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NEW PRODUCT NEWS

CHAMFERING RING DIAMETER EXPANSION

expansion

TaeguTec
Member IMC Group

Chamfering Ring Diameter Expansion

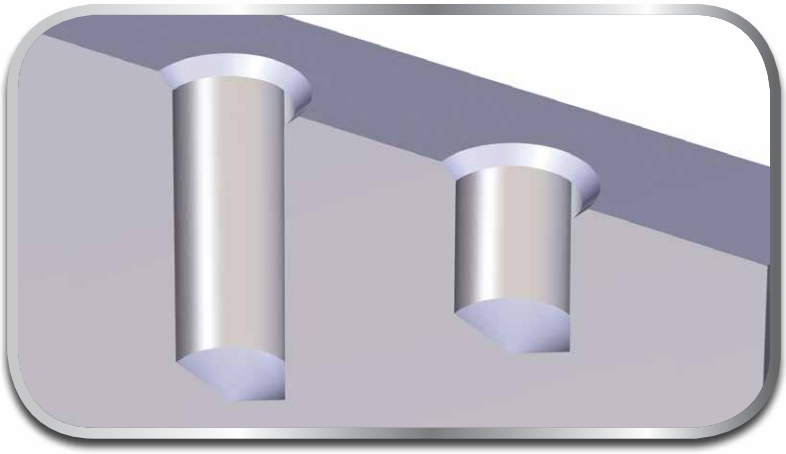
TaeguTec's chamfering ring – known for excellent performance and high productivity – is being expanded to meet the increasing demands of customers.

The chamfering ring diameters have been expanded for drills ranging from 10.0mm to 25.9mm. The expanded range offers the same remarkable machining performance on all kinds of materials.

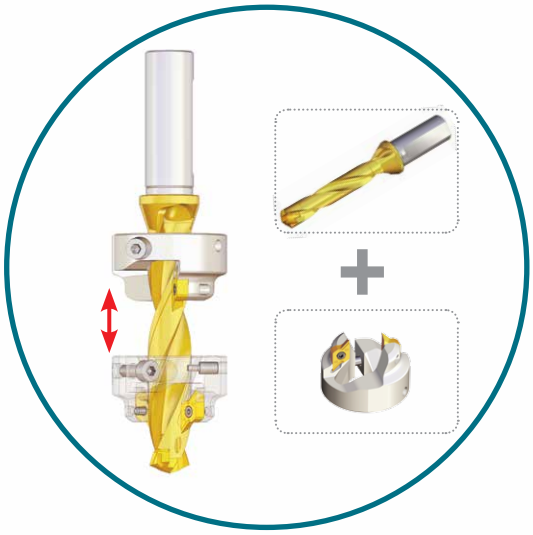
FEATURES

- **Available drill range using expanded chamfering ring : Diameter 10.0mm ~ 13.9mm**
  : Diameter 21.0mm ~ 25.9mm
- **Minimized cycle time credit to drilling and chamfering in a single operation for improved economy**
- **Compatible with : standard DRILLRUSH bodies**
  : TOPDRILL & T-DRILL bodies (recommended for 3xD, 4xD)
- **Easy to use adjustable step length**
- **Two standard chamfering inserts for excellent performance and high productivity in a wider range of diameters**
- **Rigid clamping system for stable chamfering**

The solutions for drilling and chamfering in one operation

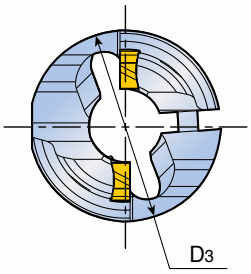


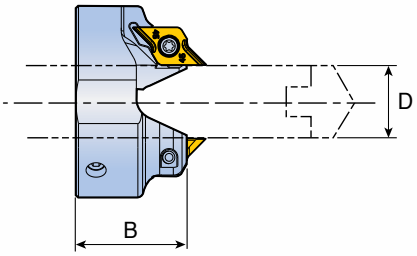
Adjustable step length designed
for use with **standard items**



