PRODUCT NEWS

No. 541

DIJET®

"Indexable EZ DRILL" TEZD type

JCTMA 2013-006 ECO PRODUCT ★★★

穴あけ加工

SERIES EXPANSION

■TEZD-MS (3D):φ13.5～φ32.5
■TEZD-ML (5D):φ13.5～φ32.5
■TEZD-XL (8D):φ13.5～φ32.5
■TEZD-MT (4D):φ13.5～φ32.5
■TEZD-KMS (3D):φ24.5～φ26.7

NEW ■TEZD*F-MS (3D):φ13.5～φ32.5
NEW ■TEZD*F-ML (5D):φ13.5～φ32.5
NEW ■TEZD*F-XL (8D):φ13.5～φ32.5

"Indexable EZ DRILL" achieved easy assembly and high cutting performance.

Line up

Fig.1

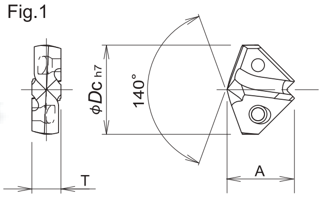
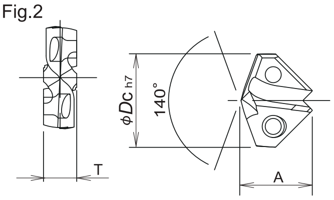
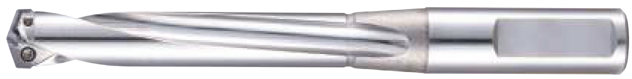


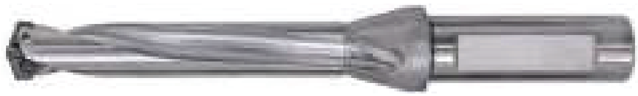
Fig.2



● MS type (3D) / ML type (5D)



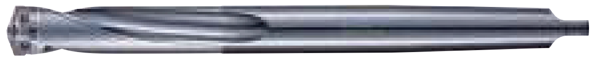
NEW ● TEZD*F-MS type (3D) / ML type (5D)



● XL type (8D)

NEW ● TEZD*F-XL type (8D)

● TEZD-MT



■Body

Applicable dia.	Tool No.	Stock	L/D	Dimensions (mm) ℓ	ℓ2	ℓs	L	φDs	φDf	MT	List Price (JPY)
13.5 Over	TEZD1400S16-MS	●	3	51	65	48	113	16	—	—	33,550
	NEW TEZD1400S16F-MS	●	3	51	65	48	113	16	20	—	40,300
	TEZD1400S16-ML	●	5	80	97	48	145	16	—	—	40,260
	NEW TEZD1400S16F-ML	●	5	80	97	48	145	16	20	—	48,300
14.5 Or under	TEZD1400S16-XL	●	8	119	133	48	181	16	—	—	60,390
	NEW TEZD1400S16F-XL	●	8	119	133	48	181	16	20	—	72,500
	TEZD1400MT1	●	4	71	—	—	205	—	—	MT1	52,360
14.5 Over	TEZD1500S20-MS	●	3	54	69	50	119	20	—	—	35,750
	NEW TEZD1500S20F-MS	●	3	54	69	50	119	20	24.9	—	42,900
	TEZD1500S20-ML	●	5	85	103	50	153	20	—	—	42,900
	NEW TEZD1500S20F-ML	●	5	85	103	50	153	20	24.9	—	51,500
15.5 Or under	TEZD1500S20-XL	●	8	128	143	50	193	20	—	—	64,350
	NEW TEZD1500S20F-XL	●	8	128	143	50	193	20	24.9	—	77,300
	TEZD1500MT2	●	4	76	—	—	228	—	—	MT2	55,770
15.5 Over	TEZD1600S20-MS	●	3	58	74	50	124	20	—	—	35,750
	NEW TEZD1600S20F-MS	●	3	58	74	50	124	20	24.9	—	42,900
	TEZD1600S20-ML	●	5	91	110	50	160	20	—	—	42,900
	NEW TEZD1600S20F-ML	●	5	91	110	50	160	20	24.9	—	51,500
16.5 Or under	TEZD1600S20-XL	●	8	136	152	50	202	20	—		64,350
	NEW TEZD1600S20F-XL	●	8	136	152	50	202	20	24.9	—	77,300
16.5 Over	TEZD1700S20-MS	●	3	61	78	50	128	20	—	—	35,750
	NEW TEZD1700S20F-MS	●	3	61	78	50	128	20	24.9	—	42,900
	TEZD1700S20-ML	●	5	96	117	50	167	20	—	—	42,900
	NEW TEZD1700S20F-ML	●	5	96	117	50	167	20	24.9	—	51,500
17.5 Or under	TEZD1700S20-XL	●	8	145	162	50	212	20	—	—	64,350
	NEW TEZD1700S20F-XL	●	8	145	162	50	212	20	24.9	—	77,300
	TEZD1700MT2	●	4	86	—	—	240	—	—	MT2	55,770
17.5 Over	TEZD1800S20-MS	●	3	65	83	50	133	20	—	—	35,750
	NEW TEZD1800S20F-MS	●	3	65	83	50	133	20	24.9	—	42,900
	TEZD1800S20-ML	●	5	102	123	50	173	20	—	—	42,900
	NEW TEZD1800S20F-ML	●	5	102	123	50	173	20	24.9	—	51,500
18.5 Or under	TEZD1800S20-XL	●	8	153	171	50	221	20	—	—	64,350
	NEW TEZD1800S20F-XL	●	8	153	171	50	221	20	24.9	—	77,300
	TEZD1800MT2	●	4	91	—	—	240	—	—	MT2	55,770

