/S0-8D	CFR D220-A45	93	150
		230-239-32T2/S0-8D	CFR D230-A45	97	158
		240-249-32T2/S0-8D	CFR D240-A45	101	166
		250-259-32T2/S0-8D	CFR D250-A45	105	174
12D	TCD	120-124-16S0-12D	CFR D120-A45	87	121
		125-129-16S0-12D	CFR D125-A45	90	127
		130-134-16S0-12D	CFR D130-A45	93	133
		135-139-16S0-12D	CFR D135-A45	96	137
		140-144-16S0-12D	CFR D140-A45	99	143
		145-149-16S0-12D	CFR D145-A45	102	149
		150-159-20S0-12D	CFR D150-A45	105	155
		160-169-20S0-12D	CFR D160-A45	111	166
		170-179-20S0-12D	CFR D170-A45	117	178
		180-189-25S0-12D	CFR D180-A45	123	189
		190-199-25S0-12D	CFR D190-A45	129	201
		200-209-25S0-12D	CFR D200-A45	135	213
		210-219-25S0-12D	CFR D210-A45	141	225
		220-229-25S0-12D	CFR D220-A45	147	237



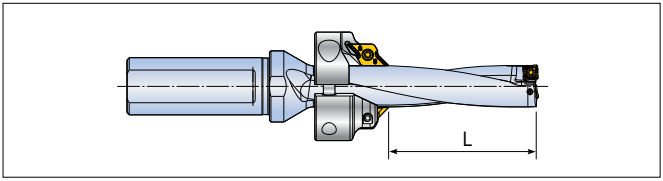
Chamfering ring designation - TOPDRILL and T-DRILL



	TOPDRILL	T-DRILL	CFR designation	L	
				min	max
3D	TOP -	TDR 3125-20T2-05	CFR D125-A45	16	16
	-	3130-20T2-05	CFR D130-A45	16	16
	-	3135-20T2-05	CFR D135-A45	17	18
	3140-20T2-05	3140-20T2-05	CFR D140-A45	17	18
	3145-20T2-05	3145-20T2-05	CFR D145-A45	18	19
	3150-20T2-05	3150-20T2-05	CFR D150-A45	18	19
	3155-20T2-05	3155-25T2-06	CFR D160-A45	19	21
	3160-20T2-05	3160-25T2-06	CFR D160-A45	19	21
	3165-25T2-06	3165-25T2-06	CFR D170-A45	21	24
	3170-25T2-06	3170-25T2-06	CFR D170-A45	22	24
	3175-25T2-06	3175-25T2-06	CFR D180-A45	23	27
	3180-25T2-06	3180-25T2-06	CFR D180-A45	23	26
	3185-25T2-06	3185-25T2-06	CFR D180-A45	24	29
	3190-25T2-06	3190-25T2-06	CFR D190-A45	25	29
	3195-25T2-07	3195-25T2-06	CFR D190-A45	25	32
	3200-25T2-07	3200-25T2-06	CFR D200-A45	26	32
	3205-25T2-07	3205-25T2-06	CFR D200-A45	27	35
	3210-25T2-07	3210-25T2-06	CFR D210-A45	27	35
	3215-25T2-07	3215-25T2-07	CFR D210-A45	28	38
	3220-25T2-07	3220-25T2-07	CFR D220-A45	29	38
	3225-25T2-08	3225-25T2-07	CFR D220-A45	29	41
	3230-25T2-08	3230-25T2-07	CFR D230-A45	30	41
	3235-25T2-08	3235-25T2-07	CFR D230-A45	31	44
	3240-25T2-08	3240-25T2-07	CFR D240-A45	31	44
	3245-25T2-08	3245-25T2-07	CFR D240-A45	32	47
	3250-25T2-08	3250-25T2-07	CFR D250-A45	33	47



Chamfering ring designation - TOPDRILL and T-DRILL



	TOPDRILL		T-DRILL		CFR designation	L	
						min	max
4D	TOP	-	TDR	4125-20T2-05	CFR D125-A45	25	26
		-		4130-20T2-05	CFR D130-A45	25	26
		-		4135-20T2-05	CFR D135-A45	27	30
		4140-20T2-05		4140-20T2-05	CFR D140-A45	28	30
		4145-20T2-05		4145-20T2-05	CFR D145-A45	29	34
		4150-20T2-05		4150-20T2-05	CFR D150-A45	30	34
		4155-20T2-05		4155-25T2-06	CFR D160-A45	31	37
		4160-20T2-05		4160-25T2-06	CFR D160-A45	32	37
		4165-25T2-06		4165-25T2-06	CFR D170-A45	33	41
		4170-25T2-06		4170-25T2-06	CFR D170-A45	34	41
		4175-25T2-06		4175-25T2-06	CFR D180-A45	35	45
		4180-25T2-06		4180-25T2-06	CFR D180-A45	36	44
		4185-25T2-06		4185-25T2-06	CFR D180-A45	37	48
		4190-25T2-06		4190-25T2-06	CFR D190-A45	38	48
		4195-25T2-07		4195-25T2-06	CFR D190-A45	39	52
		4200-25T2-07		4200-25T2-06	CFR D200-A45	40	52
		4205-25T2-07		4205-25T2-06	CFR D200-A45	41	56
		4210-25T2-07		4210-25T2-06	CFR D210-A45	42	56
		4215-25T2-07		4215-25T2-07	CFR D210-A45	43	60
		4220-25T2-07		4220-25T2-07	CFR D220-A45	44	60
		4225-25T2-08		4225-25T2-07	CFR D220-A45	45	64
		4230-25T2-08		4230-25T2-07	CFR D230-A45	46	64
		4235-25T2-08		4235-25T2-07	CFR D230-A45	47	68
		4240-25T2-08		4240-25T2-07	CFR D240-A45	48	68
		4245-25T2-08		4245-25T2-07	CFR D240-A45	49	72
		4250-25T2-08		4250-25T2-07	CFR D250-A45	50	72



Hole tolerance

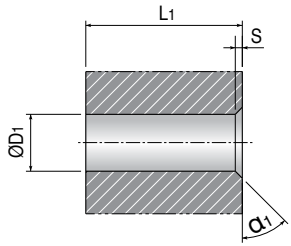
Diameter D(mm)		Tolerance (μm)															
>D	≤D	B10	C9	C10	D8	D9	D10	E7	E8	E9	F6	F7	F8	G6	G7	H6	H7
–	3	+180 +140	+85 +60	+100 +60	+34 +20	+45 +20	+60 +20	+24 +14	+28 +14	+39 +14	+12 +6	+16 +6	+20 +6	+8 +2	+12 +2	+6 0	+10 0
3	6	+180 +140	+100 +70	+118 +70	+48 +30	+60 +30	+78 +30	+32 +20	+38 +20	+50 +20	+18 +10	+22 +10	+28 +10	+12 +4	+16 +4	+8 0	+12 0
6	10	+208 +150	+116 +80	+138 +80	+62 +40	+76 +40	+98 +40	+40 +25	+47 +25	+61 +25	+22 +13	+28 +13	+35 +13	+14 +5	+20 +5	+9 0	+15 0
10	14	+220 +150	+138 +95	+165 +95	+77 +50	+93 +50	+120 +50	+50 +32	+59 +32	+75 +32	+27 +16	+34 +16	+43 +16	+17 +6	+24 +6	+11 0	+18 0
14	18																
18	24	+244 +160	+162 +110	+194 +110	+98 +65	+117 +65	+149 +65	+61 +40	+73 +40	+92 +40	+33 +20	+41 +20	+53 +20	+20 +7	+28 +7	+13 0	+21 0
24	30																
30	40	+270 +170	+182 +120	+220 +120	+119 +80	+142 +80	+180 +80	+75 +50	+89 +50	+112 +50	+41 +25	+50 +25	+64 +25	+25 +9	+34 +9	+16 0	+25 0
40	50	+280 +180	+192 +130	+230 +130													
50	65	+310 +190	+214 +140	+260 +140	+146 +100	+174 +100	+220 +146	+90 +60	+106 +60	+134 +60	+49 +30	+60 +30	+76 +30	+29 +10	+40 +10	+19 0	+30 0
65	80	+320 +200	+224 +150	+270 +150													

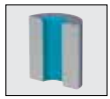
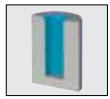
Hole tolerance

Tolerance (μm)																
H8	H9	H10	JS6	JS7	K6	K7	M6	M7	N6	N7	P6	P7	R7	S7	T7	U7	X7
+14 0	+25 0	+40 0	±3	±5	0 -6	0 -10	-2 -8	-2 -12	-4 -10	-4 -14	-6 -12	-6 -16	-10 -20	-14 -24	–	-18 -28	-20 -30
+18 0	+30 0	+48 0	±4	±6	+2 -6	+3 -9	-1 -9	0 -12	-5 -13	-4 -16	-9 -17	-8 -20	-11 -23	-15 -27	–	-19 -31	-24 -36
+22 0	+36 0	+58 0	±4.5	±7.5	+2 -7	+5 -10	-3 -12	0 -15	-7 -16	-4 -19	-12 -21	-9 -24	-13 -28	-17 -32	–	-22 -37	-28 -43
+27 0	+43 0	+70 0	±5.5	±9	+2 -9	+6 -12	-4 -15	0 -18	-9 -20	-5 -23	-15 -26	-11 -29	-16 -34	-21 -39	–	-26 -44	-33 -51 -38 -56
+33 0	+52 0	+84 0	±6.5	±10.5	+2 -11	+6 -15	-4 -17	0 -21	-11 -24	-7 -28	-18 -31	-14 -35	-20 -41	-27 -48	– -33 -54	-33 -54 -40 -61	-46 -67 -56 -77
+39 0	+62 0	+100 0	±8	±12.5	+3 -13	+7 -18	-4 -20	0 -25	-12 -28	-8 -33	-21 -37	-17 -42	-25 -50	-34 -59	-39 -64 -45 -70	-51 -76 -61 -86	–
+46 0	+74 0	+120 0	±9.5	±15	+4 -15	+9 -21	-5 -24	0 -30	-14 -33	-9 -39	-26 -45	-21 -51	-30 -60 -32 -62	-42 -72 -48 -78	-55 -85 -64 -94	-76 -106 -91 -121	–

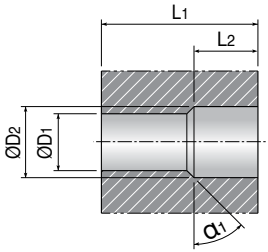
Tailor-made Order Form

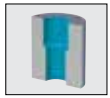
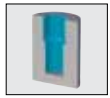
Specific dimensions



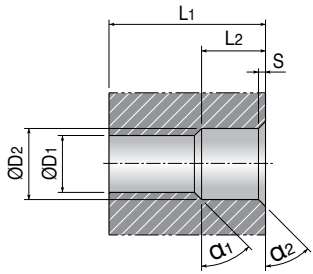



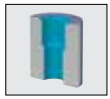
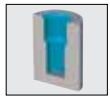
Through ☐ Blind ☐
ØD1 L1
α1 S
•Hole tolerance



Through ☐ Blind ☐
ØD1 ØD2
L1 L2
α1
•Hole tolerance



Through ☐ Blind ☐
ØD1 ØD2
L1 L2
α1 α2
S
•Hole tolerance

Comment

Drill type

•TOPDRILL ☐
•T-DRILL ☐

Technical data

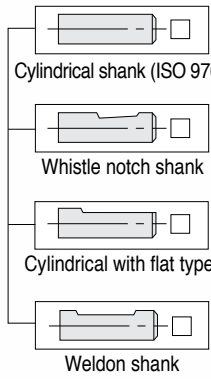
•Machine type
MCT ☐ Lathe ☐
Vertical ☐ Horizontal ☐
Machine name
Power kW

•Coolant supply
Internal ☐ External ☐
Coolant pressure bar
Coolant type

Workpiece

•Part
•Material
•Hardness

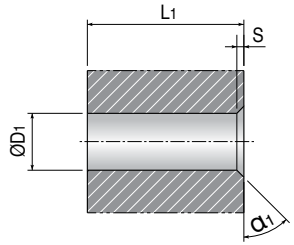
Shank type

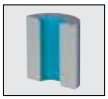
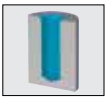


Tailor-made Order Form

DRILL•RUSH

Specific dimensions



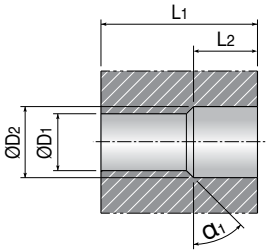



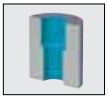
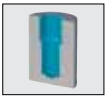
Through ☐ Blind ☐

ØD1 _____ L1 _____

α1 _____ S _____

•Hole tolerance _____



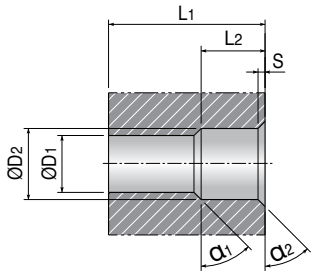
Through ☐ Blind ☐

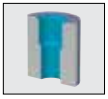
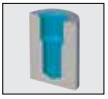
ØD1 _____ ØD2 _____

L1 _____ L2 _____

α1 _____

•Hole tolerance _____



Through ☐ Blind ☐

ØD1 _____ ØD2 _____

L1 _____ L2 _____

α1 _____ α2 _____

S _____

•Hole tolerance _____

Comment

Technical data

•Machine type

MCT ☐ Lathe ☐

Vertical ☐ Horizontal ☐

Machine name _____

Power _____ kW

•Coolant supply

Internal ☐ External ☐

Coolant pressure _____ bar

Coolant type _____

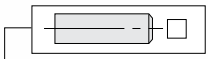
Workpiece

•Part _____

•Material _____

•Hardness _____

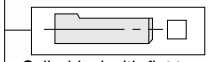
Shank type



Cylindrical shank (ISO 9766)



