

TDMX

TOP DRILL™ MODULAR X



STABILITY AND RELIABILITY COMBINED INTO ONE MODULAR DRILL SYSTEM

WIDIA™ TOP DRILL Modular X (TDMX) is the ultimate choice for high-demanding drilling applications when stability and reliability are required.





Platform

Standard cutter bodies in 1.5 x D, 3 x D, 5 x D, 8 x D, and 12 x D.

Insert diameter range from .629" up to 1.574".

Two geometries, one grade to cover steel and cast iron applications.

Easy to Apply

Front clamping design. No need to disassemble the body from the holder to change insert.

Easy insert nomenclature logic to identify the targeted material group.

Increased Stability and Performance

Highly engineered pocket seat design to ensure maximum stability, even in challenging applications like cross hole, inclined entry/exit, and interrupted cuts.

Suitable for high feed rates.

Flanged shank for higher rigidity.

Polished flutes for improved chip evacuation.

Brand new WP40PD grade for longer tool life in steel and cast iron applications.



FPE: P, M, K Flat bottom drilling, stacked plates, piloting for deep-hole drilling.
New 1.5 x D and 12 x D bodies



TDMX — TOP DRILL™ Modular X

Modular Drills • TOP DRILL Modular X

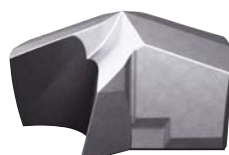


- Augmented insert stability thanks to the highly engineered pocket seat design.
- Front clamping for an easy insert change, without disassembling the holder from the machine spindle.
- Diameter range from .629" up to 1.574".
- L/D ratio of 1.5 x D, 3 x D, 5 x D, 8 x D, and 12 x D.



Two geometries to cover two material groups in modular drilling.

PK(M)



P K

First choice for Steel and Cast Iron drilling.



FPE(M)



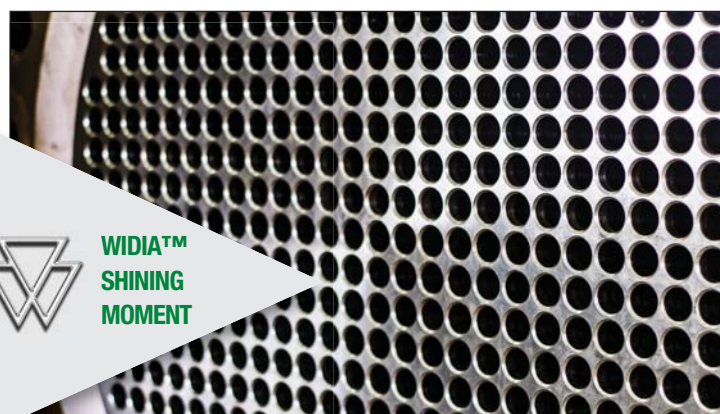
P M K

Flat bottom drilling, stacked plates, piloting for deep-hole drilling.

TDMX — Tube Sheet Drilling

P Steel

Material: Fe510/1.0553/A441
Condition: rough surface

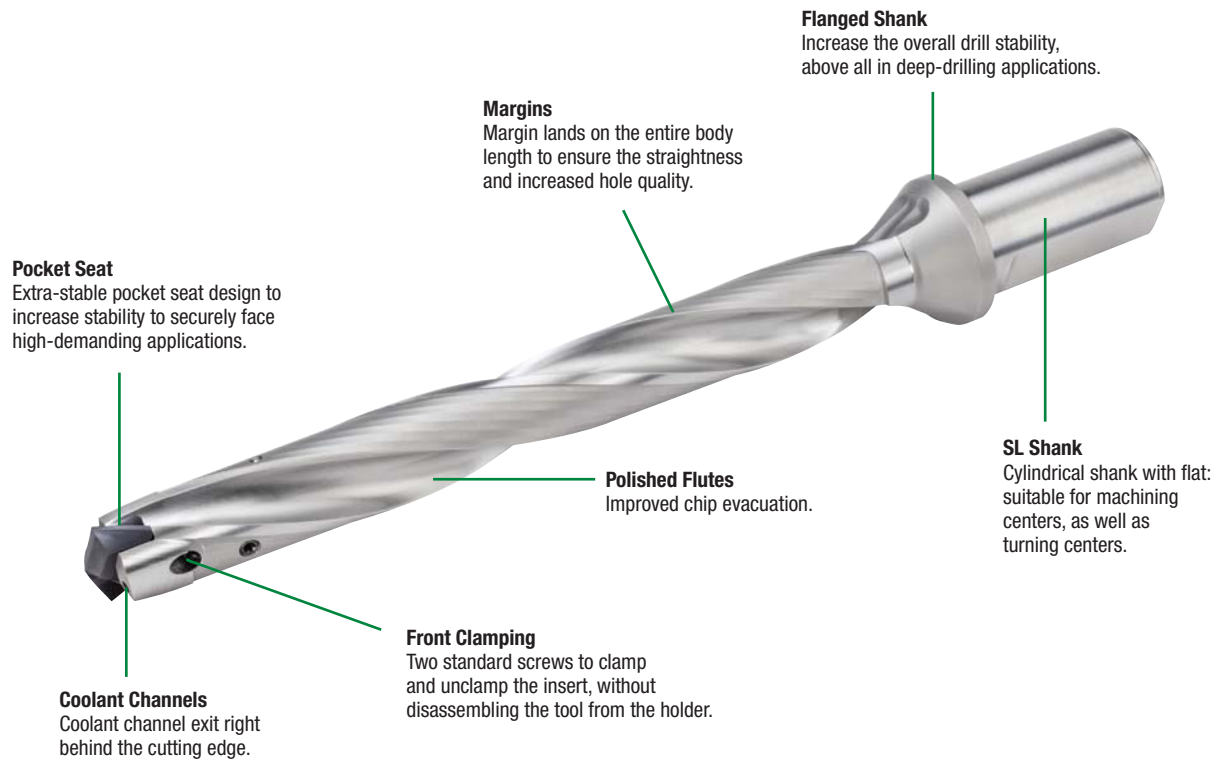


Specifications	Competitor	WIDIA
Diameter (Inch)	1.00"	1.00"
Grade	—	WP40PD
Geometry	—	PK
Vc (SFM)	300	300
n (rev/min)	1.247	1.247
f (IPR)	0.013	0.014
Vf (in/min)	15.7	17.2
LOC (in)	2	2
Coolant	Internal Emulsion	Internal Emulsion
Tool Life (ft)	98.4	157.4

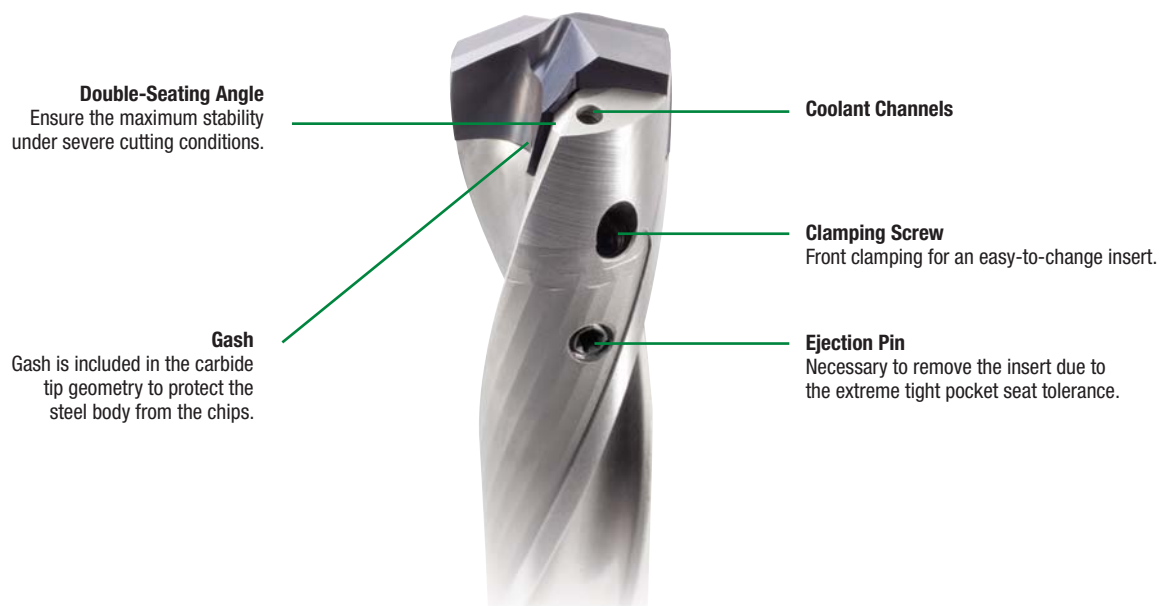


Modular Drills • TOP DRILL™ Modular X

TDMX Body — Technical Details



TDMX Pocket Seat — Technical Details



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TDMX Components

Drilling is not always a simple, straightforward job. Workpiece instability, vibrations, and chip control are just a few challenges typically encountered in drilling applications. In addition to these challenges, the cost per hole becomes a critical subject in many shops with pressure to achieve sustainable production at the lowest cost possible. The TOP DRILL Modular X (TDMX) holmaking solution is able to address such machining applications and economic requirements with ease.

