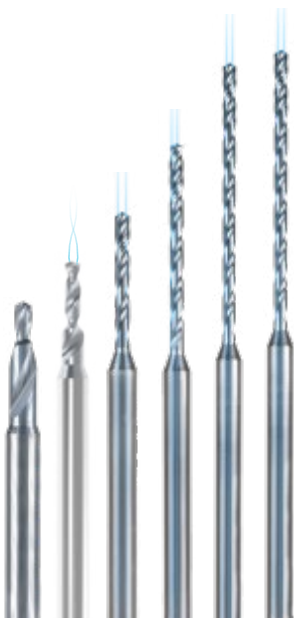


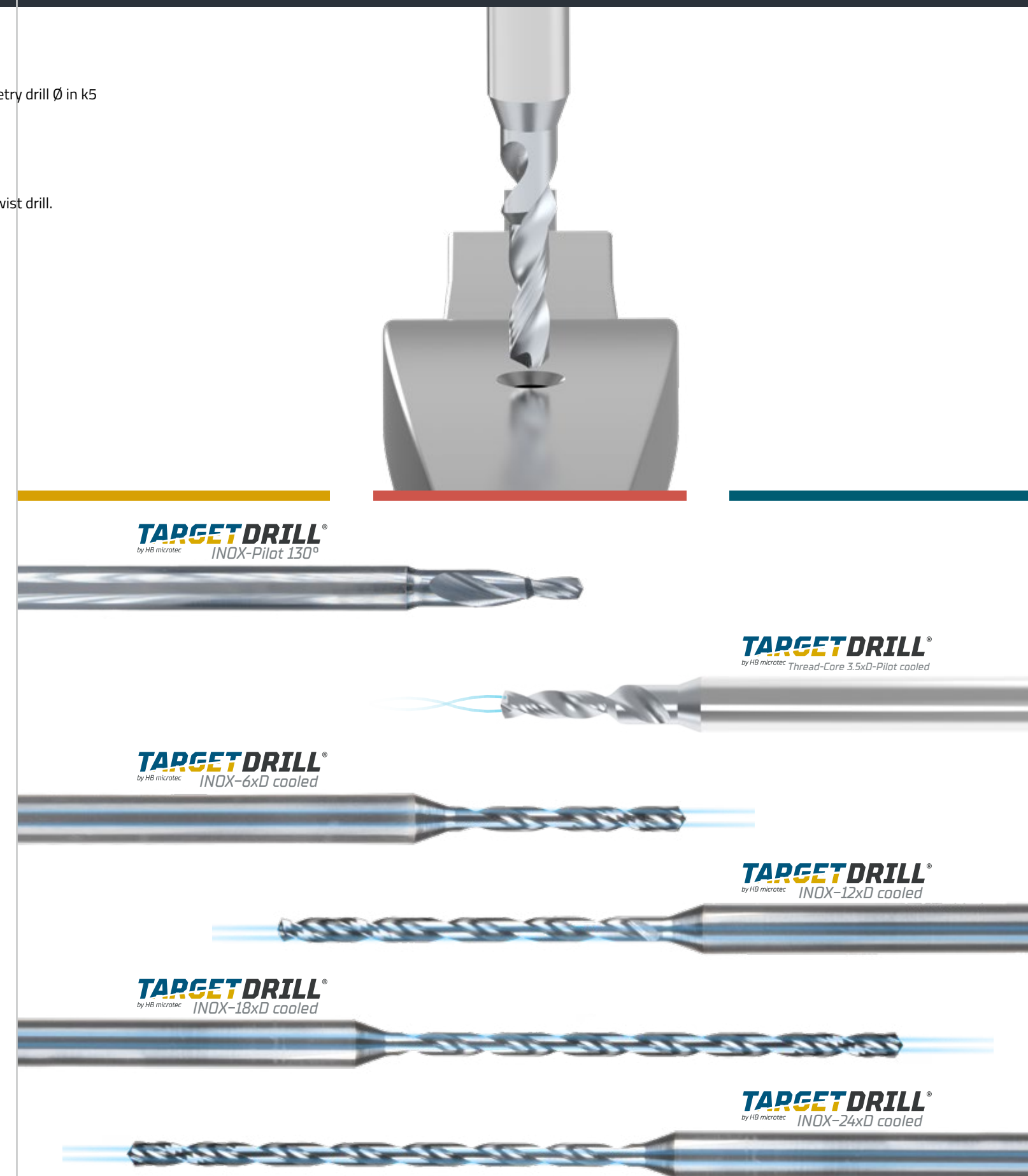
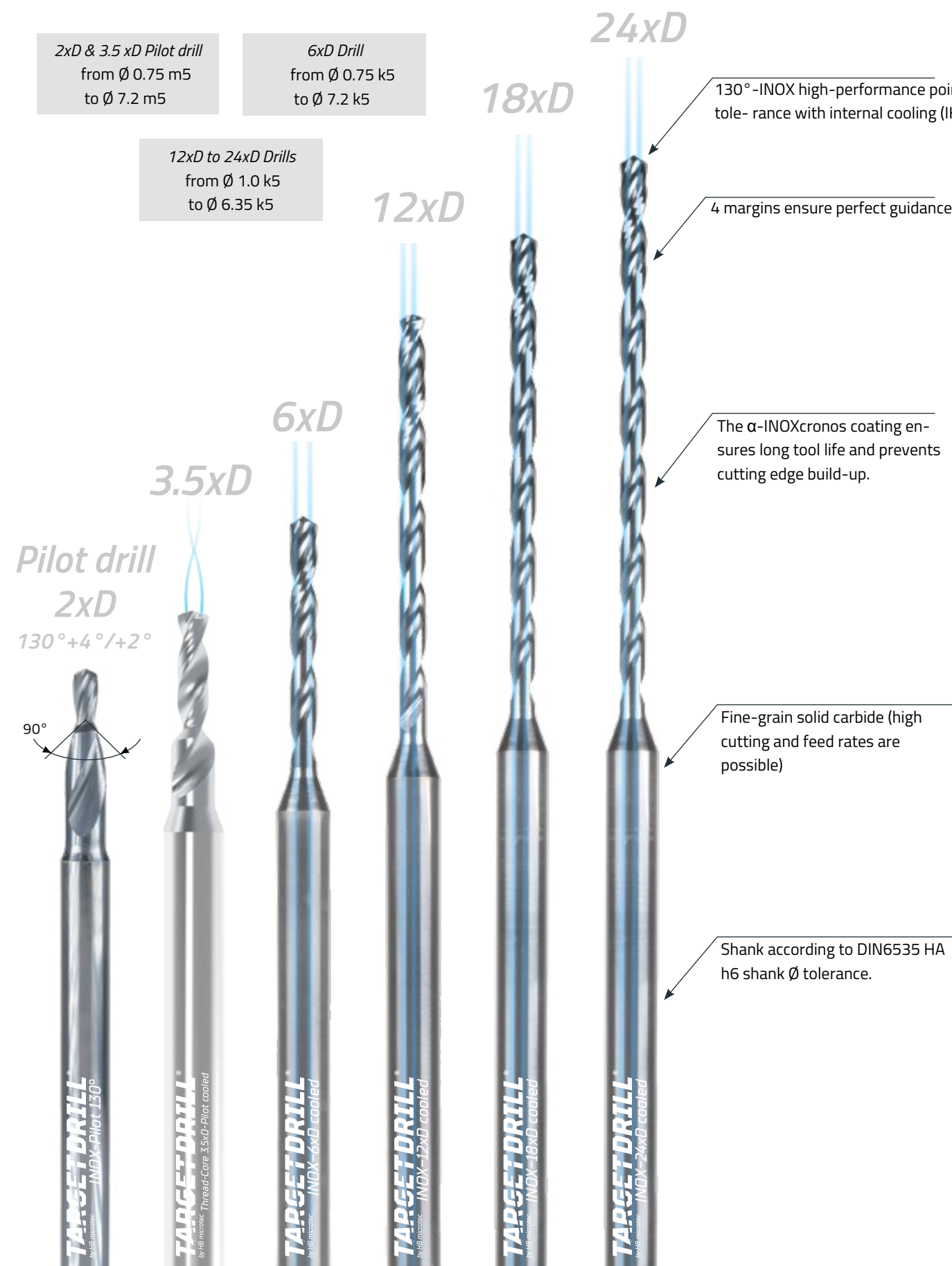
INOX-2D/3,5D/6D/8D/12D/18D/24D

HBmicrotec[®]
ACTIONTOOLS & ENGINEERING

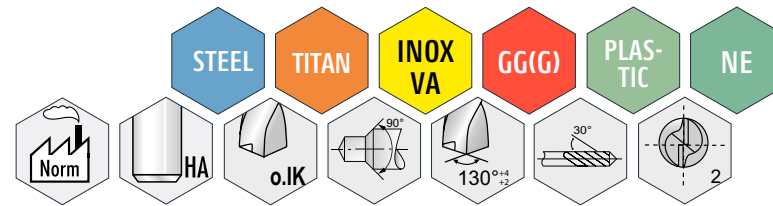


TARGET DRILL[®]
by HB microtec
INOX cooled

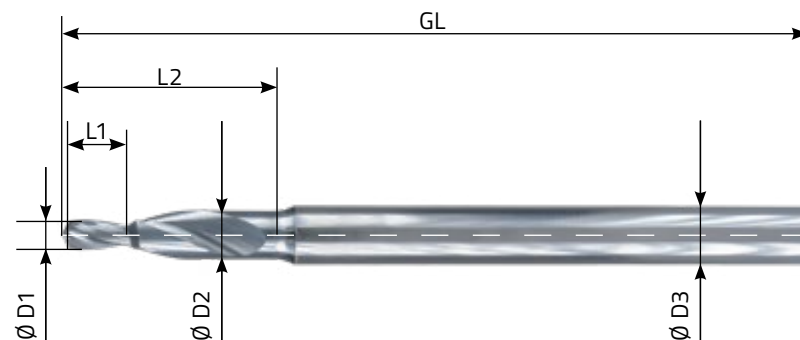
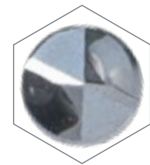




INOX-Pilot 130°



TARGETDRILL INOX-Pilot
TD.IP.100.200.90 ← 90° chamfer
D1: Ø 1.00mm L1: 2.00mm



■ α-INOXcronos coated



5 PRO's of the ACTIONDRILL:

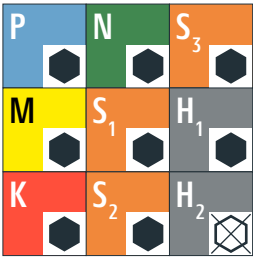
- Combination tool: centering + drilling + chamfering
- Perfect positional accuracy
- 2xD drilling + chamfering
- Pilot drill (tolerance Øm5) for deep-hole drilling
- Shorter process times and high process reliability

Article number	D1 m5 (mm)	D1 m5 (inch)	D2 (mm)	D3 (mm)	L1 (mm)	L2 (mm)	GL (mm)
TD.IP.075.150.90	Ø 0.750	-	Ø 1.80	Ø 3.00	1.50	7.30	45.00
TD.IP.080.160.90	Ø 0.800	-	Ø 1.80	Ø 3.00	1.60	7.30	45.00
TD.IP.085.170.90	Ø 0.850	-	Ø 1.80	Ø 3.00	1.70	7.30	45.00
TD.IP.090.180.90	Ø 0.900	-	Ø 1.80	Ø 3.00	1.80	8.30	45.00
TD.IP.095.190.90	Ø 0.950	-	Ø 1.80	Ø 3.00	1.90	7.30	45.00
TD.IP.100.200.90	Ø 1.000	-	Ø 1.80	Ø 4.00	2.00	7.30	45.00
TD.IP.105.210.90	Ø 1.050	-	Ø 1.80	Ø 4.00	2.10	7.70	45.00
TD.IP.110.220.90	Ø 1.100	-	Ø 1.80	Ø 4.00	2.20	8.05	45.00
TD.IP.115.230.90	Ø 1.150	-	Ø 1.80	Ø 4.00	2.30	8.40	45.00
TD.IP.120.240.90	Ø 1.200	-	Ø 2.10	Ø 4.00	2.40	8.80	45.00
TD.IP.125.250.90	Ø 1.250	-	Ø 2.10	Ø 4.00	2.50	9.15	45.00
TD.IP.130.260.90	Ø 1.300	-	Ø 2.10	Ø 4.00	2.60	9.50	45.00
TD.IP.135.270.90	Ø 1.350	-	Ø 2.10	Ø 4.00	2.70	9.90	45.00
TD.IP.140.280.90	Ø 1.400	-	Ø 2.10	Ø 4.00	2.80	10.25	45.00
TD.IP.145.290.90	Ø 1.450	-	Ø 2.45	Ø 4.00	2.90	10.60	45.00
TD.IP.150.300.90	Ø 1.500	-	Ø 2.45	Ø 4.00	3.00	10.95	48.00
TD.IP.155.310.90	Ø 1.550	-	Ø 2.45	Ø 4.00	3.10	11.35	48.00
TD.IP.1588.3175.90	Ø 1.588	1/16"	Ø 2.45	Ø 4.00	3.175	11.70	48.00
TD.IP.160.320.90	Ø 1.600	-	Ø 2.45	Ø 4.00	3.20	11.70	48.00
TD.IP.165.330.90	Ø 1.650	-	Ø 2.45	Ø 4.00	3.30	12.05	48.00
TD.IP.170.340.90	Ø 1.700	-	Ø 2.80	Ø 4.00	3.40	12.45	48.00
TD.IP.175.350.90	Ø 1.750	-	Ø 2.80	Ø 4.00	3.50	12.80	48.00
TD.IP.180.360.90	Ø 1.800	-	Ø 2.80	Ø 4.00	3.60	13.15	48.00
TD.IP.185.370.90	Ø 1.850	-	Ø 2.80	Ø 4.00	3.70	13.55	48.00
TD.IP.190.380.90	Ø 1.900	-	Ø 2.80	Ø 4.00	3.80	13.90	48.00
TD.IP.195.390.90	Ø 1.950	-	Ø 2.80	Ø 4.00	3.90	14.25	48.00
TD.IP.200.400.90	Ø 2.000	-	Ø 3.30	Ø 4.00	4.00	14.60	52.00
TD.IP.203.4060.90	Ø 2.030	-	Ø 3.30	Ø 4.00	4.06	15.00	52.00
TD.IP.205.410.90	Ø 2.050	-	Ø 3.30	Ø 4.00	4.10	15.00	52.00
TD.IP.210.420.90	Ø 2.100	-	Ø 3.30	Ø 4.00	4.20	15.35	52.00
TD.IP.215.430.90	Ø 2.150	-	Ø 3.30	Ø 4.00	4.30	15.70	52.00
TD.IP.220.440.90	Ø 2.200	-	Ø 3.30	Ø 4.00	4.40	16.10	52.00
TD.IP.225.450.90	Ø 2.250	-	Ø 3.30	Ø 4.00	4.50	16.45	52.00
TD.IP.230.460.90	Ø 2.300	-	Ø 3.60	Ø 4.00	4.60	16.80	52.00
TD.IP.233.4660.90	Ø 2.330	-	Ø 3.60	Ø 4.00	4.66	17.20	52.00
TD.IP.235.470.90	Ø 2.350	-	Ø 3.60	Ø 4.00	4.70	17.20	52.00
TD.IP.2381.4762.90	Ø 2.381	3/32"	Ø 3.60	Ø 4.00	4.762	17.55	52.00
TD.IP.240.480.90	Ø 2.400	-	Ø 3.60	Ø 4.00	4.80	17.55	52.00
TD.IP.245.490.90	Ø 2.450	-	Ø 3.60	Ø 4.00	4.90	17.90	52.00
TD.IP.250.500.90	Ø 2.500	-	Ø 3.60	Ø 4.00	5.00	18.25	56.00
TD.IP.255.510.90	Ø 2.550	-	Ø 3.60	Ø 4.00	5.10	18.65	56.00
TD.IP.260.520.90	Ø 2.600	-	Ø 4.00	Ø 4.00	5.20	-	56.00
TD.IP.265.530.90	Ø 2.650	-	Ø 4.00	Ø 4.00	5.30	-	56.00
TD.IP.270.540.90	Ø 2.700	-	Ø 4.00	Ø 4.00	5.40	-	56.00
TD.IP.275.550.90	Ø 2.750	-	Ø 4.00	Ø 4.00	5.50	-	56.00
TD.IP.280.560.90	Ø 2.800	-	Ø 4.00	Ø 4.00	5.60	-	56.00
TD.IP.285.570.90	Ø 2.850	-	Ø 4.00	Ø 4.00	5.70	-	56.00
TD.IP.290.580.90	Ø 2.900	-	Ø 4.00	Ø 4.00	5.80	-	56.00
TD.IP.295.590.90	Ø 2.950	-	Ø 4.00	Ø 4.00	5.90	-	56.00
TD.IP.300.600.90	Ø 3.000	-	Ø 4.80	Ø 6.00	6.00	21.90	60.00
TD.IP.305.610.90	Ø 3.050	-	Ø 4.80	Ø 6.00	6.10	22.30	60.00
TD.IP.310.620.90	Ø 3.100	-	Ø 4.80	Ø 6.00	6.20	22.65	60.00
TD.IP.315.630.90	Ø 3.150	-	Ø 4.80	Ø 6.00	6.30	23.00	60.00

