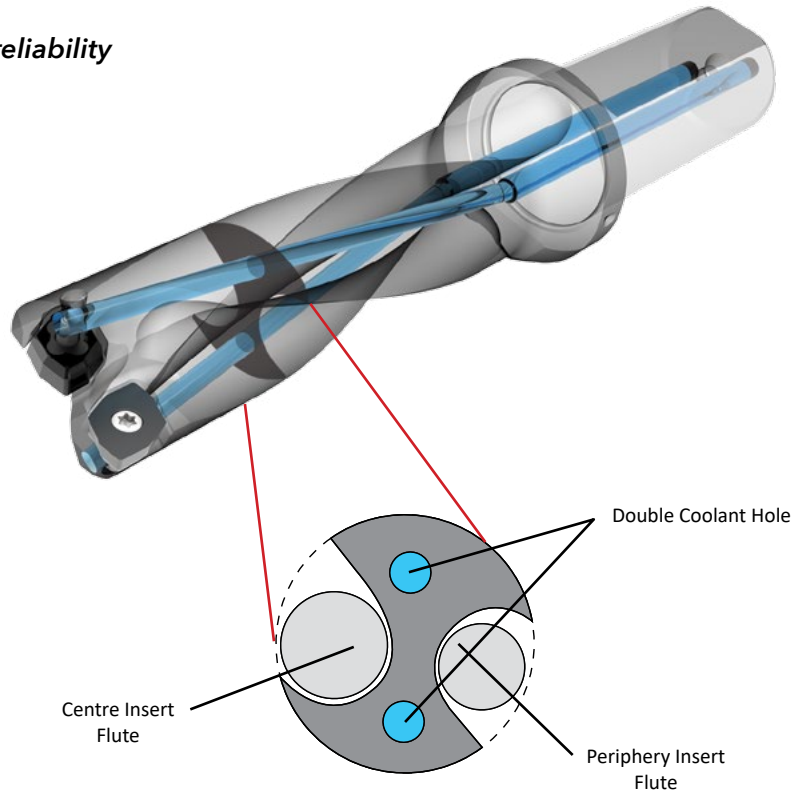




Product Overview

4TEX Drill **Advantages**

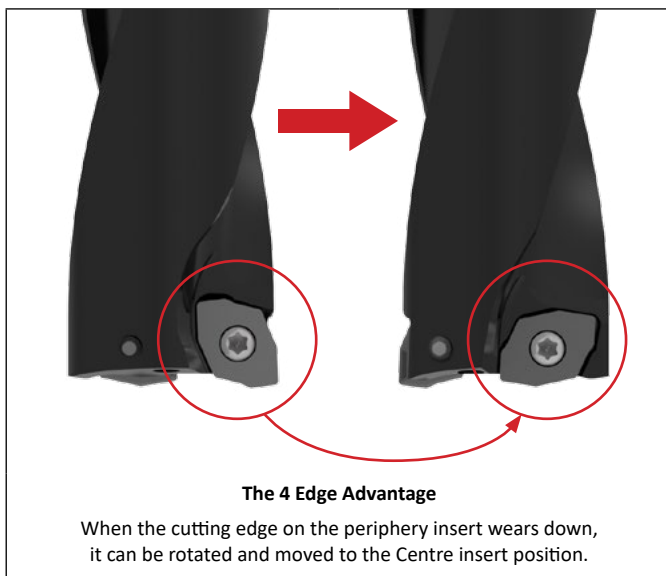
- ✓ **Improved tool holder rigidity and increased reliability**
provided by the stronger core
- ✓ **Superior chip evacuation**
provided by the 2 twisted coolant holes
- ✓ **Improved hole size**
from the stronger core and increased coolant volume
- ✓ **Longer tool life**
provided by the 4-sided insert design
- ✓ **Simplified tooling selection**
with ISO-specific insert geometry/coating combinations
- ✓ **Increased penetration rates**
due to single effective cutting on light duty machines



