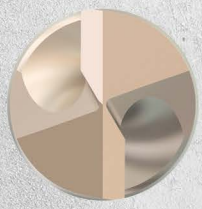
NEW PRODUCT NEWS

mgt
MEGA TECH METALWORK

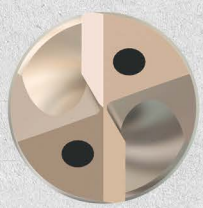
Taegutec Hole Making Line

Multipurpose Solid Carbide Drills

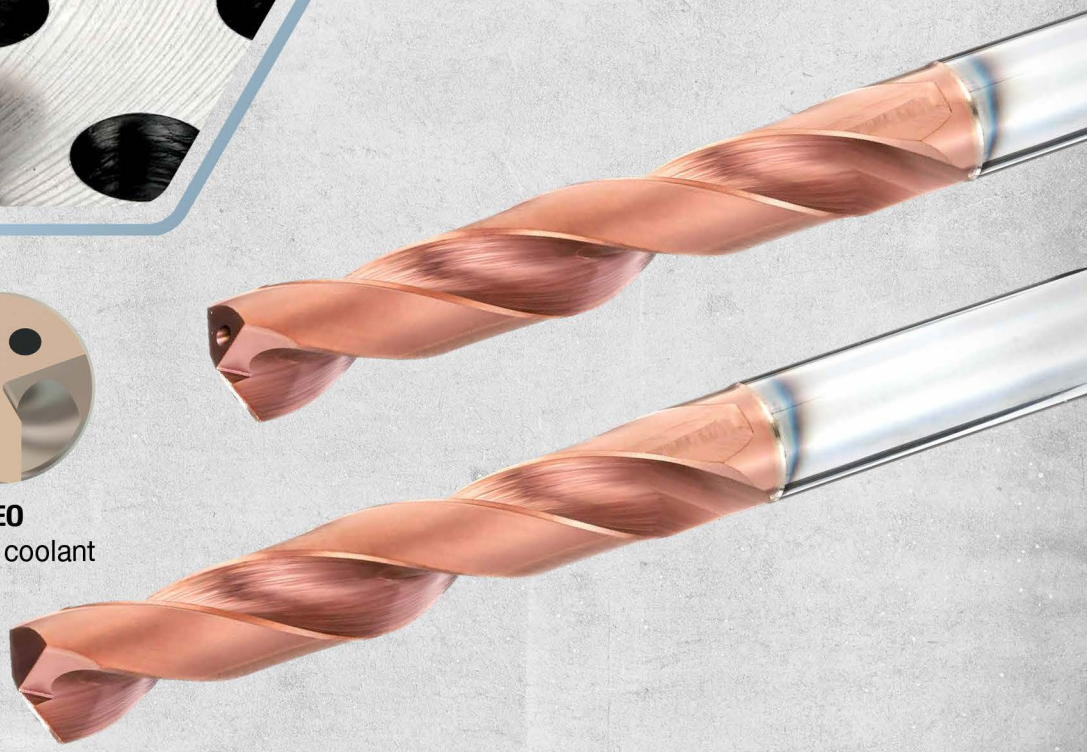
new



TED
External coolant



TEO
Internal coolant



ADVANCECUTTING
TaeguTec

TaeguTec
Member IMC Group

NEW PRODUCT NEWS

Taegutec Hole Making Line

MEGA TECH METALWORK

KEY POINT

TaeguTec has introduced a new line of solid carbide drills, featuring the essential aspects of drilling.

TaeguTec's new solid carbide drill line offers greater versatility compared to the competition, delivering stable machining performance and excellent tool life across various materials.

The new line is available in diameters ranging from 3.0 to 12.0 mm, with drilling depths of 3xD and 5xD.

For further details, please contact the product manager.

Features

- 2 flute straight cutting edge for ideal drilling
- Superior machining tolerance enabling mass production
- Internal and external coolant type drills available
  - -TED drills: external coolant type
  - -TEO drills: internal coolant type
- Diameter range: 3.0-12.0 mm (in 0.1 mm increments)
- Drilling depths: 3xD (S type) and 5xD (R type)

Designation system

TED S051-6 TT5130

1 2 3 4 5

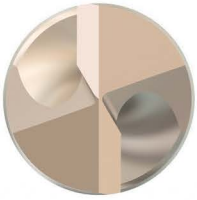
1 Drill type — TED: External coolant
TEO: Internal coolant

