PRODUCT NEWS

PN-E-007

SERIES EXPANSION

TEZDF-XXL type (holder)

DIJET

Indexable drill

TEZD type

reich ADVANCED TECHNOLOGY TOOLS Wir verändern.

- TEZDF-MS type (L/D=3): Ø13.5 – Ø32.5
- TEZDF-ML type (L/D=5): Ø13.5 – Ø32.5
- TEZDF-XL type (L/D=8): Ø13.5 – Ø32.5
- TEZDF-XXL type (L/D=12): Ø13.5 – Ø23.5
- TEZD-M type (Modular Head): Ø13.5 – Ø32.5

Drilling

"Indexable drill TEZD type" achieves easy assembly and high cutting performance.

DIJET GmbH

www.dijet.de

The rigid clamping system and highly rigid body ensure stable machining. The unique coolant supply system provides efficient cooling and chip evacuation.

Feature 1

Drill Body Variations

L/D=3
Ø13.5–32.5

L/D=5
Ø13.5–32.5

L/D=8
Ø13.5–32.5

NEW

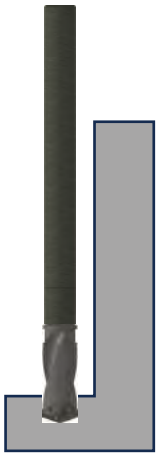
L/D=12
Ø13.5–23.5

Modular Head
L/D=2
Ø13.5–32.5

carbide modular head holder MSN type

Feature 2 **TEZD-M (Modular head) type**

The combination of a modular head and a carbide shank holder enables stable drilling even with a long overhang.



Feature 3

The high-rigidity flanged shank body ensures stable and accurate hole making.

Conventional model

Hole Dia : Ø17.013

TEZDF-ML type

Hole Dia : Ø17.005

Improved chip formation and hole accuracy!

P

dia : Ø17
tool : TEZD1700S20F-ML
material : SS400
Vc : 75 m/min
f : 0.15 mm/rev

Feature 4

Available in three insert types

TEZ type - General purpose

P M K

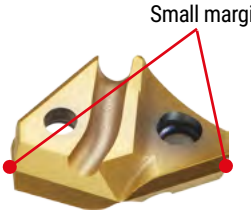
Ø13.5–32.5

- PVD coating grade "**JC8050**"
- Suitable for all types of materials.

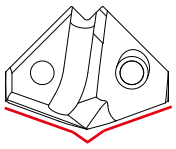
TEZ-S type - For Stainless Steel and Titanium Alloys

P M K S

Ø13.5–20.5



- PVD coating grade "**JC7515**"
  (for high thermal crack and oxidation resistance)
- Small margins reduce cutting heat generated.
- Improved centripetal centering geometry
  for smooth drilling and good chip evacuation.
- First choice for stainless steels and titanium alloys.



Centripetal centering geometry

Competitor C | **TEZ type** | **TEZ-S type**

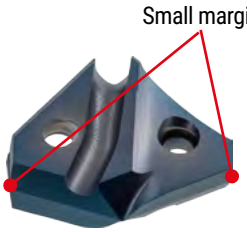
Rifle mark

Good surface finish

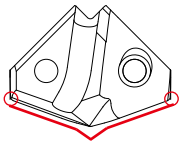
TEZ-H type - For Mold Steel and Hardened Steel (up to 52 HRC)

H

Ø13.5–20.5



- PVD coating grade "**DH115**"
  (for high hardness and heat resistance)
- Small margins reduce cutting heat generated.
- Optimized tip and corner geometry for hardened materials.
- Strong drill corner edges prevent chipping.



Optimized Tip and Corner geometry
for hardened materials

TEZ-H type

Competitor

dia : Ø16
insert : TEZ-1600H
grade : DH115
material : NAK80(40HRC)
Vc : 50 m/min
f : 0.2 mm/rev

PROCEDURE FOR MOUNTING INSERT

1. Removing the Used Insert

Before removing the used insert, remove any chips or dust from the drill tip. Remove the used insert, then clean the insert pocket with a brush or compressed air before mounting the new insert.

2. Mounting the New Insert

Place the new insert in the pocket and lightly tighten both screws while pressing down on the top of the insert (see photo). After confirming there is no gap between the drill body and the insert, tighten both screws to the recommended torque, starting with the screw that was lightly tightened first, while continuing to press down on the top of the insert.

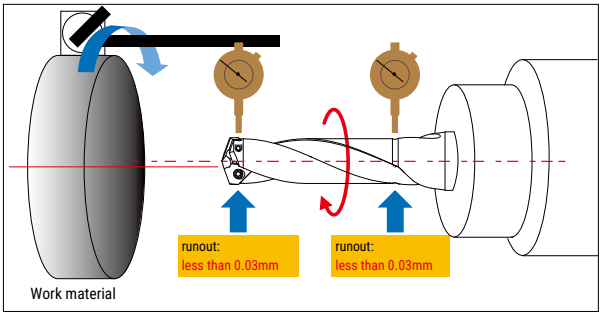
Note:

Replace the clamp screw after approximately every 10 insert replacements, or immediately if any damage or wear is observed.

