



TRUEDEX SOLID DRILLING TOOLS

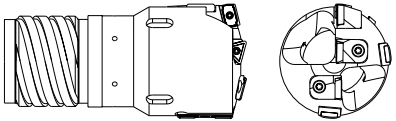
Diameter range 63.50 mm - 183.90 mm (2.500" - 7.240")



TrueDex

Diameter Range: 63.50 mm – 183.90 mm (2.500” - 7.240”)

Drill Head Part Numbering Code Example: Metric: TDM#####M413 Imperial: TD#####M413



TD		M#####		M		4		13	
DirectDex Prefix		Bore Size		Connection Type		Thread Starts		Connection Size	
Description	Code	Description	Code	Description	Code	Description	Code	Description	Code
TrueDex	TD	Size in Metric (###.## mm)	M#####	Male / External	M	Four-Start	4	63.50 - 64.99 mm 2.500 - 2.559 in	13
		Size in Imperial ##.### in	#####	Female / Internal	F	Single-Start	1		

Connection Size Numbering Code

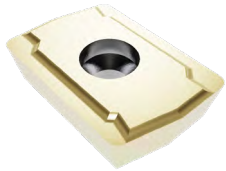
Bore Size Range	63.50-64.99 mm	63.50-65.00 mm	65.00 - 67.00 mm	67.00 - 73.00 mm	73.00- 80.00 mm	80.00 - 87.00 mm	87.00 - 100.00 mm	100.00 - 112.00 mm	112.00 - 124.00 mm	124.00 - 136.00 mm	136.00 - 148.00 mm	148.00 - 160.00 mm	160.00 - 171.90 mm	172.00- 183.90 mm
	2.500-2.559 in	2.500 - 2.559 in	2.559 - 2.637 in	2.638 - 2.873 in	2.874 - 3.149 in	3.150 - 3.424 in	3.425 - 3.936 in	3.937 - 4.408 in	4.409 - 4.881 in	4.882 - 5.353 in	5.354 - 5.826 in	5.827 - 6.298 in	6.299 - 6.767 in	6.772-7.240 in
Code	13	13E	14	15	16	17	18	19	20	21	22	23	24	25