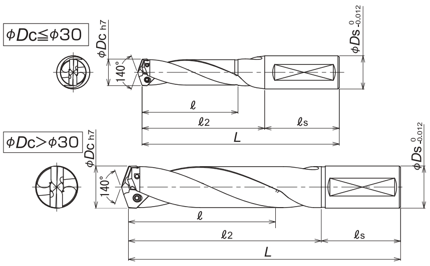
■Insert

(mm) Drill dia.	(Fig.1) PVDcoated JC8050 Insert No.	Stock	NEW (Fig.2) PVDcoated JC7515 Insert No.	Stock	(mm) Dimensions A	T	List Price (JPY)	Parts Clamp screw	Wrench (not be included)
13.5	NEW TEZ1350	●	TEZ1350S	●	11.4	4.5	8,800	DSW-2045H	A-07
13.6	TEZ1360	●	TEZ1360S	●			8,800		
13.7	NEW TEZ1370	●	TEZ1370S	●			8,800		
13.8	TEZ1380	●	TEZ1380S	●			8,800		
13.9	NEW TEZ1390	●	TEZ1390S	●			8,800		
14.0	TEZ1400	●	TEZ1400S	●			8,800		
14.1	TEZ1410	●	TEZ1410S	●			8,800		
14.2	TEZ1420	●	TEZ1420S	●			8,800		
14.3	TEZ1430	●	TEZ1430S	●			8,800		
14.4	TEZ1440	●	TEZ1440S	●			8,800		
14.5	TEZ1450	●	TEZ1450S	●			8,800		
14.6	TEZ1460	●	TEZ1460S	●	11.5	4.8	9,020	DSW-2045H	A-07
14.7	TEZ1470	●	TEZ1470S	●			9,020		
14.8	TEZ1480	●	TEZ1480S	●			9,020		
14.9	TEZ1490	●	TEZ1490S	●			9,020		
15.0	TEZ1500	●	TEZ1500S	●			9,020		
15.1	TEZ1510	●	TEZ1510S	●			9,020		
15.2	TEZ1520	●	TEZ1520S	●			9,020		
15.3	TEZ1530	●	TEZ1530S	●			9,020		
15.4	TEZ1540	●	TEZ1540S	●			9,020		
15.5	TEZ1550	●	TEZ1550S	●			9,020		
15.6	TEZ1560	●	TEZ1560S	●	12.4	5.0	9,020	TSW-2556H	A-08
15.7	TEZ1570	●	TEZ1570S	●			9,020		
15.8	TEZ1580	●	TEZ1580S	●			9,020		
15.9	TEZ1590	●	TEZ1590S	●			9,020		
16.0	TEZ1600	●	TEZ1600S	●			9,020		
16.1	TEZ1610	●	TEZ1610S	●			9,020		
16.2	TEZ1620	●	TEZ1620S	●			9,020		
16.3	TEZ1630	●	TEZ1630S	●			9,020		
16.4	TEZ1640	●	TEZ1640S	●			9,020		
16.5	TEZ1650	●	TEZ1650S	●			9,020		
16.6	TEZ1660	●	TEZ1660S	●	13.2	5.5	9,900	TSW-2556H	A-08
16.7	TEZ1670	●	TEZ1670S	●			9,900		
16.8	TEZ1680	●	TEZ1680S	●			9,900		
16.9	TEZ1690	●	TEZ1690S	●			9,900		
17.0	TEZ1700	●	TEZ1700S	●			9,900		
17.1	TEZ1710	●	TEZ1710S	●			9,900		
17.2	TEZ1720	●	TEZ1720S	●			9,900		
17.3	TEZ1730	●	TEZ1730S	●			9,900		
17.4	TEZ1740	●	TEZ1740S	●			9,900		
17.5	TEZ1750	●	TEZ1750S	●			9,900		
17.6	TEZ1760	●	TEZ1760S	●	13.5	5.8	9,900	TSW-2556H	A-08
17.7	TEZ1770	●	TEZ1770S	●			9,900		
17.8	TEZ1780	●	TEZ1780S	●			9,900		
17.9	TEZ1790	●	TEZ1790S	●			9,900		
18.0	TEZ1800	●	TEZ1800S	●			9,900		
18.1	TEZ1810	●	TEZ1810S	●			9,900		
18.2	TEZ1820	●	TEZ1820S	●			9,900		
18.3	TEZ1830	●	TEZ1830S	●			9,900		
18.4	TEZ1840	●	TEZ1840S	●			9,900		
18.5	TEZ1850	●	TEZ1850S	●			9,900		

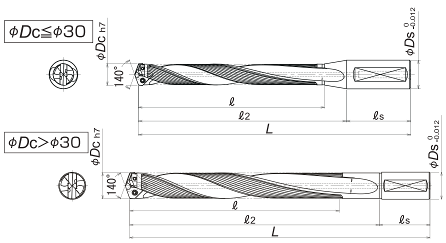
1 insert per case.