Tube sheets, baffles, I-beams, valves, axles and track drive units are just a few examples of components that can be machined with more confidence thanks to the TDMX drill, its material-specific inserts, and optimized body design.

The combination of an extra stable pocket seat design, reinforced cutting corners, and a through grade, ensures increased process reliability and consequently longer tool life associated, with better hole quality.

The WP40PD grade provides the right toughness to face even the most unstable cutting conditions while also suitable for MQL applications.

The PK(M) point geometry is designed to operate high feed rates and provide the right guidance for improved hole straightness.

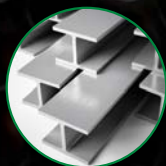
The FPE(M) flat bottom geometry is the solution to address the most challenging operations such as thin stack plate drilling, half holes, and any other applications where the standard 140° shows limits. FPE(M) can also be used as pilot for deep-hole drills.



Baffles



Tube Sheets



I-Beams



Valves



Cable Tensioner
- Post Tension System



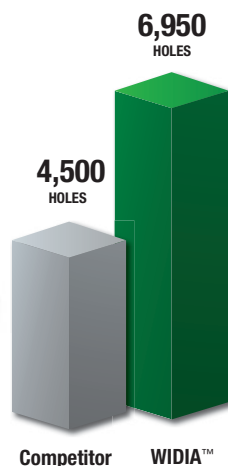
Axles



Track Drive
Components

Longer tool life, reliability, and increased chip control on a steel structural component for a high-voltage electrical line customer

19-224648



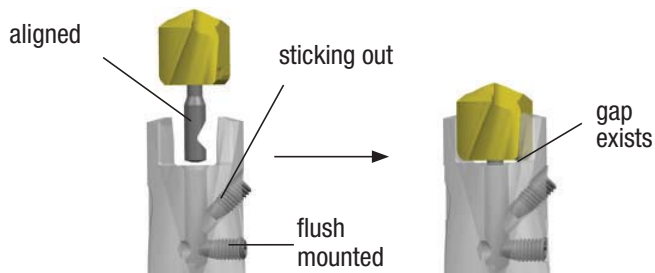
Specifications	Competitor	WIDIA
Tool body	Dia. 17mm 3 x D	TDMX
Insert	—	TDMX
Grade	—	WP40PD
Diameter	17,99mm	18mm
L/D Ratio	1.5 x D	3 x D
LOC	.787" (20mm)	.787" (20mm)
Cutting Speed Vc	210 SFM (70m/min)	70m/min 210sfm
Feed Rate in	.0098 IPR (0,25mm/rev)	.25mm/rev (.0098ipr)
Coolant	Internal MQL	
Tool Life	4500 Holes	6950 Holes

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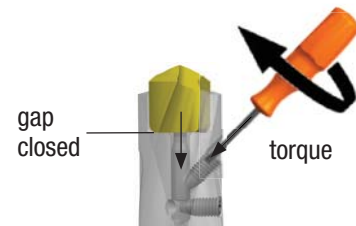
Assembling and Disassembling Instructions

Assembly

1 Insert positioning



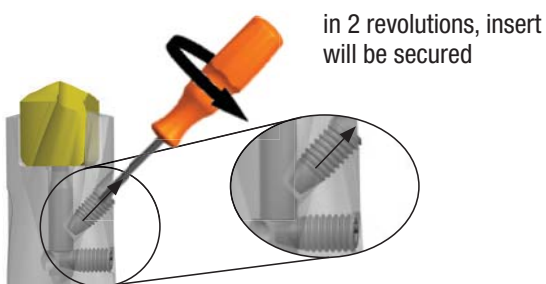
2 Insert clamping



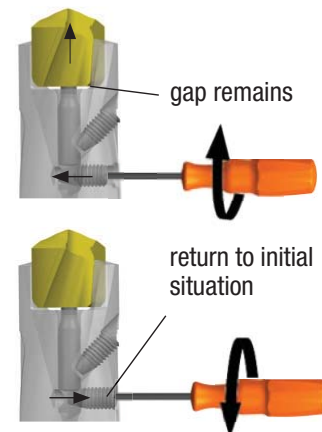
Drill diameter	Torque
ø .6300–.7874"	1.1 ft. lbs.
ø .7875–.9448"	1.5 ft. lbs.
ø .9449–1.1023"	2.2 ft. lbs.
ø 1.1024–1.5748"	3.3 ft. lbs.

Disassembly

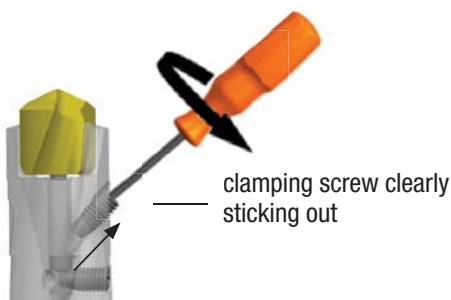
1 Clamping screw loosening



2 Insert pushing out



3 Further clamping screw loosening



4 Insert removal

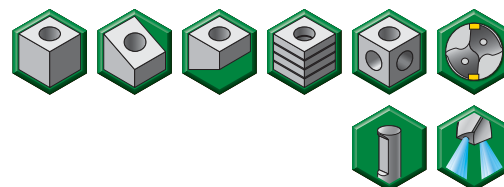
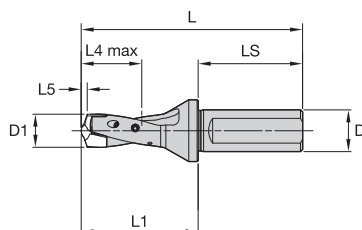


TDMX — TOP DRILL™ Modular X

Modular Drills • TOP DRILL Modular X



TDMX • 1.5 x D • Side Lock Shank • Inch

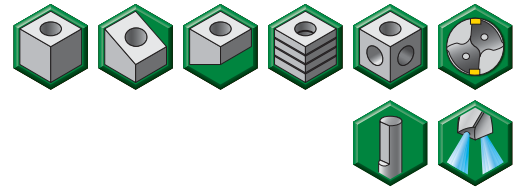
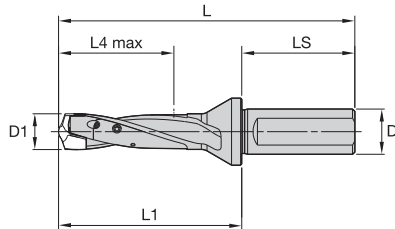


order number	catalog number	SSC	D1	D1 max	LS	D	L	L1	L4 max
6680912	TDMX0630R1SL075	A	.6300	.6692	1.97	.75	4.17	2.20	1.02
6680914	TDMX0670R1SL075	B	.6693	.7086	1.97	.75	4.29	2.32	1.06
6680915	TDMX0709R1SL100	C	.7087	.7480	2.20	1.00	4.65	2.44	1.14
6680916	TDMX0749R1SL100	D	.7481	.7874	2.20	1.00	4.76	2.56	1.18
6680917	TDMX0788R1SL100	E	.7875	.8267	2.20	1.00	4.88	2.68	1.26
6680918	TDMX0827R1SL100	F	.8268	.8661	2.20	1.00	5.00	2.80	1.30
6680919	TDMX0867R1SL100	G	.8662	.9055	2.20	1.00	5.12	2.91	1.38
6680920	TDMX0906R1SL100	H	.9056	.9448	2.20	1.00	5.24	3.03	1.42
6680931	TDMX0945R1SL125	I	.9449	.9842	2.36	1.25	5.51	3.15	1.50
6680932	TDMX0985R1SL125	J	.9843	1.0236	2.36	1.25	5.63	3.27	1.54
6680933	TDMX1024R1SL125	K	1.0237	1.0629	2.36	1.25	5.75	3.39	1.61
6680934	TDMX1063R1SL125	L	1.0630	1.1023	2.36	1.25	5.87	3.50	1.65
6680935	TDMX1103R1SL125	M	1.1024	1.1417	2.36	1.25	5.98	3.62	1.73
6680937	TDMX1142R1SL125	N	1.1418	1.1811	2.36	1.25	6.10	3.74	1.77
6680938	TDMX1182R1SL125	O	1.1812	1.2204	2.36	1.25	6.22	3.86	1.85
6680940	TDMX1221R1SL125	P	1.2205	1.2598	2.36	1.25	6.34	3.98	1.89

NOTE: SSC = Pocket Seat Reference. To correspond with the SSC on the inserts.
L5 is dependent on the insert.