Drill Ø	Item Code	Drill Tube	Dimensions		Item Code						
‘D’			Tube OD	L	Peripheral		Center		Intermediate	Guide Pad	
63.50 - 64.99 mm	TDM#####M413	13 (Single Tube can be ordered as a special)	56 mm	115 mm	CTTDN13P R430.30-1516-16	1	CTTDT16MC L430.31-1216-16	1	CTTDT16MI R430.30-1216-16	1	GPS1435D0650TE 800-14 D065
2.500 - 2.559 in	TD#####M413		2.205 in	4.527 in							
63.50 - 65.00 mm	TDM#####M413E	13E	56 mm	115 mm	CTTDN13P R430.30-1516-16	1	CTTDT16MC L430.31-1216-16	1	CTTDT16MI R430.30-1216-16	1	GPS1435D0650TE 800-14 D065
2.500 - 2.559 in	TD#####M413E		2.204 in	4.527 in							
63.50 - 65.00 mm	TDM#####M414	14	56 mm	150 mm	CTTDN13P R430.30-1516-16	1	CTTDT16MC L430.31-1216-16	1	CTTDT16MI R430.30-1216-16	1	GPS1435D0650TE 800-14 D065
2.500 - 2.559 in	TD#####M414		2.204 in	1.968 in							
65.01 - 74.99 mm	TDM#####M415	15	62 mm	150 mm	CTTDN13P R430.30-1516-16	1	CTTDT16MC L430.31-1216-16	1	CTTDT16MI R430.30-1216-16	1	GPS1435D0650TE 800-14 D065
2.559 - 2.952 in	TD#####M415		2.440 in	1.968 in							
75.00 - 79.99 mm	TDM#####M416	16	68 mm	160 mm	CTTDN18P R430.28-1822-22	1	CTTDT16MC L430.31-1216-16	1	CTTDT16MI R430.30-1216-16	1	GPS1435D0750TE 800-16 D075
2.953 - 3.149 in	TD#####M416		2.677 in	6.299 in							
80.00 - 84.99 mm	TDM#####M417	17	75 mm	190 mm	CTTDN18P R430.28-1822-22	1	CTTDT16MC L430.31-1216-16	1	CTTDT16MI R430.30-1216-16	1	GPS1435D0750TE 800-16 D075
3.150 - 3.346 in	TD#####M417		2.952 in	7.480 in							
85.00 - 88.89 mm	TDM#####M417	17	75 mm	190 mm	CTTDN18P R430.28-1822-22	1	CTTDT22MC L430.31-1522-22	1	CTTDT16MI R430.30-1216-16	1	GPS1435D0850TE 800-16 D085
3.346 - 3.500 in	TD#####M417		2.952 in	7.480 in							
88.90-94.99 mm	TDM#####M418	18	82 mm	190 mm	CTTDN18P R430.28-1822-22	1	CTTDT22MC L430.31-1522-22	1	CTTDT16MI R430.30-1216-16	1	GPS1435D0850TE 800-16 D085
3.500 - 3.740 in	TD#####M418		3.228 in	7.480 in							
95.00-99.99 mm	TDM#####M418	18	82 mm	190 mm	CTTDN18P R430.28-1822-22	1	CTTDT22MC L430.31-1522-22	1	CTTDT22MI R430.30-1522-22	1	GPS1435D0850TE 800-16 D085
3.740 - 3.937 in	TD#####M418		3.228 in	7.480 in							
100.00-107.94 mm	TDM#####M419	19	94 mm	195 mm	CTTDN18P R430.28-1822-22	1	CTTDT22MC L430.31-1522-22	1	CTTDT22MI R430.30-1522-22	1	GPS2050D1000TE 800-20 D100
3.937 - 4.250 in	TD#####M419		7.700 in	7.677 in							
107.95-114.29 mm	TDM#####M419	19	94 mm	195 mm	CTTDN13P R430.30-1516-16	1	CTTDT16MC L430.31-1216-16	1	CTTDT16MI R430.30-1216-16	3	GPS2050D1100TE 800-22 D110
4.250 - 4.500 in	TD#####M419		7.700 in	7.677 in							
114.30-119.99 mm	TDM#####M420	20	106 mm	220 mm	CTTDN13P R430.30-1516-16	1	CTTDT16MC L430.31-1216-16	1	CTTDT16MI R430.30-1216-16	3	GPS2050D1100TE 800-22 D110
4.500 - 4.724 in	TD#####M420		4.173 in	8.661 in							
120.00-120.64 mm	TDM#####M420	20	106 mm	220 mm	CTTDN13P R430.30-1516-16	1	CTTDT16MC L430.31-1216-16	1	CTTDT16MI R430.30-1216-16	3	GPS2050D1200TE 800-10A
4.724 - 4.750 in	TD#####M420		4.173 in	8.661 in							
120.65-124.99 mm	TDM#####M420	20	106 mm	220 mm	CTTDN13P R430.28-1822-22	1	CTTDT16MC L430.31-1216-16	1	CTTDT16MI R430.30-1216-16	3	GPS2050D1200TE 800-24 D120
4.750 - 4.921 in	TD#####M420		4.173 in	8.661 in							
125.00-130.00 mm	TDM#####M421	21	118 mm	220 mm	CTTDN18P R430.28-1822-22	1	CTTDT16MC L430.31-1216-16	1	CTTDT16MI R430.30-1216-16	3	GPS2050D1200TE 800-24 D120
4.921 - 5.118 in	TD#####M421		4.465 in	8.661 in							
130.01-139.99 mm	TDM#####M421	21	118 mm	220 mm	CTTDN18P R430.28-1822-22	1	CTTDT16MC L430.31-1216-16	1	CTTDT16MI R430.30-1216-16	3	GPS2050D1300TE 800-26 D130
5.119 - 5.511 in	TD#####M421		4.465 in	8.661 in							

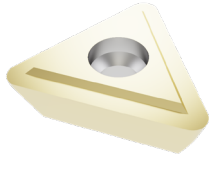
Additional Sizes up to 183.90 mm (7.240 in) are available and made to order.
Sandvik Coromant part number shown in Red

