

THCD SERIES

HOLEMAKING



THCD SERIES

- ◇ Precise, reliable and durable locking structure
- ◇ Different tips for processing various materials
- ◇ Excellent self-centering and chip breaking ability
- ◇ Customized drill is available

Drill Head

D12.5~D40mm

Tolerance -0.02/-0.03

Drill L/D

1D、3D、5D、7D、8D、10D、12D

| Tool diameter | Hole diameter tolerance* |
|---------------|--------------------------|
| ∅12.5-∅30 | +0.06 / 0 |
| ∅30-∅40 | +0.07 / 0 |

*Just for reference

★ When the drilling depth $L/D \geq 7$, it is recommended to use 3D THCD drill to process the 1.5D depth pilot hole.

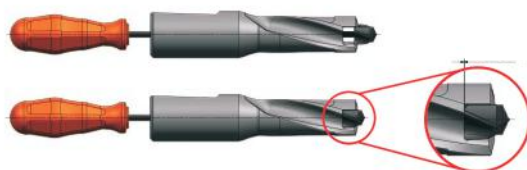
Mounting Instruction

| D(mm) | X_F (mm) |
|-------------|------------|
| 12,50-32,00 | 0 |
| 32,01-40,00 | 2 |

Start to pull THCD drill head into the pocket seat by turning the wrench clockwise until there is full contact with the bottom of the pocket seat.



Set the screw to distance X_F



NO VISUAL GAP

Application Data • Coolant

Required minimum coolant quantity in l/min. relative to coolant pressure(P)and L x D ratio.

| Drill Dia.(D) in mm | 8 bar for 1-3xD | 12 bar for 5xD | 20 bar for 7-8xD | 30 bar for 10xD | 50 bar for >10xD |
|------------------------|--------------------|-------------------|---------------------|--------------------|---------------------|
| 16.00 | 8 | 10 | 13 | 16 | 21 |
| 20.00 | 12 | 14 | 18 | 23 | 29 |
| 25.00 | 15 | 18 | 23 | 29 | 37 |
| 30.00 | 20 | 25 | 32 | 39 | 51 |
| 35.00 | 27 | 33 | 43 | 52 | 67 |
| 40.00 | 27 | 33 | 43 | 52 | 67 |



Carbide Drills

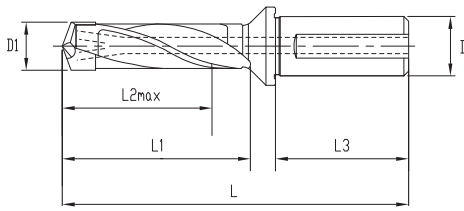
U Drills

Head Exchangable Drills

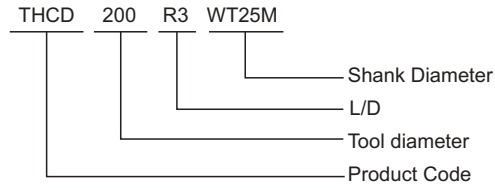
Deep Hole Drills

CDR 45° Chamfer Cutter

Non-standard Tools

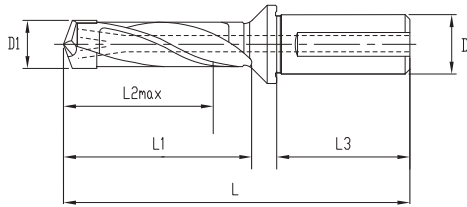


Holder model No. description :



Unit (mm)

| Model No. | L | L1 | L2max | L3 | D | D1 | D1max |
|----------------|-----|----|-------|----|----|-------|-------|
| THCD160R1WT20M | 100 | 36 | 16 | 50 | 20 | 16.00 | 16.99 |
| THCD170R1WT20M | 102 | 39 | 17 | 50 | 20 | 17.00 | 18.00 |
| THCD180R1WT20M | 104 | 41 | 18 | 50 | 20 | 18.00 | 18.00 |
| THCD181R1WT25M | 115 | 41 | 18 | 56 | 25 | 18.01 | 18.99 |
| THCD190R1WT25M | 116 | 43 | 19 | 56 | 25 | 19.00 | 19.99 |
| THCD200R1WT25M | 118 | 46 | 20 | 56 | 25 | 20.00 | 20.99 |
| THCD210R1WT25M | 119 | 48 | 21 | 56 | 25 | 21.00 | 22.00 |
| THCD220R1WT25M | 121 | 50 | 22 | 56 | 25 | 22.00 | 22.00 |
| THCD221R1WT25M | 121 | 50 | 22 | 56 | 25 | 22.01 | 22.99 |
| THCD230R1WT25M | 123 | 52 | 23 | 56 | 25 | 23.00 | 24.00 |
| THCD240R1WT25M | 124 | 55 | 24 | 56 | 25 | 24.00 | 24.00 |
| THCD241R1WT32M | 134 | 55 | 24 | 60 | 32 | 24.01 | 24.99 |
| THCD250R1WT32M | 136 | 57 | 25 | 60 | 32 | 25.00 | 26.00 |
| THCD260R1WT32M | 137 | 59 | 26 | 60 | 32 | 26.00 | 26.00 |
| THCD261R1WT32M | 137 | 60 | 26 | 60 | 32 | 26.01 | 26.99 |
| THCD270R1WT32M | 139 | 62 | 27 | 60 | 32 | 27.00 | 28.00 |
| THCD280R1WT32M | 140 | 64 | 28 | 60 | 32 | 28.00 | 28.00 |
| THCD281R1WT32M | 141 | 64 | 28 | 60 | 32 | 28.01 | 28.99 |
| THCD290R1WT32M | 142 | 66 | 29 | 60 | 32 | 29.00 | 30.00 |
| THCD300R1WT32M | 144 | 69 | 30 | 60 | 32 | 30.00 | 30.00 |
| THCD301R1WT32M | 144 | 69 | 30 | 60 | 32 | 30.01 | 30.99 |
| THCD310R1WT32M | 145 | 71 | 31 | 60 | 32 | 31.00 | 32.00 |
| THCD320R1WT32M | 147 | 73 | 32 | 60 | 32 | 32.00 | 32.00 |
| THCD321R1WT40M | 165 | 73 | 32 | 70 | 40 | 32.01 | 32.99 |
| THCD330R1WT40M | 166 | 75 | 33 | 70 | 40 | 33.00 | 33.99 |
| THCD340R1WT40M | 168 | 78 | 34 | 70 | 40 | 34.00 | 34.99 |
| THCD350R1WT40M | 169 | 80 | 35 | 70 | 40 | 35.00 | 36.00 |
| THCD360R1WT40M | 171 | 82 | 36 | 70 | 40 | 36.00 | 36.00 |
| THCD361R1WT40M | 171 | 83 | 36 | 70 | 40 | 36.01 | 36.99 |
| THCD370R1WT40M | 172 | 85 | 37 | 70 | 40 | 37.00 | 37.99 |
| THCD380R1WT40M | 174 | 87 | 38 | 70 | 40 | 38.00 | 38.99 |
| THCD390R1WT40M | 176 | 89 | 39 | 70 | 40 | 39.00 | 39.99 |
| THCD400R1WT40M | 178 | 91 | 40 | 70 | 40 | 40.00 | 40.00 |



