

Product Information



Work Material



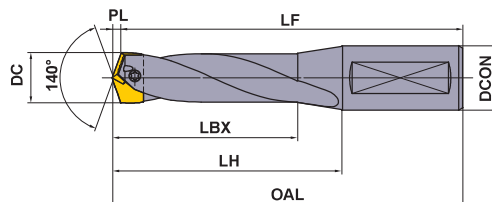
TECHNICAL DATA >> 1997

ISO13399 Property >> 1966

SYMBOL DESCRIPTIONS >> 1623

DRILLS SELECTION CHART >> 1624

(General Use)



HOLDERS

DC (mm)	Hole Depth (l/d)	Holder		Dimensions (mm)						Clamp Screw	Wrench	Plate	Anti-seize Lubricant	Insert				
		Order Number	Stock	LBX	LH	OAL	LF	PL	DCON					DC (mm)	Order Number	Stock		
															VP15TF	DP5010	VP10H	
18.5 19.4	3	TAWSN1900S25	●	71.4	102.4	158.4	155	3.4	25	WS304517T	TKY10T	WPT4405	MK1KS	18.5	TAWNH1850T	●		<input type="checkbox"/>
															TAWKH1850TG		●	
														18.6	TAWNH1860T	●		<input type="checkbox"/>
															TAWKH1860TG		●	
		18.7	TAWNH1870T	●		<input type="checkbox"/>												
			TAWKH1870TG		●													
		18.8	TAWNH1880T	●		<input type="checkbox"/>												
			TAWKH1880TG		●													
		18.9	TAWNH1890T	●		<input type="checkbox"/>												
			TAWKH1890TG		●													
		19.0	TAWNH1900T	●		<input type="checkbox"/>												
			TAWKH1900TG		●													
	19.1	TAWNH1910T	●		<input type="checkbox"/>													
		TAWKH1910TG		●														
	19.2	TAWNH1920T	●		<input type="checkbox"/>													
		TAWKH1920TG		●														
	19.3	TAWNH1930T	●		<input type="checkbox"/>													
		TAWKH1930TG		●														
	19.4	TAWNH1940T	●		<input type="checkbox"/>													
		TAWKH1940TG		●														
19.5 20.4	3	TAWSN2000S25	●	75.5	102.5	158.5	155	3.5	25	WS304518T	TKY10T	WPT4405	MK1KS	19.5	TAWNH1950T	●		<input type="checkbox"/>
															TAWKH1950TG		●	
														19.6	TAWNH1960T	●		<input type="checkbox"/>
															TAWKH1960TG		●	
		19.7	TAWNH1970T	●		<input type="checkbox"/>												
			TAWKH1970TG		●													
		19.8	TAWNH1980T	●		<input type="checkbox"/>												
			TAWKH1980TG		●													
		19.9	TAWNH1990T	●		<input type="checkbox"/>												
			TAWKH1990TG		●													
		20.0	TAWNH2000T	●		<input type="checkbox"/>												
			TAWKH2000TG		●													
	20.1	TAWNH2010T	<input type="checkbox"/>		<input type="checkbox"/>													
		TAWKH2010TG		<input type="checkbox"/>														
	20.2	TAWNH2020T	<input type="checkbox"/>		<input type="checkbox"/>													
		TAWKH2020TG		<input type="checkbox"/>														
	20.3	TAWNH2030T	<input type="checkbox"/>		<input type="checkbox"/>													
		TAWKH2030TG		<input type="checkbox"/>														
	20.4	TAWNH2040T	<input type="checkbox"/>		<input type="checkbox"/>													
		TAWKH2040TG		<input type="checkbox"/>														

(Note 1) The dimensions in brackets represent the sizes when TAWNH type inserts are used.

(Note 2) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan.

: Non stock, produced to order only.

TAW

DC (mm)	Hole Depth (l/d)	Holder		Dimensions (mm)						Clamp Screw	Wrench	Plate	Anti-seize Lubricant	Insert					
		Order Number	Stock	LBX	LH	OAL	LF	PL	DCON					DC (mm)	Order Number	Stock			
																VP15TF	DP5010	VP10H	
20.5 21.4	3	TAWSN2100S25	●	78.7	102.7	158.7	155.0	3.7	25	WS304518T	TKY10T	WPT4405	MK1KS	20.5	TAWNH2050T	●			
															TAWKH2050TG		●		
														20.6	TAWNH2060T				
															TAWKH2060TG				
		5	TAWMN2100S25	●	121.8	142.8	198.8	195.0	3.8	25	WS304518T	TKY10T	WPT4405	MK1KS	20.7	TAWNH2070T			
															TAWKH2070TG				
	20.8														TAWNH2080T				
															TAWKH2080TG				
		8	TAWLN2100S25	●	181.9	205.9	261.9	258.0	3.9	25	WS304518T	TKY10T	WPT4405	MK1KS	20.9	TAWNH2090T			
															TAWKH2090TG				
	21.0														TAWNH2100T	●			
															TAWKH2100TG		●		
	3	TAWSN2200S25	●	83.2	108.2	164.2	160.3	3.9	25	WS355520T	TKY15T	WPT4405	MK1KS	21.1	TAWNH2110T				
														TAWKH2110TG					
21.2														TAWNH2120T					
														TAWKH2120TG					
	5	TAWMN2200S25	●	128.3	148.3	204.3	200.3	4.0	25	WS355520T	TKY15T	WPT4405	MK1KS	21.3	TAWNH2130T				
														TAWKH2130TG					
21.4														TAWNH2140T					
														TAWKH2140TG					
	8	TAWLN2200S25	●	190.0	214.0	270.0	266.0	4.0	25	WS355520T	TKY15T	WPT4405	MK1KS	21.5	TAWNH2150T	●			
														TAWKH2150TG		●			
21.6														TAWNH2160T					
														TAWKH2160TG					
	3	TAWSN2300S25	●	86.4	108.4	164.4	160.3	4.1	25	WS355521T	TKY15T	WPT4405	MK1KS	21.7	TAWNH2170T				
														TAWKH2170TG					
21.8														TAWNH2180T					
														TAWKH2180TG					
	5	TAWMN2300S25	●	133.4	158.4	214.4	210.3	4.1	25	WS355521T	TKY15T	WPT4405	MK1KS	21.9	TAWNH2190T				
														TAWKH2190TG					
22.0														TAWNH2200T	●				
														TAWKH2200TG		●			
	8	TAWLN2300S25	●	198.2	227.2	283.2	279.0	4.2	25	WS355521T	TKY15T	WPT4405	MK1KS	22.1	TAWNH2210T				
														TAWKH2210TG					
22.2														TAWNH2220T					
														TAWKH2220TG					
	3	TAWSN2300S25	●	86.4	108.4	164.4	160.3	4.1	25	WS355521T	TKY15T	WPT4405	MK1KS	22.3	TAWNH2230T				
														TAWKH2230TG					
22.4														TAWNH2240T					
														TAWKH2240TG					
	5	TAWMN2300S25	●	133.4	158.4	214.4	210.3	4.1	25	WS355521T	TKY15T	WPT4405	MK1KS	22.5	TAWNH2250T	●			
														TAWKH2250TG		●			
22.6														TAWNH2260T					
														TAWKH2260TG					
	8	TAWLN2300S25	●	198.2	227.2	283.2	279.0	4.2	25	WS355521T	TKY15T	WPT4405	MK1KS	22.7	TAWNH2270T				
														TAWKH2270TG					
22.8														TAWNH2280T					
														TAWKH2280TG					
	3	TAWSN2300S25	●	86.4	108.4	164.4	160.3	4.1	25	WS355521T	TKY15T	WPT4405	MK1KS	22.9	TAWNH2290T				
														TAWKH2290TG					
23.0														TAWNH2300T	●				
														TAWKH2300TG		●			
	5	TAWMN2300S25	●	133.4	158.4	214.4	210.3	4.1	25	WS355521T	TKY15T	WPT4405	MK1KS	23.1	TAWNH2310T				
														TAWKH2310TG					
23.2														TAWNH2320T					
														TAWKH2320TG					
	8	TAWLN2300S25	●	198.2	227.2	283.2	279.0	4.2	25	WS355521T	TKY15T	WPT4405	MK1KS	23.3	TAWNH2330T				
														TAWKH2330TG					
23.4														TAWNH2340T					
														TAWKH2340TG					

