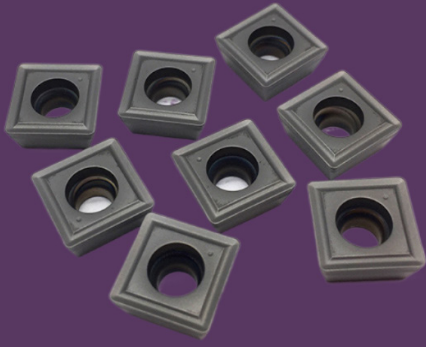


ECONOMICAL & EXCELLENCE IN HOLE MAKING



EcoCut

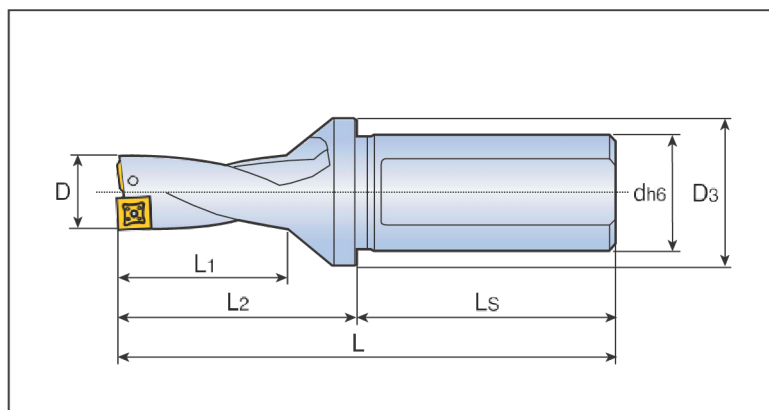
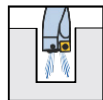
EcoCut Machining Solutions

DRILLING TOOLS

Indexable drill holder



- Drilling depth: 2x diameter

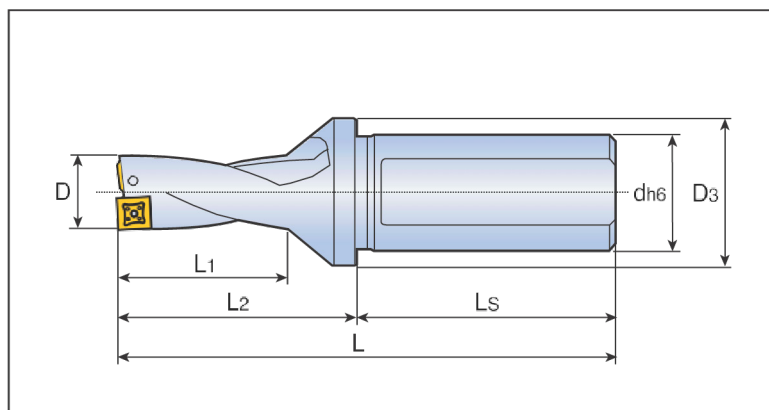
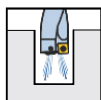


Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
HRG 2125-20T2-05	12.5	20	25	94	26	44	50	SPMG 05...
2130-20T2-05	13.0	20	25	94	26	44	50	
2135-20T2-05	13.5	20	25	96	28	46	50	
2140-20T2-05	14.0	20	25	96	28	46	50	
2145-20T2-05	14.5	20	25	99	30	49	50	
2150-20T2-05	15.0	20	25	99	30	49	50	
2155-25T2-06	15.5	25	32	108	32	52	56	SPMG 06...
2160-25T2-06	16.0	25	32	108	32	52	56	
2165-25T2-06	16.5	25	32	110	34	54	56	
2170-25T2-06	17.0	25	32	110	34	54	56	
2175-25T2-06	17.5	25	32	113	36	57	56	
2180-25T2-06	18.0	25	32	113	36	57	56	
2185-25T2-06	18.5	25	32	115	38	59	56	
2190-25T2-06	19.0	25	32	115	38	59	56	
2195-25T2-06	19.5	25	32	119	40	63	56	
2200-25T2-06	20.0	25	32	119	40	63	56	
2205-25T2-06	20.5	25	32	121	42	65	56	
2210-25T2-06	21.0	25	32	121	42	65	56	
2215-25T2-06	21.5	25	32	123	44	67	56	
2220-25T2-07	22.0	25	32	123	44	67	56	SPMG 07...
2225-25T2-07	22.5	25	45	127	46	71	56	
2225-32T2-07	22.5	32	45	131	46	71	60	
2230-25T2-07	23.0	25	45	127	46	71	56	
2230-32T2-07	23.0	32	45	131	46	71	60	
2235-25T2-07	23.5	25	45	130	48	74	56	
2235-32T2-07	23.5	32	45	134	48	74	60	
2240-25T2-07	24.0	25	45	130	48	74	56	
2240-32T2-07	24.0	32	45	134	48	74	60	
2245-25T2-07	24.5	25	45	133	50	77	56	
2245-32T2-07	24.5	32	45	137	50	77	60	
2250-25T2-07	25.0	25	45	133	50	77	56	
2250-32T2-07	25.0	32	45	137	50	77	60	
2255-25T2-07	25.5	25	45	135	52	79	56	
2255-32T2-07	25.5	32	45	139	52	79	60	
2260-25T2-07	26.0	25	45	135	52	79	56	

Indexable drill holder



- Drilling depth: 2x diameter

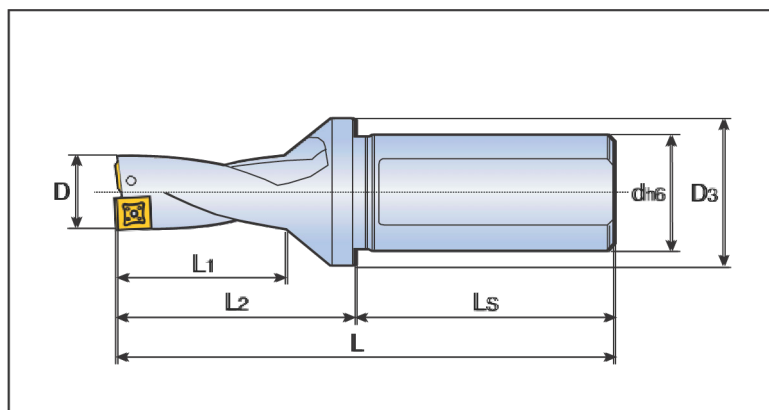
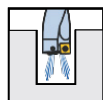


Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
HRG 2260-32T2-07	26.0	32	45	139	52	79	60	SPMG 07...
2265-25T2-07	26.5	25	45	137	54	81	56	
2265-32T2-07	26.5	32	45	141	54	81	60	
2270-25T2-07	27.0	25	45	137	54	81	56	
2270-32T2-07	27.0	32	45	141	54	81	60	
2275-25T2-07	27.5	25	45	140	56	84	56	
2275-32T2-07	27.5	32	45	144	56	84	60	
2280-25T2-09	28.0	25	45	140	56	84	56	SPMG 09...
2280-32T2-09	28.0	32	45	144	56	84	60	
2285-25T2-09	28.5	25	45	142	58	86	56	
2285-32T2-09	28.5	32	45	146	58	86	60	
2290-25T2-09	29.0	25	45	142	58	86	56	
2290-32T2-09	29.0	32	45	146	58	86	60	
2295-32T2-09	29.5	32	55	151	60	91	60	
2295-40T2-09	29.5	40	55	161	60	91	70	
2300-32T2-09	30.0	32	55	151	60	91	60	
2300-40T2-09	30.0	40	55	161	60	91	70	
2305-32T2-09	30.5	32	55	154	62	94	60	
2305-40T2-09	30.5	40	55	164	62	94	70	
2310-32T2-09	31.0	32	55	154	62	94	60	
2310-40T2-09	31.0	40	55	164	62	94	70	
2315-32T2-09	31.5	32	55	156	64	96	60	
2315-40T2-09	31.5	40	55	166	64	96	70	
2320-32T2-09	32.0	32	55	156	64	96	60	SPMG 11...
2320-40T2-09	32.0	40	55	166	64	96	70	
2325-32T2-09	32.5	32	55	159	66	99	60	
2325-40T2-09	32.5	40	55	169	66	99	70	
2330-32T2-09	33.0	32	55	159	66	99	60	
2330-40T2-09	33.0	40	55	169	66	99	70	
2340-32T2-11	34.0	32	55	161	68	101	60	
2340-40T2-11	34.0	40	55	171	68	101	70	
2350-32T2-11	35.0	32	55	164	70	104	60	
2350-40T2-11	35.0	40	55	174	70	104	70	
2360-32T2-11	36.0	32	55	167	72	107	60	
2360-40T2-11	36.0	40	55	177	72	107	70	

Indexable drill holder



• Drilling depth: 2x diameter



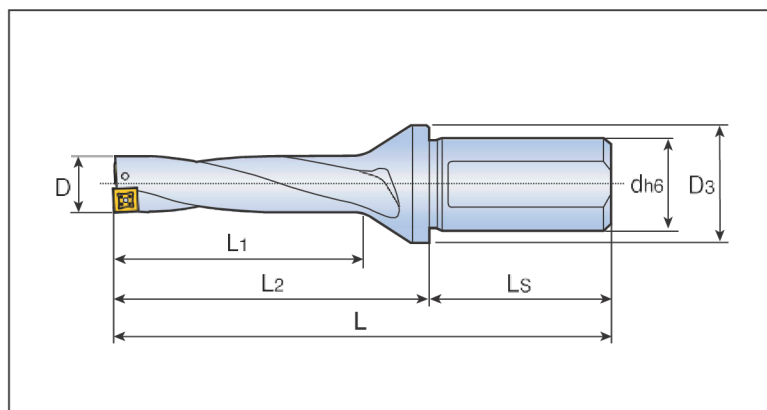
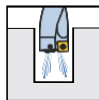
Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	L3	
HRG 2370-32T2-11	37.0	32	55	170	74	110	60	SPMG 11...
2370-40T2-11	37.0	40	55	180	74	110	70	
2380-32T2-11	38.0	32	55	173	76	113	60	
2380-40T2-11	38.0	40	55	183	76	113	70	
2390-32T2-11	39.0	32	55	175	78	115	60	
2390-40T2-11	39.0	40	55	185	78	115	70	
2400-32T2-11	40.0	32	60	178	80	118	60	
2400-40T2-11	40.0	40	60	188	80	118	70	
2410-40T2-11	41.0	40	60	191	82	121	70	
2420-40T2-14	42.0	40	60	193	84	123	70	SPMG 14...
2430-40T2-14	43.0	40	60	196	86	126	70	
2440-40T2-14	44.0	40	60	198	88	128	70	
2450-40T2-14	45.0	40	60	202	90	132	70	
2460-40T2-14	46.0	40	60	205	92	135	70	
2470-40T2-14	47.0	40	60	207	94	137	70	
2480-40T2-14	48.0	40	60	210	96	140	70	
2490-40T2-14	49.0	40	60	212	98	142	70	
2500-40T2-14	50.0	40	60	215	100	145	70	

Designation	Dimensions (mm)							Insert
	D	d	D3	L	L1	L2	L3	
HRG 2510-40T2-09	51	40	49	202	102	132	70	SPMG09
2520-40T2-09	52	40	49	204	104	134	70	
2530-40T2-09	53	40	49	206	106	136	70	
2540-40T2-09	54	40	49	208	108	138	70	
2550-40T2-09	55	40	49	210	110	140	70	
2560-40T2-09	56	40	49	212	112	142	70	
2570-40T2-09	57	40	49	212	114	142	70	
2580-40T2-09	58	40	49	212	116	142	70	
2590-40T2-09	59	40	49	218	118	142	70	
2600-40T2-09	60	40	49	218	120	142	70	
2610-40T2-09	61	40	49	222	122	152	70	
2620-40T2-09	62	40	49	224	124	154	70	
2630-40T2-09	63	40	49	226	126	156	70	
2640-40T2-09	64	40	49	228	128	158	70	
2650-40T2-09	65	40	49	230	130	160	70	
2610-40T2-09	66	40	49	232	132	162	70	
2620-40T2-09	67	40	49	234	134	164	70	
2630-40T2-09	68	40	49	236	136	166	70	
2640-40T2-09	69	40	49	238	138	168	70	
2650-40T2-09	70	40	49	240	140	170	70	