Article number	D1 m5 (mm)	D1 m5 (inch)	D2 (mm)	D3 (mm)	L1 (mm)	L2 (mm)	GL (mm)
TD.IP.3175.6350.90	Ø 3.175	1/8"	Ø 4.80	Ø 6.00	6.35	23.40	60.00
TD.IP.320.640.90	Ø 3.200	-	Ø 4.80	Ø 6.00	6.40	23.40	60.00
TD.IP.325.650.90	Ø 3.250	-	Ø 4.80	Ø 6.00	6.50	23.75	60.00
TD.IP.330.660.90	Ø 3.300	-	Ø 4.80	Ø 6.00	6.60	24.10	60.00
TD.IP.335.670.90	Ø 3.350	-	Ø 4.80	Ø 6.00	6.70	24.50	60.00
TD.IP.340.680.90	Ø 3.400	-	Ø 4.80	Ø 6.00	6.80	24.85	60.00
TD.IP.345.690.90	Ø 3.450	-	Ø 4.80	Ø 6.00	6.90	25.20	60.00
TD.IP.350.700.90	Ø 3.500	-	Ø 5.50	Ø 6.00	7.00	25.55	65.00
TD.IP.355.710.90	Ø 3.550	-	Ø 5.50	Ø 6.00	7.10	25.95	65.00
TD.IP.360.720.90	Ø 3.600	-	Ø 5.50	Ø 6.00	7.20	26.30	65.00
TD.IP.365.730.90	Ø 3.650	-	Ø 5.50	Ø 6.00	7.30	26.65	65.00
TD.IP.370.740.90	Ø 3.700	-	Ø 5.50	Ø 6.00	7.40	27.05	65.00
TD.IP.375.750.90	Ø 3.750	-	Ø 5.50	Ø 6.00	7.50	27.40	70.00
TD.IP.380.760.90	Ø 3.800	-	Ø 5.50	Ø 6.00	7.60	27.75	70.00
TD.IP.385.770.90	Ø 3.850	-	Ø 5.50	Ø 6.00	7.70	28.15	70.00
TD.IP.390.780.90	Ø 3.900	-	Ø 5.50	Ø 6.00	7.80	28.50	70.00
TD.IP.395.790.90	Ø 3.950	-	Ø 5.50	Ø 6.00	7.90	28.85	70.00
TD.IP.3969.7937.90	Ø 3.969	5/32"	Ø 5.50	Ø 6.00	7.937	29.20	70.00
TD.IP.400.800.90	Ø 4.000	-	Ø 5.50	Ø 6.00	8.00	29.20	70.00
TD.IP.410.820.90	Ø 4.100	-	Ø 6.00	Ø 6.00	8.20	-	75.00
TD.IP.420.840.90	Ø 4.200	-	Ø 6.00	Ø 6.00	8.40	-	75.00
TD.IP.430.860.90	Ø 4.300	-	Ø 6.00	Ø 6.00	8.60	-	75.00
TD.IP.440.880.90	Ø 4.400	-	Ø 6.00	Ø 6.00	8.80	-	75.00
TD.IP.450.900.90	Ø 4.500	-	Ø 6.00	Ø 6.00	9.00	-	75.00
TD.IP.460.920.90	Ø 4.600	-	Ø 6.00	Ø 6.00	9.20	-	75.00
TD.IP.465.930.90	Ø 4.650	-	Ø 6.00	Ø 6.00	9.30	-	75.00
TD.IP.470.940.90	Ø 4.700	-	Ø 6.00	Ø 6.00	9.40	-	75.00
TD.IP.4763.9525.90	Ø 4.763	3/16"	Ø 6.00	Ø 6.00	9.525	-	75.00
TD.IP.480.960.90	Ø 4.800	-	Ø 6.00	Ø 6.00	9.60	-	75.00
TD.IP.490.980.90	Ø 4.900	-	Ø 6.00	Ø 6.00	9.80	-	75.00
TD.IP.500.1000.90	Ø 5.000	-	Ø 8.00	Ø 8.00	10.00	-	80.00
TD.IP.510.1020.90	Ø 5.100	-	Ø 8.00	Ø 8.00	10.20	-	80.00
TD.IP.520.1040.90	Ø 5.200	-	Ø 8.00	Ø 8.00	10.40	-	80.00
TD.IP.530.1060.90	Ø 5.300	-	Ø 8.00	Ø 8.00	10.60	-	80.00
TD.IP.540.1080.90	Ø 5.400	-	Ø 8.00	Ø 8.00	10.80	-	80.00
TD.IP.550.1100.90	Ø 5.500	-	Ø 8.00	Ø 8.00	11.00	-	80.00
TD.IP.5556.1111.90	Ø 5.556	7/32"	Ø 8.00	Ø 8.00	11.112	-	80.00
TD.IP.560.1120.90	Ø 5.600	-	Ø 8.00	Ø 8.00	11.20	-	80.00
TD.IP.570.1140.90	Ø 5.700	-	Ø 8.00	Ø 8.00	11.40	-	80.00
TD.IP.580.1160.90	Ø 5.800	-	Ø 8.00	Ø 8.00	11.60	-	80.00
TD.IP.590.1180.90	Ø 5.900	-	Ø 8.00	Ø 8.00	11.80	-	80.00
TD.IP.600.1200.90	Ø 6.000	-	Ø 8.00	Ø 8.00	12.00	-	80.00
TD.IP.620.12400.90	Ø 6.200	-	Ø 8.00	Ø 8.00	12.40	-	80.00
TD.IP.6350.1270.90	Ø 6.350	1/4"	Ø 8.00	Ø 8.00	12.70	-	80.00
TD.IP.660.1320.90	Ø 6.600	-	Ø 8.00	Ø 8.00	13.20	-	80.00
TD.IP.670.1320.90	Ø 6.700	-	Ø 8.00	Ø 8.00	13.40	-	80.00
TD.IP.680.1360.90	Ø 6.800	-	Ø 8.00	Ø 8.00	13.60	-	80.00
TD.IP.690.1360.90	Ø 6.900	-	Ø 8.00	Ø 8.00	13.80	-	80.00
TD.IP.700.1400.90	Ø 7.000	-	Ø 8.00	Ø 8.00	14.00	-	80.00
TD.IP.720.1400.90	Ø 7.200	-	Ø 8.00	Ø 8.00	14.40	-	80.00

Available from stock



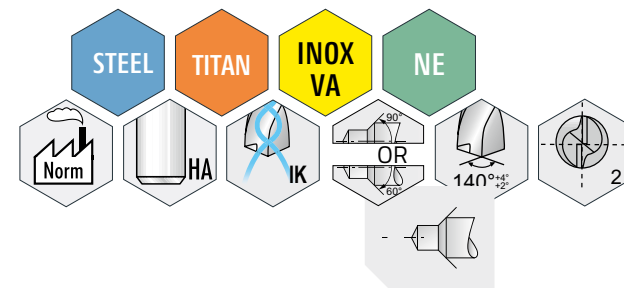


Recommended use Highly suitable Partially suitable Not recommended

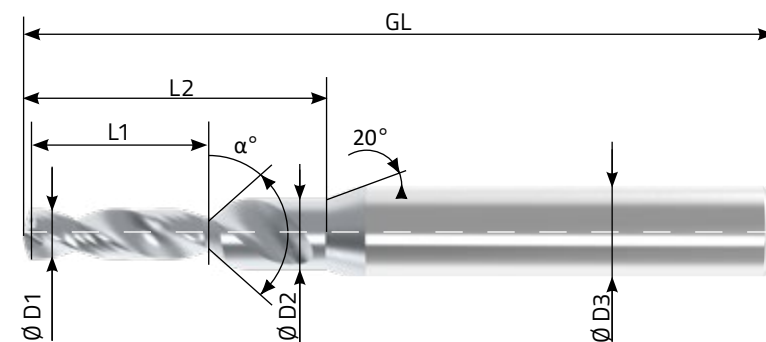
Material group	Material group	Mat. no.	DIN	AISI/ASTM/UNS
P	Steels up to RM < 1200N/mm ²	1.0044	S275JR	AISI 1020
		1.0715	11SMn30	AISI 1215
		1.7131	16MnCr5	AISI 5115
		1.3505	100Cr6	AISI 52100
		1.7225	42CrMo4	AISI 4140
M	Stainless steels: ferritic, martensitic, austenitic	1.4034	X46Cr13	AISI 420C
		1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH
		1.4301	X5CrNi 18-10	AISI 304
		1.4435	X2CrNiMo 18-14-3	AISI 316L
K	Cast iron	0.6020	GG20	ASTM 30
		0.6030	GG30	ASTM 40B
		0.7040	GGG40	ASTM 60-40-18
		0.7060	GGG60	ASTM 80-60-03
N	Non-ferrous metals	3.2315	AlMgSi1	ASTM 6351
		2.0065	Cu-ETP / CW004A	UNS C11000
		2.0321	CuZn37 CW508L	UNS C27400
		2.0401	CuZn39Pb3 / CW614N	UNS C38500
		2.0966	CuAl10Ni5Fe4	UNS C63000
S (S1, S2, S3)	Heat-resistant steels, titanium, CrCo	2.4617	NiMo28	Hastelloy B-2
		2.4665	NiCr22Fe18Mo	Hastelloy X
		3.7165	TiAl6V4	ASTM B348 / F136
		9.9367	TiAl6Nb7	ASTM F1295
		2.4964	CoCr20W15Ni	Haynes 25
H	Hardened steels ≥ 60 HRC		CrCoMo28	ASTM F1537
		1.2510	100MnCrMoW4	AISI O1
		1.2379	X153CrMoV12	AISI D2

Ø 0.75 - 1.2 mm		Ø 1.2 - 1.8 mm		Ø 1.8 - 2.5 mm		Ø 2.5 - 4.0 mm		Ø 4.0 - 7.2 mm	
vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]
40-85	0.042 - 0.066	60-130	0.122 - 0.128	60-130	0.130 - 0.182	60-140	0.128 - 0.232	60-160	0.220 - 0.280
40-90	0.042 - 0.056	60-120	0.120 - 0.122	60-130	0.130 - 0.182	60-120	0.128 - 0.202	60-150	0.200 - 0.260
50-120	0.025 - 0.04	50-120	0.043 - 0.055	50-120	0.060 - 0.080	50-100	0.074 - 0.098	50-120	0.115 - 0.185
50-80	0.02 - 0.038	50-80	0.040 - 0.068	50-90	0.050 - 0.070	50-90	0.072 - 0.084	50-100	0.115 - 0.175
80-140	0.030 - 0.042	80-140	0.06 - 0.115	80-160	0.126 - 0.135	80-160	0.100 - 0.145	80-180	0.145 - 0.210
80-160	0.042 - 0.066	80-160	0.096 - 0.122	80-160	0.132 - 0.18	80-160	0.136 - 0.172	80-180	0.200 - 0.250
80-140	0.046 - 0.088	80-140	0.098 - 0.122	80-160	0.132 - 0.210	80-160	0.134 - 0.164	80-180	0.200 - 0.252
80-120	0.032 - 0.088	80-120	0.066 - 0.122	80-140	0.085 - 0.120	80-120	0.132 - 0.162	80-160	0.195 - 0.242
15 - 50	0.025 - 0.045	15 - 50	0.049 - 0.060	15 - 60	0.060 - 0.07	15 - 70	0.062 - 0.08	15 - 80	0.080 - 0.10
15 - 50	0.025 - 0.045	15 - 50	0.048 - 0.060	15 - 60	0.060 - 0.07	15 - 70	0.062 - 0.08	15 - 80	0.080 - 0.10
15 - 50	0.020 - 0.024	15 - 50	0.05 - 0.060	15 - 50	0.055 - 0.07	15 - 60	0.052 - 0.08	15 - 75	0.076 - 0.10
15-32	0.005 - 0.009	15-32	0.006 - 0.010	15-32	0.006 - 0.012	15-35	0.009 - 0.014	15-40	0.009 - 0.018
15-32	0.004 - 0.009	15-32	0.006 - 0.010	15-32	0.006 - 0.012	15-35	0.009 - 0.014	15-40	0.009 - 0.018