●: Standard stock items

MS type (3D) / ML type (5D)

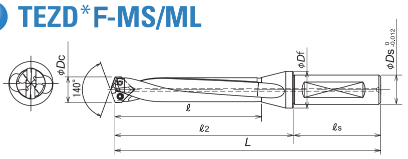


XL type (8D)

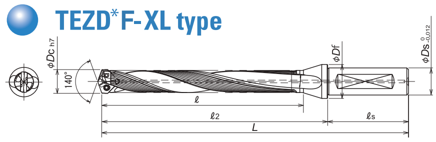


Clamp screw	(N·m) Recommended torque
DSW-2045H	0.9
TSW-2556H	1.2
TSW-2567H	1.2
DSW-307H	2.1
DSW-309H	2.1
TSW-3510H	3.0
TSW-3512H	3.0

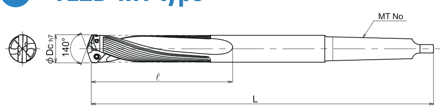
TEZD*F-MS/ML



TEZD*F-XL type



TEZD-MT type



■ Body

Applicable dia.	Tool No.	Stock	L/D	Dimensions (mm) ℓ	ℓ2	ℓs	L	φDs	φDf	MT	List Price (JPY)
18.5 Over	TEZD1900S25-MS	●	3	68	87	56	143	25	—	—	39,380
	NEW TEZD1900S25F-MS	●	3	68	87	56	143	25	32	—	47,300
	TEZD1900S25-ML	●	5	107	130	56	186	25	—	—	47,300
19.5 Or under	NEW TEZD1900S25F-ML	●	5	107	130	56	186	25	32	—	56,800
	TEZD1900S25-XL	●	8	162	181	56	237	25	—	—	70,840
	NEW TEZD1900S25F-XL	●	8	162	181	56	237	25	32	—	85,100
19.5 Over	TEZD2000S25-MS	●	3	72	92	56	148	25	—	—	39,380
	NEW TEZD2000S25F-MS	●	3	72	92	56	148	25	32	—	47,300
	TEZD2000S25-ML	●	5	113	137	56	193	25	—	—	47,300
20.5 Or under	NEW TEZD2000S25F-ML	●	5	113	137	56	193	25	32	—	56,800
	TEZD2000S25-XL	●	8	170	190	56	246	25	—	—	70,840
	NEW TEZD2000S25F-XL	●	8	170	190	56	246	25	32	—	85,100
20.5 Over	TEZD2100S25-MS	●	3	75	96	56	152	25	—	—	39,380
	NEW TEZD2100S25F-MS	●	3	75	96	56	152	25	32	—	47,300
	TEZD2100S25-ML	●	5	118	143	56	199	25	—	—	47,300
	NEW TEZD2100S25F-ML	●	5	118	143	56	199	25	32	—	56,800
21.5 Or under	TEZD2100S25-XL	●	8	179	200	56	256	25	—	—	70,840
	NEW TEZD2100S25F-XL	●	8	179	200	56	256	25	32	—	85,100
	TEZD2100MT2	●	4	105	—	—	255	—	—	MT2	61,490
21.5 Over	TEZD2200S25-MS	●	3	79	101	56	157	25	—	—	39,380
	NEW TEZD2200S25F-MS	●	3	79	101	56	157	25	32	—	47,300
	TEZD2200S25-ML	●	5	124	150	56	206	25	—	—	47,300
	NEW TEZD2200S25F-ML	●	5	124	150	56	206	25	32	—	56,800
22.5 Or under	TEZD2200S25- XL	●	8	187	209	56	265	25	—	—	70,840
	NEW TEZD2200S25F-XL	●	8	187	209	56	265	25	32	—	85,100
	TEZD2200MT2	●	4	111	—	—	260	—	—	MT2	61,490
22.5 Over	TEZD2300S25-MS	●	3	82	105	56	161	25	—	—	39,380
	NEW TEZD2300S25F-MS	●	3	82	105	56	161	25	32	—	47,300
	TEZD2300S25-ML	●	5	129	157	56	213	25	—	—	47,300
23.5 Or under	NEW TEZD2300S25F-ML	●	5	129	157	56	213	25	32	—	56,800
	TEZD2300S25-XL	●	8	196	219	56	275	25	—	—	70,840
	NEW TEZD2300S25F-XL	●	8	196	219	56	275	25	32	—	85,100

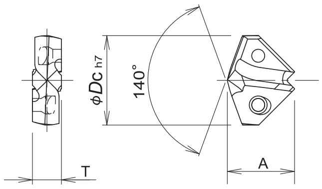
■ Insert

(mm) Drill dia.	(Fig.1) PVDcoated JC8050 Insert No.	Stock	NEW (Fig.2) PVDcoated JC7515 Insert No.	Stock	(mm) Dimensions A	T	List Price (JPY)	Parts Clamp screw	Wrench (not be included)
18.6	TEZ1860	●	TEZ1860S	●	14.2	6.0	9,900	TSW-2567H	A-08
18.7	TEZ1870	●	TEZ1870S	●			9,900		
18.8	TEZ1880	●	TEZ1880S	●			9,900		
18.9	TEZ1890	●	TEZ1890S	●			9,900		
19.0	TEZ1900	●	TEZ1900S	●			9,900		
19.1	TEZ1910	●	TEZ1910S	●			9,900		
19.2	TEZ1920	●	TEZ1920S	●			9,900		
19.3	TEZ1930	●	TEZ1930S	●			9,900		
19.4	TEZ1940	●	TEZ1940S	●			9,900		
19.5	TEZ1950	●	TEZ1950S	●			9,900		
19.6	TEZ1960	●	TEZ1960S	●	15.1	6.5	9,900	TSW-2567H	A-08
19.7	TEZ1970	●	TEZ1970S	●			9,900		
19.8	TEZ1980	●	TEZ1980S	●			9,900		
19.9	TEZ1990	●	TEZ1990S	●			9,900		
20.0	TEZ2000	●	TEZ2000S	●			9,900		
20.1	TEZ2010	●	—	—			9,900		
20.2	NEW TEZ2020	●	—	—			9,900		
20.3	NEW TEZ2030	●	—	—			9,900		
20.4	NEW TEZ2040	●	—	—			9,900		
20.5	TEZ2050	●	—	—			9,900		
20.6	TEZ2060	●	—	—	15.7	6.7	11,000	TSW-2567H	A-08
20.7	NEW TEZ2070	●	—	—			11,000		
20.8	NEW TEZ2080	●	—	—			11,000		
20.9	NEW TEZ2090	●	—	—			11,000		
21.0	TEZ2100	●	—	—			11,000		
21.1	TEZ2110	●	—	—			11,000		
21.2	TEZ2120	●	—	—			11,000		
21.3	NEW TEZ2130	●	—	—			11,000		
21.4	NEW TEZ2140	●	—	—			11,000		
21.5	TEZ2150	●	—	—			11,000		
21.6	TEZ2160	●	—	—	16.6	7.5	11,000	DSW-307H	A-10
21.7	NEW TEZ2170	●	—	—			11,000		
21.8	NEW TEZ2180	●	—	—			11,000		
21.9	TEZ2190	●	—	—			11,000		
22.0	TEZ2200	●	—	—			11,000		
22.1	TEZ2210	●	—	—			11,000		
22.2	NEW TEZ2220	●	—	—			11,000		
22.3	TEZ2230	●	—	—			11,000		
22.4	NEW TEZ2240	●	—	—			11,000		
22.5	TEZ2250	●	—	—			11,000		
22.6	TEZ2260	●	—	—	17.4	7.5	11,000	DSW-307H	A-10
22.7	TEZ2270	●	—	—			11,000		
22.8	NEW TEZ2280	●	—	—			11,000		
22.9	NEW TEZ2290	●	—	—			11,000		
23.0	TEZ2300	●	—	—			11,000		
23.1	TEZ2310	●	—	—			11,000		
23.2	NEW TEZ2320	●	—	—			11,000		
23.3	NEW TEZ2330	●	—	—			11,000		
23.4	NEW TEZ2340	●	—	—			11,000		
23.5	TEZ2350	●	—	—			11,000		