2 Drilling depth — S: 3xD
R: 5xD

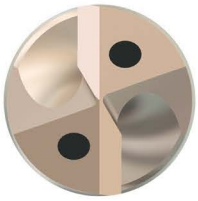
3 Drill diameter

4 Shank diameter

5 Grade



TED
External coolant



TEO
Internal coolant

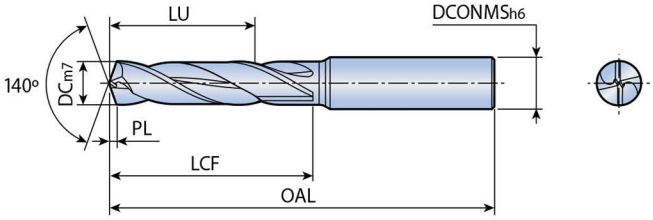
S type: 3xD

R type: 5xD

TED S

Solid carbide drills without oil holes

• Drilling depth: 3xdiameter



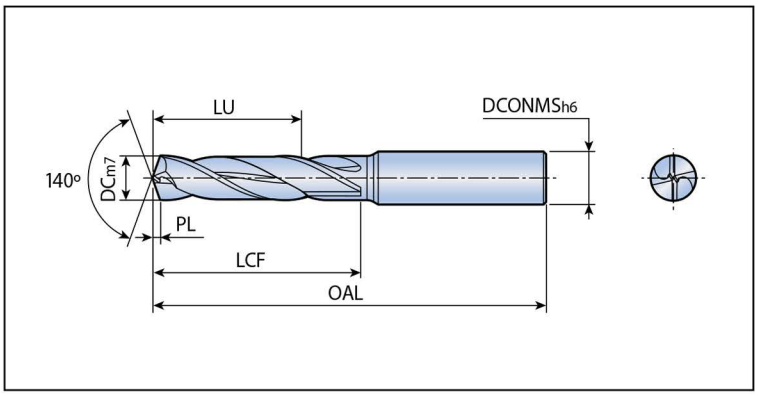
Designation	Dimension (mm)						Grade
	DC	DCONMS	OAL	LU	LCF	PL	TT5130
TED S030-4	3.0	4	62	11	18	0.5	●
S031-4	3.1	4	62	11	18	0.5	●
S032-4	3.2	4	62	11	18	0.5	●
S033-4	3.3	4	62	11	18	0.5	●
S034-4	3.4	4	62	11	18	0.5	●
S035-4	3.5	4	62	11	18	0.6	●
S036-4	3.6	4	62	11	18	0.6	●
S037-4	3.7	4	62	11	18	0.6	●
S038-4	3.8	4	66	10	18	0.6	●
S039-4	3.9	4	66	10	18	0.6	●
S040-4	4.0	4	66	10	18	0.6	●
S041-5	4.1	5	66	19	27	0.7	●
S042-5	4.2	5	66	19	27	0.7	●
S043-5	4.3	5	66	19	27	0.7	●
S044-5	4.4	5	66	19	27	0.7	●
S045-5	4.5	5	66	19	27	0.7	●
S046-5	4.6	5	66	19	27	0.8	●
S047-5	4.7	5	66	19	27	0.8	●
S048-5	4.8	5	66	18	27	0.8	●
S049-5	4.9	5	66	18	27	0.8	●
S050-5	5.0	5	66	18	27	0.8	●
S051-6	5.1	6	66	22	31	0.8	●
S052-6	5.2	6	66	22	31	0.8	●
S053-6	5.3	6	66	22	31	0.8	●
S054-6	5.4	6	66	22	31	0.8	●
S055-6	5.5	6	66	22	31	0.9	●
S056-6	5.6	6	66	22	31	0.9	●
S057-6	5.7	6	66	22	31	0.9	●
S058-6	5.8	6	66	22	31	0.9	●
S059-6	5.9	6	66	22	31	0.9	●
S060-6	6.0	6	66	22	31	0.9	●
S061-7	6.1	7	79	26	37	1.0	●
S062-7	6.2	7	79	26	37	1.0	●
S063-7	6.3	7	79	26	37	1.0	●

●: Standard items

TED S

Solid carbide drills without oil holes

- Drilling depth: 3xdiameter



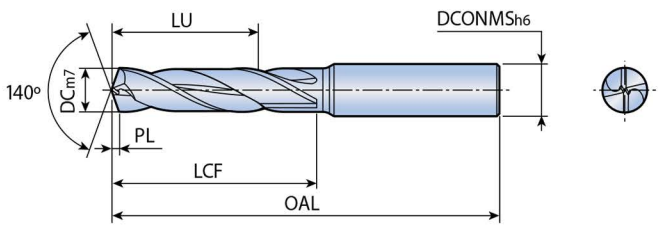
Designation	Dimension (mm)						Grade
	DC	DCONMS	OAL	LU	LCF	PL	TT5130
TED S064-7	6.4	7	79	26	37	1.0	●
S065-7	6.5	7	79	26	37	1.0	●
S066-7	6.6	7	79	26	37	1.0	●
S067-7	6.7	7	79	26	37	1.1	●
S068-7	6.8	7	79	26	37	1.1	●
S069-7	6.9	7	79	26	37	1.1	●
S070-7	7.0	7	79	26	37	1.1	●
S071-8	7.1	8	79	28	41	1.1	●
S072-8	7.2	8	79	28	41	1.1	●
S073-8	7.3	8	79	28	41	1.1	●
S074-8	7.4	8	79	28	41	1.2	●
S075-8	7.5	8	79	28	41	1.2	●
S076-8	7.6	8	79	28	41	1.2	●
S077-8	7.7	8	79	28	41	1.2	●
S078-8	7.8	8	79	28	41	1.2	●
S079-8	7.9	8	79	28	41	1.3	●
S080-8	8.0	8	79	28	41	1.3	●
S081-9	8.1	9	89	32	45	1.3	●
S082-9	8.2	9	89	32	45	1.3	●
S083-9	8.3	9	89	32	45	1.3	●
S084-9	8.4	9	89	32	45	1.3	●
S085-9	8.5	9	89	32	45	1.3	●
S086-9	8.6	9	89	32	45	1.4	●
S087-9	8.7	9	89	32	45	1.4	●
S088-9	8.8	9	89	32	45	1.4	●
S089-9	8.9	9	89	32	45	1.4	●
S090-9	9.0	9	89	32	45	1.4	●
S091-10	9.1	10	89	35	48	1.4	●
S092-10	9.2	10	89	35	48	1.4	●
S093-10	9.3	10	89	35	48	1.5	●
S094-10	9.4	10	89	35	48	1.5	●
S095-10	9.5	10	89	35	48	1.5	●
S096-10	9.6	10	89	35	48	1.5	●
S097-10	9.7	10	89	35	48	1.5	●

