

# Deep Hole Drilling Tools

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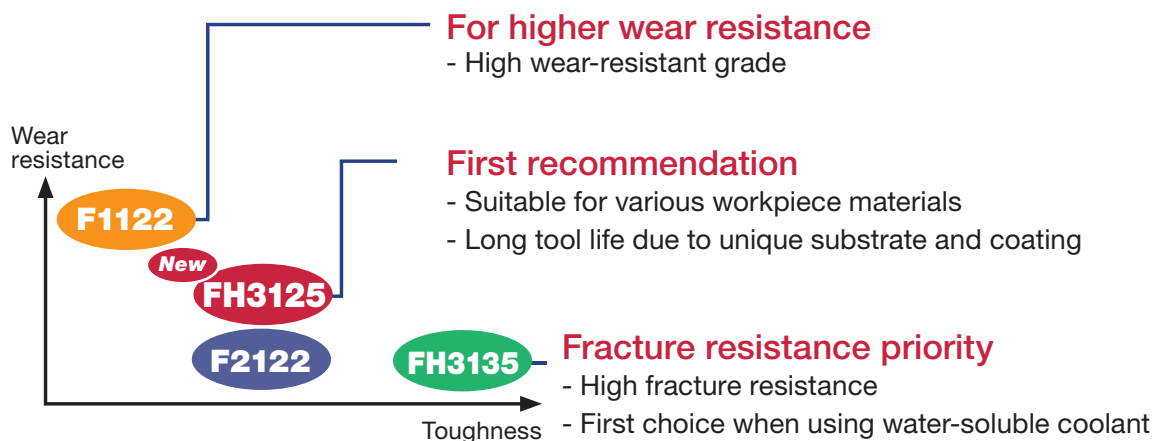
Tungaloy Report No. 538-G

**Expansion** of Indexable carbide guide pads  
- **Double chamfer & FH3125** grade

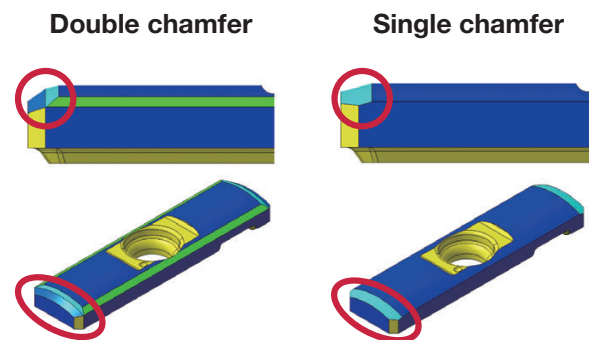
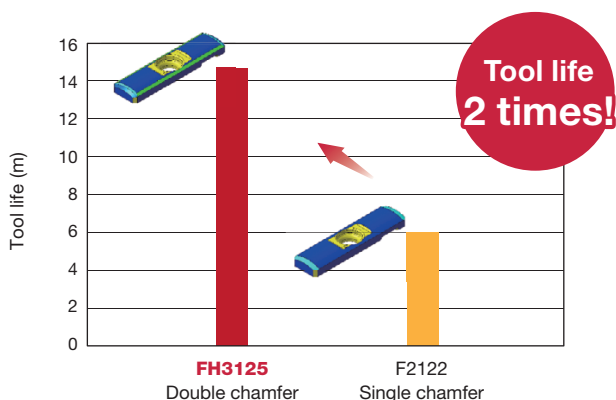


# Deep Hole Drilling Tools

Long tool life and high performance are now possible with new combination of **double chamfer & FH3125** grade



## CUTTING PERFORMANCE



### Advantages:

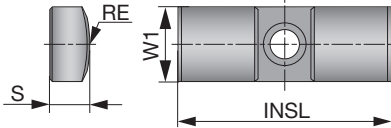
- Promotes smooth entry into the bore
- Reduces the risk of guide pad rupture for extended tool life

**P** Drill : TRLG20.01X1200-U04  
 Workpiece material : SNCM439H  
 Cutting speed :  $V_c = 100$  m/min  
 Feed :  $f = 0.15$  mm/rev  
 Coolant : Wet

**Double chamfer significantly improved fracture resistance and has increased tool life by 2 times more than single chamfer.**