(Note 1) The dimensions in brackets represent the sizes when TAWNH type inserts are used.
 (Note 2) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

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DC (mm)	Hole Depth (l/d)	Holder		Dimensions (mm)						Clamp Screw	Wrench	Plate	Anti-seize Lubricant	Insert					
		Order Number	Stock	LBX	LH	OAL	LF	PL	DCON					DC (mm)	Order Number	Stock			
																VP15TF	DP5010	VP10H	
23.5 24.4	3	TAWSN2400S32	●	90.6	114.6	174.6	170.3	4.3	32	WS355521T	TKY15T	WPT4405	MK1KS	23.5	TAWNH2350T	●			
															TAWKH2350TG		●		
														23.6	TAWNH2360T				
															TAWKH2360TG				
		5	TAWMN2400S32	●	139.6	164.6	224.6	220.3	4.3	32	WS355521T	TKY15T	WPT4405	MK1KS	23.7	TAWNH2370T			
															TAWKH2370TG				
	23.8														TAWNH2380T				
															TAWKH2380TG				
		8	TAWLN2400S32	●	206.4	236.4	296.4	292.0	4.4	32	WS355521T	TKY15T	WPT4405	MK1KS	23.9	TAWNH2390T			
															TAWKH2390TG				
	24.0														TAWNH2400T	●			
															TAWKH2400TG		●		
	3	TAWSN2500S32	●	93.1	115.1	175.1	170.6	4.5	32	WS406023T	TKY25T	WPT4405	MK1KS	24.1	TAWNH2410T				
														TAWKH2410TG					
24.2														TAWNH2420T					
														TAWKH2420TG					
	5	TAWMN2500S32	●	145.1	170.1	230.1	225.6	4.5	32	WS406023T	TKY25T	WPT4405	MK1KS	24.3	TAWNH2430T				
														TAWKH2430TG					
24.4														TAWNH2440T					
														TAWKH2440TG					
	8	TAWLN2500S32	●	214.6	244.6	304.6	300.0	4.6	32	WS406023T	TKY25T	WPT4405	MK1KS	24.5	TAWNH2450T	●			
														TAWKH2450TG		●			
24.6														TAWNH2460T					
														TAWKH2460TG					
	3	TAWSN2600S32	●	97.2	120.2	180.2	175.6	4.6	32	WS406024T	TKY25T	WPT4405	MK1KS	24.7	TAWNH2470T				
														TAWKH2470TG					
24.8														TAWNH2480T					
														TAWKH2480TG					
	5	TAWMN2600S32	●	151.3	175.3	235.3	230.6	4.7	32	WS406024T	TKY25T	WPT4405	MK1KS	24.9	TAWNH2490T				
														TAWKH2490TG					
25.0														TAWNH2500T	●				
														TAWKH2500TG		●			
	8	TAWLN2600S32	●	222.8	252.8	312.8	308.0	4.8	32	WS406024T	TKY25T	WPT4405	MK1KS	25.1	TAWNH2510T				
														TAWKH2510TG					
25.2														TAWNH2520T					
														TAWKH2520TG					
	3	TAWSN2600S32	●	97.2	120.2	180.2	175.6	4.6	32	WS406024T	TKY25T	WPT4405	MK1KS	25.3	TAWNH2530T				
														TAWKH2530TG					
25.4														TAWNH2540T					
														TAWKH2540TG					
	5	TAWMN2600S32	●	151.3	175.3	235.3	230.6	4.7	32	WS406024T	TKY25T	WPT4405	MK1KS	25.5	TAWNH2550T	●			
														TAWKH2550TG		●			
25.6														TAWNH2560T					
														TAWKH2560TG					
	8	TAWLN2600S32	●	222.8	252.8	312.8	308.0	4.8	32	WS406024T	TKY25T	WPT4405	MK1KS	25.7	TAWNH2570T				
														TAWKH2570TG					
25.8														TAWNH2580T					
														TAWKH2580TG					
	3	TAWSN2600S32	●	97.2	120.2	180.2	175.6	4.6	32	WS406024T	TKY25T	WPT4405	MK1KS	25.9	TAWNH2590T				
														TAWKH2590TG					
26.0														TAWNH2600T	●				
														TAWKH2600TG		●			
	5	TAWMN2600S32	●	151.3	175.3	235.3	230.6	4.7	32	WS406024T	TKY25T	WPT4405	MK1KS	26.1	TAWNH2610T				
														TAWKH2610TG					
26.2														TAWNH2620T					
														TAWKH2620TG					
	8	TAWLN2600S32	●	222.8	252.8	312.8	308.0	4.8	32	WS406024T	TKY25T	WPT4405	MK1KS	26.3	TAWNH2630T				
														TAWKH2630TG					
26.4														TAWNH2640T					
														TAWKH2640TG					