Select **tailor-made** solid carbide drill
according to step length

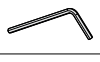
Chamfering ring





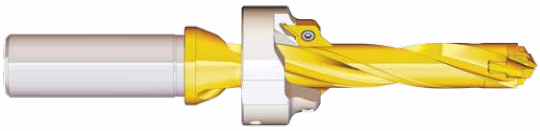
Designation	Dimension (mm)			Chamfer size	Chamfer insert
	D	D3	B		
CFR D100-A45 new	10.0	34	20	3	CRNG 0802-45CD
D105-A45 new	10.5	34	20	3	
D110-A45 new	11.0	34	20	3	
D115-A45 new	11.5	34	20	3	
D120-A45 new	12.0	34	20	3	
D125-A45 new	12.5	34	20	3	
D130-A45 new	13.0	34	20	3	
D135-A45 new	13.5	34	20	3	
D140-A45	14.0	38	22	3	
D145-A45 new	14.5	38	22	3	
D150-A45	15.0	38	22	3	
D160-A45	16.0	42	23	3	
D170-A45	17.0	42	23	3	
D180-A45	18.0	42	23	3	
D190-A45	19.0	42	24	3	
D200-A45	20.0	42	24	3	
D210-A45 new	21.0	47	24	3	
D220-A45 new	22.0	47	24	3	
D230-A45 new	23.0	47	24	3	
D240-A45 new	24.0	47	24	3	
D250-A45 new	25.0	47	24	3	

Spare parts

Designation	Insert screw	Wrench	Clamping screw	L-wrench
				
CFR D100 - D135	SO 25065I	TD 7	SH M3x0.5x10 (1)	L-W2.5
CFR D140 - D150	SO 25065I	TD 7	SH M4x0.7x12 (2)	L-W3
CFR D160 - D250	SO 25065I	TD 7	SH M5x0.8x16 (3)	L-W4

(1)Clamping torque: 2-3 [N•m] (2)Clamping torque: 3.5-4.5 [N•m] (3)Clamping torque: 5-6 [N•m]

Assembly

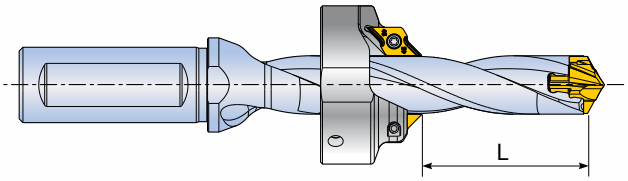


(Recommended for TOPDRILL & T-DRILL in 3xD, 4xD)

DRILLRUSH	
Diameter range	CFR designation
10.0-10.4	CFR D100-A45
10.5-10.9	CFR D105-A45
11.0-11.4	CFR D110-A45
11.5-11.9	CFR D115-A45
12.0-12.4	CFR D120-A45
12.5-12.9	CFR D125-A45
13.0-13.4	CFR D130-A45
13.5-13.9	CFR D135-A45
14.0-14.4	CFR D140-A45
14.5-14.9	CFR D145-A45
15.0-15.9	CFR D150-A45
16.0-16.9	CFR D160-A45
17.0-17.9	CFR D170-A45
18.0-18.9	CFR D180-A45
19.0-19.9	CFR D190-A45
20.0-20.9	CFR D200-A45
21.0-21.9	CFR D210-A45
22.0-22.9	CFR D220-A45
23.0-23.9	CFR D230-A45
24.0-24.9	CFR D240-A45
25.0-25.9	CFR D250-A45

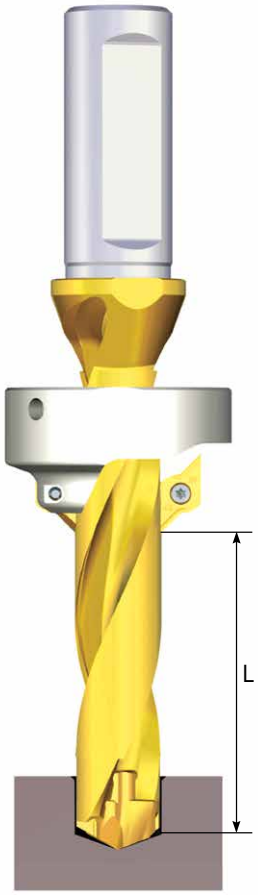
TOPDRILL & T-DRILL	
Diameter range	CFR designation
-	-
-	-
-	-
-	-
-	-
12.5-12.9	CFR D125-A45
13.0-13.4	CFR D130-A45
13.5-13.9	CFR D135-A45
14.0-14.4	CFR D140-A45
14.5-14.9	CFR D145-A45
15.0-15.4	CFR D150-A45
15.5-16.4	CFR D160-A45
16.5-17.4	CFR D170-A45
17.5-18.5	CFR D180-A45
18.6-19.5	CFR D190-A45
19.6-20.5	CFR D200-A45
20.6-21.5	CFR D210-A45
21.6-22.5	CFR D220-A45
22.6-23.5	CFR D230-A45
23.6-24.5	CFR D240-A45
24.6-25.5	CFR D250-A45