Modular Drills • TOP DRILL™ Modular X

TDMX • 3 x D • Side Lock Shank • Inch



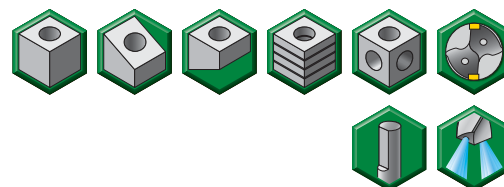
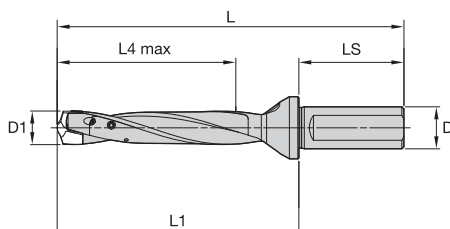
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6572186	TDMX0630R3SL075	A	.6300	.6692	1.97	.75	5.16	3.19	2.01
6572187	TDMX0670R3SL075	B	.6693	.7086	1.97	.75	5.35	3.39	2.13
6572188	TDMX0709R3SL100	C	.7087	.7480	2.20	1.00	5.75	3.54	2.24
6572189	TDMX0749R3SL100	D	.7481	.7874	2.20	1.00	5.94	3.74	2.36
6572190	TDMX0788R3SL100	E	.7875	.8267	2.20	1.00	6.10	3.90	2.48
6572191	TDMX0827R3SL100	F	.8268	.8661	2.20	1.00	6.30	4.09	2.60
6572192	TDMX0867R3SL100	G	.8662	.9055	2.20	1.00	6.46	4.25	2.72
6572193	TDMX0906R3SL100	H	.9056	.9448	2.20	1.00	6.65	4.45	2.83
6572194	TDMX0945R3SL125	I	.9449	.9842	2.36	1.25	6.97	4.61	2.95
6572195	TDMX0985R3SL125	J	.9843	1.0236	2.36	1.25	7.17	4.80	3.07
6572196	TDMX1024R3SL125	K	1.0237	1.0629	2.36	1.25	7.32	4.96	3.19
6572197	TDMX1063R3SL125	L	1.0630	1.1023	2.36	1.25	7.52	5.16	3.31
6572198	TDMX1103R3SL125	M	1.1024	1.1417	2.36	1.25	7.68	5.32	3.43
6572199	TDMX1142R3SL125	N	1.1418	1.1811	2.36	1.25	7.87	5.51	3.54
6572200	TDMX1182R3SL125	O	1.1812	1.2204	2.36	1.25	8.03	5.67	3.66
6572201	TDMX1221R3SL125	P	1.2205	1.2598	2.36	1.25	8.23	5.87	3.78
6572202	TDMX1260R3SL150	Q	1.2599	1.3385	2.76	1.50	8.98	6.22	4.02
6572203	TDMX1339R3SL150	R	1.3386	1.4173	2.76	1.50	9.33	6.57	4.25
6572204	TDMX1418R3SL150	S	1.4174	1.4960	2.76	1.50	9.69	6.93	4.49
6572205	TDMX1497R3SL150	T	1.4961	1.5748	2.76	1.50	10.04	7.28	4.72

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TDMX — TOP DRILL™ Modular X

Modular Drills • TOP DRILL Modular X

TDMX • 5 x D • Side Lock Shank • Inch

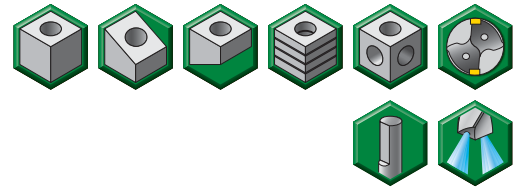
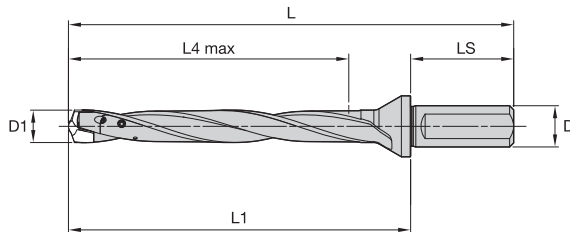


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6572206	TDMX0630R5SL075	A	.6300	.6692	1.97	.75	6.50	4.53	3.35
6572207	TDMX0670R5SL075	B	.6693	.7086	1.97	.75	6.77	4.80	3.54
6572208	TDMX0709R5SL100	C	.7087	.7480	2.20	1.00	7.24	5.04	3.74
6572210	TDMX0749R5SL100	D	.7481	.7874	2.20	1.00	7.52	5.32	3.94
6572231	TDMX0788R5SL100	E	.7875	.8267	2.20	1.00	7.76	5.55	4.13
6572232	TDMX0827R5SL100	F	.8268	.8661	2.20	1.00	8.03	5.83	4.33
6572233	TDMX0867R5SL100	G	.8662	.9055	2.20	1.00	8.27	6.06	4.53
6572234	TDMX0906R5SL100	H	.9056	.9448	2.20	1.00	8.54	6.34	4.72
6572235	TDMX0945R5SL125	I	.9449	.9842	2.36	1.25	8.94	6.57	4.92
6572236	TDMX0985R5SL125	J	.9843	1.0236	2.36	1.25	9.21	6.85	5.12
6572237	TDMX1024R5SL125	K	1.0237	1.0629	2.36	1.25	9.45	7.09	5.32
6572238	TDMX1063R5SL125	L	1.0630	1.1023	2.36	1.25	9.72	7.36	5.51
6572239	TDMX1103R5SL125	M	1.1024	1.1417	2.36	1.25	9.96	7.60	5.71
6572240	TDMX1142R5SL125	N	1.1418	1.1811	2.36	1.25	10.24	7.87	5.91
6572241	TDMX1182R5SL125	O	1.1812	1.2204	2.36	1.25	10.47	8.11	6.10
6572242	TDMX1221R5SL125	P	1.2205	1.2598	2.36	1.25	10.75	8.39	6.30
6572243	TDMX1260R5SL150	Q	1.2599	1.3385	2.76	1.50	11.65	8.90	6.69
6572244	TDMX1339R5SL150	R	1.3386	1.4173	2.76	1.50	12.17	9.41	7.09
6572245	TDMX1418R5SL150	S	1.4174	1.4960	2.76	1.50	12.68	9.92	7.48
6572246	TDMX1497R5SL150	T	1.4961	1.5748	2.76	1.50	13.19	10.43	7.87

NOTE: SSC = Pocket Seat Reference. To correspond with the SSC on the inserts.
L5 is dependent on the insert.

Modular Drills • TOP DRILL™ Modular X

TDMX • 8 x D • Side Lock Shank • Inch

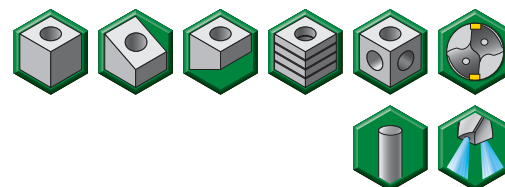
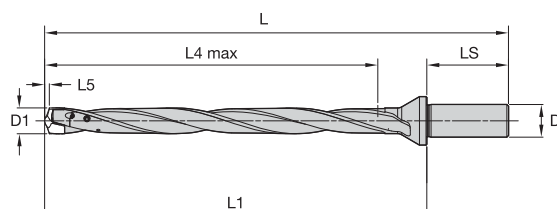


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6572247	TDMX0630R8SL075	A	.6300	.6692	1.97	.75	8.50	6.54	5.35
6572248	TDMX0670R8SL075	B	.6693	.7086	1.97	.75	8.90	6.93	5.67
6572249	TDMX0709R8SL100	C	.7087	.7480	2.20	1.00	9.49	7.28	5.98
6572250	TDMX0749R8SL100	D	.7481	.7874	2.20	1.00	9.88	7.68	6.30
6572251	TDMX0788R8SL100	E	.7875	.8267	2.20	1.00	10.24	8.03	6.61
6572252	TDMX0827R8SL100	F	.8268	.8661	2.20	1.00	10.63	8.43	6.93
6572253	TDMX0867R8SL100	G	.8662	.9055	2.20	1.00	10.98	8.78	7.24
6572254	TDMX0906R8SL100	H	.9056	.9448	2.20	1.00	11.38	9.17	7.56
6572255	TDMX0945R8SL125	I	.9449	.9842	2.36	1.25	11.89	9.53	7.87
6572256	TDMX0985R8SL125	J	.9843	1.0236	2.36	1.25	12.28	9.92	8.19
6572257	TDMX1024R8SL125	K	1.0237	1.0629	2.36	1.25	12.64	10.28	8.50
6572258	TDMX1063R8SL125	L	1.0630	1.1023	2.36	1.25	13.03	10.67	8.82
6572259	TDMX1103R8SL125	M	1.1024	1.1417	2.36	1.25	13.39	11.02	9.13
6572260	TDMX1142R8SL125	N	1.1418	1.1811	2.36	1.25	13.78	11.42	9.45
6572261	TDMX1182R8SL125	O	1.1812	1.2204	2.36	1.25	14.13	11.77	9.76
6572262	TDMX1221R8SL125	P	1.2205	1.2598	2.36	1.25	14.53	12.17	10.08
6572263	TDMX1260R8SL150	Q	1.2599	1.3385	2.76	1.50	15.67	12.91	10.71
6572264	TDMX1339R8SL150	R	1.3386	1.4173	2.76	1.50	16.42	13.66	11.34
6572265	TDMX1418R8SL150	S	1.4174	1.4960	2.76	1.50	17.17	14.41	11.97
6572266	TDMX1497R8SL150	T	1.4961	1.5748	2.76	1.50	17.91	15.16	12.60