●: Standard items

TED S

Solid carbide drills without oil holes

• Drilling depth: 3xdiameter

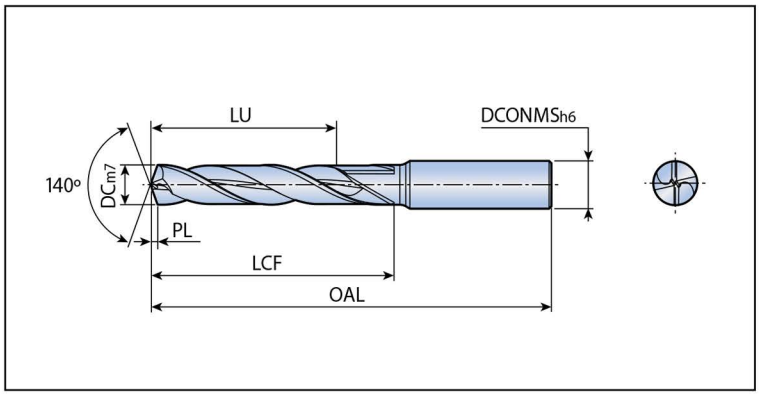


Designation	Dimension (mm)						Grade
	DC	DCONMS	OAL	LU	LCF	PL	TT5130
TED S098-10	9.8	10	89	35	48	1.6	●
S099-10	9.9	10	89	35	48	1.6	●
S100-10	10.0	10	89	35	48	1.6	●
S101-11	10.1	11	102	36	50	1.6	●
S102-11	10.2	11	102	36	50	1.6	●
S103-11	10.3	11	102	36	50	1.6	●
S104-11	10.4	11	102	36	50	1.6	●
S105-11	10.5	11	102	36	50	1.6	●
S106-11	10.6	11	102	36	50	1.7	●
S107-11	10.7	11	102	36	50	1.7	●
S108-11	10.8	11	102	36	50	1.7	●
S109-11	10.9	11	102	36	50	1.7	●
S110-11	11.0	11	102	36	50	1.7	●
S111-12	11.1	12	102	42	57	1.7	●
S112-12	11.2	12	102	42	57	1.8	●
S113-12	11.3	12	102	42	57	1.8	●
S114-12	11.4	12	102	42	57	1.8	●
S115-12	11.5	12	102	42	57	1.8	●
S116-12	11.6	12	102	42	57	1.8	●
S117-12	11.7	12	102	42	57	1.9	●
S118-12	11.8	12	102	42	57	1.9	●
S119-12	11.9	12	102	42	57	1.9	●
S120-12	12.0	12	102	42	57	1.9	●

●: Standard items

TED R

Solid carbide drills without oil holes



- Drilling depth: 5xdiameter

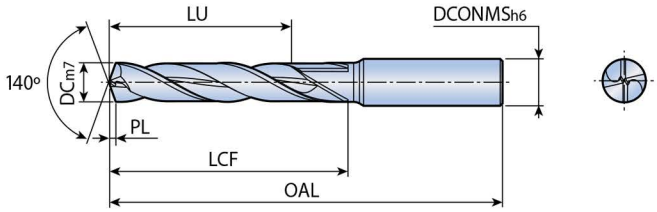
Designation	Dimension (mm)						Grade
	DC	DCONMS	OAL	LU	LCF	PL	TT5130
TED R030-4	3.0	4	66	24	30	0.5	●
R031-4	3.1	4	66	24	30	0.5	●
R032-4	3.2	4	66	24	30	0.5	●
R033-4	3.3	4	66	24	30	0.5	●
R034-4	3.4	4	66	24	30	0.5	●
R035-4	3.5	4	66	24	30	0.6	●
R036-4	3.6	4	66	24	30	0.6	●
R037-4	3.7	4	66	24	30	0.6	●
R038-4	3.8	4	74	22	30	0.6	●
R039-4	3.9	4	74	22	30	0.6	●
R040-4	4.0	4	74	22	30	0.6	●
R041-5	4.1	5	74	32	40	0.7	●
R042-5	4.2	5	74	32	40	0.7	●
R043-5	4.3	5	74	32	40	0.7	●
R044-5	4.4	5	74	32	40	0.7	●
R045-5	4.5	5	74	32	40	0.7	●
R046-5	4.6	5	74	32	40	0.7	●
R047-5	4.7	5	74	32	40	0.8	●
R048-5	4.8	5	82	30	40	0.8	●
R049-5	4.9	5	82	30	40	0.8	●
R050-5	5.0	5	82	30	40	0.8	●
R051-6	5.1	6	82	35	45	0.8	●
R052-6	5.2	6	82	35	45	0.8	●
R053-6	5.3	6	82	35	45	0.8	●
R054-6	5.4	6	82	35	45	0.8	●
R055-6	5.5	6	82	35	45	0.9	●
R056-6	5.6	6	82	35	45	0.9	●
R057-6	5.7	6	82	35	45	0.9	●
R058-6	5.8	6	82	35	45	0.9	●
R059-6	5.9	6	82	35	45	0.9	●
R060-6	6.0	6	82	35	45	0.9	●
R061-7	6.1	7	91	37	48	1.0	●
R062-7	6.2	7	91	37	48	1.0	●
R063-7	6.3	7	91	37	48	1.0	●