DRILLRUSH

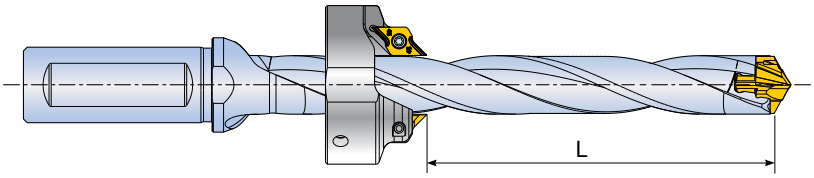


Recommended step length

	Designation	CFR designation	L	
			min	max
3D	TCD 130-134-16T3/S0-3D	CFR D130-A45	19	19
	135-139-16T3/S0-3D	CFR D135-A45	19	20
	140-144-16T3/S0-3D	CFR D140-A45	21	22
	145-149-16T3/S0-3D	CFR D145-A45	22	23
	150-159-20T3/S0-3D	CFR D150-A45	23	23
	160-169-20T3/S0-3D	CFR D160-A45	24	25
	170-179-20T3/S0-3D	CFR D170-A45	26	28
	180-189-25T2/S0-3D	CFR D180-A45	27	30
	190-199-25T2/S0-3D	CFR D190-A45	29	33
	200-209-25T2/S0-3D	CFR D200-A45	30	36
	210-219-25T2/S0-3D	CFR D210-A45	32	39
	220-229-25T2/S0-3D	CFR D220-A45	33	42
	230-239-32T2/S0-3D	CFR D230-A45	35	45
	240-249-32T2/S0-3D	CFR D240-A45	36	48
	250-259-32T2/S0-3D	CFR D250-A45	38	51
5D	TCD 100-104-16T3/S0-5D	CFR D100-A45	28	28
	105-109-16T3/S0-5D	CFR D105-A45	29	30
	110-114-16T3/S0-5D	CFR D110-A45	31	33
	115-119-16T3/S0-5D	CFR D115-A45	32	35
	120-124-16T3/S0-5D	CFR D120-A45	33	45
	125-129-16T3/S0-5D	CFR D125-A45	34	40
	130-134-16T3/S0-5D	CFR D130-A45	36	43
	135-139-16T3/S0-5D	CFR D135-A45	37	43
	140-144-16T3/S0-5D	CFR D140-A45	38	48
	145-149-16T3/S0-5D	CFR D145-A45	39	48
	150-159-20T3/S0-5D	CFR D150-A45	41	53
	160-169-20T3/S0-5D	CFR D160-A45	43	58
	170-179-20T3/S0-5D	CFR D170-A45	46	63
	180-189-25T2/S0-5D	CFR D180-A45	48	68
	190-199-25T2/S0-5D	CFR D190-A45	51	73
	200-209-25T2/S0-5D	CFR D200-A45	53	78
	210-219-25T2/S0-5D	CFR D210-A45	56	79
	220-229-25T2/S0-5D	CFR D220-A45	58	84
	230-239-32T2/S0-5D	CFR D230-A45	61	89
	240-249-32T2/S0-5D	CFR D240-A45	63	94
	250-259-32T2/S0-5D	CFR D250-A45	66	99