3.5xD Threaded core drill Step drill - Pilot drill



TARGETDRILL
TD.TC.100.IK.XX ← XX= α 60 or 90°
D1 m6 Internal cooling



■ α-INOXcronos coated



5 PRO's of the TARGETDRILL:

- Combination tool: centering + drilling + chamfering
- High-performance 4-margin drill
- 3.5xD core drill for all thread types up to M8
- Pilot drill (tolerance Øm6) for deep hole drilling
- Shorter process times and high process reliability

Article number	D1 m6 (mm)	D1 m6 (inch)	For thread taps	For thread formers	D2 (mm)	D3 h6 (mm)	L1 (mm)	L2 (mm)	α (XX°)	GL (mm)
TD.TC.075.IK.XX	0.750	-	M1x0.25	-	1.950	3	2.625	8.00	60° / 90°	50
TD.TC.080.IK.XX	0.800	-	-	-	2.000	3	2.800	8.00	60° / 90°	50
TD.TC.085.IK.XX	0.850	-	M1.1x0.25	-	2.050	3	2.975	8.00	60° / 90°	50
TD.TC.090.IK.XX	0.900	-	-	M1	2.100	3	2.700	8.00	60° / 90°	50
TD.TC.095.IK.XX	0.950	-	M1.2x0.25	-	2.150	3	3.325	8.00	60° / 90°	50
TD.TC.100.IK.XX	1.000	-	M1.2x0.2	M1.1	2.200	3	3.500	8.20	60° / 90°	50
TD.TC.105.IK.XX	1.050	-	-	-	2.250	3	3.675	8.30	60° / 90°	50
TD.TC.110.IK.XX	1.100	-	M1.4	M1.2	2.300	3	3.850	8.50	60° / 90°	50
TD.TC.115.IK.XX	1.150	-	-	-	2.350	3	4.025	8.60	60° / 90°	50
TD.TC.120.IK.XX	1.200	-	M1.4x0.2	-	2.400	3	4.200	8.70	60° / 90°	50
TD.TC.125.IK.XX	1.250	-	M1.6/#0-80	-	2.450	4	4.375	9.70	60° / 90°	60
TD.TC.130.IK.XX	1.300	-	UNF-Nr.0 / M1.6x0.35	-	2.500	4	4.550	9.80	60° / 90°	60
TD.TC.135.IK.XX	1.350	-	M1.7	-	2.550	4	4.725	9.90	60° / 90°	60
TD.TC.140.IK.XX	1.400	-	M1.6x0.2	#0-80	2.600	4	4.900	10.00	60° / 90°	60
TD.TC.145.IK.XX	1.450	-	M1.8	-	2.650	4	5.075	10.10	60° / 90°	60
TD.TC.150.IK.XX	1.500	-	UNC-Nr.1	M1.6	2.700	4	5.250	11.10	60° / 90°	60
TD.TC.155.IK.XX	1.550	-	#1-64	-	2.750	4	5.425	11.20	60° / 90°	60
TD.TC.1587.IK.XX	1.587	1/16"	-	-	2.787	4	5.555	11.30	60° / 90°	60
TD.TC.160.IK.XX	1.600	-	UNF-Nr.1/M2/M1.8x0.2	-	2.800	4	5.600	11.30	60° / 90°	60
TD.TC.165.IK.XX	1.650	-	-	-	2.850	4	5.775	11.40	60° / 90°	60
TD.TC.170.IK.XX	1.700	-	-	#1-64/#1-72	2.900	4	5.950	11.60	60° / 90°	60
TD.TC.175.IK.XX	1.750	-	M2.2/M2x0.25	-	2.950	4	6.125	11.70	60° / 90°	60
TD.TC.180.IK.XX	1.800	-	UNC-Nr.2	-	3.000	4	6.300	12.60	60° / 90°	60
TD.TC.185.IK.XX	1.850	-	#2-56/#2-64	M2	3.050	4	6.475	12.80	60° / 90°	60
TD.TC.190.IK.XX	1.900	-	UNF-Nr.2/M2.3	-	3.100	4	6.650	12.90	60° / 90°	60
TD.TC.195.IK.XX	1.950	-	M2.2x0.25/M2.3x0.35	-	3.150	4	6.825	13.00	60° / 90°	60
TD.TC.200.IK.XX	2.000	-	-	#2-56	3.200	4	7.000	13.10	60° / 90°	60
TD.TC.203.IK.XX	2.030	-	-	M2.2	3.230	4	7.105	13.20	60° / 90°	60
TD.TC.205.IK.XX	2.050	-	M2.5/M2.3x0.25	-	3.250	4	7.175	13.20	60° / 90°	60
TD.TC.210.IK.XX	2.100	-	MJ2.5x0.45/#3-48/UNF-Nr.3	-	3.300	4	7.350	13.30	60° / 90°	60
TD.TC.215.IK.XX	2.150	-	M2.6/M2.5x0.35/#3-56	M2.3	3.350	4	7.525	13.40	60° / 90°	60
TD.TC.220.IK.XX	2.200	-	-	-	3.400	4	7.700	15.30	60° / 90°	60
TD.TC.225.IK.XX	2.250	-	M2.6x0.35	-	3.450	6	7.875	15.40	60° / 90°	70
TD.TC.230.IK.XX	2.300	-	UNC-Nr.4	#3-48	3.500	6	8.050	15.50	60° / 90°	70
TD.TC.233.IK.XX	2.330	-	-	M2.5	3.530	6	8.155	15.60	60° / 90°	70
TD.TC.235.IK.XX	2.350	-	#4-40	-	3.550	6	8.225	15.60	60° / 90°	70
TD.TC.2381.IK.XX	2.381	3/32"	-	-	3.581	6	8.334	15.70	60° / 90°	70
TD.TC.240.IK.XX	2.400	-	UNF-Nr.4/#4-48	-	3.600	6	8.400	15.70	60° / 90°	70
TD.TC.245.IK.XX	2.450	-	-	-	3.650	6	8.575	15.90	60° / 90°	70
TD.TC.250.IK.XX	2.500	-	M3	-	3.700	6	8.750	16.00	60° / 90°	70
TD.TC.255.IK.XX	2.550	-	-	#4-40	3.750	6	8.925	16.10	60° / 90°	70
TD.TC.260.IK.XX	2.600	-	UNF/UNC-Nr.5/MJ3x0.5	-	3.800	6	9.100	16.20	60° / 90°	70
TD.TC.265.IK.XX	2.650	-	M3x0.35/#5-40	-	3.850	6	9.275	17.20	60° / 90°	70
TD.TC.270.IK.XX	2.700	-	#5-44	-	3.900	6	9.450	17.30	60° / 90°	70
TD.TC.275.IK.XX	2.750	-	M3x0.25	-	3.950	6	9.625	17.40	60° / 90°	70
TD.TC.280.IK.XX	2.800	-	UNC-Nr.6	M3	4.000	6	9.800	17.50	60° / 90°	70
TD.TC.285.IK.XX	2.850	-	#6-32	-	4.050	6	9.975	17.60	60° / 90°	70
TD.TC.290.IK.XX	2.900	-	UNF-Nr.6/M3.5	#5-40	4.100	6	10.150	17.70	60° / 90°	70
TD.TC.2955.IK.XX	2.950	-	-	-	4.150	6	10.325	17.90	60° / 90°	70
TD.TC.300.IK.XX	3.000	-	-	-	4.200	6	10.500	18.70	60° / 90°	70

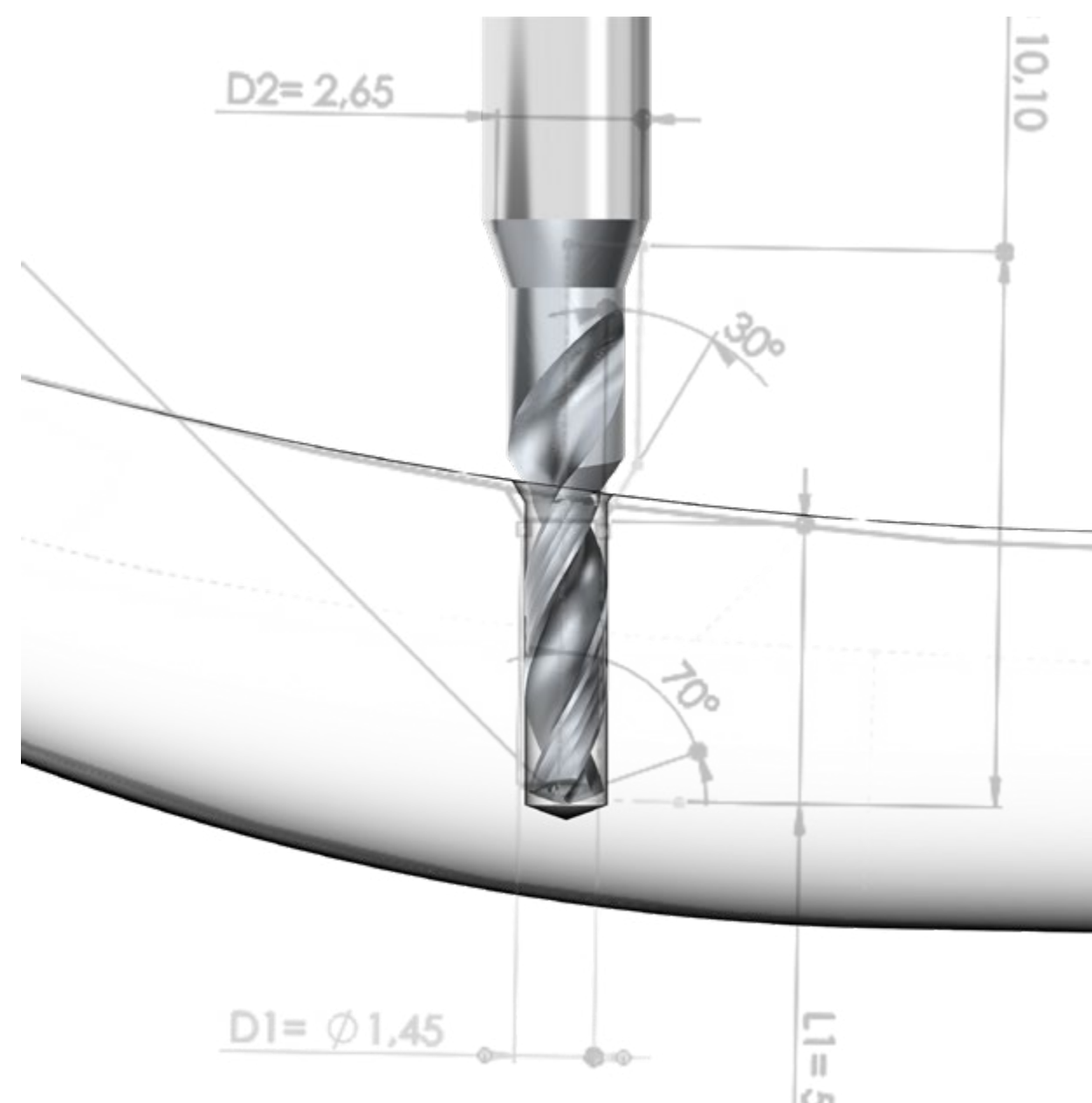
Article number	D1 m6 (mm)	D1 m6 (inch)	For thread taps	For thread formers	D2 (mm)	D3 h6 (mm)	L1 (mm)	L2 (mm)	α (XX°)	GL (mm)
TD.TC.310.IK.XX	3.100	-	-	-	4.300	6	10.850	18.90	60°/90°	70
TD.TC.315.IK.XX	3.150	-	M3.5x0.35	-	4.350	6	11.025	19.20	60°/90°	70
TD.TC.3175.IK.XX	3.175	1/8"	-	-	4.375	6	11.113	19.20	60°/90°	70
TD.TC.320.IK.XX	3.200	-	-	-	4.400	6	11.200	19.20	60°/90°	70
TD.TC.325.IK.XX	3.250	-	-	M3.5	4.450	6	11.375	19.40	60°/90°	70
TD.TC.330.IK.XX	3.300	-	M4	M3.5x0.5	4.500	6	11.550	19.40	60°/90°	70
TD.TC.340.IK.XX	3.400	-	UNC-Nr.8	-	4.600	6	11.900	19.60	60°/90°	70
TD.TC.350.IK.XX	3.500	-	UNF-Nr.8/M4x0.5	-	4.700	6	12.250	19.80	60°/90°	70
TD.TC.360.IK.XX	3.600	-	-	-	4.800	6	12.600	20.10	60°/90°	70
TD.TC.365.IK.XX	3.650	-	M4x0.35	-	4.850	6	12.775	20.30	60°/90°	70
TD.TC.370.IK.XX	3.700	-	M4.5	M4	4.900	6	12.950	20.30	60°/90°	70
TD.TC.380.IK.XX	3.800	-	UNC-Nr.10	-	5.000	6	13.300	20.50	60°/90°	70
TD.TC.390.IK.XX	3.900	-	-	-	5.100	6	13.650	20.70	60°/90°	70
TD.TC.3968.IK.XX	3.968	5/32"	-	-	5.168	6	13.888	21.00	60°/90°	70
TD.TC.400.IK.XX	4.000	-	-	-	5.200	6	14.000	21.00	60°/90°	70
TD.TC.410.IK.XX	4.100	-	UNF-Nr.10	-	5.300	6	14.350	22.80	60°/90°	70
TD.TC.420.IK.XX	4.200	-	M5/M5x0.75	M4.5	5.400	6	14.700	22.50	60°/90°	70
TD.TC.430.IK.XX	4.300	-	-	-	5.500	8	15.050	23.10	60°/90°	85
TD.TC.440.IK.XX	4.400	-	-	-	5.600	8	15.400	23.20	60°/90°	85
TD.TC.450.IK.XX	4.500	-	UNC-Nr.12/M5x0.5	-	5.700	8	15.750	28.50	60°/90°	85
TD.TC.460.IK.XX	4.600	-	UNF-Nr.12	-	5.800	8	16.100	28.60	60°/90°	85
TD.TC.465.IK.XX	4.650	-	-	M5	5.850	8	16.275	28.80	60°/90°	85
TD.TC.470.IK.XX	4.700	-	UNEF-Nr.12	-	5.900	8	16.450	28.80	60°/90°	85
TD.TC.4762.IK.XX	4.762	3/16"	-	-	5.962	8	16.667	28.90	60°/90°	85
TD.TC.480.IK.XX	4.800	-	-	-	6.000	8	16.800	28.90	60°/90°	85
TD.TC.490.IK.XX	4.900	-	-	-	6.100	8	17.150	29.10	60°/90°	85
TD.TC.500.IK.XX	5.000	-	M6	#12-24	6.200	8	17.500	29.20	60°/90°	85
TD.TC.510.IK.XX	5.100	-	1/4"	-	6.300	8	17.850	29.400	60°/90°	85
TD.TC.520.IK.XX	5.200	-	M6x0.75	-	6.400	8	18.200	30.00	60°/90°	85
TD.TC.530.IK.XX	5.300	-	-	-	6.500	8	18.550	30.50	60°/90°	85
TD.TC.540.IK.XX	5.400	-	-	-	6.600	8	18.900	31.00	60°/90°	85
TD.TC.550.IK.XX	5.500	-	M6x0.5/UNF-1/4"	-	6.700	8	19.250	31.60	60°/90°	85
TD.TC.5556.IK.XX	5.556	7/32"	-	-	6.756	8	19.446	31.80	60°/90°	85
TD.TC.560.IK.XX	5.600	-	UNEF-1/4"/MJ6x0.5	M6	6.800	8	19.600	32.00	60°/90°	85
TD.TC.570.IK.XX	5.700	-	-	-	6.900	8	19.950	32.60	60°/90°	85
TD.TC.580.IK.XX	5.800	-	-	-	7.000	8	20.300	33.10	60°/90°	85
TD.TC.590.IK.XX	5.900	-	-	-	7.100	8	20.650	33.70	60°/90°	85
TD.TC.600.IK.XX	6.000	-	M7	-	7.200	8	21.000	34.20	60°/90°	85
TD.TC.620.IK.XX	6.200	-	M7x0.75	-	7.400	10	21.700	35.20	60°/90°	90
TD.TC.635.IK.XX	6.350	1/4"	-	-	7.550	10	22.225	36.00	60°/90°	90
TD.TC.660.IK.XX	6.600	-	5/16"-18	M7	7.800	10	23.100	37.40	60°/90°	90
TD.TC.670.IK.XX	6.700	-	1/16"	-	7.900	10	23.450	37.90	60°/90°	90
TD.TC.680.IK.XX	6.800	-	M8/G1/16	M7x0.5	8.000	10	23.800	38.40	60°/90°	90
TD.TC.690.IK.XX	6.900	-	UNF-5/16"	-	8.100	10	24.150	38.90	60°/90°	90
TD.TC.700.IK.XX	7.000	-	M8x1	-	8.200	10	24.500	39.50	60°/90°	90
TD.TC.720.IK.XX	7.200	-	UNEF-5/16"	-	8.400	10	24.500	40.50	60°/90°	90