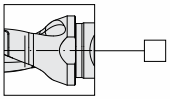
Whistle notch shank

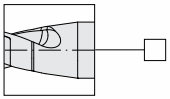


Cylindrical with flat type



Weldon shank

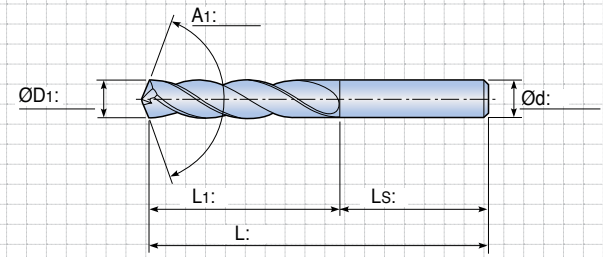


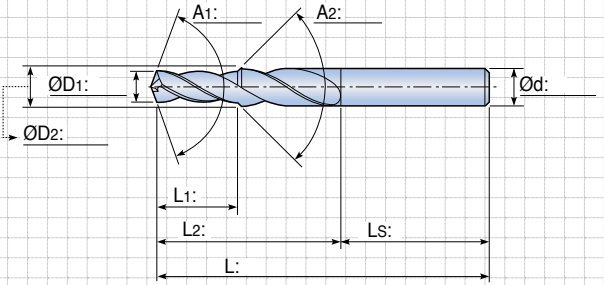


•Shank dia: _____

•Shank length: _____

Specific dimensions





• $ØD_1$, $ØD_2$ would be hole dimensions and please note hole tolerance if possible

Technical data

- Machine type
  - MCT ☐ Lathe ☐
  - Vertical ☐ Horizontal ☐
  - Machine name _____
  - Power _____ kW
- Coolant supply
  - Internal ☐ External ☐
  - Coolant pressure _____ bar
  - Coolant type _____

Workpiece

- Part _____
- Material _____
- Hardness _____

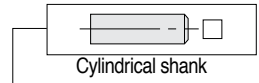
Hole type

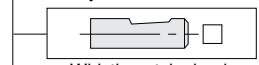
- Blind hole _____ ☐
- Through hole _____ ☐

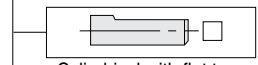
Coating

- TiAlN _____ ☐
- Non-coated _____ ☐

Shank type


Cylindrical shank


Whistle notch shank


Cylindrical with flat type


Weldon shank

Comment

Deep hole drilling order form

★: Mandatory data field

Campany name :	Inquiry number :
Address :	Inquiry date :
Contact person :	Customer No :

Workpiece (If possible,please attach a drawing)			
Product name			
Hole diameter (ø)	(mm)		
Hole depth (drilling length)	(mm)		
No. of holes			
Tolerance (of hole)			
Surface finish (Rz,Ra...)			
Deviation (mm/100)			
Straightness (mm/100)			
Material			
Material (DIN,AISI,JIS...)			
Hardness (HB,HS,HRC...)			
Condition ★	☐ Annealed	☐ Quenched	☐ Tempered
	☐ Cast	☐	
	☐ Other	☐	

Machine			
Machine supplier name			
Machine type/model			
Rigidity	☐ Good	☐ Normal	☐ Bad
Date of manufacture			
Retrofitted	☐ NC lathe	☐ M/C	☐ Other
Double rotation (TR/WR)	☐ Tool and workpiece		
Rotating workpiece (WR)	☐		
Rotating tool (TR)	☐		
Safety devices			
Motor power	(kW)		

Type of coolant			
Coolant supplier name			
Water based	☐ Soluble	☐ Emulsion	%
Oil based	☐		
Coolant pressure	(bar)		
Coolant volume	(L/min)		

Tailor-made Order Form

Deep hole drilling order form

★: Mandatory data field

Tool (Drill head)			
Drill diameter(ø)		(mm)	
Thread	☐ Inner	☐ Outer	
Brazed	☐		
Indexable	☐ Adjustable	☐ Direct mount	☐
Coating	☐ Coated	☐ Uncoated	
Coating type	☐ TiN	☐ TiAlN	☐ Other
• Solid drilling	☐		
• Counterboring	☐		
Cutting angle★ Brazed indexable	☐ 20°	☐ 45°	
	☐ Nomal angle	☐ Close angle	
Pre-bored size(per side)		(mm)	
Bottom finishing★	☐ Fullball R	☐ Flatbottom R	☐ Corner R
	☐ Compound R		
• Trepanning	☐		
Core size(ø)		(mm)	☐
Tube inner dia(ø)		(mm)	
Tube outer dia(ø)		(mm)	
Tube			
Outside dia(ø)		(mm)	
Total length(L)		(mm)	
Internal thread	☐		
External thread	☐ 4 Starts	☐ 2 Starts	☐ 1 Starts
Tube thread	☐ 1 end	☐ Both ends	
Inner tube length		(mm)	
Inner tube slit	☐ 1 end	☐ Both ends	

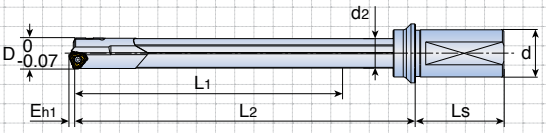
Drilling system		
Single tube system	☐	STS
Double tube system	☐	DTS

Boring conditions	
Through hole drilling	☐
Blind hole drilling	☐
Cross hole drilling★	☐

★ **Please sketch your drilling application**

General information	Production			
Quantity per year:				
Present performance status:				
grade, tool life, etc:				
Cutting data:	Vc=	m/min,	N=	rpm
	f=	mm/rev,	F=	mm/min

Deep hole drilling order form



Sketch of drilling application

• Note: It may be necessary to change several of the parameters that you indicated based on our experience with your application.

Tool	
Quantity	
Nominal diameter and tolerance	
- Please fill in dimensions on the sketch above.	
Driver	
Code No	

- For standard drivers, please use codes from pages 212-213 and for special drivers, please attach sketch and specifications.

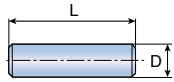
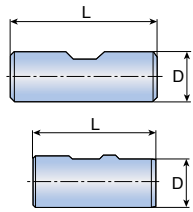
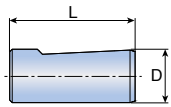
Workpiece (If possible, please attach a drawing)		
Material description (DIN material number or any other standard)		
Hardness and properties		
Hole type		☐ Blind hole ☐ Through hole ☐ Drilling into pre-hole ☐ Angled entry ☐ Drilling into solid ☐ Boring ☐ Angled exit
Drilling depth		mm
Hole tolerance		
Application	Workpiece	☐ Stationary ☐ Rotating
	Tool	☐ Stationary ☐ Rotating

Machine					
Machine type					
Power		kW			
Cutting data	Cutting speed (Vc)	m/min			
	Revolutions	**N**min :	RPM	**N**max :	RPM
	Feed	**F**min :	mm/rev	**F**min :	mm/rev
	Feed rate (VF)	mm/min			
Coolant	Coolant type	☐ Oil	☐ Soluble oil	☐ Other	
	Coolant pressure	Bar			
	Coolant volume	liter/min			

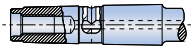
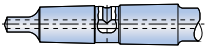
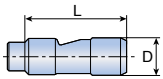
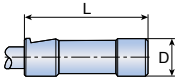
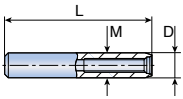
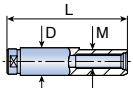
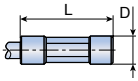
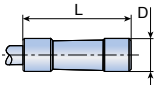
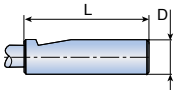
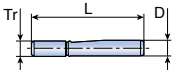
Standard gundrill drivers for machining centers and lathes

Drivers

Drivers are available for dedicated and CNC machines as well as any specified diameter or length. Please note that the driver codes and technical data can be found in the chart below.

Driver type	Drawing	ØD x L	Driver code
Cylindrical DIN1835A DIN6535HA		20x50	10
		25x56	11
		32x60	12
		40x70	13
		.75x2.03"	95
		1.00x2.28"	96
		1.25x2.28"	97
Weldon DIN1835B DIN6535HB		20x50	22
		25x56	23
		32x60	24
		40x70	25
		.75x2.03"	99
		1.00x2.28"	100
		1.25x2.28"	101
Whistle notch DIN1835E		20x50	34
		25x56	35
		32x60	36
		40x70	37

Standard drivers for gundrill machines

Driver type	Drawing	ØD x L	Driver code
DIN228AK		CM2	46
		CM3	47
		CM4	48
DIN228BK		CM2	50
		CM3	51
		CM4	52
Central clamping surface 15°		.750x2.75”	56
		25x70	57
		1.00x2.75”	58
		1.25x2.75”	59
		1.50x2.75”	60
Frontal clamping surface 15°		16x50	61
Cylindrical with thread		25x100 M16x1.5	66
		36x120 M24x1.5	67
VDI design		25x112 M16x1.5	70
		36x135 M24x1.5	71
Central clamping hexagonal		25x70	72
		32x70	73
Central clamping tapered		.75x2.75”	76
		20x70	77
Frontal clamping surface 2°		1.00x2.75”	80
		1.00x3.94”	81
		1.25x2.75”	82
		1.25x3.94”	83
		1.50x2.75”	84
		1.50x3.94”	85
Trapezoidal thread		28x126 Tr 28x2	88
		36x162 Tr 36x2	89
Spraymist driver		25x50	91
		35x60	92

T-REAM order form

★: Mandatory data field

Date: Subsidiary:

Company★ : Enquiry dead line:

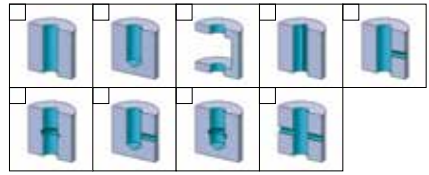
Contact person:

Address:

Request reason	
New tool ☐	Problem ☐
Quality	
Cycle time	
Alternative supplier	
Other	

Existing tool	
Maker	
Tool type	
Speed & Feed	
Tool life	
No of teeth	
Coolant type	

Machine		
Model		
Type★	vertical	☐
	horizontal	☐
	multi-spindle	☐
Adaption★		
Max RPM		
Power		
Spindle accuracy		
Coolant		

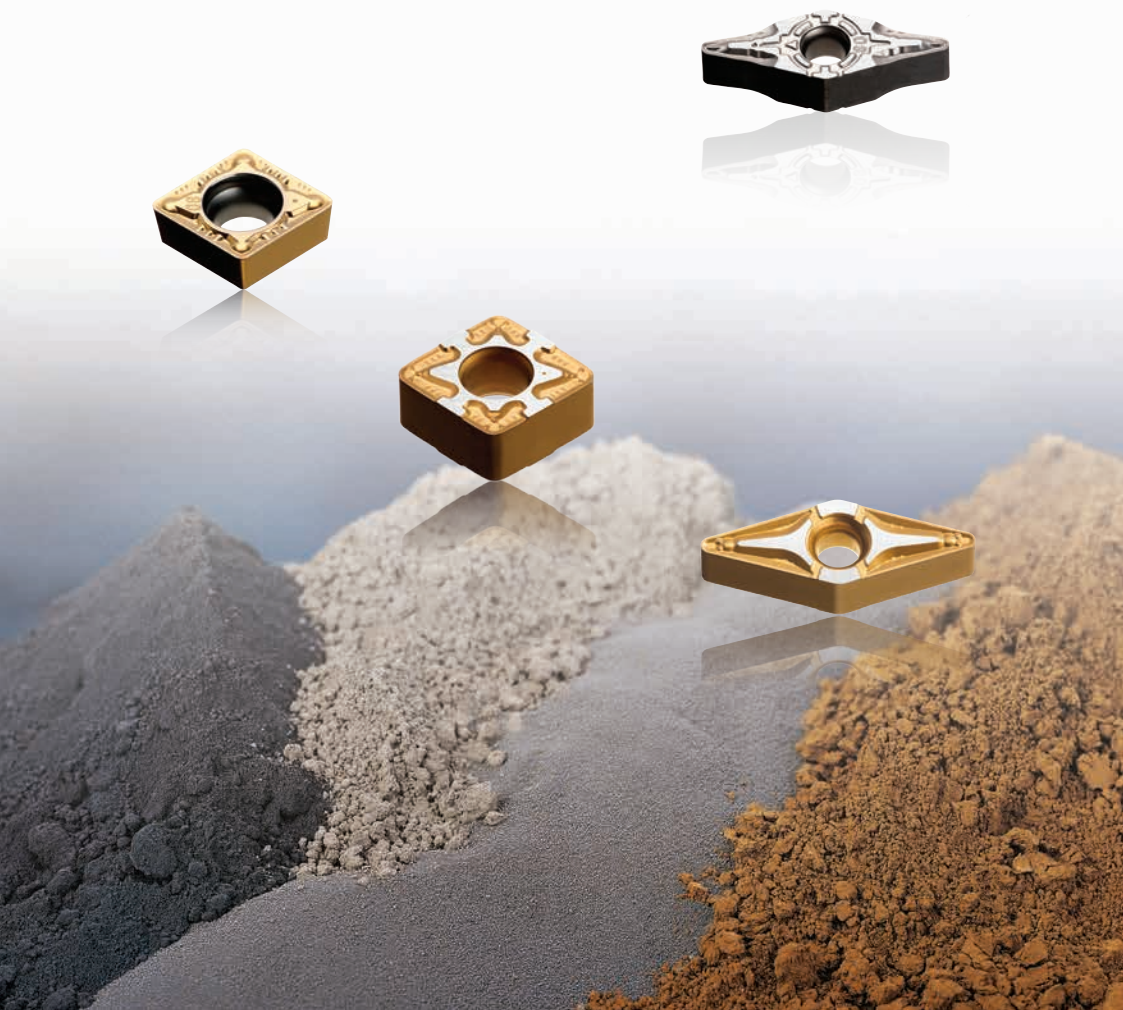
Workpiece	
Description★	
Hardness★	
Pre-hole size★	(Tolerance :)
Depth★	
Bore type	
Clamping information	