Clamp screw

WHEN USING A LATHE

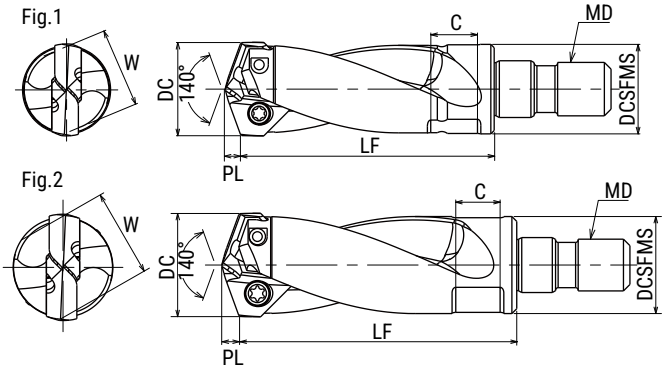
1. Check that the insert O.D. runout is within 0.03 mm (center offset: 0.015 mm) and that the shank flute O.D. runout is within approx. 0.03 mm.
2. Due to the high thrust cutting forces, make sure the drill is fully seated in the holder.
3. Reduce the cutting speed and feed rate by 20% from the standard cutting conditions.



TEZD-M TYPE

Modular Type

Through coolant hole | 2D L/D | Drilling



Cat.No.	Stock	DC		Dimensions (mm)						Fig.	Parts	
		Min.	Max.	LF	PL	DCSFMS	MD	C	W		Screw	Wrench
TEZD1400-M8	●	13.5	14.5	38.0	2.3	13.4	M8	8	12	1	DSW-2045H	A-07
TEZD1500-M8	●	14.6	15.5	40.5	2.4	14.0	M8	8	12	2		
TEZD1600-M8	●	15.6	16.5	43.0	2.6	15.0	M8	8	12	2	TSW-2556H	A-08
TEZD1700-M8	●	16.6	17.5	45.5	2.7	16.0	M8	8	12	2		
TEZD1800-M8	●	17.6	18.5	48.0	2.9	17.0	M8	8	12	2		
TEZD1900-M10	●	18.6	19.5	50.5	3.1	18.0	M10	9	14	2	TSW-2567H	A-08
TEZD2000-M10	●	19.6	20.5	53.0	3.2	19.0	M10	9	14	2		
TEZD2100-M10	●	20.6	21.5	55.5	3.4	20.0	M10	9	14	2		
TEZD2200-M10	●	21.6	22.5	58.0	3.5	21.0	M10	9	14	2	DSW-307H	A-10
TEZD2300-M10	●	22.6	23.5	60.5	3.7	22.0	M10	9	14	2		
TEZD2400-M12	●	23.6	24.5	63.0	3.9	23.0	M12	11	19	2		
TEZD2500-M12	●	24.6	25.5	65.5	4.0	24.0	M12	11	19	2	DSW-309H	A-10
TEZD2600-M12	●	25.6	26.5	68.0	4.2	25.0	M12	11	19	2		
TEZD2700-M12	●	26.6	27.5	70.5	4.4	26.0	M12	11	19	2		
TEZD2800-M12	●	27.6	28.5	73.0	4.5	27.0	M12	11	19	2	TSW-3510H	A-15
TEZD2900-M16	●	28.6	29.5	75.5	4.7	28.0	M16	12	22	2		
TEZD3000-M16	●	29.6	30.5	78.0	4.8	29.0	M16	12	22	2		
TEZD3100-M16	●	30.6	31.5	80.5	5.0	30.0	M16	12	22	2	TSW-3512H	A-15
TEZD3200-M16	●	31.6	32.5	83.0	5.2	31.0	M16	14	26	2		

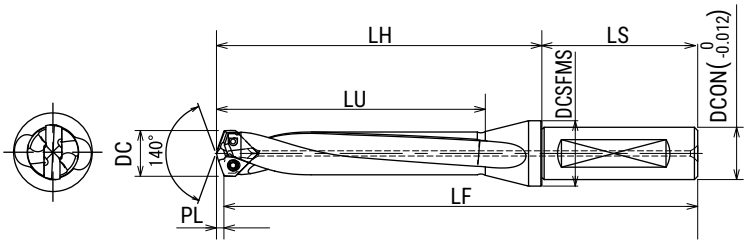
Note: All drill bodies are supplied without inserts, wrenches, or MOLY.

● : Stocked Items

Clamp screw	Torque(N·m)
DSW-2045H	0.9
TSW-2556H	1.2
TSW-2567H	1.2
DSW-307H	2.1
DSW-309H	2.1
TSW-3510H	3.0
TSW-3512H	3.0