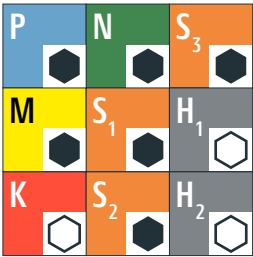
Delivery time: 3-4 weeks

The suffix of the article number is replaced by the desired chamfer angle:
With .90 for 90° or .60 for 60°

Exemplary order:
For the thread former M1 &
Chamfer angle 90° core hole step drill
Ø0.9 = TD.TC.090.IK.90

Exemplary order:
For the thread mill M1.8 &
Chamfer angle 60°
Ø1.45 = TD.TC.145.IK.60



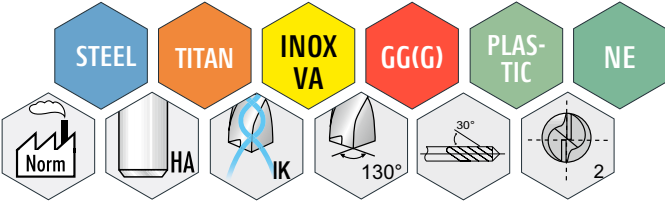


Material group	Material group	Mat. no.	DIN	AISI/ASTM/UNS
P	Steels up to RM < 1200N/mm ²	1.0044	S275JR	AISI 1020
		1.0715	11SMn30	AISI 1215
		1.7131	16MnCr5	AISI 5115
		1.3505	100Cr6	AISI 52100
		1.7225	42CrMo4	AISI 4140
M	Stainless steels: ferritic, martensitic, austenitic	1.4034	X46Cr13	AISI 420C
		1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH
		1.4301	X5CrNi 18-10	AISI 304
		1.4435	X2CrNiMo 18-14-3	AISI 316L
K	Cast iron	0.6020	GG20	ASTM 30
		0.6030	GG30	ASTM 40B
		0.7040	GGG40	ASTM 60-40-18
		0.7060	GGG60	ASTM 80-60-03
N	Non-ferrous metals	3.2315	AlMgSi1	ASTM 6351
		2.0065	Cu-ETP / CW004A	UNS C11000
		2.0321	CuZn37 CW508L	UNS C27400
		2.0401	CuZn39Pb3 / CW614N	UNS C38500
		2.0966	CuAl10Ni5Fe4	UNS C63000
S (S1, S2, S3)	Heat-resistant steels, titanium, CrCo	2.4617	NiMo28	Hastelloy B-2
		2.4665	NiCr22Fe18Mo	Hastelloy X
		3.7165	TiAl6V4	ASTM B348 / F136
		9.9367	TiAl6Nb7	ASTM F1295
		2.4964	CoCr20W15Ni	Haynes 25
H	Hardened steels ≥ 60 HRC		CrCoMo28	ASTM F1537
		1.2510	100MnCrMoW4	AISI O1
		1.2379	X153CrMoV12	AISI D2

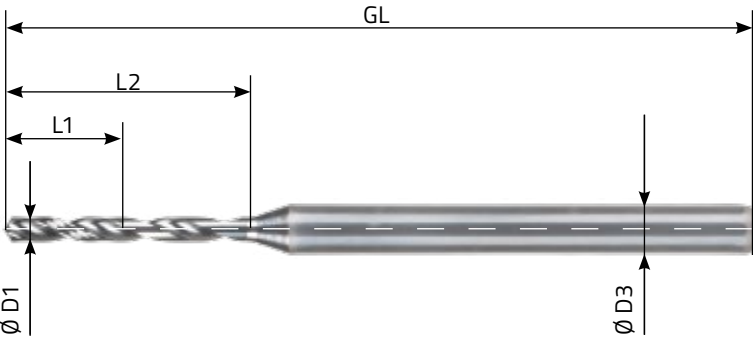
Recommended use Highly suitable Partially suitable Not recommended

Ø 0.75 - 1.2 mm		Ø 1.2 - 1.8 mm		Ø 1.8 - 2.5 mm		Ø 2.5 - 5.0 mm		Ø 5.0 - 7.2 mm	
vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]
60-130	0.032 - 0.066	60-130	0.122 - 0.128	60-130	0.130 - 0.182	60-140	0.128 - 0.232	60-160	0.220 - 0.280
60-120	0.032 - 0.056	60-120	0.120 - 0.122	60-130	0.130 - 0.182	60-120	0.128 - 0.202	60-150	0.200 - 0.260
50-120	0.015 - 0.04	50-120	0.043 - 0.055	50-120	0.060 - 0.080	50-100	0.074 - 0.098	50-120	0.115 - 0.185
50-80	0.01 - 0.038	50-80	0.040 - 0.068	50-90	0.050 - 0.070	50-90	0.072 - 0.084	50-100	0.115 - 0.175
80-140	0.020 - 0.042	80-140	0.06 - 0.115	80-160	0.126 - 0.135	80-160	0.100 - 0.145	80-180	0.145 - 0.210
80-160	0.032 - 0.066	80-160	0.096 - 0.122	80-160	0.132 - 0.18	80-160	0.136 - 0.172	80-180	0.200 - 0.250
80-140	0.036 - 0.088	80-140	0.098 - 0.122	80-160	0.132 - 0.210	80-160	0.134 - 0.164	80-180	0.200 - 0.252
80-120	0.022 - 0.088	80-120	0.066 - 0.122	80-140	0.085 - 0.120	80-120	0.132 - 0.162	80-160	0.195 - 0.242
15 - 50	0.015 - 0.045	15 - 50	0.049 - 0.060	15 - 60	0.060 - 0.07	15 - 70	0.062 - 0.08	15 - 80	0.080 - 0.10
15 - 50	0.015 - 0.045	15 - 50	0.048 - 0.060	15 - 60	0.060 - 0.07	15 - 70	0.062 - 0.08	15 - 80	0.080 - 0.10
15 - 50	0.010 - 0.024	15 - 50	0.05 - 0.060	15 - 50	0.055 - 0.07	15 - 60	0.052 - 0.08	15 - 75	0.076 - 0.10
15-32	0.006 - 0.009	15-32	0.006 - 0.010	15-32	0.006 - 0.012	15-35	0.009 - 0.014	15-40	0.009 - 0.018
15-32	0.006 - 0.009	15-32	0.006 - 0.010	15-32	0.006 - 0.012	15-35	0.009 - 0.014	15-40	0.009 - 0.018

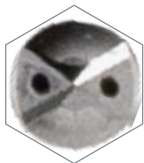
INOX-6xD cooled



TARGETDRILL
TD.100.IK.6D
D1: Ø 1.00 mm
Internal cooling
6xD drilling depth



■ α-INOXcronos coated



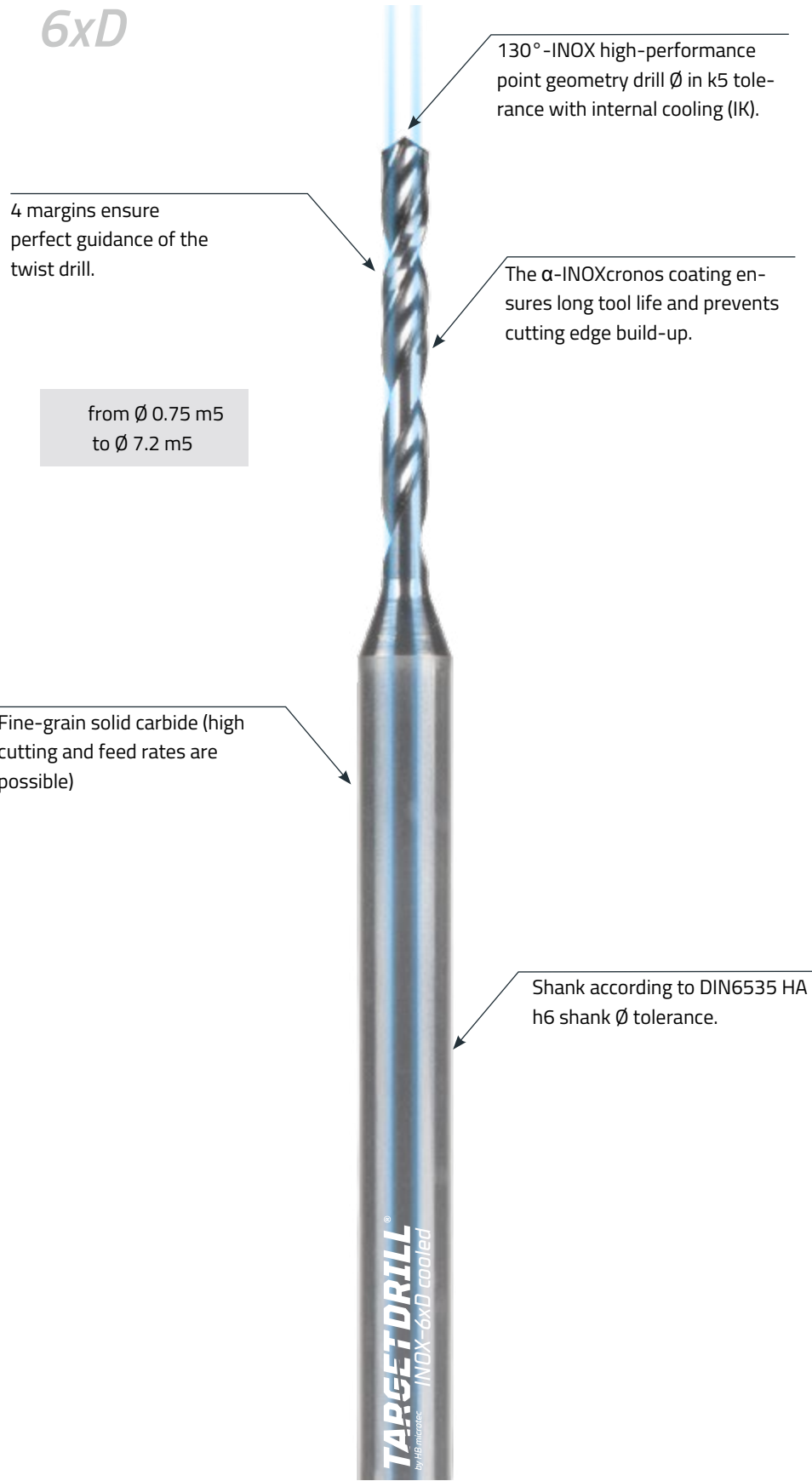
5 PRO's of the TARGETDRILL:

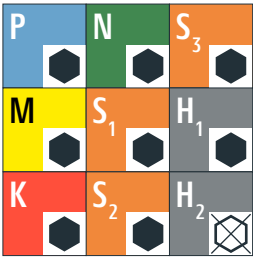
- Self-centering
- Perfect alignment accuracy - 6xD with 4 margins
- High cutting and feed speeds possible
- High performance & positioning accuracy
- A plus for your process reliability and quality