Unit (mm)

| Model No. | L | L1 | L2max | L3 | D | D1 | D1max |
|----------------|-----|-----|-------|----|----|-------|-------|
| THCD125R3WT16M | 110 | 53 | 38 | 45 | 16 | 12.50 | 12.99 |
| THCD130R3WT16M | 113 | 56 | 39 | 45 | 16 | 13.00 | 13.50 |
| THCD135R3WT16M | 115 | 58 | 40 | 45 | 16 | 13.50 | 13.50 |
| THCD136R3WT16M | 115 | 58 | 41 | 45 | 16 | 13.51 | 13.99 |
| THCD140R3WT16M | 117 | 60 | 42 | 45 | 16 | 14.00 | 14.50 |
| THCD145R3WT16M | 119 | 62 | 43 | 45 | 16 | 14.50 | 14.50 |
| THCD146R3WT20M | 125 | 62 | 44 | 50 | 20 | 14.51 | 14.99 |
| THCD150R3WT20M | 127 | 64 | 45 | 50 | 20 | 15.00 | 15.50 |
| THCD155R3WT20M | 129 | 66 | 46 | 50 | 20 | 15.50 | 15.87 |
| THCD160R3WT20M | 132 | 68 | 48 | 50 | 20 | 15.88 | 16.99 |
| THCD170R3WT20M | 136 | 73 | 51 | 50 | 20 | 17.00 | 18.00 |
| THCD180R3WT20M | 140 | 77 | 54 | 50 | 20 | 18.00 | 18.00 |
| THCD181R3WT25M | 151 | 77 | 54 | 56 | 25 | 18.01 | 18.99 |
| THCD190R3WT25M | 154 | 81 | 57 | 56 | 25 | 19.00 | 19.99 |
| THCD200R3WT25M | 158 | 86 | 60 | 56 | 25 | 20.00 | 20.99 |
| THCD210R3WT25M | 161 | 90 | 63 | 56 | 25 | 21.00 | 22.00 |
| THCD220R3WT25M | 165 | 94 | 66 | 56 | 25 | 22.00 | 22.00 |
| THCD221R3WT25M | 165 | 95 | 66 | 56 | 25 | 22.01 | 22.99 |
| THCD230R3WT25M | 169 | 98 | 69 | 56 | 25 | 23.00 | 24.00 |
| THCD240R3WT25M | 172 | 103 | 72 | 56 | 25 | 24.00 | 24.00 |
| THCD241R3WT32M | 182 | 103 | 72 | 60 | 32 | 24.01 | 24.99 |
| THCD250R3WT32M | 186 | 107 | 75 | 60 | 32 | 25.00 | 26.00 |
| THCD260R3WT32M | 189 | 111 | 78 | 60 | 32 | 26.00 | 26.00 |
| THCD261R3WT32M | 190 | 112 | 78 | 60 | 32 | 26.01 | 26.99 |
| THCD270R3WT32M | 193 | 116 | 81 | 60 | 32 | 27.00 | 28.00 |
| THCD280R3WT32M | 196 | 120 | 84 | 60 | 32 | 28.00 | 28.00 |
| THCD281R3WT32M | 197 | 120 | 84 | 60 | 32 | 28.01 | 28.99 |
| THCD290R3WT32M | 200 | 124 | 87 | 60 | 32 | 29.00 | 30.00 |
| THCD300R3WT32M | 204 | 129 | 90 | 60 | 32 | 30.00 | 30.00 |
| THCD301R3WT32M | 204 | 129 | 90 | 60 | 32 | 30.01 | 30.99 |
| THCD310R3WT32M | 207 | 133 | 93 | 60 | 32 | 31.00 | 32.00 |
| THCD320R3WT32M | 211 | 137 | 96 | 60 | 32 | 32.00 | 32.00 |
| THCD321R3WT40M | 229 | 138 | 96 | 70 | 40 | 32.01 | 32.99 |
| THCD330R3WT40M | 232 | 141 | 99 | 70 | 40 | 33.00 | 33.99 |
| THCD340R3WT40M | 236 | 146 | 102 | 70 | 40 | 34.00 | 34.99 |
| THCD350R3WT40M | 239 | 150 | 105 | 70 | 40 | 35.00 | 36.00 |
| THCD360R3WT40M | 243 | 154 | 108 | 70 | 40 | 36.00 | 36.00 |
| THCD361R3WT40M | 243 | 155 | 108 | 70 | 40 | 36.01 | 36.99 |
| THCD370R3WT40M | 246 | 159 | 111 | 70 | 40 | 37.00 | 37.99 |
| THCD380R3WT40M | 250 | 163 | 114 | 70 | 40 | 38.00 | 38.99 |
| THCD390R3WT40M | 254 | 167 | 117 | 70 | 40 | 39.00 | 39.99 |
| THCD400R3WT40M | 258 | 171 | 120 | 70 | 40 | 40.00 | 40.00 |

Carbide Drills

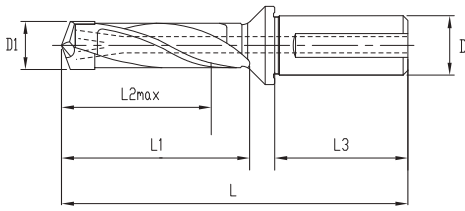
U Drills

Head Exchangable Drills

Deep Hole Drills

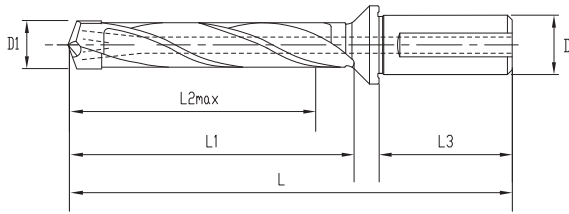
CDR 45° Chamfer Cutter

Non-standard Tools



Unit (mm)