Indexable drill holder



- Drilling depth: 3x diameter



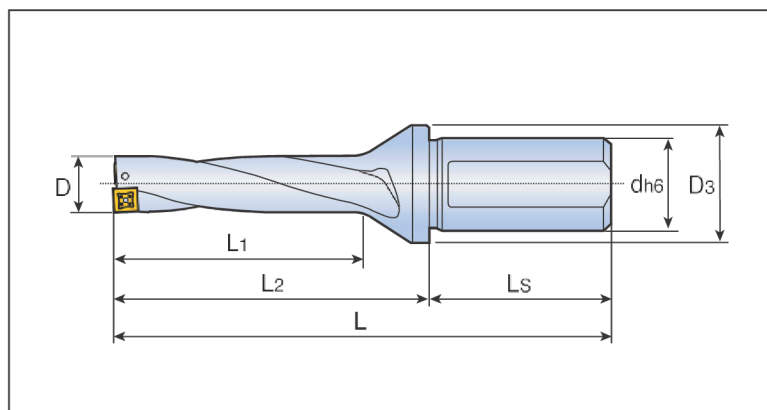
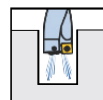
Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
HRG 3125-20T2-05	12.5	20	25	107	39	57	50	SPMG 05...
3130-20T2-05	13.0	20	25	107	39	57	50	
3135-20T2-05	13.5	20	25	110	42	60	50	
3140-20T2-05	14.0	20	25	110	42	60	50	
3145-20T2-05	14.5	20	25	114	45	64	50	
3150-20T2-05	15.0	20	25	114	45	64	50	
3155-25T2-06	15.5	25	32	124	48	68	56	SPMG 06...
3160-25T2-06	16.0	25	32	124	48	68	56	
3165-25T2-06	16.5	25	32	127	51	71	56	
3170-25T2-06	17.0	25	32	127	51	71	56	
3175-25T2-06	17.5	25	32	131	54	75	56	
3180-25T2-06	18.0	25	32	131	54	75	56	
3185-25T2-06	18.5	25	32	134	57	78	56	
3190-25T2-06	19.0	25	32	134	57	78	56	
3195-25T2-06	19.5	25	32	139	60	83	56	
3200-25T2-06 *	20.0	25	32	139	60	83	56	
3205-25T2-06	20.5	25	32	142	63	86	56	
3209-25T2-06 *	20.9	25	32	142	63	86	56	
3210-25T2-06	21.0	25	32	142	63	86	56	
3215-25T2-06	21.5	25	32	145	66	89	56	SPMG 07...
3220-25T2-07	22.0	25	32	145	66	89	56	
3225-25T2-07	22.5	25	45	150	69	94	56	
3225-32T2-07	22.5	32	45	154	69	94	60	
3230-25T2-07	23.0	25	45	150	69	94	56	
3230-32T2-07	23.0	32	45	154	69	94	60	
3235-25T2-07	23.5	25	45	154	72	98	56	
3235-32T2-07	23.5	32	45	158	72	98	60	
3239-25T2-07 *	23.9	25	32	154	72	98	56	
3239-32T2-07 *	23.9	32	45	158	72	98	60	
3240-25T2-07	24.0	25	45	154	72	98	56	
3240-32T2-07	24.0	32	45	158	72	98	60	
3245-25T2-07	24.5	25	45	158	75	102	56	
3245-32T2-07	24.5	32	45	162	75	102	60	
3250-25T2-07	25.0	25	45	158	75	102	56	
3250-32T2-07	25.0	32	45	162	75	102	60	

- '*' Marked items are for pre-thread hole making

Indexable drill holder



- Drilling depth: 3x diameter



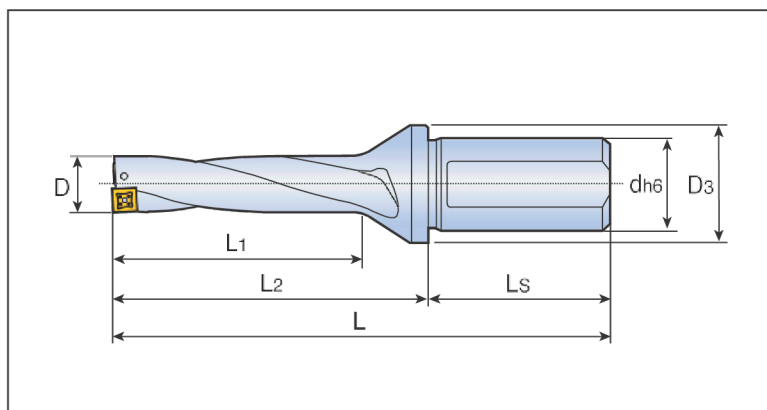
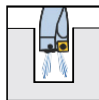
Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	LS	
HRG 3255-25T2-07	25.5	25	45	161	78	105	56	SPMG 07...
3255-32T2-07	25.5	32	45	165	78	105	60	
3260-25T2-07	26.0	25	45	161	78	105	56	
3260-32T2-07	26.0	32	45	165	78	105	60	
3264-25T2-07 *	26.4	25	45	164	81	108	56	
3264-32T2-07 *	26.4	32	45	168	81	108	60	
3265-25T2-07	26.5	25	45	164	81	108	56	
3265-32T2-07	26.5	32	45	168	81	108	60	
3270-25T2-07	27.0	25	45	164	81	108	56	
3270-32T2-07	27.0	32	45	168	81	108	60	
3275-25T2-07	27.5	25	45	168	84	112	56	
3275-32T2-07	27.5	32	45	172	84	112	60	
3280-25T2-09	28.0	25	45	168	84	112	56	SPMG 09... DG/DK/DA
3280-32T2-09	28.0	32	45	172	84	112	60	
3285-25T2-09	28.5	25	45	171	87	115	56	
3285-32T2-09	28.5	32	45	171	87	115	56	
3290-25T2-09	29.0	25	45	171	87	115	56	
3290-32T2-09	29.0	32	45	175	87	115	60	
3294-32T2-09 *	29.4	32	55	181	90	121	60	
3294-40T2-09 *	29.4	40	55	191	90	121	70	
3295-32T2-09	29.5	32	55	181	90	121	60	
3295-40T2-09	29.5	40	55	191	90	121	70	
3300-32T2-09	30.0	32	55	181	90	121	60	
3300-40T2-09	30.0	40	55	191	90	121	70	
3305-32T2-09	30.5	32	55	185	93	125	60	
3305-40T2-09	30.5	40	55	195	93	125	70	
3310-32T2-09	31.0	32	55	185	93	125	60	
3310-40T2-09	31.0	40	55	195	93	125	70	
3315-32T2-09	31.5	32	55	188	96	128	60	
3315-40T2-09	31.5	40	55	198	96	128	70	
3320-32T2-09	32.0	32	55	188	96	128	60	
3320-40T2-09	32.0	40	55	198	96	128	70	