1 insert per case.
List price is as of November 2022.

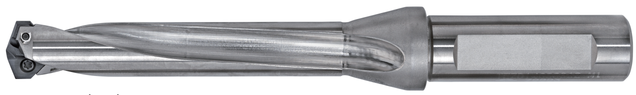
●: Standard stock items

Line up



● MS type (3D) / ML type (5D)

NEW ● TEZDF-MS type (3D) / ML type (5D)



● XL type (8D)

NEW ● TEZDF-XL type (8D)

● TEZD-MT

■ Body

Applicable dia.	Tool No.	Stock	L/D	Dimensions (mm) ℓ	ℓ2	ℓs	L	φDs	φDf	MT	List Price (JPY)
23.5 Over	TEZD2400S32-MS	●	3	86	110	60	170	32	—	—	41,580
	NEW TEZD2400S32F-MS	●	3	86	110	60	170	32	41.9	—	50,000
	TEZD2400S32-ML	●	5	135	164	60	224	32	—	—	49,940
24.5 Or under	NEW TEZD2400S32F-ML	●	5	135	164	60	224	32	41.9	—	60,000
	TEZD2400S32-XL	●	8	204	228	60	288	32	—	—	74,800
	NEW TEZD2400S32F-XL	●	8	204	228	60	288	32	41.9	—	89,800
24.5 Over	TEZD2500S32-MS	●	3	89	114	60	174	32	—	—	41,580
	NEW TEZD2500S32F-MS	●	3	89	114	60	174	32	41.9	—	50,000
	TEZD2500S32-ML	●	5	140	170	60	230	32	—	—	49,940
	NEW TEZD2500S32F-ML	●	5	140	170	60	230	32	41.9	—	60,000
25.5 Or under	TEZD2500S32-XL	●	8	213	238	60	298	32	—	—	74,800
	NEW TEZD2500S32F-XL	●	8	213	238	60	298	32	41.9	—	89,800
	TEZD2500MT3	●		124	—	—	285	—	—	MT3	65,010
25.5 Over	TEZD2600S32-MS	●	3	93	119	60	179	32	—	—	41,580
	NEW TEZD2600S32F-MS	●	3	93	119	60	179	32	41.9	—	50,000
	TEZD2600S32-ML	●	5	146	177	60	237	32	—	—	49,940
	NEW TEZD2600S32F-ML	●	5	146	177	60	237	32	41.9	—	60,000
26.5 Or under	TEZD2600S32-XL	●	8	221	247	60	307	32	—	—	74,800
	NEW TEZD2600S32F-XL	●	8	221	247	60	307	32	41.9	—	89,800
	TEZD2600MT3	●	4	130	—	—	290	—	—	MT3	65,010
26.5 Over	TEZD2700S32-MS	●	3	96	123	60	183	32	—	—	41,580
	NEW TEZD2700S32F-MS	●	3	96	123	60	183	32	41.9	—	50,000
	TEZD2700S32-ML	●	5	151	184	60	244	32	—	—	49,940
27.5 Or under	NEW TEZD2700S32F-ML	●	5	151	184	60	244	32	41.9	—	60,000
	TEZD2700S32-XL	●	8	230	257	60	317	32	—	—	74,800
	NEW TEZD2700S32F-XL	●	8	230	257	60	317	32	41.9	—	89,000
27.5 Over	TEZD2800S32-MS	●	3	100	128	60	188	32	—	—	41,580
	NEW TEZD2800S32F-MS	●	3	100	128	60	188	32	41.9	—	50,000
	TEZD2800S32-ML	●	5	157	190	60	250	32	—	—	49,940
	NEW TEZD2800S32F-ML	●	5	157	190	60	250	32	41.9	—	60,000
28.5 Or under	TEZD2800S32-XL	●	8	238	266	60	326	32	—	—	74,800
	NEW TEZD2800S32F-XL	●	8	238	266	60	326	32	41.9	—	89,800

