

# ACHTTECK

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ACHTTECK  
HP-3D220-S32-S07



## CUTTING TOOL CATALOGUE

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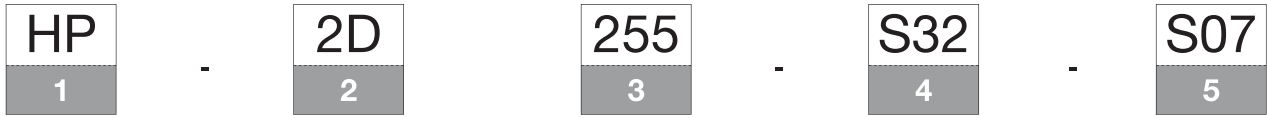
# ACHTTECK

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Drilling holders

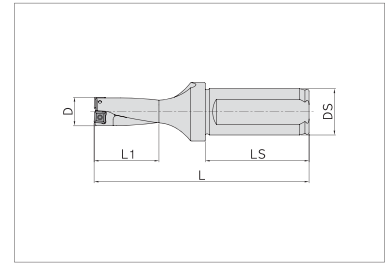
**Drilling Holder Designation System**



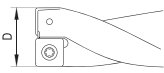


1	HP	Machining method	Represent for high efficiency machining			
2	2D	Length-diameter ratio	2D, 3D, 4D,			
3	255	Tool diameter	255-25.5mm, 500-50mm			
4	S32	Shank diameter	S20=20mm	S25=25mm	S32=32mm	S40=40mm
5	S07	Inserts shape and edge length	Insert shape "S", means the cutting edge length 7mm, if insert shape "W", the code is "W07"			

**DP Series Drilling Holder**

**Length-diameter ratio: 2D**

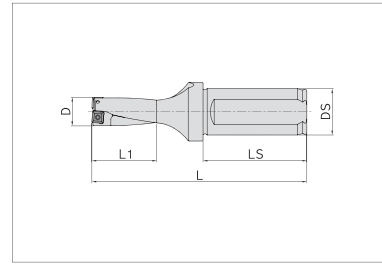


Designation	Dimension(mm)					Inserts
	D	L <sub>1</sub>	L	D <sub>s</sub>	L <sub>s</sub>	
HP-2D130-S20-S05	13.0	29	99	20	50	SPMT 050204E-DP
HP-2D135-S20-S05	13.5	30	100	20	50	
HP-2D140-S20-S05	14.0	31	101	20	50	
HP-2D145-S20-S05	14.5	32	102	20	50	
HP-2D150-S20-S05	15.0	33	103	20	50	
HP-2D155-S25-S06	15.5	34	115	25	56	SPMT 060204E-DP
HP-2D160-S25-S06	16.0	35	116	25	56	
HP-2D165-S25-S06	16.5	36	117	25	56	
HP-2D170-S25-S06	17.0	37	118	25	56	
HP-2D175-S25-S06	17.5	38	119	25	56	
HP-2D180-S25-S06	18.0	39	120	25	56	
HP-2D185-S25-S06	18.5	40	121	25	56	
HP-2D190-S25-S06	19.0	41	122	25	56	
HP-2D195-S25-S06	19.5	42	123	25	56	
HP-2D200-S25-S06	20.0	43	124	25	56	
HP-2D205-S25-S06	20.5	44	125	25	56	
HP-2D210-S25-S06	21.0	45	126	25	56	
HP-2D215-S25-S06	21.5	46	127	25	56	
HP-2D220-S32-S07	22.0	47	137	32	60	SPMT 07T308E-DP
HP-2D225-S32-S07	22.5	48	138	32	60	
HP-2D230-S32-S07	23.0	49	139	32	60	
HP-2D235-S32-S07	23.5	50	140	32	60	
HP-2D240-S32-S07	24.0	51	141	32	60	
HP-2D245-S32-S07	24.5	52	142	32	60	
HP-2D250-S32-S07	25.0	53	143	32	60	
HP-2D255-S32-S07	25.5	54	144	32	60	
HP-2D260-S32-S07	26.0	55	145	32	60	
HP-2D265-S32-S07	26.5	56	146	32	60	
HP-2D270-S32-S07	27.0	57	147	32	60	
HP-2D275-S32-S07	27.5	58	148	32	60	