Lubricant	
Oil	☐
MQL	☐
Emulsion	☐
Ratio of mixture	
Coolant pressure	

Quality requirement	
Tolerance★	
Surface finish(Ra)★	
Roundness	
Straightness	
Cylindricity	
Concentricity	

Tool			
Type★	TM(Index multi-edge) ☐	TB(Single blade) ☐	TS(Solid) ☐ Other ☐ ( )
Diameter★			
Depth of cut★			
Coolant★	Internal ☐	External ☐	
Shank type★			
Holder type	Collet ☐	Hydraulic ☐	Other ☐
Adjustable adaptor	Yes ☐	No ☐	

MATERIALS & GRADES



Grade Comparison Table

Turning grades

ISO class	TaeguTec	Sandvik	Walter	Seco	Kennametal	Mitsubishi	Sumitomo	Tungaloy	Kyocera	Korloy	Iscar
P	TT8105	GC4305 GC4205	WPP05	TP0501 TP0500	KCP05	UE6105 UE6005	AC810P AC500G	T9105 T9005	CA5505		
	TT8115	GC4315 GC4215	WPP10S WPP10	TP1501 TP1500 TP1000	KCP10 KCP10B KC9110	MC6015 UE6110 UE6010	AC1000 AC700G	T9115 T9015	CA515 CA5515	NC3010 NC3015	IC8150 IC9150
	TT8125 TT5100	GC4325 GC4225	WPP20S WMP20S	TP2501 TP2500 TP2000	KCP25 KCP25B KC9125	MC6025 UE6020	AC820P AC2000 ACZ310	T9125 T9025	CA525 CA5525	NC3220 NC3120 NC3020	IC8250 IC9250
	TT8135 TT7100	GC4235 GC4035 GC2135	WPP30S WPP30	TP3500 TP3000 TP40	KCP30 KCP40 KC9040	UE6135 UH6400	AC830P AC3000	T9135 T9035	CA5535 CR9025	NC3030 NC500H	IC8350 IC9350
M	TT9215	GC2015	WSM10 WAM10	TM2000 CP600 TP200	KCM15	MC7015 US7020 VP05RT	AC610M EH10Z	T6120	CA6515	PC8110 NC9020	IC6015 IC807
	TT9225	GC2025	WMP20S WSM20	CP500	KCM25	MC7025 US735	AC630M AC304	T6130 AH630 T6020	CA6525	NC9025	IC6025 IC9300
	TT9235 TT8020	GC2135 GC2035 GC30	WSM30 WAM30	TM4000 CP600 TP400	KCM35	UH6400 MP7035	AC6040M AC3000	AH645 T6030	PR630	NC5330 PC9030 PC5400	IC3028
K	TT7005	GC3205 GC3005	WKK10S WAK10	TK1001 TK1000	KCK05 KC9315	MC5005 UC5105	AC405K AC410K AC300G	T5105 T5010	CA4505 CA4010	NC6205 NC6105	IC5010 IC4028
	TT7015 TT7310	GC3210 GC3015	WKK20S WAK20	TK2001 TK2000	KCK15 KCK15B KC9325	MC5015 UC5115	AC415K AC500G	T5115 T5020	CA4515 CA4115 CA4120	NC6210 NC6110	IC5005
		GC3215	WAK30		KCK20		AC420K	T5125		NC315K	
S H	TT5080	GCS05F GC1105 GC1115	WSM10	TH1000 TH1500 TS2000 TS2500 CP200	KCU10 KC5510 KC5010	MP9005 MP9015 VP05RT VP10RT	AC510U EH510Z EH10Z	AH110	PR1005 PR930	PC8110	IC807 IC907
	TT9080	GC15 GC1125 GC1025 GC1515 GC1525	WSM21 WSM20 WSM30	CP500	KCU25 KC5525 KC5025	VP15TF VP20RT	AC520U EH20Z	AH120	PR1025 PR1125 PR1225 PR1425	PC5300 PC9530 PC5400	IC808 IC908

Grade Comparison Table

▶ Cermet grades

ISO class	TaeguTec	Sandvik	Kennametal	Sumitomo	Kyocera	Tungaloy	Mitsubishi	Korloy	Seco	NTK	Ceramtec
P01	PV3010 PV3030		KT315	T110A T1000A T1500Z	PV30 TN30 PV720 PV7010	GT720 NS710	AP25N NX2525	CC105 CC115 CN1000		T3N	SC35
P10	CT3000	CT5005 CT5015 CT525 GC1525	KT5020 KT125 KT150	T1500A T1200A T2000Z	PV7020 PV7025 PV60 TN6010 TN6020 TN60 TN620	GT730 GT530 NS520 NS720	MP3025 UP35N	CN1500 CN2000 CC125	TP1030 CMP CM	T15 C30 Q50	SC15 SC8015 SC7035 SC40
P20	CT7000	CT530	KT1120 KT175	T3000Z T130Z	TN100M TC60M PV90	NS730 NS530	VP45N NX99 NX3035	CN20 CN30	TP1020 C15M	N20 Z15 C50 C7X	SC7015 SC60
P30				T250A T130A		NS740	NX4545			Q50 N40	
M01	PV3010 PV3030		KT315	T110A	PV30 TN30 PV7010	GT720 NS710	AP25N NX2525	CC105 CC115 CN1000		T3N	SC35
M10	CT3000	CT5005 CT5015 CT525 GC1525	KT5020 KT125 KT150	T1500A T1200A T2000Z	PV7020 PV60 TN6010 TN6020 TN60	GT730 GT530 NS520 NS720	MP3025 UP35N	CN2000 CC125	TP1030 CMP CM	T15 C30 Q50	SC15 SC8015 SC7035 SC40
M20	CT7000	CT530	KT1120 KT175	T3000Z T130Z	TN100M TC60M PV90	NS730 NS530	VP45N NX99 NX3035	CN20 CN30	TP1020 C15M	N20 Z15 C50 C7X	SC7015 SC60
M30				T250A T130A		NS740	NX4545			Q50 N40	
K01	PV3030		KT315	T110A T1000A T1500Z	PV30 PV7005 PV7020 PV60	NS710 GT720 NS720 NS520	AP25N NX2525	CN1000	CM	T3N Q15	SC8015
K10	CT3000	CT5015	KT125	T1200A T2000Z	TN60 TN6020	GT730 NS730 NS530		CN2000	C15M	T15 Z15 C7Z	SC7015
K20				T3000Z							

Grade Comparison Table

Ceramic grades

Application	Composition	TaeguTec	Sandvik	Kennametal	Ceramtec	NTK	Kyocera	Sumitomo	Ssang-yong
K	Al_2O_3	AW120	CC620		SN60 SN80	HC1 HW2	KA30		SZ200 SZ300
	Al_2O_3+TiC	AB30	CC650	KY1615	SH2 SH4	HC2 HC5 HC6	A65	NB90S NB90M	ST100 SD200 TC100
	SiAlON	AS500		KY1310 KY3000	SL506 SL508 SL606 SL608	SX9			SN800
	Si_3N_4	AS10	CC6090 CC6091	KY1320 KY3500 KYK10	SL500 SL808	SX1 SX6 SX8	KS6000 KS6050	SN2000K SN2100K NS260	SN26 SN300 SN400 SN500 SN600
	Si_3N_4+CVD	SC10	CC1690	KY3400 KYK25	SL550C SL554C SL654C SL658C SL854C SL858C	SP2 SP9	CS7050	NS260C	
H	Al_2O_3+TiCN	AB20			SH2 SH4	HC2 HC5 HC7			ST300 ST500 ST700
	Al_2O_3+TiCN + PVD	AB2010	CC6050	KY4400		ZC4 ZC7	A66N PT600M	NB100C	TC300
S	Al_2O_3+SiCw	TC430	CC670	KY4300		WA1 WA5		WX2000	SW400 SW800
	Si_3N_4+TiN	AS20	CC6060 CC6065	KY2100 KY1540 KYS30 KYS25		SX5 SX7 SX9	KS6040		SN800 SN900

Grade Comparison Table

▶ CBN grades

Application		TaeguTec	Iscar	Tungaloy	Sandvik	Kennametal	Mitsubishi	Seco
H	Continuous	TB610	IB10H IB50	BX310	CB7015	KB1610	MBC010	CBN10
			IB10HC			KB5610 KB9610	MB8025	CBN050C
	General	TB650	IB20H IB55	BX330 BX530	CB7025	KB1625	MB810	CBN100
		TB670	IB25HC	BX360 BX380	CB50		MB825 MB8025	CBN150 CBN170
K	General	TB730(KB90)	IB90	BX930 BX850 BX950	CB50	KB1630 KB1345	MB4020 MB710	CBN200
			IB05S IB10S	BX470 BX480	CB7050	KB5630 KB9640	MB730	CBN400C
	Solid CBN	KB90A		BX90S BXC90			MBS140	CBN300 CBN350

▶ PCD grades

ISO class	TaeguTec	Iscar	Tungaloy	Sumitomo	Sandvik	Kennametal	Mitsubishi	Kyocera	Seco	NTK
N01-N10	TD810 KP500	ID8	DX180 DX160	DA90		KD1405	MD203	KPD230	PCD30M PCD30	
N05-N20	KP300	ID5	DX140	DA150	CD10	KD1400	MD220	KPD010	PCD20	PD1
N15-N30	KP100		DX120 DX110	DA2200 DA1000		KD1425	MD205	KPD001	PCD10 PCD05	PD2

Turning Chip Breaker Comparison Table

▶ Negative insert

ISO classfication		Cutting mode	TaeguTec	Sandvik	Kennametal	Seco	Walter
P	Double sided	Finishing with wiper	WS, WA	WF	FW	W-MF2	NF
		Medium with wiper	WT	WMX, WM	MW	W-M3	NM
		Finishing	FA, FS FX		FF, FS	FF1, FF2	FP5
			FG FM	QF	FP LF, FN	MF2	NF4
		Semi-finishing	FC, FT	PF, XF			NS6
		Medium	VF, DNUX	K		UX	
			MC		MN	MR3	MP3
			PC MM	PM, XM QM	 P	MF3 MF5, M3	MP5 NM4
			MT	HM, XMR	MP RP, RM		NM6 NM9
			MG-		MG-, UN	M4 MR4	MG-
		Roughing	RT	PR	RN	M5 MR7, M6	NR4, RP5
		Low carbon steel	FS	WL, LC			
	Single sided	Heavy	RX	PR	RM		NRF
			RH	QR MR	MR, RP	R6, RR9 R4, R5, 37 RR6	NR6
			HT, HD	HR, 31	RH	R8, 56, 57 R7	NRR
			HY, HZ				
M	Double sided	Finishing	EA, SF	MF	FP	MF1	NF4
		Medium	EM	MM	MP, UP, MR	MF4	NM4
		Roughing	ET	MR MM-MR	RP	MR6, MF5 MM-RR6	NR4 NRS
K	Double sided	Finishing-medium	MT	KF KM	KN	MF5 M4	NM, MK5
		Medium	MG-		MG-,RN	M5	NM5, RK5
		Roughing	KT RT	KR	 UN	 MR7	RK7
N	Double sided	Medium	ML	QM, 23	MS, MP		
S	Double sided	Finishing	EA, SF	SF	FS	MF1	NF4
		Medium	ML	SGF, GP-	MS, GP-	M1	NFT
			MP, SU,MK	SM, 23 SR, SMR	UP, P RP	MF4, MF5 M5, MR3, MR4	NMS, NMT NRS, NRT

Valenite	Mitsubishi	Sumitomo	Kyocera	Tungaloy	Korloy	Iscar
W3	SW	LUW, SEW	WP	AFW	VW	WF
W6	MW	GUW	WQ	ASW	LW	WG
F2	FH	FA FL	DP, GP, PP VF	TF, 01 ZF	HU, VL	SF
	LP SH	 SU SE	 HQ	NS, 11 TS, AS TSF	 VG, VF VQ	 NF, F3P
	SA	LU	CQ, PQ CJ		VB, VC, HC	
	ES	GX, HM		S		
			GS	AS	HC	
M2	MP, MV MA	GE GU	PG PS	 TM	VM HS, GS	M3P VL
M3		UX, UG	HS CS		HM, GM	GN
	MG-	UZ	MG- C	33, 37, 38 DM, MG-	B25	MG-
R3	MH GH, RP	ME MU, MX	PT, GT PH, HT	 TH	 HR, GR	 NR, R3P
	FS, FY SY	FL	XF, XP,XP-T XQ, XS	17	VL	
			PX			
R6	HZ	MP HG HP	 HX	TRS 57	 GH	R3P NM
	HCS HX, HBS	HF HU		65 TU	 VT	
	HV, HDS, HXD	HW			VH	
F5	FS, LM	SU	MQ, GU	SF	HA, VP2	SF, F3M
	MS, GM, MA	EX, UP, GU	MS, MU	SS, S	GS, HS	M3M
M5	RM	MU, HM	HU	SM	VM	R3M
	LK MA, MK	 UZ	 MG-	CF CM	 VM	 GN
	MG-, GK		C	MG-		MG-
	 GH, RK	 GZ	 ZS, GC	 CH	VK GR	
	MJ	UP, GX, AG	A3, AH	P	HA	PP
F5	FJ	EF	MQ		VP1	SF
	MJ	SU	TK		VP2	PP
M2	MS GJ	EG, EX, UP MU	MS, MU	HMM, SA	VP3 VM	TF