Cartridges and Inserts

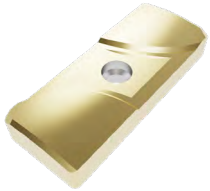
Peripheral Cartridge						
Item code	Insert	Insert Screw	Cartridge Screw	Pad	Pad Screw	Set Screw
CTTDN13P R430.30-1516-16	BTTDN13PGU1TE R424.9-13T3308-22	PHSM1154 5513 020-24	PHSM1180 430.21-825	PPF1018 5636 030-01	PHSM662 154.3-835	PHSM596 3214 010-357
	BTTDN13PLU1TE R424.9-13T3308-23					
CTTDN18P R430.28-1822-22	BBTTDN18PGU1TE R424.9-180608-22	PHSM1159 5513 020-25	PHSM1180 430.21-825	PPF1220 5636-030-02	PHSM662 154.3-835	PHSM596 3214 010-357
	BTTDN18PLU1TE R424.9-180608-23					
Central Cartridge						
Item code	Insert	Insert Screw		Cartridge Screw		
CTTDT16MC L430.31-1216-16	BTTDT16MGU1TE TPMT 16T312R-22	PHSM1159 5513 020-25		PHSM1160 5513 020-26		
	BTTDT16MLU1TE TPMT 16T312TR-23					
CTTDT22MC L430.31-1522-22	BTTDT22MGU1TE TPMT 220612R-22	PHSM1160 5513 020-26				
	BTTDT22MLU1TE TPMT 220612TR-23					
Intermediate Cartridge						
Item code	Insert	Insert Screw		Cartridge Screw		
CTTDT16MI R430.30-1216-16	BTTDT16MGU1TE TPMT 16T312R-22	PHSM1159 5513 020-25		PHSM1160 5513 020-26		
	BTTDT16MLU1TE TPMT 16T312TR-23					
CTTDT22MI R430.30-1522-22	BTTDT22MGU1TE TPMT 220612R-22	PHSM1160 5513 020-26				
	BTTDT22MLU1TE TPMT 220612TR-23					