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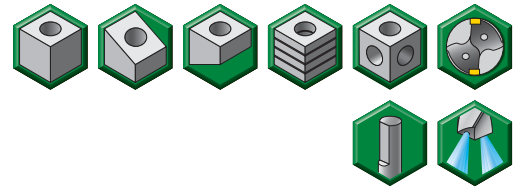
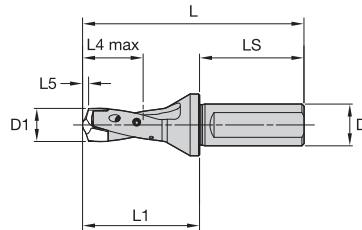


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6680978	TDMX0630R12SF075	A	.6300	.6692	1.97	.75	11.18	9.21	8.03
6680979	TDMX0670R12SF075	B	.6693	.7086	1.97	.75	11.73	9.76	8.50
6680980	TDMX0709R12SF100	C	.7087	.7480	2.20	1.00	12.48	10.28	8.98
6681001	TDMX0749R12SF100	D	.7481	.7874	2.20	1.00	13.03	10.83	9.45
6681002	TDMX0788R12SF100	E	.7875	.8267	2.20	1.00	13.54	11.34	9.92
6681003	TDMX0827R12SF100	F	.8268	.8661	2.20	1.00	14.09	11.89	10.39
6681004	TDMX0867R12SF100	G	.8662	.9055	2.20	1.00	14.61	12.40	10.87
6681005	TDMX0906R12SF100	H	.9056	.9448	2.20	1.00	15.16	12.95	11.34
6681006	TDMX0945R12SF125	I	.9449	.9842	2.36	1.25	15.83	13.46	11.81
6681007	TDMX0985R12SF125	J	.9843	1.0236	2.36	1.25	16.38	14.02	12.28
6681008	TDMX1024R12SF125	K	1.0237	1.0629	2.36	1.25	16.89	14.53	12.76
6681010	TDMX1063R12SF125	L	1.0630	1.1023	2.36	1.25	17.44	15.08	13.23
6681011	TDMX1103R12SF125	M	1.1024	1.1417	2.36	1.25	17.95	15.59	13.70
6681012	TDMX1142R12SF125	N	1.1418	1.1811	2.36	1.25	18.50	16.14	14.17
6681013	TDMX1182R12SF125	O	1.1812	1.2204	2.36	1.25	19.02	16.65	14.65
6681015	TDMX1221R12SF125	P	1.2205	1.2598	2.36	1.25	19.57	17.20	15.12

NOTE: SSC = Pocket Seat Reference. To correspond with the SSC on the inserts.
L5 is dependent on the insert.

Modular Drills • TOP DRILL™ Modular X

TDMX • 1.5 x D • Side Lock Shank • Metric



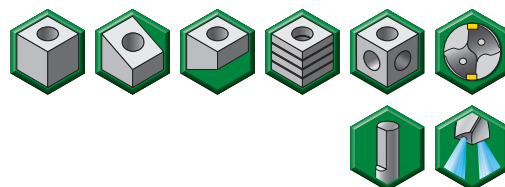
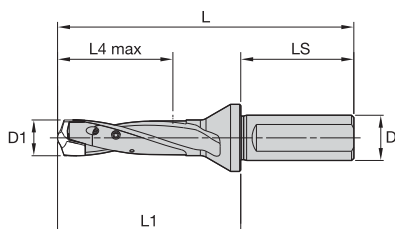
order number	catalog number	SSC	D1	D1 max	LS	D	L	L1	L4 max
6680951	TDMX160R1SL20M	A	16,000	16,999	50	20	106	56	26
6680952	TDMX170R1SL20M	B	17,000	17,999	50	20	109	59	27
6680953	TDMX180R1SL25M	C	18,000	18,999	56	25	118	62	29
6680954	TDMX190R1SL25M	D	19,000	19,999	56	25	121	65	30
6680955	TDMX200R1SL25M	E	20,000	20,999	56	25	124	68	32
6680956	TDMX210R1SL25M	F	21,000	21,999	56	25	127	71	33
6680957	TDMX220R1SL25M	G	22,000	22,999	56	25	130	74	35
6680958	TDMX230R1SL25M	H	23,000	23,999	56	25	133	77	36
6680959	TDMX240R1SL32M	I	24,000	24,999	60	32	140	80	38
6680960	TDMX250R1SL32M	J	25,000	25,999	60	32	143	83	39
6680971	TDMX260R1SL32M	K	26,000	26,999	60	32	146	86	41
6680972	TDMX270R1SL32M	L	27,000	27,999	60	32	149	89	42
6680973	TDMX280R1SL32M	M	28,000	28,999	60	32	152	92	44
6680974	TDMX290R1SL32M	N	29,000	29,999	60	32	155	95	45
6680975	TDMX300R1SL32M	O	30,000	30,999	60	32	158	98	47
6680976	TDMX310R1SL32M	P	31,000	31,999	60	32	161	101	48

NOTE: SSC = Pocket Seat Reference. To correspond with the SSC on the inserts.
L5 is dependent on the insert.

TDMX — TOP DRILL™ Modular X

Modular Drills • TOP DRILL Modular X

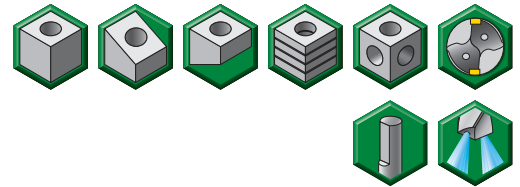
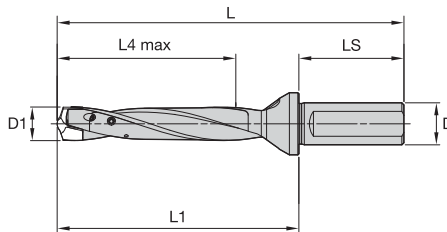
TDMX • 3 x D • Side Lock Shank • Metric



order number	catalog number	SSC	D1	D1 max	LS	D	L	L1	L4 max
6572091	TDMX160R3SL20M	A	16,000	16,999	50	20	131	81	51
6572092	TDMX170R3SL20M	B	17,000	17,999	50	20	136	86	54
6572093	TDMX180R3SL25M	C	18,000	18,999	56	25	146	90	57
6572094	TDMX190R3SL25M	D	19,000	19,999	56	25	151	95	60
6572096	TDMX200R3SL25M	E	20,000	20,999	56	25	155	99	63
6572097	TDMX210R3SL25M	F	21,000	21,999	56	25	160	104	66
6572098	TDMX220R3SL25M	G	22,000	22,999	56	25	164	108	69
6572099	TDMX230R3SL25M	H	23,000	23,999	56	25	169	113	72
6572100	TDMX240R3SL32M	I	24,000	24,999	60	32	177	117	75
6572101	TDMX250R3SL32M	J	25,000	25,999	60	32	182	122	78
6572102	TDMX260R3SL32M	K	26,000	26,999	60	32	186	126	81
6572104	TDMX270R3SL32M	L	27,000	27,999	60	32	191	131	84
6572105	TDMX280R3SL32M	M	28,000	28,999	60	32	195	135	87
6572106	TDMX290R3SL32M	N	29,000	29,999	60	32	200	140	90
6572107	TDMX300R3SL32M	O	30,000	30,999	60	32	204	144	93
6572108	TDMX310R3SL32M	P	31,000	31,999	60	32	209	149	96
6572109	TDMX320R3SL40M	Q	32,000	33,999	70	40	228	158	102
6572110	TDMX340R3SL40M	R	34,000	35,999	70	40	237	167	108
6572121	TDMX360R3SL40M	S	36,000	37,999	70	40	246	176	114
6572122	TDMX380R3SL40M	T	38,000	40,000	70	40	255	185	120

NOTE: SSC = Pocket Seat Reference. To correspond with the SSC on the inserts.
L5 is dependent on the insert.