TAW

DC (mm)	Hole Depth (l/d)	Holder		Dimensions (mm)						Clamp Screw	Wrench	Plate	Anti-seize Lubricant	Insert				
		Order Number	Stock	LBX	LH	OAL	LF	PL	DCON					DC (mm)	Order Number	Stock		
																VP15TF	DP5010	VP10H
26.5 27.4	3	TAWSN2700S32	●	99.4	120.4	180.4	175.6	4.8	32	WS406024T	TKY25T	WPT4405	MK1KS	26.5	TAWNH2650T	●		
															TAWKH2650TG		●	
														26.6	TAWNH2660T			
															TAWKH2660TG			
	5	TAWMN2700S32	●	156.5	180.5	240.5	235.6	4.9	32	WS406024T	TKY25T	WPT4405	MK1KS	26.7	TAWNH2670T			
															TAWKH2670TG			
														26.8	TAWNH2680T			
															TAWKH2680TG			
	8	TAWLN2700S32	●	230.9	260.9	320.9	316.0	4.9	32	WS406024T	TKY25T	WPT4405	MK1KS	26.9	TAWNH2690T			
															TAWKH2690TG			
														27.0	TAWNH2700T	●		
															TAWKH2700TG		●	
27.5 28.4	3	TAWSN2800S32	●	102.2	125.2	185.2	180.2	5.0	32	WS508026T	TKY27T	WPT4405	MK1KS	27.1	TAWNH2710T			
															TAWKH2710TG			
														27.2	TAWNH2720T			
															TAWKH2720TG			
	5	TAWMN2800S32	●	162.3	185.3	245.3	240.2	5.1	32	WS508026T	TKY27T	WPT4405	MK1KS	27.3	TAWNH2730T			
															TAWKH2730TG			
														27.4	TAWNH2740T			
															TAWKH2740TG			
8	TAWLN2800S32	●	239.1	269.1	329.1	324.0	5.1	32	WS508026T	TKY27T	WPT4405	MK1KS	27.5	TAWNH2750T	●			
														TAWKH2750TG		●		
													27.6	TAWNH2760T				
														TAWKH2760TG				
28.5 29.4	3	TAWSN2900S32	●	105.4	130.4	190.4	185.2	5.2	32	WS508027T	TKY27T	WPT4405	MK1KS	27.7	TAWNH2770T			
															TAWKH2770TG			
														27.8	TAWNH2780T			
															TAWKH2780TG			
	5	TAWMN2900S32	●	167.4	190.4	250.4	245.2	5.2	32	WS508027T	TKY27T	WPT4405	MK1KS	27.9	TAWNH2790T			
															TAWKH2790TG			
														28.0	TAWNH2800T	●		
															TAWKH2800TG		●	
8	TAWLN2900S32	●	247.3	277.3	337.3	332.0	5.3	32	WS508027T	TKY27T	WPT4405	MK1KS	28.1	TAWNH2810T				
														TAWKH2810TG				
													28.2	TAWNH2820T				
														TAWKH2820TG				
28.5 29.4	3	TAWSN2900S32	●	105.4	130.4	190.4	185.2	5.2	32	WS508027T	TKY27T	WPT4405	MK1KS	28.3	TAWNH2830T			
															TAWKH2830TG			
														28.4	TAWNH2840T			
															TAWKH2840TG			
	5	TAWMN2900S32	●	167.4	190.4	250.4	245.2	5.2	32	WS508027T	TKY27T	WPT4405	MK1KS	28.5	TAWNH2850T	●		
															TAWKH2850TG		●	
														28.6	TAWNH2860T			
															TAWKH2860TG			
8	TAWLN2900S32	●	247.3	277.3	337.3	332.0	5.3	32	WS508027T	TKY27T	WPT4405	MK1KS	28.7	TAWNH2870T				
														TAWKH2870TG				
													28.8	TAWNH2880T				
														TAWKH2880TG				
5	TAWMN2900S32	●	167.4	190.4	250.4	245.2	5.2	32	WS508027T	TKY27T	WPT4405	MK1KS	28.9	TAWNH2890T				
														TAWKH2890TG				
													29.0	TAWNH2900T	●			
														TAWKH2900TG		●		
8	TAWLN2900S32	●	247.3	277.3	337.3	332.0	5.3	32	WS508027T	TKY27T	WPT4405	MK1KS	29.1	TAWNH2910T				
														TAWKH2910TG				
													29.2	TAWNH2920T				
														TAWKH2920TG				
5	TAWMN2900S32	●	167.4	190.4	250.4	245.2	5.2	32	WS508027T	TKY27T	WPT4405	MK1KS	29.3	TAWNH2930T				
														TAWKH2930TG				
													29.4	TAWNH2940T				
														TAWKH2940TG				

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TAW

DC (mm)	Hole Depth (l/d)	Holder		Dimensions (mm)						 Clamp Screw	 Wrench	 Plate	 Anti-seize Lubricant	Insert				
		Order Number	Stock	LBX	LH	OAL	LF	PL	DCON					DC (mm)	Order Number	Stock		
																VP15TF	DP5010	VP10H
29.5 30.4	3	TAWSN3000S32	●	109.6	130.6	190.6	185.2	5.4	32	WS508027T	TKY27T	WPT4405	MK1KS	29.5	TAWNH2950T	●		□
															TAWKH2950TG		●	
														29.6	TAWNH2960T	□		□
															TAWKH2960TG		□	
														29.7	TAWNH2970T	□		□
															TAWKH2970TG		□	
	29.8	TAWNH2980T	□		□													
		TAWKH2980TG		□														
	5	TAWMN3000S32	●	172.6	200.6	260.6	255.2	5.4	32	WS508027T	TKY27T	WPT4405	MK1KS	29.9	TAWNH2990T	□		□
															TAWKH2990TG		□	
														30.0	TAWNH3000T	●		□
															TAWKH3000TG		●	
30.1														TAWNH3010T	□		□	
														TAWKH3010TG		□		
30.2	TAWNH3020T	□		□														
	TAWKH3020TG		□															
8	TAWLN3000S32	●	255.5	290.5	350.5	345.0	5.5	32	WS508027T	TKY27T	WPT4405	MK1KS	30.3	TAWNH3030T	□		□	
														TAWKH3030TG		□		
													30.4	TAWNH3040T	□		□	
														TAWKH3040TG		□		