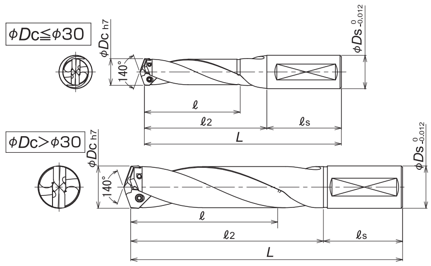
■ Insert

(mm) Drill dia.	(Fig.1) PVDcoated JC8050 Insert No.	Stock	(mm) Dimensions A	T	List Price (JPY)	Parts Clamp screw	Wrench (not be included)
23.6	TEZ2360	●	18.2	8.0	11,000	DSW-307H	A-10
23.7	NEW TEZ2370	●			11,000		
23.8	NEW TEZ2380	●			11,000		
23.9	NEW TEZ2390	●			11,000		
24.0	TEZ2400	●			11,000		
24.1	TEZ2410	●			11,000		
24.2	TEZ2420	●			11,000		
24.3	NEW TEZ2430	●			11,000		
24.4	NEW TEZ2440	●			11,000		
24.5	TEZ2450	●			11,000		
24.6	NEW TEZ2460	●	19.1	8.0	12,100	DSW-309H	A-10
24.7	NEW TEZ2470	●			12,100		
24.8	NEW TEZ2480	●			12,100		
24.9	NEW TEZ2490	●			12,100		
25.0	TEZ2500	●			12,100		
25.1	TEZ2510	●			12,100		
25.2	NEW TEZ2520	●			12,100		
25.3	NEW TEZ2530	●			12,100		
25.4	NEW TEZ2540	●			12,100		
25.5	TEZ2550	●			12,100		
25.6	TEZ2560	●	19.7	8.5	12,100	DSW-309H	A-10
25.7	TEZ2570	●			12,100		
25.8	NEW TEZ2580	●			12,100		
25.9	NEW TEZ2590	●			12,100		
26.0	TEZ2600	●			12,100		
26.1	TEZ2610	●			12,100		
26.2	NEW TEZ2620	●			12,100		
26.3	NEW TEZ2630	●			12,100		
26.4	NEW TEZ2640	●			12,100		
26.5	TEZ2650	●			12,100		
26.6	TEZ2660	●	20.4	8.5	12,100	TSW-3510H	A-15
26.7	TEZ2670	●			12,100		
26.8	NEW TEZ2680	●			12,100		
26.9	NEW TEZ2690	●			12,100		
27.0	TEZ2700	●			12,100		
27.1	TEZ2710	●			12,100		
27.2	NEW TEZ2720	●			12,100		
27.3	NEW TEZ2730	●			12,100		
27.4	TEZ2740	●			12,100		
27.5	TEZ2750	●			12,100		
27.6	NEW TEZ2760	●	21.2	9.0	13,310	TSW-3510H	A-15
27.7	NEW TEZ2770	●			13,310		
27.8	NEW TEZ2780	●			13,310		
27.9	NEW TEZ2790	●			13,310		
28.0	TEZ2800	●			13,310		
28.1	TEZ2810	●			13,310		
28.2	NEW TEZ2820	●			13,310		
28.3	NEW TEZ2830	●			13,310		
28.4	NEW TEZ2840	●			13,310		
28.5	TEZ2850	●			13,310		

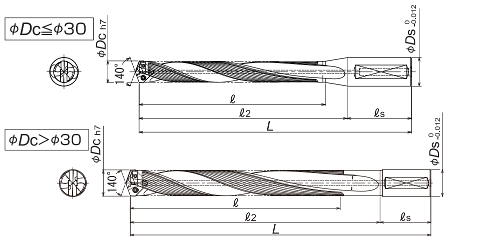
●: Standard stock items

1 insert per case.
List price is as of November 2022.

MS type (3D) / ML type (5D)

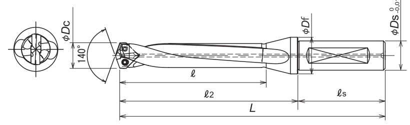


XL type (8D)

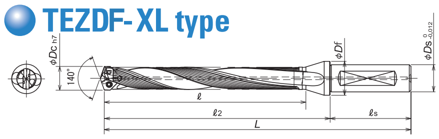


Clamp screw	(N・m) Recommended torque
DSW-2045H	0.9
TSW-2556H	1.2
TSW-2567H	1.2
DSW-307H	2.1
DSW-309H	2.1
TSW-3510H	3.0
TSW-3512H	3.0

