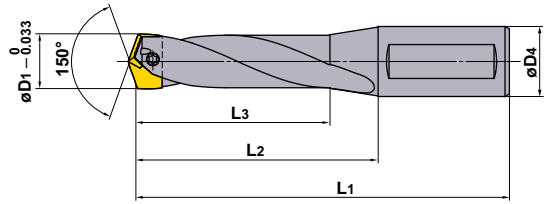


- Wavy cutting edge design for good chip control.
- Serration geometry for accurate insert location.
- Easy insert exchange.

(For Bridge Construction)



HOLDERS

Drill Dia. Range D1 (mm)	Hole Depth (l/d)	Holder		Insert			Dimensions (mm)				Clamp Screw	Wrench	Plate	Anti-seize Lubricant
		Order Number	Stock	Drill Dia. D1 (mm)	Order Number	Stock	L3	L2	L1	D4				
24.5 24.6 24.7	3	TAWSB2500S32	●	24.5	TAWB2450T	★	88.6	110.6	170.6	32	WS406023T	TKY25T	WPT4405	MK1KS
				NEW	TAWBH2450T	●								
	5	TAWMB2500S32	□	24.6	TAWB2460T	□	140.6	165.6	225.6	32	WS406023T	TKY25T	WPT4405	MK1KS
				NEW	TAWBH2460T	□								
26.5 26.7	3	TAWSB2700S32	●	26.5	TAWB2650T	□	94.6	115.6	175.6	32	WS406024T	TKY25T	WPT4405	MK1KS
				NEW	TAWBH2650T	□								
	5	TAWMB2700S32	□	26.7	TAWB2670T	★	151.6	175.6	235.6	32	WS406024T	TKY25T	WPT4405	MK1KS
				NEW	TAWBH2670T	●								


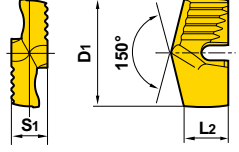

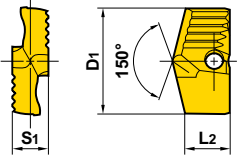
(Note 1) The dimensions in brackets represent the sizes when TAWN-U type inserts are used.

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

● : Inventory maintained. ★ : Inventory maintained in Japan.

□ : Non stock, produced to order only.

INSERTS

Shape	Order Number	Stock	Dimensions (mm)			Applicable Holder	Honing Width (mm)	Geometry
			VPI5TF	D1	L2			
 U type	TAWB2450T	★	24.5	11.1	9.0	TAWSB2500S32 TAWMB2500S32	0.20-0.25	
	2460T	□	24.6	11.1	9.0			
	2470T	★	24.7	11.1	9.0			
	2650T	□	26.5	10.7	9.0	TAWSB2700S32 TAWMB2700S32		
	2670T	★	26.7	10.7	9.0			
 H type	TAWBH2450T	●	24.5	11.7	9.0	TAWSB2500S32 TAWMB2500S32	0.20-0.25	
	2460T	□	24.6	11.7	9.0			
	2470T	●	24.7	11.7	9.0			
	2650T	□	26.5	11.3	9.0	TAWSB2700S32 TAWMB2700S32		
	2670T	●	26.7	11.3	9.0			

● : Inventory maintained. (Note: 2 inserts in one case) ★ : Inventory maintained in Japan. (Note: 2 inserts in one case)

□ : Non stock, produced to order only.

RECOMMENDED CUTTING CONDITIONS

Work Material	Drill Diameter		φ24.5, φ24.6, φ24.7		φ26.5, φ26.7	
	Conditions	Hardness	Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)
P Structural Steel	Tensile Strength ≤ 400-500 N/mm ²		70 (60-80)	0.30 (0.25-0.35)	70 (60-80)	0.30 (0.25-0.35)
	Tensile Strength ≤ 490-610 N/mm ²		65 (55-75)	0.30 (0.25-0.35)	65 (55-75)	0.30 (0.25-0.35)
	Tensile Strength ≤ 570-720 N/mm ²		60 (50-70)	0.30 (0.25-0.35)	60 (50-70)	0.30 (0.25-0.35)

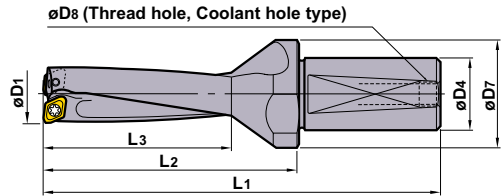
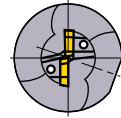
(Note) Recommended for use only with a rigid machine and set up. Use the internal coolant system when machining stainless steel. (MQL and mist machining should not be used.)



DRILLING (INDEXABLE TYPE)

TAFS, TAFM, TAFL

- High rigidity holder.
- 4 corner use insert.
- Various grades and chip breakers.



* The screw hole on the flange section is not a coolant hole.



