

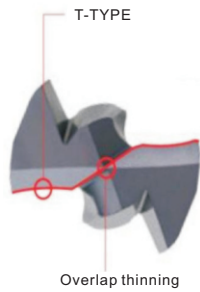
Code system of holder

<b>DDT</b>	<b>C</b>	<b>5D</b> — <b>150</b>	<b>20</b> — <b>75</b>
<b>Insert type</b> C: Cone type	<b>Aspect ratio(L/D)</b> 3D, 5D, 8D	<b>Drill dia.</b> 150: $\phi$ 15.0	<b>Shank dia</b> 20: $\phi$ 20 <b>Flute length (mm)</b>

Code system of insert

<b>DTT</b>	<b>1500</b>	<b>C</b>
<b>Drill dia.</b> 1500: $\phi$ 15.00	<b>Insert type</b> C: Cone type	

Features



Recommended cutting condition

Workpiece			Grade	vc	Depth of cut = 3D,5D		
ISO	Material	HB			Feed rate (mm/rev) per drill dia.(mm)		
				m/min	$\phi$ 12.00- $\phi$ 15.99	$\phi$ 16.00- $\phi$ 25.99	
P	Carbon steel	Low carbon steel	80-120	TD530	110(80-140)	0.15-0.30	0.20-0.35
		High carbon steel	180-280	TD530	100(70-130)	0.15-0.30	0.20-0.35
	Alloy steel	Low alloy steel	140-260	TD530	110(80-140)	0.18-0.35	0.23-0.38
		Low pre-hardened steel	200-400	TD530	75(50-100)	0.18-0.35	0.23-0.38
		High alloy steel	260-320	TD530	70(50-90)	0.18-0.30	0.20-0.35
		High pre-hardened steel	300-450	TD530	60(40-80)	0.18-0.30	0.20-0.35

In case of 8D, reduce the cutting condition 40~50% lower than above after machining the beginning of hole(1.5D).  
In case of interrupted machining, reduce the feed to 0.1~0.15 around the interrupted part.

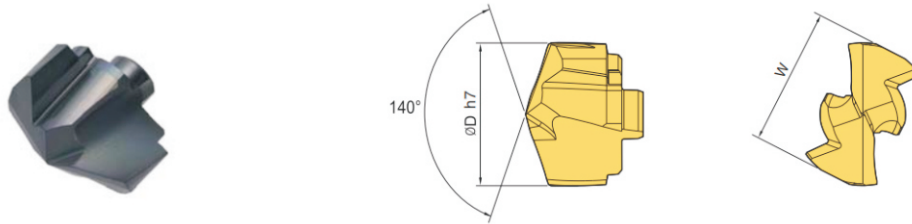
How to make good insert clamping



1. Clean the mounting seat with air or cloth.
2. Put an insert on the holder.
3. A part of wrench and B part of insert must be parallel to each other before clamp the insert. Turn the wrench clockwise to finish clamping.
4. Clamped state

Carbide Drills  
U Drills  
Head Exchangable Drills  
Deep Hole Drills  
CDR 45° Chamfer Cutter  
Non-standard Tools

DTTC insert



Designation	Drill dia. (φ D)	W	Coated	Holder	Wrench
			TD530		
DTT 1200C	12.0	11.4	●	DTTC(3,5,8)D-12016-(36,60,96)	DTTC-W12
1220C	12.2				
1250C	12.5				
1260C	12.6				
1300C	13.0	12.3	●	DTTC(3,5,8)D-13016-(39,65,104)	DTTC-W13
1350C	13.5				
1400C	14.0	13.4	●	DTTC(3,5,8)D-14016-(42,70,112)	DTTC-W14
1420C	14.2				
1430C	14.3				
1450C	14.5				
1500C	15.0	14.3	●	DTTC(3,5,8)D-15020-(45,75,120)	DTTC-W15
1550C	15.5				
1600C	16.0	15.3	●	DTTC(3,5,8)D-16020-(48,80,128)	DTTC-W16
1630C	16.3				
1650C	16.5				
1670C	16.7				
1700C	17.0	16.3	●	DTTC(3,5,8)D-17020-(51,85,136)	DTTC-W17
1750C	17.5				
1770C	17.7				
1800C	18.0				
1810C	18.1	17.3	●	DTTC(3,5,8)D-18025-(54,90,144)	DTTC-W18
1850C	18.5				
1860C	18.6				
1870C	18.7				
1900C	19.0	18.3	●	DTTC(3,5,8)D-19025-(57,95,152)	DTTC-W19
1920C	19.2				
1950C	19.5				
1970C	19.7				
2000C	20.0	19.2	●	DTTC(3,5,8)D-20025-(60,100,160)	DTTC-W20
2050C	20.5				
2100C	21.0	20.1	●	DTTC(3,5,8)D-21025-(63,105,168)	DTTC-W21
2150C	21.5				
2200C	22.0	21.0	●	DTTC(3,5,8)D-22025(66,110,176)	DTTC-W22
2250C	22.5				
2260C	22.6				
2270C	22.7				
2300C	23.0	21.9	●	DTTC(3,5,8)D-23025-(69,115,184)	DTTC-W23
2350C	23.5				
2400C	24.0	22.9	●	DTTC(3,5,8)D-24032-(72,120,192)	DTTC-W24
2450C	24.5				
2500C	25.0	23.9	●	DTTC(3,5,8)D-25032-(75,125,200)	DTTC-W25
2530C	25.3				
2550C	25.5				
2580C	25.8				
2590C	25.9	24.9	●	DTTC(3,5,8)D-26032-(78,130,208)	DTTC-W26
2600C	26.0				
2650C	26.5	25.9	●	DTTC(3,5,8)D-27032-(81,135,216)	DTTC-W27
2700C	27.0				
2750C	27.5	26.9	●	DTTC(3,5,8)D-28032-(84,140,224)	DTTC-W28
2800C	28.0				
2850C	28.5	27.9	●	DTTC(3,5,8)D-29032-(87,145,232)	DTTC-W29
2900C	29.0				
2950C	29.5	28.9	●	DTTC(3,5,8)D-30032-(90,150,240)	DTTC-W30
3000C	30.0				
3050C	30.5				