●: Standard items

TED R

Solid carbide drills without oil holes

• Drilling depth: 5xdiameter



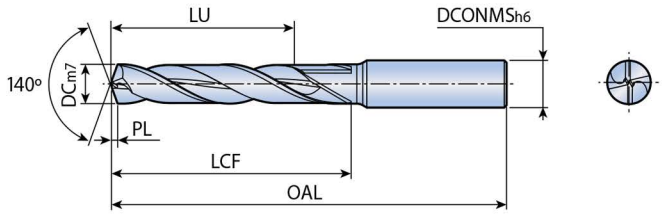
Designation	Dimension (mm)						Grade
	DC	DCONMS	OAL	LU	LCF	PL	TT5130
TED R064-7	6.4	7	91	37	48	1.0	●
R065-7	6.5	7	91	37	48	1.0	●
R066-7	6.6	7	91	37	48	1.0	●
R067-7	6.7	7	91	37	48	1.1	●
R068-7	6.8	7	91	37	48	1.1	●
R069-7	6.9	7	91	37	48	1.1	●
R070-7	7.0	7	91	37	48	1.1	●
R071-8	7.1	8	91	42	53	1.1	●
R072-8	7.2	8	91	42	53	1.1	●
R073-8	7.3	8	91	42	53	1.1	●
R074-8	7.4	8	91	42	53	1.2	●
R075-8	7.5	8	91	42	53	1.2	●
R076-8	7.6	8	91	42	53	1.2	●
R077-8	7.7	8	91	42	53	1.2	●
R078-8	7.8	8	91	42	53	1.2	●
R079-8	7.9	8	91	42	53	1.3	●
R080-8	8.0	8	91	42	53	1.3	●
R081-9	8.1	9	103	46	59	1.3	●
R082-9	8.2	9	103	46	59	1.3	●
R083-9	8.3	9	103	46	59	1.3	●
R084-9	8.4	9	103	46	59	1.3	●
R085-9	8.5	9	103	46	59	1.3	●
R086-9	8.6	9	103	46	59	1.4	●
R087-9	8.7	9	103	46	59	1.4	●
R088-9	8.8	9	103	46	59	1.4	●
R089-9	8.9	9	103	46	59	1.4	●
R090-9	9.0	9	103	46	59	1.4	●
R091-10	9.1	10	103	50	63	1.4	●
R092-10	9.2	10	103	50	63	1.4	●
R093-10	9.3	10	103	50	63	1.5	●
R094-10	9.4	10	103	50	63	1.5	●
R095-10	9.5	10	103	50	63	1.5	●
R096-10	9.6	10	103	50	63	1.5	●
R097-10	9.7	10	103	50	63	1.5	●

●: Standard items

TED R

Solid carbide drills without oil holes

• Drilling depth: 5xdiameter



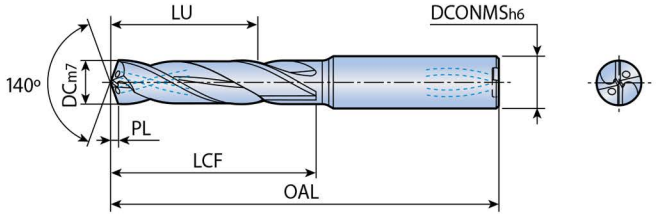
Designation	Dimension (mm)						Grade
	DC	DCONMS	OAL	LU	LCF	PL	TT5130
TED R098-10	9.8	10	103	50	63	1.6	●
R099-10	9.9	10	103	50	63	1.6	●
R100-10	10.0	10	103	50	63	1.6	●
R101-11	10.1	11	118	53	68	1.6	●
R102-11	10.2	11	118	53	68	1.6	●
R103-11	10.3	11	118	53	68	1.6	●
R104-11	10.4	11	118	53	68	1.6	●
R105-11	10.5	11	118	53	68	1.6	●
R106-11	10.6	11	118	53	68	1.7	●
R107-11	10.7	11	118	53	68	1.7	●
R108-11	10.8	11	118	53	68	1.7	●
R109-11	10.9	11	118	53	68	1.7	●
R110-11	11.0	11	118	53	68	1.7	●
R111-12	11.1	12	118	59	75	1.7	●
R112-12	11.2	12	118	59	75	1.8	●
R113-12	11.3	12	118	59	75	1.8	●
R114-12	11.4	12	118	59	75	1.8	●
R115-12	11.5	12	118	59	75	1.8	●
R116-12	11.6	12	118	59	75	1.8	●
R117-12	11.7	12	118	59	75	1.9	●
R118-12	11.8	12	118	59	75	1.9	●
R119-12	11.9	12	118	59	75	1.9	●
R120-12	12.0	12	118	59	75	1.9	●