RECOMMENDED CUTTING CONDITIONS

Work Material	Drill Diameter	φ 14.0—φ 15.4		φ 15.5—φ 18.4		φ 18.5—φ 21.4	
		Conditions Hardness	Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)
P Mild Steel	≤180HB	70(60—90)	0.20 (0.15—0.25)	80 (60—100)	0.25 (0.20—0.30)	90 (70—110)	0.25 (0.20—0.30)
	180—280HB	70 (60—90)	0.20 (0.15—0.25)	80 (60—100)	0.25 (0.20—0.30)	80 (60—100)	0.25 (0.20—0.30)
	280—350HB	60 (50—80)	0.15 (0.12—0.18)	70 (50—90)	0.20 (0.15—0.25)	70 (50—90)	0.20 (0.15—0.25)
M Stainless Steel	≤200HB	50 (40—60)	0.15 (0.12—0.18)	50 (40—60)	0.15 (0.12—0.18)	60 (50—70)	0.20 (0.15—0.22)
K Gray Cast Iron	Tensile Strength ≤350MPa	70 (50—90)	0.20 (0.15—0.25)	100 (60—120)	0.25 (0.20—0.30)	120 (60—140)	0.25 (0.20—0.30)
	Ductile Cast Iron	Tensile Strength ≤450MPa	70 (50—90)	0.20 (0.15—0.25)	80 (60—90)	0.25 (0.20—0.30)	80 (60—90)

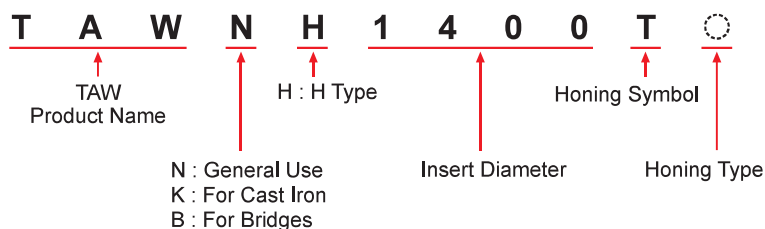
Work Material	Drill Diameter	φ 21.5—φ 24.4		φ 24.5—φ 27.4		φ 27.5—φ 30.4	
		Conditions Hardness	Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)
P Mild Steel	≤180HB	100 (80—120)	0.30 (0.25—0.35)	110 (80—120)	0.30 (0.25—0.35)	110 (80—120)	0.30 (0.25—0.35)
	180—280HB	90 (70—110)	0.30 (0.25—0.35)	100 (80—120)	0.30 (0.25—0.35)	100 (80—120)	0.30 (0.25—0.35)
	280—350HB	80 (60—100)	0.25 (0.20—0.30)	90 (70—110)	0.25 (0.20—0.30)	90 (70—110)	0.25 (0.20—0.30)
M Stainless Steel	≤200HB	60 (50—70)	0.20 (0.15—0.22)	70 (60—80)	0.25 (0.20—0.28)	70 (60—80)	0.25 (0.20—0.28)
K Gray Cast Iron	Tensile Strength ≤350MPa	130 (80—150)	0.35 (0.25—0.40)	140 (90—160)	0.35 (0.25—0.40)	140 (90—160)	0.40 (0.30—0.45)
	Ductile Cast Iron	Tensile Strength ≤450MPa	90 (60—100)	0.30 (0.25—0.35)	100 (80—110)	0.30 (0.25—0.35)	100 (80—110)

(Note 1) When using the 8DC type holder, reduce the cutting speed by approx. 20%.
 (Note 2) When using the 8DC type holder, it is recommended to drill a pilot guide hole.
 (Note 3) H type honing is recommended when machining mild steel and stainless steel.

HONE WIDTH

If an insert with honing other than standard is needed, please order using the symbols below.

(Insert Order Number)



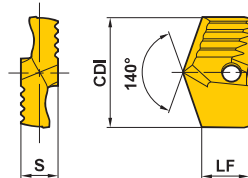
(Honing Standard)

Honing Type	Hone Width (mm)
F	0
G	0.02—0.05
H	0.05—0.10
-(Standard)	0.10—0.15
K	0.15—0.20
S	0.20—0.25
M	0.25—0.30

TAW

INSERTS

H Type



Order Number	Stock		Dimensions (mm)			Applicable Holder
	VP15TF	VP10H	CDI	LF	S	
TAWNH1400T	▲		14.0	7.6	5.0	TAWSNH 1400S16
TAWNH1410T	▲		14.1	7.6	5.0	TAWMNH 1400S16
TAWNH1420T	▲		14.2	7.6	5.0	TAWLNH 1400S16
TAWNH1430T	▲		14.3	7.6	5.0	
TAWNH1440T	▲		14.4	7.6	5.0	
TAWNH1450T	▲		14.5	7.5	5.0	
TAWNH1460T	▲		14.6	7.5	5.0	
TAWNH1470T	▲		14.7	7.5	5.0	TAWSNH 1500S20
TAWNH1480T	▲		14.8	7.5	5.0	TAWMNH 1500S20
TAWNH1490T	▲		14.9	7.5	5.0	TAWLNH 1500S20
TAWNH1500T	▲		15.0	7.4	5.0	
TAWNH1510T	▲		15.1	7.4	5.0	
TAWNH1520T	▲		15.2	7.4	5.0	
TAWNH1530T	▲		15.3	7.4	5.0	
TAWNH1540T	▲		15.4	7.4	5.0	
TAWNH1550T	▲		15.5	7.9	6.0	
TAWNH1560T	▲		15.6	7.9	6.0	
TAWNH1570T	▲		15.7	7.9	6.0	TAWSN 1600S20
TAWNH1580T	▲		15.8	7.9	6.0	TAWMN 1600S20
TAWNH1590T	▲		15.9	7.9	6.0	TAWLN 1600S20
TAWNH1600T	▲		16.0	7.8	6.0	
TAWNH1610T	▲		16.1	7.8	6.0	
TAWNH1620T	▲		16.2	7.8	6.0	
TAWNH1630T	▲		16.3	7.8	6.0	
TAWNH1640T	▲		16.4	7.8	6.0	
TAWNH1650T	▲		16.5	7.7	6.0	
TAWNH1660T	▲		16.6	7.7	6.0	
TAWNH1670T	▲		16.7	7.7	6.0	TAWSN 1700S20
TAWNH1680T	▲		16.8	7.7	6.0	TAWMN 1700S20
TAWNH1690T	▲		16.9	7.7	6.0	TAWLN 1700S20
TAWNH1700T	▲		17.0	7.6	6.0	
TAWNH1710T	▲		17.1	7.6	6.0	
TAWNH1720T	▲		17.2	7.6	6.0	
TAWNH1730T	▲		17.3	7.6	6.0	
TAWNH1740T	▲		17.4	7.6	6.0	
TAWNH1750T	▲		17.5	7.5	6.0	
TAWNH1760T	▲		17.6	7.5	6.0	
TAWNH1770T	▲		17.7	7.5	6.0	TAWSN 1800S20
TAWNH1780T	▲		17.8	7.5	6.0	TAWMN 1800S20
TAWNH1790T	▲		17.9	7.5	6.0	TAWLN 1800S20
TAWNH1800T	▲		18.0	7.4	6.0	
TAWNH1810T	▲		18.1	7.4	6.0	
TAWNH1820T	▲		18.2	7.4	6.0	
TAWNH1830T	▲		18.3	7.4	6.0	
TAWNH1840T	▲		18.4	7.4	6.0	