Turning Chip Breaker Comparison Table

▶ Positive insert

ISO classfication	Cutting mode	TaeguTec	Sandvik	Kennametal	Seco	Walter
P	Medium with wiper	WT	WM	MW	W-F2	PM
	Finishing	FA FX	PF, UF	UF, 11, GM	FF1	PF4, PF5
		SA				
		FG	UM XF	FP LF	F1	PS5
	Medium	PC FM	PM	MP		
		MT	XM PR, UR XR	MF	F2	PM5 E47, MT-
		PMR-	PMR-	PMR-		PMR-
N	Finishing-Medium	FL	AL	HP	AL	PM2

Valenite	Mitsubishi	Sumitomo	Kyocera	Tungaloy	Korloy	Iscar
	MW					WG
	FV	LU PP	XP GK, GP, DP VF	01, PF, PSF	VL, VF, HFP	38, PF
	SMG	FC	CF, GF GQ CK	JS		
PM3 PM4	SQ, SV	FK SU SC, SK	XQ GK		VF HMP, C05	SM 16, GT-
			HQ	PSS PS		
PM5	MQ, MV MT- G	SF, MU	MT-	PM	C25	14, 17 19, MT-
	PMR-	UJ	GP, HQ G, PMR-	23		
IL	AZ	AW, AG	AH	AL	AK, AR	AF, AS

Hardness Conversion Table

Vickers 50kg HV	Brinell HB10mm ball LOAD 3000kgf		Rockwell				Shore's HS	Tensile strength N/mm^2 (kgf/mm^2)
	Standard ball	Tungsten carbide ball	A scale 60kgf diamond brale HRA	B scale 100kgf 1/16in ball HRB	C scale 150kgf diamond brale HRC	D scale 100kgf diamond brale HRD		
1900			93.1		80.5			
1800			92.6		79.2			
1700			91.9		77.9			
1600			91.3		76.6			
1500			90.5		75.3			
1450			90.1		74.6			
1400			89.6		74.0			
1350			89.1		73.4			
1300			88.7		72.7			
1250			88.3		72.1			
1200			87.9		71.5			
1150			87.5		70.9			
1100			87.1		70.3			
1050			86.6		69.6			
1000			86.2		68.9			
940			85.6		68.0	76.9	97	
920			85.3		67.5	76.5	96	
900			85.0		67.0	76.1	95	
880		(767)	84.7		66.4	75.7	93	
860		(757)	84.4		65.9	75.3	92	
840		(745)	84.1		65.3	74.8	91	
820		(733)	83.8		64.7	74.3	90	
800		(722)	83.4		64.0	74.8	88	
780		(710)	83.0		63.3	73.3	87	
760		(698)	82.6		62.5	72.6	86	
740		(684)	82.2		61.8	72.1	84	
720		(670)	81.8		61.0	71.5	83	
700		(656)	81.3		60.1	70.8	81	
690		(647)	81.1		59.7	70.5		
680		(638)	80.8		59.2	70.1	80	
670		630	80.6		58.8	69.8		
660		620	80.3		58.3	69.4	79	
650		611	80.0		57.8	69.0		
640		601	79.8		57.3	68.7	77	2205(210)
630		591	79.5		56.8	68.3		2020(206)
620		582	79.2		56.3	67.9	75	1985(202)
610		573	78.9		55.7	67.5		1950(199)
600		564	78.6		55.2	67.0	74	1905(194)
590		554	78.4		54.7	66.7		1860(190)
580		515	78.0		54.1	66.2	72	1825(186)
570		535	77.8		53.6	65.8		1795(183)
560		525	77.4		53.0	65.4	71	1750(179)
550	(505)	517	77.0		52.3	64.8		1750(174)
540	(496)	507	76.7		51.7	64.4	69	1660(169)
530	(488)	497	76.4		51.1	66.2		1620(165)
520	(480)	488	76.1		50.5	63.5	67	1570(160)
510	(473)	479	75.7		49.8	62.9		1530(156)
500	(465)	471	75.3		49.1	62.2	66	1459(153)
490	(456)	460	74.9		48.4	61.6		1460(149)
480	488	452	74.5		47.7	61.3	64	1410(144)

• Note: Gray figures come from ASTM E 140 table (Calculated by SAE-ASM-ASTM together)

Vickers 50kg HV	Brinell HB10mm ball LOAD 3000kgf		Rockwell				Shore's HS	Tensile strength N/mm² (kgf/mm²)
	Standard ball	Tungsten carbide ball	A scale 60kgf diamond brale HRA	B scale 100kgf 1/16in ball HRB	C scale 150kgf diamond brale HRC	D scale 100kgf diamond brale HRD		
470	441	442	74.1		46.9	60.7		1570(160)
460	433	433	73.6		46.1	60.1	62	1530(156)
450	425	425	73.3		45.3	59.4		1459(153)
440	415	415	72.8		44.5	58.8	59	1460(149)
430	405	405	72.3		43.6	58.2		1410(144)
420	397	397	71.8		42.7	57.5	57	1370(140)
410	388	388	71.4		41.8	56.8		1330(136)
400	379	379	70.8		40.8	56.0	55	1290(131)
390	369	369	70.3		39.8	55.2		1240(127)
380	360	360	69.8	(110.0)	38.8	54.4	52	1250(123)
370	350	350	69.2		37.7	53.6		1170(120)
360	341	341	68.7	(109.0)	36.6	52.8	50	1130(115)
350	331	331	68.1		35.5	51.9		1095(112)
340	322	322	67.6	(108.0)	34.4	51.1	47	1070(109)
330	313	313	67.0		33.3	50.2		1035(105)
320	303	303	66.4	(107.0)	32.2	49.4	45	1005(103)
310	294	294	65.8		31.0	48.4		980 (100)
300	284	284	65.2	(105.5)	29.8	47.5	42	950 (97)
295	280	280	64.8		29.2	47.1		935 (96)
290	275	275	64.5	(104.5)	28.5	46.5	41	915 (94)
285	270	270	64.2		27.8	46.0		905 (92)
280	265	265	63.8	(103.5)	27.1	45.3	40	890 (91)
275	261	261	63.5		26.4	44.9		875 (89)
270	256	256	63.1	(102.0)	25.6	44.3	38	855 (87)
265	252	252	62.7		24.8	43.7		840 (86)
260	247	247	62.4	(101.0)	24.0	43.1	37	825 (84)
255	243	243	62.0		23.1	42.2		805 (82)
250	238	238	61.6	99.5	22.2	41.7	36	795 (81)
245	233	233	61.2		21.3	41.1		780 (79)
240	228	228	60.7	98.1	20.3	40.3	34	765 (78)
230	219	219		96.7	(18.0)		33	730 (75)
220	209	209		95.0	(15.7)		32	695 (71)
210	200	200		93.4	(13.4)		30	670 (68)
200	190	190		91.5	(11.0)		29	635 (65)
190	181	181		89.5	(8.5)		28	605 (62)
180	171	171		87.1	(6.0)		26	580 (59)
170	162	162		85.0	(3.0)		25	545 (56)
160	152	152		81.7	(0.0)		24	515 (53)
150	143	143		78.7			22	490 (50)
140	133	133		75.0			21	455 (45)
130	124	124		71.2			20	425 (44)
127	121			69.8			19	(42)
122	116			67.6			18	(41)
117	111			65.7			15	(39)

• Note: Gray figures come from ASTM E 140 table (Calculated by SAE-ASM-ASTM together)

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS EN	AFNOR
1	A 366 (1012) 1008	0.0030	C10	040 A 10 045 M 10 1449 10 CS	AF 34 C 10 XC 10
1		1.0028	Ust 34-2 (S250G1T)		A 34-2
1		1.0034	RSt 34-2 (S250G2T)	1449 34/20 HR, HS, CR, CS	A 34-2 NE
1		1.0035	St185 (Fe 310-0) St 33	Fe 310-0 1449 15 HR, HS	A 33
1	A 570 Gr. 33,36	1.0036	S235JRG1 (Fe 360 B) Ust 37-2	Fe 360 B 4360-40 B	
1		1.0037	S235JR (Fe 360 B) St 37-2	Fe 360 B 4360-40 B	E 24-2
1	1115	1.0038	GS-CK16	030A04 1A	
1	A 570 Gr. 40	1.0044	S275JR (Fe 430 B) St44-2	Fe 430 B FN 1449 43/25 HR, HS 4360-43 B	E 28-2
1		1.0045	S355JR	4360-50 B	E 36-2
1	A 570 Gr.50 A 572 Gr.50	1.0050	E295 (Fe 490-2) St 50-2	Fe 490-2 FN 4360-50 B	A 50-2
1	A 572 Gr. 65	1.0060	E335 (Fe 590-2) St 60-2	Fe 60-2 4360-55 E; 55 C	A 60-2
1		1.0060	St 60-2		
1		1.0070	E360 (Fe 690-2) St 70-2	Fe 690-2 FN	A 70-2
1		1.0112	P235S	1501-164-360B LT20	A37AP
1		1.0114	S235JU;St 37-3 U	4360-40C	E 24-3
1	A 284 Gr.D A 573 Gr.58 A 570 Gr 36;C A 611 Gr. C	1.0116	S235J2G3 (Fe 360 D 1) St 37-3	Fe 360 D1 FF 1449 37/23 CR 4360-40 D	E 24-3 E 24-4
1		1.0130	P265S	1501-164-400B LT 20	A 42 AP
1		1.0143	S275J0; St 44-3 U	4360-43C	E 28-3

SS	UNI	UNE	JIS	KS	GOST
	C 10 1 C 10	F.1511 F.151A	S 10C	SM 10C	10
	Fe 330,Fe 330 B FU		SS 330	SS 330	
	Fe 330 B FU				St2sp
1300	Fe 320	Fe 310-0			St0
1311 1312	FE37BFU	AE 235 B Fe 360 B			16D, 18Kp St3Kp
1311	Fe 360 B 1449 37/23 HR	AE 235 B Fe 360 B	STKM 12A;C	STKM 12A;C	
1325	Fe 330,Fe 330 B FU		SS 330	SS 330	
1412	Fe 430 B Fe 430 B FN	AE 275 B Fe 430 B FN	SM 400 A;B;C	SM 400 A;B;C	St4ps; sp
2172	Fe 510 B	AE 355 B			
1550 2172	Fe 490	a 490-2 Fe 490-2 FN	SS 490	SS 490	ST5ps; sp
1650	Fe 60-2 Fe 590	A 590-2 Fe 590-2 FN	SM 570	SM 570	St6ps; sp
	Fe 60-2				
1655	Fe 70-2 Fe 690	A 690-2 Fe 690-2 FN			
	Fe 360 C	AE 235 C			
	Fe 360 C	AE 235 C			
1312 1313	Fe 360 D1 FF Fe 360 C FN Fe 360 D FF Fe 37-2	AE 235 D Fe 360 D1 FF			St3kp; ps; sp 16D
		SPH 265			
1414-01	Fe 430 D	AE 275 D			

Material Conversion Table

▶ According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS EN	AFNOR
1	A 573 Gr. 70 A 611 Gr.D	1.0144	S275J2G3 (Fe 430 D 1) St 44-3	Fe 430 D1 FF 4360-43 C; 43 D	E 28-3 E 28-4
1		1.0149	S275JOH; RoSt 44-2	4360-43C	
1		1.0226	DX51D; St 02 Z	Z2	GC
1	M 1010	1.0301	C10	040 A 10 045 M 10 1449 10 CS	AF 34 C 10 XC 10
1	A 621 (1008)	1.0330	DC 01 St 2; St 12	1449 4 CR 1449 3 CS	 TE
1	A 619 (1008)	1.0333	Ust 3 (DC03G1) Ust 13	1449 2 CR;3 CR	E
1	A 621 (1008)	1.0334	UStW 23 (DD12G1)		SC
1	A 622 (1008)	1.0335	DD13; StW 24	1449 1 HR	3C
1	A 620 (1008)	1.0338	DC04 St4; St 14	1449 1 CR;2 CR	ES
1	A 516 Gr. 65; 55 A 515 Gr. 65;55 A 414 Gr. C A 442 Gr.55	1.0345	P235GH HI	1501 Gr. 141-360 1501 Gr. 161-360; 151-360 1501 Gr. 161-400; 154-360 1501 Gr. 164-360; 161-360	A 37 CP;AP
1	(M) 1020 M 1023	1.0402	C22	055 M 15, 070 M 20 2C/2D 1499 22 HS, CS	AF 42 C 20; XC 25;1 C 22
1	1020	1.0402	C22	050A20 2C/2D	CC20
1	1020;1023	1.0402	C22	055 M 15, 070 M 20 2C	AF 42 C 20; XC 25;1 C 22
1		1.0425	P265GH H II	1501 Gr. 161-400;151-400 1501 Gr. 164-360; 161-400 1501 Gr. 164-400;154-400	A 42 CP; AP
1	A27 65-35	1.0443	GS-45	A1	E 23-45 M
1		1.0539	S355NH;StE 335		TSE 355-4
1		1.0545	S355N; StE 355	4360-50E	E 355 R
1		1.0546	S355NL;TStE 355	4360-50EE	E 355 FP
1		1.0547	S355JOH	4360-50C	TSE 355-3
1		1.0549	S355 NLH;TStE 355		
1		1.0553	S355JO;St 52-3U	4360-50C	E 36-3