| Model No. | L | L1 | L2max | L3 | D | D1 | D1max |
|----------------|-----|-----|-------|----|----|-------|-------|
| THCD125R5WT16M | 135 | 78 | 62 | 45 | 16 | 12.50 | 12.99 |
| THCD130R5WT16M | 139 | 82 | 65 | 45 | 16 | 13.00 | 13.50 |
| THCD135R5WT16M | 142 | 85 | 67 | 45 | 16 | 13.50 | 13.50 |
| THCD136R5WT16M | 143 | 86 | 68 | 45 | 16 | 13.51 | 13.99 |
| THCD140R5WT16M | 145 | 88 | 70 | 45 | 16 | 14.00 | 14.50 |
| THCD145R5WT16M | 148 | 91 | 72 | 45 | 16 | 14.50 | 14.50 |
| THCD146R5WT20M | 155 | 92 | 73 | 50 | 20 | 14.51 | 14.99 |
| THCD150R5WT20M | 157 | 94 | 75 | 50 | 20 | 15.00 | 15.50 |
| THCD155R5WT20M | 160 | 97 | 77 | 50 | 20 | 15.50 | 15.87 |
| THCD160R5WT20M | 164 | 100 | 80 | 50 | 20 | 15.88 | 16.99 |
| THCD170R5WT20M | 170 | 107 | 85 | 50 | 20 | 17.00 | 18.00 |
| THCD180R5WT20M | 176 | 113 | 90 | 50 | 20 | 18.00 | 18.00 |
| THCD181R5WT25M | 187 | 114 | 90 | 56 | 25 | 18.01 | 18.99 |
| THCD190R5WT25M | 192 | 119 | 95 | 56 | 25 | 19.00 | 19.99 |
| THCD200R5WT25M | 198 | 126 | 100 | 56 | 25 | 20.00 | 20.99 |
| THCD210R5WT25M | 203 | 132 | 105 | 56 | 25 | 21.00 | 22.00 |
| THCD220R5WT25M | 209 | 138 | 110 | 56 | 25 | 22.00 | 22.00 |
| THCD221R5WT25M | 209 | 139 | 110 | 56 | 25 | 22.01 | 22.99 |
| THCD230R5WT25M | 215 | 144 | 115 | 56 | 25 | 23.00 | 24.00 |
| THCD240R5WT25M | 220 | 151 | 120 | 56 | 25 | 24.00 | 24.00 |
| THCD241R5WT32M | 231 | 151 | 120 | 60 | 32 | 24.01 | 24.99 |
| THCD250R5WT32M | 236 | 157 | 125 | 60 | 32 | 25.00 | 26.00 |
| THCD260R5WT32M | 241 | 163 | 130 | 60 | 32 | 26.00 | 26.00 |
| THCD261R5WT32M | 242 | 164 | 130 | 60 | 32 | 26.01 | 26.99 |
| THCD270R5WT32M | 247 | 170 | 135 | 60 | 32 | 27.00 | 28.00 |
| THCD280R5WT32M | 252 | 176 | 140 | 60 | 32 | 28.00 | 28.00 |
| THCD281R5WT32M | 253 | 177 | 140 | 60 | 32 | 28.01 | 28.99 |
| THCD290R5WT32M | 258 | 182 | 145 | 60 | 32 | 29.00 | 30.00 |
| THCD300R5WT32M | 264 | 189 | 150 | 60 | 32 | 30.00 | 30.00 |
| THCD301R5WT32M | 264 | 189 | 150 | 60 | 32 | 30.01 | 30.99 |
| THCD310R5WT32M | 269 | 195 | 155 | 60 | 32 | 31.00 | 32.00 |
| THCD320R5WT32M | 275 | 201 | 160 | 60 | 32 | 32.00 | 32.00 |
| THCD321R5WT40M | 293 | 202 | 160 | 70 | 40 | 32.01 | 32.99 |
| THCD330R5WT40M | 298 | 207 | 165 | 70 | 40 | 33.00 | 33.99 |
| THCD340R5WT40M | 304 | 214 | 170 | 70 | 40 | 34.00 | 34.99 |
| THCD350R5WT40M | 309 | 220 | 175 | 70 | 40 | 35.00 | 36.00 |
| THCD360R5WT40M | 315 | 226 | 180 | 70 | 40 | 36.00 | 36.00 |
| THCD361R5WT40M | 315 | 227 | 180 | 70 | 40 | 36.01 | 36.99 |
| THCD370R5WT40M | 320 | 233 | 185 | 70 | 40 | 37.00 | 37.99 |
| THCD380R5WT40M | 326 | 239 | 190 | 70 | 40 | 38.00 | 38.99 |
| THCD390R5WT40M | 332 | 245 | 195 | 70 | 40 | 39.00 | 39.99 |
| THCD400R5WT40M | 338 | 251 | 200 | 70 | 40 | 40.00 | 40.00 |



Unit (mm)

| Model No. | L | L1 | L2max | L3 | D | D1 | D1max |
|----------------|-----|-----|-------|----|----|-------|-------|
| THCD125R7WT16M | 160 | 103 | 87 | 45 | 16 | 12.50 | 12.99 |
| THCD130R7WT16M | 165 | 108 | 91 | 45 | 16 | 13.00 | 13.50 |
| THCD135R7WT16M | 169 | 112 | 94 | 45 | 16 | 13.50 | 13.50 |
| THCD136R7WT16M | 170 | 113 | 95 | 45 | 16 | 13.51 | 13.99 |
| THCD140R7WT16M | 173 | 116 | 98 | 45 | 16 | 14.00 | 14.50 |
| THCD145R7WT16M | 177 | 120 | 101 | 45 | 16 | 14.50 | 14.50 |
| THCD146R7WT20M | 184 | 121 | 102 | 50 | 20 | 14.51 | 14.99 |
| THCD150R7WT20M | 187 | 124 | 105 | 50 | 20 | 15.00 | 15.50 |
| THCD155R7WT20M | 191 | 128 | 108 | 50 | 20 | 15.50 | 15.87 |
| THCD160R7WT20M | 196 | 132 | 112 | 50 | 20 | 15.88 | 16.99 |
| THCD170R7WT20M | 204 | 141 | 119 | 50 | 20 | 17.00 | 18.00 |
| THCD180R7WT20M | 212 | 149 | 126 | 50 | 20 | 18.00 | 18.00 |
| THCD181R7WT25M | 223 | 150 | 126 | 56 | 25 | 18.01 | 18.99 |
| THCD190R7WT25M | 230 | 157 | 133 | 56 | 25 | 19.00 | 19.99 |
| THCD200R7WT25M | 238 | 166 | 140 | 56 | 25 | 20.00 | 20.99 |
| THCD210R7WT25M | 245 | 174 | 147 | 56 | 25 | 21.00 | 22.00 |
| THCD220R7WT25M | 253 | 182 | 154 | 56 | 25 | 22.00 | 22.00 |
| THCD221R7WT25M | 254 | 183 | 154 | 56 | 25 | 22.01 | 22.99 |
| THCD230R7WT25M | 261 | 190 | 161 | 56 | 25 | 23.00 | 24.00 |
| THCD240R7WT25M | 268 | 199 | 168 | 56 | 25 | 24.00 | 24.00 |
| THCD241R7WT32M | 279 | 200 | 168 | 60 | 32 | 24.01 | 24.99 |
| THCD250R7WT32M | 286 | 207 | 175 | 60 | 32 | 25.00 | 26.00 |
| THCD260R7WT32M | 293 | 215 | 182 | 60 | 32 | 26.00 | 26.00 |
| THCD261R7WT32M | 294 | 216 | 182 | 60 | 32 | 26.01 | 26.99 |
| THCD270R7WT32M | 301 | 224 | 189 | 60 | 32 | 27.00 | 28.00 |
| THCD280R7WT32M | 308 | 232 | 196 | 60 | 32 | 28.00 | 28.00 |
| THCD281R7WT32M | 301 | 224 | 196 | 60 | 32 | 28.01 | 28.99 |
| THCD290R7WT32M | 307 | 232 | 203 | 60 | 32 | 29.00 | 30.00 |
| THCD300R7WT32M | 315 | 240 | 210 | 60 | 32 | 30.00 | 30.00 |
| THCD301R7WT32M | 315 | 240 | 210 | 60 | 32 | 30.01 | 30.99 |
| THCD310R7WT32M | 322 | 248 | 217 | 60 | 32 | 31.00 | 32.00 |
| THCD320R7WT32M | 329 | 256 | 224 | 60 | 32 | 32.00 | 32.00 |
| THCD321R7WT40M | 348 | 256 | 224 | 70 | 40 | 32.01 | 32.99 |
| THCD330R7WT40M | 354 | 264 | 231 | 70 | 40 | 33.00 | 33.99 |
| THCD340R7WT40M | 362 | 272 | 238 | 70 | 40 | 34.00 | 34.99 |
| THCD350R7WT40M | 369 | 280 | 245 | 70 | 40 | 35.00 | 36.00 |
| THCD360R7WT40M | 376 | 288 | 252 | 70 | 40 | 36.00 | 36.00 |
| THCD361R7WT40M | 377 | 288 | 252 | 70 | 40 | 36.01 | 36.99 |
| THCD370R7WT40M | 383 | 296 | 259 | 70 | 40 | 37.00 | 37.99 |
| THCD380R7WT40M | 391 | 304 | 266 | 70 | 40 | 38.00 | 38.99 |
| THCD390R7WT40M | 398 | 312 | 273 | 70 | 40 | 39.00 | 39.99 |
| THCD400R7WT40M | 406 | 320 | 280 | 70 | 40 | 40.00 | 40.00 |

