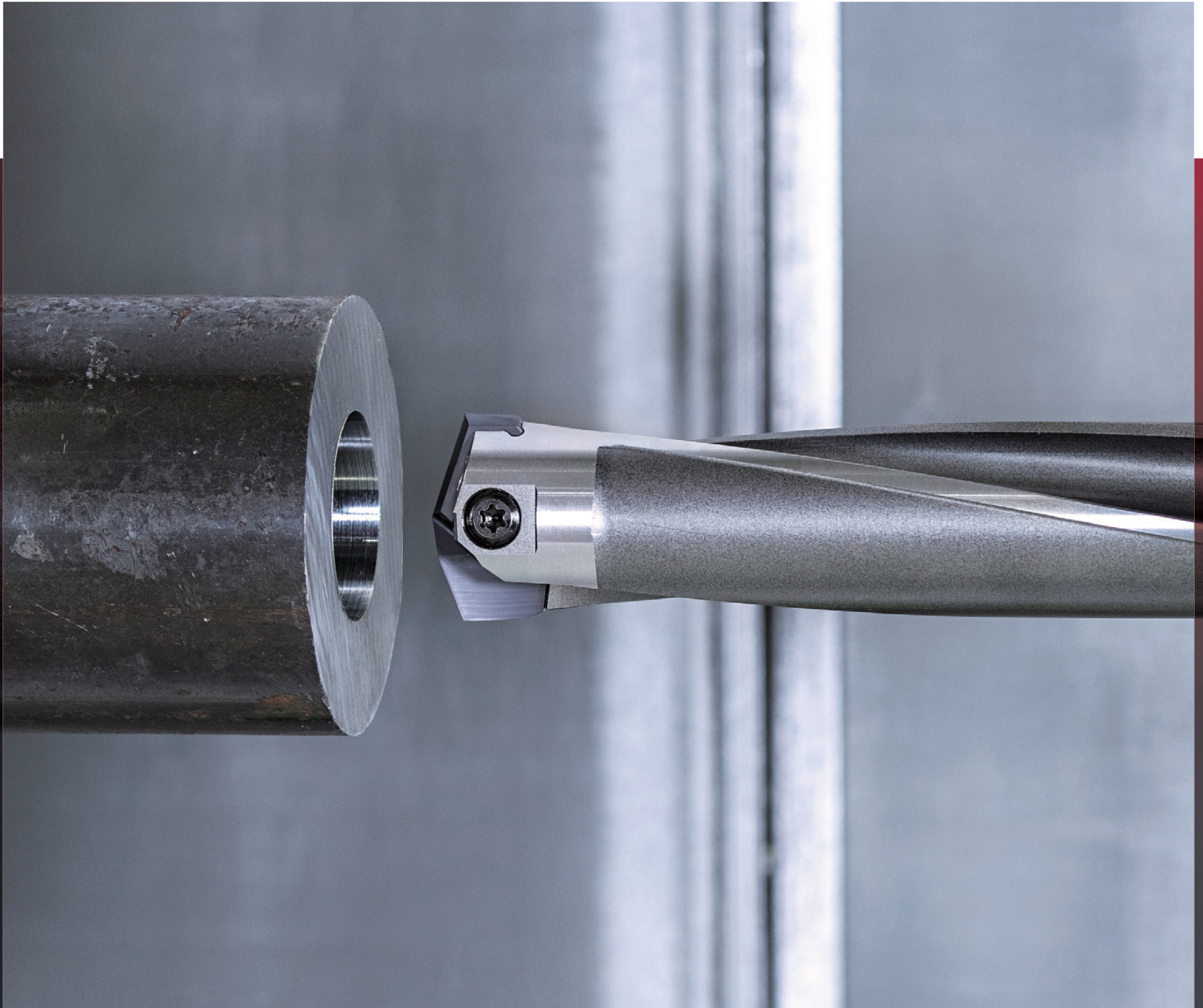


Exchangeable head drill

DRILL^{ORCE}**MEISTER**

Tungaloy Report No. 509S4-US

Expansion of new 8xD drill bodies





For more information

Lineup



L/D = 3

Drill dia. range:
ø20 - ø41 mm
(ø1.024" - ø1.614")



L/D = 5

Drill dia. range:
ø20 - ø41 mm
(ø1.024" - ø1.614")

