Unique Modular System for Various Drilling Diameters and Depths
KEY POINT

As part of the new technologically advanced SFEED-TEC products, TaeguTec is introducing the MODU-R-DRILL modular type tool for holemaking applications, which is part of the TWIN-RUSH family.

The new SFEED-TEC modular type TWIN-RUSH line, provides superior machining and excellent hole quality for hole machining of 26 mm diameter and above, as well as improved productivity due to the symmetric design which reduces tool cost, yet expands the range of TWIN-RUSH applications.

By assembling a modular holder that fits the depth of the hole into a single modular head, the new offering is able to maintain high-feed machining and quality. It also reduces tool cost by only requiring the modular head be removed when changing the tool.

In the center of the modular head, a new uniquely designed head (TCD P-CO+) has been applied with a self-centering capability to improve the hole straightness. In addition, the exterior inserts with wiper area (SPGX-DW) and dedicated guide pads provide excellent surface roughness.

For further technical questions, please contact TaeguTec's product manager.
Features

- Unique cutting edge design improves self-centering and hole straightness
- TCD P-CO will be phased out when stock is sold-out
- Excellent surface roughness due to an insert with a wiper area
- Improved machining stability due to its dedicated guide pads
- Modular body changes enable 3xD and 5xD machining
  (Existing all-in-one holder can be delivered on demand)
Modular head replacement instructions

1. Remove both outer inserts, then remove the center drill head.
   (When clamping, go in the reverse order)

2. Use a wrench to turn the screw counter-clock-wise to remove the modular head.

3. Insert the setting gauge into the bottom of the disconnected modular head.

4. Rotate the screw to adjust to the same height as the setting gauge.

5. Remove the height adjusted modular head from the setting gauge and attach it to the holder.

<table>
<thead>
<tr>
<th>Drill dia.</th>
<th>Designation</th>
</tr>
</thead>
<tbody>
<tr>
<td>D26-D29</td>
<td>SG TNDH D26-29-TP</td>
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<tr>
<td>D30-D35</td>
<td>SG TNDH D30-35-TP</td>
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<tr>
<td>D36-D39</td>
<td>SG TNDH D36-39-TP</td>
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<tr>
<td>D40-D43</td>
<td>SG TNDH D40-43-TP</td>
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<tr>
<td>D44-D50</td>
<td>SG TNDH D44-50-TP</td>
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</tbody>
</table>
Modular head disassembly in the event of center drill damage

If the modular head cannot be unclamped due to center drill damage, insert the wrench into the rear section of the shank. Then, turn it clock-wise to disassemble the modular head.

- Disassembling wrench and handle are included with the modular drill holder. (MDB Dxx/xx…)
**MDB...T2-3**

Modular drill holders - Weldon type shank

- Drilling depth: 3x diameter

<table>
<thead>
<tr>
<th>Designation</th>
<th>Dimension (mm)</th>
<th>DC</th>
<th>DCONWS</th>
<th>DCONMS</th>
<th>DF</th>
<th>LU</th>
<th>LF</th>
<th>LS</th>
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<tr>
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- DC: Cutting diameter range
- DCONWS: Modular head connection size

**Spare parts**

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<thead>
<tr>
<th>Designation</th>
<th>Wrench</th>
<th>Wrench handle</th>
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<tr>
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<tr>
<td>MDB D36/37-D42/43</td>
<td>BLD H-W3.0x225</td>
<td>SW6-T-SH</td>
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<tr>
<td>MDB D44/45-D48/50</td>
<td>BLD H-W4.0x255</td>
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- Wrench: Disassemble the modular head from the modular body (Insert from the rear shank)
 MDB...T2-5

Modular drill holders - Weldon type shank

- Drilling depth: 5x diameter

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<thead>
<tr>
<th>Designation</th>
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- DC: Cutting diameter range
- DCONWS: Modular head connection size