Carbide Drills

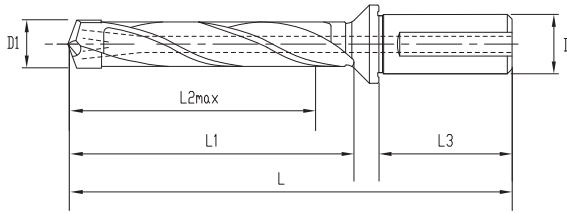
U Drills

Head Exchangable Drills

Deep Hole Drills

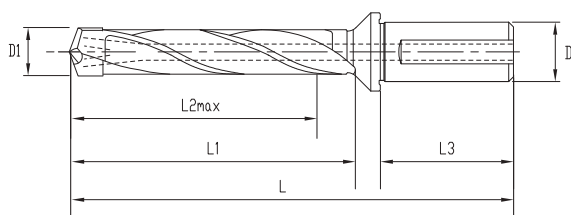
CDR 45° Chamfer Cutter

Non-standard Tools



Unit (mm)

| Model No. | L | L1 | L2max | L3 | D | D1 | D1max |
|----------------|-----|-----|-------|----|----|-------|-------|
| THCD125R8WT16M | 173 | 116 | 100 | 45 | 16 | 12.50 | 12.99 |
| THCD130R8WT16M | 178 | 121 | 104 | 45 | 16 | 13.00 | 13.50 |
| THCD135R8WT16M | 182 | 125 | 108 | 45 | 16 | 13.50 | 13.50 |
| THCD136R8WT16M | 183 | 126 | 108 | 45 | 16 | 13.51 | 13.99 |
| THCD140R8WT16M | 187 | 130 | 112 | 45 | 16 | 14.00 | 14.50 |
| THCD145R8WT16M | 192 | 135 | 116 | 45 | 16 | 14.50 | 14.50 |
| THCD146R8WT20M | 198 | 135 | 116 | 50 | 20 | 14.51 | 14.99 |
| THCD150R8WT20M | 202 | 139 | 120 | 50 | 20 | 15.00 | 15.50 |
| THCD155R8WT20M | 207 | 144 | 124 | 50 | 20 | 15.50 | 15.87 |
| THCD160R8WT20M | 212 | 148 | 128 | 50 | 20 | 15.88 | 16.99 |
| THCD170R8WT20M | 221 | 158 | 136 | 50 | 20 | 17.00 | 18.00 |
| THCD180R8WT20M | 230 | 167 | 144 | 50 | 20 | 18.00 | 18.00 |
| THCD181R8WT25M | 241 | 168 | 144 | 56 | 25 | 18.01 | 18.99 |
| THCD190R8WT25M | 249 | 176 | 152 | 56 | 25 | 19.00 | 19.99 |
| THCD200R8WT25M | 258 | 186 | 160 | 56 | 25 | 20.00 | 20.99 |
| THCD210R8WT25M | 266 | 195 | 168 | 56 | 25 | 21.00 | 22.00 |
| THCD220R8WT25M | 275 | 204 | 176 | 56 | 25 | 22.00 | 22.00 |
| THCD221R8WT25M | 276 | 205 | 176 | 56 | 25 | 22.01 | 22.99 |
| THCD230R8WT25M | 284 | 213 | 184 | 56 | 25 | 23.00 | 24.00 |
| THCD240R8WT25M | 292 | 223 | 192 | 56 | 25 | 24.00 | 24.00 |
| THCD241R8WT32M | 303 | 224 | 192 | 60 | 32 | 24.01 | 24.99 |
| THCD250R8WT32M | 311 | 232 | 200 | 60 | 32 | 25.00 | 26.00 |
| THCD260R8WT32M | 319 | 241 | 208 | 60 | 32 | 26.00 | 26.00 |
| THCD261R8WT32M | 320 | 242 | 208 | 60 | 32 | 26.01 | 26.99 |
| THCD270R8WT32M | 328 | 251 | 216 | 60 | 32 | 27.00 | 28.00 |
| THCD280R8WT32M | 336 | 260 | 224 | 60 | 32 | 28.00 | 28.00 |
| THCD281R8WT32M | 329 | 252 | 224 | 60 | 32 | 28.01 | 28.99 |
| THCD290R8WT32M | 336 | 261 | 232 | 60 | 32 | 29.00 | 30.00 |
| THCD300R8WT32M | 345 | 270 | 240 | 60 | 32 | 30.00 | 30.00 |
| THCD301R8WT32M | 345 | 270 | 240 | 60 | 32 | 30.01 | 30.99 |
| THCD310R8WT32M | 353 | 279 | 248 | 60 | 32 | 31.00 | 32.00 |
| THCD320R8WT32M | 361 | 288 | 256 | 60 | 32 | 32.00 | 32.00 |
| THCD321R8WT40M | 380 | 288 | 256 | 70 | 40 | 32.01 | 32.99 |
| THCD330R8WT40M | 387 | 297 | 264 | 70 | 40 | 33.00 | 33.99 |
| THCD340R8WT40M | 396 | 306 | 272 | 70 | 40 | 34.00 | 34.99 |
| THCD350R8WT40M | 404 | 315 | 280 | 70 | 40 | 35.00 | 36.00 |
| THCD360R8WT40M | 412 | 324 | 288 | 70 | 40 | 36.00 | 36.00 |
| THCD361R8WT40M | 413 | 324 | 288 | 70 | 40 | 36.01 | 36.99 |
| THCD370R8WT40M | 420 | 333 | 296 | 70 | 40 | 37.00 | 37.99 |
| THCD380R8WT40M | 429 | 342 | 304 | 70 | 40 | 38.00 | 38.99 |
| THCD390R8WT40M | 437 | 351 | 312 | 70 | 40 | 39.00 | 39.99 |
| THCD400R8WT40M | 445 | 360 | 320 | 70 | 40 | 40.00 | 40.00 |



Unit (mm)