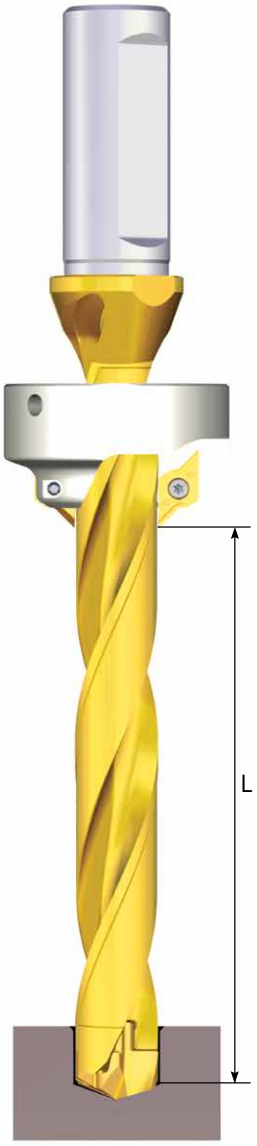


DRILLRUSH

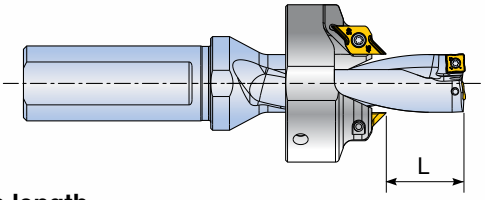


Recommended step length

	Designation	CFR designation	L	
			min	max
8D	TCD 100-104-16T3/S0-8D	CFR D100-A45	45	58
	105-109-16T3/S0-8D	CFR D105-A45	49	62
	110-114-16T3/S0-8D	CFR D110-A45	49	66
	115-119-16T3/S0-8D	CFR D115-A45	53	70
	120-124-16T3/S0-8D	CFR D120-A45	53	74
	125-129-16T3/S0-8D	CFR D125-A45	57	78
	130-134-16T3/S0-8D	CFR D130-A45	57	82
	135-139-16T3/S0-8D	CFR D135-A45	61	84
	140-144-16T3/S0-8D	CFR D140-A45	61	88
	145-149-16T3/S0-8D	CFR D145-A45	65	92
	150-159-20T3/S0-8D	CFR D150-A45	65	96
	160-169-20T3/S0-8D	CFR D160-A45	69	103
	170-179-20T3/S0-8D	CFR D170-A45	73	111
	180-189-25T2/S0-8D	CFR D180-A45	77	118
	190-199-25T2/S0-8D	CFR D190-A45	81	126
	200-209-25T2/S0-8D	CFR D200-A45	85	134
	210-219-25T2/S0-8D	CFR D210-A45	89	142
	220-229-25T2/S0-8D	CFR D220-A45	93	150
	230-239-32T2/S0-8D	CFR D230-A45	97	158
	240-249-32T2/S0-8D	CFR D240-A45	101	166
	250-259-32T2/S0-8D	CFR D250-A45	105	174
12D	TCD 120-124-16S0-12D	CFR D120-A45	87	121
	125-129-16S0-12D	CFR D125-A45	90	127
	130-134-16S0-12D	CFR D130-A45	93	133
	135-139-16S0-12D	CFR D135-A45	96	137
	140-144-16S0-12D	CFR D140-A45	99	143
	145-149-16S0-12D	CFR D145-A45	102	149
	150-159-20S0-12D	CFR D150-A45	105	155
	160-169-20S0-12D	CFR D160-A45	111	166
	170-179-20S0-12D	CFR D170-A45	117	178
	180-189-25S0-12D	CFR D180-A45	123	189
	190-199-25S0-12D	CFR D190-A45	129	201
	200-209-25S0-12D	CFR D200-A45	135	213
	210-219-25S0-12D	CFR D210-A45	141	225
	220-229-25S0-12D	CFR D220-A45	147	237



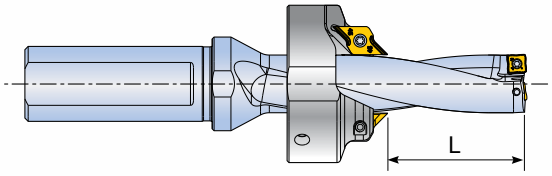
TOPDRILL and T-DRILL



Recommended step length

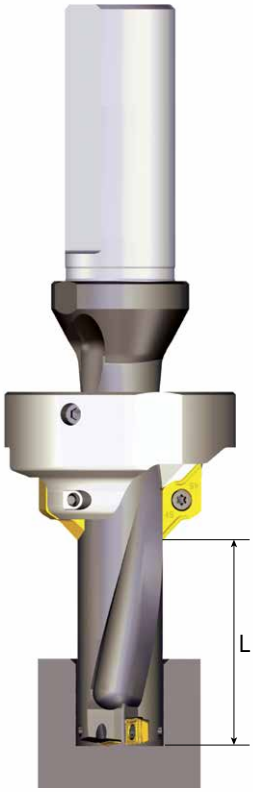
	TOPDRILL		T-DRILL		CFR designation	L	
						min	max
3D	TOP	-	TDR	3125-20T2-05	CFR D125-A45	16	16
		-		3130-20T2-05	CFR D130-A45	16	16
		-		3135-20T2-05	CFR D135-A45	17	18
		3140-20T2-05		3140-20T2-05	CFR D140-A45	17	18
		3145-20T2-05		3145-20T2-05	CFR D145-A45	18	19
		3150-20T2-05		3150-20T2-05	CFR D150-A45	18	19
		3155-20T2-05		3155-25T2-06	CFR D160-A45	19	21
		3160-20T2-05		3160-25T2-06	CFR D160-A45	19	21
		3165-25T2-06		3165-25T2-06	CFR D170-A45	21	24
		3170-25T2-06		3170-25T2-06	CFR D170-A45	22	24
		3175-25T2-06		3175-25T2-06	CFR D180-A45	23	27
		3180-25T2-06		3180-25T2-06	CFR D180-A45	23	26
		3185-25T2-06		3185-25T2-06	CFR D180-A45	24	29
		3190-25T2-06		3190-25T2-06	CFR D190-A45	25	29
		3195-25T2-07		3195-25T2-06	CFR D190-A45	25	32
		3200-25T2-07		3200-25T2-06	CFR D200-A45	26	32
		3205-25T2-07		3205-25T2-06	CFR D200-A45	27	35
		3210-25T2-07		3210-25T2-06	CFR D210-A45	27	35
		3215-25T2-07		3215-25T2-07	CFR D210-A45	28	38
		3220-25T2-07		3220-25T2-07	CFR D220-A45	29	38
		3225-25T2-08		3225-25T2-07	CFR D220-A45	29	41
		3230-25T2-08		3230-25T2-07	CFR D230-A45	30	41
		3235-25T2-08		3235-25T2-07	CFR D230-A45	31	44
		3240-25T2-08		3240-25T2-07	CFR D240-A45	31	44
		3245-25T2-08		3245-25T2-07	CFR D240-A45	32	47
		3250-25T2-08		3250-25T2-07	CFR D250-A45	33	47