Dimensions (mm)	Spare parts	
Holder diameter	Screw	Wrench
		
13-15	AST2043-60	AWF-T06
15.5-21.5	AST2255-60	AWF-T06
22-27.5	AST25065-60S	AWF-T08

**DP Series Drilling Holder**

**Length-diameter ratio: 2D**



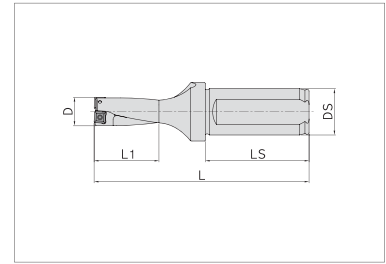
Designation	Dimension(mm)					Inserts
	D	L <sub>1</sub>	L	D <sub>s</sub>	L <sub>s</sub>	
HP-2D280-S32-S09	28.0	59	149	32	60	SPMT 090408E-DP
HP-2D285-S32-S09	28.5	60	150	32	60	
HP-2D290-S32-S09	29.0	61	151	32	60	
HP-2D295-S32-S09	29.5	63	153	32	60	
HP-2D300-S32-S09	30.0	65	155	32	60	
HP-2D310-S32-S09	31.0	67	157	32	60	
HP-2D320-S32-S09	32.0	69	159	32	60	
HP-2D330-S32-S09	33.0	71	161	32	60	
HP-2D340-S40-S11	34.0	73	178	40	70	SPMT 110408E-DP
HP-2D350-S40-S11	35.0	75	180	40	70	
HP-2D360-S40-S11	36.0	77	182	40	70	
HP-2D370-S40-S11	37.0	79	184	40	70	
HP-2D380-S40-S11	38.0	81	186	40	70	
HP-2D390-S40-S11	39.0	83	188	40	70	
HP-2D400-S40-S11	40.0	85	190	40	70	
HP-2D410-S40-S11	41.0	87	192	40	70	
HP-2D420-S40-S14	42.0	89	194	40	70	SPMT 140512E-DP
HP-2D430-S40-S14	43.0	91	196	40	70	
HP-2D440-S40-S14	44.0	93	198	40	70	
HP-2D450-S40-S14	45.0	95	200	40	70	
HP-2D460-S40-S14	46.0	97	202	40	70	
HP-2D470-S40-S14	47.0	99	204	40	70	
HP-2D480-S40-S14	48.0	101	206	40	70	
HP-2D490-S40-S14	49.0	103	208	40	70	
HP-2D500-S40-S14	50.0	105	210	40	70	

Dimensions (mm)	Spare parts	
Holder diameter	Screw	Wrench
28-33	AST35084-60H	AWF-T15
34-41	AST410-60H	AWF-T15
42-50	AST5126-60	AWF-T20

Drilling holders

**DP Series Drilling Holder**

**Length-diameter ratio: 3D**

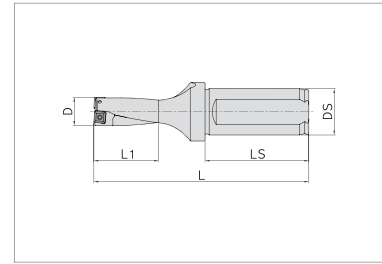


Designation	Dimension(mm)					Inserts
	D	L <sub>1</sub>	L	D <sub>s</sub>	L <sub>s</sub>	
HP-3D130-S20-S05	13.0	42	112	20	50	SPMT 050204E-DP
HP-3D135-S20-S05	13.5	44	114	20	50	
HP-3D140-S20-S05	14.0	45	115	20	50	
HP-3D145-S20-S05	14.5	47	117	20	50	
HP-3D150-S20-S05	15.0	48	118	20	50	
HP-3D155-S25-S06	15.5	50	131	25	56	SPMT 060204E-DP
HP-3D160-S25-S06	16.0	51	132	25	56	
HP-3D165-S25-S06	16.5	53	134	25	56	
HP-3D170-S25-S06	17.0	54	135	25	56	
HP-3D175-S25-S06	17.5	56	137	25	56	
HP-3D180-S25-S06	18.0	57	138	25	56	
HP-3D185-S25-S06	18.5	59	140	25	56	
HP-3D190-S25-S06	19.0	60	141	25	56	
HP-3D195-S25-S06	19.5	62	143	25	56	
HP-3D200-S25-S06	20.0	63	144	25	56	
HP-3D205-S25-S06	20.5	65	146	25	56	
HP-3D210-S25-S06	21.0	66	147	25	56	
HP-3D215-S25-S06	21.5	68	149	25	56	
HP-3D220-S32-S07	22.0	69	159	32	60	SPMT 07T308E-DP
HP-3D225-S32-S07	22.5	71	161	32	60	
HP-3D230-S32-S07	23.0	72	162	32	60	
HP-3D235-S32-S07	23.5	74	164	32	60	
HP-3D240-S32-S07	24.0	75	165	32	60	
HP-3D245-S32-S07	24.5	77	167	32	60	
HP-3D250-S32-S07	25.0	78	168	32	60	
HP-3D255-S32-S07	25.5	80	170	32	60	
HP-3D260-S32-S07	26.0	81	171	32	60	
HP-3D265-S32-S07	26.5	83	173	32	60	
HP-3D270-S32-S07	27.0	84	174	32	60	
HP-3D275-S32-S07	27.5	86	176	32	60	

Dimensions (mm)	Spare parts	
Holder diameter	Screw	Wrench
13-15	AST2043-60	AWF-T06
15.5-21.5	AST2255-60	AWF-T06
22-27.5	AST25065-60S	AWF-T08