Modular Drills • TOP DRILL™ Modular X

TDMX • 5 x D • Side Lock Shank • Metric

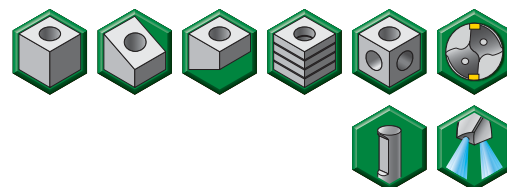
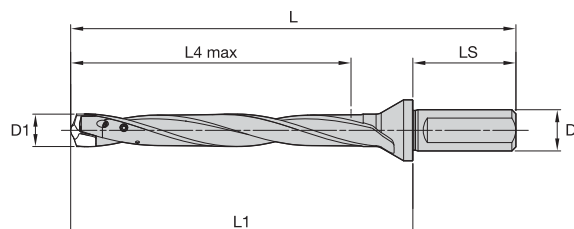
order number	catalog number	SSC	D1	D1 max	LS	D	L	L1	L4 max
6572125	TDMX160R5SL20M	A	16,000	16,999	50	20	165	115	85
6572126	TDMX170R5SL20M	B	17,000	17,999	50	20	172	122	90
6572127	TDMX180R5SL25M	C	18,000	18,999	56	25	184	128	95
6572128	TDMX190R5SL25M	D	19,000	19,999	56	25	191	135	100
6572129	TDMX200R5SL25M	E	20,000	20,999	56	25	197	141	105
6572130	TDMX210R5SL25M	F	21,000	21,999	56	25	204	148	110
6572141	TDMX220R5SL25M	G	22,000	22,999	56	25	210	154	115
6572142	TDMX230R5SL25M	H	23,000	23,999	56	25	217	161	120
6572143	TDMX240R5SL32M	I	24,000	24,999	60	32	227	167	125
6572144	TDMX250R5SL32M	J	25,000	25,999	60	32	234	174	130
6572145	TDMX260R5SL32M	K	26,000	26,999	60	32	240	180	135
6572146	TDMX270R5SL32M	L	27,000	27,999	60	32	247	187	140
6572147	TDMX280R5SL32M	M	28,000	28,999	60	32	253	193	145
6572148	TDMX290R5SL32M	N	29,000	29,999	60	32	260	200	150
6572149	TDMX300R5SL32M	O	30,000	30,999	60	32	266	206	155
6572150	TDMX310R5SL32M	P	31,000	31,999	60	32	273	213	160
6572151	TDMX320R5SL40M	Q	32,000	33,999	70	40	296	226	170
6572152	TDMX340R5SL40M	R	34,000	35,999	70	40	309	239	180
6572153	TDMX360R5SL40M	S	36,000	37,999	70	40	322	252	190
6572154	TDMX380R5SL40M	T	38,000	40,000	70	40	335	265	200

NOTE: SSC = Pocket Seat Reference. To correspond with the SSC on the inserts.
L5 is dependent on the insert.

TDMX — TOP DRILL™ Modular X

Modular Drills • TOP DRILL Modular X

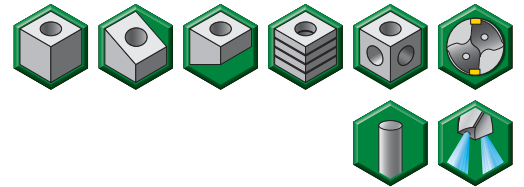
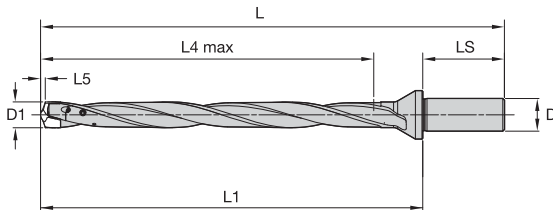
TDMX • 8 x D • Side Lock Shank • Metric



order number	catalog number	SSC	D1	D1 max	LS	D	LATTH	L	L1	L4 max
6572155	TDMX160R8SL20M	A	16,000	16,999	50	20	153,8	216	166	136
6572156	TDMX170R8SL20M	B	17,000	17,999	50	20	163,8	226	176	144
6572157	TDMX180R8SL25M	C	18,000	18,999	56	25	171,7	241	185	152
6572158	TDMX190R8SL25M	D	19,000	19,999	56	25	181,7	251	195	160
6572159	TDMX200R8SL25M	E	20,000	20,999	56	25	189,6	260	204	168
6572160	TDMX210R8SL25M	F	21,000	21,999	56	25	199,6	270	214	176
6572171	TDMX220R8SL25M	G	22,000	22,999	56	25	207,5	279	223	184
6572172	TDMX230R8SL25M	H	23,000	23,999	56	25	217,5	289	233	192
6572173	TDMX240R8SL32M	I	24,000	24,999	60	32	225,4	302	242	200
6572174	TDMX250R8SL32M	J	25,000	25,999	60	32	235,4	312	252	208
6572175	TDMX260R8SL32M	K	26,000	26,999	60	32	243,3	321	261	216
6572176	TDMX270R8SL32M	L	27,000	27,999	60	32	253,3	331	271	224
6572177	TDMX280R8SL32M	M	28,000	28,999	60	32	261,2	340	280	232
6572178	TDMX290R8SL32M	N	29,000	29,999	60	32	271,2	350	290	240
6572179	TDMX300R8SL32M	O	30,000	30,999	60	32	279,0	359	299	248
6572180	TDMX310R8SL32M	P	31,000	31,999	60	32	289,1	369	309	256
6572181	TDMX320R8SL40M	Q	32,000	33,999	70	40	306,0	398	328	272
6572182	TDMX340R8SL40M	R	34,000	35,999	70	40	325,0	417	347	288
6572183	TDMX360R8SL40M	S	36,000	37,999	70	40	341,8	436	366	304
6572184	TDMX380R8SL40M	T	38,000	40,000	70	40	360,8	455	385	320

NOTE: SSC = Pocket Seat Reference. To correspond with the SSC on the inserts.
L5 is dependent on the insert.

Modular Drills • TOP DRILL™ Modular X

TDMX • 12 x D • Flanged Round Shank • Metric

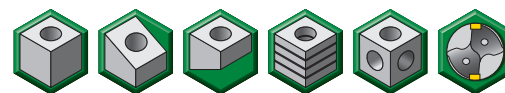
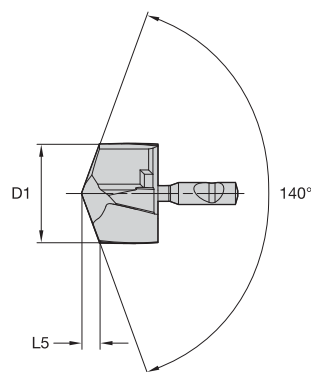
order number	catalog number	SSC	D1	D1 max	LS	D	LATTH	L	L1	L4 max
6681017	TDMX160R12SF20M	A	16,000	16,999	50	20	221,8	284	234	204
6681018	TDMX170R12SF20M	B	17,000	17,999	50	20	235,8	298	248	216
6681019	TDMX180R12SF25M	C	18,000	18,999	56	25	247,7	317	261	228
6681020	TDMX190R12SF25M	D	19,000	19,999	56	25	261,7	331	275	240
6681041	TDMX200R12SF25M	E	20,000	20,999	56	25	273,6	344	288	252
6681042	TDMX210R12SF25M	F	21,000	21,999	56	25	287,6	358	302	264
6681043	TDMX220R12SF25M	G	22,000	22,999	56	25	299,5	371	315	276
6681044	TDMX230R12SF25M	H	23,000	23,999	56	25	313,5	385	329	288
6681045	TDMX240R12SF32M	I	24,000	24,999	60	32	325,4	402	342	300
6681046	TDMX250R12SF32M	J	25,000	25,999	60	32	339,4	416	356	312
6681047	TDMX260R12SF32M	K	26,000	26,999	60	32	351,3	429	369	324
6681049	TDMX270R12SF32M	L	27,000	27,999	60	32	365,3	443	383	336
6681050	TDMX280R12SF32M	M	28,000	28,999	60	32	377,2	456	396	348
6681051	TDMX290R12SF32M	N	29,000	29,999	60	32	391,2	470	410	360
6681052	TDMX300R12SF32M	O	30,000	30,999	60	32	403,1	483	423	372
6681053	TDMX310R12SF32M	P	31,000	31,999	60	32	417,1	497	437	384

NOTE: SSC = Pocket Seat Reference. To correspond with the SSC on the inserts.
L5 is dependent on the insert.