Drill Diameter D1 (mm)	Hole Depth (l/d)	Order Number	Stock	Number of Teeth	Dimensions (mm)						Insert Number	Clamp Screw	Wrench
					D4	D7	D8	L1	L2	L3			
12.0	2	TAFS1200F20	●	2	20	25	PT1/8	82	39	29	GCMT040204-U	TS2	TKY06F
	3	TAFM1200F20	●	2	20	25	PT1/8	94	51	41	GCMT040204-U	TS2	TKY06F
	4	TAFL1200F20	●	2	20	25	PT1/8	106	63	53	GCMT040204-U	TS2	TKY06F
12.5	2	TAFS1250F20	●	2	20	25	PT1/8	82	39	29	GCMT040204-U	TS2	TKY06F
	3	TAFM1250F20	●	2	20	25	PT1/8	94	51	41	GCMT040204-U	TS2	TKY06F
	4	TAFL1250F20	●	2	20	25	PT1/8	106	63	53	GCMT040204-U	TS2	TKY06F
13.0	2	TAFS1300F20	●	2	20	25	PT1/8	84	41	31	GCMT040204-U	TS2	TKY06F
	3	TAFM1300F20	●	2	20	25	PT1/8	97	54	44	GCMT040204-U	TS2	TKY06F
	4	TAFL1300F20	●	2	20	25	PT1/8	110	67	57	GCMT040204-U	TS2	TKY06F
13.5	2	TAFS1350F20	●	2	20	25	PT1/8	84	41	31	GCMT040204-U	TS2	TKY06F
	3	TAFM1350F20	●	2	20	25	PT1/8	97	54	44	GCMT040204-U	TS2	TKY06F
	4	TAFL1350F20	●	2	20	25	PT1/8	110	67	57	GCMT040204-U	TS2	TKY06F
14.0	2	TAFS1400F20	●	2	20	25	PT1/8	86	43	33	GCMT040204-U	TS2	TKY06F
	3	TAFM1400F20	●	2	20	25	PT1/8	100	57	47	GCMT040204-U	TS2	TKY06F
	4	TAFL1400F20	●	2	20	25	PT1/8	114	71	61	GCMT040204-U	TS2	TKY06F
14.5	2	TAFS1450F20	●	2	20	25	PT1/8	86	43	33	GCMT040204-U	TS2	TKY06F
	3	TAFM1450F20	●	2	20	25	PT1/8	100	57	47	GCMT040204-U	TS2	TKY06F
	4	TAFL1450F20	●	2	20	25	PT1/8	114	71	61	GCMT040204-U	TS2	TKY06F
15.0	2	TAFS1500F20	●	2	20	25	PT1/8	88	45	35	GPMT060204-U	TS2	TKY06F
	3	TAFM1500F20	●	2	20	25	PT1/8	103	60	50	GPMT060204-U	TS2	TKY06F
	4	TAFL1500F20	●	2	20	25	PT1/8	118	75	65	GPMT060204-U	TS2	TKY06F
15.5	2	TAFS1550F20	●	2	20	25	PT1/8	88	45	35	GPMT060204-U	TS2	TKY06F
	3	TAFM1550F20	●	2	20	25	PT1/8	103	60	50	GPMT060204-U	TS2	TKY06F
	4	TAFL1550F20	●	2	20	25	PT1/8	118	75	65	GPMT060204-U	TS2	TKY06F
16.0	2	TAFS1600F25	●	2	25	35	PT1/8	107	57	38	GPMT060204-U	TS2	TKY06F
	3	TAFM1600F25	●	2	25	35	PT1/8	123	73	54	GPMT060204-U	TS2	TKY06F
	4	TAFL1600F25	●	2	25	35	PT1/8	139	89	70	GPMT060204-U	TS2	TKY06F
16.5	2	TAFS1650F25	●	2	25	35	PT1/8	107	57	38	GPMT060204-U	TS2	TKY06F
	3	TAFM1650F25	●	2	25	35	PT1/8	123	73	54	GPMT060204-U	TS2	TKY06F
17.0	2	TAFS1700F25	●	2	25	35	PT1/8	109	59	41	GPMT060204-U	TS2	TKY06F
	3	TAFM1700F25	●	2	25	35	PT1/8	126	76	58	GPMT060204-U	TS2	TKY06F
	4	TAFL1700F25	●	2	25	35	PT1/8	143	93	75	GPMT060204-U	TS2	TKY06F
17.5	2	TAFS1750F25	●	2	25	35	PT1/8	109	59	41	GPMT060204-U	TS2	TKY06F
	3	TAFM1750F25	●	2	25	35	PT1/8	126	76	58	GPMT060204-U	TS2	TKY06F
	4	TAFL1750F25	●	2	25	35	PT1/8	143	93	75	GPMT060204-U	TS2	TKY06F

DRILLING TAF DRILLS



D082

● : Inventory maintained.