Through coolant hole | 3D L/D | Drilling

TEZDF-MS TYPE Holder



Cat.No.	Stock	DC		Dimensions (mm)							Parts	
		Min.	Max.	LU	LH	LS	LF	PL	DCON	DCSFMS	Screw	Wrench
TEZD1400S16F-MS	●	13.5	14.5	53.5	67.5	48	113	2.3	16	20.0	DSW-2045H	A-07
TEZD1500S20F-MS	●	14.6	15.5	56.7	71.7	50	119	2.4	20	24.9		
TEZD1600S20F-MS	●	15.6	16.5	60.9	76.9	50	124	2.6	20	24.9	TSW-2556H	A-08
TEZD1700S20F-MS	●	16.6	17.5	64.1	81.1	50	128	2.7	20	24.9		
TEZD1800S20F-MS	●	17.6	18.5	68.3	86.3	50	133	2.9	20	24.9		
TEZD1900S25F-MS	●	18.6	19.5	71.5	90.5	56	143	3.1	25	32.0	TSW-2567H	A-08
TEZD2000S25F-MS	●	19.6	20.5	75.6	95.6	56	148	3.2	25	32.0		
TEZD2100S25F-MS	●	20.6	21.5	78.8	99.8	56	152	3.4	25	32.0		
TEZD2200S25F-MS	●	21.6	22.5	83.0	105.0	56	157	3.5	25	32.0	DSW-307H	A-10
TEZD2300S25F-MS	●	22.6	23.5	86.2	109.2	56	161	3.7	25	32.0		
TEZD2400S32F-MS	●	23.6	24.5	90.4	114.4	60	170	3.9	32	41.9		
TEZD2500S32F-MS	●	24.6	25.5	93.5	118.5	60	174	4.0	32	41.9	DSW-309H	A-10
TEZD2600S32F-MS	●	25.6	26.5	97.7	123.7	60	179	4.2	32	41.9		
TEZD2700S32F-MS	●	26.6	27.5	100.9	127.9	60	183	4.4	32	41.9		
TEZD2800S32F-MS	●	27.6	28.5	105.1	133.1	60	188	4.5	32	41.9	TSW-3510H	A-15
TEZD2900S32F-MS	●	28.6	29.5	108.3	137.3	60	192	4.7	32	41.9		
TEZD3000S32F-MS	●	29.6	30.5	112.5	142.5	60	197	4.8	32	41.9		
TEZD3100S32F-MS	●	30.6	31.5	115.7	146.7	60	201	5.0	32	41.9	TSW-3512H	A-15
TEZD3200S32F-MS	●	31.6	32.5	119.8	151.8	60	206	5.2	32	41.9		

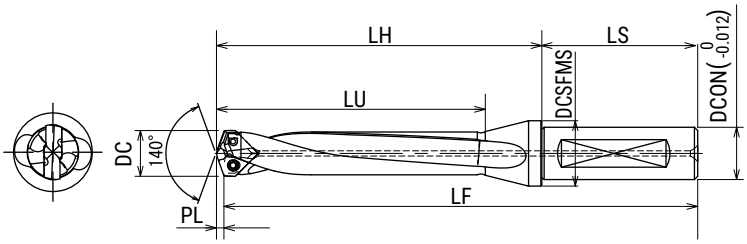
Note: All drill bodies are supplied without inserts, wrenches, or MOLY.

● : Stocked Items

Clamp screw	Torque(N·m)
DSW-2045H	0.9
TSW-2556H	1.2
TSW-2567H	1.2
DSW-307H	2.1
DSW-309H	2.1
TSW-3510H	3.0
TSW-3512H	3.0

Through coolant hole | 5D L/D | Drilling

TEZDF-ML TYPE Holder



Cat.No.	Stock	DC		Dimensions (mm)							Parts	
		Min.	Max.	LU	LH	LS	LF	PL	DCON	DCSFMS	Screw	Wrench
TEZD1400S16F-ML	●	13.5	14.5	82.5	99.5	48	145	2.3	16	20.0	DSW-2045H	A-07
TEZD1500S20F-ML	●	14.6	15.5	87.7	105.7	50	153	2.4	20	24.9		
TEZD1600S20F-ML	●	15.6	16.5	93.9	112.9	50	160	2.6	20	24.9	TSW-2556H	A-08
TEZD1700S20F-ML	●	16.6	17.5	99.1	120.1	50	167	2.7	20	24.9		
TEZD1800S20F-ML	●	17.6	18.5	105.3	126.3	50	173	2.9	20	24.9		
TEZD1900S25F-ML	●	18.6	19.5	110.5	133.5	56	186	3.1	25	32.0	TSW-2567H	A-08
TEZD2000S25F-ML	●	19.6	20.5	116.6	140.6	56	193	3.2	25	32.0		
TEZD2100S25F-ML	●	20.6	21.5	121.8	146.8	56	199	3.4	25	32.0		
TEZD2200S25F-ML	●	21.6	22.5	128.0	154.0	56	206	3.5	25	32.0	DSW-307H	A-10
TEZD2300S25F-ML	●	22.6	23.5	133.2	161.2	56	213	3.7	25	32.0		
TEZD2400S32F-ML	●	23.6	24.5	139.4	168.4	60	224	3.9	32	41.9		
TEZD2500S32F-ML	●	24.6	25.5	144.5	174.5	60	230	4.0	32	41.9	DSW-309H	A-10
TEZD2600S32F-ML	●	25.6	26.5	150.7	181.7	60	237	4.2	32	41.9		
TEZD2700S32F-ML	●	26.6	27.5	155.9	188.9	60	244	4.4	32	41.9		
TEZD2800S32F-ML	●	27.6	28.5	162.1	195.1	60	250	4.5	32	41.9	TSW-3510H	A-15
TEZD2900S32F-ML	●	28.6	29.5	167.3	202.3	60	257	4.7	32	41.9		
TEZD3000S32F-ML	●	29.6	30.5	173.5	209.5	60	264	4.8	32	41.9		
TEZD3100S32F-ML	●	30.6	31.5	178.7	215.7	60	270	5.0	32	41.9	TSW-3512H	A-15
TEZD3200S32F-ML	●	31.6	32.5	184.8	222.8	60	277	5.2	32	41.9		