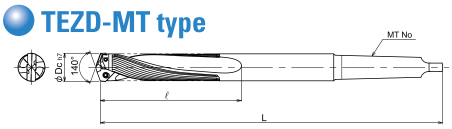
TEZDF-MS/ML



TEZDF- XL type



TEZD-MT type



■Body

Applicable dia.	Tool No.	Stock	L/D	Dimensions (mm) ℓ	ℓ2	ℓs	L	ϕDs	ϕDf	MT	List Price (JPY)
28.5 Over	TEZD2900S32-MS	●	3	103	132	60	192	32	—	—	41,580
	NEW TEZD2900S32F-MS	●	3	103	132	60	192	32	41.9	—	50,000
	TEZD2900S32-ML	●	5	162	197	60	257	32	—	—	49,940
29.5 Or under	NEW TEZD2900S32F-ML	●	5	162	197	60	257	32	41.9	—	60,000
	TEZD2900S32-XL	●	8	247	276	60	336	32	—	—	74,800
	NEW TEZD2900S32F-XL	●	8	247	276	60	336	32	41.9	—	89,800
29.5 Over	TEZD3000S32-MS	●	3	107	137	60	197	32	—	—	41,580
	NEW TEZD3000S32F-MS	●	3	107	137	60	197	32	41.9	—	50,000
	TEZD3000S32-ML	●	5	168	204	60	264	32	—	—	49,940
30.5 Or under	NEW TEZD3000S32F-ML	●	5	168	204	60	264	32	41.9	—	60,000
	TEZD3000S32-XL	●	8	255	285	60	345	32	—	—	74,800
	NEW TEZD3000S32F-XL	●	8	255	285	60	345	32	41.9	—	89,800
30.5 Over	TEZD3100S32-MS	●	3	110	141	60	201	32	—	—	44,000
	NEW TEZD3100S32F-MS	●	3	110	141	60	201	32	41.9	—	52,800
	TEZD3100S32-ML	●	5	173	210	60	270	32	—	—	52,800
	NEW TEZD3100S32F-ML	●	5	173	210	60	270	32	41.9	—	63,400
31.5 Or under	TEZD3100S32-XL	●	8	248	295	60	355	32	—	—	79,200
	NEW TEZD3100S32F-XL	●	8	248	295	60	355	32	41.9	—	95,100
	TEZD3100MT3	●	4	157	—	—	310	—	—	MT3	68,640
31.5 Over	TEZD3200S32-MS	●	3	114	146	60	206	32	—	—	44,000
	NEW TEZD3200S32F-MS	●	3	114	146	60	206	32	41.9	—	52,800
	TEZD3200S32-ML	●	5	179	217	60	277	32	—	—	52,800
	NEW TEZD3200S32F-ML	●	5	179	217	60	277	32	41.9	—	63,400
32.5 Or under	TEZD3200S32-XL	●	8	256	304	60	364	32	—	—	79,200
	NEW TEZD3200S32F-XL	●	8	256	304	60	364	32	41.9	—	95,100
	TEZD3200MT3	●	4	162	—	—	315	—	—	MT3	68,640

1 insert per case.

List price is as of November 2022.

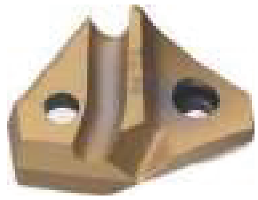
■Insert

(mm) Drill dia.	(Fig.1) PVDcoated JC8050 Insert No.	Stock	Dimensions A	Dimensions T	List Price (JPY)	Parts: Clamp screw	Parts: Wrench (not be included)
28.6	TEZ2860	●	22.1	9.0	13,310	TSW-3510H	A-15
28.7	TEZ2870	●			13,310		
28.8	NEW TEZ2880	●			13,310		
28.9	NEW TEZ2890	●			13,310		
29.0	TEZ2900	●			13,310		
29.1	TEZ2910	●			13,310		
29.2	NEW TEZ2920	●			13,310		
29.3	NEW TEZ2930	●			13,310		
29.4	NEW TEZ2940	●			13,310		
29.5	TEZ2950	●			13,310		
29.6	NEW TEZ2960	●	22.5	9.5	13,310	TSW-3510H	A-15
29.7	NEW TEZ2970	●			13,310		
29.8	NEW TEZ2980	●			13,310		
29.9	NEW TEZ2990	●			13,310		
30.0	TEZ3000	●			13,310		
30.1	TEZ3010	●			13,310		
30.2	NEW TEZ3020	●			13,310		
30.3	NEW TEZ3030	●			13,310		
30.4	NEW TEZ3040	●			13,310		
30.5	TEZ3050	●			13,310		
30.6	NEW TEZ3060	●	23.4	10.0	14,190	TSW-3512H	A-15
30.7	NEW TEZ3070	●			14,190		
30.8	NEW TEZ3080	●			14,190		
30.9	NEW TEZ3090	●			14,190		
31.0	TEZ3100	●			14,190		
31.1	NEW TEZ3110	●			14,190		
31.2	NEW TEZ3120	●			14,190		
31.3	NEW TEZ3130	●			14,190		
31.4	NEW TEZ3140	●			14,190		
31.5	TEZ3150	●			14,190		
31.6	NEW TEZ3160	●	24.3	10.0	14,190	TSW-3512H	A-15
31.7	NEW TEZ3170	●			14,190		
31.8	NEW TEZ3180	●			14,190		
31.9	NEW TEZ3190	●			14,190		
32.0	TEZ3200	●			14,190		
32.1	TEZ3210	●			14,190		
32.2	NEW TEZ3220	●			14,190		
32.3	NEW TEZ3230	●			14,190		
32.4	NEW TEZ3240	●			14,190		
32.5	NEW TEZ3250	●			14,190		

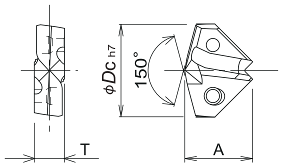
●: Standard stock items

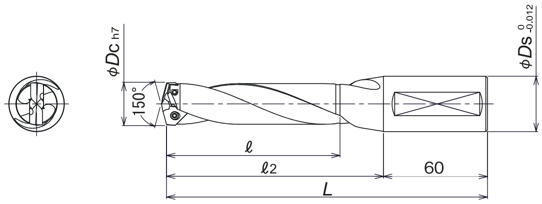
Line up

TEZD-KMS type for bridge construction



Through coolant hole
Hole Depth：3×Dc





■ Insert / ■ Body

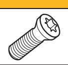
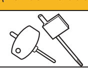
(mm) Drill dia.	Insert					Body						
	Insert No.	PVD coated	(mm) Dimensions		List Price (JPY)	KMS type (3D)		Dimeisions (mm)				List Price (JPY)
φDc		JC7550	A	T		Tool No.	Stock	ℓ	ℓ2	L	φDs	
24.5	TEZ2450K	●	17.4	8.0	12,100	TEZD2450S32-KMS	●	100	125	185	32	37,510
24.7	TEZ2470K	●			12,100							
26.5	TEZ2650K	●	18.8	8.5	13,310	TEZD2650S32-KMS	●	108	135	195	32	39,930
26.7	TEZ2670K	●			13,310							

1 insert per case.
List price is as of November 2022.