Order Number	Stock		Dimensions (mm)			Applicable Holder
	VP15TF	VP10H	CDI	LF	S	
TAWNH1850T	●	□	18.5	9.3	7.0	
TAWNH1860T	●	□	18.6	9.3	7.0	
TAWNH1870T	●	□	18.7	9.3	7.0	TAWSN 1900S25
TAWNH1880T	●	□	18.8	9.3	7.0	TAWMN 1900S25
TAWNH1890T	●	□	18.9	9.3	7.0	TAWLN 1900S25
TAWNH1900T	●	□	19.0	9.2	7.0	
TAWNH1910T	●	□	19.1	9.2	7.0	
TAWNH1920T	●	□	19.2	9.2	7.0	
TAWNH1930T	●	□	19.3	9.2	7.0	
TAWNH1940T	●	□	19.4	9.2	7.0	
TAWNH1950T	●	□	19.5	9.1	7.0	
TAWNH1960T	●	□	19.6	9.1	7.0	
TAWNH1970T	●	□	19.7	9.1	7.0	TAWSN 2000S25
TAWNH1980T	●	□	19.8	9.1	7.0	TAWMN 2000S25
TAWNH1990T	●	□	19.9	9.1	7.0	TAWLN 2000S25
TAWNH2000T	●	□	20.0	9.0	7.0	
TAWNH2010T	□	□	20.1	9.0	7.0	
TAWNH2020T	□	□	20.2	9.0	7.0	
TAWNH2030T	□	□	20.3	9.0	7.0	
TAWNH2040T	□	□	20.4	9.0	7.0	
TAWNH2050T	●	□	20.5	8.9	7.0	
TAWNH2060T	□	□	20.6	8.9	7.0	
TAWNH2070T	□	□	20.7	8.9	7.0	TAWSN 2100S25
TAWNH2080T	□	□	20.8	8.9	7.0	TAWMN 2100S25
TAWNH2090T	□	□	20.9	8.9	7.0	TAWLN 2100S25
TAWNH2100T	●	□	21.0	8.8	7.0	
TAWNH2110T	□	□	21.1	8.8	7.0	
TAWNH2120T	□	□	21.2	8.8	7.0	
TAWNH2130T	□	□	21.3	8.8	7.0	
TAWNH2140T	□	□	21.4	8.8	7.0	
TAWNH2150T	●	□	21.5	10.6	8.0	
TAWNH2160T	□	□	21.6	10.6	8.0	
TAWNH2170T	□	□	21.7	10.6	8.0	TAWSN 2200S25
TAWNH2180T	□	□	21.8	10.6	8.0	TAWMN 2200S25
TAWNH2190T	□	□	21.9	10.6	8.0	TAWLN 2200S25
TAWNH2200T	●	□	22.0	10.5	8.0	
TAWNH2210T	□	□	22.1	10.5	8.0	
TAWNH2220T	□	□	22.2	10.5	8.0	
TAWNH2230T	□	□	22.3	10.5	8.0	
TAWNH2240T	□	□	22.4	10.5	8.0	
TAWNH2250T	●	□	22.5	10.4	8.0	TAWSN 2300S25
TAWNH2260T	□	□	22.6	10.4	8.0	TAWMN 2300S25
TAWNH2270T	□	□	22.7	10.4	8.0	TAWLN 2300S25
TAWNH2280T	□	□	22.8	10.4	8.0	
TAWNH2290T	□	□	22.9	10.4	8.0	

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

▲ : Inventory maintained in Japan. To be replaced by new products.

(1 insert in one case)

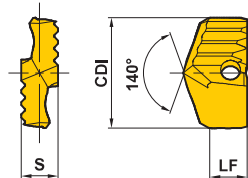
Order Number	Stock		Dimensions (mm)			Applicable Holder
	VP15TF	VP10H	CDI	LF	S	
TAWNH2300T	●	□	23.0	10.3	8.0	TAWSN 2300S25
TAWNH2310T	□	□	23.1	10.3	8.0	TAWMN 2300S25
TAWNH2320T	□	□	23.2	10.3	8.0	TAWLN 2300S25
TAWNH2330T	□	□	23.3	10.3	8.0	
TAWNH2340T	□	□	23.4	10.3	8.0	
TAWNH2350T	●	□	23.5	10.2	8.0	
TAWNH2360T	□	□	23.6	10.2	8.0	
TAWNH2370T	□	□	23.7	10.2	8.0	TAWSN 2400S32
TAWNH2380T	□	□	23.8	10.2	8.0	TAWMN 2400S32
TAWNH2390T	□	□	23.9	10.2	8.0	TAWLN 2400S32
TAWNH2400T	●	□	24.0	10.1	8.0	
TAWNH2410T	□	□	24.1	10.1	8.0	
TAWNH2420T	□	□	24.2	10.1	8.0	
TAWNH2430T	□	□	24.3	10.1	8.0	
TAWNH2440T	□	□	24.4	10.1	8.0	
TAWNH2450T	●	□	24.5	11.7	9.0	
TAWNH2460T	□	□	24.6	11.7	9.0	
TAWNH2470T	□	□	24.7	11.7	9.0	TAWSN 2500S32
TAWNH2480T	□	□	24.8	11.7	9.0	TAWMN 2500S32
TAWNH2490T	□	□	24.9	11.7	9.0	TAWLN 2500S32
TAWNH2500T	●	□	25.0	11.6	9.0	
TAWNH2510T	□	□	25.1	11.6	9.0	
TAWNH2520T	□	□	25.2	11.6	9.0	
TAWNH2530T	□	□	25.3	11.6	9.0	
TAWNH2540T	□	□	25.4	11.6	9.0	
TAWNH2550T	●	□	25.5	11.5	9.0	
TAWNH2560T	□	□	25.6	11.5	9.0	
TAWNH2570T	□	□	25.7	11.5	9.0	TAWSN 2600S32
TAWNH2580T	□	□	25.8	11.5	9.0	TAWMN 2600S32
TAWNH2590T	□	□	25.9	11.5	9.0	TAWLN 2600S32
TAWNH2600T	●	□	26.0	11.4	9.0	
TAWNH2610T	□	□	26.1	11.4	9.0	
TAWNH2620T	□	□	26.2	11.4	9.0	
TAWNH2630T	□	□	26.3	11.4	9.0	
TAWNH2640T	□	□	26.4	11.4	9.0	
TAWNH2650T	●	□	26.5	11.3	9.0	
TAWNH2660T	□	□	26.6	11.3	9.0	
TAWNH2670T	□	□	26.7	11.3	9.0	TAWSN 2700S32
TAWNH2680T	□	□	26.8	11.3	9.0	TAWMN 2700S32
TAWNH2690T	□	□	26.9	11.3	9.0	TAWLN 2700S32
TAWNH2700T	●	□	27.0	11.2	9.0	
TAWNH2710T	□	□	27.1	11.2	9.0	
TAWNH2720T	□	□	27.2	11.2	9.0	
TAWNH2730T	□	□	27.3	11.2	9.0	
TAWNH2740T	□	□	27.4	11.2	9.0	