## CARBIDE GUIDE PADS LINE UP

**GP04,05, 06, 07, 08, 10, 12, 14, 18**



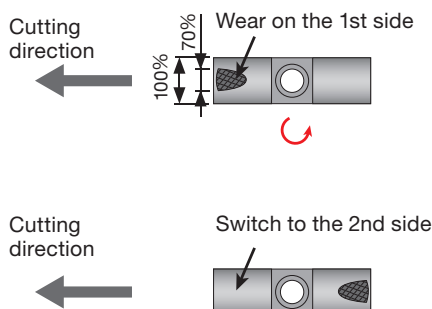
Designation	Applicable drill																Chamfer
	F1122	F2122	FH3125	FH3135	W1	INSL	S	RE	DEEPTDRILL		TRI-FINE		FINE-BEAM		UNIDEX		
									Min. dia	Max. dia	Min. dia	Max. dia	Min. dia	Max. dia	Min. dia	Max. dia	
GP04-055	●	▲			4	16	2	5.5	12	13.99	-	-	-	-	-	-	Single
GP04-16-055-DC			●	●	4	16	2	5.5	12	13.99	-	-	-	-	-	-	Double
GP05-060	●	▲			5	18	2.5	6	14	15.99	-	-	-	-	-	-	Single
GP05-18-060-DC			●	●	5	18	2.5	6	14	15.99	-	-	-	-	-	-	Double
GP05-075	●	▲			5	18	2.5	7.5	16	18	-	-	-	-	-	-	Single
GP05-18-075-DC			●	●	5	18	2.5	7.5	16	18	-	-	-	-	-	-	Double
GP06-075	●	▲			6	20	3	7.5	-	-	16	18	-	-	-	-	Single
GP06-20-075-DC			●	●	6	20	3	7.5	-	-	16	18	-	-	-	-	Double
GP06-085	●	▲			6	20	3	8.5	18.01	21	18.01	21	-	-	-	-	Single
GP06-20-085-DC			●	●	6	20	3	8.5	18.01	21	18.01	21	-	-	-	-	Double
GP06-100	●	▲			6	20	3	10	21.01	25	21.01	25	-	-	-	-	Single
GP06-20-100-DC			●	●	6	20	3	10	21.01	25	21.01	25	-	-	-	-	Double
GP06	●	▲			6	20	3	12	25.01	33	25.01	28	25	29.99	-	-	Single
GP06-20-120-DC			●	●	6	20	3	12	25.01	33	25.01	28	25	29.99	-	-	Double
GP07	●	▲			7	20	3.5	12	33.01	38	-	-	30	39	-	-	Single
GP07-20-120-DC			●	●	7	20	3.5	12	33.01	38	-	-	30	39	-	-	Double
GP08	●	▲			8	25	4.5	15.5	38.01	40	-	-	39.01	45	38	44.99	Single
GP08-25-155-DC			●	●	8	25	4.5	15.5	38.01	40	-	-	39.01	45	38	44.99	Double
GP10S	●	▲			10	30	4.5	20	-	-	-	-	45.01	57	-	-	Single
GP10-30-200-DC			●	●	10	30	4.5	20	-	-	-	-	45.01	57	-	-	Double
GP10	●	▲			10	35	6	20	-	-	-	-	-	-	45	59.99	Single
GP10-35-200-DC			●	●	10	35	6	20	-	-	-	-	-	-	45	59.99	Double
GP12	●	▲			12	35	5.5	25	-	-	-	-	57.01	65	-	-	Single
GP12-35-250-DC			●	●	12	35	5.5	25	-	-	-	-	57.01	65	-	-	Double
GP14	●	▲			14	40	7.5	25	-	-	-	-	-	-	60	98.99	Single
GP14-40-250-DC			●	●	14	40	7.5	25	-	-	-	-	-	-	60	98.99	Double
GP18	●	▲			18	40	9	30	-	-	-	-	-	-	99	293.99	Single
GP18-40-300-DC			●	●	18	40	9	30	-	-	-	-	-	-	99	293.99	Double

●: Line-up  
 ●: New product  
 ▲: To be discontinued  
 Package quantity = 5 pcs.

### Guide pad grade and the timing for replacement

Guide pads are subject to wear, like inserts

- The guide pad has two sides.
- Each guide pad can be used on two sides. When the first corner wears out to 70% of the width, reverse the guide pad to use the second side.
- Replace with a new guide pad when the second side wears out.



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