

# NEW PRODUCT NEWS

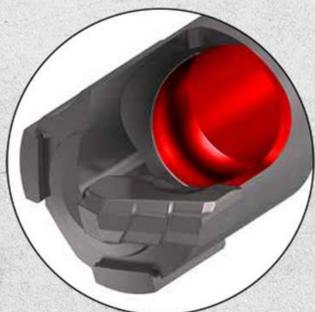


Taegutec Hole Making Line

## TDEEP

**NEW DEEP HOLE DRILLING BRAZED DRILLS**

NEW  
TTB930  
Grade



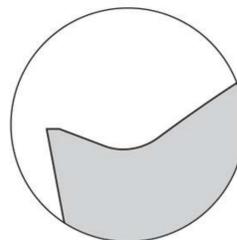
### KEY POINT

TaeguTec's deep hole drilling T-DEEP line introduces new brazed BTE drills.

TaeguTec's multi-solution T-DEEP deep hole drilling line now includes BTE brazed drills for longer tool life and excellent machining performance. Featuring a new TTB930 brazed tip as well as a sharp cutting edge design, the new BTE drills are available upon request in a  $\varnothing 15.60$ - $16.70$  mm range.

For further information, please contact the relevant product manager.

### BTE drill features



Positive rake angle design  
for low cutting force



NEW  
TTB930  
Grade

New tip grade  
for excellent tool life



Reinforced cutting edge  
with corner chamfer design



Widened mouth design  
for improved chip evacuation

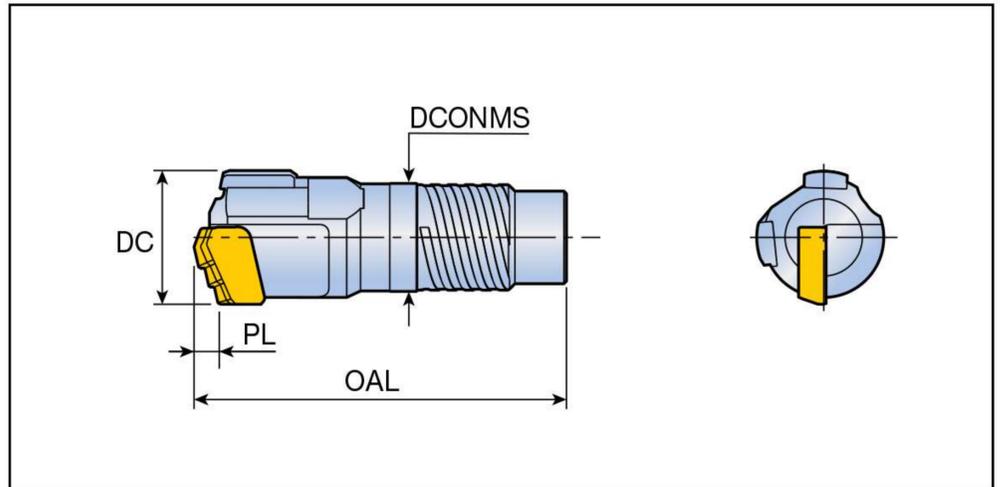
### BTE...SE4



Single tube system



- Outer four start thread



Designation	DC	Dimension (mm)			Tube	
		OAL	PL	DCONMS	Part	Diameter (mm)
<b>BTE XXX.XX SE4-14</b>	15.60-16.70	43.4	3.4	12.6	BTSI014	14

### Recommended Cutting Conditions

#### Machining data - BTE

ISO	Material	Condition	Tensile Strength (N/mm <sup>2</sup> )	Hardness HB	Material No.	Cutting speed Vc(m/min)	Feed (mm/rev) vs. drill diameter	
							Ø15.60-Ø16.70	
P	Non-alloy steel and cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	80-140	0.10-0.16
		>=0.25%C	Annealed	650	190	2	80-130	0.10-0.16
		<0.55%C	Quenched and tempered	850	250	3	80-120	0.10-0.16
		>=0.55%C	Annealed	750	220	4	70-110	0.10-0.16
			Quenched and tempered	1000	300	5	50-90	0.10-0.12
	Low alloy steel and cast steel (less than 5% of alloying elements)	Annealed	600	200	6	70-120	0.10-0.16	
		Quenched and tempered	930	275	7	70-110	0.10-0.12	
			1000	300	8	50-90	0.10-0.12	
			1200	350	9	40-70	0.10-0.12	
	High alloy steel, cast steel and tool steel	Annealed	680	200	10	50-90	0.10-0.16	
		Quenched and tempered	1100	325	11	40-80	0.10-0.12	
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	40-70	0.04-0.16	
		Martensitic	820	240	13	40-70	0.04-0.16	
		Austenitic	600	180	14	30-70	0.04-0.14	
K	Grey cast iron (GG)	Ferritic / pearlitic		160	15	90-160	0.06-0.16	
		Pearlitic		250	16	80-140	0.06-0.16	
	Cast iron nodular (GGG)	Ferritic		180	17	90-180	0.06-0.16	
		Pearlitic		260	18	80-140	0.06-0.16	
	Malleable cast iron	Ferritic		130	19	90-160	0.06-0.16	
		Pearlitic		230	20	80-140	0.06-0.16	
N	Aluminum-wrought alloy	Not cureable		60	21	90-220	0.08-0.16	
		Cured		100	22	90-220	0.08-0.16	
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	90-220	0.08-0.16
			Cured		90	24	90-220	0.08-0.16
	>12% Si	High temperature		130	25	80-160	0.08-0.16	
		Free cutting		110	26	90-220	0.08-0.16	
	Copper alloys	Brass		90	27	90-220	0.08-0.16	
		Electrolytic copper		100	28	90-220	0.08-0.16	
		Non-metallic	Duroplastics, fiber plastics			29		
	Hard rubber				30			
S	High temp. alloys	Fe based	Annealed		200	31	30-60	0.06-0.14
			Cured		280	32	20-50	0.06-0.14
		Ni or Co based	Annealed		250	33	20-50	0.06-0.14
			Cured		350	34	20-50	0.06-0.14
			Cast		320	35	20-50	0.06-0.14
	Titanium and Ti alloys		Rm 400		36	20-50	0.06-0.12	
		Alpa+bata alloys cured	Rm 1050		37	20-50	0.06-0.12	
H	Hardened steel	Hardened		55HRC	38			
		Hardened		60HRC	39			
	Chilled cast iron	Cast		400	40			
	Cast iron nodular (GGG)	Hardened		55HRC	41			

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

# CONTACT US



## MEGA TECH METALWORK CO.,LTD ( Headquarter )



**Tel : 02-943-1591**



**Fax : 02-943-1592**



**Line ID : @mgt\_metalwork**



**Email : sales.m@mgtg.co.th**



**Web : <https://www.mgtg.co.th/>**



**17/4 Soi Ramintra 89  
Ramintra Khannayao  
Bangkok 10230**