●：Standard stock items

Note) 1. All holders are supplied without insert.
2. Insert for bridge construction (TEZ○○○○K) isn't compatible with insert for general use (TEZ○○○○). Please install TEZ○○○○K insert to TEZD○○○○S32-KMS body.
3. All products are supplied without wrench & MOLY since February 2019 for our stock production.

■ Parts

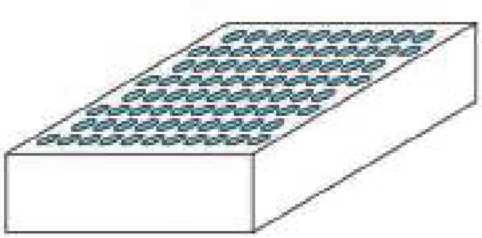
Clamp screw	Wrench (not be included)
	
DSW-309H	A-10

Clamp screw	(N･m) Recommended torque
DSW-309H	2.1

Cutting data for "Indexable EZ DRILL"

① Drilling for tube plate of air conditioner

Longer tool life!



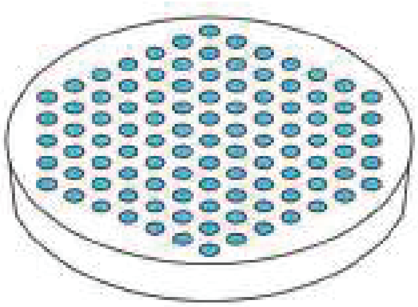
Work	Part name		Tube plate of air conditioner
	Material		Steel for structure (low carbon steel)
	Hardness		–
Tool	Cat. No.		TEZD1600S20-MS
	Insert No. (Grade)		TEZ1630(JC8050)
Cutting conditions	Spindle speed	*n*	*n*=1,450min⁻¹
	Cutting speed	*Vc*	*Vc*=73.76m/min
	feed speed	*Vf*	*Vf*=362.5mm/min
	feed	*f*	*f*=0.25mm/rev
	Hole depth		28mm(thru.)
	Clamp		Good
	Coolant		Water soluble
	Machine		Vertical MC

Result

TEZD could cut 3.5pcs.
【First axis: 4,040 holes (113m),
second axis: 3,922 holes(110m) 】

② Drilling for heat exchanger

High efficiency!



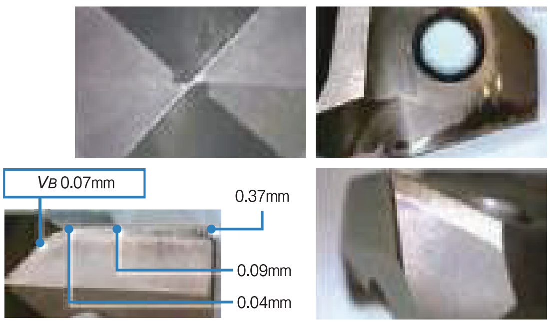
			Heat exchanger
			Stainless steel
			250HB
			TEZD1900S25-MS
			TEZ1930(JC8050)
		n	*n*=1,000min⁻¹
		Vc	*Vc*=60.3m/min
		Vf	*Vf*=300mm/min
		f	*f*=0.3mm/rev
			45mm(thru.)
			Good
			Water soluble
			Double column MC

Compared with competitor, TEZD increased feed speed by 2 times and achieved good chip removal.

③ Drilling for weatherproof steel sheet

Longer tool life!

Damaged condition after 99m



			Splice plate
			Weatherproof steel (①SMA490AW ②SMA490AW ③SMA570QW+SMA490AW)
			–
			TEZD2450S32-KMS
			TEZ2470K(JC7550)
		n	① *n*=790min⁻¹ , *Vc*=61.27m/min
		Vc	②③ *n*=590min⁻¹ , *Vc*=45.75m/min
		Vf	① *f*=0.379mm/rev
		f	②③ *f*=0.3mm/rev
			① t=9mm×2pcs. ,stack plate (thru.) ②③ t=23mm×2pcs. ,stack plate (thru.)
			Good
			Water soluble
			Vertical MC

TEZD achieved 99m by one insert.
Insert showed normal wear.

Cutting data for “Indexable EZ DRILL”

④ Improvement machining efficiency by replacing from HSS drill to Indexable EZ drill.（1）

High efficiency!

Overhung length：130mm
Drilling pilot hole for tap

Result

HSS drill was required step feed but Indexable EZ drill achieved 1.4 times faster feed speed without step feed. Surface roughness and accuracy of hole was good.

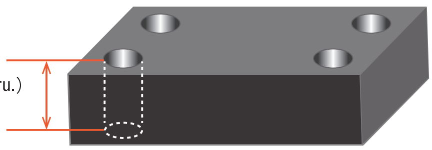
Work	Part name		Stampng die
	Material		GGG54
	Hardness		—
Tool	Cat. No.		TEZD1400MT1
	Insert No. (Grade)		TEZ1400 (JC8050)
Cutting conditions	Spindle speed	n	n=1,800min^{-1}
	Cutting speed	V_c	V_c=79m/min
	feed speed	V_f	V_f=396mm/min
	feed	f	f=0.22mm/rev
	Hole depth		60mm（blind）
	Clamp		Good
	Coolant		Air blow
	Machine		Double column MC

2994

⑤ Improvement machining efficiency by replacing from HSS drill to Indexable EZ drill.（2）

High efficiency!