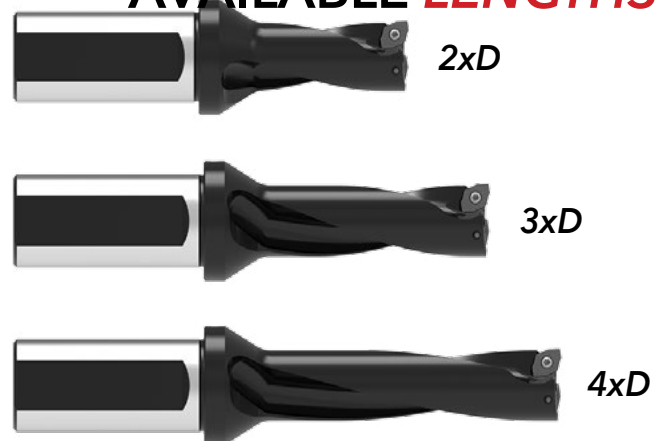
STABLE & EFFICIENT

- The 2 twisted coolant holes allow the core to remain intact, making the core thicker and stronger.
- The dual coolant outlets increase the coolant volume, which improves the chip evacuation and improves the hole size.
- The flute space of the internal cutting edge side (where chips get stuck most often) is 1.6x larger than typical IC drills.

LONGER TOOL LIFE



AVAILABLE LENGTHS

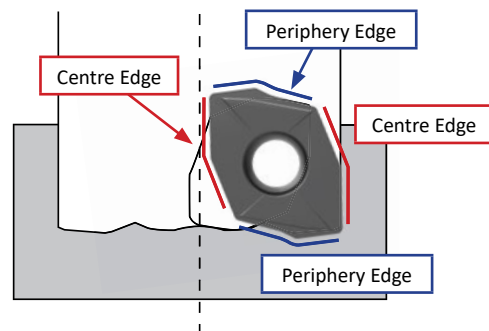




Insert Information

4 CUTTING EDGES

- Each insert has 2 inner cutting edges and 2 outer cutting edges
- Economical solution that increases tool life because of the rotation ability of the inserts
- Available in ISO material-specific geometry/coating combinations



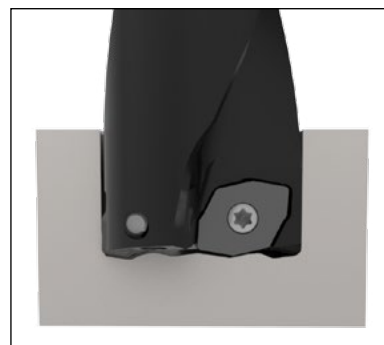
Periphery Insert



Periphery edge chip formation:



Centre Insert



Centre edge chip formation:






180°

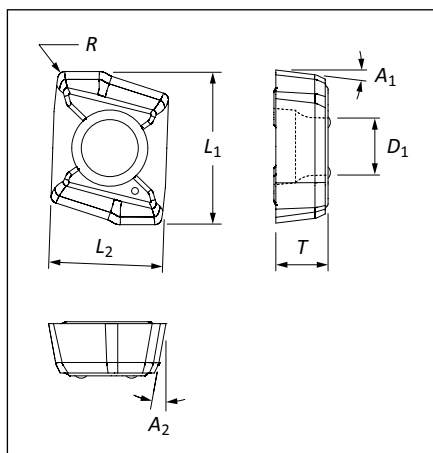
ISO Material	Geometry	Coating	Description
P	General Rake	AM480	A general purpose geometry that provides excellent chip formation in most steels including free machining, medium and high carbon steels. A P30 carbide substrate for improved toughness and AM480 coating, a proprietary wear resistant multi-layer PVD coating to improve tool life.
S M	High Rake	AM485	A higher rake geometry that provides excellent chip formation in both stainless steels and high temperature alloys. A tough M25 carbide substrate coated with AM485, a high heat resistance proprietary multi-layer PVD coating.
K	General Rake	AM480	With a general purpose geometry, the K inserts can be used in grey cast irons as well as ductile irons. A high wear resistant K10 carbide substrate to improve tool life and coated with AM480, a proprietary multi-layer PVD coating to improve resistance against tool wear.
H	Low Rake	AM480	A low rake geometry to improve edge strength in both hardened tool steels and high strength alloys. With a P30 carbide substrate for improved toughness and coated with AM480, a proprietary multi-layer PVD coating to improve resistance against tool wear.
N	High Rake	TiCN	A higher rake cutting geometry provides excellent chip formation in non-ferrous materials. An M15/K15 carbide substrate paired with TiCN coating for improved lubricity to resist build-up-material, increasing tool life and maintaining chip formation.