TOPDRILL and T-DRILL

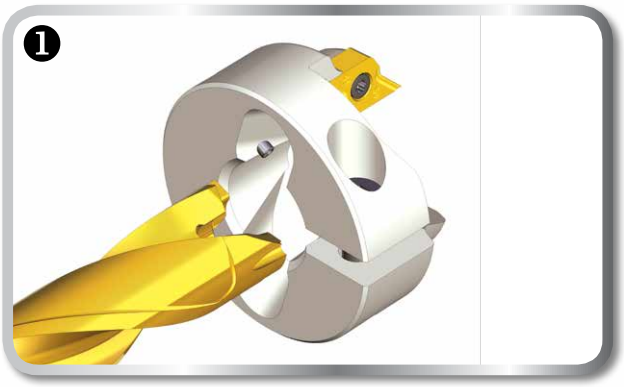


Recommended step length

	TOPDRILL	T-DRILL	CFR designation	L	
				min	max
4D	TOP -	TDR 4125-20T2-05	CFR D125-A45	25	26
	-	4130-20T2-05	CFR D130-A45	25	26
	-	4135-20T2-05	CFR D135-A45	27	30
	4140-20T2-05	4140-20T2-05	CFR D140-A45	28	30
	4145-20T2-05	4145-20T2-05	CFR D145-A45	29	34
	4150-20T2-05	4150-20T2-05	CFR D150-A45	30	34
	4155-20T2-05	4155-25T2-06	CFR D160-A45	31	37
	4160-20T2-05	4160-25T2-06	CFR D160-A45	32	37
	4165-25T2-06	4165-25T2-06	CFR D170-A45	33	41
	4170-25T2-06	4170-25T2-06	CFR D170-A45	34	41
	4175-25T2-06	4175-25T2-06	CFR D180-A45	35	45
	4180-25T2-06	4180-25T2-06	CFR D180-A45	36	44
	4185-25T2-06	4185-25T2-06	CFR D180-A45	37	48
	4190-25T2-06	4190-25T2-06	CFR D190-A45	38	48
	4195-25T2-07	4195-25T2-06	CFR D190-A45	39	52
	4200-25T2-07	4200-25T2-06	CFR D200-A45	40	52
	4205-25T2-07	4205-25T2-06	CFR D200-A45	41	56
	4210-25T2-07	4210-25T2-06	CFR D210-A45	42	56
	4215-25T2-07	4215-25T2-07	CFR D210-A45	43	60
	4220-25T2-07	4220-25T2-07	CFR D220-A45	44	60
	4225-25T2-08	4225-25T2-07	CFR D220-A45	45	64
	4230-25T2-08	4230-25T2-07	CFR D230-A45	46	64
	4235-25T2-08	4235-25T2-07	CFR D230-A45	47	68
	4240-25T2-08	4240-25T2-07	CFR D240-A45	48	68
	4245-25T2-08	4245-25T2-07	CFR D240-A45	49	72
	4250-25T2-08	4250-25T2-07	CFR D250-A45	50	72