DTTC Parts

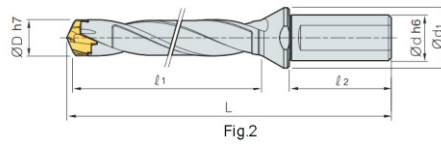
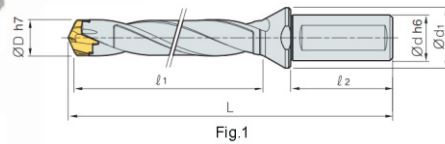
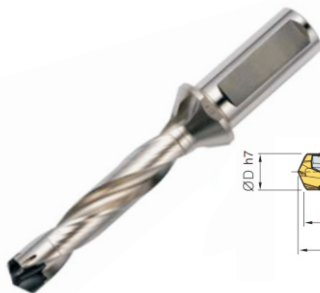
Parts(Recommended torque per wrench)

Designation	Drill dia.( $\phi$ D)	Torque(Nm)
DTTC-W12	12	2.5
DTTC-W13	13	2.5
DTTC-W14	14	2.5
DTTC-W15	15	2.5
DTTC-W16	16	2.5
DTTC-W17	17	2.5
DTTC-W18	18	2.5
DTTC-W19	19	2.5
DTTC-W20	20	3.5

(mm)

Designation	Drill dia.( $\phi$ D)	Torque(Nm)
DTTC-W21	21	3.5
DTTC-W22	22	3.5
DTTC-W23	23	3.5
DTTC-W24	24	3.5
DTTC-W25	25	3.5
DTTC-W26	26	5.5
DTTC-W27	27	5.5
DTTC-W28	28	5.5
DTTC-W29	29	5.5
DTTC-W30	30	5.5

DTTC 3D/5D/8D



Designation	$\phi$ D	$\phi$ d	$\phi$ d1	l1	l2	L	Insert	Fig.
DTTC 3D-12016-36	12.00-12.49	16	20	36	48	99	DTT1200C□-1249C□	1
3D-12516-38	12.50-12.99	16	20	38	48	101	DTT1250C□-1299C□	1
3D-13016-39	13.00-13.49	16	20	39	48	103	DTT1300C□-1349C□	1
3D-13516-41	13.50-13.99	16	20	41	48	105	DTT1350C□-1399C□	1
3D-14016-42	14.00-14.49	16	20	42	48	106	DTT1400C□-1449C□	1
3D-14516-44	14.50-14.99	16	20	44	48	107	DTT1450C□-1449C□	1
3D-15020-45	15.00-15.99	20	25	45	50	113	DTT1500C□-1599C□	2
3D-16020-48	16.00-16.99	20	25	48	50	117	DTT1600C□-1699C□	2
3D-17020-51	17.00-17.99	20	25	51	50	120	DTT1700C□-1799C□	2
3D-18025-54	18.00-18.99	25	33	54	56	132	DTT1800C□-1899C□	2
3D-19025-57	19.00-19.99	25	33	57	56	135	DTT1900C□-1999C□	2
3D-20025-60	20.00-20.99	25	33	60	56	138	DTT2000C□-2099C□	2
3D-21025-63	21.00-21.99	25	33	63	56	141	DTT2100C□-2199C□	2
3D-22025-66	22.00-22.99	25	33	66	56	145	DTT2200C□-2299C□	2
3D-23025-69	23.00-23.99	25	33	69	56	149	DTT2300C□-2399C□	2
3D-24032-72	24.00-24.99	32	43	72	60	159	DTT2400C□-2499C□	2
3D-25032-75	25.00-25.99	32	43	75	60	162	DTT2500C□-2599C□	2
3D-26032-78	26.00-26.99	32	43	78	60	173	DTT2600C□-2699C□	2