**DP Series Drilling Holder**

**Length-diameter ratio: 3D**



Designation	Dimension(mm)					Inserts
	D	L <sub>1</sub>	L	D <sub>s</sub>	L <sub>s</sub>	
HP-3D280-S32-S09	28.0	87	177	32	60	SPMT 090408E-DP
HP-3D285-S32-S09	28.5	89	179	32	60	
HP-3D290-S32-S09	29.0	90	180	32	60	
HP-3D295-S32-S09	29.5	93	183	32	60	
HP-3D300-S32-S09	30.0	95	185	32	60	
HP-3D310-S32-S09	31.0	98	188	32	60	
HP-3D320-S32-S09	32.0	101	191	32	60	
HP-3D330-S32-S09	33.0	104	194	32	60	
HP-3D340-S40-S11	34.0	107	212	40	70	SPMT 110408E-DP
HP-3D350-S40-S11	35.0	110	215	40	70	
HP-3D360-S40-S11	36.0	113	218	40	70	
HP-3D370-S40-S11	37.0	116	221	40	70	
HP-3D380-S40-S11	38.0	119	224	40	70	
HP-3D390-S40-S11	39.0	122	227	40	70	
HP-3D400-S40-S11	40.0	125	230	40	70	
HP-3D410-S40-S11	41.0	128	233	40	70	
HP-3D420-S40-S14	42.0	131	236	40	70	SPMT 140512E-DP
HP-3D430-S40-S14	43.0	134	239	40	70	
HP-3D440-S40-S14	44.0	137	242	40	70	
HP-3D450-S40-S14	45.0	140	245	40	70	
HP-3D460-S40-S14	46.0	143	248	40	70	
HP-3D470-S40-S14	47.0	146	251	40	70	
HP-3D480-S40-S14	48.0	149	254	40	70	
HP-3D490-S40-S14	49.0	152	257	40	70	
HP-3D500-S40-S14	50.0	155	260	40	70	

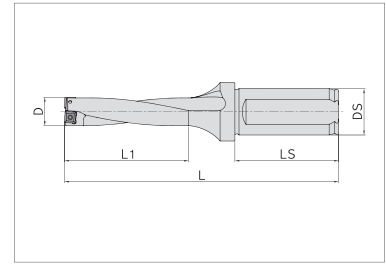
Dimensions (mm)	Spare parts	
Holder diameter	Screw	Wrench
28-33	AST35084-60H	AWF-T15
34-41	AST410-60H	AWF-T15
42-50	AST5126-60	AWF-T20

Drilling holders

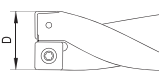




**DP Series Drilling Holder**

**Length-diameter ratio: 4D**

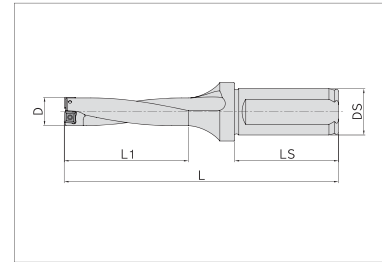


Designation	Dimension(mm)					Inserts
	D	L <sub>1</sub>	L	D <sub>s</sub>	L <sub>s</sub>	
HP-4D130-S20-S05	13.0	55	125	20	50	SPMT 050204E-DP
HP-4D135-S20-S05	13.5	57	127	20	50	
HP-4D140-S20-S05	14.0	59	129	20	50	
HP-4D145-S20-S05	14.5	61	131	20	50	
HP-4D150-S20-S05	15.0	63	133	20	50	
HP-4D155-S25-S06	15.5	65	146	25	56	SPMT 060204E-DP
HP-4D160-S25-S06	16.0	67	148	25	56	
HP-4D165-S25-S06	16.5	69	150	25	56	
HP-4D170-S25-S06	17.0	71	152	25	56	
HP-4D175-S25-S06	17.5	73	154	25	56	
HP-4D180-S25-S06	18.0	75	156	25	56	
HP-4D185-S25-S06	18.5	77	158	25	56	
HP-4D190-S25-S06	19.0	79	160	25	56	
HP-4D195-S25-S06	19.5	81	162	25	56	
HP-4D200-S25-S06	20.0	83	164	25	56	
HP-4D205-S25-S06	20.5	85	166	25	56	
HP-4D210-S25-S06	21.0	87	168	25	56	
HP-4D215-S25-S06	21.5	89	170	25	56	
HP-4D220-S32-S07	22.0	91	181	32	60	SPMT 07T308E-DP
HP-4D225-S32-S07	22.5	93	183	32	60	
HP-4D230-S32-S07	23.0	95	185	32	60	
HP-4D235-S32-S07	23.5	97	187	32	60	
HP-4D240-S32-S07	24.0	99	189	32	60	
HP-4D245-S32-S07	24.5	101	191	32	60	
HP-4D250-S32-S07	25.0	103	193	32	60	
HP-4D255-S32-S07	25.5	105	195	32	60	
HP-4D260-S32-S07	26.0	107	197	32	60	
HP-4D265-S32-S07	26.5	109	199	32	60	
HP-4D270-S32-S07	27.0	111	201	32	60	
HP-4D275-S32-S07	27.5	113	203	32	60	