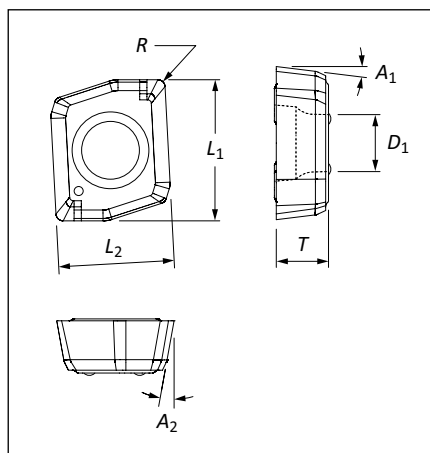
Insert Information

Series	Insert Prefix	Dimension (mm)					Angle		Shape
		L_1	L_2	T	D_1	R	A_1	A_2	
03	4T-030203C-x	5.9	4.8	2.30	2.4	0.3	7°	10°	 Style 1
	4T-030203P-x	6.5	4.8	2.30	2.4	0.3	7°	10°	 Style 2
04	4T-040203-x	6.2	5.1	2.60	2.4	0.3	13°	10°	 Style 3
05	4T-05T203-x	7.3	5.5	2.74	2.5	0.3	13°	7°	
06	4T-06T204-x	8.6	6.4	2.89	2.8	0.4	13°	7°	
07	4T-070305-x	10.2	8.0	3.24	3.0	0.5	13°	7°	
09	4T-09T306-x	12.2	9.6	4.03	3.6	0.6	13°	7°	
11	4T-11T306-x	14.5	11.6	4.06	4.6	0.6	13°	7°	
14	4T-140408-x	18.0	14.4	4.88	5.7	0.8	13°	7°	

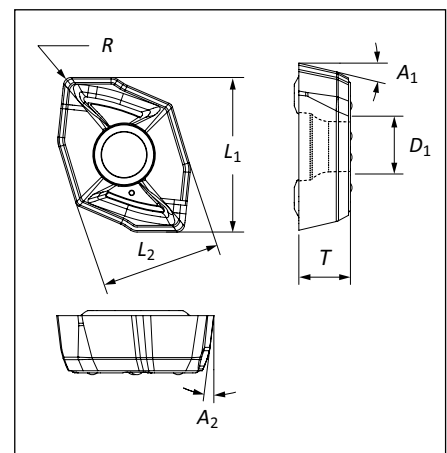
Style 1



Style 2



Style 3

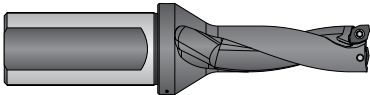




Product Nomenclature

4TEX Drill Holders

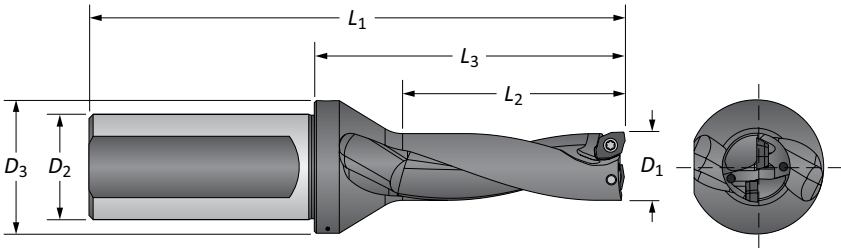
D4	03	1200	M	—	20	FM
1	2	3	4		5	6



1. Length to Diameter Ratio	2. Series	3. Diameter	4. Diameter Style
D2 = 2xD D3 = 3xD D4 = 4xD	03 = 03 series 04 = 04 series 05 = 05 series 06 = 06 series 07 = 07 series 09 = 09 series 11 = 11 series 14 = 14 series	1200 = 12mm 0750 = .075"	M = Metric I = Imperial
5. Shank Diameter		6. Shank Style	
Metric 20 = 20mm 25 = 25mm 32 = 32mm 40 = 40mm	Imperial 075 = .075" 100 = 1.000" 125 = 1.250" 150 = 1.500"	FM = Metric flanged shank F = Imperial flanged shank	

Reference Key

Symbol	Attribute
D₁	Drill diameter
D₂	Shank diameter
D₃	Flange diameter
L₁	Assembled overall length
L₂	Drill depth
L₃	Reference length



A

DRILLING

B

BORING

C

REAMING

D

BURNISHING

E

THREADING

X

SPECIALS