TDMX — TOP DRILL™ Modular X

Modular Drills • TOP DRILL Modular X

TDMX • Inserts • PK(M)



● first choice

○ alternate choice

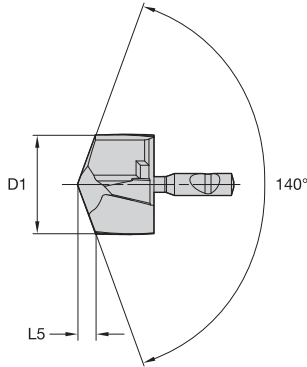
P		●
M		○
K		●
N		
S		
H		

catalog number	D1		L5		SSC	WP40PD
	mm	in	mm	in		
TDMX16000PKM	16,00	.630	3,21	.126	A	6568446
TDMX16200PKM	16,20	.638	3,25	.128	A	6568447
TDMX16281PKM	16,28	.641	3,26	.128	A	6568448
TDMX16500PKM	16,50	.650	3,30	.130	A	6568449
TDMX16667PKM	16,67	.656	3,33	.131	A	6568450
TDMX17000PKM	17,00	.669	3,39	.134	B	6568461
TDMX17064PKM	17,06	.672	3,41	.134	B	6568462
TDMX17463PKM	17,46	.688	3,48	.137	B	6568464
TDMX17500PKM	17,50	.689	3,49	.137	B	6568465
TDMX17600PKM	17,60	.693	3,50	.138	B	6568467
TDMX17800PKM	17,80	.701	3,54	.139	B	6568471
TDMX17859PKM	17,86	.703	3,55	.140	B	6568472
TDMX18000PKM	18,00	.709	3,58	.141	C	6568473
TDMX18255PKM	18,26	.719	3,64	.143	C	6568474
TDMX18500PKM	18,50	.728	3,68	.145	C	6568475
TDMX18651PKM	18,65	.734	3,71	.146	C	6568476
TDMX18800PKM	18,80	.740	3,74	.147	C	6568477
TDMX19000PKM	19,00	.748	3,78	.149	D	6568478
TDMX19050PKM	19,05	.750	3,78	.149	D	6568479
TDMX19200PKM	19,20	.756	3,81	.150	D	6568480
TDMX19270PKM	19,27	.759	3,82	.150	D	6568481
TDMX19450PKM	19,45	.766	3,86	.152	D	6568482
TDMX19500PKM	19,50	.768	3,87	.152	D	6568483
TDMX19700PKM	19,70	.776	3,90	.154	D	6568484
TDMX19840PKM	19,84	.781	3,93	.155	D	6568485
TDMX20000PKM	20,00	.787	3,97	.156	E	6568813
TDMX20100PKM	20,10	.791	3,99	.157	E	6568814
TDMX20200PKM	20,20	.795	4,01	.158	E	6568815
TDMX20239PKM	20,24	.797	4,02	.158	E	6568816
TDMX20300PKM	20,30	.799	4,03	.159	E	6568817
TDMX20400PKM	20,40	.803	4,05	.159	E	6568818
TDMX20500PKM	20,50	.807	4,06	.160	E	6568819
TDMX20600PKM	20,60	.811	4,08	.161	E	6568820
TDMX20650PKM	20,65	.813	4,09	.161	E	6568841
TDMX20700PKM	20,70	.815	4,10	.161	E	6568842
TDMX20800PKM	20,80	.819	4,12	.162	E	6568843

Modular Drills • TOP DRILL™ Modular X

TDMX • Inserts • PK(M)

(continued)



● first choice

○ alternate choice

P		●
M		○
K		●
N		
S		
H		

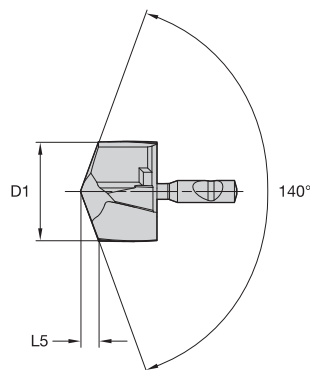
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TDMX21000PKM	21,00	.827	4,16	.164	F	6568845
TDMX21430PKM	21,43	.844	4,23	.167	F	6568846
TDMX21500PKM	21,50	.847	4,25	.167	F	6568847
TDMX22000PKM	22,00	.866	4,35	.171	G	6568848
TDMX22225PKM	22,23	.875	4,39	.173	G	6568849
TDMX22450PKM	22,45	.884	4,44	.175	G	6568850
TDMX22500PKM	22,50	.886	4,44	.175	G	6568851
TDMX23000PKM	23,00	.906	4,54	.179	H	6568852
TDMX23500PKM	23,50	.925	4,63	.182	H	6568853
TDMX23813PKM	23,81	.938	4,68	.184	H	6568854
TDMX24000PKM	24,00	.945	4,73	.186	I	6568856
TDMX24500PKM	24,50	.965	4,82	.190	I	6568857
TDMX24605PKM	24,61	.969	4,84	.191	I	6568858
TDMX25000PKM	25,00	.984	4,91	.193	J	6568859
TDMX25400PKM	25,40	1.000	4,99	.197	J	6568860
TDMX25500PKM	25,50	1.004	5,01	.197	J	6568861
TDMX25670PKM	25,67	1.011	5,04	.198	J	6568862
TDMX25700PKM	25,70	1.012	5,04	.198	J	6568863
TDMX25760PKM	25,76	1.014	5,05	.199	J	6568864
TDMX25796PKM	25,80	1.016	5,06	.199	J	6568865
TDMX26000PKM	26,00	1.024	5,11	.201	K	6568866
TDMX26192PKM	26,19	1.031	5,15	.203	K	6568867
TDMX26400PKM	26,40	1.039	5,18	.204	K	6568868
TDMX26500PKM	26,50	1.043	5,20	.205	K	6568869
TDMX26589PKM	26,59	1.047	5,22	.206	K	6568870
TDMX27000PKM	27,00	1.063	5,29	.208	L	6568871
TDMX27500PKM	27,50	1.083	5,38	.212	L	6568872
TDMX27780PKM	27,78	1.094	5,43	.214	L	6568873
TDMX28000PKM	28,00	1.102	5,49	.216	M	6568874
TDMX28176PKM	28,18	1.109	5,52	.217	M	6568875
TDMX28500PKM	28,50	1.122	5,58	.220	M	6568876
TDMX28575PKM	28,58	1.125	5,59	.220	M	6568877
TDMX29000PKM	29,00	1.142	5,67	.223	N	6568878
TDMX29367PKM	29,37	1.156	5,74	.226	N	6568879
TDMX29500PKM	29,50	1.161	5,76	.227	N	6568880

TDMX — TOP DRILL™ Modular X

Modular Drills • TOP DRILL Modular X

TDMX • Inserts • PK(M)

(continued)



- first choice
- alternate choice

P		●
M		○
K		●
N		
S		
H		

catalog number	D1		L5		SSC	WP40PD
	mm	in	mm	in		
TDMX29764PKM	29,76	1.172	5,81	.229	N	6568891
TDMX30000PKM	30,00	1.181	5,87	.231	O	6568892
TDMX30163PKM	30,16	1.188	5,90	.232	O	6568893
TDMX30500PKM	30,50	1.201	5,96	.235	O	6568896
TDMX30955PKM	30,96	1.219	6,04	.238	O	6568897
TDMX31000PKM	31,00	1.221	6,05	.238	P	6568898
TDMX31500PKM	31,50	1.240	6,14	.242	P	6568899
TDMX31750PKM	31,75	1.250	6,18	.243	P	6568900
TDMX32000PKM	32,00	1.260	6,25	.246	Q	6568901
TDMX32500PKM	32,50	1.280	6,34	.250	Q	6568902
TDMX33000PKM	33,00	1.299	6,43	.253	Q	6568903
TDMX33338PKM	33,34	1.313	6,49	.256	Q	6568904
TDMX34000PKM	34,00	1.339	6,61	.260	R	6568905
TDMX34130PKM	34,13	1.344	6,64	.261	R	6568906
TDMX34925PKM	34,93	1.375	6,78	.267	R	6568907
TDMX35000PKM	35,00	1.378	6,79	.267	R	6568908
TDMX35500PKM	35,50	1.398	6,89	.271	R	6568909
TDMX36000PKM	36,00	1.417	7,00	.276	S	6568910
TDMX36500PKM	36,50	1.437	7,09	.279	S	6568911
TDMX37000PKM	37,00	1.457	7,18	.283	S	6568912
TDMX37500PKM	37,50	1.476	7,27	.286	S	6568913
TDMX38000PKM	38,00	1.496	7,36	.290	T	6568914
TDMX38100PKM	38,10	1.500	7,38	.291	T	6568915
TDMX38500PKM	38,50	1.516	7,46	.294	T	6568916
TDMX39000PKM	39,00	1.535	7,55	.297	T	6568917
TDMX39289PKM	39,29	1.547	7,60	.299	T	6568918
TDMX39500PKM	39,50	1.555	7,64	.301	T	6568919
TDMX40000PKM	40,00	1.575	7,73	.304	T	6568920

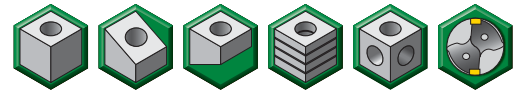
NOTE: SSC = Pocket Seat Reference. To correspond with the SSC on the toolholder.