●: Standard items

TEO S

Solid carbide drills with oil holes

• Drilling depth: 3xdiameter



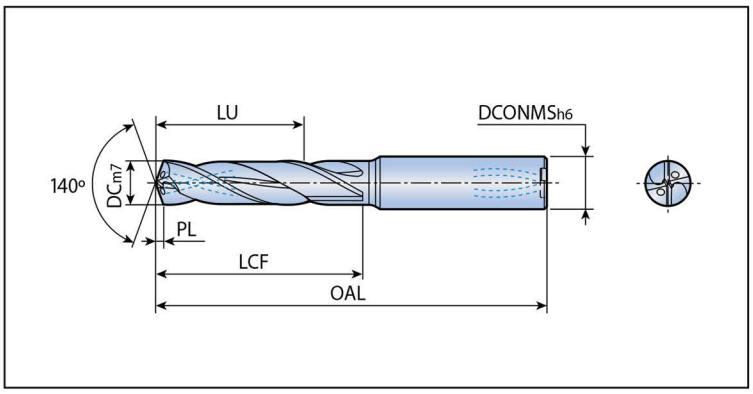
Designation	Dimension (mm)						Grade
	DC	DCONMS	OAL	LU	LCF	PL	TT5130
TEO S030-6	3.0	6	62	11	18	0.5	●
S031-6	3.1	6	62	11	18	0.5	●
S032-6	3.2	6	62	11	18	0.5	●
S033-6	3.3	6	62	11	18	0.5	●
S034-6	3.4	6	62	11	18	0.5	●
S035-6	3.5	6	62	11	18	0.6	●
S036-6	3.6	6	62	11	18	0.6	●
S037-6	3.7	6	62	11	18	0.6	●
S038-6	3.8	6	66	10	18	0.6	●
S039-6	3.9	6	66	10	18	0.6	●
S040-6	4.0	6	66	10	18	0.6	●
S041-6	4.1	6	66	19	27	0.7	●
S042-6	4.2	6	66	19	27	0.7	●
S043-6	4.3	6	66	19	27	0.7	●
S044-6	4.4	6	66	19	27	0.7	●
S045-6	4.5	6	66	19	27	0.7	●
S046-6	4.6	6	66	19	27	0.8	●
S047-6	4.7	6	66	19	27	0.8	●
S048-6	4.8	6	66	18	27	0.8	●
S049-6	4.9	6	66	18	27	0.8	●
S050-6	5.0	6	66	18	27	0.8	●
S051-6	5.1	6	66	22	31	0.8	●
S052-6	5.2	6	66	22	31	0.8	●
S053-6	5.3	6	66	22	31	0.8	●
S054-6	5.4	6	66	22	31	0.8	●
S055-6	5.5	6	66	22	31	0.9	●
S056-6	5.6	6	66	22	31	0.9	●
S057-6	5.7	6	66	22	31	0.9	●
S058-6	5.8	6	66	22	31	0.9	●
S059-6	5.9	6	66	22	31	0.9	●
S060-6	6.0	6	66	22	31	0.9	●
S061-7	6.1	7	79	26	37	1.0	●
S062-7	6.2	7	79	26	37	1.0	●
S063-7	6.3	7	79	26	37	1.0	●