 SS	 UNI	 UNE	 JIS	 KS	 GOST
1411, 1412 1414	Fe 430 B, Fe 430 C (FN) Fe 430 D (FF)	AE 275 D Fe 430 D1 FF	SM 400 A;B;C	SM 400 A;B;C	St4kp> ps; sp
1412-04	Fe 430 C	Fe 430 C			
1151 10	FeP 02 G	FeP 02 G			
	C 10 1 C 10	F.1511 F.151.A	S 10C	SM 10C	10
1142	FeP 00 FeP 01	AP 11	SPHD	SPHD	15kp
	FeP 02	AP 02	SPCD	SPCD	
	FeP 12	AP 12	SPHE	SPHE	10kp
	FeP 13	AP 13	SPHE	SPHE	08kp
1147	FeP 04	AP 04	SPCE	SPCE	08jU; JUA
1331 1330	FeE235, Fe 360 1 KW;KG Fe 360 2 KW;KG	A 37 RC I RA II	SGV 410, SGV 450, SGV 48, SPV 450;SPV 480	SGV 410, SGV 450, SGV 480, SPPV 450;SPPV 480	
1450	C 20 C 21, C 25	1 C 22 F.112	S20C	SM 20C	20
1450	C20, C21	F.112	S22C	SM 22C	20
1450	C 20; C 21;C 25	1 C 22F.112	S 20 C;S 22 C	SM 20 C;SM 22C	
1431 1430 1432	Fe 410 1 KW; KG; KT Fe 410 2 KW; KG	A 42 RC I A 42 RC II	SPV 315; SPV 355 SG 295; SGV 410 SGV 450; SGV 480	SPPV 315; SPPV 355 SG 295; SGV 410 SGV 450; SGV 480	16K 20K
1305					
2134-04	Fe 510 B	Fe 355 KGN			
2334-01	FeE 355 KG	AE 355 KG			
2135-01	FeE 355 KT	AE 355 KT			
2172-04	Fe 510 C	Fe 510 C			
2135	Fe 510 D	FeE 355 KTM			
	Fe 510 C				

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS EN	AFNOR
1	A 633 Gr.C A 588	1.0562	P355N StE 355	1501 Gr.225-490A LT 20	FeE 355 KG N E 355 R/FP; A 510 AP
1		1.0565	P355NH; WStE 355	1501-225-490B LT 20	A 510 AP
1		1.0566	P355NL1; TStE 355	1501-225-490A LT 50	A 510 FP
1	1	1.0570	S355J2G3 St 52-3	Fe 510 D1 FF 1449 50/35 HR>HS 4360-50 D	E 36-3 E 36-4
1	1213	1.0715	9 SMn 28 (1SMn30)	230 M 07	S 250
1	1213	1.0715	9 SMn 28	230 M 07	S 250
1	12 L 13	1.0718	9 SMnPb 28 (11SMnPb30)		S 250 Pb
1	1108 1109	1.0721	10 S 20	(210 M 15)	10S20 10F 2
1	11 L 08	1.0722	10 SPb 20		10PbF 2
1	11 L 08	1.0722	10 SPb 20		10PbF 2
1	1215	1.0736	9 SMn 36 11SMn37)		S 300
1	12 L 14	1.0737	9 SMnPb 36 (11SMnPb37)		
1		1.0972	S315MC; QStE 300 TM	1501-40F30	E 315 D
1		1.0976	S355MC; QStE 360 TM	1501-43F35	E 355 D
1		1.0982	S460MC; QStE 460 TM	1501-50F45	
1		1.0984	S500MC; QStE 500 TM		E 490 D
1		1.0986	S500MC; QStE 500 TM	1501 - 60F55	E 560 D
1	1010	1.1121	CK 10 (C10E)	040 A 10	XC 10
1		1.1121	St 37-1	4360 40 A	
1	1015	1.1141	CK 15 (C15E)	040 A 15 32C 080 M 15	XC 12 XC 15 XC 18
1	1020 1023	1.1151	C22E CK 22	055 M 15 (070 M 20)	2 C 22 XC 18 XC 25
1	D 3	1.2080	X 210 Cr 12	BD 3	Z 200 C 12

SS	UNI	UNE	JIS	KS	GOST
2106	FeE 355 KG;KW	AEE 355 KG;DD	SM 490 A;B;C; YA;YB	SM 490 A;B;C; YA;YB	15GF
2106	FeE 355-2				
2107-01	FeE 355-3				
2132, 2133 2134, 2174	17GS 17G1S	AE 355 D Fe 510, D1 FF	SM 490 A;B;C; YA;YB	SM 490 A;B;C; YA;YB	17GS 17G1S
1912	CF SMn 28	F.2111 - 11 SMn 28	SUM 22	SUM 22	
1912	CF 9 SMn 28	11 SMn 28	SUM 22	SUM 22	
1914	CF 9 SMnPb 28	F.2112-11 SMnPb 28	SUM 22 L SUM 23 L, SUM 24 L	SUM 22 L SUM 23 L, SUM 24 L	
	CF 10 S 20	F. 2121 - 10 S 20			
	CF 10 SPb 20	F.2122-10 SPb 20			
	CF 10 SPb 20	10 SPb 20			
	CF 9 Mn 36	F.2113 - 12 SMn 35	SUM25	SUM25	
2642	FeE 355TM				
2662	FeE 490 TM				
	FeE 560 TM				
1265	C 10, 2 C 10 2 C 15	F-1510-C 10 K	S 9 CK S 10 C	S 9 CK S 10 C	08;10
1300					
1370	C 15 C 16	F.1110-C 15 F.1511-C 16 K	S 15 S 15 CK	SM 15C SM 15CK	15
1450	C 20 C 25	F.1120-C 25 K	S 20 C, S 20 CK S 22 C	SM 20 C, SM20 CK SM22 C	20
2642					

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS EN	AFNOR
1	A36		St 44-2	4360 43 A	NFA 35-501 E 28
1			StE 320-3Z	1 501 160	
1	A572-60	1.8900	StE 380	4360 55 E	
2	(M) 1025	1.0406	C 25	070 M 26	1 C 25
2		1.0416	GS-38		20-400 M
2	A 537 Cl.1 A 414 Gr. G A 612	1.0473	P355GH	19 Mn 6	A 52 CP
2	1035	1.0501	C 35	080 A 32, 080 A 35 080 M 36, 1449 40 CS	1 C 35 AF 55 C 35 XC 38
2	1045	1.0503	CF 45 (C45G)	060 A 47 080 M 46	XC 42 H 1 TS
2	1040	1.0511	C 40	080 M 40	1 C 40 AF 60 C 40
2		1.0540	C 50		
2	A27 70-36	1.0551	GS-52	A2	280-480 M
2	A148 80-40	1.0553	GS-60	A3	320-560 M
2	A738	1.0577	S355J2G4 (Fe 510 D 2)	Fe 510 D2 FF 1501 Gr.224-460 1501 Gr. 224-490	A 52 FP
2	1140	1.0726	35 S 20	212 M 36 8M	35MF 6
2	1146	1.0727	45 S 20 (46S20)		45 MF 4
2	1035 1041	1.1157	40Mn4	150 M 36 15	35 M 5 40 M 5
2	1025	1.1158	C25E CK 25	(070 M 25)	2 C 25 XC 25
2	1536	1.1166	34Mn5		
2	1330	1.1170	28Mn6	(150 M 28), (150 M 18)	20 M 5, 28 Mn 6
2	1330	1.1170	28Mn6	150 M 5	20 M 5
2	1330	1.1170	28Mn6	14A	20 M 5
2		1.1178	C30E; CK 30	080M30	XC 32

SS	UNI	UNE	JIS	KS	GOST
1411					
1421					
2145	FeE390KG		S 25C	SM 25C	
	C 25 1 C 25				
1306					
2101 2102	Fe E 355-2	A 52 RC I RA II	SGV 410 SGV 450 SGV 480	SGV 410 SGV 450 SGV 480	
1572 1550	C 35 1 C 35	F.113	S35C	SM35C	35
1672	C 43 C 46		S 45 C	SM 45 C	45
	C 40	1 C 40	S 40 C	SM 40 C	
1674	C 50	1 C 50			
1505					
1606					
2107		A 52 RB II AE 355 D			
1957		F.210.G			
1973					
			S 09CK	SMn 433	
C 25	F.1120 - C 25 K	S 25 C S 28 C	S 25 C	SM 25 C	
	TO.B	SMn 433 H			
1421	C 28 Mn	28 Mn 6	SCMn 1	SCMn 1	30G
2145					
	C 28 Mn		SCMn 1	SCMn 1	
	C 30	2 C 30			

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS EN	AFNOR
2	1035	1.1180	C35R Cm 35	080 A 35	3 C 35 XC 32
2	1035 1038	1.1181	C35E CK 35	080 A 35 (080 M 36)	2 C 35, XC 32 XC 38 H 1
2	1035	1.1181	C35E CK 35	080 A 35 (080 M 36)	
2	1042	1.1191	GS- Ck 45	080 A 46	XC 45
2	1049 1050	1.1206	C50E CK 50	080 M 50	2 C 50 XC 48 H 1; XC 50 H 1
2	1050 1055	1.1213	Cf 53 (C53G)	070 M 55	XC 48 H TS
2	4520	1.5423	22Mo4	1503-245-420	
3		1.0050	St50-2		
3	A 516 Gr.70 A 515 Gr. 70 A 414 Gr.F; G	1.0481	P295GH 17 Mn 4	1501 Gr. 224	a 48 Cp;AP
3	1043	1.0503	C35	060 A 47 080 M 46 1449 50 HS, CS	1 C 45 AF 65 C 45
3	1074	1.0614	C 76 D; D 75-2		XC 75
3	1086	1.0616	C 86 D; D 85-2		XC 80
3	1095	1.0618	C 92 D;D 95-2		XC 90
3	1036 1330	1.1165	30Mn5	120 M 36 (150 M 28)	35 M 5
3	1335	1.1167	30Mn5	150 M 36	40 M 5
3	1040	1.1186	C40E CK 40	060 A 40, 080 A 40 080 M 40	2 C 40 XC 42 H 1
3	1045	1.1191	C45E CK 45	080 M 46 060 A 47	2 C 45 XC 42 H 1 XC 45 XC 48 H 1

SS	UNI	UNE	JIS	KS	GOST
1572		F.1130-C 35 K-1			
1550 1572	C35	F.1130-C 35 K	S 35 C	SM 35 C	35
1572	C36		S 35 C	SM 35 C	
1660	C45	F-1140			
1674	C 50				50
1674	C 53		S 50 C	SM 50 C	50
	16 Mo 5 KG; KW	F.2602- 16 Mo 5	SB 450 M	SB 450 M	SB 480 M
	FE50				
	Fe 510 KG;KT;KW Fe 510-2 KG;KT;KW FeE 295	A 47 RC I RA II	SG 365, SGV 410 SGV 450 SGV 480	SG 365, SGV 410 SGV 450 SGV 480	14G2
1672 1650	C 45 1 C 45	F.114	S 45 C	SM 45 C	45
C 85					
		F.8211-30 Mn 5 f.8311-AM 30 Mn 5	SMn 433 H SCMn 2	SMn 433 H SCMn 2	27ChGSNMDTL 30GSL
2120		F. 1203-36 Mn 6 F. 8212-36 Mn 5	SMn 438 (H) SCMn 3	SMn 438 (H) SCMn 3	35G2 35GL
	C 40		S 40 C	SM 40 C	
1672	C 45 C 46	F.1140-C 45 K F.1142-C48 K	S 45 C S 48 C	S 45 C S 48 C	45

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS	EN	AFNOR
3	1049	1.1201	C45R Cm 45	080 M 46		3 C 45 XC 42 H 1 XC 48 H 1
3		1.7242	18 CrMo 4			
3	A 387 Gr. 12 Cl	1.7337	16 CrMo 4 4			
3	A 387 Gr. 12 Cl	1.7337	16 CrMo 4 4			
3		1.7362	12 CrMo 19 5	3606-625		Z 10 CD 5.05
3	A572-60		17 MnV 6	436055 E		NFA 35-501 E 36
4	1055	1.0535	C55	070 M 55		1 C 55 AF 70 C 55
4	1060	1.0601	C60	060 A 62 1449 HS,CS	43D	1 C 60 AF 70 C 55
4	1070	1.0603	C67	080 A 67 1449 70HS		XC65
4	1074 1075	1.0605	C75	1449 80 HS		
4	1055	1.1203	C55E CK 55	060 A 57 070 M 55		2 C 5 XC 55 H 1
4	1055	1.1209	C55R Cm 55	070 M 55		3 C 55 XC 55 H 1
4	1060 1064	1.1221	C60E CK 60	060 A 62	43D	2 C 60 XC 60 H 1
4	1070	1.1231	CK 67 (C67E)	060 A 67		XC 68
4	1074 1075 1078	1.1248	CK 75 (C75E)	060 A 78		XC 75
4	1086	1.1269	CK 85 (C85E)			XC 90
4	1095	1.1274	Ck 101 (C101E)			XC 100
4	W 112	1.1663	C 125 W			Y2 120
4						
5		1.0070	St70-2			
5		1.7238	49 CrMo 4			
5		1.7701	51 CrMoV 4			

SS	UNI	UNE	JIS	KS	GOST
1660	C 45	F.1145-C 45K-1 F.1147C 48 K-1	S 50 C	SM 50 C	
18 CrMo 4					
	A 18 CrMo 4 5 KW				
	A 18 CrMo 4 5 KW				
	16 CrMo 20 5				
2142					
1655	C 55 1 C 55		S 55 C	SM 55 C	55
	C 60 1 C 60		S 58 C	SM 58 C	60(G)
	C 67				
	C 75				75
1655	C 55	F.1150-C 55 K	S 55 C	SM 55 C	55
	C 55	F.1155-C 55 K-1			
1655 1678	C 60		S 58 C	SM 58 C	60 60G, 60GA
1770	C 70				65GA 68GA , 70
774	C 75				75(A)
	C 90				85(A)
	C 100	F-5117	SUP 4	SPS 4	
1870					
2223					
	FE70-2				
	51 CrMoV 4				