Dimensions (mm)	Spare parts	
Holder diameter	Screw	Wrench
		
13-15	AST2043-60	AWF-T06
15.5-21.5	AST2255-60	AWF-T06
22-27.5	AST25065-60S	AWF-T08

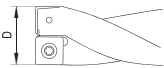


**DP Series Drilling Holder**

**Length-diameter ratio: 4D**



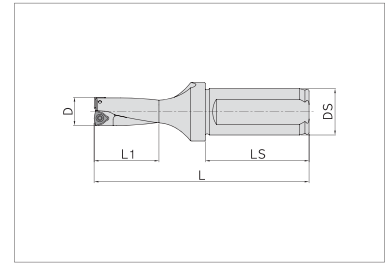
Designation	Dimension(mm)					Inserts
	D	L <sub>1</sub>	L	D <sub>s</sub>	L <sub>s</sub>	
HP-4D280-S32-S09	28.0	115	205	32	60	SPMT 090408E-DP
HP-4D285-S32-S09	28.5	117	207	32	60	
HP-4D290-S32-S09	29.0	120	210	32	60	
HP-4D295-S32-S09	29.5	123	213	32	60	
HP-4D300-S32-S09	30.0	125	215	32	60	
HP-4D310-S32-S09	31.0	129	219	32	60	
HP-4D320-S32-S09	32.0	133	223	32	60	
HP-4D330-S32-S09	33.0	137	227	32	60	
HP-4D340-S40-S11	34.0	141	246	40	70	SPMT 110408E-DP
HP-4D350-S40-S11	35.0	145	250	40	70	
HP-4D360-S40-S11	36.0	149	254	40	70	
HP-4D370-S40-S11	37.0	153	258	40	70	
HP-4D380-S40-S11	38.0	157	262	40	70	
HP-4D390-S40-S11	39.0	161	266	40	70	
HP-4D400-S40-S11	40.0	165	270	40	70	
HP-4D410-S40-S11	41.0	169	274	40	70	
HP-4D420-S40-S14	42.0	173	278	40	70	SPMT 140512E-DP
HP-4D430-S40-S14	43.0	177	282	40	70	
HP-4D440-S40-S14	44.0	181	286	40	70	
HP-4D450-S40-S14	45.0	185	290	40	70	
HP-4D460-S40-S14	46.0	189	294	40	70	
HP-4D470-S40-S14	47.0	193	298	40	70	
HP-4D480-S40-S14	48.0	197	302	40	70	
HP-4D490-S40-S14	49.0	201	306	40	70	
HP-4D500-S40-S14	50.0	205	310	40	70	

Drilling holders

Dimensions (mm)	Spare parts	
Holder diameter	Screw	Wrench
		
28-33	AST35084-60H	AWF-T15
34-41	AST410-60H	AWF-T15
42-50	AST5126-60	AWF-T20

**DG Series Drilling Holder**

**Length-diameter ratio: 2D**

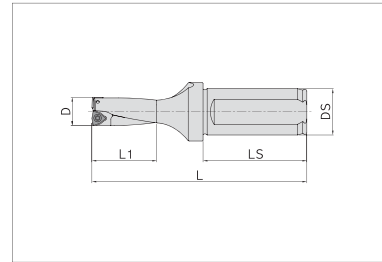


Designation	Dimension(mm)					Inserts
	D	L <sub>1</sub>	L	D <sub>s</sub>	L <sub>s</sub>	
HP-2D160-S25-W03	16.0	35	116	25	56	WCMT 030204E-DG
HP-2D165-S25-W03	16.5	36	117	25	56	
HP-2D170-S25-W03	17.0	37	118	25	56	
HP-2D175-S25-W03	17.5	38	119	25	56	
HP-2D180-S25-W03	18.0	39	120	25	56	
HP-2D185-S25-W03	18.5	40	121	25	56	
HP-2D190-S25-W03	19.0	41	122	25	56	
HP-2D195-S25-W03	19.5	42	123	25	56	
HP-2D200-S25-W03	20.0	43	124	25	56	
HP-2D205-S25-W04	20.5	44	125	25	56	WCMT 040204E-DG
HP-2D210-S25-W04	21.0	45	126	25	56	
HP-2D215-S25-W04	21.5	46	127	25	56	
HP-2D220-S25-W04	22.0	47	128	25	56	
HP-2D225-S25-W04	22.5	48	129	25	56	
HP-2D230-S25-W04	23.0	49	130	25	56	
HP-2D235-S25-W04	23.5	50	131	25	56	
HP-2D240-S25-W04	24.0	51	132	25	56	
HP-2D245-S25-W04	24.5	52	133	25	56	
HP-2D250-S25-W04	25.0	53	134	25	56	
HP-2D255-S32-W05	25.5	54	144	32	60	WCMT 050308E-DG
HP-2D260-S32-W05	26.0	55	145	32	60	
HP-2D265-S32-W05	26.5	56	146	32	60	
HP-2D270-S32-W05	27.0	57	147	32	60	
HP-2D275-S32-W05	27.5	58	148	32	60	
HP-2D280-S32-W05	28.0	59	149	32	60	
HP-2D285-S32-W05	28.5	60	150	32	60	
HP-2D290-S32-W05	29.0	61	151	32	60	
HP-2D295-S32-W05	29.5	62	152	32	60	
HP-2D300-S32-W05	30.0	63	153	32	60	