Spare parts

<table>
<thead>
<tr>
<th>Designation</th>
<th>Wrench</th>
<th>Wrench handle</th>
</tr>
</thead>
<tbody>
<tr>
<td>MDB D26/27-D34/35</td>
<td>BLD H-W2.5x280</td>
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<tr>
<td>MDB D36/37-D42/43</td>
<td>BLD H-W3.0x310</td>
<td>SW6-T-SH</td>
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<tr>
<td>MDB D44/45-D48/50</td>
<td>BLD H-W4.0x350</td>
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</table>

- Wrench: Disassemble the modular head from the modular body (Insert from the rear shank)
## TNDH-TP

**Modular drill heads**

![Diagram of drill head](image)

<table>
<thead>
<tr>
<th>Designation</th>
<th>Dimension (mm)</th>
<th>Clamping Key</th>
<th>Insert</th>
</tr>
</thead>
<tbody>
<tr>
<td>TNDH 2600-C26-TP</td>
<td>DC 26, DCONMS 10.4, LPR 24.9, PL 3.98, PDD 15.9</td>
<td>K TCD D15-CO</td>
<td>TCD-159-P-CO+ SPGX 06...DW</td>
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<td>27, 10.4, 25.4, 4.14, 16.9</td>
<td>K TCD D16-CO</td>
<td>TCD-169-P-CO+ SPGX 06...DW</td>
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<tr>
<td>2800-C28-TP</td>
<td>28, 11.2, 26.9, 4.29, 17.9</td>
<td>K TCD D17-CO</td>
<td>TCD-179-P-CO+ SPGX 06...DW</td>
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<td>2900-C28-TP</td>
<td>29, 11.2, 26.6, 3.97, 15.9</td>
<td>K TCD D15-CO</td>
<td>TCD-159-P-CO+ SPGX 07...DW</td>
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<td>3000-C30-TP</td>
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<td>K TCD D16-CO</td>
<td>TCD-169-P-CO+ SPGX 07...DW</td>
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<td>3100-C30-TP</td>
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<td>K TCD D17-CO</td>
<td>TCD-179-P-CO+ SPGX 07...DW</td>
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<td>3200-C32-TP</td>
<td>32, 12.8, 30.3, 4.46, 18.9</td>
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<td>TCD-189-P-CO+ SPGX 07...DW</td>
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<td>3300-C32-TP</td>
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<td>3400-C34-TP</td>
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- **DCONMS**: Holder connection size
# TNDH-TP

## Spare parts

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<thead>
<tr>
<th>Designation</th>
<th>For double pitch screw</th>
<th>For SPGX</th>
<th>For Guide pad</th>
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<td>Screw2</td>
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## Setting gauge

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<td>SG TNDH D44-50-TP</td>
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**Self-centering drill heads**

![Image of drill heads]

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<th>Designation</th>
<th>Dimension (mm)</th>
<th>Grade</th>
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<td>189-P-CO+</td>
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<td>199-P-CO+</td>
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<td>209-P-CO+</td>
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<td>219-P-CO+</td>
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<td>229-P-CO+</td>
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<td>239-P-CO+</td>
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<td>249-P-CO+</td>
<td>24.9</td>
<td>13.90</td>
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<tr>
<td>259-P-CO+</td>
<td>25.9</td>
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* SSC: Seat size code
* •: Standard items
**SPGX...DW**

**Inserts**

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- **Insert Designation**: Coated/Uncoated
  - TT9080
  - TT8020
  - TT9300
  - TT6030
  - TT7400
  - K10

- **Designation**: SPGX 060204 DW
- **Designation**: 07T308 DW
- **Designation**: 090408 DW
- **Designation**: 110408 DW
- **Designation**: 140512 DW

*• Standard items*

---

**Guide Pad for TNDH-TP**

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*• Guide pad is sold separately from drill body.*

*• Standard items*
### Recommended Cutting Conditions

<table>
<thead>
<tr>
<th>ISO</th>
<th>Material</th>
<th>Condition</th>
<th>Tensile Strength (N/mm²)</th>
<th>Hardness HB</th>
<th>Material Group No.</th>
<th>Cutting speed Vc (m/min)</th>
<th>Feed vs. Drill Diameter (mm/rev)</th>
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<tr>
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<td>SPGX 06 026-028 029-032 033-036 037-043 044-050</td>
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<td>&lt;0.25%C</td>
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