Article number	D1 k5 (mm)	D1 k5 (inch)	D3 h6 (mm)	L1 [4 margins] (mm)	L2 [Spiral slot] (mm)	GL (mm)
TD.075.IK.6D	Ø 0.75	-	Ø 3.00	3.30	6.75	50.00
TD.080.IK.6D	Ø 0.80	-	Ø 3.00	3.52	7.20	50.00
TD.085.IK.6D	Ø 0.85	-	Ø 3.00	3.74	7.65	50.00
TD.090.IK.6D	Ø 0.90	-	Ø 3.00	3.96	8.10	50.00
TD.095.IK.6D	Ø 0.95	-	Ø 3.00	4.18	8.55	50.00
TD.100.IK.6D	Ø 1.00	-	Ø 3.00	4.40	9.30	50.00
TD.105.IK.6D	Ø 1.05	-	Ø 3.00	4.65	9.80	50.00
TD.110.IK.6D	Ø 1.10	-	Ø 3.00	4.85	10.25	50.00
TD.115.IK.6D	Ø 1.15	-	Ø 3.00	5.10	10.70	50.00
TD.120.IK.6D	Ø 1.20	-	Ø 3.00	5.30	11.20	50.00
TD.125.IK.6D	Ø 1.25	-	Ø 3.00	5.50	11.65	50.00
TD.130.IK.6D	Ø 1.30	-	Ø 3.00	5.75	12.10	52.00
TD.135.IK.6D	Ø 1.35	-	Ø 3.00	5.95	12.60	52.00
TD.140.IK.6D	Ø 1.40	-	Ø 3.00	6.20	13.05	52.00
TD.145.IK.6D	Ø 1.45	-	Ø 3.00	6.40	13.50	52.00
TD.150.IK.6D	Ø 1.50	-	Ø 3.00	6.60	13.95	52.00
TD.155.IK.6D	Ø 1.55	-	Ø 3.00	6.85	14.45	55.00
TD.1588.IK.6D	Ø 1.588	1/16"	Ø 3.00	7.00	14.30	55.00
TD.160.IK.6D	Ø 1.60	-	Ø 3.00	7.05	14.90	55.00
TD.165.IK.6D	Ø 1.65	-	Ø 3.00	7.30	15.35	55.00
TD.170.IK.6D	Ø 1.70	-	Ø 3.00	7.50	15.85	55.00
TD.175.IK.6D	Ø 1.75	-	Ø 3.00	7.70	16.30	55.00
TD.180.IK.6D	Ø 1.80	-	Ø 3.00	7.95	16.75	57.00
TD.185.IK.6D	Ø 1.85	-	Ø 3.00	8.15	17.25	57.00
TD.190.IK.6D	Ø 1.90	-	Ø 3.00	8.40	17.70	57.00
TD.195.IK.6D	Ø 1.95	-	Ø 3.00	8.60	18.15	57.00
TD.200.IK.6D	Ø 2.00	-	Ø 4.00	8.80	18.60	57.00
TD.203.IK.6D	Ø 2.03	-	Ø 4.00	9.05	19.10	60.00
TD.205.IK.6D	Ø 2.05	-	Ø 4.00	9.05	19.10	60.00
TD.210.IK.6D	Ø 2.10	-	Ø 4.00	9.25	19.55	60.00
TD.215.IK.6D	Ø 2.15	-	Ø 4.00	9.50	20.00	60.00
TD.220.IK.6D	Ø 2.20	-	Ø 4.00	9.70	20.50	60.00
TD.225.IK.6D	Ø 2.25	-	Ø 4.00	9.90	20.95	60.00
TD.230.IK.6D	Ø 2.30	-	Ø 4.00	10.15	21.40	62.00
TD.233.IK.6D	Ø 2.33	-	Ø 4.00	10.35	21.90	62.00
TD.235.IK.6D	Ø 2.35	-	Ø 4.00	10.35	21.90	62.00
TD.2381.IK.6D	Ø 2.381	3/32"	Ø 4.00	10.5	21.40	62.00
TD.240.IK.6D	Ø 2.40	-	Ø 4.00	10.60	22.35	62.00
TD.245.IK.6D	Ø 2.45	-	Ø 4.00	10.80	22.80	62.00
TD.250.IK.6D	Ø 2.50	-	Ø 4.00	11.00	23.25	62.00
TD.255.IK.6D	Ø 2.55	-	Ø 4.00	11.25	23.75	65.00
TD.260.IK.6D	Ø 2.60	-	Ø 4.00	11.45	24.20	65.00
TD.265.IK.6D	Ø 2.65	-	Ø 4.00	11.70	24.65	65.00
TD.270.IK.6D	Ø 2.70	-	Ø 4.00	11.90	25.15	65.00
TD.275.IK.6D	Ø 2.75	-	Ø 4.00	12.10	25.60	65.00
TD.280.IK.6D	Ø 2.80	-	Ø 4.00	12.35	26.05	67.00
TD.285.IK.6D	Ø 2.85	-	Ø 4.00	12.55	26.55	67.00
TD.290.IK.6D	Ø 2.90	-	Ø 4.00	12.80	27.00	67.00
TD.295.IK.6D	Ø 2.95	-	Ø 4.00	13.00	27.45	67.00
TD.300.IK.6D	Ø 3.00	-	Ø 6.00	13.20	27.90	70.00
TD.305.IK.6D	Ø 3.05	-	Ø 6.00	13.45	28.40	70.00
TD.310.IK.6D	Ø 3.10	-	Ø 6.00	13.65	28.85	70.00
TD.315.IK.6D	Ø 3.15	-	Ø 6.00	13.90	29.30	70.00
TD.3175.IK.6D	Ø 3.175	1/8"	Ø 6.00	14.00	28.60	70.00

Article number	D1 k5 (mm)	D1 k5 (inch)	D3 h6 (mm)	L1 [4 margins] (mm)	L2 [Spiral slot] (mm)	GL (mm)
TD.320.IK.6D	Ø 3.20	-	Ø 6.00	14.10	29.80	70.00
TD.325.IK.6D	Ø 3.25	-	Ø 6.00	14.30	30.25	70.00
TD.330.IK.6D	Ø 3.30	-	Ø 6.00	14.55	30.70	72.00
TD.335.IK.6D	Ø 3.35	-	Ø 6.00	14.75	31.20	72.00
TD.340.IK.6D	Ø 3.40	-	Ø 6.00	15.00	31.65	72.00
TD.345.IK.6D	Ø 3.45	-	Ø 6.00	15.20	32.10	72.00
TD.350.IK.6D	Ø 3.50	-	Ø 6.00	15.40	32.55	72.00
TD.355.IK.6D	Ø 3.55	-	Ø 6.00	15.65	33.05	75.00
TD.360.IK.6D	Ø 3.60	-	Ø 6.00	15.85	33.50	75.00
TD.365.IK.6D	Ø 3.65	-	Ø 6.00	16.10	33.95	75.00
TD.370.IK.6D	Ø 3.70	-	Ø 6.00	16.30	34.45	75.00
TD.375.IK.6D	Ø 3.75	-	Ø 6.00	16.50	34.90	75.00
TD.380.IK.6D	Ø 3.80	-	Ø 6.00	16.75	35.35	77.00
TD.385.IK.6D	Ø 3.85	-	Ø 6.00	16.95	35.85	77.00
TD.390.IK.6D	Ø 3.90	-	Ø 6.00	17.20	36.30	77.00
TD.395.IK.6D	Ø 3.95	-	Ø 6.00	17.40	36.75	77.00
TD.3969.IK.6D	Ø3.969	5/32"	Ø 6.00	17.50	35.70	80.00
TD.400.IK.6D	Ø 4.00	-	Ø 6.00	17.60	37.20	80.00
TD.410.IK.6D	Ø 4.10	-	Ø 6.00	18.05	38.15	80.00
TD.420.IK.6D	Ø 4.20	-	Ø 6.00	18.50	39.10	80.00
TD.430.IK.6D	Ø 4.30	-	Ø 6.00	18.95	40.00	80.00
TD.440.IK.6D	Ø 4.40	-	Ø 6.00	19.40	40.95	80.00
TD.450.IK.6D	Ø 4.50	-	Ø 6.00	19.80	41.85	80.00
TD.460.IK.6D	Ø 4.60	-	Ø 6.00	20.25	42.80	85.00
TD.465.IK.6D	Ø 4.65	-	Ø 6.00	20.46	41.85	85.00
TD.470.IK.6D	Ø 4.70	-	Ø 6.00	20.70	43.75	85.00
TD.4763.IK.6D	Ø 4.763	3/16"	Ø 6.00	21.00	42.90	85.00
TD.480.IK.6D	Ø 4.80	-	Ø 6.00	21.15	44.65	85.00
TD.490.IK.6D	Ø 4.90	-	Ø 6.00	21.60	45.60	85.00
TD.500.IK.6D	Ø 5.00	-	Ø 6.00	22.00	46.50	85.00
TD.510.IK.6D	Ø 5.10	-	Ø 6.00	22.45	47.45	90.00
TD.520.IK.6D	Ø 5.20	-	Ø 6.00	22.90	48.40	90.00
TD.530.IK.6D	Ø 5.30	-	Ø 6.00	23.35	49.30	90.00
TD.540.IK.6D	Ø 5.40	-	Ø 6.00	23.80	50.25	90.00
TD.550.IK.6D	Ø 5.50	-	Ø 6.00	24.20	51.15	90.00
TD.5556.IK.6D	Ø 5.556	7/32"	Ø 6.00	24.50	50.00	95.00
TD.560.IK.6D	Ø 5.60	-	Ø 6.00	24.65	52.10	95.00
TD.570.IK.6D	Ø 5.70	-	Ø 6.00	25.10	53.05	95.00
TD.580.IK.6D	Ø 5.80	-	Ø 6.00	25.55	53.95	95.00
TD.590.IK.6D	Ø 5.90	-	Ø 6.00	26.00	54.90	95.00
TD.600.IK.6D	Ø 6.00	-	Ø 6.00	26.40	55.80	95.00
TD.620.IK.6D	Ø 6.20	-	Ø 6.00	28.00	57.20	95.00
TD.6350.IK.6D	Ø6.35	1/4"	Ø 6.00	28.00	57.20	95.00
TD.660.IK.6D	Ø6.60	-	Ø 6.00	28.00	57.20	95.00
TD.670.IK.6D	Ø6.70	-	Ø 6.00	28.00	57.20	95.00
TD.680.IK.6D	Ø6.80	-	Ø 6.00	28.00	57.20	95.00
TD.690.IK.6D	Ø6.90	-	Ø 6.00	28.00	57.20	95.00
TD.700.IK.6D	Ø7.00	-	Ø 6.00	28.00	57.20	95.00
TD.720.IK.6D	Ø7.20	-	Ø 6.00	28.00	57.20	95.00

Available from stock



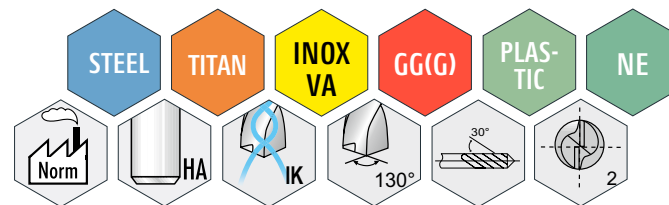


Material group	Material group	Mat. no.	DIN	AISI/ASTM/UNS
P	Steels up to RM < 1200N/mm ²	1.0044	S275JR	AISI 1020
		1.0715	11SMn30	AISI 1215
		1.7131	16MnCr5	AISI 5115
		1.3505	100Cr6	AISI 52100
		1.7225	42CrMo4	AISI 4140
M	Stainless steels: ferritic, martensitic, austenitic	1.4034	X46Cr13	AISI 420C
		1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH
		1.4301	X5CrNi 18-10	AISI 304
		1.4435	X2CrNiMo 18-14-3	AISI 316L
K	Cast iron	0.6020	GG20	ASTM 30
		0.6030	GG30	ASTM 40B
		0.7040	GGG40	ASTM 60-40-18
		0.7060	GGG60	ASTM 80-60-03
N	Non-ferrous metals	3.2315	AlMgSi1	ASTM 6351
		2.0065	Cu-ETP / CW004A	UNS C11000
		2.0321	CuZn37 CW508L	UNS C27400
		2.0401	CuZn39Pb3 / CW614N	UNS C38500
		2.0966	CuAl10Ni5Fe4	UNS C63000
S (S1, S2, S3)	Heat-resistant steels, titanium, CrCo	2.4617	NiMo28	Hastelloy B-2
		2.4665	NiCr22Fe18Mo	Hastelloy X
		3.7165	TiAl6V4	ASTM B348 / F136
		9.9367	TiAl6Nb7	ASTM F1295
		2.4964	CoCr20W15Ni	Haynes 25
H	Hardened steels ≥ 60 HRC		CrCoMo28	ASTM F1537
		1.2510	100MnCrMoW4	AISI O1
		1.2379	X153CrMoV12	AISI D2

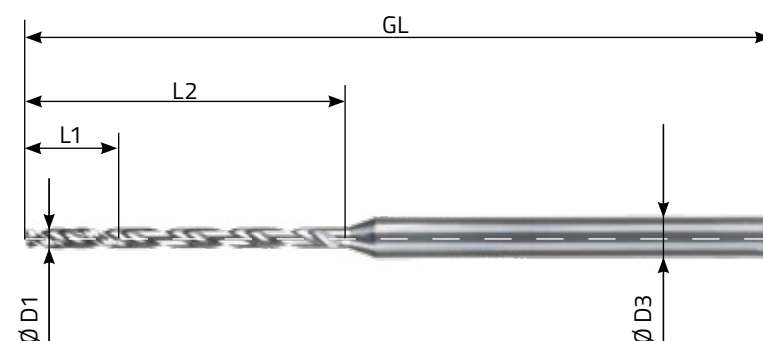
Recommended use Highly suitable Partially suitable Not recommended