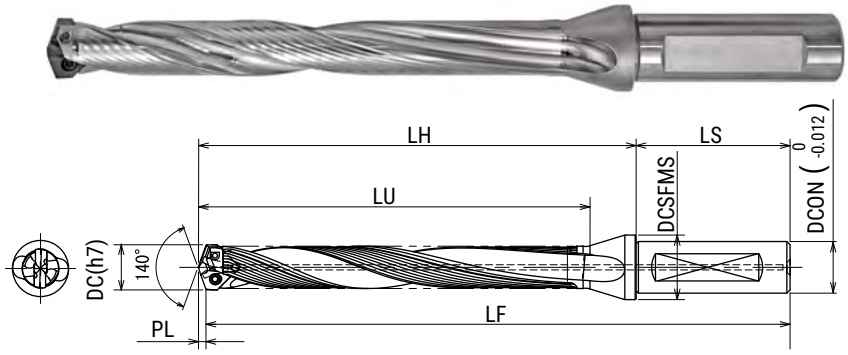
Note: All drill bodies are supplied without inserts, wrenches, or MOLY.

● : Stocked Items

Clamp screw	Torque(N·m)
DSW-2045H	0.9
TSW-2556H	1.2
TSW-2567H	1.2
DSW-307H	2.1
DSW-309H	2.1
TSW-3510H	3.0
TSW-3512H	3.0

Through coolant hole | 8D L/D | Drilling

TEZDF-XL TYPE Holder



Cat.No.	Stock	DC		Dimensions (mm)							Parts	
		Min.	Max.	LU	LH	LS	LF	PL	DCON	DCSFMS	Screw	Wrench
TEZD1400S16F-XL	●	13.5	14.5	121.5	135.5	48	181	2.3	16	20.0	DSW-2045H	A-07
TEZD1500S20F-XL	●	14.6	15.5	130.7	145.7	50	193	2.4	20	24.9		
TEZD1600S20F-XL	●	15.6	16.5	138.9	154.9	50	202	2.6	20	24.9	TSW-2556H	A-08
TEZD1700S20F-XL	●	16.6	17.5	148.1	165.1	50	212	2.7	20	24.9		
TEZD1800S20F-XL	●	17.6	18.5	156.3	174.3	50	221	2.9	20	24.9		
TEZD1900S25F-XL	●	18.6	19.5	165.5	184.5	56	237	3.1	25	32.0	TSW-2567H	A-08
TEZD2000S25F-XL	●	19.6	20.5	173.6	193.6	56	246	3.2	25	32.0		
TEZD2100S25F-XL	●	20.6	21.5	182.8	203.8	56	256	3.4	25	32.0		
TEZD2200S25F-XL	●	21.6	22.5	191.0	213.0	56	265	3.5	25	32.0	DSW-307H	A-10
TEZD2300S25F-XL	●	22.6	23.5	200.2	223.2	56	275	3.7	25	32.0		
TEZD2400S32F-XL	●	23.6	24.5	208.4	232.4	60	288	3.9	32	41.9		
TEZD2500S32F-XL	●	24.6	25.5	217.5	242.5	60	298	4.0	32	41.9	DSW-309H	A-10
TEZD2600S32F-XL	●	25.6	26.5	225.7	251.7	60	307	4.2	32	41.9		
TEZD2700S32F-XL	●	26.6	27.5	234.9	261.9	60	317	4.4	32	41.9		
TEZD2800S32F-XL	●	27.6	28.5	243.1	271.1	60	326	4.5	32	41.9	TSW-3510H	A-15
TEZD2900S32F-XL	●	28.6	29.5	252.3	281.3	60	336	4.7	32	41.9		
TEZD3000S32F-XL	●	29.6	30.5	260.5	290.5	60	345	4.8	32	41.9		
TEZD3100S32F-XL	●	30.6	31.5	253.7	300.7	60	355	5.0	32	41.9	TSW-3512H	A-15
TEZD3200S32F-XL	●	31.6	32.5	261.8	309.8	60	364	5.2	32	41.9		

Note: All drill bodies are supplied without inserts, wrenches, or MOLY.

● : Stocked Items

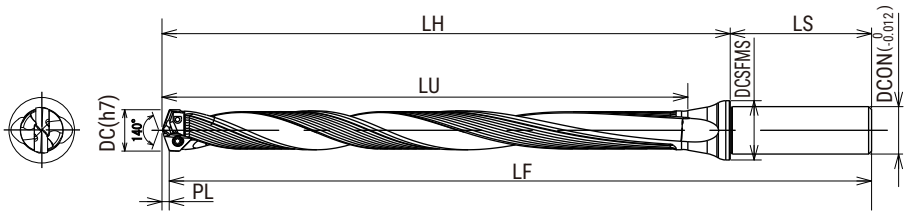
Clamp screw	Torque(N·m)
DSW-2045H	0.9
TSW-2556H	1.2
TSW-2567H	1.2
DSW-307H	2.1
DSW-309H	2.1
TSW-3510H	3.0
TSW-3512H	3.0