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS	EN	AFNOR
6	A573-81 65	1.0116	St 37-3	4360 40 B		E 24-U
6	A515 65	1.0345	H1	1 501 161		A 37 CP
6	5120	1.0841	St 52-3	150 M 19		20 MC 5
6	9255	1.0904	55 Si 7	250A53	45	55S7
6	9254	1.0904	55 Si 7	250 A 53		55 S 7
6	9262	1.0961	60SiCr7	1 501 161		60SC6
6	L3	1.2067	100Cr6	BL3		Y100C6
6	L1	1.2108	90 CrSi 5			
6	L2	1.2210	115CrV3			100C3
6		1.2241	51CrV4			
6		1.2311	40 CrMnMo 7			
6	4135	1.2330	35 CrMo 4	708 A 37		34 CD 4
6		1.2419	105WCr6	BO1		105WC13
6	0 1	1.2510	100 MnCrW 4	BS1		8 MO 8
6	S1	1.2542	45 WCrV7			
6	S1	1.255	60WCrV7			55WC20
6	L6	1.2713	55NiCrMoV6			55NCDV7
6	L6	1.2721	50NiCr13			55 NCV 6
6	O2	1.2842	90MnCrV8	BO2		90 MV8
6	E 50100	1.3501	100 Cr 2			55WC20
6	52100	1.3505	100Cr6	2 S 135 535 A 99	31	100 C 6
6		1.5024	46Si7			45 S 7; Y 46 7;46 SI 7
6	9255	1.5025	51Si7			51 S 7 51 Si 7
6	9255	1.5026	55Si7	251 a 58		55 S 7
6	9260	1.5027	60Si7	251 A 60 251 H 60		60 S 7
6	9260 H	1.5028	65Si7			60 S 7
6		1.5120	38 MnSi 4			

SS	UNI	UNE	JIS	KS	GOST
1312	Fe37-3				
1330					
2172	Fe 52	F-431			
2085	55Si8	56Si7			
2090		F-431			
60SiCr8	60SiCr8				
	100Cr6				
2092	105WCR 5				
	107CrV3KU				
	35 cRmO 8 KU				
2234	35CrMo4	34CrMo4	SCM435TK	SCM435TK	
2140	10WCr6	105WCr5			
2140	10WCr6	105WCr5	SKS 31	STS 31	
2710	45 WCrV8 KU	45WCrSi8			
2710	58WCr9KU				
		F.520.S	SKT 4	STF 4	
2550		f-528			
2258	100Cr6	F.1310 - 100 Cr 6	SUJ2	STB 2	SchCh 15
		F. 1451 - 46 SI 7			
2090	48 Si 7	F.1450-50 Si 7			
	50 Si 7				
2085 2090	55 Si 7	F.1440 - 56 Si 7			55S2
	60 Si 7	F. 1441 - 60 Si 7			60S2
			50 P 7 SUP 6	SPS 6	

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS	EN	AFNOR
6	A 204 Gr.A 4017	1.5415	16Mo3 15 Mo 3	1503-243 B		15 D 3
6	4419	1.5419	20Mo4	1503-243-430		
6	A 350-LF 5	1.5622	14Ni6			16N6
6	3415	1.5732	1 NilCr10			14 NC 11
6	3310; 3314	1.5752	14NilCr14	655M13	36A	12NC15
6		1.6587	17CrNiMo6	820A16		18NCD6
6		1.6657	14NiCrMo134			
6	5515	1.7015	15 Cr 3	523 M 15		12 C 3
6	5132	1.7033	34Cr4	530A32	18B	32C4
6	5140	1.7035	41C r4	530M40	18	42C4
6	5140	1.7045	42Cr41	530 A 40		42 C 4 TS
6	5115	1.7131	16MnCr5	527 M 17		16 MC 5
6		1.7139	16MnCr5			
6	5515	1.7176	55Cr3	527 A 60	48	55 C 3
6	4135; 4137	1.7220	34CrMo4	708 Aa 37		35 CD 4
6	4142	1.7223	41CrMo4			
6	4140	1.7225	42CrMo4	708 M 0		42 CD 4
6		1.7228	55NiCrMoV6G	823M30	33	
6		1.7262	15CrMo5			12 CD 4
6		1.7321	20 mOcR 4			
6	ASTM A182 F-12	1.7335	13CrMo4 4	1501-620Gr27		
6	A 182-F11;12	1.7335	13 CrMo 4 4	1 501 620 Gr. 27		15 CD 4.5
6	ASTM A 182 F.22	1.7380	10CrMo9 10	1501-622gR31; 45		
6	A182 F-22	1.7380	10 CrMo 9 10	1501-622		12 CD 9.10
6		1.7715	14MoV6 3	1503-660-440		
6	A355A	1.8509	41CrAlMo 7	905 M 39	41B	40 CAD 6.12
7	A570.36	1.0038	S235JRG2 (Fe 360 B) RSt 37-2	Fe 360 B FU 1449 27/23 CR 4360-40 B		E 24-2NE
7	3135	1.5710	36NiCr6	640A35		35NC6

SS	UNI	UNE	JIS	KS	GOST
2912	16Mo3(KG;KW)	F. 2601 - 16 Mo 3			
-2512	G 20 Mo 5 G 22 Mo5		SCPH 11	SCPH 11	
14 Ni 6 KG;KT	F.2641 - 15 Ni 6				
16NiCr11	15NiCr11	SNC415(H)			
		SNC815(H)			
	14NiCrMo13				
	14NiCrMo131				
			SCr415(H)	SCr415(H)	
	34Cr4(KB)	35Cr4	SCr430(H)	SCr430(H)	
	41Cr4	42Cr4	SCr440(H)	SCr440(H)	
2245	41Cr4	42Cr4	SCr440	SCr440	
2511	16MnCr5	16MnCr5			
2127					
2253			SUP9(A)	SPS 9(A)	
2234					
	41CrMo4	42CrMo4	SNB 22-1	SNB 22-1	
2244					
2512	653M31				
2216		12CrMo4			
2625					
	14CrMo4 5	14CrMo45			
2216		12CrMo4	SCM415(H)	SCM415(H)	
2218	12CrMo9,10	TU.H			
		13MoCrV6			
2940	41CrAlMo7	41CrAlMo7			
1312	Fe 360 B FN	AE 235 B FN;FU Fe 360 B FN; FU			St3ps; sp

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS	EN	AFNOR
7		1.5755	31 NiCr 14	653 M 31		18 NC 13
7	8620	1.6523	2 NiCrMo2	805M20	362	20 NCD 2
7	8740	1.6546	40 NiCrMo 22	311-Tyre 7		
7	4130	1.7218	25CrMo4	CDS 110		25 CD 4
7		1.7733	24 CrMoV 5 5			20 CDV 6
7		1.7755	GS-45 CrMOV 10 4			
7		1.8070	21 CrMoV 5 11			
8	4142	1.2332	47 CrMo 4	708 M 40	19A	42 CD 4
8	A128 (A)	1.3401	G-X120 Mn 12			Z 120 M 12
8	3435	1.5736	36 NiCr 10			30 NC 11
8	9840	1.6511	36CrNiMo4	816M40	110	40NCD3
8	4340	1.6582	35CrNiM 6	817 M 40	24	35 NCD 6
8		1.7361	32 CeMo12	722 M 24	40B	30 CD 12
8	6150	1.8159	50 CrV 4	735 A 50	47	50CrV4
8		1.8161	58 CrV 4			
8		1.8515	32 CrMo 12	722 M 24	40B	30 CD 12
8		1.8523	39CrMoV13 9	897M39	40C	
9		1.4882	X 50 CrMnNiNbN 21 9			Z 50 CMNNb 21.09
9	3135	1.5710	36NiCr6	640A35	111A	35NC6
9		1.5864	35 niCr 18			
9			31 NiCrMo 13 4	830 m 31		
10	A573-81	1.0144	ST 44-3	4360 43 C		E 28-3
10	A 619	1.0347	DCO3 RSt;RRSt 13	1449 3 CR 1449 2 CR		E
10	M 1015 M 1016 M 1017	1.0401	C15	080 M 15 080 M 15 1449 17 CS		AF 37 C12 XC 18
10		1.0570	ST 52-3	4360 50 B		E 36-3
10	12L13	1.0718	9SMnPb28			S250Pb
10	(12L13)	1.0718	9 SMnPb 28			S 250 Pb

SS	UNI	UNE	JIS	KS	GOST
2506	20NiCrMo2	20NiCrMo2	SNCM220(H)	SNCM220(H)	
	40NiCrMo2(KB)	40NiCrMo2	SNCM240	SNCM240	
2225	25CrMo4(KB)	55Cr3	SCM420/430	SCM420/430	
	21 CrMoV 5 11				
	35 NiCr 9				
2244	42CrMo4	42CrMo4	SCM (440)	SCM (440)	
2183	GX120Mn12	F. 8251-AM-X120Mn12	SCMnH 1, SCMn H 11	SCMnH 1, SCMn H 11	110G13L
	36nIcRmO4(KB)	35NiCrMo4	SUP 10	SPS 10	
2541	35NiCrMo6(KB)		SNCM 447	SNCM 447	
2240	30CrMo12	F.124.A			
2230	50CrV4	51CrV4			
2240	32CrMo12	F.124.A			
	36CrMoV12				
			SNC236	SNC236	
2534		f-1270			
1412			SM 400A;B;C	SM 400A;B;C	
	Fep 02	AP 02			08JU
1350	C15 C16 1 C 15	F.111	S 15 C	SM 15 C	
2132	Fe52BFN/Fe52CFN		SM490A;B;C;YA;YB	SM490A;B;C;YA;YB	
1914	CF9SMnPb28	11SMnPb28			
1914	CF 9 SMnPb 28	11 SMnPb 28	SUM 22L	SUM 22L	

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS EN	AFNOR
10		1.0723	15 S 22 15 S 20	210 A 15 210 M 15	
10		1.2083			
10	H 11	1.2343	x 38 CrMoV 5 1	BH 11	Z 38 CDV 5
10	H 13	1.2344	X 40 CrMoV 5 1	BH 13	Z 40 CDV 5
10	A 2	1.2363	X100 CrMoV 5 1	BA 2	Z 100 CDV 5
10	D 2	1.2379	X 155 CrVMo 12 1	BD2	Z 160 CDV 12
10	HNV3	1.2379	X210Cr12G	BD2	Z160CDV12
10	D 4 (D 6)	1.2436	X 210 CrW 12	BD6	Z 200 CD 12
10	H 21	1.2581	X 30 WCrV 9 3	BH 21	Z 30 WCV 9
10		1.2601	X 165 CrMoV 12		
10	H 12	1.2606	X 37 CrMoW 5 1	BH 12	Z 35 CWDV 5
10	D3	1.3343	S 6-5-2	BM2	Z200C12
10	N08028	1.4563			Z1NCDU31-27-03
10	ASTM A353	1.5662	X8Ni9	1501-509;510	
10	ASM A353	1.5662	X8Ni9	502-650	9 Ni
10	2517	1.5680	12Ni19	12Ni19	Z18N5
10	2515	1.5680	12 Ni 19		Z 18 N 5
11		1.3202	S 12-1-4-5	BT 15	
11		1.3207	S 10-4-3-10	BT 42	Z130WKCDV
11	T15	1.3243	S 6-5-2-5		KCV 06-05-05-04-02
11		1.3246	S 7-4-2-5		Z110 WKCDV 07-05-04
11		1.3247	S 2-10-1-8	BM 42	Z110 DKCWV 09-08-04
11	M 42	1.3249	S 2-9-2-8	BM 34	
11	T 4	1.3255	S 18-1-2-5	BT 4	Z 80 WKCV 18-05-04-0
11	M 2	1.3343	S6-5-2	BM2	Z 85 WDCV
11	M 7	1.3348	S2-9-2		Z 100 DCWV 09-04-02-

SS	UNI	UNE	JIS	KS	GOST
1922		F.210.F	SUM 32	SUM 32	
2314					
	X 37 CrMoV 5 1 KU				
2242	X40CrMoV511KU	F-5318	SKD61	STD61	
2260	X100CrMoV51KU	F-5227	SKD12	STD12	
2310	X165CrMoW12KU	X160CrMoW12KU			
2736					
2312	X215CrW 12 1 KU	F-5213			
	X30WCrV 9 3 KU	F-526	SKD5	STD5	
2310					
	X 35 CrMoW 05 KU	F.537			
2715	X210Cr13KU	X210Cr12	SUH3	STR3	
2584					
	14 Ni 6 KG;KT	XBNiO9			
	X10Ni9	F-2645	SL9N60(53)	SL9N590(520)	
	HS 12-1-5-5	12-1-5-5			
2723	HS 6-5-2-5	6-5-2-5	SKH55	SKH55	
7-4-2-5	HS 7-4-2-5	M 35			
2-10-1-8	HS 2-9-1-8 2-9-2-8	M 41			
2722	HS 652	F-5604	SKH 51	SKH 51	
2782	HS 292	F-5607			

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS	EN	AFNOR
11	T 1	1.3355	S 18-0-1	BT 1		Z 80 WCV 18-4-01
11	630	1.4548				Z7CNU17-04
11	HNV 3	1.4718	X45CrSi 9 3	401S45	52	Z45CS9
11	422	1.4935	x20 CrMoWV 12 1			
12	403	1.4000	X6Cr13	403 S 17		Z 6 C 13
12		1.4001	X6Cr14			
12	(410S)	1.4001	X7 Cr 13	(403 S 7)		Z 8 C 13
12	405	1.4002	X6CrA12	405S17		Z8CA12
12	405	1.4002	X6 CrAl 13	405 S 17		Z6CA13
12	416	1.4005	X12CrS 13	416 S 21		Z11 CF 13
12	410; CA-15	1.4006	(G-)X10 Cr 13	410S21	56A	Z10 C 13
12	430	1.4016	X8Cr17	Z8C17		430S15
12	430	1.4016	X6 Cr 17	430 S 15	60	Z 8 C 17
12		1.4027	G-X20Cr14	420 C 29		Z20 C 13M
12		1.4027	G-X 20 Cr 14	420 C 29		Z 20 C 13M
12	420	1.4028	X30 Cr 13	420 S 45		Z 30 C 13
12		1.4086	G-X120Cr29	452C11		
12	430 F	1.4104	X12CrMoS17	420 S 37		Z 10 CF 17
12	440B	1.4112	X90 CrMoV 18			
12	434	1.4113	X6CrMo 17	434 S 17		Z 8 CD 17.01
12		1.4340	G-X40CrNi27 4			
12	S31500	1.4417	X2CrNiM0Si19 5			
12	S31500	1.4417	X2 CrNoMoSi 18 5 3			
12		1.4418	X4 CrNiMo16 5			Z6CND16-04-01
12	XM 8 430 Ti 439	1.4510				Z 4 CT 17
12	430tl	1.4510	X6 CrTi 17			Z 4 CT 17
12		1.4511	X 6 CrNb 17(X 6 CrNb 17			Z 4 CNb 17
12	409	1.4512	X 6 CrTi 12 (X2CrTi12)	LW 19 409 S 19		Z 3 CT 12
12		1.4720	X20CrMo13			