Carbide Drills

U Drills

Head Exchangeable Drills

Deep Hole Drills

CDR 45° Chamfer Cutter

Non-standard Tools

DTTC 3D/5D/8D

Designation	$\phi$ D	$\phi$ d	$\phi$ d1	I1	I2	L	Insert	Fig.
DTTC 3D-27032-81	27.00-27.99	32	43	81	60	176	DTT2700C□-2799C□	2
3D-28032-84	28.00-28.99	32	43	84	60	180	DTT2800C□-2899C□	2
3D-29032-87	29.00-29.99	32	43	87	60	185	DTT2900C□-2999C□	2
3D-30032-90	30.00-30.99	32	43	90	60	188	DTT3000C□-3099C□	2
5D-12016-60	12.00-12.49	16	20	60	48	123	DTT1200C□-1249C□	1
5D-12516-63	12.50-12.99	16	20	63	48	126	DTT1250C□-1299C□	1
5D-13016-65	13.00-13.49	16	20	65	48	129	DTT1300C□-1349C□	1
5D-13516-68	13.50-13.99	16	20	68	48	132	DTT1350C□-1399C□	1
5D-14016-70	14.00-14.49	16	20	70	48	134	DTT1400C□-1449C□	1
5D-14516-73	14.50-14.99	16	20	73	48	136	DTT1450C□-1499C□	1
5D-15020-75	15.00-15.99	20	25	75	50	143	DTT1500C□-1599C□	2
5D-16020-80	16.00-16.99	20	25	80	50	149	DTT1600C□-1699C□	2
5D-17020-85	17.00-17.99	20	25	85	50	154	DTT1700C□-1799C□	2
5D-18025-90	18.00-18.99	25	33	90	56	168	DTT1800C□-1899C□	2
5D-19025-95	19.00-19.99	25	33	95	56	173	DTT1900C□-1999C□	2
5D-20025-100	20.00-20.99	25	33	100	56	178	DTT2000C□-2099C□	2
5D-21025-105	21.00-21.99	25	33	105	56	183	DTT2100C□-2199C□	2
5D-22025-110	22.00-22.99	25	33	110	56	189	DTT2200C□-2299C□	2
5D-23025-115	23.00-23.99	25	33	115	56	195	DTT2300C□-2399C□	2
5D-24032-120	24.00-24.99	32	43	120	60	207	DTT2400C□-2499C□	2
5D-25032-125	25.00-25.99	32	43	125	60	212	DTT2500C□-2599C□	2
5D-26032-130	26.00-26.99	32	43	130	60	225	DTT2600C□-2699C□	2
5D-27032-135	27.00-27.99	32	43	135	60	230	DTT2700C□-2799C□	2
5D-28032-140	28.00-28.99	32	43	140	60	236	DTT2800C□-2899C□	2
5D-29032-145	29.00-29.99	32	43	145	60	243	DTT2900C□-2999C□	2
5D-30032-150	30.00-30.99	32	43	150	60	248	DTT3000C□-3099C□	2
8D-12016-96	12.00-12.49	16	20	96	48	159	DTT1200C□-1249C□	1
8D-12516-100	12.50-12.99	16	20	100	48	163	DTT1250C□-1299C□	1
8D-13016-104	13.00-13.49	16	20	104	48	168	DTT1300C□-1349C□	1
8D-13516-108	13.50-13.99	16	20	108	48	173	DTT1350C□-1399C□	1
8D-14016-112	14.00-14.49	16	20	112	48	176	DTT1400C□-1449C□	1
8D-14516-116	14.50-14.99	16	20	116	48	180	DTT1450C□-1499C□	1
8D-15020-120	15.00-15.99	20	25	120	50	188	DTT1500C□-1599C□	2
8D-16020-128	16.00-16.99	20	25	128	50	197	DTT1600C□-1699C□	2
8D-17020-136	17.00-17.99	20	25	136	50	205	DTT1700C□-1799C□	2
8D-18025-144	18.00-18.99	25	33	144	56	222	DTT1800C□-1899C□	2
8D-19025-152	19.00-19.99	25	33	152	56	230	DTT1900C□-1999C□	2
8D-20025-160	20.00-20.99	25	33	160	56	238	DTT2000C□-2099C□	2
8D-21025-168	21.00-21.99	25	33	168	56	246	DTT2100C□-2199C□	2
8D-22025-176	22.00-22.99	25	33	176	56	255	DTT2200C□-2299C□	2
8D-23025-184	23.00-23.99	25	33	184	56	264	DTT2300C□-2399C□	2
8D-24032-192	24.00-24.99	32	43	192	60	279	DTT2400C□-2499C□	2
8D-25032-200	25.00-25.99	32	43	200	60	287	DTT2500C□-2599C□	2
8D-26032-208	26.00-26.99	32	43	208	60	303	DTT2600C□-2699C□	2
8D-27032-216	27.00-27.99	32	43	216	60	311	DTT2700C□-2799C□	2
8D-28032-224	28.00-28.99	32	43	224	60	320	DTT2800C□-2899C□	2
8D-29032-232	29.00-29.99	32	43	232	60	330	DTT2900C□-2999C□	2
8D-30032-240	30.00-30.99	32	43	240	60	338	DTT3000C□-3099C□	2