Ø 0.75 - 1.2 mm		Ø 1.2 - 1.8 mm		Ø 1.8 - 2.5 mm		Ø 2.5 - 4.0 mm		Ø 4.0 - 7.2 mm	
vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]
60-130	0.042 - 0.066	60-130	0.122 - 0.128	60-130	0.130 - 0.182	60-140	0.128 - 0.232	60-160	0.220 - 0.280
60-120	0.042 - 0.056	60-120	0.120 - 0.122	60-130	0.130 - 0.182	60-120	0.128 - 0.202	60-150	0.200 - 0.260
50-120	0.025 - 0.04	50-120	0.043 - 0.055	50-120	0.060 - 0.080	50-100	0.074 - 0.098	50-120	0.115 - 0.185
50-80	0.02 - 0.038	50-80	0.040 - 0.068	50-90	0.050 - 0.070	50-90	0.072 - 0.084	50-100	0.115 - 0.175
80-140	0.030 - 0.042	80-140	0.06 - 0.115	80-160	0.126 - 0.135	80-160	0.100 - 0.145	80-180	0.145 - 0.210
80-160	0.042 - 0.066	80-160	0.096 - 0.122	80-160	0.132 - 0.18	80-160	0.136 - 0.172	80-180	0.200 - 0.250
80-140	0.046 - 0.088	80-140	0.098 - 0.122	80-160	0.132 - 0.210	80-160	0.134 - 0.164	80-180	0.200 - 0.252
80-120	0.032 - 0.088	80-120	0.066 - 0.122	80-140	0.085 - 0.120	80-120	0.132 - 0.162	80-160	0.195 - 0.242
15 - 50	0.025 - 0.045	15 - 50	0.049 - 0.060	15 - 60	0.060 - 0.07	15 - 70	0.062 - 0.08	15 - 80	0.080 - 0.10
15 - 50	0.025 - 0.045	15 - 50	0.048 - 0.060	15 - 60	0.060 - 0.07	15 - 70	0.062 - 0.08	15 - 80	0.080 - 0.10
15 - 50	0.020 - 0.024	15 - 50	0.05 - 0.060	15 - 50	0.055 - 0.07	15 - 60	0.052 - 0.08	15 - 75	0.076 - 0.10
15-32	0.006 - 0.009	15-32	0.006 - 0.010	15-32	0.006 - 0.012	15-35	0.009 - 0.014	15-40	0.009 - 0.018
15-32	0.006 - 0.009	15-32	0.006 - 0.010	15-32	0.006 - 0.012	15-35	0.009 - 0.014	15-40	0.009 - 0.018

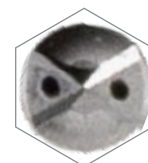
INOX-12xD cooled



TARGETDRILL
Internal cooling
TD.100.IK.12D ← 12xD drilling depth
D1: Ø 1.00 mm



■ α-INOXcronos coated

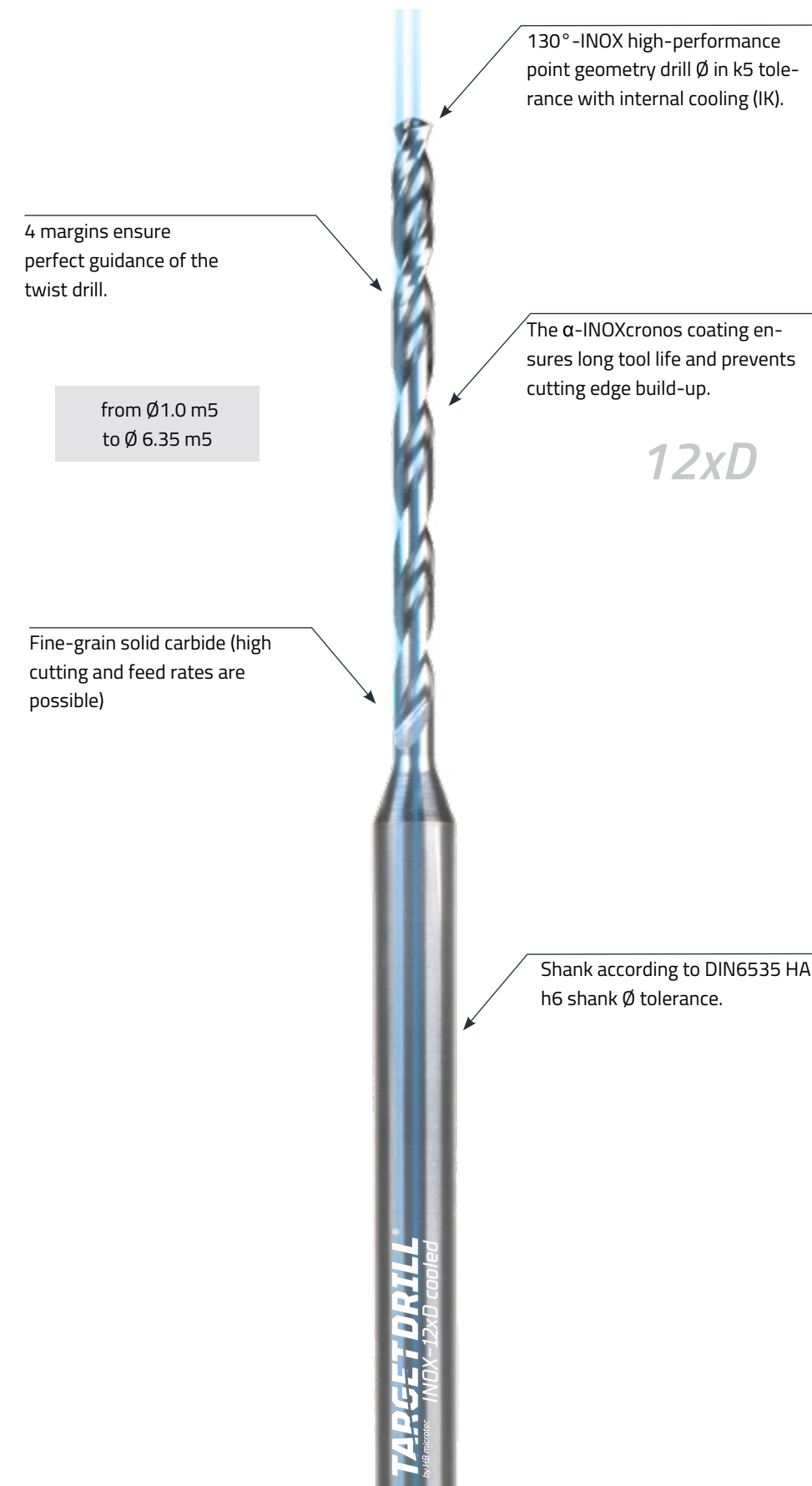


5 PRO's of the TARGETDRILL:

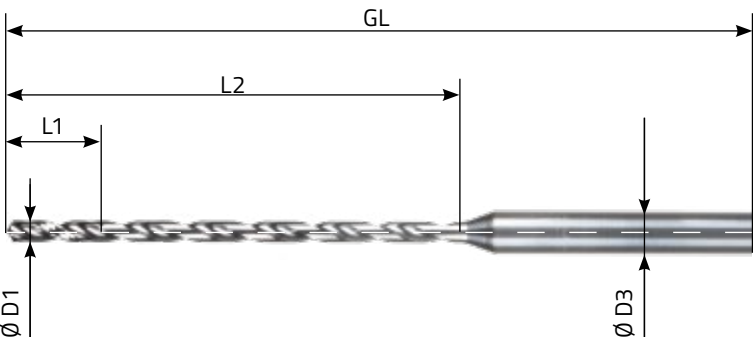
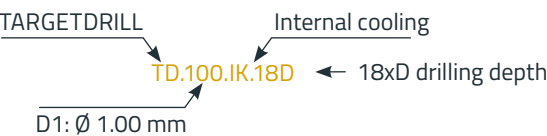
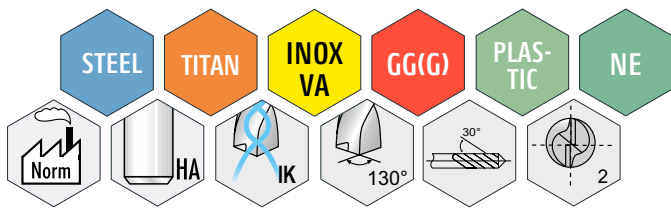
- Helical deep hole drill with internal cooling
- Perfect alignment accuracy - 12xD with 4 margins
- High cutting and feed speeds possible
- High performance & positioning accuracy
- A plus for your process reliability and quality

Article number	D1 k5 (mm)	-D1 k5 -(inch) -	D3 h6 (mm)	L1 [4 margins] (mm)	L2 [Spiral slot] (mm)	GL (mm)
TD.100.IK.12D	Ø 1.00	-	Ø 3.00	4.40	15.30	58.00
TD.105.IK.12D	Ø 1.05	-	Ø 3.00	4.65	16.10	58.00
TD.110.IK.12D	Ø 1.10	-	Ø 3.00	4.85	16.85	58.00
TD.115.IK.12D	Ø 1.15	-	Ø 3.00	5.10	17.60	58.00
TD.120.IK.12D	Ø 1.20	-	Ø 3.00	5.30	18.40	58.00
TD.125.IK.12D	Ø 1.25	-	Ø 3.00	5.50	19.15	58.00
TD.130.IK.12D	Ø 1.30	-	Ø 3.00	5.75	19.90	64.00
TD.135.IK.12D	Ø 1.35	-	Ø 3.00	5.95	20.70	64.00
TD.140.IK.12D	Ø 1.40	-	Ø 3.00	6.20	21.45	64.00
TD.145.IK.12D	Ø 1.45	-	Ø 3.00	6.40	22.20	64.00
TD.150.IK.12D	Ø 1.50	-	Ø 3.00	6.60	22.95	64.00
TD.155.IK.12D	Ø 1.55	-	Ø 3.00	6.85	23.75	68.00
TD.1588.IK.12D	Ø 1.588	1/16"	Ø3.00	7.00	23.80	68.00
TD.160.IK.12D	Ø 1.60	-	Ø 3.00	7.05	24.50	68.00
TD.165.IK.12D	Ø 1.65	-	Ø 3.00	7.30	25.25	68.00
TD.170.IK.12D	Ø 1.70	-	Ø 3.00	7.50	26.05	68.00
TD.175.IK.12D	Ø 1.75	-	Ø 3.00	7.70	26.80	68.00
TD.180.IK.12D	Ø 1.80	-	Ø 3.00	7.95	27.55	72.00
TD.185.IK.12D	Ø 1.85	-	Ø 3.00	8.15	28.35	72.00
TD.190.IK.12D	Ø 1.90	-	Ø 3.00	8.40	29.10	72.00
TD.195.IK.12D	Ø 1.95	-	Ø 3.00	8.60	29.85	72.00
TD.200.IK.12D	Ø 2.00	-	Ø 4.00	8.80	30.60	72.00
TD.205.IK.12D	Ø 2.05	-	Ø 4.00	9.05	31.40	76.00
TD.210.IK.12D	Ø 2.10	-	Ø 4.00	9.25	32.15	76.00
TD.215.IK.12D	Ø 2.15	-	Ø 4.00	9.50	32.90	76.00
TD.220.IK.12D	Ø 2.20	-	Ø 4.00	9.70	33.70	76.00
TD.225.IK.12D	Ø 2.25	-	Ø 4.00	9.90	34.45	76.00
TD.230.IK.12D	Ø 2.30	-	Ø 4.00	10.15	35.20	80.00
TD.235.IK.12D	Ø 2.35	-	Ø 4.00	10.35	36.00	80.00
TD.2381.IK.12D	Ø2.381	3/32"	Ø4.00	10.50	35.70	80.00
TD.240.IK.12D	Ø 2.40	-	Ø 4.00	10.60	36.75	80.00
TD.245.IK.12D	Ø 2.45	-	Ø 4.00	10.80	37.50	80.00
TD.250.IK.12D	Ø 2.50	-	Ø 4.00	11.00	38.25	80.00
TD.255.IK.12D	Ø 2.55	-	Ø 4.00	11.25	39.05	84.00
TD.260.IK.12D	Ø 2.60	-	Ø 4.00	11.45	39.80	84.00
TD.265.IK.12D	Ø 2.65	-	Ø 4.00	11.70	40.55	84.00
TD.270.IK.12D	Ø 2.70	-	Ø 4.00	11.90	41.35	84.00
TD.275.IK.12D	Ø 2.75	-	Ø 4.00	12.10	42.10	84.00
TD.280.IK.12D	Ø 2.80	-	Ø 4.00	12.35	42.85	88.00
TD.285.IK.12D	Ø 2.85	-	Ø 4.00	12.55	43.65	88.00
TD.290.IK.12D	Ø 2.90	-	Ø 4.00	12.80	44.40	88.00
TD.295.IK.12D	Ø 2.95	-	Ø 4.00	13.00	45.15	88.00
TD.300.IK.12D	Ø 3.00	-	Ø 6.00	13.20	45.90	92.00
TD.305.IK.12D	Ø 3.05	-	Ø 6.00	13.45	46.70	92.00
TD.310.IK.12D	Ø 3.10	-	Ø 6.00	13.65	47.45	92.00
TD.3175.IK.12D	Ø3.175	1/8"	Ø6.00	14.00	48.20	92.00
TD.315.IK.12D	Ø 3.15	-	Ø 6.00	13.90	47.60	92.00
TD.320.IK.12D	Ø 3.20	-	Ø 6.00	14.10	49.00	92.00