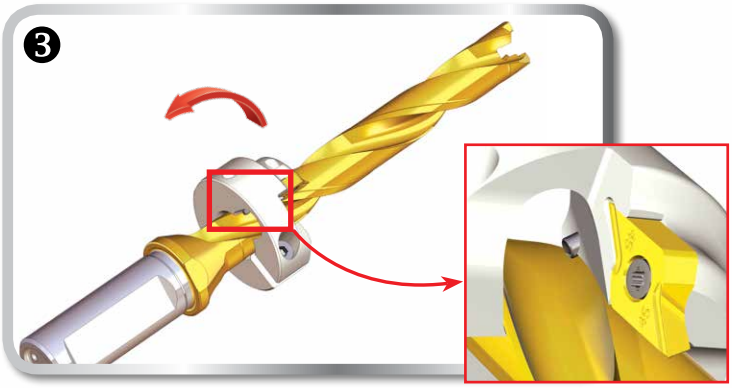


Assembly of chamfering ring

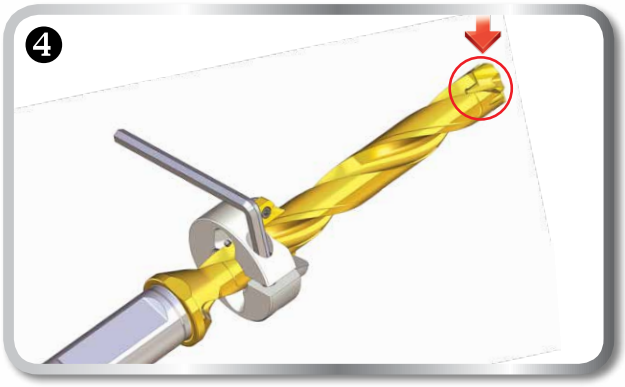


1. Insert the chamfering ring on to the drill body. The stopper must be inside the flute.

2. Slide the chamfering ring to the desired position.

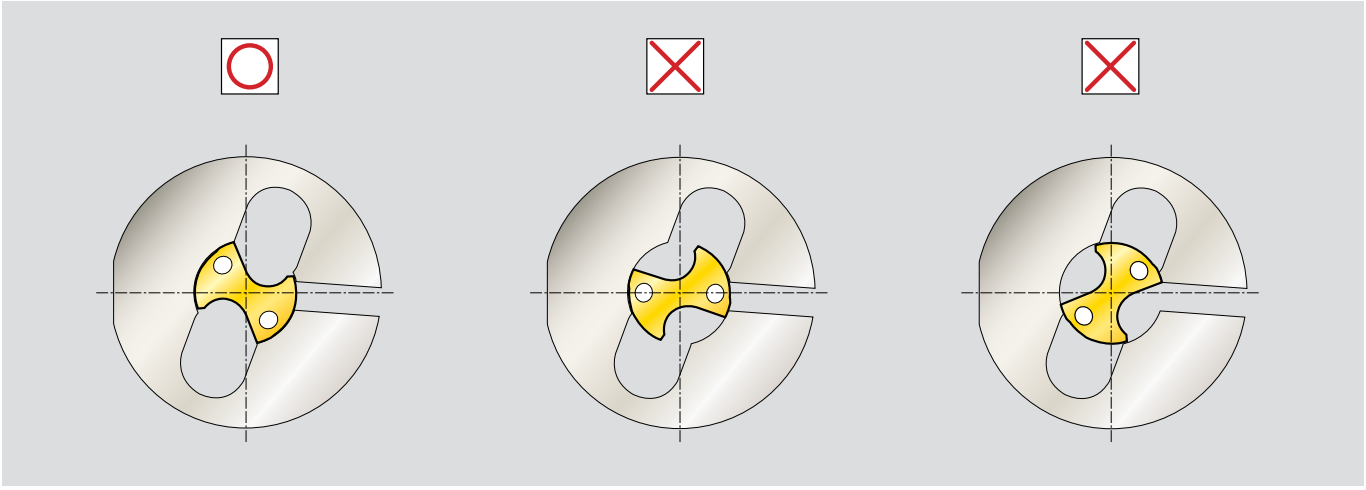