●: Standard items

TEO S

Solid carbide drills with oil holes

• Drilling depth: 3xdiameter

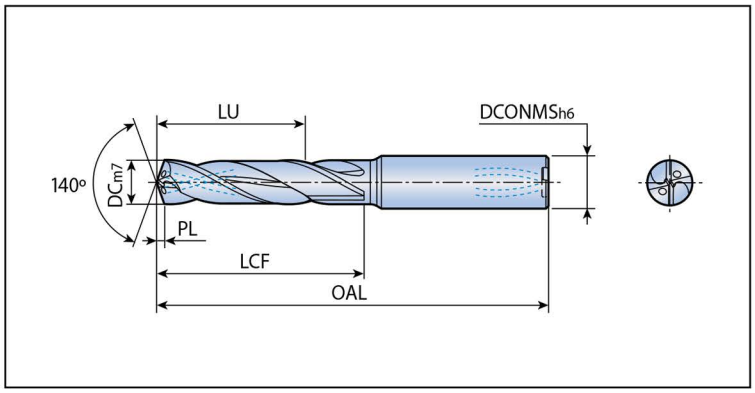


Designation	Dimension (mm)						Grade
	DC	DCONMS	OAL	LU	LCF	PL	TT5130
TEO S064-7	6.4	7	79	26	37	1.0	●
S065-7	6.5	7	79	26	37	1.0	●
S066-7	6.6	7	79	26	37	1.0	●
S067-7	6.7	7	79	26	37	1.1	●
S068-7	6.8	7	79	26	37	1.1	●
S069-7	6.9	7	79	26	37	1.1	●
S070-7	7.0	7	79	26	37	1.1	●
S071-8	7.1	8	79	28	41	1.1	●
S072-8	7.2	8	79	28	41	1.1	●
S073-8	7.3	8	79	28	41	1.1	●
S074-8	7.4	8	79	28	41	1.2	●
S075-8	7.5	8	79	28	41	1.2	●
S076-8	7.6	8	79	28	41	1.2	●
S077-8	7.7	8	79	28	41	1.2	●
S078-8	7.8	8	79	28	41	1.2	●
S079-8	7.9	8	79	28	41	1.3	●
S080-8	8.0	8	79	28	41	1.3	●
S081-9	8.1	9	89	32	45	1.3	●
S082-9	8.2	9	89	32	45	1.3	●
S083-9	8.3	9	89	32	45	1.3	●
S084-9	8.4	9	89	32	45	1.3	●
S085-9	8.5	9	89	32	45	1.3	●
S086-9	8.6	9	89	32	45	1.4	●
S087-9	8.7	9	89	32	45	1.4	●
S088-9	8.8	9	89	32	45	1.4	●
S089-9	8.9	9	89	32	45	1.4	●
S090-9	9.0	9	89	32	45	1.4	●
S091-10	9.1	10	89	35	48	1.4	●
S092-10	9.2	10	89	35	48	1.4	●
S093-10	9.3	10	89	35	48	1.5	●
S094-10	9.4	10	89	35	48	1.5	●
S095-10	9.5	10	89	35	48	1.5	●
S096-10	9.6	10	89	35	48	1.5	●
S097-10	9.7	10	89	35	48	1.5	●

●: Standard items

TEO S

Solid carbide drills with oil holes



• Drilling depth: 3xdiameter

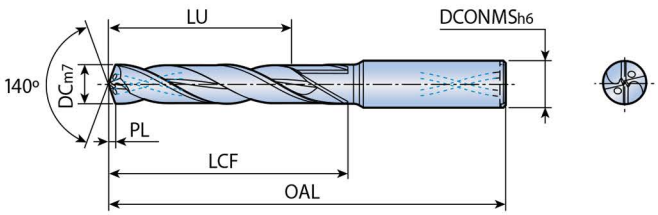
Designation	Dimension (mm)						Grade
	DC	DCONMS	OAL	LU	LCF	PL	TT5130
TEO S098-10	9.8	10	89	35	48	1.6	●
S099-10	9.9	10	89	35	48	1.6	●
S100-10	10.0	10	89	35	48	1.6	●
S101-11	10.1	11	102	36	50	1.6	●
S102-11	10.2	11	102	36	50	1.6	●
S103-11	10.3	11	102	36	50	1.6	●
S104-11	10.4	11	102	36	50	1.6	●
S105-11	10.5	11	102	36	50	1.6	●
S106-11	10.6	11	102	36	50	1.7	●
S107-11	10.7	11	102	36	50	1.7	●
S108-11	10.8	11	102	36	50	1.7	●
S109-11	10.9	11	102	36	50	1.7	●
S110-11	11.0	11	102	36	50	1.7	●
S111-12	11.1	12	102	42	57	1.7	●
S112-12	11.2	12	102	42	57	1.8	●
S113-12	11.3	12	102	42	57	1.8	●
S114-12	11.4	12	102	42	57	1.8	●
S115-12	11.5	12	102	42	57	1.8	●
S116-12	11.6	12	102	42	57	1.8	●
S117-12	11.7	12	102	42	57	1.9	●
S118-12	11.8	12	102	42	57	1.9	●
S119-12	11.9	12	102	42	57	1.9	●
S120-12	12.0	12	102	42	57	1.9	●