SS	UNI	UNE	JIS	KS	GOST
	X45CrSi8	F322	SUH1	STR1	
2301	X6Cr13	F.3110	SUS403	STS 403	
		F8401			
2301					
	X6CrAl13				
2302	X6CrAl13				
2380	X12 CrSC13	F-3411	SUS 416	SUS 416	
2302	X12Cr13	F.3401	SUS 410	SUS 410	
2320	X8Cr17	F.3113			
2320	X8Cr17	F.3113	SUS 430	SUS 430	
2304					
2383	X10CrS17	F.3117	SUS430F	STS 430F	
2325	X8CrMo17		SUS434	STS 434	
2376					
2376					
2387					
	X 6 CrTi 17	F.3115-X 5 CrTi 17	SUS 430 LK	STS 430 LX	08 Ch17T
	X 6 CrNb 17	F.3122-X 5 CrNb 17	SUS 430 LK	STS 430 LX	
	X 6 CrTi 17		SUH 409	STR 409	

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS	EN	AFNOR
12	405	1.4724	X10CrA113	403S17		Z10C13
12	430	1.4742	X10CrA118	439S15	60	Z10CAS18
12	HNV6	1.4747	X80CrNiSi20	443S65	59	Z80CSN20.02
12	446	1.4749	x18 cRn 28			
12	446	1.4762	X10CrA124			Z10CAS24
12	EV 8	1.4871	X 53 CrMnNiN 21 9	349 S 54		Z 52 CMN 21.09
12	302		x12 CrNi 18 9	302 S 31		Z 10 CN 18-09
12	429		X10 CrNi 15			
13	420	1.4021	X20Cr13	420S37		Z 20 C 13
13	420	1.4031	X40 Cr 13			Z 40 C 14
13		1.4034	X46Cr13	420 S 45		Z40 C 14
13	431	1.4057	X20CrNi172	431 S 29	57	Z 15 CN 16.02
13		1.4125	X 105 CrMo 17			Z 100 CD 17
13	CA6-NM	1.4313	G-X4 CrNi 13 4	425 C 11		Z 4 CND 13-04 M
13	630	1.4542	X 5 CrNiCuNb 17 4 (X5CrNiCuNb 16-4)			
13		1.4544		S. 524 S. 526		
13	348	1.4546	X5CrNiNb 18-10	347 S 31 2 S. 130 2 S. 143/144/145 S.525/527		
13		1.4922	x20cRmV12-1			
13		1.4923	X22 CrMoV12 1			
14	304	1.4301	X 5 CrNi 18 9	304 S 15		Z 5 CN 18.09
14	303	1.4305	X10 CrNiS 18 9	303 S 21	58M	Z 8 CNF 18-09
14	304L	1.4306	X2CrNi18 9	304S12		Z2CrNi18 10
14	304L	1.4306	X2 CrNi 18 10	304 S 11		Z 3 CN 19-11
14	CF-8	1.4308	X6 CrNi 18 9	304 C 15	58E	Z 6 CN 18-10 M
14	301	1.4310	X12CrN i17 7	301 S 21		Z 12 CN 17.07

SS	UNI	UNE	JIS	KS	GOST
	X10CrA112	F.311			
	X8Cr17	F.3113	SUS430	STS430	
	X80CrSiNi20	F.320B	SUH4	STR4	
2322	X16Cr26		SUH446	STR446	
	X53CrMnNiN21 9		SUH35,SUH36	STR35,STR36	
2330					
2303	14210				
-2304					
	X40Cr14	F.3405	SUS420J2	STS420J2	
2321	X16CrNi16	F.3427	SUS431	STS431	
	X 105 CrMo 17				
2385	(G)X6CrNi304		SCS5	SSC5	
	X 6 CrNiTi 18 11				08Ch 18N12T
	X 6 CrNiNb 18 11				
2317	x20cRmOnI 12 01				
2332;2333					
2346	X10CrNiS18.09	F.3508	SUS303	STS303	
2352	x2cRnI18 11	F.3503	SCS19	SSC19	
2352	X2CrNi18 11				
2333			SUS304L	STS304L	
2331	X2CrNi18 07	F.3517			

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS	EN	AFNOR
14	304 LN	1.4311	X2 CrNiN 18 10	304 S 62		Z 2 CN18.10
14		1.4312	G-X10CrNi18 8	302C25		Z10CN18.9M
14	305	1.4312	X8 CrNi 18 12	305 S 19		
14		1.4332	X2 CrNi 18-8			
14	304	1.4350	X5CrNi18 9	304S15	58E	Z6CN18.09
14	S32304	1.4362	X2 CrNiN 23 4			Z 2 CN 23-04 AZ
14	202	1.4371	X3 CrMnNiN 188 8 7	284 S 16		Z 8 CMN 18- 08-05
14	316	1.4401	X 5 CrNiMo 17 12 2 (X4 CrNiMo 17 -12-2)	316 S 13 316 S 17 316 S 19 316 S 31 316 S 33		Z 3 CND 17 -11-01 Z 6 CND 17-11 Z 6 CND 17-11-02 Z 7 CND 17-11-02 Z 7 CND 17-12-02
14	316L	1.4404	X2 CrNiMo 17 13 2 (X2 CrNiMo 17-12-2) GX 2 CrNiMoN 18-10	316 S 11, 316 S 13 316 S 14, 316 S 31; 316 S 42, S.537;316 C 12, T.75, S. 161		Z 2 CND 17-12 Z 2 CND 18-13 Z 3 CND 17-11-02 Z 3 CND 17-12-02 FF Z 3 CND 18-12-03 Z 3 CND 19.10 M
14	316LN	1.4406	X2 CrNiMoN 17 12 2 (X2CrNiMoN 18-10)	316 S 61 316 S 63		Z2 CND 17-12 AZ
14	CF-8M	1.4408	GX 5 CrNiMoN 7 12 2 G-X 6 CrNiMo 18 10	316 C 16 (LT 196) ANC 4 B		
14		1.4410	G-X10CrNiMo18 9			Z5CNaD20.12M
14	316 Ln	1.4429	X2 CrNiMo 17 -13-3	316 S 62		Z 2 CND 17-13 Az
14	316L	1.4435	X2 CrNiMo18 14 3	316 S 11;316 S 13 316 S 14;316 S 31 LW 22 LWCF 22		Z 3 CND 17-12-03 Z 3 CND 18-14-03
14	316	1.4436	X 5 CrNiMo 17 13 3 (X4CRNIMO 17-13-3	316 S 19; 316 S 31 316 S 33 LW 23 LWCF 23		Z 6 CND 18-12-03 Z 7 CND 18-12-03

SS	UNI	UNE	JIS	KS	GOST
2371	X2CrNiN18 10		SUS304LN	STS304LN	
2332	X5CrNi18 10	F.3551	SUS304	STS304	
2347	X 5 CrNiMo 17 12	F.3534-X 5 CrNiMo 17 12 2	SUS 316	STS 316	
2348	X 2 CrNiMo 17 12	F.3533 - X 2 CrNiMo 17 13 2			
	G-X 2 CrNiMo 19 11	F.3537 - X 2 CrNiMo 17 13 3	SUS 316 L	STS 316 L	
	X 2 CrNiMoN 17 12	F.3542-X 2 CrNiMoN 17 12 2	SUS316LN	STS316LN	
2343		F.8414-AM-X 7 CrNiMo 20 10	SCS 14	SSC 14	07 Ch 18N10G2S2MSL
2328					
2375	X 2 CrNiMoN 17 13	F.3543-X 2 CrNiMoN 17 13 3	SUS 316 LN	STS 316 LN	
2375	X 2 CrNiMoN 17 13	F.3533-X 2 CrNiMo 17 13 2	SUS 316 L	STS 316 L	O3 Ch 17N14M3
2343	X 5 CrNiMo 117 13 X 8 cRnImO 17 13	F.3543-X 5 CrNiMo 17 12 2 F.3538-X 5 CrNiMo 17 13	SUS 316	STS 316	

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS	EN	AFNOR
14	317L	1.4438	X2 CrNiMo 18 16 4 (X2CrNiMo 18-15-4)	317 S 12		Z 2 CND 19-15-04 z 3 cnd 19-15-04
14	(s31726)	1.4439	X2 CrNiMoN 17 13 5			Z 3 CND 18-14-06 AZ
14		1.4440	X 2 CrNiMo 18 13			
14	317	1.4449	X5 CrNiMo 17 13 3	317 S 16		
14	329	1.4449 1.4460	X 4 CrNiMo 27 5 2 (X3CrNiMo27-5-2)			(Z 3 CND 25-07 Az) Z 5 CND 27-05 Az
14	329	1.4460	X8CrNiMo27 5			
14		1.4462	X2CrNiMoN22 5 3	318 S 13		Z 3 CND 22-05 Az (Z 2 CND 24 -08 Az) (Z 3 CND 25-06-03 Az)
14		1.4500	G-X7NiCrMoCuNb25 20			23NCDU25.20M
14	17-7PH	1.4504		316S111		
14	443 444	1.4521	X2CrMoTi18-2	317 S 16		
14	UNS N 08904	1.4539	X1NiCrMoCuN25-20-5			Z 2 NCDU 25-20
14	CN-7M	1.4539	(G-)X1 NiCrMoCu 25 20 5			Z1 NCDU 25-02 M
14	321	1.4541	Z 6 CrNiTi 18-10	321 S 31 321 S 51 (1010;1105) LW 24 LWCF 24		Z 6 CNT 18-10
14	630	1.4542	X5 CrNiCuNb 17 4 (X5 CrNiChNb 16-4)			Z 7 CNU 15-05 Z 7 CNU 17-04
14	17-4PH	1.4542				Z7CNU17-04
14	S31254	1.4547	X1 CrNiMoN 20 18 7			
14	17-4PH	1.4548				Z7CNU17-04
14	347	1.4550	X6 CrNiNb 18 10	347 S 17	58F	Z 6 CNNb 18.10
14		1.4552	G-X7CrNiNb18 9			Z4CNNb19.10M
14	17-7PH	1.4568		316S111		
14	316tTi	1.4571	X6 CrNiMoTi 17 12 2	320 S 31		Z 6 CNDT 17-12002
14		1.4581	G-X 5 CrNiMoNb	318 C 17		Z 4 CNDNb 18.12 M
14	318	1.4583	X 10CrNiMoNb 18 12	303 S 21		Z15CNS20.12

SS	UNI	UNE	JIS	KS	GOST
2367	X2CrNiMo18 16	f.3539-x 2 cRnImO 18 16 4	SUS317L	STS317L	
	X 5 CrNiMo 18 15		SUS 317	STS 317	
2324		F.3309-X 8 CrNiMo 17 12 2 F.3552-X 8 CrNiMo 18 16 4	SUS 329 J 1	STS 329 J 1	
2377			SUS 329 J3L	STS 329 J3L	
	Z8CNA17-07	X2CrNiMo1712			
2326		F.3123-X 2 CrMoTiNb 18 2	SUS 444	STS 444	
2562					
2564					
2337	X 6 CrNiTi 18 11	F.3523 - X 6 CrNiTi 18 10	SUS 321	STS 321	06Ch18N10T 08Ch18N10T 09Ch18N10T 12Ch18N10T
			SCS 24 SUS 630	SSC 24 STS 630	
2378					
2338	X6CrNiNb18 11	F.3552	SUS347	STS347	
	Z8CNA17-07	X2CrNiMo1712			
2350					
	x15cRnIsI2 12				

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS	EN	AFNOR
14		1.4585	G-X7CrNiMoCuNb18 18			
14		1.4821	X20CrNiSi25 4			Z20CNS25.04
14		1.4823	G-X40CrNiSi27 4			
14	309	1.4828	X15CrNiSi20 12	309 S 24	58C	Z15CNS20.12
14	309S	1.4833	X6 CrNi 22 13	309 S 13		Z 15 CN 24-13
14	310 S	1.4845	X12 CrNi 25 21	310S24		Z 12 CN 25-20
14	321	1.4878	X6 CrNiTi 18 9	32 1 S 20	58B	Z 6 CNT 18-12 (B)
14	Ss30415	1.4891	X5 CrNiNb 18 10			Z20CNS25.04
14	S30815	1.4893	X8 CrNiNb 11			
14	304H	1.4948	X6 CrNi 18 11	304 S 51		Z 5 CN 18-09
14	660	1.498	X5 NiCrTi 25 15			Zz 8 nctv 25-15 b ff
14			X5 NiCrN 35 25			
14	S31753		X2 CrNiMoN 18 13 4			
14			X2 CrNiMoN 25 22 7			
15	CLASS20	0.6010	GG10			Ft10D
15	A48-20B	0.6010	GG-10			Ft 10 D
15	NO 25 B	0.6015	GG 15	Grade 150		Ft 15 D
15	CLASS25	0.6015	GG 15	Grade 150		Ft 15D
15	A48 25 B	0.6015	GG 15	Grade 150		Ft 15 D
15	A48-30B	0.6020	GG-20	Grade 220		Ft 20 D
15	NO 30 B	0.6020	GG 20	Grade 220		Ft 20 D
15	A436 Type 2	0.6660	GGL-NiCr202	L-NiCuCr202		L-NC 202
15	60-40-18	0.7040	GGG 40	SNG 420/12		FCS 400-12
15	No 20 B		GG 10			Ft 10 D
16	CLASS30	0.6020	GG 20	Grade 220		Ft 20D
16	CLASS45	0.6030	GG 30	Grade 300		Ft 30D
16	A48-45 B	0.6030		Grade 350		Ft 30D
16	A48-50	0.6035	GG-35	Grade 350		Ft 35 D
16	A48-60 B	0.6040	GG40	Grade 400		Ft 40 D
16	100/70/03	0.7070	GGG-70	SNG700/2		FGS 700-2