3. Rotate the chamfering ring counterclockwise until stopper engages the flute edge.

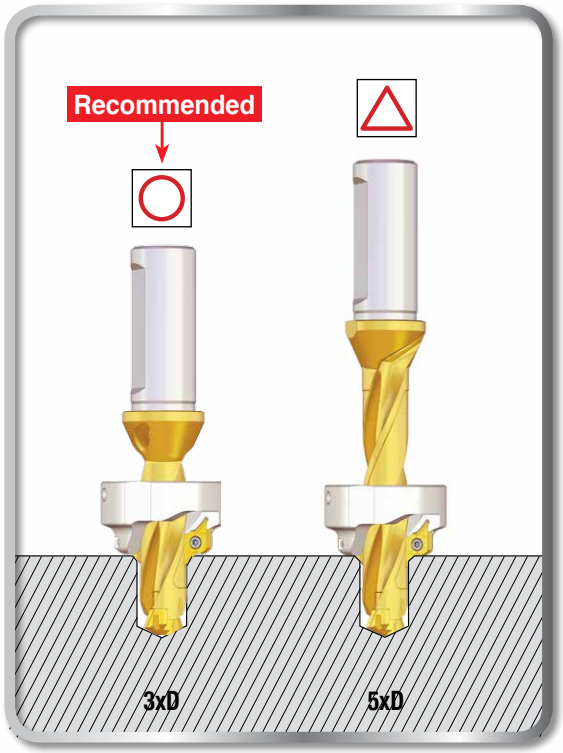


4. Tighten the chamfering ring and clamp the drill head.

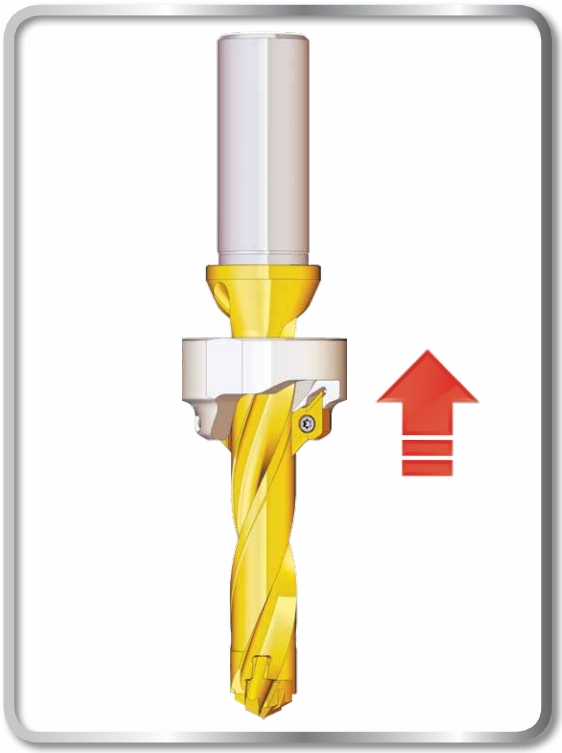
For correct clamping of the chamfering ring, the drill flute should be aligned with the chamfering ring flute.