- '*' Marked items are for pre-thread hole making

Indexable drill holder



- Drilling depth: $3 \times \text{diameter}$

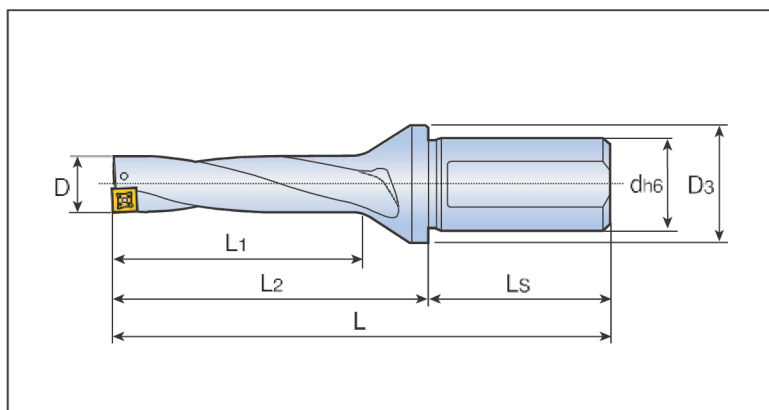
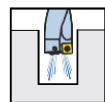
[illegible]

- '*' Marked items are for pre-thread hole making

Indexable drill holder



- Drilling depth: 3x diameter



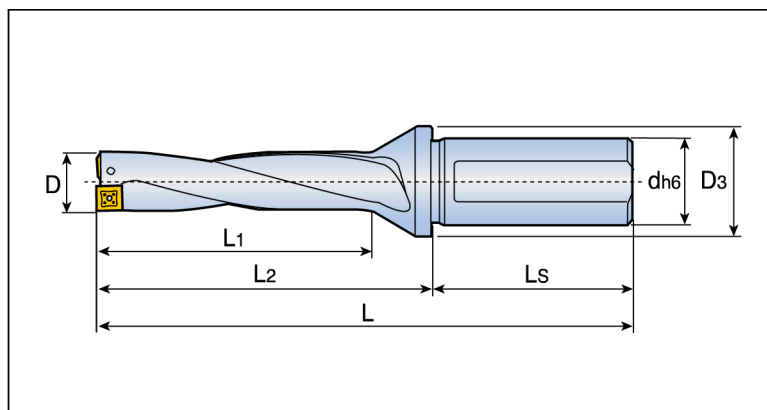
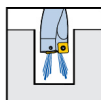
Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	L3	
HRG 3420-40T2-14	42.0	40	60	235	126	165	70	SPMG 14...
3430-40T2-14	43.0	40	60	239	129	169	70	
3440-40T2-14	44.0	40	60	242	132	172	70	
3450-40T2-14	45.0	40	60	247	135	177	70	
3460-40T2-14	46.0	40	60	251	138	181	70	
3470-40T2-14	47.0	40	60	254	141	184	70	
3480-40T2-14	48.0	40	60	258	144	188	70	
3490-40T2-14	49.0	40	60	261	147	191	70	
3500-40T2-14	50.0	40	60	265	150	195	70	

- '*' Marked items are for pre-thread hole making

Indexable drill holder



- Drilling depth: 4xdiameter

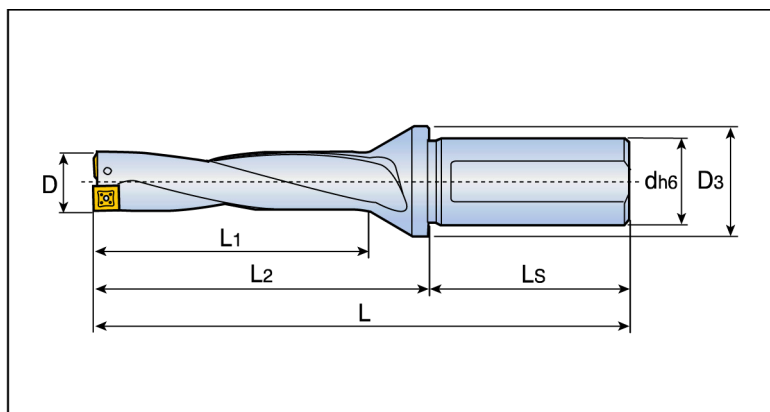
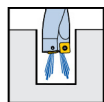


Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
HRG 4125-20T2-05	12.5	20	25	120	52	70	50	SPMG 05...
4130-20T2-05	13.0	20	25	120	52	70	50	
4135-20T2-05	13.5	20	25	124	56	74	50	
4140-20T2-05	14.0	20	25	124	56	74	50	
4145-20T2-05	14.5	20	25	129	60	79	50	
4150-20T2-05	15.0	20	25	129	60	79	50	
4155-25T2-06	15.5	25	32	140	64	84	56	SPMG 06...
4160-25T2-06	16.0	25	32	140	64	84	56	
4165-25T2-06	16.5	25	32	144	68	88	56	
4170-25T2-06	17.0	25	32	144	68	88	56	
4175-25T2-06	17.5	25	32	149	72	93	56	
4180-25T2-06	18.0	25	32	149	72	93	56	
4185-25T2-06	18.5	25	32	153	76	97	56	
4190-25T2-06	19.0	25	32	153	76	97	56	
4195-25T2-06	19.5	25	32	159	80	103	56	
4200-25T2-06	20.0	25	32	159	80	103	56	
4205-25T2-06	20.5	25	32	163	84	107	56	
4210-25T2-06	21.0	25	32	163	84	107	56	
4215-25T2-06	21.5	25	32	167	88	111	56	
4220-25T2-07	22.0	25	32	167	88	111	56	SPMG 07...
4225-25T2-07	22.5	25	45	173	92	117	56	
4225-32T2-07	22.5	32	45	177	92	117	60	
4230-25T2-07	23.0	25	45	173	92	117	56	
4230-32T2-07	23.0	32	45	177	92	117	60	
4235-25T2-07	23.5	25	45	178	96	122	56	
4235-32T2-07	23.5	32	45	182	96	122	60	
4240-25T2-07	24.0	25	45	178	96	122	56	
4240-32T2-07	24.0	32	45	182	96	122	60	
4245-25T2-07	24.5	25	45	183	100	127	56	
4245-32T2-07	24.5	32	45	187	100	127	60	
4250-25T2-07	25.0	25	45	183	100	127	56	
4250-32T2-07	25.0	32	45	187	100	127	60	
4255-25T2-07	25.5	25	45	187	104	131	56	
4255-32T2-07	25.5	32	45	191	104	131	60	
4260-25T2-07	26.0	25	45	187	104	131	56	