NEW

TEZDF-XXL TYPE

Holder

Through coolant hole | 12D L/D | Drilling



Cat.No.	Stock	DC		Dimensions (mm)							Parts	
		Min.	Max.	LU	LH	LS	LF	PL	DCON	DCSFMS	Screw	Wrench
TEZD1400S16F-XXL	●	13.5	14.5	177.5	191.5	48	237	2.3	16	20.0	DSW-2045H	A-07
TEZD1500S20F-XXL	●	14.6	15.5	190.7	205.7	50	253	2.4	20	24.9		
TEZD1600S20F-XXL	●	15.6	16.5	202.9	218.9	50	266	2.6	20	24.9	TSW-2556H	A-08
TEZD1700S20F-XXL	●	16.6	17.5	216.1	233.1	50	280	2.7	20	24.9		
TEZD1800S20F-XXL	●	17.6	18.5	228.3	246.3	50	293	2.9	20	24.9		
TEZD1900S25F-XXL	●	18.6	19.5	241.5	260.5	56	313	3.1	25	32.0	TSW-2567H	A-08
TEZD2000S25F-XXL	●	19.6	20.5	253.6	273.6	56	326	3.2	25	32.0		
TEZD2100S25F-XXL	●	20.6	21.5	266.8	287.8	56	340	3.4	25	32.0		
TEZD2200S25F-XXL	※	21.6	22.5	279.0	301.0	56	353	3.5	25	32.0	DSW-307H	A-10
TEZD2300S25F-XXL	●	22.6	23.5	292.2	315.2	56	367	3.7	25	32.0		

Note: All drill bodies are supplied without inserts, wrenches, or MOLY.

●：Stocked Items ※：Soon to be stocked

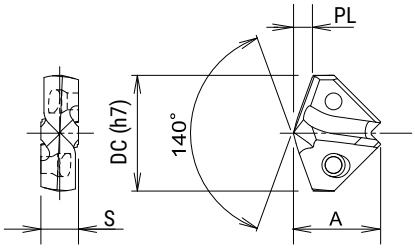
Clamp screw	Torque(N·m)
DSW-2045H	0.9
TSW-2556H	1.2
TSW-2567H	1.2
DSW-307H	2.1

Through coolant hole | DV Coating | Drilling

TEZ TYPE

Insert - Grade JC8050

● Suitable for General Steel



DC	Cat.No.	Stk	A	S	PL	Holder
13.5	TEZ1350	●	11.4	4.5	2.3	TEZD14*
13.6	TEZ1360	●				
13.7	TEZ1370	●				
13.8	TEZ1380	●				
13.9	TEZ1390	●				
14.0	TEZ1400	●				
14.1	TEZ1410	●				
14.2	TEZ1420	●				
14.3	TEZ1430	●				
14.4	TEZ1440	●				
14.5	TEZ1450	●				
14.6	TEZ1460	●	11.5	4.8	2.4	TEZD15*
14.7	TEZ1470	●				
14.8	TEZ1480	●				
14.9	TEZ1490	●				
15.0	TEZ1500	●				
15.1	TEZ1510	●				
15.2	TEZ1520	●				
15.3	TEZ1530	●				
15.4	TEZ1540	●				
15.5	TEZ1550	●				
15.6	TEZ1560	●	12.4	5.0	2.6	TEZD16*
15.7	TEZ1570	●				
15.8	TEZ1580	●				
15.9	TEZ1590	●				
16.0	TEZ1600	●				
16.1	TEZ1610	●				
16.2	TEZ1620	●				
16.3	TEZ1630	●				
16.4	TEZ1640	●				
16.5	TEZ1650	●				
16.6	TEZ1660	●	13.2	5.5	2.7	TEZD17*
16.7	TEZ1670	●				
16.8	TEZ1680	●				
16.9	TEZ1690	●				
17.0	TEZ1700	●				
17.1	TEZ1710	●				
17.2	TEZ1720	●				
17.3	TEZ1730	●				
17.4	TEZ1740	●				
17.5	TEZ1750	●				
17.6	TEZ1760	●	13.5	5.8	2.9	TEZD18*
17.7	TEZ1770	●				
17.8	TEZ1780	●				
17.9	TEZ1790	●				
18.0	TEZ1800	●				
18.1	TEZ1810	●				
18.2	TEZ1820	●				