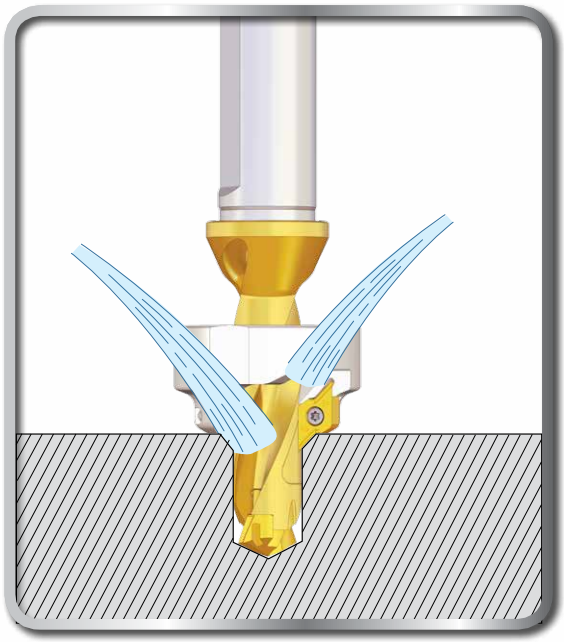
Recommendations for stable machining



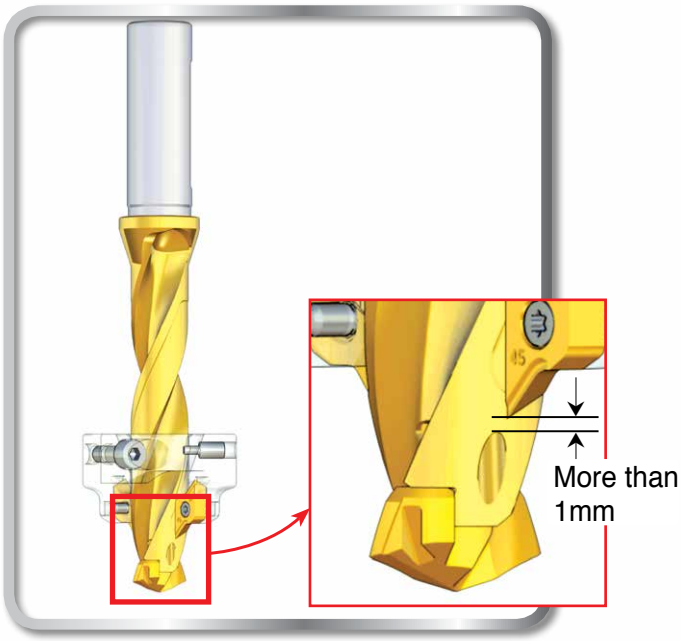
1. If possible, always use a short holder. If not, reduce the cutting speed to minimize vibration.



2. Mount the chamfering ring as close as possible to the drill shank when drilling a through hole.

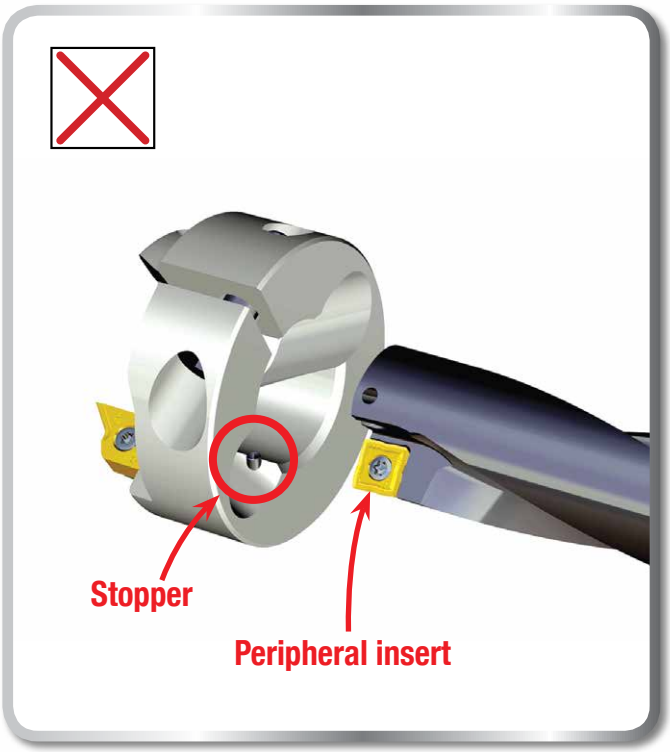


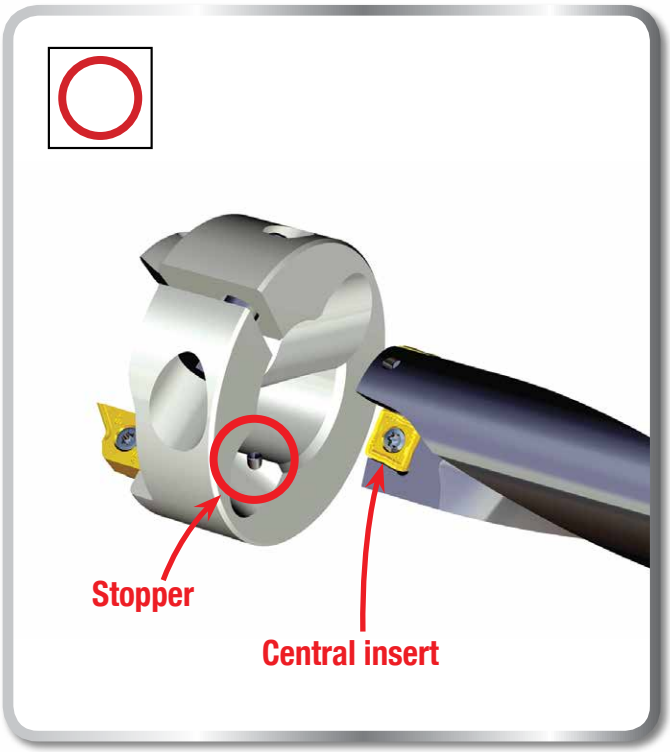
3. For better insert life, apply external and internal coolant to the insert.



4. When mounting the chamfering ring, please ensure that it does not block the coolant.

User guide - Assembly with indexable drill





Position the stopper by following it to the Central insert pocket