Peripheral Insert



Central & Intermediate Insert



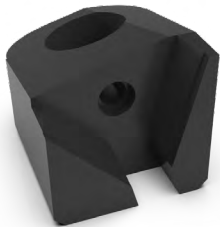
Solid Carbide Guide Pad



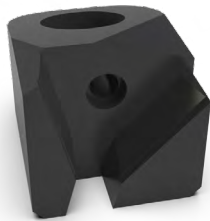
Brazed carbide Guide Pad



Peripheral Cartridge



Intermediate Cartridge



Central Cartridge

Guide Pad Sizes

Guide Pads			
Diameter	Item code	Description	Guide Pad Screw
63.50-74.99 mm	GPS1435D0650TE 800-14 D065	SOLID CARBIDE GUIDE PAD	PHSM1158 5513 020-01
75.00-84.99 mm	GPS1435D0750TE 800-16 D075	SOLID CARBIDE GUIDE PAD	PHSM1158 5513 020-01
85.00-99.99 mm	GPS1435D0850TE 800-18 D085	SOLID CARBIDE GUIDE PAD	PHSM1158 5513 020-01
100.00-109.99 mm	GPS2050D1000TE 800-20 D100	SOLID CARBIDE GUIDE PAD	PHSM1160 5513 020-26
110.00-119.99 mm	GPS2050D1100TE 800-22 D110	SOLID CARBIDE GUIDE PAD	PHSM1160 5513 020-26
120.00-129.99 mm	GPS2050D1200TE 800-24 D120	SOLID CARBIDE GUIDE PAD	PHSM1160 5513 020-26
65.00 - 69.99 mm	GPB1435D0650 430.32-12 D65.0	BRAZED CARBIDE GUIDE PAD	PHSM1158 5513 020-01
70.00 - 74.99 mm	GPB1435D0700 430.32-12 D70.0	BRAZED CARBIDE GUIDE PAD	PHSM1158 5513 020-01
75.00 - 79.99 mm	GPB1435D0750 430.32-12 D75.0	BRAZED CARBIDE GUIDE PAD	PHSM1158 5513 020-01
80.00 - 84.99 mm	GPB1435D0800 430.32-12 D80.0	BRAZED CARBIDE GUIDE PAD	PHSM1158 5513 020-01
85.00 - 89.99 mm	GPB1435D0850 430.32-12 D85.0	BRAZED CARBIDE GUIDE PAD	PHSM1158 5513 020-01
90.00 - 94.99 mm	GPB1435D0900 430.32-12 D90.0	BRAZED CARBIDE GUIDE PAD	PHSM1158 5513 020-01
95.00 - 99.99 mm	GPB1435D0950 430.32-12 D95.0	BRAZED CARBIDE GUIDE PAD	PHSM1158 5513 020-01
100.00 - 104.99 mm	GPB2050D1000 430.32-16 D100.0	BRAZED CARBIDE GUIDE PAD	PHSM1160 5513 020-26
105.00 - 109.99 mm	GPB2050D1050 430.32-16 D105.0	BRAZED CARBIDE GUIDE PAD	PHSM1160 5513 020-26
110.00 - 114.99 mm	GPB2050D1100 430.32-16 D110.0	BRAZED CARBIDE GUIDE PAD	PHSM1160 5513 020-26
115.00 - 119.99 mm	GPB2050D1150 430.32-16 D115.0	BRAZED CARBIDE GUIDE PAD	PHSM1160 5513 020-26
120.00 - 124.99 mm	GPB2050D1200 430.32-16 D120.0	BRAZED CARBIDE GUIDE PAD	PHSM1160 5513 020-26
125.00 - 129.99 mm	GPB2050D1250 430.32-16 D125.0	BRAZED CARBIDE GUIDE PAD	PHSM1160 5513 020-26
130.00 - 139.99 mm	GPB2050D1300 430.32-16 D130.0	BRAZED CARBIDE GUIDE PAD	PHSM1160 5513 020-26
140.00 - 149.99 mm	GPB2050D1400 430.32-16 D140.0	BRAZED CARBIDE GUIDE PAD	PHSM1160 5513 020-26
150.00 - 159.00 mm	GPB2050D1500 430.32-16 D150.0	BRAZED CARBIDE GUIDE PAD	PHSM1160 5513 020-26
160.00 - 169.99 mm	GPB2050D1600 430.32-16 D160.0	BRAZED CARBIDE GUIDE PAD	PHSM1160 5513 020-26
170.00 - 179.99 mm	GPB2050D1700 430.32-16 D170.0	BRAZED CARBIDE GUIDE PAD	PHSM1160 5513 020-26
180.00 - 189.99 mm	GPB2050D1800 430.32-16 D180.0	BRAZED CARBIDE GUIDE PAD	PHSM1160 5513 020-26

NOTE: Brazed Carbide Guide Pads can be coated upon request.
Sandvik Coromant part number shown in Red