Drill Diameter D1 (mm)	Hole Depth (l/d)	Order Number	Stock	Number of Teeth	Dimensions (mm)						Insert Number		
					D4	D7	D8	L1	L2	L3			
18.0	2	TAFS1800F25	●	2	25	35	PT1/8	111	61	43	GPMT070204-U	TS25	TKY08F
	3	TAFM1800F25	●	2	25	35	PT1/8	129	79	61	GPMT070204-U	TS25	TKY08F
	4	TAFL1800F25	●	2	25	35	PT1/8	147	97	79	GPMT070204-U	TS25	TKY08F
18.5	2	TAFS1850F25	●	2	25	35	PT1/8	111	61	43	GPMT070204-U	TS25	TKY08F
	3	TAFM1850F25	●	2	25	35	PT1/8	129	79	61	GPMT070204-U	TS25	TKY08F
19.0	2	TAFS1900F25	●	2	25	35	PT1/8	113	63	46	GPMT070204-U	TS25	TKY08F
	3	TAFM1900F25	●	2	25	35	PT1/8	132	82	65	GPMT070204-U	TS25	TKY08F
	4	TAFL1900F25	●	2	25	35	PT1/8	151	101	84	GPMT070204-U	TS25	TKY08F
19.5	2	TAFS1950F25	●	2	25	35	PT1/8	113	63	46	GPMT070204-U	TS25	TKY08F
	3	TAFM1950F25	●	2	25	35	PT1/8	132	82	65	GPMT070204-U	TS25	TKY08F
20.0	2	TAFS2000F25	●	2	25	35	PT1/8	115	65	48	GPMT070204-U	TS25	TKY08F
	3	TAFM2000F25	●	2	25	35	PT1/8	135	85	68	GPMT070204-U	TS25	TKY08F
	4	TAFL2000F25	●	2	25	35	PT1/8	155	105	88	GPMT070204-U	TS25	TKY08F
20.5	2	TAFS2050F25	●	2	25	35	PT1/8	115	65	48	GPMT070204-U	TS25	TKY08F
	3	TAFM2050F25	●	2	25	35	PT1/8	135	85	68	GPMT070204-U	TS25	TKY08F
21.0	2	TAFS2100F25	●	2	25	35	PT1/8	117	67	50	GPMT070204-U	TS25	TKY08F
	3	TAFM2100F25	●	2	25	35	PT1/8	138	88	71	GPMT070204-U	TS25	TKY08F
	4	TAFL2100F25	●	2	25	35	PT1/8	159	109	92	GPMT070204-U	TS25	TKY08F
21.5	2	TAFS2150F25	●	2	25	35	PT1/8	117	67	50	GPMT070204-U	TS25	TKY08F
	3	TAFM2150F25	●	2	25	35	PT1/8	138	88	71	GPMT070204-U	TS25	TKY08F
22.0	2	TAFS2200F25	●	2	25	35	PT1/8	119	69	53	GPMT070204-U	TS25	TKY08F
	3	TAFM2200F25	●	2	25	35	PT1/8	141	91	75	GPMT070204-U	TS25	TKY08F
	4	TAFL2200F25	●	2	25	35	PT1/8	163	113	97	GPMT070204-U	TS25	TKY08F
22.5	2	TAFS2250F25	●	2	25	35	PT1/8	119	69	53	GPMT070204-U	TS25	TKY08F
	3	TAFM2250F25	●	2	25	35	PT1/8	141	91	75	GPMT070204-U	TS25	TKY08F
23.0	2	TAFS2300F25	●	2	25	35	PT1/8	121	71	55	GPMT090304-U	TS3	TKY08F
	3	TAFM2300F25	●	2	25	35	PT1/8	144	94	78	GPMT090304-U	TS3	TKY08F
	4	TAFL2300F25	●	2	25	35	PT1/8	167	117	101	GPMT090304-U	TS3	TKY08F
23.5	2	TAFS2350F25	●	2	25	35	PT1/8	121	71	55	GPMT090304-U	TS3	TKY08F
	3	TAFM2350F25	●	2	25	35	PT1/8	144	94	78	GPMT090304-U	TS3	TKY08F
	4	TAFL2350F25	●	2	25	35	PT1/8	167	117	101	GPMT090304-U	TS3	TKY08F
24.0	2	TAFS2400F25	●	2	25	35	PT1/8	123	73	58	GPMT090304-U	TS3	TKY08F
	3	TAFM2400F25	●	2	25	35	PT1/8	147	97	82	GPMT090304-U	TS3	TKY08F
	4	TAFL2400F25	●	2	25	35	PT1/8	171	121	106	GPMT090304-U	TS3	TKY08F
24.5	2	TAFS2450F25	●	2	25	35	PT1/8	123	73	58	GPMT090304-U	TS3	TKY08F
	3	TAFM2450F25	●	2	25	35	PT1/8	147	97	82	GPMT090304-U	TS3	TKY08F
25.0	2	TAFS2500F32	●	2	32	42	PT1/8	130	75	60	GPMT090304-U	TS3	TKY08F
	3	TAFM2500F32	●	2	32	42	PT1/8	155	100	85	GPMT090304-U	TS3	TKY08F
	4	TAFL2500F25	●	2	25	35	PT1/8	180	125	110	GPMT090304-U	TS3	TKY08F
	4	TAFL2500F32	●	2	32	42	PT1/8	180	125	110	GPMT090304-U	TS3	TKY08F
25.5	2	TAFS2550F32	●	2	32	42	PT1/8	130	75	60	GPMT090304-U	TS3	TKY08F
	3	TAFM2550F32	●	2	32	42	PT1/8	155	100	85	GPMT090304-U	TS3	TKY08F
26.0	2	TAFS2600F32	●	2	32	42	PT1/8	132	77	62	GPMT090304-U	TS3	TKY08F
	3	TAFM2600F32	●	2	32	42	PT1/8	158	103	88	GPMT090304-U	TS3	TKY08F
	4	TAFL2600F32	●	2	32	42	PT1/8	184	129	114	GPMT090304-U	TS3	TKY08F
26.5	2	TAFS2650F32	●	2	32	42	PT1/8	132	77	62	GPMT090304-U	TS3	TKY08F
	3	TAFM2650F32	●	2	32	42	PT1/8	158	103	88	GPMT090304-U	TS3	TKY08F
	4	TAFL2650F32	●	2	32	42	PT1/8	184	129	114	GPMT090304-U	TS3	TKY08F

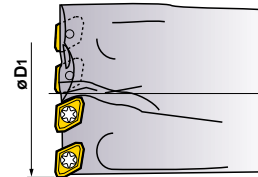
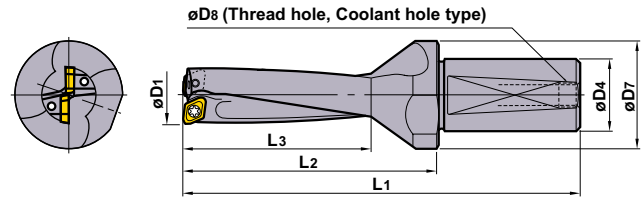
TAF DRILLS



DRILLING (INDEXABLE TYPE)

TAFS, TAFM, TAFL

- High rigidity holder.
- 4 corner use insert.
- Various grades and chip breakers.


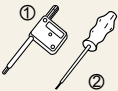


Number of Teeth = 4 ($\phi D1 \geq 49$)



* The screw hole on the flange section is not a coolant hole.

