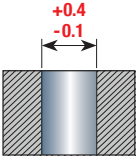
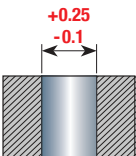
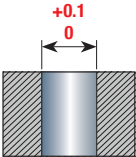
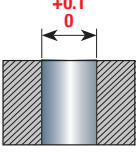
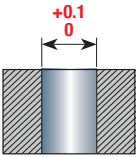
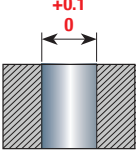
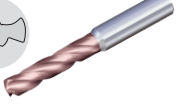


HOLEMAKING Selection Guide

Tool Selection by Application

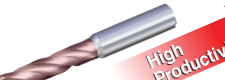
	Hole tolerance (mm)	Application	Recommended drill series	Diameter range
Rough		 Medium to large	  TOP 2/3/4/5D	Direct mounting Ø12.0 - Ø50.0 mm Cartridge type Ø51.0 - Ø80.0 mm
		 Medium to large	  TNDH (Head) MDB-3/5/7D (Body)	Ø26.0 - Ø50.0 mm

General		 Medium to large	  LCD-3/5/8D	Ø20.0 - Ø41.0 mm
		 Small to medium	  TCD-1.5/3/5/8/12D	Ø4.0 - Ø25.9 mm

High Productivity		 Small to medium	  3ED-3/5/8D	Ø12.0 - Ø25.9 mm
		 Small hole drilling	  3HD-PI3/PI5/PI8 3HD-CI2	Ø4.0 - Ø12.0 mm

ISO materials			
	 for Alloy steel	 for Low carbon steel	
 *N: SOMT-DA	SOMT-DP TT9080 Vc 180 - 160 - 140 fn 0.08 - 0.12 - 0.14	SOMT-DL TT9080 Vc 220 - 180 - 160 fn 0.06 - 0.08 - 0.10	SOMT-DK TT6080 Vc 200 - 160 - 140 fn 0.10 - 0.15 - 0.20
	 Vc 180 - 140 - 100 fn 0.20 - 0.25 - 0.35		 Vc 200 - 160 - 120 fn 0.20 - 0.30 - 0.50
	TCD-P-CO+	SPGX-DW TT9080	TCD-P-CO+

	 Vc 200 - 100 - 80 fn 0.20 - 0.25 - 0.30	 Vc 80 - 60 - 70 fn 0.12 - 0.20 - 0.25	 Vc 150 - 120 - 100 fn 0.20 - 0.35 - 0.50
 *N: TCD-N	LCD-P/P+ TT9080	LCD-P TT9080	LCD-P/P+ TT9080
	 Vc 200 - 100 - 70 fn 0.20 - 0.25 - 0.30	 Vc 70 - 60 - 50 fn 0.12 - 0.18 - 0.25	 Vc 150 - 120 - 100 fn 0.20 - 0.27 - 0.35
	TCD-P/P+ TT9080	TCD-M TT9080	TCD-K TT9080

	 Vc 140 - 100 - 70 fn 0.30 - 0.40 - 0.55	-	 Vc 160 - 120 - 80 fn 0.40 - 0.50 - 0.60
	3ED-P+ TT5130		3ED-P+ TT5130
	 Vc 140 - 100 - 70 fn 0.20 - 0.35 - 0.55	-	 Vc 140 - 100 - 80 fn 0.25 - 0.45 - 0.60
	3HD TT5130		3HD TT5130

(Vc, m/min, fn, mm/rev)