Order Number	Stock		Dimensions (mm)			Applicable Holder
	VP15TF	VP10H	CDI	LF	S	
TAWNH2750T	●	□	27.5	12.3	10.0	
TAWNH2760T	□	□	27.6	12.3	10.0	
TAWNH2770T	□	□	27.7	12.3	10.0	TAWSN 2800S32
TAWNH2780T	□	□	27.8	12.3	10.0	TAWMN 2800S32
TAWNH2790T	□	□	27.9	12.3	10.0	TAWLN 2800S32
TAWNH2800T	●	□	28.0	12.2	10.0	
TAWNH2810T	□	□	28.1	12.2	10.0	
TAWNH2820T	□	□	28.2	12.2	10.0	
TAWNH2830T	□	□	28.3	12.2	10.0	
TAWNH2840T	□	□	28.4	12.2	10.0	
TAWNH2850T	●	□	28.5	12.1	10.0	
TAWNH2860T	□	□	28.6	12.1	10.0	
TAWNH2870T	□	□	28.7	12.1	10.0	TAWSN 2900S32
TAWNH2880T	□	□	28.8	12.1	10.0	TAWMN 2900S32
TAWNH2890T	□	□	28.9	12.1	10.0	TAWLN 2900S32
TAWNH2900T	●	□	29.0	12.0	10.0	
TAWNH2910T	□	□	29.1	12.0	10.0	
TAWNH2920T	□	□	29.2	12.0	10.0	
TAWNH2930T	□	□	29.3	12.0	10.0	
TAWNH2940T	□	□	29.4	12.0	10.0	
TAWNH2950T	●	□	29.5	11.9	10.0	
TAWNH2960T	□	□	29.6	11.9	10.0	
TAWNH2970T	□	□	29.7	11.9	10.0	TAWSN 3000S32
TAWNH2980T	□	□	29.8	11.9	10.0	TAWMN 3000S32
TAWNH2990T	□	□	29.9	11.9	10.0	TAWLN 3000S32
TAWNH3000T	●	□	30.0	11.8	10.0	
TAWNH3010T	□	□	30.1	11.8	10.0	
TAWNH3020T	□	□	30.2	11.8	10.0	
TAWNH3030T	□	□	30.3	11.8	10.0	
TAWNH3040T	□	□	30.4	11.8	10.0	

TAW

INSERTS

H Type
(Cast Iron)



Order Number	Stock	Dimensions (mm)			Applicable Holder
	DP5010	CDI	LF	S	
TAWKH1400TG	▲	14.0	7.1	5.0	TAWSNH 1400S16
TAWKH1410TG	▲	14.1	7.1	5.0	TAWMNH 1400S16
TAWKH1420TG	▲	14.2	7.1	5.0	TAWLNH 1400S16
TAWKH1430TG	▲	14.3	7.1	5.0	
TAWKH1440TG	▲	14.4	7.1	5.0	
TAWKH1450TG	▲	14.5	7.0	5.0	
TAWKH1460TG	▲	14.6	7.0	5.0	
TAWKH1470TG	▲	14.7	7.0	5.0	TAWSNH 1500S20
TAWKH1480TG	▲	14.8	7.0	5.0	TAWMNH 1500S20
TAWKH1490TG	▲	14.9	7.0	5.0	TAWLNH 1500S20
TAWKH1500TG	▲	15.0	6.9	5.0	
TAWKH1510TG	▲	15.1	6.9	5.0	
TAWKH1520TG	▲	15.2	6.9	5.0	
TAWKH1530TG	▲	15.3	6.9	5.0	
TAWKH1540TG	▲	15.4	6.9	5.0	
TAWKH1550TG	▲	15.5	7.3	6.0	
TAWKH1560TG	▲	15.6	7.3	6.0	
TAWKH1570TG	▲	15.7	7.3	6.0	TAWSN 1600S20
TAWKH1580TG	▲	15.8	7.3	6.0	TAWMNH 1600S20
TAWKH1590TG	▲	15.9	7.3	6.0	TAWLNH 1600S20
TAWKH1600TG	▲	16.0	7.2	6.0	
TAWKH1610TG	▲	16.1	7.2	6.0	
TAWKH1620TG	▲	16.2	7.2	6.0	
TAWKH1630TG	▲	16.3	7.2	6.0	
TAWKH1640TG	▲	16.4	7.2	6.0	
TAWKH1650TG	▲	16.5	7.1	6.0	
TAWKH1660TG	▲	16.6	7.1	6.0	
TAWKH1670TG	▲	16.7	7.1	6.0	TAWSN 1700S20
TAWKH1680TG	▲	16.8	7.1	6.0	TAWMNH 1700S20
TAWKH1690TG	▲	16.9	7.1	6.0	TAWLNH 1700S20
TAWKH1700TG	▲	17.0	7.0	6.0	
TAWKH1710TG	▲	17.1	7.0	6.0	
TAWKH1720TG	▲	17.2	7.0	6.0	
TAWKH1730TG	▲	17.3	7.0	6.0	
TAWKH1740TG	▲	17.4	7.0	6.0	
TAWKH1750TG	▲	17.5	6.8	6.0	
TAWKH1760TG	▲	17.6	6.8	6.0	
TAWKH1770TG	▲	17.7	6.8	6.0	TAWSN 1800S20
TAWKH1780TG	▲	17.8	6.8	6.0	TAWMNH 1800S20
TAWKH1790TG	▲	17.9	6.8	6.0	TAWLNH 1800S20
TAWKH1800TG	▲	18.0	6.8	6.0	
TAWKH1810TG	▲	18.1	6.8	6.0	
TAWKH1820TG	▲	18.2	6.8	6.0	
TAWKH1830TG	▲	18.3	6.8	6.0	
TAWKH1840TG	▲	18.4	6.8	6.0	