| Model No. | L | L1 | L2max | L3 | D | D1 | D1max |
|-----------------|-----|-----|-------|----|----|-------|-------|
| THCD125R10WT16M | 197 | 140 | 125 | 45 | 16 | 12.50 | 12.99 |
| THCD130R10WT16M | 203 | 146 | 130 | 45 | 16 | 13.00 | 13.50 |
| THCD135R10WT16M | 209 | 152 | 135 | 45 | 16 | 13.50 | 13.50 |
| THCD136R10WT16M | 210 | 153 | 136 | 45 | 16 | 13.51 | 13.99 |
| THCD140R10WT16M | 215 | 158 | 140 | 45 | 16 | 14.00 | 14.50 |
| THCD145R10WT16M | 220 | 163 | 145 | 45 | 16 | 14.50 | 14.50 |
| THCD146R10WT20M | 227 | 164 | 146 | 50 | 20 | 14.51 | 14.99 |
| THCD150R10WT20M | 232 | 169 | 150 | 50 | 20 | 15.00 | 15.50 |
| THCD155R10WT20M | 238 | 175 | 155 | 50 | 20 | 15.50 | 15.87 |
| THCD160R10WT20M | 244 | 180 | 160 | 50 | 20 | 15.88 | 16.99 |
| THCD170R10WT20M | 255 | 192 | 170 | 50 | 20 | 17.00 | 18.00 |
| THCD180R10WT20M | 266 | 203 | 180 | 50 | 20 | 18.00 | 18.00 |
| THCD181R10WT25M | 278 | 204 | 180 | 56 | 25 | 18.01 | 18.99 |
| THCD190R10WT25M | 287 | 214 | 190 | 56 | 25 | 19.00 | 19.99 |
| THCD200R10WT25M | 298 | 226 | 200 | 56 | 25 | 20.00 | 20.99 |
| THCD210R10WT25M | 308 | 237 | 210 | 56 | 25 | 21.00 | 22.00 |
| THCD220R10WT25M | 319 | 248 | 220 | 56 | 25 | 22.00 | 22.00 |
| THCD221R10WT25M | 320 | 249 | 220 | 56 | 25 | 22.01 | 22.99 |
| THCD230R10WT25M | 330 | 259 | 230 | 56 | 25 | 23.00 | 24.00 |
| THCD240R10WT25M | 340 | 271 | 240 | 56 | 25 | 24.00 | 24.00 |
| THCD241R10WT32M | 351 | 272 | 240 | 60 | 32 | 24.01 | 24.99 |
| THCD250R10WT32M | 361 | 282 | 250 | 60 | 32 | 25.00 | 26.00 |
| THCD260R10WT32M | 371 | 293 | 260 | 60 | 32 | 26.00 | 26.00 |
| THCD261R10WT32M | 372 | 294 | 260 | 60 | 32 | 26.01 | 26.99 |
| THCD270R10WT32M | 382 | 305 | 270 | 60 | 32 | 27.00 | 28.00 |
| THCD280R10WT32M | 392 | 316 | 280 | 60 | 32 | 28.00 | 28.00 |
| THCD281R10WT32M | 385 | 309 | 280 | 60 | 32 | 28.01 | 28.99 |
| THCD290R10WT32M | 394 | 319 | 290 | 60 | 32 | 29.00 | 30.00 |
| THCD300R10WT32M | 405 | 330 | 300 | 60 | 32 | 30.00 | 30.00 |
| THCD301R10WT32M | 406 | 331 | 300 | 60 | 32 | 30.01 | 30.99 |
| THCD310R10WT32M | 415 | 341 | 310 | 60 | 32 | 31.00 | 32.00 |
| THCD320R10WT40M | 435 | 352 | 320 | 60 | 40 | 32.00 | 32.00 |
| THCD321R10WT40M | 444 | 353 | 320 | 70 | 40 | 32.01 | 32.99 |
| THCD330R10WT40M | 453 | 363 | 330 | 70 | 40 | 33.00 | 33.99 |
| THCD340R10WT40M | 464 | 374 | 340 | 70 | 40 | 34.00 | 34.99 |
| THCD350R10WT40M | 474 | 385 | 350 | 70 | 40 | 35.00 | 36.00 |
| THCD360R10WT40M | 484 | 396 | 360 | 70 | 40 | 36.00 | 36.00 |
| THCD361R10WT40M | 485 | 397 | 360 | 70 | 40 | 36.01 | 36.99 |
| THCD370R10WT40M | 494 | 407 | 370 | 70 | 40 | 37.00 | 37.99 |
| THCD380R10WT40M | 505 | 418 | 380 | 70 | 40 | 38.00 | 38.99 |
| THCD390R10WT40M | 515 | 429 | 390 | 70 | 40 | 39.00 | 39.99 |
| THCD400R10WT40M | 525 | 440 | 400 | 70 | 40 | 40.00 | 40.00 |

Carbide Drills

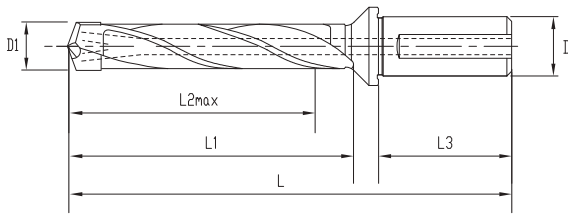
U Drills

Head Exchangable Drills

Deep Hole Drills

CDR 45° Chamfer Cutter

Non-standard Tools



Unit (mm)

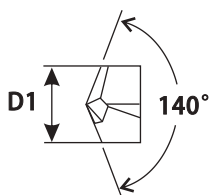
| Model No. | L | L1 | L2max | L3 | D | D1 | D1max |
|-----------------|-----|-----|-------|----|----|-------|-------|
| THCD125R12WT16M | 223 | 166 | 150 | 45 | 16 | 12.50 | 12.99 |
| THCD130R12WT16M | 229 | 172 | 156 | 45 | 16 | 13.00 | 13.50 |
| THCD135R12WT16M | 236 | 179 | 162 | 45 | 16 | 13.50 | 13.50 |
| THCD136R12WT16M | 237 | 180 | 163 | 45 | 16 | 13.51 | 13.99 |
| THCD140R12WT16M | 243 | 186 | 168 | 45 | 16 | 14.00 | 14.50 |
| THCD145R12WT16M | 249 | 192 | 174 | 45 | 16 | 14.50 | 14.50 |
| THCD146R12WT20M | 257 | 194 | 175 | 50 | 20 | 14.51 | 14.99 |
| THCD150R12WT20M | 262 | 199 | 180 | 50 | 20 | 15.00 | 15.50 |
| THCD155R12WT20M | 269 | 206 | 186 | 50 | 20 | 15.50 | 15.87 |
| THCD160R12WT20M | 276 | 212 | 192 | 50 | 20 | 15.88 | 16.99 |
| THCD170R12WT20M | 289 | 226 | 204 | 50 | 20 | 17.00 | 18.00 |
| THCD180R12WT20M | 302 | 239 | 216 | 50 | 20 | 18.00 | 18.00 |
| THCD181R12WT25M | 314 | 240 | 216 | 56 | 25 | 18.01 | 18.99 |
| THCD190R12WT25M | 325 | 252 | 228 | 56 | 25 | 19.00 | 19.99 |
| THCD200R12WT25M | 338 | 266 | 240 | 56 | 25 | 20.00 | 20.99 |
| THCD210R12WT25M | 350 | 279 | 252 | 56 | 25 | 21.00 | 22.00 |
| THCD220R12WT25M | 356 | 286 | 264 | 56 | 25 | 22.00 | 22.00 |
| THCD221R12WT25M | 364 | 293 | 264 | 56 | 25 | 22.01 | 22.99 |
| THCD230R12WT25M | 376 | 305 | 276 | 56 | 25 | 23.00 | 24.00 |
| THCD240R12WT25M | 382 | 319 | 288 | 56 | 25 | 24.00 | 24.00 |
| THCD241R12WT32M | 399 | 320 | 288 | 60 | 32 | 24.01 | 24.99 |
| THCD250R12WT32M | 411 | 332 | 300 | 60 | 32 | 25.00 | 26.00 |
| THCD260R12WT32M | 423 | 345 | 312 | 60 | 32 | 26.00 | 26.00 |
| THCD261R12WT32M | 424 | 347 | 312 | 60 | 32 | 26.01 | 26.99 |
| THCD270R12WT32M | 436 | 359 | 324 | 60 | 32 | 27.00 | 28.00 |
| THCD280R12WT32M | 448 | 372 | 336 | 60 | 32 | 28.00 | 28.00 |
| THCD281R12WT32M | 441 | 365 | 336 | 60 | 32 | 28.01 | 28.99 |
| THCD290R12WT32M | 453 | 377 | 348 | 60 | 32 | 29.00 | 30.00 |
| THCD300R12WT32M | 465 | 390 | 360 | 60 | 32 | 30.00 | 30.00 |



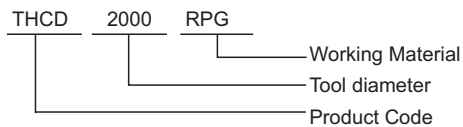
RPG



RSG



Drill Head model No. description:



