



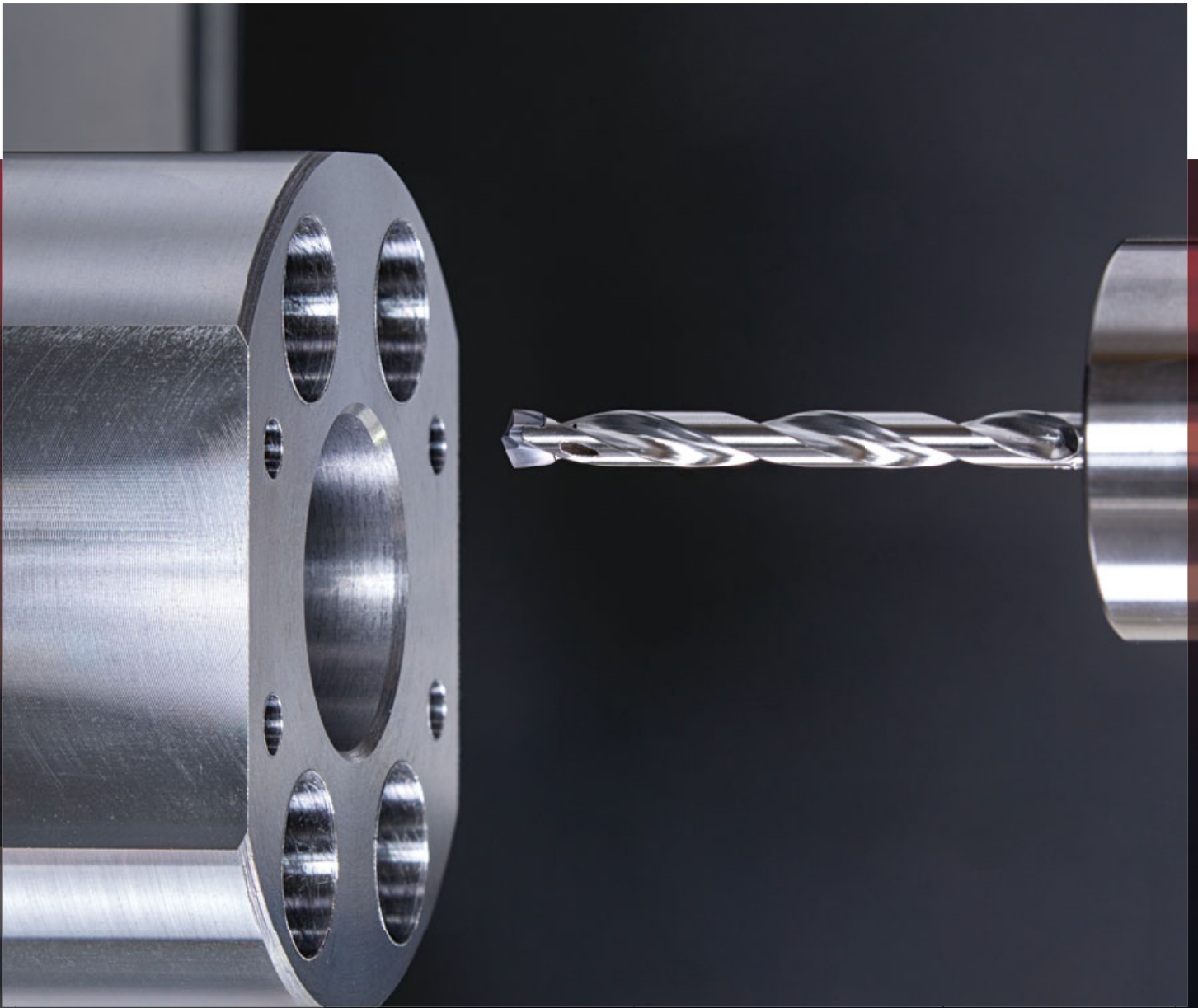
For more information

Exchangeable head drill

ADD M^{EISTER} DRILL

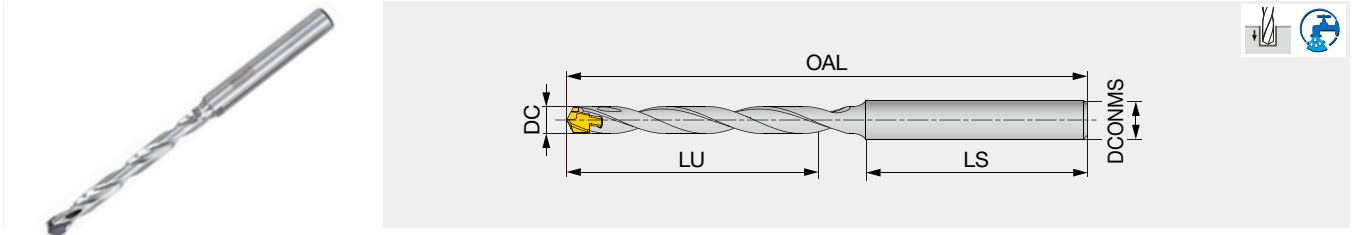
Tungaloy Report No. 412S13-G

Expansion of **L/D = 8** drill bodies



TID-R L/D=8

Exchangeable head drill, L/D = 8, Cylindrical shank



Designation	DC	DCONMS	LU	LS	OAL		Pocket size	Head
					DMP	DMC		
TID045R06-8	4.5 - 4.9	6	37	35	82.2	82.4	4.5	DM*045 - DM*049
TID050R06-8	5 - 5.4	6	41	35	86.3	86.6	5	DM*045 - DM*049
TID055R06-8	5.5 - 5.9	6	45	35	90.7	91	5.5	DM*045 - DM*049

Tool diameter	Hole diameter tolerance*
ø4.5 - ø5.9	+0.05 / 0

- An overall length (OAL) differs based on each head geometry.
- When using the drill at a higher feed rate, make sure to provide an axial support by placing the overhang adjusting screw at the drill shank end in the tool holder. This will prevent high thrust force from pushing the drill back into the holder during drilling.
- When axially adjusting the shank inside the holder to obtain a required drill overhang, make sure the shank length remaining inside the holder does not come short of the minimum clamping length (LSCN) specified by the holder supplier.
- DMC drill heads are recommended when using 8xD bodies.

*Just for reference

SPARE PARTS

Designation	Clamping key
TID045...	K-TID4-4.99
TID050..., TID055...	K-TID5-5.99

STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Hardness	Cutting speed Vc (m/min)	Feed: f (mm/rev)	
				Tool diameter: DC (mm)	
				ø4.5 - 4.9	ø5 - 5.9
P	Low carbon steels (C < 0.3) SS400, SM490, S25C, etc. C15E4, E275A, E355D, etc.	- 200 HB	80 - 140	0.04 - 0.08	0.07 - 0.13
	High carbon steels (C > 0.3) S45C, S55C, etc. C45, C55, etc.	- 300 HB	70 - 120	0.04 - 0.08	0.07 - 0.13
	Low alloy steels SCM415, etc. 18CrMo4, etc.	- 200 HB	70 - 120	0.05 - 0.08	0.07 - 0.13
	Alloy steels SCM440, SCr420, etc. 42CrMo4, 20Cr4, etc.	- 300 HB	40 - 90	0.05 - 0.08	0.07 - 0.13
M	Stainless steels SUS304, SUS316, etc. X5CrNi18-9, X5CrNiMo17-12-2, etc.	- 250 HB	30 - 70	-	0.04 - 0.08
K	Grey cast irons FC250, etc. GG25, etc.	150 - 250 HB	80 - 180	0.04 - 0.08	0.1 - 0.15
	Ductile cast irons FCD700, etc. GGG70, etc.	150 - 250 HB	80 - 140	0.04 - 0.08	0.1 - 0.15
N	Aluminium alloys ADC12, etc. AISi11Cu3, etc.	-	80 - 220	-	-
S	Titanium alloys Ti-6Al-4V, etc.	- 40 HRC	20 - 50	-	-
	Nickel-based alloys	- 40 HRC	20 - 50	-	-
H	Hardened steel	- 50 HRC	20 - 50	-	-



tungaloy.com

follow us at:
facebook.com/tungaloyjapan
twitter.com/tungaloyjapan
www.youtube.com/tungaloycorporation

Distributed by:



Tungaloy APP & SNS

FIND US ON THE CLOUD!
machingcloud.com



AS9100 Certified
78006
2015.11.04
ISO 14001 Certified
EC97J1123
1997.11.26