Article number	D1 k5 (mm)	D1 k5 (inch)	D3 h6 (mm)	L1 [4 margins] (mm)	L2 [Spiral slot] (mm)	GL (mm)
TD.325.IK.12D	Ø 3.25	-	Ø 6.00	14.30	49.75	92.00
TD.330.IK.12D	Ø 3.30	-	Ø 6.00	14.55	50.50	96.00
TD.335.IK.12D	Ø 3.35	-	Ø 6.00	14.75	51.30	96.00
TD.340.IK.12D	Ø 3.40	-	Ø 6.00	15.00	52.05	96.00
TD.345.IK.12D	Ø 3.45	-	Ø 6.00	15.20	52.80	96.00
TD.350.IK.12D	Ø 3.50	-	Ø 6.00	15.40	53.55	96.00
TD.355.IK.12D	Ø 3.55	-	Ø 6.00	15.65	54.35	100.00
TD.360.IK.12D	Ø 3.60	-	Ø 6.00	15.85	55.10	100.00
TD.365.IK.12D	Ø 3.65	-	Ø 6.00	16.10	55.85	100.00
TD.370.IK.12D	Ø 3.70	-	Ø 6.00	16.30	56.65	100.00
TD.375.IK.12D	Ø 3.75	-	Ø 6.00	16.50	57.40	100.00
TD.380.IK.12D	Ø 3.80	-	Ø 6.00	16.75	58.15	104.00
TD.385.IK.12D	Ø 3.85	-	Ø 6.00	16.95	58.95	104.00
TD.390.IK.12D	Ø 3.90	-	Ø 6.00	17.20	59.70	104.00
TD.395.IK.12D	Ø 3.95	-	Ø 6.00	17.40	60.45	104.00
TD.3969.IK.12D	Ø3.969	5/32"	Ø6.00	17.50	59.50	108.00
TD.400.IK.12D	Ø 4.00	-	Ø 6.00	17.60	61.20	108.00
TD.410.IK.12D	Ø 4.10	-	Ø 6.00	18.05	62.75	108.00
TD.420.IK.12D	Ø 4.20	-	Ø 6.00	18.50	64.30	108.00
TD.430.IK.12D	Ø 4.30	-	Ø 6.00	18.95	65.80	108.00
TD.440.IK.12D	Ø 4.40	-	Ø 6.00	19.40	67.35	108.00
TD.450.IK.12D	Ø 4.50	-	Ø 6.00	19.80	68.85	108.00
TD.460.IK.12D	Ø 4.60	-	Ø 6.00	20.25	70.40	115.00
TD.470.IK.12D	Ø 4.70	-	Ø 6.00	20.70	71.95	115.00
TD.4763.IK.12D	Ø4.763	3/16"	Ø6.00	21.00	71.40	115.00
TD.480.IK.12D	Ø 4.80	-	Ø 6.00	21.15	73.45	115.00
TD.490.IK.12D	Ø 4.90	-	Ø 6.00	21.60	75.00	115.00
TD.500.IK.12D	Ø 5.00	-	Ø 6.00	22.00	76.50	115.00
TD.510.IK.12D	Ø 5.10	-	Ø 6.00	22.45	78.05	122.00
TD.520.IK.12D	Ø 5.20	-	Ø 6.00	22.90	79.60	122.00
TD.530.IK.12D	Ø 5.30	-	Ø 6.00	23.35	81.10	122.00
TD.540.IK.12D	Ø 5.40	-	Ø 6.00	23.80	82.65	122.00
TD.550.IK.12D	Ø 5.50	-	Ø 6.00	24.20	84.15	122.00
TD.5556.IK.12D	Ø5.556	7/32"	Ø6.00	24.50	83.30	130.00
TD.560.IK.12D	Ø 5.60	-	Ø 6.00	24.65	85.70	130.00
TD.570.IK.12D	Ø 5.70	-	Ø 6.00	25.10	87.25	130.00
TD.580.IK.12D	Ø 5.80	-	Ø 6.00	25.55	88.75	130.00
TD.590.IK.12D	Ø 5.90	-	Ø 6.00	26.00	90.30	130.00
TD.600.IK.12D	Ø 6.00	-	Ø 6.00	26.40	91.80	130.00
TD.6350.IK.12D	Ø6.35	1/4"	Ø6.00	28.00	95.30	130.00



INOX-18xD cooled



■ α-INOXcronos coated



5 PRO's of the TARGETDRILL:

- Helical deep hole drill with internal cooling
- Perfect alignment accuracy - 18xD with 4 margins
- High cutting and feed speeds possible
- High performance & positioning accuracy
- A plus for your process reliability and quality

Article number	D1 k5 (mm)	D1 k5 (inch)	D3 h6 (mm)	L1 [4 margins] (mm)	L2 [Spiral slot] (mm)	GL (mm)
TD.100.IK.18D	Ø 1.00	-	Ø 3.00	4.40	21.30	64.00
TD.105.IK.18D	Ø 1.05	-	Ø 3.00	4.65	22.40	64.00
TD.110.IK.18D	Ø 1.10	-	Ø 3.00	4.85	23.45	64.00
TD.115.IK.18D	Ø 1.15	-	Ø 3.00	5.10	24.00	64.00
TD.120.IK.18D	Ø 1.20	-	Ø 3.00	5.30	25.60	64.00
TD.125.IK.18D	Ø 1.25	-	Ø 3.00	5.50	26.65	64.00
TD.130.IK.18D	Ø 1.30	-	Ø 3.00	5.75	27.70	72.00
TD.135.IK.18D	Ø 1.35	-	Ø 3.00	5.95	28.80	72.00
TD.140.IK.18D	Ø 1.40	-	Ø 3.00	6.20	29.85	72.00
TD.145.IK.18D	Ø 1.45	-	Ø 3.00	6.40	30.90	72.00
TD.150.IK.18D	Ø 1.50	-	Ø 3.00	6.60	31.95	72.00
TD.155.IK.18D	Ø 1.55	-	Ø 3.00	6.85	33.05	80.00
TD.1588.IK.18D	Ø1.588	1/16"	Ø3.00	7.00	33.30	80.00
TD.160.IK.18D	Ø 1.60	-	Ø 3.00	7.05	34.10	80.00
TD.165.IK.18D	Ø 1.65	-	Ø 3.00	7.30	35.15	80.00
TD.170.IK.18D	Ø 1.70	-	Ø 3.00	7.50	36.25	80.00
TD.175.IK.18D	Ø 1.75	-	Ø 3.00	7.70	37.30	80.00
TD.180.IK.18D	Ø 1.80	-	Ø 3.00	7.95	38.35	88.00
TD.185.IK.18D	Ø 1.85	-	Ø 3.00	8.15	39.45	88.00
TD.190.IK.18D	Ø 1.90	-	Ø 3.00	8.40	40.50	88.00
TD.195.IK.18D	Ø 1.95	-	Ø 3.00	8.60	41.55	88.00
TD.200.IK.18D	Ø 2.00	-	Ø 4.00	8.80	42.60	88.00
TD.205.IK.18D	Ø 2.05	-	Ø 4.00	9.05	43.70	94.00
TD.210.IK.18D	Ø 2.10	-	Ø 4.00	9.25	44.75	94.00
TD.215.IK.18D	Ø 2.15	-	Ø 4.00	9.50	45.80	94.00
TD.220.IK.18D	Ø 2.20	-	Ø 4.00	9.70	46.90	94.00
TD.225.IK.18D	Ø 2.25	-	Ø 4.00	9.90	47.95	94.00
TD.230.IK.18D	Ø 2.30	-	Ø 4.00	10.15	49.00	100.00
TD.235.IK.18D	Ø 2.35	-	Ø 4.00	10.35	49.35	100.00
TD.2381.IK.18D	Ø2.381	3/32"	Ø4.00	10.50	50.00	100.00
TD.240.IK.18D	Ø 2.40	-	Ø 4.00	10.60	50.40	100.00
TD.245.IK.18D	Ø 2.45	-	Ø 4.00	10.80	51.45	100.00
TD.250.IK.18D	Ø 2.50	-	Ø 4.00	11.00	52.50	100.00
TD.255.IK.18D	Ø 2.55	-	Ø 4.00	11.25	53.55	106.00
TD.260.IK.18D	Ø 2.60	-	Ø 4.00	11.45	54.60	106.00
TD.265.IK.18D	Ø 2.65	-	Ø 4.00	11.70	55.65	106.00
TD.270.IK.18D	Ø 2.70	-	Ø 4.00	11.90	56.70	106.00
TD.275.IK.18D	Ø 2.75	-	Ø 4.00	12.10	57.75	106.00
TD.280.IK.18D	Ø 2.80	-	Ø 4.00	12.35	58.80	110.00
TD.285.IK.18D	Ø 2.85	-	Ø 4.00	12.55	59.85	110.00
TD.290.IK.18D	Ø 2.90	-	Ø 4.00	12.80	60.90	110.00
TD.295.IK.18D	Ø 2.95	-	Ø 4.00	13.00	61.95	110.00
TD.300.IK.18D	Ø 3.00	-	Ø 6.00	13.20	63.00	114.00
TD.305.IK.18D	Ø 3.05	-	Ø 6.00	13.45	64.05	114.00
TD.310.IK.18D	Ø 3.10	-	Ø 6.00	13.65	65.10	114.00
TD.315.IK.18D	Ø 3.15	-	Ø 6.00	13.90	66.15	114.00
TD.3175.IK.18D	Ø3.175	1/8"	Ø6.00	14.00	66.70	114.00
TD.320.IK.18D	Ø 3.20	-	Ø 6.00	14.10	67.20	114.00

Article number	D1 k5 (mm)	D1 k5 (inch)	D3 h6 (mm)	L1 [4 margins] (mm)	L2 [Spiral slot] (mm)	GL (mm)
TD.325.IK.18D	Ø 3.25	-	Ø 6.00	14.30	68.25	114.00
TD.330.IK.18D	Ø 3.30	-	Ø 6.00	14.55	69.30	118.00
TD.335.IK.18D	Ø 3.35	-	Ø 6.00	14.75	70.35	118.00
TD.340.IK.18D	Ø 3.40	-	Ø 6.00	15.00	71.40	118.00
TD.345.IK.18D	Ø 3.45	-	Ø 6.00	15.20	72.45	118.00
TD.350.IK.18D	Ø 3.50	-	Ø 6.00	15.40	73.50	118.00
TD.355.IK.18D	Ø 3.55	-	Ø 6.00	15.65	74.55	122.00
TD.360.IK.18D	Ø 3.60	-	Ø 6.00	15.85	75.60	122.00
TD.365.IK.18D	Ø 3.65	-	Ø 6.00	16.10	76.65	122.00
TD.370.IK.18D	Ø 3.70	-	Ø 6.00	16.30	77.70	122.00
TD.375.IK.18D	Ø 3.75	-	Ø 6.00	16.50	78.75	122.00
TD.380.IK.18D	Ø 3.80	-	Ø 6.00	16.75	79.80	126.00
TD.385.IK.18D	Ø 3.85	-	Ø 6.00	16.95	80.85	126.00
TD.390.IK.18D	Ø 3.90	-	Ø 6.00	17.20	81.90	126.00
TD.395.IK.18D	Ø 3.95	-	Ø 6.00	17.40	82.95	126.00
TD.3969.IK.18D	Ø3.969	5/32"	Ø6.00	17.50	83.30	130.00
TD.400.IK.18D	Ø 4.00	-	Ø 6.00	17.60	84.00	130.00
TD.410.IK.18D	Ø 4.10	-	Ø 6.00	18.05	86.10	130.00
TD.420.IK.18D	Ø 4.20	-	Ø 6.00	18.50	88.20	130.00
TD.430.IK.18D	Ø 4.30	-	Ø 6.00	18.95	90.30	130.00
TD.440.IK.18D	Ø 4.40	-	Ø 6.00	19.40	92.40	130.00
TD.450.IK.18D	Ø 4.50	-	Ø 6.00	19.80	94.50	130.00
TD.460.IK.18D	Ø 4.60	-	Ø 6.00	20.25	96.60	142.00
TD.470.IK.18D	Ø 4.70	-	Ø 6.00	20.70	98.70	142.00
TD.4763.IK.18D	Ø4.763	3/16"	Ø6.00	21.00	100.00	142.00
TD.480.IK.18D	Ø 4.80	-	Ø 6.00	21.15	100.80	142.00
TD.490.IK.18D	Ø 4.90	-	Ø 6.00	21.60	102.90	142.00
TD.500.IK.18D	Ø 5.00	-	Ø 6.00	22.00	105.00	142.00
TD.510.IK.18D	Ø 5.10	-	Ø 6.00	22.45	107.10	153.00
TD.520.IK.18D	Ø 5.20	-	Ø 6.00	22.90	109.20	153.00
TD.530.IK.18D	Ø 5.30	-	Ø 6.00	23.35	111.30	153.00
TD.540.IK.18D	Ø 5.40	-	Ø 6.00	23.80	113.40	153.00
TD.550.IK.18D	Ø 5.50	-	Ø 6.00	24.20	115.50	153.00
TD.5556.IK.18D	Ø5.556	7/32"	Ø6.00	24.50	116.70	165.00
TD.560.IK.18D	Ø 5.60	-	Ø 6.00	24.65	117.60	165.00
TD.570.IK.18D	Ø 5.70	-	Ø 6.00	25.10	119.70	165.00
TD.580.IK.18D	Ø 5.80	-	Ø 6.00	25.55	121.80	165.00
TD.590.IK.18D	Ø 5.90	-	Ø 6.00	26.00	123.90	165.00
TD.600.IK.18D	Ø 6.00	-	Ø 6.00	26.40	126.00	165.00
TD.6350.IK.18D	Ø6.35	1/4"	Ø6.00	28.00	133.40	165.00

Available from stock

18xD

4 margins ensure perfect guidance of the twist drill.

from Ø1.0 m5
to Ø 6.35 m5

Fine-grain solid carbide (high cutting and feed rates are possible)

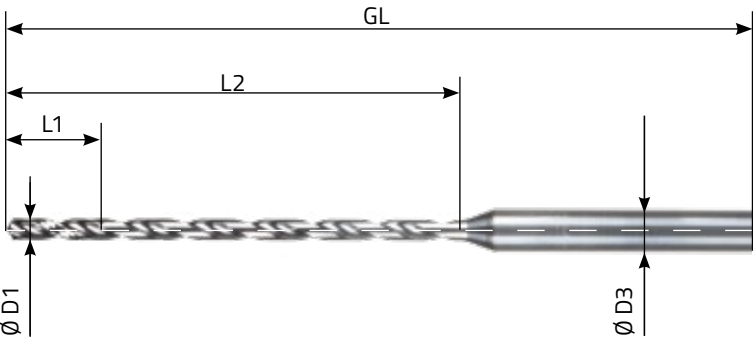
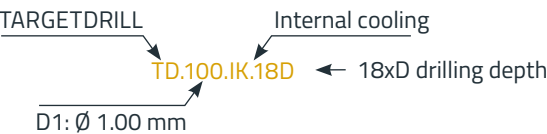
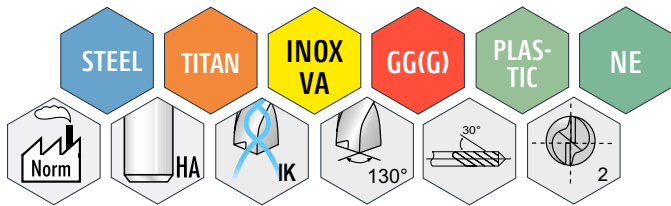
130°-INOX high-performance point geometry drill Ø in k5 tolerance with internal cooling (IK).

The α-INOXcronos coating ensures long tool life and prevents cutting edge build-up.