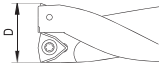


Dimensions (mm)	Spare parts	
Holder diameter	Screw	Wrench
16-20	AST22045-55	AWF-T06
20.5-25	AST25055-50	AWF-T08
25.5-30	AST307-55	AWF-T08

**DG Series Drilling Holder**

**Length-diameter ratio: 2D**



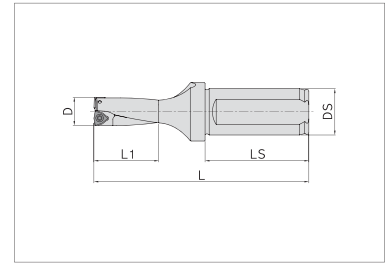
Designation	Dimension(mm)					Inserts
	D	L <sub>1</sub>	L	D <sub>s</sub>	L <sub>s</sub>	
HP-2D310-S32-W06	31.0	65	155	32	60	WCMT 06T308E-DG
HP-2D320-S32-W06	32.0	67	157	32	60	
HP-2D330-S32-W06	33.0	69	159	32	60	
HP-2D340-S32-W06	34.0	71	161	32	60	
HP-2D350-S32-W06	35.0	73	163	32	60	
HP-2D360-S32-W06	36.0	75	165	32	60	
HP-2D370-S32-W06	37.0	77	167	32	60	
HP-2D380-S32-W06	38.0	79	169	32	60	
HP-2D390-S32-W06	39.0	81	171	32	60	
HP-2D400-S32-W06	40.0	83	173	32	60	
HP-2D410-S32-W06	41.0	85	175	32	60	
HP-2D420-S40-W08	42.0	87	192	40	70	WCMT 080408E-DG
HP-2D430-S40-W08	43.0	89	194	40	70	
HP-2D440-S40-W08	44.0	91	196	40	70	
HP-2D450-S40-W08	45.0	93	198	40	70	
HP-2D460-S40-W08	46.0	95	200	40	70	
HP-2D470-S40-W08	47.0	97	202	40	70	
HP-2D480-S40-W08	48.0	99	204	40	70	
HP-2D490-S40-W08	49.0	101	206	40	70	
HP-2D500-S40-W08	50.0	103	208	40	70	
HP-2D510-S40-W08	51.0	105	210	40	70	
HP-2D520-S40-W08	52.0	107	212	40	70	
HP-2D530-S40-W08	53.0	109	214	40	70	
HP-2D540-S40-W08	54.0	111	216	40	70	
HP-2D550-S40-W08	55.0	113	218	40	70	
HP-2D560-S40-W08	56.0	115	220	40	70	
HP-2D470-S40-W08	57.0	117	222	40	70	
HP-2D580-S40-W08	58.0	119	224	40	70	

Dimensions (mm)	Spare parts	
Holder diameter	Screw	Wrench
 31-41	 AST3509-55	 AWF-T15
42-58	AST4101-60W	AWF-T15