Order Number	Stock	Dimensions (mm)			Applicable Holder
	DP5010	CDI	LF	S	
TAWKH1850TG	●	18.5	8.6	7.0	
TAWKH1860TG	●	18.6	8.6	7.0	
TAWKH1870TG	●	18.7	8.6	7.0	TAWSN 1900S25
TAWKH1880TG	●	18.8	8.6	7.0	TAWMNH 1900S25
TAWKH1890TG	●	18.9	8.6	7.0	TAWLNH 1900S25
TAWKH1900TG	●	19.0	8.5	7.0	
TAWKH1910TG	●	19.1	8.5	7.0	
TAWKH1920TG	●	19.2	8.5	7.0	
TAWKH1930TG	●	19.3	8.5	7.0	
TAWKH1940TG	●	19.4	8.5	7.0	
TAWKH1950TG	●	19.5	8.4	7.0	
TAWKH1960TG	●	19.6	8.4	7.0	
TAWKH1970TG	●	19.7	8.4	7.0	TAWSN 2000S25
TAWKH1980TG	●	19.8	8.4	7.0	TAWMNH 2000S25
TAWKH1990TG	●	19.9	8.4	7.0	TAWLNH 2000S25
TAWKH2000TG	●	20.0	8.3	7.0	
TAWKH2010TG	□	20.1	8.3	7.0	
TAWKH2020TG	□	20.2	8.3	7.0	
TAWKH2030TG	□	20.3	8.3	7.0	
TAWKH2040TG	□	20.4	8.3	7.0	
TAWKH2050TG	●	20.5	8.2	7.0	
TAWKH2060TG	□	20.6	8.2	7.0	
TAWKH2070TG	□	20.7	8.2	7.0	TAWSN 2100S25
TAWKH2080TG	□	20.8	8.2	7.0	TAWMNH 2100S25
TAWKH2090TG	□	20.9	8.2	7.0	TAWLNH 2100S25
TAWKH2100TG	●	21.0	8.1	7.0	
TAWKH2110TG	□	21.1	8.1	7.0	
TAWKH2120TG	□	21.2	8.1	7.0	
TAWKH2130TG	□	21.3	8.1	7.0	
TAWKH2140TG	□	21.4	8.1	7.0	
TAWKH2150TG	●	21.5	9.8	8.0	
TAWKH2160TG	□	21.6	9.8	8.0	
TAWKH2170TG	□	21.7	9.8	8.0	TAWSN 2200S25
TAWKH2180TG	□	21.8	9.8	8.0	TAWMNH 2200S25
TAWKH2190TG	□	21.9	9.8	8.0	TAWLNH 2200S25
TAWKH2200TG	●	22.0	9.7	8.0	
TAWKH2210TG	□	22.1	9.7	8.0	
TAWKH2220TG	□	22.2	9.7	8.0	
TAWKH2230TG	□	22.3	9.7	8.0	
TAWKH2240TG	□	22.4	9.7	8.0	
TAWKH2250TG	●	22.5	9.6	8.0	TAWSN 2300S25
TAWKH2260TG	□	22.6	9.6	8.0	TAWMNH 2300S25
TAWKH2270TG	□	22.7	9.6	8.0	TAWLNH 2300S25
TAWKH2280TG	□	22.8	9.6	8.0	
TAWKH2290TG	□	22.9	9.6	8.0	

● : Inventory maintained in Japan. □ : Non stock, produced to order only.
▲ : Inventory maintained in Japan. To be replaced by new products.
(1 insert in one case)

Order Number	Stock	Dimensions (mm)			Applicable Holder
	DP5010	CDI	LF	S	
TAWKH2300TG	●	23.0	9.5	8.0	TAWSN 2300S25
TAWKH2310TG	□	23.1	9.5	8.0	
TAWKH2320TG	□	23.2	9.5	8.0	
TAWKH2330TG	□	23.3	9.5	8.0	
TAWKH2340TG	□	23.4	9.5	8.0	
TAWKH2350TG	●	23.5	9.4	8.0	TAWSN 2400S32
TAWKH2360TG	□	23.6	9.4	8.0	
TAWKH2370TG	□	23.7	9.4	8.0	
TAWKH2380TG	□	23.8	9.4	8.0	
TAWKH2390TG	□	23.9	9.4	8.0	
TAWKH2400TG	●	24.0	9.3	8.0	
TAWKH2410TG	□	24.1	9.3	8.0	
TAWKH2420TG	□	24.2	9.3	8.0	
TAWKH2430TG	□	24.3	9.3	8.0	
TAWKH2440TG	□	24.4	9.3	8.0	
TAWKH2450TG	●	24.5	10.8	9.0	TAWSN 2500S32
TAWKH2460TG	□	24.6	10.8	9.0	
TAWKH2470TG	□	24.7	10.8	9.0	
TAWKH2480TG	□	24.8	10.8	9.0	
TAWKH2490TG	□	24.9	10.8	9.0	
TAWKH2500TG	●	25.0	10.7	9.0	
TAWKH2510TG	□	25.1	10.7	9.0	
TAWKH2520TG	□	25.2	10.7	9.0	
TAWKH2530TG	□	25.3	10.7	9.0	
TAWKH2540TG	□	25.4	10.7	9.0	
TAWKH2550TG	●	25.5	10.6	9.0	TAWSN 2600S32
TAWKH2560TG	□	25.6	10.6	9.0	
TAWKH2570TG	□	25.7	10.6	9.0	
TAWKH2580TG	□	25.8	10.6	9.0	
TAWKH2590TG	□	25.9	10.6	9.0	
TAWKH2600TG	●	26.0	10.5	9.0	
TAWKH2610TG	□	26.1	10.5	9.0	
TAWKH2620TG	□	26.2	10.5	9.0	
TAWKH2630TG	□	26.3	10.5	9.0	
TAWKH2640TG	□	26.4	10.5	9.0	
TAWKH2650TG	●	26.5	10.4	9.0	TAWSN 2700S32
TAWKH2660TG	□	26.6	10.4	9.0	
TAWKH2670TG	□	26.7	10.4	9.0	
TAWKH2680TG	□	26.8	10.4	9.0	
TAWKH2690TG	□	26.9	10.4	9.0	
TAWKH2700TG	●	27.0	10.3	9.0	
TAWKH2710TG	□	27.1	10.3	9.0	
TAWKH2720TG	□	27.2	10.3	9.0	
TAWKH2730TG	□	27.3	10.3	9.0	
TAWKH2740TG	□	27.4	10.3	9.0	