DRILLING TAF DRILLS

CARBIDE

Drill Diameter D1 (mm)	Hole Depth (l/d)	Order Number	Stock	Number of Teeth	Dimensions (mm)						Insert Number	 Clamp Screw	 Wrench
					D4	D7	D8	L1	L2	L3			
27.0	2	TAFS2700F32	●	2	32	42	PT1/8	134	79	65	GPMT090304-U	TS3	①TKY08F
	3	TAFM2700F32	●	2	32	42	PT1/8	161	106	92	GPMT090304-U	TS3	①TKY08F
	4	TAFL2700F32	●	2	32	42	PT1/8	188	133	119	GPMT090304-U	TS3	①TKY08F
27.5	2	TAFS2750F32	●	2	32	42	PT1/8	134	79	65	GPMT090304-U	TS3	①TKY08F
	3	TAFM2750F32	●	2	32	42	PT1/8	161	106	92	GPMT090304-U	TS3	①TKY08F
28.0	2	TAFS2800F32	●	2	32	42	PT1/8	136	81	67	GPMT11T308-U	TS4	②TKY15D
	3	TAFM2800F32	●	2	32	42	PT1/8	164	109	95	GPMT11T308-U	TS4	②TKY15D
	4	TAFL2800F32	●	2	32	42	PT1/8	192	137	123	GPMT11T308-U	TS4	②TKY15D
28.5	2	TAFS2850F32	●	2	32	42	PT1/8	136	81	67	GPMT11T308-U	TS4	②TKY15D
	3	TAFM2850F32	●	2	32	42	PT1/8	164	109	95	GPMT11T308-U	TS4	②TKY15D
	4	TAFL2850F40	●	2	40	50	PT1/8	202	137	123	GPMT11T308-U	TS4	②TKY15D
29.0	2	TAFS2900F32	●	2	32	42	PT1/8	138	83	70	GPMT11T308-U	TS4	②TKY15D
	3	TAFM2900F32	●	2	32	42	PT1/8	167	112	99	GPMT11T308-U	TS4	②TKY15D
	4	TAFL2900F32	●	2	32	42	PT1/8	196	141	128	GPMT11T308-U	TS4	②TKY15D
29.5	2	TAFS2950F32	●	2	32	42	PT1/8	138	83	70	GPMT11T308-U	TS4	②TKY15D
	3	TAFM2950F32	●	2	32	42	PT1/8	167	112	99	GPMT11T308-U	TS4	②TKY15D
30.0	2	TAFS3000F32	●	2	32	50	PT1/8	145	90	72	GPMT11T308-U	TS4	②TKY15D
	2	TAFS3000F40	●	2	40	50	PT1/4	155	90	72	GPMT11T308-U	TS4	②TKY15D
	3	TAFM3000F32	●	2	32	50	PT1/8	175	120	102	GPMT11T308-U	TS4	②TKY15D
	3	TAFM3000F40	●	2	40	50	PT1/4	185	120	102	GPMT11T308-U	TS4	②TKY15D
	4	TAFL3000F32	●	2	32	42	PT1/8	205	150	132	GPMT11T308-U	TS4	②TKY15D
30.5	4	TAFL3000F40	●	2	40	50	PT1/4	215	150	132	GPMT11T308-U	TS4	②TKY15D
	2	TAFS3050F40	●	2	40	50	PT1/4	155	90	72	GPMT11T308-U	TS4	②TKY15D
31.0	3	TAFM3050F40	●	2	40	50	PT1/4	185	120	102	GPMT11T308-U	TS4	②TKY15D
	2	TAFS3100F32	●	2	32	50	PT1/8	147	92	74	GPMT11T308-U	TS4	②TKY15D
	2	TAFS3100F40	●	2	40	50	PT1/4	157	92	74	GPMT11T308-U	TS4	②TKY15D
	3	TAFM3100F32	●	2	32	50	PT1/8	178	123	105	GPMT11T308-U	TS4	②TKY15D
	3	TAFM3100F40	●	2	40	50	PT1/4	188	123	105	GPMT11T308-U	TS4	②TKY15D
	4	TAFL3100F32	●	2	32	42	PT1/8	209	154	136	GPMT11T308-U	TS4	②TKY15D
4	TAFL3100F40	●	2	40	50	PT1/4	219	154	136	GPMT11T308-U	TS4	②TKY15D	

● : Inventory maintained.