RPG: Steel / Cast Iron

RSG: Stainless Steel

Unit (mm)

| D1 | Model No. | | D1 | Model No. | |
|-------|-------------|-------------|-------|-------------|-------------|
| 12.50 | THCD1250RPG | THCD1250RSG | 12.60 | THCD1260RPG | THCD1260RSG |
| 12.70 | THCD1270RPG | THCD1270RSG | 12.80 | THCD1280RPG | THCD1280RSG |
| 12.90 | THCD1290RPG | THCD1290RSG | 13.00 | THCD1300RPG | THCD1300RSG |
| 13.10 | THCD1310RPG | THCD1310RSG | 13.20 | THCD1320RPG | THCD1320RSG |
| 13.30 | THCD1330RPG | THCD1330RSG | 13.40 | THCD1340RPG | THCD1340RSG |
| 13.50 | THCD1350RPG | THCD1350RSG | 13.60 | THCD1360RPG | THCD1360RSG |
| 13.70 | THCD1370RPG | THCD1370RSG | 13.80 | THCD1380RPG | THCD1380RSG |
| 13.90 | THCD1390RPG | THCD1390RSG | 14.00 | THCD1400RPG | THCD1400RSG |
| 14.10 | THCD1410RPG | THCD1410RSG | 14.20 | THCD1420RPG | THCD1420RSG |
| 14.30 | THCD1430RPG | THCD1430RSG | 14.40 | THCD1440RPG | THCD1440RSG |
| 14.50 | THCD1450RPG | THCD1450RSG | 14.60 | THCD1460RPG | THCD1460RSG |
| 14.70 | THCD1470RPG | THCD1470RSG | 14.80 | THCD1480RPG | THCD1480RSG |
| 14.90 | THCD1490RPG | THCD1490RSG | 15.00 | THCD1500RPG | THCD1500RSG |
| 15.10 | THCD1510RPG | THCD1510RSG | 15.20 | THCD1520RPG | THCD1520RSG |
| 15.30 | THCD1530RPG | THCD1530RSG | 15.40 | THCD1540RPG | THCD1540RSG |
| 15.50 | THCD1550RPG | THCD1550RSG | 15.60 | THCD1560RPG | THCD1560RSG |
| 15.70 | THCD1570RPG | THCD1570RSG | 15.80 | THCD1580RPG | THCD1580RSG |
| 15.90 | THCD1590RPG | THCD1590RSG | 16.00 | THCD1600RPG | THCD1600RSG |
| 16.20 | THCD1620RPG | THCD1620RSG | 16.25 | THCD1625RPG | THCD1625RSG |
| 16.27 | THCD1627RPG | THCD1627RSG | 16.30 | THCD1630RPG | THCD1630RSG |
| 16.33 | THCD1633RPG | THCD1633RSG | 16.35 | THCD1635RPG | THCD1635RSG |
| 16.40 | THCD1640RPG | THCD1640RSG | 16.50 | THCD1650RPG | THCD1650RSG |
| 16.60 | THCD1660RPG | THCD1660RSG | 16.80 | THCD1680RPG | THCD1680RSG |
| 16.90 | THCD1690RPG | THCD1690RSG | 17.00 | THCD1700RPG | THCD1700RSG |
| 17.20 | THCD1720RPG | THCD1720RSG | 17.30 | THCD1730RPG | THCD1730RSG |
| 17.50 | THCD1750RPG | THCD1750RSG | 17.60 | THCD1760RPG | THCD1760RSG |
| 17.70 | THCD1770RPG | THCD1770RSG | 17.80 | THCD1780RPG | THCD1780RSG |
| 17.90 | THCD1790RPG | THCD1790RSG | 18.00 | THCD1800RPG | THCD1800RSG |
| 18.20 | THCD1820RPG | THCD1820RSG | 18.30 | THCD1830RPG | THCD1830RSG |
| 18.50 | THCD1850RPG | THCD1850RSG | 18.70 | THCD1870RPG | THCD1870RSG |
| 18.90 | THCD1890RPG | THCD1890RSG | 19.00 | THCD1900RPG | THCD1900RSG |
| 19.20 | THCD1920RPG | THCD1920RSG | 19.25 | THCD1925RPG | THCD1925RSG |
| 19.27 | THCD1927RPG | THCD1927RSG | 19.30 | THCD1930RPG | THCD1930RSG |

Carbide Drills

U Drills

Head Exchangeable Drills

Deep Hole Drills

CDR 45° Chamfer Cutter

Non-standard Tools

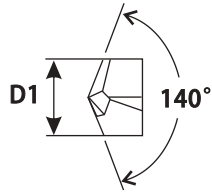
Carbide Drills



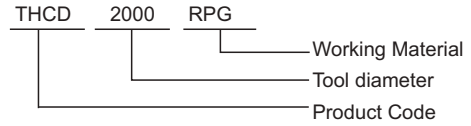
RPG



RSG



Drill Head model No. description:



RPG: Steel / Cast Iron

RSG: Stainless Steel

Unit (mm)

U Drills

Head Exchangable Drills

Deep Hole Drills

CDR 45° Chamfer Cutter

Non-standard Tools

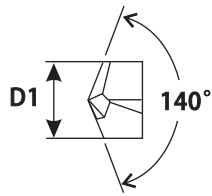
| D1 | Model No. | | D1 | Model No. | |
|-------|-------------|-------------|-------|-------------|-------------|
| 19.33 | THCD1933RPG | THCD1933RSG | 19.35 | THCD1935RPG | THCD1935RSG |
| 19.40 | THCD1940RPG | THCD1940RSG | 19.50 | THCD1950RPG | THCD1950RSG |
| 19.60 | THCD1960RPG | THCD1960RSG | 19.80 | THCD1980RPG | THCD1980RSG |
| 19.90 | THCD1990RPG | THCD1990RSG | 20.00 | THCD2000RPG | THCD2000RSG |
| 20.20 | THCD2020RPG | THCD2020RSG | 20.30 | THCD2030RPG | THCD2030RSG |
| 20.50 | THCD2050RPG | THCD2050RSG | 20.70 | THCD2070RPG | THCD2070RSG |
| 20.90 | THCD2090RPG | THCD2090RSG | 21.00 | THCD2100RPG | THCD2100RSG |
| 21.20 | THCD2120RPG | THCD2120RSG | 21.30 | THCD2130RPG | THCD2130RSG |
| 21.50 | THCD2150RPG | THCD2150RSG | 21.70 | THCD2170RPG | THCD2170RSG |
| 21.90 | THCD2190RPG | THCD2190RSG | 22.00 | THCD2200RPG | THCD2200RSG |
| 22.20 | THCD2220RPG | THCD2220RSG | 22.30 | THCD2230RPG | THCD2230RSG |
| 22.50 | THCD2250RPG | THCD2250RSG | 22.70 | THCD2270RPG | THCD2270RSG |
| 22.90 | THCD2290RPG | THCD2290RSG | 23.00 | THCD2300RPG | THCD2300RSG |
| 23.20 | THCD2320RPG | THCD2320RSG | 23.30 | THCD2330RPG | THCD2330RSG |
| 23.50 | THCD2350RPG | THCD2350RSG | 23.70 | THCD2370RPG | THCD2370RSG |
| 23.90 | THCD2390RPG | THCD2390RSG | 24.00 | THCD2400RPG | THCD2400RSG |
| 24.20 | THCD2420RPG | THCD2420RSG | 24.30 | THCD2430RPG | THCD2430RSG |
| 24.50 | THCD2450RPG | THCD2450RSG | 24.70 | THCD2470RPG | THCD2470RSG |
| 24.90 | THCD2490RPG | THCD2490RSG | 25.00 | THCD2500RPG | THCD2500RSG |
| 25.20 | THCD2520RPG | THCD2520RSG | 25.25 | THCD2525RPG | THCD2525RSG |
| 25.27 | THCD2527RPG | THCD2527RSG | 25.30 | THCD2530RPG | THCD2530RSG |
| 25.33 | THCD2533RPG | THCD2533RSG | 25.35 | THCD2535RPG | THCD2535RSG |
| 25.40 | THCD2540RPG | THCD2540RSG | 25.50 | THCD2550RPG | THCD2550RSG |
| 25.60 | THCD2560RPG | THCD2560RSG | 25.80 | THCD2580RPG | THCD2580RSG |
| 25.90 | THCD2590RPG | THCD2590RSG | 26.00 | THCD2600RPG | THCD2600RSG |
| 26.20 | THCD2620RPG | THCD2620RSG | 26.30 | THCD2630RPG | THCD2630RSG |
| 26.50 | THCD2650RPG | THCD2650RSG | 26.70 | THCD2670RPG | THCD2670RSG |
| 26.90 | THCD2690RPG | THCD2690RSG | 27.00 | THCD2700RPG | THCD2700RSG |
| 27.20 | THCD2720RPG | THCD2720RSG | 27.30 | THCD2730RPG | THCD2730RSG |
| 27.50 | THCD2750RPG | THCD2750RSG | 27.70 | THCD2770RPG | THCD2770RSG |
| 27.90 | THCD2790RPG | THCD2790RSG | 28.00 | THCD2800RPG | THCD2800RSG |
| 28.20 | THCD2820RPG | THCD2820RSG | 28.30 | THCD2830RPG | THCD2830RSG |
| 28.50 | THCD2850RPG | THCD2850RSG | 28.70 | THCD2870RPG | THCD2870RSG |