Indexable drill holder



• Drilling depth: 4xdiameter

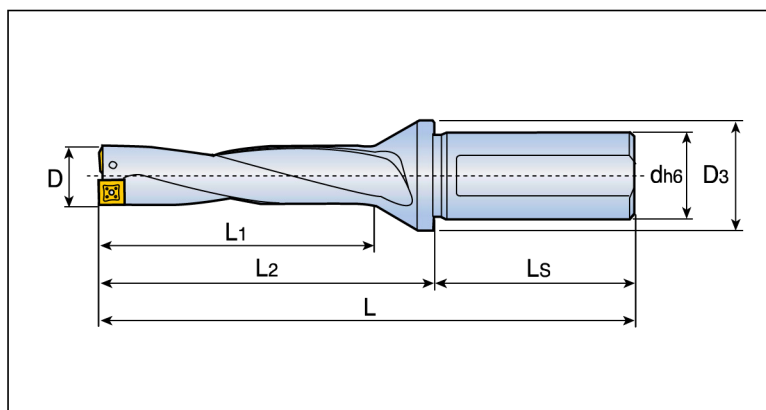
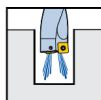


Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
HRG 4260-32T2-07	26.0	32	45	191	104	131	60	SPMG 07...
4265-25T2-07	26.5	25	45	191	108	135	56	
4265-32T2-07	26.5	32	45	195	108	135	60	
4270-25T2-07	27.0	25	45	191	108	135	56	
4270-32T2-07	27.0	32	45	195	108	135	60	
4275-25T2-07	27.5	25	45	196	112	140	56	
4275-32T2-07	27.5	32	45	200	112	140	60	
4280-25T2-09	28.0	25	45	196	112	140	56	SPMG 09...
4280-32T2-09	28.0	32	45	200	112	140	60	
4285-25T2-09	28.5	25	45	200	116	144	56	
4285-32T2-09	28.5	32	45	204	116	144	60	
4290-25T2-09	29.0	25	45	200	116	144	56	
4290-32T2-09	29.0	32	45	204	116	144	60	
4295-32T2-09	29.5	32	55	211	120	151	60	
4295-40T2-09	29.5	40	55	221	120	151	70	
4300-32T2-09	30.0	32	55	211	120	151	60	
4300-40T2-09	30.0	40	55	221	120	151	70	
4305-32T2-09	30.5	32	55	216	124	156	60	
4305-40T2-09	30.5	40	55	226	124	156	70	
4310-32T2-09	31.0	32	55	216	124	156	60	
4310-40T2-09	31.0	40	55	226	124	156	70	
4315-32T2-09	31.5	32	55	220	128	160	60	
4315-40T2-09	31.5	40	55	230	128	160	70	
4320-32T2-09	32.0	32	55	220	128	160	60	SPMG 11...
4320-40T2-09	32.0	40	55	230	128	160	70	
4325-32T2-09	32.5	32	55	225	132	165	60	
4325-40T2-09	32.5	40	55	235	132	165	70	
4330-32T2-09	33.0	32	55	225	132	165	60	
4330-40T2-09	33.0	40	55	235	132	165	70	
4340-32T2-11	34.0	32	55	229	136	169	60	
4340-40T2-11	34.0	40	55	239	136	169	70	
4350-32T2-11	35.0	32	55	234	140	174	60	
4350-40T2-11	35.0	40	55	244	140	174	70	
4360-32T2-11	36.0	32	55	239	144	179	60	
4360-40T2-11	36.0	40	55	249	144	179	70	

Indexable drill holder



- Drilling depth: 4x diameter

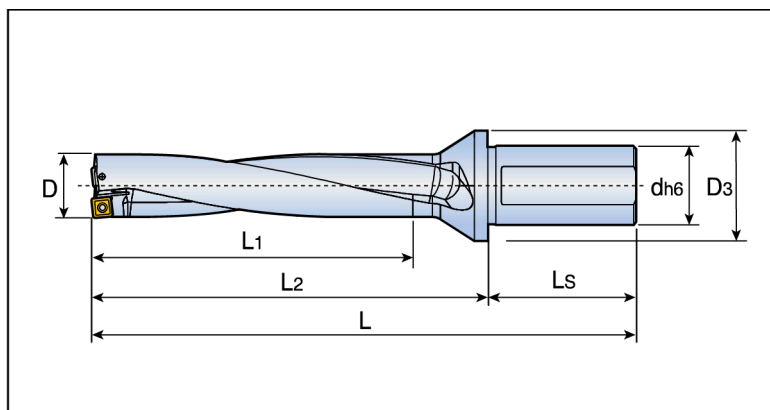
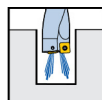


Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
HRG 4370-32T2-11	37.0	32	55	244	148	184	60	SPMG 11...
4370-40T2-11	37.0	40	55	254	148	184	70	
4380-32T2-11	38.0	32	55	249	152	189	60	
4380-40T2-11	38.0	40	55	259	152	189	70	
4390-32T2-11	39.0	32	55	253	156	193	60	
4390-40T2-11	39.0	40	55	263	156	193	70	
4400-32T2-11	40.0	32	60	258	160	198	60	
4400-40T2-11	40.0	40	60	268	160	198	70	
4410-40T2-11	41.0	40	60	273	164	203	70	
4420-40T2-14	42.0	40	60	277	168	207	70	SPMG 14...
4430-40T2-14	43.0	40	60	282	172	212	70	
4440-40T2-14	44.0	40	60	286	176	216	70	
4450-40T2-14	45.0	40	60	292	180	222	70	
4460-40T2-14	46.0	40	60	297	184	227	70	
4470-40T2-14	47.0	40	60	301	188	231	70	
4480-40T2-14	48.0	40	60	306	192	236	70	
4490-40T2-14	49.0	40	60	310	196	240	70	
4500-40T2-14	50.0	40	60	315	200	245	70	