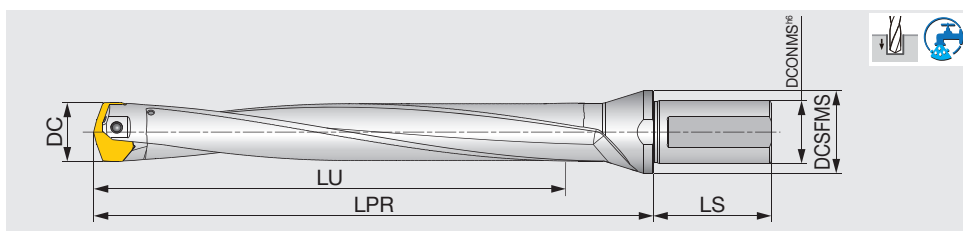


L/D = 8

Drill dia. range:
ø26 - ø41 mm

TIS L/D=8

Exchangeable head drill



	Metric	DC	DCSFMS	DCONMS	LU	LPR	LS	Pocket size	Head
	TIS260F32-8	26 - 26.9	40	32	212	247	60	26	SM*26*
	TIS270F32-8	27 - 27.9	40	32	220.2	255	60	27	SM*27*
New	TIS280F32-8	28 - 28.9	40	32	228.4	268.4	60	28	SM*28*
	TIS290F32-8	29 - 29.9	40	32	236.5	276.4	60	29	SM*29*
	TIS300F32-8	30 - 30.9	42	32	244.7	284.7	60	30	SM*30*
New	TIS310F32-8	31 - 31.9	42	32	252.9	292.7	60	31	SM*31*
	TIS320F40-8	32 - 32.9	48	40	261	303.7	68	32	SM*32*
	TIS330F40-8	33 - 33.9	48	40	269.2	311	68	33	SM*33*
New	TIS340F40-8	34 - 34.9	48	40	277.3	319	68	34	SM*34*
New	TIS350F40-8	35 - 35.9	48	40	285.4	327.4	68	35	SM*35*
New	TIS360F40-8	36 - 36.9	48	40	293.6	335.4	68	36	SM*36*
New	TIS370F40-8	37 - 37.9	48	40	301.8	343.4	68	37	SM*37*
New	TIS380F40-8	38 - 38.9	50	40	309.9	356.9	68	38	SM*38*
New	TIS390F40-8	39 - 39.9	50	40	318.1	364.9	68	39	SM*39*
New	TIS400F40-8	40 - 41	50	40	326.3	372.9	68	40	SM*40*

LU, LPR: based on SMP head.

Additional tailor made bodies available in other diameters upon request.

Tool diameter	Hole diameter tolerance*
ø26 - ø29.9	+0.08 / 0
ø30 - ø41	+0.09 / 0

* Just for reference.

e-catalog



SPARE PARTS

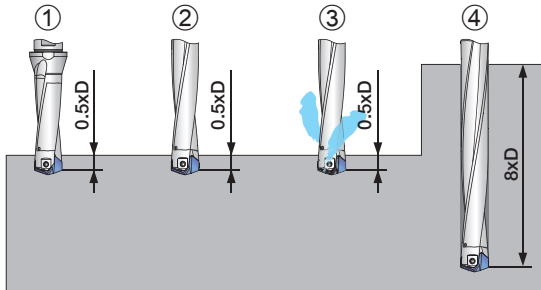


Designation	Clamping screw	Torx Bit	Wrench Grip
TIS260F32-*, TIS270F32-*	TS50230D3	BLDT20/S7	H-TB2W
TIS280F32-*, TIS290F32-*	TS50250D35	BLDT25/S7	H-TB2W
TIS300F32-*, TIS310F32-*	TS60265D4	BLDT25/S7	H-TB2W
TIS320F40-*, TIS330F40-*, TIS340F40-*	TS60285D42	BLDT25/S7	H-TB2W
TIS350F40-*, TIS360F40-*, TIS370F40-*	TS60320D5	BLDT25/S7	H-TB2W
TIS380F40-*, TIS390F40-*, TIS400F40-*	TS80340D6	BLDT25/S7	H-TB2W

Recommended clamping torque (N·m):

TS50230D3 = 5, TS50250D35 = 5.5, TS60265D4, TS60285D42, TS60320D5 = 6, TS80340D6 = 7

● Tips when using 8xD drills



- ① Drill a pilot hole in the depth of 0.5xD (3xD drill body is recommended). The same head diameter should be used for the pre-hole and the main drilling process.
- ② Rotate the drill at a low speed (eg. 100 rpm). While maintaining the drill speed, slowly feed into the pilot hole for several millimeters from the entry.
- ③ Activate the internal coolant and increase the drill rotation to the required speed.
- ④ Drill to the required depth using the recommended cutting parameters.

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Cutting speed Vc (sfm)	Feed: f (ipr)	
			ø26 - ø29.9	ø30 - ø41
P	Low carbon steel 1015, 1020, etc.	262 - 459	0.008 - 0.020	0.008 - 0.020
	Carbon steel and alloy steel 1055, 4140, etc.	262 - 427	0.008 - 0.020	0.008 - 0.020
	Prehardened steel NAK80, PX5, etc.	164 - 328	0.008 - 0.020	0.008 - 0.020
M	Stainless steel 304SS, 316SS, etc.	131 - 262	0.006 - 0.012	0.008 - 0.012
K	Gray cast iron Class 25, Class 30, etc.	262 - 591	0.010 - 0.022	0.010 - 0.022
	Ductile cast iron 60-40-18, 80-55-06, etc.	262 - 459	0.010 - 0.022	0.010 - 0.022
N	Non ferrous materials	328 - 656	0.016 - 0.024	0.016 - 0.024
S	Heat-resistant alloys Inconel718, etc.	66 - 164	0.004 - 0.008	0.004 - 0.008
	Titanium alloys Ti-6Al-4V, etc.	66 - 164	0.004 - 0.008	0.004 - 0.008
H	Hardened materials	66 - 197	0.004 - 0.008	0.004 - 0.008

Tungaloy America, Inc.

3726 N Ventura Drive, Arlington Heights, IL 60004, U.S.A.

Inside Sales: +1-888-554-8394

Technical Support: +1-888-554-8391

Fax: +1-888-554-8392

www.tungaloy.com/us

Tungaloy Canada

432 Elgin St. Unit 3, Brantford, Ontario N3S 7P7, Canada

Phone: +1-519-758-5779 Fax: +1-519-758-5791

www.tungaloy.com/ca

Tungaloy de Mexico S.A.

C Los Arellano 113, Parque Industrial Siglo XXI

Aguascalientes, AGS, Mexico 20290

Phone: +52-449-929-5410 Fax: +52-449-929-5411

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