●: Standard items

TEO R

Solid carbide drills with oil holes

• Drilling depth: 5xdiameter



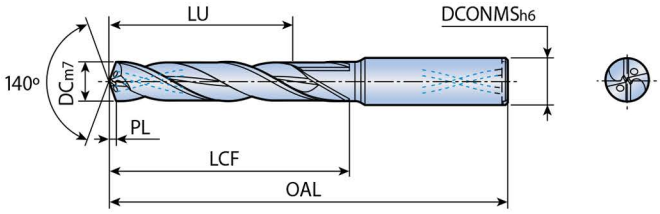
Designation	Dimension (mm)						Grade
	DC	DCONMS	OAL	LU	LCF	PL	TT5130
TEO R030-6	3.0	6	66	24	30	0.5	•
R031-6	3.1	6	66	24	30	0.5	•
R032-6	3.2	6	66	24	30	0.5	•
R033-6	3.3	6	66	24	30	0.5	•
R034-6	3.4	6	66	24	30	0.5	•
R035-6	3.5	6	66	24	30	0.6	•
R036-6	3.6	6	66	24	30	0.6	•
R037-6	3.7	6	66	24	30	0.6	•
R038-6	3.8	6	74	22	30	0.6	•
R039-6	3.9	6	74	22	30	0.6	•
R040-6	4.0	6	74	22	30	0.6	•
R041-6	4.1	6	74	32	40	0.7	•
R042-6	4.2	6	74	32	40	0.7	•
R043-6	4.3	6	74	32	40	0.7	•
R044-6	4.4	6	74	32	40	0.7	•
R045-6	4.5	6	74	32	40	0.7	•
R046-6	4.6	6	74	32	40	0.7	•
R047-6	4.7	6	74	32	40	0.8	•
R048-6	4.8	6	82	30	40	0.8	•
R049-6	4.9	6	82	30	40	0.8	•
R050-6	5.0	6	82	30	40	0.8	•
R051-6	5.1	6	82	35	45	0.8	•
R052-6	5.2	6	82	35	45	0.8	•
R053-6	5.3	6	82	35	45	0.8	•
R054-6	5.4	6	82	35	45	0.8	•
R055-6	5.5	6	82	35	45	0.9	•
R056-6	5.6	6	82	35	45	0.9	•
R057-6	5.7	6	82	35	45	0.9	•
R058-6	5.8	6	82	35	45	0.9	•
R059-6	5.9	6	82	35	45	0.9	•
R060-6	6.0	6	82	35	45	0.9	•
R061-7	6.1	7	91	37	48	1.0	•
R062-7	6.2	7	91	37	48	1.0	•
R063-7	6.3	7	91	37	48	1.0	•

•: Standard items

TEO R

Solid carbide drills with oil holes

• Drilling depth: 5xdiameter



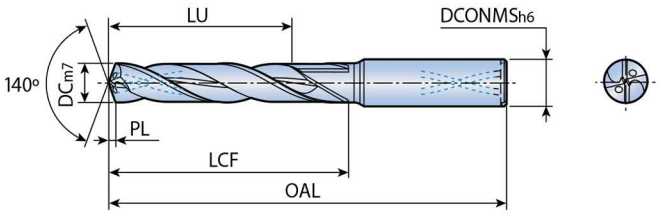
Designation	Dimension (mm)						Grade
	DC	DCONMS	OAL	LU	LCF	PL	TT5130
TEO R064-7	6.4	7	91	37	48	1.0	●
R065-7	6.5	7	91	37	48	1.0	●
R066-7	6.6	7	91	37	48	1.0	●
R067-7	6.7	7	91	37	48	1.1	●
R068-7	6.8	7	91	37	48	1.1	●
R069-7	6.9	7	91	37	48	1.1	●
R070-7	7.0	7	91	37	48	1.1	●
R071-8	7.1	8	91	42	53	1.1	●
R072-8	7.2	8	91	42	53	1.1	●
R073-8	7.3	8	91	42	53	1.1	●
R074-8	7.4	8	91	42	53	1.2	●
R075-8	7.5	8	91	42	53	1.2	●
R076-8	7.6	8	91	42	53	1.2	●
R077-8	7.7	8	91	42	53	1.2	●
R078-8	7.8	8	91	42	53	1.2	●
R079-8	7.9	8	91	42	53	1.3	●
R080-8	8.0	8	91	42	53	1.3	●
R081-9	8.1	9	103	46	59	1.3	●
R082-9	8.2	9	103	46	59	1.3	●
R083-9	8.3	9	103	46	59	1.3	●
R084-9	8.4	9	103	46	59	1.3	●
R085-9	8.5	9	103	46	59	1.3	●
R086-9	8.6	9	103	46	59	1.4	●
R087-9	8.7	9	103	46	59	1.4	●
R088-9	8.8	9	103	46	59	1.4	●
R089-9	8.9	9	103	46	59	1.4	●
R090-9	9.0	9	103	46	59	1.4	●
R091-10	9.1	10	103	50	63	1.4	●
R092-10	9.2	10	103	50	63	1.4	●
R093-10	9.3	10	103	50	63	1.5	●
R094-10	9.4	10	103	50	63	1.5	●
R095-10	9.5	10	103	50	63	1.5	●
R096-10	9.6	10	103	50	63	1.5	●
R097-10	9.7	10	103	50	63	1.5	●

●: Standard items

TEO R

Solid carbide drills with oil holes

• Drilling depth: 5xdiameter



Designation	Dimension (mm)						Grade
	DC	DCONMS	OAL	LU	LCF	PL	TT5130
TEO R098-10	9.8	10	103	50	63	1.6	●
R099-10	9.9	10	103	50	63	1.6	●
R100-10	10.0	10	103	50	63	1.6	●
R101-11	10.1	11	118	53	68	1.6	●
R102-11	10.2	11	118	53	68	1.6	●
R103-11	10.3	11	118	53	68	1.6	●
R104-11	10.4	11	118	53	68	1.6	●
R105-11	10.5	11	118	53	68	1.6	●
R106-11	10.6	11	118	53	68	1.7	●
R107-11	10.7	11	118	53	68	1.7	●
R108-11	10.8	11	118	53	68	1.7	●
R109-11	10.9	11	118	53	68	1.7	●
R110-11	11.0	11	118	53	68	1.7	●
R111-12	11.1	12	118	59	75	1.7	●
R112-12	11.2	12	118	59	75	1.8	●
R113-12	11.3	12	118	59	75	1.8	●
R114-12	11.4	12	118	59	75	1.8	●
R115-12	11.5	12	118	59	75	1.8	●
R116-12	11.6	12	118	59	75	1.8	●
R117-12	11.7	12	118	59	75	1.9	●
R118-12	11.8	12	118	59	75	1.9	●
R119-12	11.9	12	118	59	75	1.9	●
R120-12	12.0	12	118	59	75	1.9	●