Drill Diameter D1 (mm)	Hole Depth (l/d)	Order Number	Stock	Number of Teeth	Dimensions (mm)						Insert Number		
					D4	D7	D8	L1	L2	L3			
32.0	2	TAFS3200F32	●	2	32	50	PT1/8	149	94	77	GPMT11T308-U	TS4	TKY15D
	2	TAFS3200F40	●	2	40	50	PT1/4	159	94	77	GPMT11T308-U	TS4	TKY15D
	3	TAFM3200F32	●	2	32	50	PT1/8	181	126	109	GPMT11T308-U	TS4	TKY15D
	3	TAFM3200F40	●	2	40	50	PT1/4	191	126	109	GPMT11T308-U	TS4	TKY15D
	4	TAFM3200F32	●	2	32	42	PT1/8	213	158	141	GPMT11T308-U	TS4	TKY15D
	4	TAFM3200F40	●	2	40	50	PT1/4	223	158	141	GPMT11T308-U	TS4	TKY15D
33.0	2	TAFS3300F32	●	2	32	50	PT1/8	151	96	79	GPMT11T308-U	TS4	TKY15D
	2	TAFS3300F40	●	2	40	50	PT1/4	161	96	79	GPMT11T308-U	TS4	TKY15D
	3	TAFM3300F32	●	2	32	50	PT1/8	184	129	112	GPMT11T308-U	TS4	TKY15D
	3	TAFM3300F40	●	2	40	50	PT1/4	194	129	112	GPMT11T308-U	TS4	TKY15D
	4	TAFM3300F32	●	2	32	42	PT1/8	217	162	145	GPMT11T308-U	TS4	TKY15D
	4	TAFM3300F40	●	2	40	50	PT1/4	227	162	145	GPMT11T308-U	TS4	TKY15D
34.0	2	TAFS3400F32	●	2	32	50	PT1/8	153	98	82	GPMT11T308-U	TS4	TKY15D
	2	TAFS3400F40	●	2	40	50	PT1/4	163	98	82	GPMT11T308-U	TS4	TKY15D
	3	TAFM3400F32	●	2	32	50	PT1/8	187	132	116	GPMT11T308-U	TS4	TKY15D
	3	TAFM3400F40	●	2	40	50	PT1/4	197	132	116	GPMT11T308-U	TS4	TKY15D
	4	TAFM3400F32	●	2	32	42	PT1/8	231	166	150	GPMT11T308-U	TS4	TKY15D
	4	TAFM3400F40	●	2	40	50	PT1/4	231	166	150	GPMT11T308-U	TS4	TKY15D
35.0	2	TAFS3500F32	●	2	32	50	PT1/8	155	100	84	GPMT140408-U	TS55	TKY25D
	2	TAFS3500F40	●	2	40	50	PT1/4	165	100	84	GPMT140408-U	TS55	TKY25D
	3	TAFM3500F32	●	2	32	50	PT1/8	190	135	119	GPMT140408-U	TS55	TKY25D
	3	TAFM3500F40	●	2	40	50	PT1/4	200	135	119	GPMT140408-U	TS55	TKY25D
	4	TAFM3500F32	●	2	32	42	PT1/8	235	170	154	GPMT140408-U	TS5	TKY25D
	4	TAFM3500F40	●	2	40	50	PT1/4	235	170	154	GPMT140408-U	TS5	TKY25D
36.0	2	TAFS3600F32	●	2	32	50	PT1/8	157	102	86	GPMT140408-U	TS55	TKY25D
	2	TAFS3600F40	●	2	40	50	PT1/4	167	102	86	GPMT140408-U	TS55	TKY25D
	3	TAFM3600F32	●	2	32	50	PT1/8	193	138	122	GPMT140408-U	TS55	TKY25D
	3	TAFM3600F40	●	2	40	50	PT1/4	203	138	122	GPMT140408-U	TS55	TKY25D
	4	TAFM3600F32	●	2	32	42	PT1/8	229	174	158	GPMT140408-U	TS5	TKY25D
	4	TAFM3600F40	●	2	40	50	PT1/4	239	174	158	GPMT140408-U	TS5	TKY25D
37.0	2	TAFS3700F32	●	2	32	50	PT1/8	159	104	89	GPMT140408-U	TS55	TKY25D
	2	TAFS3700F40	●	2	40	50	PT1/4	169	104	89	GPMT140408-U	TS55	TKY25D
	3	TAFM3700F32	●	2	32	50	PT1/8	196	141	126	GPMT140408-U	TS55	TKY25D
	3	TAFM3700F40	●	2	40	50	PT1/4	206	141	126	GPMT140408-U	TS55	TKY25D
	4	TAFM3700F32	●	2	32	42	PT1/8	233	178	163	GPMT140408-U	TS5	TKY25D
	4	TAFM3700F40	●	2	40	50	PT1/4	243	178	163	GPMT140408-U	TS5	TKY25D
37.5	2	TAFS3750F32	●	2	32	50	PT1/8	159	104	89	GPMT140408-U	TS55	TKY25D
	2	TAFS3750F40	●	2	40	50	PT1/4	169	104	89	GPMT140408-U	TS55	TKY25D
	3	TAFM3750F32	●	2	32	50	PT1/8	196	141	126	GPMT140408-U	TS55	TKY25D
	3	TAFM3750F40	●	2	40	50	PT1/4	206	141	126	GPMT140408-U	TS55	TKY25D
	4	TAFM3750F32	●	2	32	42	PT1/8	233	178	163	GPMT140408-U	TS5	TKY25D
	4	TAFM3750F40	●	2	40	50	PT1/4	243	178	163	GPMT140408-U	TS5	TKY25D
38.0	2	TAFS3800F32	●	2	32	50	PT1/8	161	106	91	GPMT140408-U	TS55	TKY25D
	2	TAFS3800F40	●	2	40	50	PT1/4	171	106	91	GPMT140408-U	TS55	TKY25D
	3	TAFM3800F32	●	2	32	50	PT1/8	199	144	129	GPMT140408-U	TS55	TKY25D
	3	TAFM3800F40	●	2	40	50	PT1/4	209	144	129	GPMT140408-U	TS55	TKY25D
	4	TAFM3800F32	●	2	32	42	PT1/8	247	182	167	GPMT140408-U	TS5	TKY25D
	4	TAFM3800F40	●	2	40	50	PT1/4	247	182	167	GPMT140408-U	TS5	TKY25D

TAF DRILLS



INSERT DESCRIPTION

D089

CUTTING CONDITIONS

D090

USAGE NOTE

D092

TECHNICAL DATA

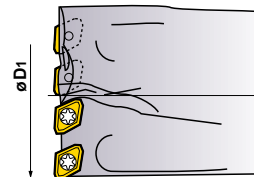
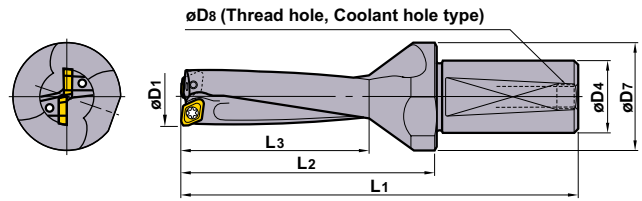
G001

D085

DRILLING (INDEXABLE TYPE)

TAFS, TAFM, TAFL

- High rigidity holder.
- 4 corner use insert.
- Various grades and chip breakers.