Drilling holders

**DG Series Drilling Holder**

**Length-diameter ratio: 3D**

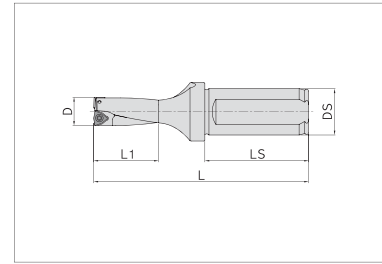


Designation	Dimension(mm)					Inserts
	D	L <sub>1</sub>	L	D <sub>s</sub>	L <sub>s</sub>	
HP-3D160-S25-W03	16.0	51	132	25	56	WCMT 030204E-DG
HP-3D165-S25-W03	16.5	53	134	25	56	
HP-3D170-S25-W03	17.0	54	135	25	56	
HP-3D175-S25-W03	17.5	56	137	25	56	
HP-3D180-S25-W03	18.0	57	138	25	56	
HP-3D185-S25-W03	18.5	59	140	25	56	
HP-3D190-S25-W03	19.0	60	141	25	56	
HP-3D195-S25-W03	19.5	62	143	25	56	
HP-3D200-S25-W03	20.0	63	144	25	56	
HP-3D205-S25-W04	20.5	65	146	25	56	WCMT 040204E-DG
HP-3D210-S25-W04	21.0	66	147	25	56	
HP-3D215-S25-W04	21.5	68	149	25	56	
HP-3D220-S25-W04	22.0	69	150	25	56	
HP-3D225-S25-W04	22.5	71	152	25	56	
HP-3D230-S25-W04	23.0	72	153	25	56	
HP-3D235-S25-W04	23.5	74	155	25	56	
HP-3D240-S25-W04	24.0	75	156	25	56	
HP-3D245-S25-W04	24.5	77	158	25	56	
HP-3D250-S25-W04	25.0	78	159	25	56	
HP-3D255-S32-W05	25.5	80	170	32	60	WCMT 050308E-DG
HP-3D260-S32-W05	26.0	81	171	32	60	
HP-3D265-S32-W05	26.5	83	173	32	60	
HP-3D270-S32-W05	27.0	84	174	32	60	
HP-3D275-S32-W05	27.5	86	176	32	60	
HP-3D280-S32-W05	28.0	87	177	32	60	
HP-3D285-S32-W05	28.5	89	179	32	60	
HP-3D290-S32-W05	29.0	90	180	32	60	
HP-3D295-S32-W05	29.5	92	182	32	60	
HP-3D300-S32-W05	30.0	93	183	32	60	

Dimensions (mm)	Spare parts	
Holder diameter	Screw	Wrench
16-20	AST22045-55	AWF-T06
20.5-25	AST25055-50	AWF-T08
25.5-30	AST307-55	AWF-T08

**DG Series Drilling Holder**

**Length-diameter ratio: 3D**



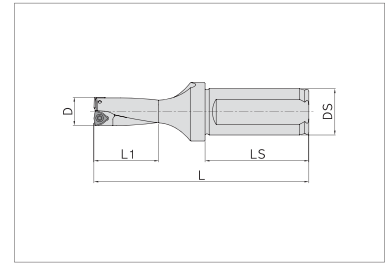
Designation	Dimension(mm)					Inserts
	D	L <sub>1</sub>	L	D <sub>s</sub>	L <sub>s</sub>	
HP-3D310-S32-W06	31.0	96	186	32	60	WCMT 06T308E-DG
HP-3D320-S32-W06	32.0	99	189	32	60	
HP-3D330-S32-W06	33.0	102	192	32	60	
HP-3D340-S32-W06	34.0	105	195	32	60	
HP-3D350-S32-W06	35.0	108	198	32	60	
HP-3D360-S32-W06	36.0	111	201	32	60	
HP-3D370-S32-W06	37.0	114	204	32	60	
HP-3D380-S32-W06	38.0	117	207	32	60	
HP-3D390-S32-W06	39.0	120	210	32	60	
HP-3D400-S32-W06	40.0	123	213	32	60	
HP-3D410-S32-W06	41.0	126	216	32	60	
HP-3D420-S40-W08	42.0	129	234	40	70	WCMT 080408E-DG
HP-3D430-S40-W08	43.0	132	237	40	70	
HP-3D440-S40-W08	44.0	135	240	40	70	
HP-3D450-S40-W08	45.0	138	243	40	70	
HP-3D460-S40-W08	46.0	141	246	40	70	
HP-3D470-S40-W08	47.0	144	249	40	70	
HP-3D480-S40-W08	48.0	147	252	40	70	
HP-3D490-S40-W08	49.0	150	255	40	70	
HP-3D500-S40-W08	50.0	153	258	40	70	
HP-3D510-S40-W08	51.0	156	261	40	70	
HP-3D520-S40-W08	52.0	159	264	40	70	
HP-3D530-S40-W08	53.0	162	267	40	70	
HP-3D540-S40-W08	54.0	165	270	40	70	
HP-3D550-S40-W08	55.0	168	273	40	70	
HP-3D560-S40-W08	56.0	171	276	40	70	
HP-3D470-S40-W08	57.0	174	279	40	70	
HP-3D580-S40-W08	58.0	177	282	40	70	

Dimensions (mm)	Spare parts	
Holder diameter	Screw	Wrench
31-41	AST3509-55	AWF-T15
42-58	AST4101-60W	AWF-T15