Order Number	Stock	Dimensions (mm)			Applicable Holder
	DP5010	CDI	LF	S	
TAWKH2750TG	●	27.5	11.3	10.0	TAWSN 2800S32
TAWKH2760TG	□	27.6	11.3	10.0	
TAWKH2770TG	□	27.7	11.3	10.0	
TAWKH2780TG	□	27.8	11.3	10.0	
TAWKH2790TG	□	27.9	11.3	10.0	
TAWKH2800TG	●	28.0	11.2	10.0	
TAWKH2810TG	□	28.1	11.2	10.0	
TAWKH2820TG	□	28.2	11.2	10.0	
TAWKH2830TG	□	28.3	11.2	10.0	
TAWKH2840TG	□	28.4	11.2	10.0	
TAWKH2850TG	●	28.5	11.1	10.0	TAWSN 2900S32
TAWKH2860TG	□	28.6	11.1	10.0	
TAWKH2870TG	□	28.7	11.1	10.0	
TAWKH2880TG	□	28.8	11.1	10.0	
TAWKH2890TG	□	28.9	11.1	10.0	
TAWKH2900TG	●	29.0	11.0	10.0	
TAWKH2910TG	□	29.1	11.0	10.0	
TAWKH2920TG	□	29.2	11.0	10.0	
TAWKH2930TG	□	29.3	11.0	10.0	
TAWKH2940TG	□	29.4	11.0	10.0	
TAWKH2950TG	●	29.5	10.9	10.0	TAWSN 3000S32
TAWKH2960TG	□	29.6	10.9	10.0	
TAWKH2970TG	□	29.7	10.9	10.0	
TAWKH2980TG	□	29.8	10.9	10.0	
TAWKH2990TG	□	29.9	10.9	10.0	
TAWKH3000TG	●	30.0	10.8	10.0	
TAWKH3010TG	□	30.1	10.8	10.0	
TAWKH3020TG	□	30.2	10.8	10.0	
TAWKH3030TG	□	30.3	10.8	10.0	
TAWKH3040TG	□	30.4	10.8	10.0	

TAW

NOTES ON USE

INSERT INSTALLATION

- Loosen the clamp screw to install the insert.
- Correctly mesh the insert and the holder serrations, then slide the insert to the bottom of the slot.
- Fasten the clamp screw using the torque wrench provided while holding the insert lightly as shown. (Figure 1)
- Check there is no gap between the bottom of the insert and holder. (Figure 2)

Tighten the clamp screw according to the torque below.

Drill Diameter (mm)	Clamp Torque (N · m)
14—15	2.0
16—18	2.0
19—21	3.5
22—24	5.5
25—27	8.5
28—30	12.0

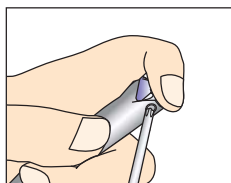


Fig. 1

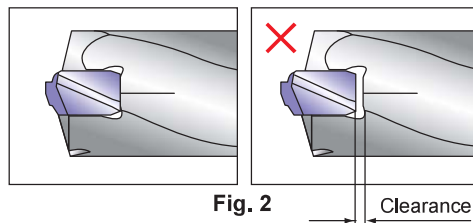


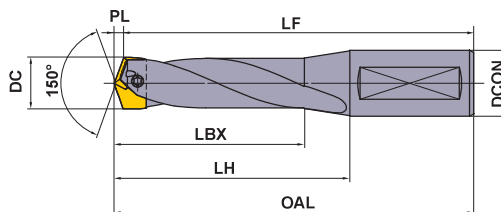
Fig. 2

INSERT REPLACEMENT

- Thoroughly clean the serrations of the holder before installing a new insert.
Remove heavy dirt in the holder serrations by using the cleaning plate provided.

TAW

(For Bridge Construction)



HOLDERS

DC (mm)	Hole Depth (l/d)	Holder		Insert			Dimensions (mm)						 Clamp Screw	 Wrench	 Plate	 Anti-seize Lubricant
		Order Number	Stock	DC (mm)	Order Number	Stock VP15TF	LBX	LH	OAL	LF	PL	DCON				
24.5	3	TAWSB2500S32	●	24.5	TAWBH2450T	●	91.9	113.9	173.9	170.6	3.3	32	WS406023T	TKY25T	WPT4405	MK1KS
24.6	5	TAWMB2500S32	□	24.6	TAWBH2460T	□	143.9	168.9	228.9	225.6	3.3	32	WS406023T	TKY25T	WPT4405	MK1KS
24.7				24.7	TAWBH2470T	●										
26.5	3	TAWSB2700S32	●	26.5	TAWBH2650T	□	98.2	119.2	179.2	175.6	3.6	32	WS406024T	TKY25T	WPT4405	MK1KS
26.7	5	TAWMB2700S32	□	26.7	TAWB2670T	●	155.2	179.2	239.2	235.6	3.6	32	WS406024T	TKY25T	WPT4405	MK1KS
					TAWBH2670T	●										

(Note 1) The above dimensions are for when installing the TAWBH (H type) insert.

(Note 2) Please contact us for any geometry that is not in this catalogue (e.g. different diameter and length).

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

INSERTS

Shape	Order Number	Stock VP15TF	Dimensions (mm)			Applicable Holder	Hone Width (mm)	Geometry
			CDI	LF	S			
 H Type	TAWBH2450T	●	24.5	11.7	9.0	TAWSB2500S32 TAWMB2500S32	0.20—0.25	 CDI 150° S LF
	TAWBH2460T	□	24.6	11.7	9.0			
	TAWBH2470T	●	24.7	11.7	9.0			
	TAWBH2650T	□	26.5	11.3	9.0	TAWSB2700S32 TAWMB2700S32		
	TAWBH2670T	●	26.7	11.3	9.0			

● : Inventory maintained in Japan. □ : Non stock, produced to order only.

(1 insert in one case)

RECOMMENDED CUTTING CONDITIONS

Work Material		Drill Diameter	φ24.5, φ24.6, φ24.7		φ26.5, φ26.7	
			Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)
P Structural Steel	SS400 (JIS)	Conditions Tensile Strength ≤400—500MPa Hardness	70 (60—80)	0.30 (0.25—0.35)	70 (60—80)	0.30 (0.25—0.35)
	SM490 (JIS)	Tensile Strength ≤490—610MPa	65 (55—75)	0.30 (0.25—0.35)	65 (55—75)	0.30 (0.25—0.35)
	SM570 (JIS)	Tensile Strength ≤570—720MPa	60 (50—70)	0.30 (0.25—0.35)	60 (50—70)	0.30 (0.25—0.35)

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