Note: 1 insert per case

● : Stocked Items

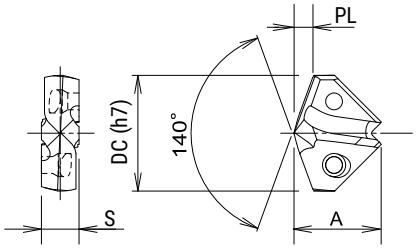
DC	Cat.No.	Stk	A	S	PL	Holder
18.3	TEZ1830	●	13.5	5.8	2.9	TEZD18*
18.4	TEZ1840	●				
18.5	TEZ1850	●				
18.6	TEZ1860	●	14.2	6.0	3.1	TEZD19*
18.7	TEZ1870	●				
18.8	TEZ1880	●				
18.9	TEZ1890	●				
19.0	TEZ1900	●				
19.1	TEZ1910	●				
19.2	TEZ1920	●				
19.3	TEZ1930	●				
19.4	TEZ1940	●				
19.5	TEZ1950	●				
19.6	TEZ1960	●	15.1	6.5	3.2	TEZD20*
19.7	TEZ1970	●				
19.8	TEZ1980	●				
19.9	TEZ1990	●				
20.0	TEZ2000	●				
20.1	TEZ2010	●				
20.2	TEZ2020	●				
20.3	TEZ2030	●				
20.4	TEZ2040	●				
20.5	TEZ2050	●				
20.6	TEZ2060	●	15.7	6.7	3.4	TEZD21*
20.7	TEZ2070	●				
20.8	TEZ2080	●				
20.9	TEZ2090	●				
21.0	TEZ2100	●				
21.1	TEZ2110	●				
21.2	TEZ2120	●				
21.3	TEZ2130	●				
21.4	TEZ2140	●				
21.5	TEZ2150	●				
21.6	TEZ2160	●	16.6	7.5	3.5	TEZD22*
21.7	TEZ2170	●				
21.8	TEZ2180	●				
21.9	TEZ2190	●				
22.0	TEZ2200	●				
22.1	TEZ2210	●				
22.2	TEZ2220	●				
22.3	TEZ2230	●				
22.4	TEZ2240	●				
22.5	TEZ2250	●				
22.6	TEZ2260	●	17.4	7.5	3.7	TEZD23*
22.7	TEZ2270	●				
22.8	TEZ2280	●				
22.9	TEZ2290	●				
23.0	TEZ2300	●				

Through coolant hole | DV Coating | Drilling

TEZ TYPE

Insert - Grade JC8050

● Suitable for General Steel



DC	Cat.No.	Stk	A	S	PL	Holder
23.1	TEZ2310	●	17.4	7.5	3.7	TEZD23*
23.2	TEZ2320	●				
23.3	TEZ2330	●				
23.4	TEZ2340	●				
23.5	TEZ2350	●				
23.6	TEZ2360	●	18.2	8.0	3.9	TEZD24*
23.7	TEZ2370	●				
23.8	TEZ2380	●				
23.9	TEZ2390	●				
24.0	TEZ2400	●				
24.1	TEZ2410	●				
24.2	TEZ2420	●				
24.3	TEZ2430	●				
24.4	TEZ2440	●				
24.5	TEZ2450	●				
24.6	TEZ2460	●	19.1	8.0	4.0	TEZD25*
24.7	TEZ2470	●				
24.8	TEZ2480	●				
24.9	TEZ2490	●				
25.0	TEZ2500	●				
25.1	TEZ2510	●				
25.2	TEZ2520	●				
25.3	TEZ2530	●				
25.4	TEZ2540	●				
25.5	TEZ2550	●				
25.6	TEZ2560	●	19.7	8.5	4.2	TEZD26*
25.7	TEZ2570	●				
25.8	TEZ2580	●				
25.9	TEZ2590	●				
26.0	TEZ2600	●				
26.1	TEZ2610	●				
26.2	TEZ2620	●				
26.3	TEZ2630	●				
26.4	TEZ2640	●				
26.5	TEZ2650	●				
26.6	TEZ2660	●	20.4	8.5	4.4	TEZD27*
26.7	TEZ2670	●				
26.8	TEZ2680	●				
26.9	TEZ2690	●				
27.0	TEZ2700	●				
27.1	TEZ2710	●				
27.2	TEZ2720	●				
27.3	TEZ2730	●				
27.4	TEZ2740	●				
27.5	TEZ2750	●				
27.6	TEZ2760	●	21.2	9.0	4.5	TEZD28*
27.7	TEZ2770	●				
27.8	TEZ2780	●				

Note: 1 insert per case

● : Stocked Items

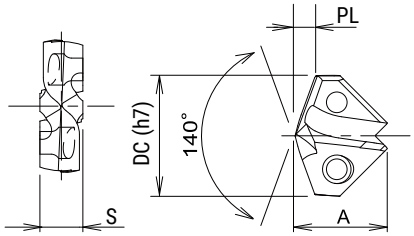
DC	Cat.No.	Stk	A	S	PL	Holder
27.9	TEZ2790	●	21.2	9.0	4.5	TEZD28*
28.0	TEZ2800	●				
28.1	TEZ2810	●				
28.2	TEZ2820	●				
28.3	TEZ2830	●				
28.4	TEZ2840	●				
28.5	TEZ2850	●				
28.6	TEZ2860	●	22.1	9.0	4.7	TEZD29*
28.7	TEZ2870	●				
28.8	TEZ2880	●				
28.9	TEZ2890	●				
29.0	TEZ2900	●				
29.1	TEZ2910	●				
29.2	TEZ2920	●				
29.3	TEZ2930	●				
29.4	TEZ2940	●				
29.5	TEZ2950	●				
29.6	TEZ2960	●	22.5	9.5	4.8	TEZD30*
29.7	TEZ2970	●				
29.8	TEZ2980	●				
29.9	TEZ2990	●				
30.0	TEZ3000	●				
30.1	TEZ3010	●				
30.2	TEZ3020	●				
30.3	TEZ3030	●				
30.4	TEZ3040	●				
30.5	TEZ3050	●				
30.6	TEZ3060	●	23.4	10	5.0	TEZD31*
30.7	TEZ3070	●				
30.8	TEZ3080	●				
30.9	TEZ3090	●				
31.0	TEZ3100	●				
31.1	TEZ3110	●				
31.2	TEZ3120	●				
31.3	TEZ3130	●				
31.4	TEZ3140	●				
31.5	TEZ3150	●				
31.6	TEZ3160	●	24.3	10	5.2	TEZD32*
31.7	TEZ3170	●				
31.8	TEZ3180	●				
31.9	TEZ3190	●				
32.0	TEZ3200	●				
32.1	TEZ3210	●				
32.2	TEZ3220	●				
32.3	TEZ3230	●				
32.4	TEZ3240	●				
32.5	TEZ3250	●				