Drilling holders

**DG Series Drilling Holder**

**Length-diameter ratio: 4D**

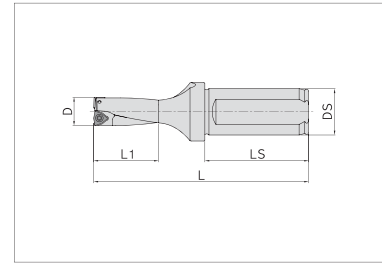


Designation	Dimension(mm)					Inserts
	D	L <sub>1</sub>	L	D <sub>s</sub>	L <sub>s</sub>	
HP-4D160-S25-W03	16.0	67	148	25	56	WCMT 030204E-DG
HP-4D165-S25-W03	16.5	69	150	25	56	
HP-4D170-S25-W03	17.0	71	152	25	56	
HP-4D175-S25-W03	17.5	73	154	25	56	
HP-4D180-S25-W03	18.0	75	156	25	56	
HP-4D185-S25-W03	18.5	77	158	25	56	
HP-4D190-S25-W03	19.0	79	160	25	56	
HP-4D195-S25-W03	19.5	81	162	25	56	
HP-4D200-S25-W03	20.0	83	164	25	56	
HP-4D205-S25-W04	20.5	85	166	25	56	WCMT 040204E-DG
HP-4D210-S25-W04	21.0	87	168	25	56	
HP-4D215-S25-W04	21.5	89	170	25	56	
HP-4D220-S25-W04	22.0	91	172	25	56	
HP-4D225-S25-W04	22.5	93	174	25	56	
HP-4D230-S25-W04	23.0	95	176	25	56	
HP-4D235-S25-W04	23.5	97	178	25	56	
HP-4D240-S25-W04	24.0	99	180	25	56	
HP-4D245-S25-W04	24.5	101	182	25	56	
HP-4D250-S25-W04	25.0	103	184	25	56	
HP-4D255-S32-W05	25.5	105	195	32	60	WCMT 050308E-DG
HP-4D260-S32-W05	26.0	107	197	32	60	
HP-4D265-S32-W05	26.5	109	199	32	60	
HP-4D270-S32-W05	27.0	111	201	32	60	
HP-4D275-S32-W05	27.5	113	203	32	60	
HP-4D280-S32-W05	28.0	115	205	32	60	
HP-4D285-S32-W05	28.5	117	207	32	60	
HP-4D290-S32-W05	29.0	119	209	32	60	
HP-4D295-S32-W05	29.5	121	211	32	60	
HP-4D300-S32-W05	30.0	123	213	32	60	

Dimension(mm)	Spare parts	
Holder diameter	Screw	Wrench
16-20	AST22045-55	AWF-T06
20.5-25	AST25055-50	AWF-T08
25.5-30	AST307-55	AWF-T08

**DG Series Drilling Holder**

**Length-diameter ratio: 4D**



Designation	Dimension(mm)					Inserts
	D	L <sub>1</sub>	L	D <sub>s</sub>	L <sub>s</sub>	
HP-4D310-S32-W06	31.0	127	217	32	60	WCMT 06T308E-DG
HP-4D320-S32-W06	32.0	131	221	32	60	
HP-4D330-S32-W06	33.0	135	225	32	60	
HP-4D340-S32-W06	34.0	139	229	32	60	
HP-4D350-S32-W06	35.0	143	233	32	60	
HP-4D360-S32-W06	36.0	147	237	32	60	
HP-4D370-S32-W06	37.0	151	241	32	60	
HP-4D380-S32-W06	38.0	155	245	32	60	
HP-4D390-S32-W06	39.0	159	249	32	60	
HP-4D400-S32-W06	40.0	163	253	32	60	
HP-4D410-S32-W06	41.0	167	257	32	60	
HP-4D420-S40-W08	42.0	171	276	40	70	WCMT 080408E-DG
HP-4D430-S40-W08	43.0	175	280	40	70	
HP-4D440-S40-W08	44.0	179	284	40	70	
HP-4D450-S40-W08	45.0	183	288	40	70	
HP-4D460-S40-W08	46.0	187	292	40	70	
HP-4D470-S40-W08	47.0	191	296	40	70	
HP-4D480-S40-W08	48.0	195	300	40	70	
HP-4D490-S40-W08	49.0	199	304	40	70	
HP-4D500-S40-W08	50.0	203	308	40	70	
HP-4D510-S40-W08	51.0	207	312	40	70	
HP-4D520-S40-W08	52.0	211	316	40	70	
HP-4D530-S40-W08	53.0	215	320	40	70	
HP-4D540-S40-W08	54.0	219	324	40	70	
HP-4D550-S40-W08	55.0	223	328	40	70	
HP-4D560-S40-W08	56.0	227	332	40	70	
HP-4D470-S40-W08	57.0	231	336	40	70	
HP-4D580-S40-W08	58.0	235	340	40	70	

Dimension(mm)	Spare parts	
Holder diameter	Screw	Wrench
31-41	AST3509-55	AWF-T15
42-58	AST4101-60W	AWF-T15

Drilling holders



**Drilling Insert Designation System**

**S**  
1


**P**  
2

**M**  
3


**T**  
4

**1-Shape/Code**










**S**



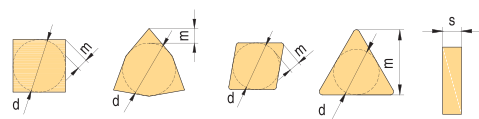
**W**



**2-Clearance angle**

<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>	<b>E</b>
				
<b>F</b>	<b>G</b>	<b>N</b>	<b>P</b>	<b>O</b>
				Other clearance angle

**3-Tolerance**

















Class	Unit	In.C Dimension d	Nose height m	Thickness s
A	mm	± 0,025	± 0,005	± 0,025
C	mm	± 0,025	± 0,013	± 0,025
E	mm	± 0,025	± 0,025	± 0,025
F	mm	± 0,013	± 0,005	± 0,025
G	mm	± 0,025	± 0,025	± 0,13
H	mm	± 0,013	± 0,013	± 0,025
J	mm	*	± 0,005	± 0,025
K	mm	*	± 0,013	± 0,025
L	mm	*	± 0,025	± 0,025
M	mm	*	*	± 0,127
U	mm	*	*	± 0,127
N	mm	*	*	± 0,025