Overhung length : 100mm
Drilling pilot hole for tap (step feed every 2mm depth)
30 hole per 1 plate



Result

Tool life of competitor K was 30holes. Indexable EZ drill achieved good surface roughness and acurracy of hole, and was still able to continue.

Work	Part name		Plate
	Material		SS400 Steel for structure
	Hardness		—
Tool	Cat. No.		TEZD2100MT2
	Insert No. (Grade)		TEZ2100（JC8050）
Cutting conditions	Spindle speed	n	n=840min^{-1}
	Cutting speed	V_c	V_c=55.4m/min
	feed speed	V_f	V_f=176mm/min
	feed	f	f=0.21mm/rev
	Hole depth		80mm（thru.）
	Clamp		Good
	Coolant		Water soluble
	Machine		Double column MC

2864

Recommended cutting conditions

Recommended cutting conditions for TEZD/TEZD*F -MS/ML/XL type

Work material	Steel for structure, carbon steel (C50) (SS400, S50C) (~280HB)		Alloy steel (1.7223) (SCM440) (280~350HB)		Stainless steel (SUS304) (~280HB)		Grey cast iron (Tensile strength ~350MPa) (GG25) (FC250)		Nodular cast iron (Tensile strength ~450MPa) (GGG40) (FCD400)	
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		0.15~0.28	
(mm) Drill dia.	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

Vc : Cutting speed n : Spindle speed Vf : Feed speed f : feed

Note)
1. Above cutting conditions are for general guidance.
2. The figures to be adjusted according to machining shape, purpose and rigidity of machine and work clamping.
3. In case of using TEZD-XL type (8D), recommend to reduce 20% both *n* and Vf in the above cutting conditions.
   And recommend to guide hole drilling by TEZD-MS type (3D) with the same diameter as the TEZD-XL type (Depth of guide hole is 0.5D).
4. Please see page 14 for recommended Cutting conditions using TEZ*S inserts
5. When machining stainless steel, TEZ*S type is recommended.

Recommended cutting conditions

Recommended cutting conditions for TEZD-MTtype

Work material	Steel for structure, carbon steel (~280HB) (C50) (SS400,S50C)		Grey cast iron (Tensile strength ~350MPa) (GG25) (FC250)		Nodular cast iron (Tensile strength ~450MPa) (GGG40) (FCD400)	
Vc (m/min)	50		60		50	
f (mm/rev)	0.25		0.3		0.25	
(mm) Drill dia.	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)
14	1,100	270	1,360	400	1,100	270
15	1,050	260	1,270	380	1,050	260
17	950	240	1,120	340	950	240
18	880	220	1,060	320	880	220
21	760	200	910	270	760	200
22	720	180	870	260	720	180
25	640	160	760	230	640	160
26	620	160	740	220	620	160
31	520	130	620	190	520	130
32	500	130	600	180	500	130

Vc : Cutting speed n : Spindle speed
Vf : Feed speed f : feed

Note)
1. Above table shows general cutting conditions in case of non-step drilling by machining center. Not recommend to use by drilling machine.
2. The figures to be adjusted according to machining shape, purpose and rigidity of machine and work clamping.
3. In case of machining steel for structure or carbon steel, be sure to use water soluble. In case of grey & nodular cast iron, recommend to use water soluble.
4. In case of mounting extension holder to TEZD-MT by using double column MC, please note as below:
   - When overhung length is over 300mm, reduce 20% both Spindle speed(n) & Feed speed(Vf) in the above cutting conditions.
   - When overhung length is over 500mm, not recommend to machine steel for structure or carbon steel.
   In case of machining grey & nodular cast iron, be sure ro make center hole and reduce 30-40% both Spindle speed(n) & Feed speed(Vf) in the above cutting conditions.

Recommended cutting conditions for TEZD-KMS type

Work material	Rolled steel (Tensile strength 400-510 N/㎟) (SS400,SM400)		Rolled steel (Tensile strength 490-610 N/㎟) (SM490)		Rolled steel (Tensile strength 520-640 N/㎟) (SM520)		Rolled steel (Tensile strength 570-720 N/㎟) (SM570)	
Vc (m/min)	50~60~70		50~60~70		40~50~60		30~40~50	
f (mm/rev)	0.30~0.30~0.35		0.25~0.30~0.35		0.25~0.30~0.35		0.25~0.25~0.30	
(mm) Drill dia.	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)	n (min^{-1})	Vf (mm/min)
24.5	770	230	770	230	640	190	510	130
24.7	770	230	770	230	640	190	510	130
26.5	720	220	720	220	600	180	480	120
26.7	720	220	720	220	600	180	480	120

Vc : Cutting speed n : Spindle speed Vf : Feed speed f : feed

Recommended cutting conditions for TEZD/TEZD*F -MS/ML/XL type using TEZ*S inserts

Work material	Titanium alloy 30~42HRC (Ti-6Al-4V)		Stainless steel (~280HB) (SUS304)	
V_c (m/min)	35~60		45~80	
f (mm/rev)	0.15~0.2		0.15~0.2	
(mm) Drill dia.	n (min^{-1})	V_f (mm/min)	n (min^{-1})	V_f (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

Vc : Cutting speed n : Spindle speed
Vf : Feed speed f : feed

Note)
1. Above cutting conditions are for general guidance.
2. The figures to be adjusted according to machining shape, purpose and rigidity of machine and work clamping.
3. In case of using TEZD-XL type (8D), recommend to reduce 20% both n and Vf in the above cutting conditions.
   And recommend to guide hole drilling by TEZD-MS type (3D) with the same diameter as the TEZD-XL type (Depth of guide hole is 0.5D).

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