Through coolant hole | JC7500 Coating | Drilling

TEZ-S TYPE

Insert - Grade JC7515

● for Stainless Steel, Titanium Alloy



DC	Cat.No.	Stk	A	S	PL	Holder
13.5	TEZ1350S	●	11.4	4.5	2.3	TEZD14*
13.6	TEZ1360S	●				
13.7	TEZ1370S	●				
13.8	TEZ1380S	●				
13.9	TEZ1390S	●				
14.0	TEZ1400S	●				
14.1	TEZ1410S	●				
14.2	TEZ1420S	●				
14.3	TEZ1430S	●				
14.4	TEZ1440S	●				
14.5	TEZ1450S	●				
14.6	TEZ1460S	●	11.5	4.8	2.4	TEZD15*
14.7	TEZ1470S	●				
14.8	TEZ1480S	●				
14.9	TEZ1490S	●				
15.0	TEZ1500S	●				
15.1	TEZ1510S	●				
15.2	TEZ1520S	●				
15.3	TEZ1530S	●				
15.4	TEZ1540S	●				
15.5	TEZ1550S	●				
15.6	TEZ1560S	●	12.4	5.0	2.6	TEZD16*
15.7	TEZ1570S	●				
15.8	TEZ1580S	●				
15.9	TEZ1590S	●				
16.0	TEZ1600S	●				
16.1	TEZ1610S	●				
16.2	TEZ1620S	●				
16.3	TEZ1630S	●				
16.4	TEZ1640S	●				
16.5	TEZ1650S	●				
16.6	TEZ1660S	●	13.2	5.5	2.7	TEZD17*
16.7	TEZ1670S	●				
16.8	TEZ1680S	●				
16.9	TEZ1690S	●				
17.0	TEZ1700S	●				
17.1	TEZ1710S	●				
17.2	TEZ1720S	●				
17.3	TEZ1730S	●				
17.4	TEZ1740S	●				
17.5	TEZ1750S	●				
17.6	TEZ1760S	●	13.5	5.8	2.9	TEZD18*
17.7	TEZ1770S	●				
17.8	TEZ1780S	●				
17.9	TEZ1790S	●				
18.0	TEZ1800S	●				
18.1	TEZ1810S	●				

Note: 1 insert per case

● : Stocked Items

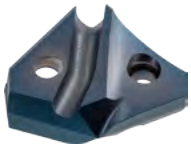
DC	Cat.No.	Stk	A	S	PL	Holder
18.2	TEZ1820S	●	13.5	5.8	2.9	TEZD18*
18.3	TEZ1830S	●				
18.4	TEZ1840S	●				
18.5	TEZ1850S	●				
18.6	TEZ1860S	●	14.2	6.0	3.1	TEZD19*
18.7	TEZ1870S	●				
18.8	TEZ1880S	●				
18.9	TEZ1890S	●				
19.0	TEZ1900S	●				
19.1	TEZ1910S	●				
19.2	TEZ1920S	●				
19.3	TEZ1930S	●				
19.4	TEZ1940S	●				
19.5	TEZ1950S	●				
19.6	TEZ1960S	●	15.1	6.5	3.2	TEZD20*
19.7	TEZ1970S	●				
19.8	TEZ1980S	●				
19.9	TEZ1990S	●				
20.0	TEZ2000S	●				
20.5	TEZ2050S	●				

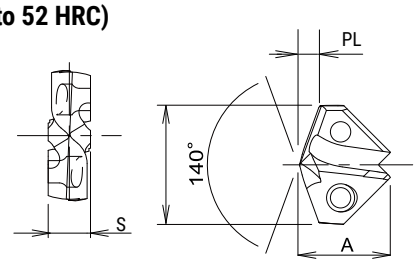
Through coolant hole | DH Coating | Drilling

TEZ-H TYPE

Insert - Grade DH115

● for Mold Steel, Hardened steel (up to 52 HRC)





DC	Cat.No.	Stk	A	S	PL	Holder
13.5	TEZ1350H	●	11.4	4.5	2.3	TEZD14*
14.0	TEZ1400H	●				
14.1	TEZ1410H	●				
14.2	TEZ1420H	●				
14.3	TEZ1430H	●				
14.5	TEZ1450H	●				
15.0	TEZ1500H	●	11.5	4.8	2.4	TEZD15*
15.1	TEZ1510H	●				
15.2	TEZ1520H	●				
15.3	TEZ1530H	●				
15.5	TEZ1550H	●				
15.8	TEZ1580H	●	12.4	5.0	2.6	TEZD16*
15.9	TEZ1590H	●				
16.0	TEZ1600H	●				
16.1	TEZ1610H	●				
16.2	TEZ1620H	●				
16.3	TEZ1630H	●				
16.5	TEZ1650H	●				
17.0	TEZ1700H	●	13.2	5.5	2.7	TEZD17*
17.1	TEZ1710H	●				
17.5	TEZ1750H	●				
17.6	TEZ1760H	●	13.5	5.8	2.9	TEZD18*
17.7	TEZ1770H	●				
17.8	TEZ1780H	●				
18.0	TEZ1800H	●				
18.1	TEZ1810H	●				
18.5	TEZ1850H	●				