\* For details refer to right and below tables

IC	Shape : C, E, H, M, O, P, S, T, R, W			
	d		m	
	J,K,L,M,N	U	M, N	U
4.76	± 0,05	± 0,08	± 0,08	± 0,13
5.56	± 0,05	± 0,08	± 0,08	± 0,13
6	± 0,05	± 0,08	± 0,08	± 0,13
6.35	± 0,05	± 0,08	± 0,08	± 0,13
7.94	± 0,05	± 0,08	± 0,08	± 0,13
8	± 0,05	± 0,08	± 0,08	± 0,13
9.525	± 0,05	± 0,08	± 0,08	± 0,13
10	± 0,05	± 0,08	± 0,08	± 0,13
12	± 0,08	± 0,13	± 0,13	± 0,2
12.7	± 0,08	± 0,13	± 0,13	± 0,2
15.875	± 0,1	± 0,18	± 0,15	± 0,27
16	± 0,1	± 0,18	± 0,15	± 0,27
19.05	± 0,1	± 0,18	± 0,15	± 0,27
20	± 0,1	± 0,18	± 0,15	± 0,27
25	± 0,13	± 0,25	± 0,18	± 0,38
25.4	± 0,13	± 0,25	± 0,18	± 0,38
31.75	± 0,15	± 0,25	± 0,2	± 0,38
32	± 0,15	± 0,25	± 0,2	± 0,38

M&N shape	D shape		V shape	
	d	m	d	m
5.56	± 0,05	± 0,11		
6.35	± 0,05	± 0,11	± 0,05	± 0,16
7.94	± 0,05	± 0,11	± 0,05	± 0,16
9.525	± 0,05	± 0,11	± 0,05	± 0,16
12.7	± 0,08	± 0,15	± 0,08	± 0,2
15.875	± 0,10	± 0,18	± 0,10	± 0,27
19.05	± 0,10	± 0,18	± 0,10	± 0,27

**4-Clamp type**

<b>A</b>	<b>B</b>	<b>C</b>	<b>F</b>	<b>G</b>
				
<b>H</b>	<b>J</b>	<b>M</b>	<b>N</b>	<b>Q</b>
				
<b>R</b>	<b>T</b>	<b>U</b>	<b>W</b>	<b>X</b>
				Special

<b>06</b>	<b>02</b>	<b>04</b>	<b>E</b>	<b>-</b>	<b>DP</b>
5	6	7	8	-	9

**5- Cutting edge length**

In.Circle Dimension (mm)	S Code	s Length	W Code	W Length
5.56			03	3.8
6.35	06	6.35	04	4.3
7.94			05	5.4
8.0	08	8.0		
9.525	09	9.525	06	6.5
12.7	12	12.7	08	8.7

**7- Corner radius**

Example		
04	=	0.4
08	=	0.8
12	=	1.2

**8- Cutting edge shape**

Example	Illustration
E	Honing cutting edge
F	Sharp cutting edge
T	Negative Land

**6-Insert thickness**

Thickness illustration	Thickness mark	Example
		00 = 0.79
		T0 = 0.99
		01 = 1.59
		T1 = 1.98
		02 = 2.38
		T2 = 2.58
		03 = 3.18
		T3 = 3.97
		04 = 4.76
		T4 = 4.96
		05 = 5.56
		T5 = 5.95
		06 = 6.35
		07 = 7.94
		09 = 9.53
		11 = 11.11
		12 = 12.70
		14 = 14.29
		15 = 15.88

Insert thickness "S" refers to the distance between cutting edge nose and bottom



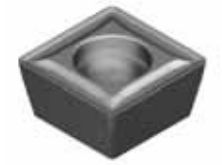
**10. Chip breakers' information refer to page 342**

Drilling inserts

**Geometry Application Guide**

**DP**

1. DP chip breaker have high efficiency. Suitable for short hole high feed drilling
2. Strong square insert with reinforced chip breaker that's gets excellent hole straightness
3. Drilling body with helical flute provides excellent chip evacuation and high hole precision.



**DU/DG**

1. Indexable insert with 80° angle and radial fitting angle makes perfect balance for the cutting force.
2. General chip breaker in two types of grades are suitable for P,M,K,S materials, especially for soft materials.
3. Achieves fine surface roughness
4. It's suitable for rotating and non-rotating machining