Indexable drill holder



- Drilling depth: 5x diameter

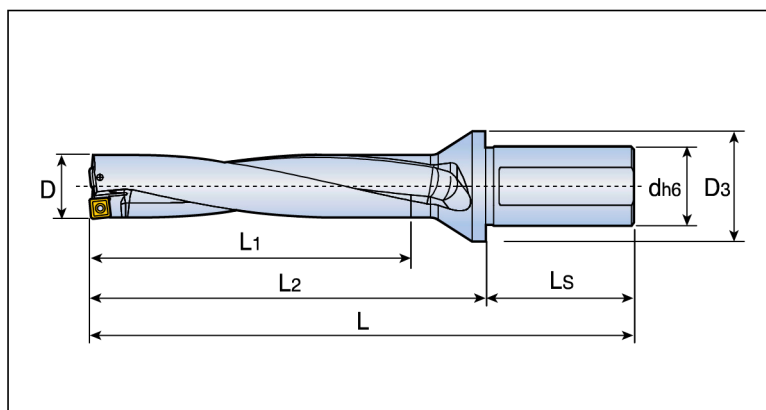
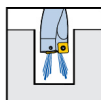


Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
HRG 5125-20T2-05	12.5	20	25	133	65	83	50	SPMG 05...
5130-20T2-05	13.0	20	25	133	65	83	50	
5135-20T2-05	13.5	20	25	138	70	88	50	
5140-20T2-05	14.0	20	25	138	70	88	50	
5145-20T2-05	14.5	20	25	144	75	94	50	
5150-20T2-05	15.0	20	25	144	75	94	50	
5155-25T2-06	15.5	25	32	156	80	100	56	SPMG 06...
5160-25T2-06	16.0	25	32	156	80	100	56	
5165-25T2-06	16.5	25	32	161	85	105	56	
5170-25T2-06	17.0	25	32	161	85	105	56	
5175-25T2-06	17.5	25	32	167	90	111	56	
5180-25T2-06	18.0	25	32	167	90	111	56	
5185-25T2-06	18.5	25	32	172	95	116	56	
5190-25T2-06	19.0	25	32	172	95	116	56	
5195-25T2-06	19.5	25	32	179	100	123	56	
5200-25T2-06	20.0	25	32	179	100	123	56	
5205-25T2-06	20.5	25	32	184	105	128	56	
5210-25T2-06	21.0	25	32	184	105	128	56	SPMG 07...
5215-25T2-06	21.5	25	32	189	110	133	56	
5220-25T2-07	22.0	25	32	189	110	133	56	
5225-32T2-07	22.5	32	45	200	115	140	60	
5230-32T2-07	23.0	32	45	200	115	140	60	
5235-32T2-07	23.5	32	45	206	120	146	60	
5240-32T2-07	24.0	32	45	206	120	146	60	
5245-32T2-07	24.5	32	45	212	125	152	60	
5250-32T2-07	25.0	32	45	212	125	152	60	
5255-32T2-07	25.5	32	45	217	130	157	60	
5260-32T2-07	26.0	32	45	217	130	157	60	
5265-32T2-07	26.5	32	45	222	135	162	60	
5270-32T2-07	27.0	32	45	222	135	162	60	
5275-32T2-07	27.5	32	45	228	140	168	60	

Indexable drill holder



- Drilling depth: 5x diameter

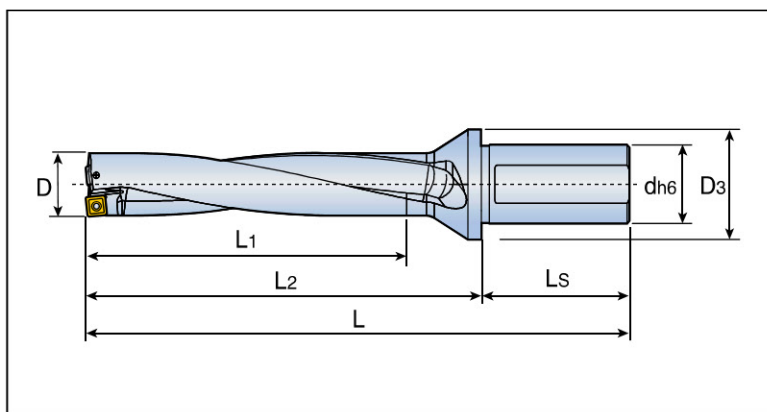
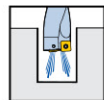


Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
HRG 5280-32T2-09	28.0	32	45	228	140	168	60	SPMG 09...
5285-32T2-09	28.5	32	45	233	145	173	60	
5290-32T2-09	29.0	32	45	233	145	173	60	
5295-32T2-09	29.5	32	55	241	150	181	60	
5300-32T2-09	30.0	32	55	241	150	181	60	
5300-40T2-09	30.0	40	55	251	150	181	70	
5310-32T2-09	31.0	32	55	247	155	187	60	
5310-40T2-09	31.0	40	55	257	155	187	70	
5320-32T2-09	32.0	32	55	252	160	192	60	
5320-40T2-09	32.0	40	55	262	160	192	70	
5330-32T2-09	33.0	32	55	258	165	198	60	
5330-40T2-09	33.0	40	55	268	165	198	70	
5340-32T2-11	34.0	32	55	263	170	203	60	SPMG 11...
5340-40T2-11	34.0	40	55	273	170	203	70	
5350-32T2-11	35.0	32	55	269	175	209	60	
5350-40T2-11	35.0	40	55	279	175	209	70	
5360-32T2-11	36.0	32	55	275	180	215	60	
5360-40T2-11	36.0	40	55	285	180	215	70	
5370-32T2-11	37.0	32	55	281	185	221	60	
5370-40T2-11	37.0	40	55	291	185	221	70	
5380-32T2-11	38.0	32	55	287	190	227	60	
5380-40T2-11	38.0	40	55	297	190	227	70	
5390-32T2-11	39.0	32	55	292	195	232	60	
5390-40T2-11	39.0	40	55	302	195	232	70	
5400-32T2-11	40.0	32	60	298	200	238	60	
5400-40T2-11	40.0	40	60	308	200	238	70	
5410-40T2-11	41.0	40	60	314	205	244	70	

Indexable drill holder



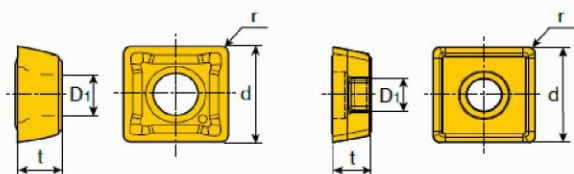
- Drilling depth: 5xdiameter



Designation	Dimension (mm)							Insert
	D	d	D3	L	L1	L2	Ls	
HRG 5420-40T2-14	42.0	40	60	319	210	249	70	SPMG 14...
5430-40T2-14	43.0	40	60	325	215	255	70	
5440-40T2-14	44.0	40	60	330	220	260	70	
5450-40T2-14	45.0	40	60	337	225	267	70	
5460-40T2-14	46.0	40	60	343	230	273	70	
5470-40T2-14	47.0	40	60	348	235	278	70	
5480-40T2-14	48.0	40	60	354	240	284	70	
5490-40T2-14	49.0	40	60	359	245	289	70	
5500-40T2-14	50.0	40	60	365	250	295	70	

