



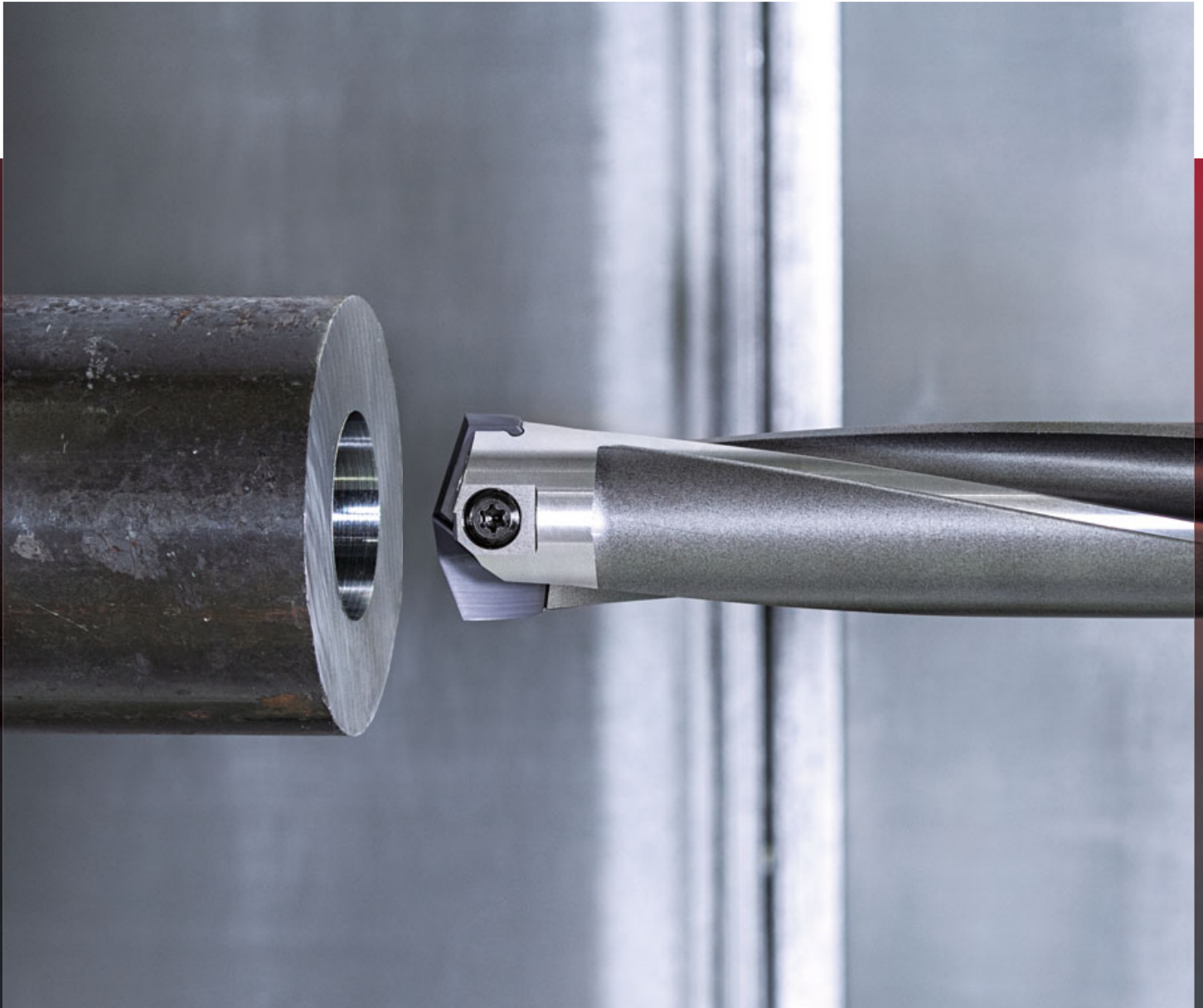
For more information

Exchangeable head drill

DRILL **F**ORCE MEISTER

Tungaloy Report No. 509S4-G

Expansion of new 8xD drill bodies



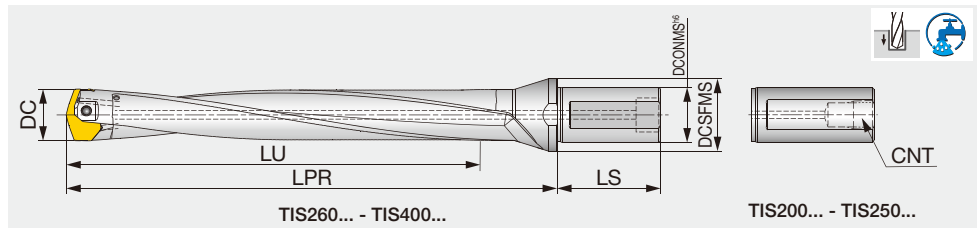
Exchangeable-head drill with 2 effective cutting edges Rigid design provides extreme reliability