Number of Teeth = 4 (øD1 ≥ 49)

* The screw hole on the flange section is not a coolant hole.

DRILLING TAF DRILLS





CARBIDE

Drill Diameter D1 (mm)	Hole Depth (l/d)	Order Number	Stock	Number of Teeth	Dimensions (mm)						Insert Number	Clamp Screw	Wrench
					D4	D7	D8	L1	L2	L3			
39.0	2	TAFS3900F32	●	2	32	50	PT1/8	163	108	94	GPMT140408-U	TS55	TKY25D
	2	TAFS3900F40	●	2	40	50	PT1/4	173	108	94	GPMT140408-U	TS55	TKY25D
	3	TAFM3900F32	●	2	32	50	PT1/8	202	147	133	GPMT140408-U	TS55	TKY25D
	3	TAFM3900F40	●	2	40	50	PT1/4	212	147	133	GPMT140408-U	TS55	TKY25D
	4	TAFL3900F32	●	2	32	42	PT1/8	251	186	172	GPMT140408-U	TS5	TKY25D
	4	TAFL3900F40	●	2	40	50	PT1/4	251	186	172	GPMT140408-U	TS5	TKY25D
40.0	2	TAFS4000F32	●	2	32	50	PT1/8	165	110	96	GPMT140408-U	TS55	TKY25D
	2	TAFS4000F40	●	2	40	50	PT1/4	175	110	96	GPMT140408-U	TS55	TKY25D
	3	TAFM4000F32	●	2	32	50	PT1/8	205	150	136	GPMT140408-U	TS55	TKY25D
	3	TAFM4000F40	●	2	40	50	PT1/4	215	150	136	GPMT140408-U	TS55	TKY25D
	4	TAFL4000F32	●	2	32	42	PT1/8	245	190	176	GPMT140408-U	TS5	TKY25D
	4	TAFL4000F40	●	2	40	50	PT1/4	255	190	176	GPMT140408-U	TS5	TKY25D
41.0	2	TAFS4100F40	●	2	40	50	PT1/4	177	112	98	GPMT140408-U	TS55	TKY25D
	3	TAFM4100F40	●	2	40	50	PT1/4	218	153	139	GPMT140408-U	TS55	TKY25D
	4	TAFL4100F40	●	2	40	50	PT1/4	259	194	180	GPMT140408-U	TS5	TKY25D
42.0	2	TAFS4200F40	●	2	40	50	PT1/4	179	114	101	GPMT140408-U	TS55	TKY25D
	3	TAFM4200F40	●	2	40	50	PT1/4	221	156	143	GPMT140408-U	TS55	TKY25D
	4	TAFL4200F40	●	2	40	50	PT1/4	263	198	185	GPMT140408-U	TS5	TKY25D
43.0	2	TAFS4300F40	●	2	40	50	PT1/4	181	116	103	GPMT140408-U	TS55	TKY25D
	3	TAFM4300F40	●	2	40	50	PT1/4	224	159	146	GPMT140408-U	TS55	TKY25D
	4	TAFL4300F40	●	2	40	50	PT1/4	267	202	189	GPMT140408-U	TS5	TKY25D
44.0	2	TAFS4400F40	●	2	40	50	PT1/4	183	118	106	GPMT140408-U	TS55	TKY25D
	3	TAFM4400F40	●	2	40	50	PT1/4	227	162	150	GPMT140408-U	TS55	TKY25D
	4	TAFL4400F40	●	2	40	50	PT1/4	271	206	194	GPMT140408-U	TS5	TKY25D
45.0	2	TAFS4500F40	●	2	40	54	PT1/4	185	120	108	GPMT140408-U	TS55	TKY25D
	3	TAFM4500F40	●	2	40	54	PT1/4	230	165	153	GPMT140408-U	TS55	TKY25D
	4	TAFL4500F40	●	2	40	54	PT1/4	275	210	198	GPMT140408-U	TS5	TKY25D
46.0	2	TAFS4600F40	●	2	40	54	PT1/4	187	122	110	GPMT140408-U	TS55	TKY25D
	3	TAFM4600F40	●	2	40	54	PT1/4	233	168	156	GPMT140408-U	TS55	TKY25D
	4	TAFL4600F40	●	2	40	54	PT1/4	279	214	202	GPMT140408-U	TS5	TKY25D

● : Inventory maintained.