Designation	Dimensions (mm)							Insert
	D	d	D3	L	L1	L2	LS	
HRG 5510-40T2-09	51	40	49	355	255	285	70	SPMG09
5520-40T2-09	52	40	49	360	260	290	70	
5530-40T2-09	53	40	49	365	265	295	70	
5540-40T2-09	54	40	49	370	270	300	70	
5550-40T2-09	55	40	49	375	275	305	70	

SPMG INSERT



S.No.	DESIGNATION	GRADE	APPLICATION	SIZE			
				d	t	r	D1
1	SPMG 050204-HM	EC2640	Steel, Cast Iron	5.00	2.38	0.40	2.25
2	SPMG 060204-HM	EC2640	Steel, Cast Iron	6.00	2.38	0.40	2.62
3	SPMG 07T308-HM	EC2640	Steel, Cast Iron	7.94	3.79	0.80	2.85
4	SPMG 090408-HM	EC2640	Steel, Cast Iron	9.80	4.30	0.80	4.05
5	SPMG 110408-HM	EC2640	Steel, Cast Iron	11.50	4.80	0.80	4.45
6	SPMG 120408-HM	EC2640	Steel, Cast Iron	12.70	4.76	0.80	4.37
7	SPMG 140412-HM	EC2640	Steel, Cast Iron	14.30	5.20	1.20	5.75

Recommended Cutting Conditions

Machining data for T-DRILL 2,3,4xD

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	250-350
		>=0.25%C	Annealed	650	190	2	180-250
		<0.55%C	Quenched and tempered	850	250	3	160-220
		>=0.55%C	Annealed	750	220	4	160-220
			Quenched and tempered	1000	300	5	160-220
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	150-220
		Quenched and tempered		930	275	7	120-160
				1000	300	8	120-160
				1200	350	9	120-160
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	140-180
			Quenched and tempered	1100	325	11	130-180
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	170-240	
		Martensitic	820	240	13	170-240	
		Austenitic	600	180	14	170-240	
K	Gray cast iron (GG)	Ferritic		160	15	180-250	
		Pearlitic		250	16	180-250	
	Cast iron nodular (GGG)	Ferritic		180	17	180-250	
		Pearlitic		260	18	180-250	
	Malleable cast iron	Ferritic		130	19	130-200	
		Pearlitic		230	20	130-200	
N	Aluminum - Wrought alloy	Not cureable		60	21	330-380	
		Cured		100	22	330-380	
	Aluminum- cast, alloyed	<=12% Si	Not cureable		75	23	330-380
			Cured		90	24	330-380
	Copper alloys	>12% Si	High temp.		130	25	330-380
		>1% Pb	Free cutting		110	26	150-230
			Brass		90	27	150-230
			Electrolitic copper		100	28	150-230
	Non-metallic	Duroplastics, fiber plastics			29	150-230	
		Hard rubber			30	150-230	
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	30-60
		Ni or Co based	Annealed		250	33	30-60
			Cured		350	34	30-60
			Cast		320	35	30-60
	Titanium, Ti alloys		Rm 400		36	30-60	
		Alpha+beta alloys cured	Rm 1050		37	30-60	
H	Hardened steel	Hardened		55HRC	38	30-60	
		Hardened		60HRC	39	30-60	
	Chilled cast iron	Cast		400	40	30-60	
	Cast iron nodular	Hardened		55HRC	41	30-60	

• For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for T-DRILL 2,3,4xD

Feed (mm/rev) vs. drill diameter Drill length 2,3,4xD					
SPMG 05 Ø13 - Ø15	SPMG 06 Ø16 - Ø21	SPMG 07 Ø22 - Ø27	SPMG 09 Ø28 - Ø33	SPMG 11 Ø34 - Ø41	SPMG 14 Ø42 - Ø50
0.04-0.06	0.04-0.06	0.04-0.08	0.04-0.08	0.06-0.10	0.06-0.12
0.05-0.08	0.06-0.10	0.06-0.12	0.07-0.13	0.08-0.15	0.08-0.16
0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.22	0.12-0.24	0.13-0.25
0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.22	0.12-0.24	0.13-0.25
0.06-0.12	0.08-0.15	0.10-0.18	0.12-0.22	0.12-0.24	0.13-0.25
0.06-0.12	0.08-0.14	0.10-0.18	0.12-0.20	0.12-0.20	0.13-0.20
0.06-0.15	0.06-0.15	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.06-0.15	0.06-0.15	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.06-0.15	0.06-0.15	0.08-0.18	0.08-0.18	0.08-0.18	0.08-0.18
0.06-0.10	0.06-0.10	0.08-0.12	0.08-0.14	0.08-0.14	0.08-0.14
0.06-0.10	0.08-0.12	0.10-0.15	0.12-0.15	0.12-0.18	0.13-0.18
0.05-0.10	0.06-0.12	0.08-0.15	0.09-0.16	0.10-0.17	0.11-0.18
0.05-0.10	0.06-0.12	0.08-0.15	0.09-0.16	0.10-0.17	0.11-0.18
0.05-0.10	0.06-0.12	0.08-0.15	0.09-0.16	0.10-0.17	0.11-0.18
0.06-0.12	0.08-0.16	0.12-0.20	0.15-0.25	0.16-0.28	0.18-0.30
0.06-0.12	0.08-0.16	0.12-0.20	0.15-0.25	0.16-0.28	0.18-0.30
0.06-0.12	0.08-0.16	0.12-0.20	0.15-0.25	0.16-0.28	0.18-0.30
0.06-0.12	0.08-0.16	0.12-0.20	0.15-0.25	0.16-0.28	0.18-0.30
0.06-0.10	0.08-0.15	0.10-0.18	0.12-0.20	0.15-0.23	0.16-0.25
0.06-0.10	0.08-0.15	0.10-0.18	0.12-0.20	0.15-0.23	0.16-0.25
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.14	0.08-0.15	0.10-0.20	0.12-0.22	0.14-0.23	0.15-0.26
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.06-0.13	0.06-0.13	0.08-0.15	0.08-0.15	0.08-0.15	0.08-0.15
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.10	0.06-0.14	0.08-0.18	0.10-0.22	0.14-0.23	0.15-0.24
0.05-0.10	0.06-0.14	0.08-0.18	0.10-0.22	0.14-0.23	0.15-0.24
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10
0.05-0.09	0.05-0.09	0.05-0.10	0.05-0.10	0.05-0.10	0.05-0.10