Note: 1 insert per case

● : Stocked Items

DC	Cat.No.	Stk	A	S	PL	Holder
19.0	TEZ1900H	●	14.2	6.0	3.1	TEZD19*
19.5	TEZ1950H	●				
19.8	TEZ1980H	●	15.1	6.5	3.2	TEZD20*
20.0	TEZ2000H	●				
20.2	TEZ2020H	●				
20.5	TEZ2050H	●				

■ Recommended Cutting Conditions | TEZDF-MS/ML/XL/XXL type, TEZD-M type | TEZ, TEZ-S type inserts

Material	Structual Steel Carbon Steel		Alloy Steel (1.7225)		Stainless Steel		Grey Cast Iron (GG25)		Nodular Cast Iron (GGG40)	
Vc (m/min)	75–90		70–90		45		85–110		60–90	
f (mm/rev)	0.3–0.35		0.22–0.25		0.25		0.3–0.4		0.3–0.4	
Drill dia. (mm)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)
14	1,700	510	1,600	350	1,000	250	1,900	570	1,500	450
15	1,600	480	1,500	350	950	240	1,900	570	1,400	420
16	1,500	450	1,400	340	890	220	1,900	570	1,350	400
17	1,400	450	1,300	330	840	210	1,800	570	1,250	400
18	1,300	450	1,250	310	790	200	1,700	570	1,000	350
19	1,250	440	1,200	300	750	190	1,600	560	1,000	350
20	1,200	420	1,100	280	710	180	1,600	560	1,000	350
21	1,200	420	1,100	280	680	170	1,550	540	1,000	350
22	1,200	420	1,050	260	650	160	1,500	530	1,000	350
23	1,200	420	1,050	260	620	155	1,450	510	1,000	350
24	1,200	420	1,050	260	600	150	1,400	490	1,000	350
25	1,150	400	1,050	260	570	140	1,350	470	1,000	350
26	1,110	390	1,050	260	550	140	1,300	460	1,000	350
27	1,070	370	1,000	250	530	135	1,250	460	950	330
28	1,030	360	1,000	250	510	130	1,200	460	950	330
29	990	350	950	240	495	125	1,150	460	950	330
30	960	340	950	240	480	120	1,150	460	950	330
31	930	330	900	225	460	115	1,100	440	850	300
32	900	315	900	225	445	110	1,100	440	850	300

Notes:

1. The above cutting conditions are provided as general guidelines.
2. Adjust the cutting conditions according to the rigidity of the machine and the workpiece.
3. When using the "-XL" (8D) or "-XXL" (12D) type, reduce both the spindle speed (n) and feed rate (Vf) by 20% from the standard cutting conditions. Pre-drilling a guide hole (depth: 0.5D) is recommended.
4. When using a modular head type, if the overhang exceeds L/D = 10, reduce both the spindle speed (n) and feed rate (Vf) by approx. 20% from the above cutting conditions.
5. The TEZ-S type is recommended for machining stainless steel.

■ Recommended Cutting Conditions | TEZDF-MS/ML/XL/XXL type, TEZD-M type | TEZ-S type inserts

Material	Titanium Alloy (Ti-6Al-4V)		Stainless Steel	
Vc (m/min)	35–60		45–80	
f (mm/rev)	0.15–0.2		0.15–0.2	
Drill dia. (mm)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)
14	1,130	170	1,360	200
15	1,060	170	1,270	200
16	990	160	1,190	190
17	930	160	1,120	190
18	880	160	1,060	190
19	830	160	1,000	190
20	790	160	950	190

■ Recommended Cutting Conditions | TEZDF-MS/ML/XL/XXL type, TEZD-M type | TEZ-H type inserts

Material	Mold Steel 30–36HRC		Mold Steel 38–43HRC		Hardened Steel 42–52HRC	
Vc (m/min)	50–70		40–60		40–60	
f (mm/rev)	0.15–0.25		0.10–0.20		0.10–0.15	
Drill dia. (mm)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)
14	1,360	270	1,140	170	1,140	140
15	1,270	260	1,060	160	1,060	130
16	1,190	240	1,000	150	1,000	125
17	1,120	225	940	140	940	115
18	1,060	210	880	130	880	110
19	1,010	200	840	125	840	105
20	960	190	800	120	800	100

Notes:

1. The above cutting conditions are provided as general guidelines.
2. Adjust the cutting conditions according to the rigidity of the machine and the workpiece.
3. Use a water-soluble coolant.
4. When using the "-XL" (8D) or "-XXL" (12D) type, reduce both the spindle speed (n) and feed rate (Vf) by 20% from the standard cutting conditions. Pre-drilling a guide hole (depth: 0.5D) is recommended.
5. When using a modular head type, if the overhang exceeds L/D = 10, reduce both the spindle speed (n) and feed rate (Vf) by approx. 20% from the above cutting conditions.
6. Depending on the workpiece material and geometry, chips may become long and difficult to break. This may result in oversized holes, damage to the hole surface, or tool failure due to chip clogging. Increase the feed rate or use step drilling to improve chip control.

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