Shank according to DIN6535 HA h6 shank Ø tolerance.



INOX-24xD cooled



■ α-INOXcronos coated



5 PRO's of the TARGETDRILL:

- Helical deep hole drill with internal cooling
- Perfect alignment accuracy - 18xD with 4 margins
- High cutting and feed speeds possible
- High performance & positioning accuracy
- A plus for your process reliability and quality

Article number	D1 k5 (mm)	D1 k5 (inch)	D3 h6 (mm)	L1 [4 margins] (mm)	L2 [Spiral slot] (mm)	GL (mm)
TD.100.IK.24D	Ø1.00	-	Ø3.00	4.40	27.30	64.00
TD.105.IK.24D	Ø1.05	-	Ø3.00	4.65	28.70	64.00
TD.110.IK.24D	Ø1.10	-	Ø3.00	4.85	30.00	64.00
TD.115.IK.24D	Ø1.15	-	Ø3.00	5.10	31.40	64.00
TD.120.IK.24D	Ø1.20	-	Ø3.00	5.30	32.80	64.00
TD.125.IK.24D	Ø1.25	-	Ø3.00	5.50	34.20	64.00
TD.130.IK.24D	Ø1.30	-	Ø3.00	5.75	35.50	72.00
TD.135.IK.24D	Ø1.35	-	Ø3.00	5.95	36.90	72.00
TD.140.IK.24D	Ø1.40	-	Ø3.00	6.20	38.20	72.00
TD.145.IK.24D	Ø1.45	-	Ø3.00	6.40	39.60	72.00
TD.150.IK.24D	Ø1.50	-	Ø3.00	6.60	41.00	72.00
TD.155.IK.24D	Ø1.55	-	Ø3.00	6.85	42.30	80.00
TD.1588.IK.24D	Ø1.588	1/16"	Ø3.00	7.00	43.40	80.00
TD.160.IK.24D	Ø1.60	-	Ø3.00	7.05	43.70	80.00
TD.165.IK.24D	Ø1.65	-	Ø3.00	7.30	45.10	80.00
TD.170.IK.24D	Ø1.70	-	Ø3.00	7.50	46.40	80.00
TD.175.IK.24D	Ø1.75	-	Ø3.00	7.70	47.80	80.00
TD.180.IK.24D	Ø1.80	-	Ø3.00	7.95	49.20	88.00
TD.185.IK.24D	Ø1.85	-	Ø3.00	8.15	50.50	88.00
TD.190.IK.24D	Ø1.90	-	Ø3.00	8.40	51.90	88.00
TD.195.IK.24D	Ø1.95	-	Ø3.00	8.60	53.30	88.00
TD.200.IK.24D	Ø2.00	-	Ø4.00	8.80	54.60	88.00
TD.205.IK.24D	Ø2.05	-	Ø4.00	9.05	56.00	94.00
TD.210.IK.24D	Ø2.10	-	Ø4.00	9.25	57.40	94.00
TD.215.IK.24D	Ø2.15	-	Ø4.00	9.50	58.70	94.00
TD.220.IK.24D	Ø2.20	-	Ø4.00	9.70	60.10	94.00
TD.225.IK.24D	Ø2.25	-	Ø4.00	9.90	61.50	94.00
TD.230.IK.24D	Ø2.30	-	Ø4.00	10.15	63.00	100.00
TD.235.IK.24D	Ø2.35	-	Ø4.00	10.35	64.20	100.00
TD.2381.IK.24D	Ø2.381	3/32"	Ø4.00	10.50	65.00	100.00
TD.240.IK.24D	Ø2.40	-	Ø4.00	10.60	65.60	100.00
TD.245.IK.24D	Ø2.45	-	Ø4.00	10.80	66.90	100.00
TD.250.IK.24D	Ø2.50	-	Ø4.00	11.00	68.30	100.00
TD.255.IK.24D	Ø2.55	-	Ø4.00	11.25	69.60	106.00
TD.260.IK.24D	Ø2.60	-	Ø4.00	11.45	71.00	106.00
TD.265.IK.24D	Ø2.65	-	Ø4.00	11.70	72.40	106.00
TD.270.IK.24D	Ø2.70	-	Ø4.00	11.90	73.70	106.00
TD.275.IK.24D	Ø2.75	-	Ø4.00	12.10	75.10	106.00
TD.280.IK.24D	Ø2.80	-	Ø4.00	12.35	76.50	110.00
TD.285.IK.24D	Ø2.85	-	Ø4.00	12.55	77.80	110.00
TD.290.IK.24D	Ø2.90	-	Ø4.00	12.80	79.20	110.00
TD.295.IK.24D	Ø2.95	-	Ø4.00	13.00	80.60	110.00
TD.300.IK.24D	Ø3.00	-	Ø6.00	13.20	81.90	114.00
TD.305.IK.24D	Ø3.05	-	Ø6.00	13.45	83.30	114.00
TD.310.IK.24D	Ø3.10	-	Ø6.00	13.65	84.70	114.00
TD.315.IK.24D	Ø3.15	-	Ø6.00	13.90	86.00	114.00
TD.3175.IK.24D	Ø3.175	1/8"	Ø6.00	14.00	86.70	125.00
TD.320.IK.24D	Ø3.20	-	Ø6.00	14.10	87.40	125.00

Article number	D1 k5 (mm)	D1 k5 (inch)	D3 h6 (mm)	L1 [4 margins] (mm)	L2 [Spiral slot] (mm)	GL (mm)
TD.325.IK.24D	Ø3.25	-	Ø6.00	14.30	88.80	125.00
TD.330.IK.24D	Ø3.30	-	Ø6.00	14.55	90.10	125.00
TD.335.IK.24D	Ø3.35	-	Ø6.00	14.75	91.50	125.00
TD.340.IK.24D	Ø3.40	-	Ø6.00	15.00	92.90	125.00
TD.345.IK.24D	Ø3.45	-	Ø6.00	15.20	94.20	125.00
TD.350.IK.24D	Ø3.50	-	Ø6.00	15.40	95.60	125.00
TD.355.IK.24D	Ø3.55	-	Ø6.00	15.65	97.00	125.00
TD.360.IK.24D	Ø3.60	-	Ø6.00	15.85	98.30	145.00
TD.365.IK.24D	Ø3.65	-	Ø6.00	16.10	99.70	145.00
TD.370.IK.24D	Ø3.70	-	Ø6.00	16.30	101.00	145.00
TD.375.IK.24D	Ø3.75	-	Ø6.00	16.50	102.40	145.00
TD.380.IK.24D	Ø3.80	-	Ø6.00	16.75	103.80	145.00
TD.385.IK.24D	Ø3.85	-	Ø6.00	16.95	105.10	145.00
TD.390.IK.24D	Ø3.90	-	Ø6.00	17.20	106.50	145.00
TD.395.IK.24D	Ø3.95	-	Ø6.00	17.40	107.90	145.00
TD.3969.IK.24D	Ø3.969	5/32"	Ø6.00	17.50	108.40	145.00
TD.400.IK.24D	Ø4.00	-	Ø6.00	17.60	109.20	145.00
TD.410.IK.24D	Ø4.10	-	Ø6.00	18.05	112.00	145.00
TD.420.IK.24D	Ø4.20	-	Ø6.00	18.50	114.70	145.00
TD.430.IK.24D	Ø4.30	-	Ø6.00	18.95	117.40	145.00
TD.440.IK.24D	Ø4.40	-	Ø6.00	19.40	120.20	165.00
TD.450.IK.24D	Ø4.50	-	Ø6.00	19.80	122.90	165.00
TD.460.IK.24D	Ø4.60	-	Ø6.00	20.25	125.60	165.00
TD.470.IK.24D	Ø4.70	-	Ø6.00	20.70	128.40	165.00
TD.4763.IK.24D	Ø4.763	3/16"	Ø6.00	21.00	130.00	165.00
TD.480.IK.24D	Ø4.80	-	Ø6.00	21.15	131.10	165.00
TD.490.IK.24D	Ø4.90	-	Ø6.00	21.60	133.80	165.00
TD.500.IK.24D	Ø5.00	-	Ø6.00	22.00	136.50	165.00
TD.510.IK.24D	Ø5.10	-	Ø6.00	22.45	139.30	200.00
TD.520.IK.24D	Ø5.20	-	Ø6.00	22.90	142.00	200.00
TD.530.IK.24D	Ø5.30	-	Ø6.00	23.35	144.70	200.00
TD.540.IK.24D	Ø5.40	-	Ø6.00	23.80	147.50	200.00
TD.550.IK.24D	Ø5.50	-	Ø6.00	24.20	150.20	200.00
TD.5556.IK.24D	Ø5.556	7/32"	Ø6.00	24.50	151.70	200.00
TD.560.IK.24D	Ø5.60	-	Ø6.00	24.65	152.90	200.00
TD.570.IK.24D	Ø5.70	-	Ø6.00	25.10	155.60	200.00
TD.580.IK.24D	Ø5.80	-	Ø6.00	25.55	158.40	200.00
TD.590.IK.24D	Ø5.90	-	Ø6.00	26.00	161.10	200.00
TD.600.IK.24D	Ø6.00	-	Ø6.00	26.40	163.80	200.00
TD.6350.IK.24D	Ø6.35	1/4"	Ø8.00	28.00	173.40	220.00

24xD

4 margins ensure perfect guidance of the twist drill.

from Ø1.0 m5
to Ø 6.35 m5

Fine-grain solid carbide (high cutting and feed rates are possible)

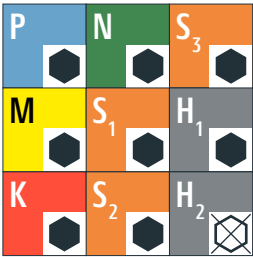
130°-INOX high-performance point geometry drill Ø in k5 tolerance with internal cooling (IK).

The α-INOXcronos coating ensures long tool life and prevents cutting edge build-up.

Shank according to DIN6535 HA h6 shank Ø tolerance.



TARGETDRILL[®]
by HB microtec
INOX-12xD cooled
INOX-18xD cooled
INOX-24xD cooled



Recommended use Highly suitable Partially suitable Not recommended

Material group	Material group	Mat. no.	DIN	AISI/ASTM/UNS
P	Steels up to RM < 1200N/mm ²	1.0044	S275JR	AISI 1020
		1.0715	11SMn30	AISI 1215
		1.7131	16MnCr5	AISI 5115
		1.3505	100Cr6	AISI 52100
		1.7225	42CrMo4	AISI 4140
M	Stainless steels: ferritic, martensitic, austenitic	1.4034	X46Cr13	AISI 420C
		1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH
		1.4301	X5CrNi 18-10	AISI 304
		1.4435	X2CrNiMo 18-14-3	AISI 316L
K	Cast iron	0.6020	GG20	ASTM 30
		0.6030	GG30	ASTM 40B
		0.7040	GGG40	ASTM 60-40-18
		0.7060	GGG60	ASTM 80-60-03
N	Non-ferrous metals	3.2315	AlMgSi1	ASTM 6351
		2.0065	Cu-ETP / CW004A	UNS C11000
		2.0321	CuZn37 CW508L	UNS C27400
		2.0401	CuZn39Pb3 / CW614N	UNS C38500
		2.0966	CuAl10Ni5Fe4	UNS C63000
S (S1, S2, S3)	Heat-resistant steels, titanium, CrCo	2.4617	NiMo28	Hastelloy B-2
		2.4665	NiCr22Fe18Mo	Hastelloy X
		3.7165	TiAl6V4	ASTM B348 / F136
		9.9367	TiAl6Nb7	ASTM F1295
		2.4964	CoCr20W15Ni	Haynes 25
H	Hardened steels ≥ 60 HRC		CrCoMo28	ASTM F1537
		1.2510	100MnCrMoW4	AISI O1
		1.2379	X153CrMoV12	AISI D2

Ø 1.0 - 1.2 mm		Ø 1.2 - 1.8 mm		Ø 1.8 - 2.5 mm		Ø 2.5 - 4.0 mm		Ø 4.0 - 6.35 mm	
vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]	vc [m/min]	f [mm/U]
60-130	0.05- 0.066	60-130	0.122 - 0.128	60-130	0.130 - 0.182	60-140	0.128 - 0.232	60-160	0.150 - 0.280
60-120	0.05- 0.056	60-120	0.120 - 0.122	60-130	0.130 - 0.182	60-120	0.128 - 0.202	60-150	0.150 - 0.260
50-120	0.03 - 0.04	50-120	0.043 - 0.055	50-120	0.060 - 0.080	50-100	0.074 - 0.098	50-120	0.10 - 0.185
50-80	0.025 - 0.038	50-80	0.040 - 0.068	50-90	0.050 - 0.070	50-90	0.072 - 0.084	50-100	0.10 - 0.175
80-140	0.035 - 0.042	80-140	0.06 - 0.115	80-160	0.126 - 0.135	80-160	0.100 - 0.145	80-180	0.110 - 0.210
80-160	0.042 - 0.066	80-160	0.096 - 0.122	80-160	0.132 - 0.18	80-160	0.136 - 0.172	80-180	0.200 - 0.250
80-140	0.046 - 0.088	80-140	0.098 - 0.122	80-160	0.132 - 0.210	80-160	0.134 - 0.164	80-180	0.200 - 0.252
80-120	0.032 - 0.088	80-120	0.066 - 0.122	80-140	0.085 - 0.120	80-120	0.132 - 0.162	80-160	0.195 - 0.242
15 - 50	0.025 - 0.05	15 - 50	0.049 - 0.060	15 - 60	0.060 - 0.07	15 - 70	0.062 - 0.08	15 - 80	0.080 - 0.12
15 - 50	0.025 - 0.05	15 - 50	0.048 - 0.060	15 - 60	0.060 - 0.07	15 - 70	0.062 - 0.08	15 - 80	0.080 - 0.12
15 - 50	0.020 - 0.04	15 - 50	0.05 - 0.060	15 - 50	0.055 - 0.07	15 - 60	0.052 - 0.08	15 - 75	0.076 - 0.12
15-32	0.006 - 0.01	15-32	0.006 - 0.010	15-32	0.006 - 0.012	15-35	0.006 - 0.014	15-40	0.009 - 0.018
15-32	0.006 - 0.01	15-32	0.006 - 0.010	15-32	0.006 - 0.012	15-35	0.006 - 0.014	15-40	0.009 - 0.018

TARGETDRILL®

by HB microtec

INOX cooled



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