Inch tolerance		Metric tolerance	
D1	tolerance k8	D1	tolerance k8
.3125-.3906	.000/+0.0009	8-10	0,000/+0,022
>.3906-.6250	.000/+0.0011	>10-17	0,000/+0,027
>.6692-.7090	.000/+0.0010	>17-18	0,000/+0,027
>.7090-.8228	.000/+0.0013	>18-21	0,000/+0,033



Modular Drills • TOP DRILL™ Modular X

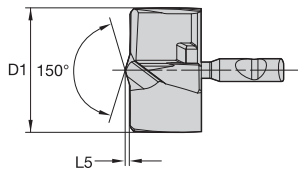
TDMX • Inserts • FPE(M)



● first choice

○ alternate choice

P		●
M		○
K		●
N		
S		
H		



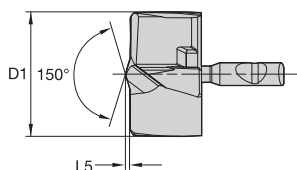
catalog number	D1		L5		SSC	WP40PD
	mm	in	mm	in		
TDMX16000FPEM	16,00	.630	1,16	.046	A	6693048
TDMX16281FPEM	16,28	.641	1,17	.046	A	6693049
TDMX16500FPEM	16,50	.650	1,17	.046	A	6693050
TDMX16667FPEM	16,67	.656	1,17	.046	A	6693111
TDMX17000FPEM	17,00	.669	1,18	.047	B	6693112
TDMX17064FPEM	17,06	.672	1,18	.047	B	6693113
TDMX17500FPEM	17,50	.689	1,19	.047	B	6693114
TDMX18000FPEM	18,00	.709	1,28	.050	C	6693115
TDMX18500FPEM	18,50	.728	1,28	.050	C	6693116
TDMX19000FPEM	19,00	.748	1,29	.051	D	6693117
TDMX19050FPEM	19,05	.750	1,29	.051	D	6693118
TDMX19500FPEM	19,50	.768	1,30	.051	D	6693119
TDMX19840FPEM	19,84	.781	1,31	.052	D	6693120
TDMX20000FPEM	20,00	.787	1,39	.055	E	6693131
TDMX20500FPEM	20,50	.807	1,40	.055	E	6693132
TDMX21000FPEM	21,00	.827	1,40	.055	F	6693133
TDMX21500FPEM	21,50	.847	1,41	.056	F	6693134
TDMX22000FPEM	22,00	.866	1,50	.059	G	6693135
TDMX22500FPEM	22,50	.886	1,51	.059	G	6693136
TDMX23000FPEM	23,00	.906	1,51	.059	H	6693137
TDMX23500FPEM	23,50	.925	1,52	.060	H	6693138
TDMX24000FPEM	24,00	.945	1,61	.063	I	6693139
TDMX24500FPEM	24,50	.965	1,62	.064	I	6693140
TDMX25000FPEM	25,00	.984	1,62	.064	J	6693151
TDMX25400FPEM	25,40	1.000	1,63	.064	J	6693152
TDMX25500FPEM	25,50	1.004	1,63	.064	J	6693153
TDMX26000FPEM	26,00	1.024	1,72	.068	K	6693154
TDMX26400FPEM	26,40	1.039	1,72	.068	K	6693194
TDMX26500FPEM	26,50	1.043	1,72	.068	K	6693155
TDMX27000FPEM	27,00	1.063	1,73	.068	L	6693156
TDMX27500FPEM	27,50	1.083	1,74	.069	L	6693157
TDMX28000FPEM	28,00	1.102	1,83	.072	M	6693158
TDMX28500FPEM	28,50	1.122	1,83	.072	M	6693160
TDMX29000FPEM	29,00	1.142	1,84	.072	N	6693161
TDMX29500FPEM	29,50	1.161	1,85	.073	N	6693162
TDMX30000FPEM	30,00	1.181	1,93	.076	O	6693163

TDMX — TOP DRILL™ Modular X

Modular Drills • TOP DRILL Modular X

TDMX • Inserts • FPE(M)

(continued)



- first choice
- alternate choice

P		●
M		○
K		●
N		
S		
H		

catalog number	D1		L5		SSC	WP40PD
	mm	in	mm	in		
TDMX30500FPEM	30,50	1.201	1,94	.076	O	6693164
TDMX31000FPEM	31,00	1.221	1,94	.076	P	6693165
TDMX31500FPEM	31,50	1.240	1,95	.077	P	6693166
TDMX31750FPEM	31,75	1.250	1,95	.077	P	6693167
TDMX32000FPEM	32,00	1.260	2,08	.082	Q	6693168
TDMX32500FPEM	32,50	1.280	2,08	.082	Q	6693169
TDMX33000FPEM	33,00	1.299	2,09	.082	Q	6693170
TDMX34000FPEM	34,00	1.339	2,10	.083	R	6693181
TDMX35000FPEM	35,00	1.378	2,11	.083	R	6693182
TDMX35500FPEM	35,50	1.398	2,12	.084	R	6693183
TDMX36000FPEM	36,00	1.417	2,29	.090	S	6693184
TDMX36500FPEM	36,50	1.437	2,29	.090	S	6693185
TDMX37000FPEM	37,00	1.457	2,30	.091	S	6693186
TDMX37500FPEM	37,50	1.476	2,30	.091	S	6693187
TDMX38000FPEM	38,00	1.496	2,31	.091	T	6693188
TDMX38100FPEM	38,10	1.500	2,31	.091	T	6693189
TDMX38500FPEM	38,50	1.516	2,32	.091	T	6693190
TDMX39000FPEM	39,00	1.535	2,32	.091	T	6693191
TDMX39500FPEM	39,50	1.555	2,33	.092	T	6693192
TDMX40000FPEM	40,00	1.575	2,33	.092	T	6693193

NOTE: SSC = Pocket Seat Reference. To correspond with the SSC on the toolholder.

Inch tolerance		Metric tolerance	
D1	tolerance k8	D1	tolerance k8
.3125-.3906	.000/+0.0009	8-10	0,000/+0,022
>.3906-.6250	.000/+0.0011	>10-17	0,000/+0,027
>.6692-.7090	.000/+0.0010	>17-18	0,000/+0,027
>.7090-.8228	.000/+0.0013	>18-21	0,000/+0,033



Modular Drills • TOP DRILL™ Modular X

Application Data • PK(M) • WP40PD • Inch

Material Group										
		Cutting Speed – Vc Range – SFM			Recommended Feed Rate (f) by Diameter					
		min	Starting Value	max	Tool Diameter (inch)	.630	.787	1.000	1.260	1.575
P	1	295	410	558	IPR	.007–.018	.010–.019	.010–.020	.011–.022	.011–.024
	2	344	459	590	IPR	.009–.018	.011–.020	.012–.020	.013–.022	.014–.024
	3	164	246	328	IPR	.009–.018	.011–.020	.012–.020	.013–.022	.014–.024
	4	164	246	328	IPR	.007–.018	.009–.019	.010–.020	.011–.022	.011–.023
	5	164	213	262	IPR	.006–.013	.007–.014	.009–.017	.009–.018	.010–.019
	6	164	213	262	IPR	.006–.013	.007–.014	.009–.017	.009–.018	.010–.019
M	1	131	262	361	IPR	.004–.010	.005–.012	.005–.013	.006–.014	.006–.015
	2	115	180	246	IPR	.004–.010	.005–.012	.005–.013	.006–.014	.006–.015
	3	66	115	164	IPR	.004–.010	.005–.012	.005–.013	.006–.014	.006–.015
K	1	197	312	558	IPR	.010–.019	.011–.020	.013–.022	.014–.024	.015–.026
	2	197	246	295	IPR	.010–.019	.011–.020	.013–.022	.014–.024	.015–.026
	3	131	213	295	IPR	.008–.017	.009–.019	.010–.020	.011–.022	.011–.023

NOTE: Through coolant recommended for greater than 3 x D applications.
Material group M is recommended for secondary applications.