Recommended Cutting Conditions

Machining data for T-DRILL 5xD

ISO	Material		Condition	Tensile strength (N/mm²)	Hardness HB	Material No.	Cutting speed Vc (m/min)
P	Non-alloy steel, cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	250-350
		>=0.25%C	Annealed	650	190	2	180-250
		<0.55%C	Quenched and tempered	850	250	3	160-220
		>=0.55%C	Annealed	750	220	4	160-220
			Quenched and tempered	1000	300	5	160-220
	Low alloy steel and cast steel (Less than 5% of alloying elements)		Annealed	600	200	6	150-220
		Quenched and tempered		930	275	7	120-160
				1000	300	8	120-160
				1200	350	9	120-160
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	140-180
			Quenched and tempered	1100	325	11	130-180
M	Stainless steel and cast steel	Ferritic / martensitic	680	200	12	170-240	
		Martensitic	820	240	13	170-240	
		Austenitic	600	180	14	170-240	
K	Gray cast iron (GG)	Ferritic		160	15	180-250	
		Pearlitic		250	16	180-250	
	Cast iron nodular (GGG)	Ferritic		180	17	180-250	
		Pearlitic		260	18	180-250	
	Malleable cast iron	Ferritic		130	19	130-200	
		Pearlitic		230	20	130-200	
N	Aluminum - Wrought alloy	Not cureable		60	21	330-380	
		Cured		100	22	330-380	
	Aluminum- cast, alloyed	<=12% Si	Not cureable		75	23	330-380
			Cured		90	24	330-380
	>12% Si	High temp.		130	25	330-380	
		>1% Pb	Free cutting		110	26	150-230
			Brass		90	27	150-230
			Electrolitic copper		100	28	150-230
	Non-metallic	Duroplastics, fiber plastics			29	150-230	
		Hard rubber			30	150-230	
S	High temp. alloys	Fe based	Annealed		200	31	30-60
			Cured		280	32	30-60
		Ni or Co based	Annealed		250	33	30-60
			Cured		350	34	30-60
			Cast		320	35	30-60
	Titanium, Ti alloys		Rm 400		36	30-60	
		Alpha+beta alloys cured	Rm 1050		37	30-60	
H	Hardened steel	Hardened		55HRC	38	30-60	
		Hardened		60HRC	39	30-60	
	Chilled cast iron	Cast		400	40	30-60	
	Cast iron nodular	Hardened		55HRC	41	30-60	

• For more information of material groups, see the materials & grades "material conversion table"

■ Steel
 ■ Stainless steel
 ■ Cast iron
 ■ Nonferrous
 ■ High temp. alloys
 ■ Hardened steel

Recommended Cutting Conditions



Machining data for T-DRILL 5xD

Feed (mm/rev) vs. drill diameter Drill length 5xD					
SPMG 05 Ø13 - Ø15	SPMG 06 Ø16 - Ø21	SPMG 07 Ø22 - Ø27	SPMG 09 Ø28 - Ø33	SPMG 11 Ø34 - Ø41	SPMG 14 Ø42 - Ø50
0.04-0.05	0.04-0.05	0.04-0.06	0.04-0.07	0.06-0.08	0.06-0.10
0.06-0.08	0.06-0.08	0.06-0.10	0.07-0.12	0.08-0.13	0.08-0.14
0.06-0.10	0.08-0.13	0.10-0.16	0.12-0.20	0.12-0.22	0.13-0.23
0.06-0.10	0.08-0.13	0.10-0.16	0.12-0.20	0.12-0.22	0.13-0.23
0.06-0.10	0.08-0.13	0.10-0.16	0.12-0.20	0.12-0.22	0.13-0.23
0.06-0.10	0.08-0.12	0.10-0.16	0.12-0.18	0.12-0.18	0.13-0.18
0.06-0.12	0.06-0.13	0.08-0.16	0.08-0.16	0.08-0.17	0.08-0.17
0.06-0.12	0.06-0.13	0.08-0.16	0.08-0.16	0.08-0.17	0.08-0.17
0.06-0.12	0.06-0.13	0.08-0.16	0.08-0.16	0.08-0.17	0.08-0.17
0.06-0.08	0.06-0.08	0.08-0.10	0.08-0.12	0.08-0.12	0.08-0.12
0.06-0.09	0.08-0.10	0.10-0.13	0.12-0.13	0.12-0.15	0.12-0.16
0.05-0.09	0.06-0.10	0.08-0.13	0.09-0.15	0.10-0.15	0.10-0.17
0.05-0.09	0.06-0.10	0.08-0.13	0.09-0.15	0.10-0.15	0.10-0.17
0.05-0.09	0.06-0.10	0.08-0.13	0.09-0.15	0.10-0.15	0.10-0.17
0.06-0.10	0.08-0.15	0.12-0.18	0.15-0.22	0.16-0.25	0.18-0.28
0.06-0.10	0.08-0.15	0.12-0.18	0.15-0.22	0.16-0.25	0.18-0.28
0.06-0.10	0.08-0.15	0.12-0.18	0.15-0.22	0.16-0.25	0.18-0.28
0.06-0.10	0.08-0.15	0.12-0.18	0.15-0.22	0.16-0.25	0.18-0.28
0.06-0.08	0.08-0.12	0.10-0.16	0.12-0.18	0.15-0.22	0.16-0.23
0.06-0.08	0.08-0.12	0.10-0.16	0.12-0.18	0.15-0.22	0.16-0.23
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.08-0.15	0.10-0.13	0.12-0.18	0.14-0.20	0.14-0.24
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.06-0.12	0.06-0.12	0.08-0.13	0.08-0.13	0.08-0.14	0.08-0.14
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.07	0.05-0.07	0.05-0.08	0.05-0.08	0.05-0.08	0.05-0.08
0.05-0.09	0.08-0.13	0.08-0.17	0.10-0.20	0.14-0.22	0.14-0.24
0.05-0.09	0.08-0.13	0.08-0.17	0.10-0.20	0.14-0.22	0.14-0.24
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09
0.05-0.08	0.05-0.08	0.05-0.09	0.05-0.09	0.05-0.09	0.05-0.09

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