Lineup



TIS L/D=8

Exchangeable head drill



Designation	DC	DCSFMS	DCONMS	LU	LPR	LS	CNT	Pocket size	Head
New TIS200F25-8	20 - 20.9	32	25	163.1	192.1	56	Rc1/4	20	SM*20*
New TIS210F25-8	21 - 21.9	32	25	171.3	200.1	56	Rc1/4	21	SM*21*
New TIS220F25-8	22 - 22.9	32	25	179.4	208.4	56	Rc1/4	22	SM*22*
New TIS230F25-8	23 - 23.9	32	25	187.6	216.4	56	Rc1/4	23	SM*23*
New TIS240F32-8	24 - 24.9	40	32	195.7	230.7	60	Rc1/4	24	SM*24*
New TIS250F32-8	25 - 25.9	40	32	203.9	238.7	60	Rc1/4	25	SM*25*
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*
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*
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*
TIS340F40-8	34 - 34.9	48	40	277.3	319	68	-	34	SM*34*
TIS350F40-8	35 - 35.9	48	40	285.4	327.4	68	-	35	SM*35*
TIS360F40-8	36 - 36.9	48	40	293.6	335.4	68	-	36	SM*36*
TIS370F40-8	37 - 37.9	48	40	301.8	343.4	68	-	37	SM*37*
TIS380F40-8	38 - 38.9	50	40	309.9	356.9	68	-	38	SM*38*
TIS390F40-8	39 - 39.9	50	40	318.1	364.9	68	-	39	SM*39*
TIS400F40-8	40 - 41	50	40	326.3	372.9	68	-	40	SM*40*

LU, LPR: based on SMP head.

Tool diameter	Hole diameter tolerance*
ø20 - ø29.9	+0.08 / 0
ø30 - ø41	+0.09 / 0

* Just for reference.

e-catalog



SPARE PARTS



Designation	Clamping screw	Wrench	
		Torx Bit	Grip
TIS200F25-*, TIS210F25-*	TS40178D25	BLDT20/S7	H-TB2W
TIS220F25-*, TIS230F25-*	TS40198D28	BLDT20/S7	H-TB2W
TIS240F32-*, TIS250F32-*	TS40210D3	BLDT20/S7	H-TB2W
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:

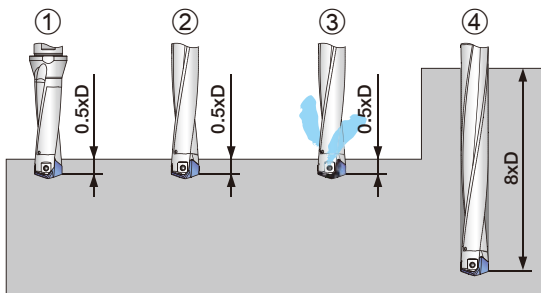
TS40178D25, TS40198D28, TS40210D3 = 4.5 N·m,

TS50230D3 = 5 N·m, TS50250D35 = 5.5 N·m,

TS60265D4, TS60285D42, TS60320D5 = 6 N·m,

TS80340D6 = 7 N·m

● 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 (m/min)	Feed: f (mm/rev)	
			ø20 - ø29.9	ø30 - ø41
P	Low carbon steel S15C, S20C, etc. C15, C20, etc.	80 - 140	0.2 - 0.5	0.2 - 0.5
	Carbon steel and alloy steel S55C, SCM440, etc. C55, 42CrMo4, etc.	80 - 130	0.2 - 0.5	0.2 - 0.5
	Prehardend steel NAK80, PX5, etc.	50 - 100	0.2 - 0.5	0.2 - 0.5
M	Stainless steel SUS304, SUS316, etc. X5CrNi18-9, X5CrNiMo17-12-3, etc.	40 - 80	0.15 - 0.3	0.2 - 0.3
K	Grey cast iron FC250, FC300, etc. 250, 300, etc.	80 - 180	0.25 - 0.55	0.25 - 0.55
	Ductile cast iron 400-15, 600-3, etc.	80 - 140	0.25 - 0.55	0.25 - 0.55
N	Non ferrous materials	100 - 200	0.4 - 0.6	0.4 - 0.6
S	Heat-resistant alloys Inconel718, etc.	20 - 50	0.1 - 0.2	0.1 - 0.2
	Titanium alloys Ti-6Al-4V, etc.	20 - 50	0.1 - 0.2	0.1 - 0.2
H	Hardened materials	20 - 60	0.1 - 0.2	0.1 - 0.2

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