RPG



RSG



Unit (mm)

| D1 | Model No. | | D1 | Model No. | |
|-------|-------------|-------------|-------|-------------|-------------|
| 28.90 | THCD2890RPG | THCD2890RSG | 29.00 | THCD2900RPG | THCD2900RSG |
| 29.20 | THCD2920RPG | THCD2920RSG | 29.30 | THCD2930RPG | THCD2930RSG |
| 29.50 | THCD2950RPG | THCD2950RSG | 29.70 | THCD2970RPG | THCD2970RSG |
| 29.90 | THCD2990RPG | THCD2990RSG | 30.00 | THCD3000RPG | THCD3000RSG |
| 30.20 | THCD3020RPG | THCD3020RSG | 30.30 | THCD3030RPG | THCD3030RSG |
| 30.50 | THCD3050RPG | THCD3050RSG | 30.70 | THCD3070RPG | THCD3070RSG |
| 30.90 | THCD3090RPG | THCD3090RSG | 31.00 | THCD3100RPG | THCD3100RSG |
| 31.20 | THCD3120RPG | THCD3120RSG | 31.30 | THCD3130RPG | THCD3130RSG |
| 31.50 | THCD3150RPG | THCD3150RSG | 31.70 | THCD3170RPG | THCD3170RSG |
| 31.90 | THCD3190RPG | THCD3190RSG | 32.00 | THCD3200RPG | THCD3200RSG |
| 32.20 | THCD3220RPG | THCD3220RSG | 32.30 | THCD3230RPG | THCD3230RSG |
| 32.50 | THCD3250RPG | THCD3250RSG | 32.70 | THCD3270RPG | THCD3270RSG |
| 32.90 | THCD3290RPG | THCD3290RSG | 33.00 | THCD3300RPG | THCD3300RSG |
| 33.20 | THCD3320RPG | THCD3320RSG | 33.30 | THCD3330RPG | THCD3330RSG |
| 33.50 | THCD3350RPG | THCD3350RSG | 33.70 | THCD3370RPG | THCD3370RSG |
| 33.90 | THCD3390RPG | THCD3390RSG | 34.00 | THCD3400RPG | THCD3400RSG |
| 34.20 | THCD3420RPG | THCD3420RSG | 34.30 | THCD3430RPG | THCD3430RSG |
| 34.50 | THCD3450RPG | THCD3450RSG | 34.70 | THCD3470RPG | THCD3470RSG |
| 34.90 | THCD3490RPG | THCD3490RSG | 35.00 | THCD3500RPG | THCD3500RSG |
| 35.20 | THCD3520RPG | THCD3520RSG | 35.30 | THCD3530RPG | THCD3530RSG |
| 35.50 | THCD3550RPG | THCD3550RSG | 35.70 | THCD3570RPG | THCD3570RSG |
| 35.90 | THCD3590RPG | THCD3590RSG | 36.00 | THCD3600RPG | THCD3600RSG |
| 36.20 | THCD3620RPG | THCD3620RSG | 36.30 | THCD3630RPG | THCD3630RSG |
| 36.50 | THCD3650RPG | THCD3650RSG | 36.70 | THCD3670RPG | THCD3670RSG |
| 36.90 | THCD3690RPG | THCD3690RSG | 37.00 | THCD3700RPG | THCD3700RSG |
| 37.20 | THCD3720RPG | THCD3720RSG | 37.30 | THCD3730RPG | THCD3730RSG |
| 37.50 | THCD3750RPG | THCD3750RSG | 37.70 | THCD3770RPG | THCD3770RSG |
| 37.90 | THCD3790RPG | THCD3790RSG | 38.00 | THCD3800RPG | THCD3800RSG |
| 38.20 | THCD3820RPG | THCD3820RSG | 38.30 | THCD3830RPG | THCD3830RSG |
| 38.50 | THCD3850RPG | THCD3850RSG | 38.70 | THCD3870RPG | THCD3870RSG |
| 38.90 | THCD3890RPG | THCD3890RSG | 39.00 | THCD3900RPG | THCD3900RSG |
| 39.20 | THCD3920RPG | THCD3920RSG | 39.30 | THCD3930RPG | THCD3930RSG |
| 39.50 | THCD3950RPG | THCD3950RSG | 39.70 | THCD3970RPG | THCD3970RSG |
| 39.90 | THCD3990RPG | THCD3990RSG | 40.00 | THCD4000RPG | THCD4000RSG |

Carbide Drills

U Drills

Head Exchangeable Drills

Deep Hole Drills

CDR 45° Chamfer Cutter

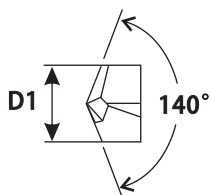
Non-standard Tools



RPG



RSG



Unit (mm)

| Wrench | | | | | | | | Screw |
|----------------|---------|---------|---------|---------|---------|---------|---------|---------------|
| Diameter Range | L/D=1 | L/D=3 | L/D=5 | L/D=7 | L/D=8 | L/D=10 | L/D=12 | Locking screw |
| 12.50-15.87 | — | THW1716 | THW1716 | THW1717 | THW1717 | THW1718 | THW1718 | 364.016 |
| 15.88-18.00 | THW1701 | THW1701 | THW1701 | THW1702 | THW1702 | THW1709 | THW1709 | 364.010 |
| 18.01-19.99 | THW1701 | THW1701 | THW1701 | THW1702 | THW1702 | THW1709 | THW1709 | |
| 20.00-22.00 | THW1703 | THW1703 | THW1703 | THW1704 | THW1704 | THW1710 | THW1710 | 364.011 |
| 22.01-24.00 | THW1703 | THW1703 | THW1703 | THW1704 | THW1704 | THW1710 | THW1710 | |
| 24.01-26.00 | THW1705 | THW1705 | THW1705 | THW1706 | THW1706 | THW1711 | THW1714 | 364.012 |
| 26.01-28.00 | THW1705 | THW1705 | THW1705 | THW1706 | THW1706 | THW1711 | THW1714 | |
| 28.01-30.00 | THW1707 | THW1707 | THW1707 | THW1708 | THW1708 | THW1712 | THW1715 | 364.013 |
| 30.01-32.00 | THW1707 | THW1707 | THW1707 | THW1708 | THW1708 | THW1712 | THW1715 | |
| 32.01-36.00 | THW1707 | THW1707 | THW1708 | THW1712 | THW1712 | THW1715 | — | 364.015 |
| 36.01-40.00 | THW1707 | THW1707 | THW1708 | THW1712 | THW1712 | THW1715 | — | |