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

D086

Drill Diameter D1 (mm)	Hole Depth (l/d)	Order Number	Stock	Number of Teeth	Dimensions (mm)						Insert Number		
					D4	D7	D8	L1	L2	L3			
47.0	2	TAFS4700F40	●	2	40	54	PT1/4	189	124	113	GPMT140408-U	TS55	②TKY25D
	3	TAFM4700F40	●	2	40	54	PT1/4	236	171	160	GPMT140408-U	TS55	②TKY25D
	4	TAFL4700F40	●	2	40	54	PT1/4	283	218	207	GPMT140408-U	TS5	②TKY25D
48.0	2	TAFS4800F40	●	2	40	54	PT1/4	191	126	115	GPMT140408-U	TS55	②TKY25D
	3	TAFM4800F40	●	2	40	54	PT1/4	239	174	163	GPMT140408-U	TS55	②TKY25D
	4	TAFL4800F40	●	2	40	54	PT1/4	287	222	211	GPMT140408-U	TS5	②TKY25D
49.0	2	TAFS4900F40	●	4	40	58	PT1/4	198	133	118	GPMT090304-U	TS3	①TKY08F
	3	TAFM4900F40	●	4	40	58	PT1/4	247	182	167	GPMT090304-U	TS3	①TKY08F
	4	TAFL4900F40	●	4	40	58	PT1/4	296	231	216	GPMT090304-U	TS3	①TKY08F
50.0	2	TAFS5000F40	▲*	4	40	58	PT1/4	200	135	120	GPMT090304-U	TS3	①TKY08F
	3	TAFM5000F40	▲*	4	40	58	PT1/4	250	185	170	GPMT090304-U	TS3	①TKY08F
	4	TAFL5000F40	▲*	4	40	58	PT1/4	300	235	220	GPMT090304-U	TS3	①TKY08F
51.0	2	TAFS5100F40	▲*	4	40	58	PT1/4	202	137	122	GPMT090304-U	TS3	①TKY08F
	3	TAFM5100F40	▲*	4	40	58	PT1/4	253	188	173	GPMT090304-U	TS3	①TKY08F
	4	TAFL5100F40	▲*	4	40	58	PT1/4	304	239	224	GPMT090304-U	TS3	①TKY08F
52.0	2	TAFS5200F40	▲*	4	40	58	PT1/4	204	139	125	GPMT090304-U	TS3	①TKY08F
	3	TAFM5200F40	▲*	4	40	58	PT1/4	256	191	177	GPMT090304-U	TS3	①TKY08F
	4	TAFL5200F40	▲*	4	40	58	PT1/4	308	243	229	GPMT090304-U	TS3	①TKY08F
53.0	2	TAFS5300F40	▲*	4	40	63	PT1/4	206	141	127	GPMT090304-U	TS3	①TKY08F
	3	TAFM5300F40	▲*	4	40	63	PT1/4	259	194	180	GPMT090304-U	TS3	①TKY08F
	4	TAFL5300F40	▲*	4	40	63	PT1/4	312	247	233	GPMT090304-U	TS3	①TKY08F
54.0	2	TAFS5400F40	▲*	4	40	63	PT1/4	208	143	128	GPMT090304-U	TS3	①TKY08F
	3	TAFM5400F40	▲*	4	40	63	PT1/4	262	197	182	GPMT090304-U	TS3	①TKY08F
	4	TAFL5400F40	▲*	4	40	63	PT1/4	316	251	236	GPMT090304-U	TS3	①TKY08F
55.0	2	TAFS5500F40	▲*	4	40	63	PT1/4	210	145	130	GPMT090304-U	TS3	①TKY08F
	3	TAFM5500F40	▲*	4	40	63	PT1/4	265	200	185	GPMT090304-U	TS3	①TKY08F
	4	TAFL5500F40	▲*	4	40	63	PT1/4	320	255	240	GPMT090304-U	TS3	①TKY08F
56.0	2	TAFS5600F40	▲*	4	40	63	PT1/4	212	147	132	GPMT090304-U	TS3	①TKY08F
	3	TAFM5600F40	▲*	4	40	63	PT1/4	268	203	188	GPMT090304-U	TS3	①TKY08F
	4	TAFL5600F40	▲*	4	40	63	PT1/4	324	259	244	GPMT090304-U	TS3	①TKY08F

(Note) * Items with an asterisk (*) will be replaced by the products on page D088.

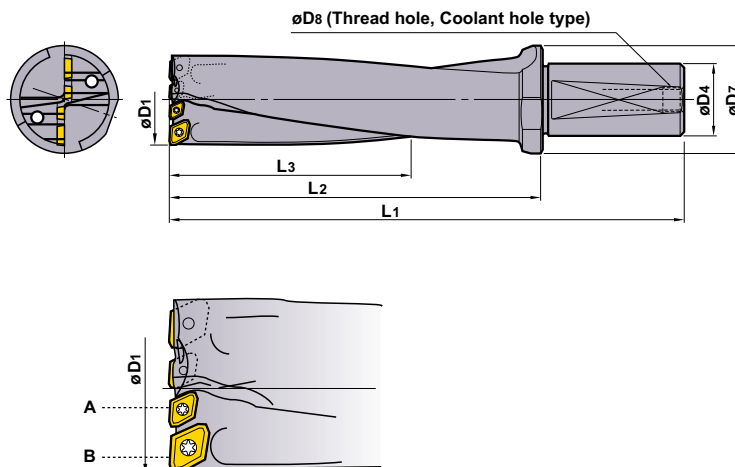
DRILLING (INDEXABLE TYPE)

TAFS, TAFM, TAFL



- High rigidity holder.
- 4 corner use insert.
- Various grades and chip breakers.

● Increased Rigidity Type

NEW



* The screw hole on the flange section is not a coolant hole.