SS	UNI	UNE	JIS	KS	GOST
	X6CrNiMoTi17 12				
		F.8414	SCS17	SSC17	
2361	X6CrNi25 20	F.331	SUH310	STR310	
2337	X6CrNiTi18 11	F.3553	SUS321	STS321	
2372					
2368					
2333					
2570					
110	G 10				
0110-00					
0115-00	G 15	FG 15	FC150	GC150	
115	G 15	FG 15			
01 15-00	G 14	FG 15			
0120-00					
120	G 20		FC200	GC200	
0523-00					
0717-02	GS 370-17	FGE 38-17	FCD400	GCD400-18,15	
110			FC100	GC100	
120	G 20	FG 20			
130	G 30	FG 30	FC300	GC300	
01 30-00					
135	G 35	FG 35	FC350	GC350	
140					
07 37-01	GGG 70	GGG 70	FCD700	GCD700-2	

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS EN	AFNOR
16		1.4829	X 12 CrNi 22 12		
17		0.7033	GGG35.3		
17		0.7033	GGG-35.3	350/22 L 40	FGS 370/17
17	60-40-18	0.7040	GGG-40	SNG 420/12	FGS 400-12
17	60/40/18	0.7043	GGG-40.3	370/7	FGS 370/17
17	80-55-06	0.7050	GGG50	SNG500/7	FGS 500/7
17	65-45-12	0.7050	GGG-50	SNG 500/7	FGS 500-7
17		0.7652	GGG-NiMn 13 7	S-NiMn 137	S-Mn 137
17	A43D2	0.7660	GGG-NiCr 20 2	Grade S6	S-NC 202
17			GGG 40.3	SNG 370/17	FGS 370-17
18	A48-40 B	0.6025	GG25	Grade260	Ft 25 D
18		0.7060	GGG60	SNG600/3	FGS600-3
18	80/55/06	0.7060	GGG-60	600/3	FGS 600/3
18	A48 40 B				
19		0.8055	GTW55		
19	32510	0.8135	GTS-35-10	B 340/12	MN35-10
19	A47-32510	0.8135	GTS-35-10	B 340/2	Mn 35-10
19	A220-40010	0.8145	GTS-45-06	P 440/7	Mn 450-6
19			GTS-35	B 340/12	
19				8 290/6	MN 32-8
19	32510		GTS-35	B340/12	MN 35-10
20		0.8035	GTM-35	W340/3	MB35-7
20		0.8040	GTW-40	W410/4	MB40-10
20		0.8045			
20		0.8065	GTMW-65		
20	A220-50005	0.8155	GTS-55-04	P 510/4	Mn 550-4
20	50005	0.8155	GTS-55-04	P 510/4	MP 50-5
20	70003	0.8165	GTS-65-02	P 570/3	Mn 650-3
20	90001	0.8170	GTS-70-02	P 690/2	Mn 700-2
20	A220-90001	0.8170	GTS-70-02		Mn 700-2

SS	UNI	UNE	JIS	KS	GOST
0717-15					
0717-15					
0717-02					
0717-15					
0727-02	GGG 50				
	0727-02		FCD 500	GCD 500-7	
0772-00					
0776-00					
0717-12					
125	G 25	FG 25	FC250	GC250	
07 32-03	GGG 60	GGG 60			
0727-03			FCD600	GCD600-3	
		GTW 55			
810		GTS 35			
0815-00					
	0852-00	GMN 45			FCMW370
0810-00					
814			AC4A	AC4A	
08 15			FCMW330	FCMW330	
852		GTM 35			
	GTB40	GTM 40			
	GMB45	GTM 45			
		GTM 65			
0854-00					
0854-00	GMN 55		FCMP490	PMC 490	
0856-00	GMN 65		FCMP590	PMC 590	

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS EN	AFNOR
20		0.8170	GTS-70-02	IP 70-2	
20	1022 1518	1.1133	20Mn5	120 M 19	20 M 5
20	1035	1.1183	Cf 35 (C35G)	080 A 35	XC 38 H 1 TS
20	400 10		GTS-45	P440/7	
20	70003		GTS-65	P 570/3	MP 60-3
21	Al99	3.0205			
21	1000	3.0255	Al99.5	L31/34/36	A59050C
21		3.3315	AlMg1		
22		3.1325	AlCuMg 1		
22		3.1655	AlCuSiPb		
22		3.2315	AlMgSi1		
21	7050	3.4345	AlZnMgCuO,5	L 86	AZ 4 GU/9051
23		3.2381	G-AlSi 10 Mg		
23		3.2382	GD-AlSi10Mg		
23		3.2581	G-AlSi12		
23		3.3561	G-AlMg 5		
23	ZE 41	3.5101	G-MgZn4sE1Zr1	MAG 5	
23	EZ 33	3.5103	MgSE3Zn27r1	MAG 6	G-TR3Z2
23	AZ 81	3.5812	G-MgAl8Zn1	NMAG 1	
23	AZ 91	3.5912	G-MgAl9Zn1	MAG 7	
24		2.1871	G-AlCu 4 TiMg		
24		3.1754	G-AlCu5Ni1,5		
24		3.2163	G-AlSi9Cu3		
24	4218 B	3.2371	G-AlSi 7 Mg		
24	SC64D	3.2373	G-AlSI9MGWA		A-S7G
24		3.2373	G-AlSi 9 Mg		
24	QE 22	3.5106	G-MgAg3SE2Zr1	mag 12	
24	GD-AlSI12		G-ALMG5	LM5	A-SU12
23-24	A360.2	3.2383	G-AlSi0Mg(Cu)	LM9	

SS	UNI	UNE	JIS	KS	GOST
0862-00	GMN 70		FCMP690	PMC 690	
0864-00					
2132	G 22 Mn 3				
	20 Mn 7	F.1515-20 Mn 6	SMnC 420	SMnC 420	
1572	C 36; C 38		S 35 C	SM 35 C	35
08 52					
858			FCMP540	PMC 540	
811-04					
4231			C4BS	C4BS	
4252					
4253					

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS EN	AFNOR
23-24	A356-72			2789;1973	NF A32-201
23-24	356.1			LM25	
23-24	A413.2		G-AlSi12	LM6	
23-24	A413.1		G-AlSi 12 (Cu)	LM20	
23-24	A413.0		GD-AlSi12		
23-24	A380.1		GD-AlSi8Cu3	LM24	
26	C93200	2.1090	G-CuSn 7 5 pb		U-E 7 Z 5 pb 4
26	C83600	2.1096	G-CuSn5ZnPb	LG 2	
26	C83600	2.1098	G-CuSn 2 Znpb		
26	C23000	2.1182	G-CuPb15Sn	LB1	U-pb 15 E 8
26	C93800	2.1182	G-CuPb15Sn		Uu-PB 15e 8
27		2.0240	CuZn 15		
27	C27200	2.0321	CuZn 37	cz 108	CuZn 36, CuZn 37
27	C27700	2.0321	CuZn 37	cz 108	CuZn 36, CuZn 37
27		2.0590	G-CuZn40Fe		
27	C 86500	2.0592	G-CuZn 35 Al 1	U-Z 36 N 3	HTB 1
27	C 86200	2.0596	G-CuZn 34 Al 2	HTB 1	U-Z 36 N 3
27	C 18200	2.1293	CuCrZr	CC 102	U-Cr 0.8 Zr
28		2.0060	E-Cu57		
28		2.0375	CuZn36Pb3		
28	C 94100	2.0596	G-CuZn 34 Al 2	HTB 1	U-Z 36 N 3
28	C 63000	2.0966	CuAl 10 Ni 5 Fe 4	Ca 104	U-A 10 N
28	B-148-52	2.0975	G-CuAl 10 Ni		
28	C 90700	2.105	G-CuSn 10	CT1	
28	C 90800	2.1052	G-CuSn 12	pb 2	UE 12 P
28	C 81500	2.1292	G-CuCrF 35	CC1-FF	
28		2.4764	CoCr20W15Ni		
31	N 08800	1.4558	X 2 NiCrAlTi 32 20	NA 15	
31	N 08031	1.4562	X 1 NiCrMoCu 32 28 7		

SS	UNI	UNE	JIS	KS	GOST
4244			A5052	A5052P	
4261					
4260			ADC12	ALDC12	
4247			A6061	A6061P	
4250			A7075	A7075P	
	C 2700				
	C 2720				

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No.	DIN	BS	EN	AFNOR
31	N 08028	1.4563	X 1 NiCrMoCuN 32 27 4			
31	N 08330	1.4564	X 12 NiCrSi 36 16	NA 17		Z 12 NCS 35.16
31	330	1.4564	X12 NiCrSi 36 16	NA 17		Z 12 NCS 37.18
31		1.4865	G-X40NiCrSi38 18	330 C 40		
31		1.4958	X 5 NiCrAlTi 31 20			
31	AMS 5544	LW2.4668	NiCr19NbMo			NC20K14
32		1.4977	X 40 CoCrNi 20 20			Z 42 CNKDWNb
33	Monel 400	2.4360	NiCu30Fe	NA 13		NU 30
33	5390A	2.4603				NC22FeD
33	Hastelloy C-4	2.4610	NiMo16cR16Ti			
33	Nimonic 75	2.4630	NiCr20Ti	HR 5,203-4		NC 20 T
33		2.4630	NiCr20Ti	HR5,203-4		NC20T
33	Inconel 690	2.4642	NiC29Fe			Nnc 30 Fe
33	Inconel 625	2.4856	NiCr22Mo9Nb	NA 21		NC 22 FeDNb
33	5666	2.4856	NiCr22Mo9Nb			Inconel 625
33	Incoloy 825	2.4858	NiCr21Mo	NA 16		NC 21 Fe DU
34	Monel k-500	2.4375	NiCu30 Al	NA 18		NU 30 AT
34	4676	2.4375	NiCu30Al	3072-76		
34		2.4631	NiCr20TiAl	Hr40;601		NC20TA
34	Inconel 718	2.4668	NiCr19FeNbMo			NC 19 Fe Nb
34	Inconel	2.4694	NiCr16fE7TiAl			
34		2.4955	NiFe25Cr20NbTi			
34	5383	LM2.4668	NiCr19Fe19NbMo	HR8		NC19eNB
34	5391	LW2 4670	S-NiCr13A16MoNb	3146-3		NC12AD
34	5660	LW2.4662	NiFe35Cr14MoTi			ZSNCDT42
34	5537C	LW2.4964	CoCr20W15Ni			KC20WN
34	AMS 5772		C0Cr22W14Ni			KC22WN
35	Inconel X-750	2.4669	NiCr15Fe7TiAl			NC 15 TNb A
35	Hastelloy B	2.4685	G-NiMo28			
35	Hastelloy C	2.4810	G-NiMo30			

SS	UNI	UNE	JIS	KS	GOST
2584					
			SUH330	STR 330	
	XG50NiCr39 19		SCH15	HRSC 15	

Material Conversion Table

According to VDI 3323 standard

Material group	AISI/SAE	Material No. DIN		BS EN	AFNOR
35	AMS 5399	2.4973	NiCr19Co11MoTi		NC19KDT
35		3.7115	TiAl5Sn2		
36	R 50250	3.7025	Ti 1	2 TA 1	
36	R 52250	3.7225	Ti 1 pd	TP 1	
36	AMS 5397	LW2 4674	NiCo15Cr10MoAlTi		
37		3.7124	TiCu2	2 TA 21-24	
37	R 54620	3.7145	TiAl6Sn2Zr4Mo2Si		
37		3.7165	TiAl6V4	TA 10-13;TA 28	T-A 6 V
37		3.7185	TiAl4Mo4Sn2	TA 45-51; TA 57	
37		3.7195	TiAl 3 V 2.5		
37			TiAl4Mo4Sn4Si0.5		
37	AMS R54520		TiAl5Sn2.5	TA14/17	T-A5E
37	AMS R56400		TiAl6V4	TA10-13/TA28	T-A6V
37	AMS R56401		TiAl6V4ELI	TA11	
38	W 1	1.1545	C105W1	BW 1A	Y1105
38	W210	1.1545	C105W1	BW2	Y120
38		1.2762	75 CrMoNiW 6 7		
38	440C	1.4125	X105 CrMo 17		Z 100 CD 17
38		1.6746	32 nIcRmO 14 5	832 M 31	35 NCD 14
40	Ni- Hard 2	0.9620	G-X 260 NiCr 4 2	Grade 2 A	
40	Ni- Hard 1	0.9625	G-X 330 Ni Cr 4 2	Grade 2 B	
40	Ni- Hard 4	0.9630	G-X 300 CrNiSi 9 5 2		
40		0.9640	G-X 300 CrMoNi 15 2 1		
40	A 532 III A 25% Cr	0.9650	G-X 260 Cr 27	Grade 3 D	
40	A 532 III A 25% Cr	0.9655	G-X 300 CrNMo 27 1	Grade 3 E	
40		1.2419	105 WCr 6	105WC 13	
40	310	1.4841	X15 CrNiSi 25 20	314 S31	Z 15 CNS 25-20
41		0.9635	G-X 300 CrMo 15 3		
41		0.9645	G-X 260 CrMoNi 20 2 1		
41		0.9655	G-X 300 CrNMo 27 1		

SS	UNI	UNE	JIS	KS	GOST
1880	C100KU	F-5118	SK3	STC 105(STC3)	
2900	C120KU	CF.515	SUP4	SPS 4	
	0512-00				
	0513-00				
	0466-00				
		107 WCr 5 KU			

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