Carbide Drills

U Drills

Head Exchangable Drills

Deep Hole Drills

CDR 45° Chamfer Cutter

Non-standard Tools

RPG (Steel and cast iron series)

| Line speed (m/min) | | Feed (mm/r) | | | | | |
|---------------------|---------------|--------------|-----------|-----------|-----------|-----------|-----------|
| Minimum value | Maximum value | mm | 16.00 | 20.00 | 25.00 | 32.00 | 40.00 |
| 75 | 130 | | 0.17-0.36 | 0.20-0.38 | 0.23-0.43 | 0.25-0.45 | 0.27-0.50 |

Low carbon steel long chips Hardness(HB):<125

| Line speed (m/min) | | Feed (mm/r) | | | | | |
|---------------------|---------------|--------------|-----------|-----------|-----------|-----------|-----------|
| Minimum value | Maximum value | mm | 16.00 | 20.00 | 25.00 | 32.00 | 40.00 |
| 80 | 140 | | 0.17-0.36 | 0.20-0.38 | 0.23-0.43 | 0.25-0.45 | 0.27-0.50 |

Low carbon steel short chips Hardness(HB):<220

| Line speed (m/min) | | Feed (mm/r) | | | | | |
|---------------------|---------------|--------------|-----------|-----------|-----------|-----------|-----------|
| Minimum value | Maximum value | mm | 16.00 | 20.00 | 25.00 | 32.00 | 40.00 |
| 60 | 90 | | 0.17-0.30 | 0.20-0.32 | 0.23-0.37 | 0.25-0.40 | 0.27-0.42 |

Medium and high carbon alloy steel Hardness(HB):<330

| Line speed (m/min) | | Feed (mm/r) | | | | | |
|---------------------|---------------|--------------|-----------|-----------|-----------|-----------|-----------|
| Minimum value | Maximum value | mm | 16.00 | 20.00 | 25.00 | 32.00 | 40.00 |
| 50 | 85 | | 0.14-0.30 | 0.17-0.32 | 0.20-0.37 | 0.22-0.40 | 0.23-0.42 |

Alloy steel and Tool steel Hardness(HB):350-450

| Line speed (m/min) | | Feed (mm/r) | | | | | |
|---------------------|---------------|--------------|-----------|-----------|-----------|-----------|-----------|
| Minimum value | Maximum value | mm | 16.00 | 20.00 | 25.00 | 32.00 | 40.00 |
| 90 | 175 | | 0.21-0.42 | 0.25-0.48 | 0.31-0.59 | 0.37-0.70 | 0.43-0.81 |

Gray cast iron and low strength spheroidal graphite cast irons Hardness(HB):120-290

| Line speed (m/min) | | Feed (mm/r) | | | | | |
|---------------------|---------------|--------------|-----------|-----------|-----------|-----------|-----------|
| Minimum value | Maximum value | mm | 16.00 | 20.00 | 25.00 | 32.00 | 40.00 |
| 90 | 125 | | 0.21-0.41 | 0.25-0.48 | 0.31-0.59 | 0.37-0.70 | 0.43-0.81 |

Low strength spheroidal graphite cast irons Hardness(HB):130-260

| Line speed (m/min) | | Feed (mm/r) | | | | | |
|---------------------|---------------|--------------|-----------|-----------|-----------|-----------|-----------|
| Minimum value | Maximum value | mm | 16.00 | 20.00 | 25.00 | 32.00 | 40.00 |
| 40 | 125 | | 0.20-0.41 | 0.21-0.44 | 0.23-0.48 | 0.25-0.53 | 0.27-0.57 |

High strength spheroidal graphite cast irons Hardness(HB):180-350

Carbide Drills

U Drills

Head Exchangable Drills

Deep Hole Drills

CDR 45° Chamfer Cutter

Non-standard Tools

RSG (Stainless Steel)

Carbide Drills

| Line speed (m/min) | | Feed (mm/r) | | | | | |
|---------------------|---------------|--------------|-----------|-----------|-----------|-----------|-----------|
| Minimum value | Maximum value | mm | 16.00 | 20.00 | 25.00 | 32.00 | 40.00 |
| 45 | 70 | | 0.10-0.20 | 0.12-0.23 | 0.12-0.25 | 0.14-0.27 | 0.15-0.30 |

Austenitic stainless steel Hardness(HB):130-200

U Drills

| Line speed (m/min) | | Feed (mm/r) | | | | | |
|---------------------|---------------|--------------|-----------|-----------|-----------|-----------|-----------|
| Minimum value | Maximum value | mm | 16.00 | 20.00 | 25.00 | 32.00 | 40.00 |
| 40 | 60 | | 0.08-0.15 | 0.10-0.20 | 0.12-0.22 | 0.14-0.25 | 0.15-0.26 |

High strength austenitic stainless steel Hardness(HB):150-230

Head Exchangable Drills

| Line speed (m/min) | | Feed (mm/r) | | | | | |
|---------------------|---------------|--------------|-----------|-----------|-----------|-----------|-----------|
| Minimum value | Maximum value | mm | 16.00 | 20.00 | 25.00 | 32.00 | 40.00 |
| 45 | 60 | | 0.10-0.17 | 0.10-0.20 | 0.12-0.22 | 0.14-0.24 | 0.15-0.27 |

Dual phase steel Hardness(HB):135-275

Deep Hole Drills

CDR 45° Chamfer Cutter

Non-standard Tools

Workpiece material:Q345R

Part name : Heat exchange plate

| | THCD | Competitor |
|---------------------------------------|----------------|--------------------------|
| Modular exchangeable-tip drill insert | THCD2530RPG | D25.30 Similar structure |
| Diameter | 25.30mm | 25.30mm |
| Modular exchangeable-tip drill | THCD250R8WT32M | D25x8D |
| VC(Line speed) | 119m/min | 91m/min |
| rpm(Rotating speed) | 1500r/min | 1150r/min |
| F(Feed per revolution) | 0.27mm/r | 0.24mm/r |
| Vf(Feed) | 405mm/min | 276mm/min |
| Hole depth | 190mm | 190mm |
| Number of drill holes | 255 | 187 |

Workpiece material: stainless steel 316L

Part name : Heat exchange plate

| | THCD | Competitor |
|---------------------------------------|----------------|--------------------------|
| Modular exchangeable-tip drill insert | THCD1930RSG | D19.30 Similar structure |
| Diameter | 19.30mm | 19.30mm |
| Modular exchangeable-tip drill | THCD190R7WT25M | D19x7D |
| VC(Line speed) | 60m/min | 50m/min |
| rpm(Rotating speed) | 1000r/min | 850r/min |
| F(Feed per revolution) | 0.14mm/r | 0.11mm/r |
| Vf(Feed) | 140mm/min | 95mm/min |
| Hole depth | 130mm | 130mm |
| Number of drill holes | 460 | 230 |

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