Application Data • PK(M) • WP40PD • Metric

Material Group										
		Cutting Speed – Vc Range – m/min			Recommended Feed Rate (f) by Diameter					
		min	Starting Value	max	Tool Diameter (mm)	16,0	20,0	25,0	32,0	40,0
P	1	90	125	170	mm/r	0,19–0,45	0,25–0,48	0,25–0,52	0,28–0,57	0,29–0,60
	2	105	140	180	mm/r	0,23–0,46	0,28–0,50	0,30–0,52	0,33–0,57	0,35–0,60
	3	50	75	100	mm/r	0,23–0,46	0,28–0,50	0,30–0,52	0,33–0,57	0,35–0,60
	4	50	75	100	mm/r	0,19–0,45	0,22–0,48	0,25–0,50	0,28–0,55	0,29–0,58
	5	50	65	80	mm/r	0,16–0,32	0,18–0,36	0,22–0,42	0,24–0,46	0,25–0,48
	6	50	65	80	mm/r	0,16–0,32	0,18–0,36	0,22–0,42	0,24–0,46	0,25–0,48
M	1	40	80	110	mm/r	0,11–0,26	0,13–0,28	0,13–0,32	0,14–0,35	0,15–0,37
	2	35	55	75	mm/r	0,11–0,26	0,13–0,28	0,13–0,32	0,14–0,35	0,15–0,37
	3	20	35	50	mm/r	0,11–0,26	0,13–0,28	0,13–0,32	0,14–0,35	0,15–0,37
K	1	60	95	170	mm/r	0,25–0,48	0,28–0,52	0,32–0,56	0,35–0,62	0,37–0,65
	2	60	75	90	mm/r	0,25–0,48	0,28–0,52	0,32–0,56	0,35–0,62	0,37–0,65
	3	40	65	90	mm/r	0,21–0,44	0,23–0,48	0,25–0,50	0,28–0,55	0,29–0,58

NOTE: Through coolant recommended for greater than 3 x D applications.
Material group M is recommended for secondary applications.

TDMX — TOP DRILL™ Modular X

Modular Drills • TOP DRILL Modular X

Application Data • FPE(M) • WP40PD • Inch

Material Group										
		Cutting Speed – Vc			Recommended Feed Rate (f) by Diameter					
		min	Starting Value	max	Tool Diameter (inch)	.630	.787	1.000	1.260	1.575
P	1	360	460	560	IPR	.007–.010	.007–.011	.009–.015	.010–.017	.013–.030
	2	330	390	460	IPR	.007–.010	.009–.011	.011–.015	.013–.017	.013–.030
	3	260	330	390	IPR	.006–.009	.007–.010	.009–.013	.010–.015	.013–.026
	4	230	300	360	IPR	.005–.009	.006–.010	.007–.013	.008–.015	.010–.026
M	1	130	200	260	IPR	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	2	110	180	230	IPR	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	3	70	130	200	IPR	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
K	1	300	440	570	IPR	.007–.010	.009–.011	.011–.015	.013–.017	.013–.030
	2	260	390	460	IPR	.007–.010	.009–.011	.011–.015	.013–.017	.013–.030
	3	230	360	410	IPR	.007–.010	.008–.011	.009–.015	.010–.017	.011–.022
S	1	70	130	200	IPR	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	3	50	100	150	IPR	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012

NOTE: Through coolant recommended for greater than 3 x D applications.
Material group M is recommended for secondary applications.

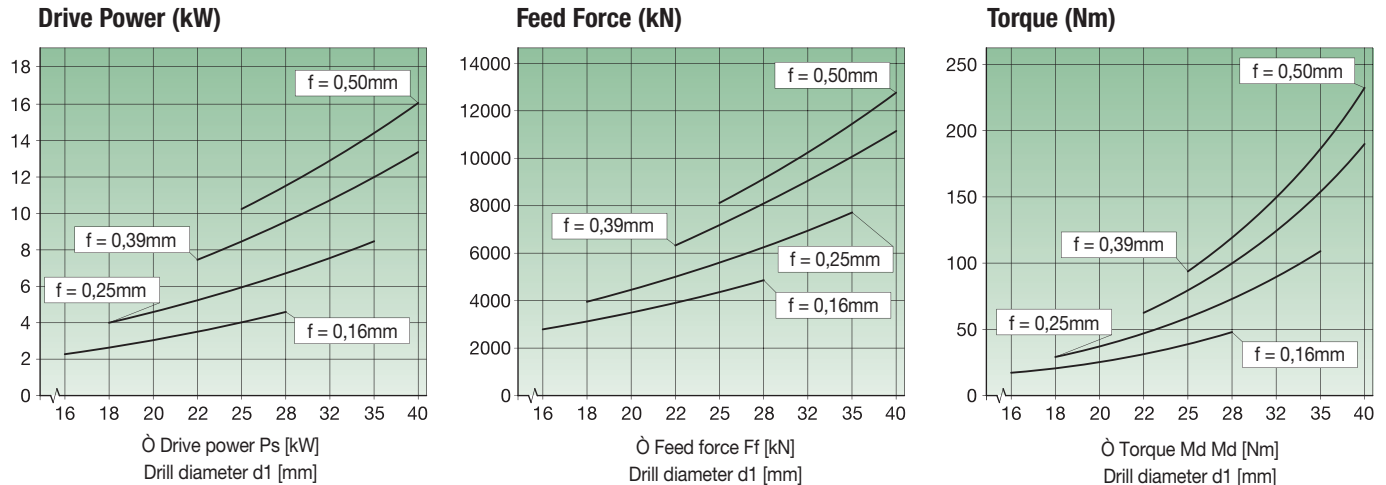
Application Data • FPE(M) • WP40PD • Metric

Material Group										
		Cutting Speed – Vc			Recommended Feed Rate (f) by Diameter					
		min	Starting Value	max	Tool Diameter (mm)	16,0	20,0	25,0	32,0	40,0
P	1	110	140	170	mm/r	0,17–0,25	0,19–0,29	0,23–0,38	0,26–0,43	0,33–0,76
	2	100	120	140	mm/r	0,19–0,25	0,22–0,29	0,29–0,38	0,32–0,43	0,33–0,76
	3	80	100	120	mm/r	0,15–0,23	0,17–0,25	0,23–0,34	0,26–0,38	0,33–0,66
	4	70	90	110	mm/r	0,13–0,23	0,14–0,25	0,18–0,34	0,21–0,38	0,26–0,66
M	1	40	60	80	mm/r	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	2	35	55	70	mm/r	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	3	20	40	60	mm/r	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
K	1	90	135	175	mm/r	0,19–0,25	0,22–0,29	0,29–0,38	0,32–0,43	0,33–0,76
	2	80	120	140	mm/r	0,19–0,25	0,22–0,29	0,29–0,38	0,32–0,43	0,33–0,76
	3	70	110	125	mm/r	0,18–0,26	0,21–0,29	0,23–0,37	0,25–0,42	0,27–0,57
S	1	20	40	60	mm/r	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	3	15	30	45	mm/r	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31

NOTE: Through coolant recommended for greater than 3 x D applications.
Material group M is recommended for secondary applications.

Modular Drills • TOP DRILL™ Modular X

TDMX Application Notes • Power and Coolant Requirements



TDMX • Regrinding Length • FPE(M) • Inch

SSC	diameter range D	L min.	L new
A	.6300-.6692	.3858	.4252
B	.6693-.7086	.3858	.4252
C	.7087-.7480	.4173	.4606
D	.7481-.7874	.4173	.4606
E	.7875-.8267	.4488	.4961
F	.8268-.8661	.4488	.4961
G	.8662-.9055	.4764	.5276
H	.9056-.9448	.4764	.5276
I	.9449-.9842	.5118	.5669
J	.9843-1.0236	.5118	.5669
K	1.0237-1.0629	.5433	.6024
L	1.063-1.1023	.5433	.6024
M	1.1024-1.1417	.5827	.6457
N	1.1418-1.1811	.5827	.6457
O	1.1812-1.2204	.6142	.6811
P	1.2205-1.2598	.6142	.6811
Q	1.2599-1.3385	.7008	.7756
R	1.3386-1.4173	.7008	.7756
S	1.4174-1.4960	.7638	.8465
T	1.4961-1.5748	.7638	.8465

NOTE: SSC = Pocket Seat Reference. To correspond with the SSC on the inserts.

TDMX • Regrinding Length • PK(M) • Inch

SSC	diameter range D	L min.	L new
A	.63-.6692	.4409	.4921
B	.6693-.7086	.4409	.4921
C	.7087-.748	.4803	.5354
D	.7481-.7874	.4803	.5354
E	.7875-.8267	.5197	.5787
F	.8268-.8661	.5197	.5787
G	.8662-.9055	.5591	.622
H	.9056-.9448	.5591	.622
I	.9449-.9842	.5984	.6654
J	.9843-1.0236	.5984	.6654
K	1.0237-1.0629	.6378	.7087
L	1.063-1.1023	.6378	.7087
M	1.1024-1.1417	.6772	.752
N	1.1418-1.1811	.6772	.752
O	1.1812-1.2204	.7165	.7953
P	1.2205-1.2598	.7165	.7953
Q	1.2599-1.3385	.7913	.878
R	1.3386-1.4173	.7913	.878
S	1.4174-1.496	.8701	.9646
T	1.4961-1.5748	.8701	.9646

The following coolant pressure is recommended:

relative drilling depth	coolant pressure
1-3 x D	8 bars
5 x D	12 bars
7 x D	20 bars
10 x D	30 bars