Drill Diameter D1 (mm)	Hole Depth (l/d)	Order Number	Stock	Number of Teeth	Dimensions (mm)						Inner / Outer type	Insert Number	 Clamp Screw	 Wrench
					D4	D7	D8	L1	L2	L3				
50.0	2	TAFS5000F40-E	●	4	40	58	PT1/4	200	135	120	A	GPMT090304-U	TS3	①TKY08F
											B	GPMT11T308-U	TS4	②TKY15D
	3	TAFM5000F40-E	●	4	40	58	PT1/4	250	185	170	A	GPMT090304-U	TS3	①TKY08F
											B	GPMT11T308-U	TS4	②TKY15D
51.0	2	TAFS5100F40-E	●	4	40	58	PT1/4	202	137	122	A	GPMT090304-U	TS3	①TKY08F
											B	GPMT11T308-U	TS4	②TKY15D
	3	TAFM5100F40-E	●	4	40	58	PT1/4	253	188	173	A	GPMT090304-U	TS3	①TKY08F
											B	GPMT11T308-U	TS4	②TKY15D
52.0	2	TAFS5200F40-E	●	4	40	58	PT1/4	204	139	125	A	GPMT090304-U	TS3	①TKY08F
											B	GPMT11T308-U	TS4	②TKY15D
	3	TAFM5200F40-E	●	4	40	58	PT1/4	256	191	177	A	GPMT090304-U	TS3	①TKY08F
											B	GPMT11T308-U	TS4	②TKY15D
53.0	2	TAFS5300F40-E	●	4	40	63	PT1/4	206	141	127	A	GPMT11T308-U	TS4	②TKY15D
	3	TAFM5300F40-E	●	4	40	63	PT1/4	259	194	180	A	GPMT11T308-U	TS4	②TKY15D
	4	TAFS5300F40-E	●	4	40	63	PT1/4	312	247	233	A	GPMT11T308-U	TS4	②TKY15D
	54.0	2	TAFS5400F40-E	●	4	40	63	PT1/4	208	134	128	A	GPMT11T308-U	TS4
3		TAFM5400F40-E	●	4	40	63	PT1/4	262	197	182	A	GPMT11T308-U	TS4	②TKY15D
4		TAFS5400F40-E	●	4	40	63	PT1/4	316	251	236	A	GPMT11T308-U	TS4	②TKY15D
55.0		2	TAFS5500F40-E	●	4	40	63	PT1/4	210	145	130	A	GPMT11T308-U	TS4
	3	TAFM5500F40-E	●	4	40	63	PT1/4	265	200	185	A	GPMT11T308-U	TS4	②TKY15D
	4	TAFS5500F40-E	●	4	40	63	PT1/4	320	255	240	A	GPMT11T308-U	TS4	②TKY15D
	56.0	2	TAFS5600F40-E	●	4	40	63	PT1/4	212	147	132	A	GPMT11T308-U	TS4
3		TAFM5600F40-E	●	4	40	63	PT1/4	268	203	188	A	GPMT11T308-U	TS4	②TKY15D
4		TAFS5600F40-E	●	4	40	63	PT1/4	324	259	244	A	GPMT11T308-U	TS4	②TKY15D

DRILLING TAF DRILLS

CARBIDE

D088

● : Inventory maintained.

INSERT DESCRIPTION [D089](#)

CUTTING CONDITIONS [D090](#)

USAGE NOTE [D092](#)

TECHNICAL DATA [G001](#)

INSERTS

Geometry	Drill Dia.	Insert Number	Dimensions (mm)			Stock					
			D1	S1	Re	NEW VP15TF	UP20M	GP20M	UE6020	US735	F5010
U1 Breaker 	ø12-ø14.5	GCMT040204-U1	5.0	2.38	0.4		●				
	ø15-ø17.5	GPMT060204-U1	5.56	2.38	0.4		●		●	●	●
	ø18-ø22.5	GPMT070204-U1	6.35	2.38	0.4		●		●	●	●
	ø23-ø27.5 ø49-ø56	GPMT090304-U1	7.94	3.18	0.4		●		●	●	●
	ø28-ø34	GPMT11T308-U1	9.525	3.97	0.8		●		●	●	●
	ø35-ø48	GPMT140408-U1	12.70	4.76	0.8		●		●	●	●
U2 Breaker 	ø12-ø14.5	GCMT040204-U2	5.0	2.38	0.4	●		●			
	ø15-ø17.5	GPMT060204-U2	5.56	2.38	0.4	●	●		●	●	●
	ø18-ø22.5	GPMT070204-U2	6.35	2.38	0.4	●	●		●	●	●
	ø23-ø27.5 ø49-ø56	GPMT090304-U2	7.94	3.18	0.4	●	●		●	●	●
	ø28-ø34	GPMT11T308-U2	9.525	3.97	0.8	●	●		●	●	●
	ø35-ø48	GPMT140408-U2	12.70	4.76	0.8	●	●		●	●	●
U3 Breaker 	ø15-ø17.5	GPMT060204-U3	5.56	2.38	0.4		●		●	●	●
	ø18-ø22.5	GPMT070204-U3	6.35	2.38	0.4		●		●	●	●
	ø23-ø27.5 ø49-ø56	GPMT090304-U3	7.94	3.18	0.4		●		●	●	●
	ø28-ø34	GPMT11T308-U3	9.525	3.97	0.8		●		●	●	●
	ø35-ø48	GPMT140408-U3	12.70	4.76	0.8		●		●	●	●

INSERT RECOMMENDATION

CHIP BREAKER RECOMMENDATION

◎ : 1st Recommendation ○ : 2nd Recommendation

Work Material	P						M		K			
	Mild Steel		Carbon Steel		Alloy Steel		Stainless Steel		Cast Iron		Ductile Cast Iron	
	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT
Breaker U1	◎	◎	○	○	○	○	○	○	○	○	○	○
U2	○	○	◎	○	◎	○	◎	◎	◎	○	◎	○
U3		○		◎		◎		○		◎		◎

INSERT GRADE RECOMMENDATION

◎ : 1st Recommendation ○ : 2nd Recommendation

Work Material	P						M		K			
	Mild Steel		Carbon Steel		Alloy Steel		Stainless Steel		Cast Iron		Ductile Cast Iron	
	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT
VP15TF	○	○	◎	○	◎	○	◎	◎	◎	○	◎	○
UP20M	◎	◎	○	○	○	○	○	○	○	○	○	◎
GP20M	○		◎		◎		◎		◎		◎	
UE6020		○		◎		◎		○		○		○
US735		○		○		○		◎		○		○
F5010										◎		◎