●: Standard items

Recommended cutting conditions

Cutting data for TED / TEO

ISO	Material		Condition	Tensile Strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc(m/min)	Feed (mm/rev) vs. drill diameter		
								Ø3 - Ø5	Ø5.1 - Ø8	Ø8.1 - Ø12
P	Non-alloy steel and cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	80-120	0.10-0.20	0.15-0.25	0.20-0.30
		>=0.25%C	Annealed	650	190	2	80-110	0.10-0.20	0.15-0.25	0.20-0.30
		<0.55%C	Quenched and tempered	850	250	3	70-100	0.10-0.20	0.15-0.25	0.20-0.30
		>=0.55%C	Annealed	750	220	4	70-100	0.10-0.20	0.15-0.25	0.20-0.30
			Quenched and tempered	1000	300	5	70-100	0.10-0.20	0.15-0.25	0.20-0.30
	Low alloy steel and cast steel (less than 5% of alloying elements)		Annealed	600	200	6	70-90	0.10-0.20	0.15-0.25	0.20-0.30
			Quenched and tempered	930	275	7	70-90	0.10-0.20	0.15-0.25	0.20-0.30
				1000	300	8	50-80	0.10-0.20	0.15-0.25	0.20-0.30
				1200	350	9	40-70	0.10-0.20	0.15-0.25	0.20-0.30
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	50-80	0.08-0.18	0.10-0.20	0.15-0.25
			Quenched and tempered	1100	325	11	40-70	0.08-0.18	0.10-0.20	0.15-0.25
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	30-60	0.06-0.12	0.10-0.15	0.12-0.18
			Martensitic	820	240	13	30-60	0.06-0.12	0.10-0.15	0.12-0.18
			Austenitic	600	180	14	30-60	0.06-0.12	0.10-0.15	0.12-0.18
K	Grey cast iron (GG)		Ferritic / pearlitic		160	15	65-80	0.10-0.20	0.15-0.25	0.20-0.30
			Pearlitic		250	16	65-80	0.10-0.20	0.15-0.25	0.20-0.30
	Cast iron nodular (GGG)		Ferritic		180	17	85-105	0.10-0.20	0.15-0.25	0.20-0.30
			Pearlitic		260	18	75-90	0.10-0.20	0.15-0.25	0.20-0.30
	Malleable cast iron		Ferritic		130	19	65-80	0.10-0.20	0.15-0.25	0.20-0.30
			Pearlitic		230	20	65-80	0.10-0.20	0.15-0.25	0.20-0.30
N	Aluminum-wrought alloy		Not cureable		60	21	70-200	0.10-0.25	0.15-0.35	0.25-0.45
			Cured		100	22	70-200	0.10-0.25	0.15-0.35	0.25-0.45
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	70-200	0.10-0.25	0.15-0.35	0.25-0.45
			Cured		90	24	70-200	0.10-0.25	0.15-0.35	0.25-0.45
		>12% Si	High temperature		130	25	70-150	0.10-0.25	0.15-0.35	0.25-0.45
	Copper alloys	>1% Pb	Free cutting		110	26	70-200	0.08-0.18	0.15-0.25	0.20-0.35
			Brass		90	27	70-200	0.08-0.18	0.15-0.25	0.20-0.35
			Electrolitic copper		100	28	70-200	0.08-0.18	0.15-0.25	0.20-0.35
	Non-metallic		Duroplastics, fiber plastics		70 Shore D	29				
			Hard rubber		55 Shore D	30				
S	High temp. alloys	Fe based	Annealed		200	31	15-40	0.02-0.08	0.04-0.10	0.06-0.12
			Cured		280	32	15-40	0.02-0.08	0.04-0.10	0.06-0.12
		Ni or Co based	Annealed		250	33	15-40	0.02-0.08	0.04-0.10	0.06-0.12
			Cured		350	34	15-40	0.02-0.08	0.04-0.10	0.06-0.12
			Cast		320	35	15-40	0.02-0.08	0.04-0.10	0.06-0.12
	Titanium and Ti alloys		Pure	Rm 400	190	36				
			Alpa+bata alloys cured	Rm 1050	310	37				
H	Hardened steel		Hardened		55HRC	38	10-40	0.02-0.08	0.04-0.10	0.06-0.12
			Hardened		60HRC	39	10-40	0.02-0.08	0.04-0.10	0.06-0.12
	Chilled cast iron		Cast		400	40				
	Cast iron nodular (GGG)		Hardened		55HRC	41				

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

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