TrueDex - feed & speed

Inch values

ISO	MC No. (CMC No.)	Material	Specific cutting force kc1 lbs/in²	Hardness Brinell HB	Geometry / Grade	Cutting speed vc ft/min	Drill diameter, inch
							≥ 2.500
							Feed f _n inch/rev
P	P1.1.Z.AN (01.1)	Unalloyed steel Non-hardened 0.10-0.25% C	290 000	90-200	-G// -L/TE	260-330	.007-.014
	P1.2.Z.AN (01.2)	Non-hardened 0.25-0.55% C	304 500	125-225	-G/TE	260-330	.007-.014
	P1.3.Z.AN (01.3)	Non-hardened 0.55-0.80% C	316 100	150-250	-G/TE	260-330	.007-.014
	P1.3.Z.AN (01.4)	High carbon steel, annealed	336 400	180-275	-G/TE	260-330	.007-.014
	P2.1.Z.AN (02.1)	Low alloy steel Non hardened	304 500	150-260	-G/TE	230-330	.007-.014
	P2.5.Z.HT (02.2)	Hardened and tempered	402 400	220-450	-G/TE	200-330	.006-.014
	P3.0.Z.AN (03.11)	High alloy steel Annealed	362 500	150-250	-G/TE	200-330	.007-.012
	(03,13)	Annealed HSS	398 750	150-250	-G/TE	200-330	.007-.012
	P3.0.Z.HT (03.21)	Hardened tool steel	543 750	250-350	-G/TE	200-330	.007-.012
	(03,22)	Hardened steel, others	580 000	250-450	-G/TE	200-330	.007-.012
	P1.5.C.UT (06.1)	Castings Unalloyed	261 000	90-225	-G/TE	165-330	.006-.012
	P2.6.C.UT (06.2)	Low alloyed (alloying elements < 5%)	2304 500	150-250	-G/TE	165-330	.006-.012
M	P5.0.Z.AN (05.11)	Rolled/forged Ferritic/Martensitic, non hardened	333 500	150-270	-G/TE	165-300	.006.014
	M1.0.Z.AQ (05.21)	Austenitic	377 000	150-270	-L/TE	165-300	.006-.014
K	K1.1.C.NS (07.1)	Malleable Ferritic	137 750	110-145	-G/TE	260-330	.007-.012
	K1.1.C.NS (07.2)	Pearlitic	159 500	150-270	-G/TE	260-330	.007-.012
	K2.1.C.UT (08.1)	Grey Low tensile strength	159 500	150-220	-G/TE	200-330	.006-.014
	K2.2.C.UT (08.2)	High tensile strength	187 050	200-330	-G/TE	200-330	.006-.014
	K3.1.C.UT (09.1)	Nodular Ferritic	152 250	125-230	-G/TE	165-330	.006-.014
N	K3.3.C.UT (09.2)	Pearlitic	253 750	200-300	-G/TE	165-330	.006-.014
	(30,11)	Aluminium alloys Wrought or wrought and coldworked, non- aging	72 500	30-100	-L/TE	210-600	.004-.012
	N1.2.Z.AG (30.12)	Wrought or wrought and aged	116 000	30-150	-L/TE	210-600	.004-.012
	N1.3.C.UT (30.21)	Cast, non aging	108 750	40-100	-L/TE	210-600	.004-.012
	N1.3.C.AG (30.22)	Cast or cast and aged	130 500	70-140	-L/TE	210-600	.004-.012
	N3.3.U.UT (33.1)	Copper and copper alloys Free cutting alloys (Pb > 1%)	101 500	70-160	-L/TE	210-600	.004-.012
	N3.2.C.UT (33.2)	Brass and leaded alloys (Pb < 1%)	101 500	50-200	-L/TE	210-600	.004-.012
S	(20,11)	Iron base Annealed or solution treated	435 000	180-230	-G/TE	65-210	.006-.012
	S2.0.Z.AN (20.21)	Nickel base Annealed or solution treated	481 400	140-300	-L/TE	65-210	.006-.012
	(20,31)	Cobalt alloys Annealed or solution treated	478 500	180-230	-L/TE	65-210	.006-.012
	S4.2.Z.AN (23.21)	Titanium Alfa- , near Alfa- and Alfa + Beta alloys annealed	242 875	600-1100	-L/TE -L/TE	100-330 100-330	.006-.012 .006-.012

TrueDex - feed & speed

Metric values

ISO	MC No. (CMC No.)	Material	Specific cutting force kc1 N/mm²	Hardness Brinell HB	Geometry / Grade	Cutting speed vc m/min	Drill diameter, mm
							≥ 63.50
							Feed f _n mm/r
P	P1.1.Z.AN (01.1)	Unalloyed steel Non-hardened 0.10-0.25% C	1500	90-200	-G/-L/TE	80-100	0.18-0.35
	P1.2.Z.AN (01.2)	Non-hardened 0.25-0.55% C	1600	125-225	-G/TE	80-100	0.18-0.35
	P1.3.Z.AN (01.3)	Non-hardened 0.55-0.80% C	1700	150-250	-G/TE	80-100	0.18-0.35
	P1.3.Z.AN (01.4)	High carbon steel, annealed	1800	180-275	-G/TE	80-100	0.18-0.35
	P2.1.Z.AN (02.1)	Low alloy steel Non hardened	1700	150-260	-G/TE	70-100	0.18-0.35
	P2.5.Z.HT (02.2)	Hardened and tempered	1900	220-450	-G/TE	60-100	0.18-0.35
	P3.0.Z.AN (03.11)	High alloy steel Annealed	1950	150-250	-G/TE	70-100	0.18-0.30
	P3.0.Z.HT (03.21)	Annealed HSS Hardened tool steel	2150 2900	150-250 250-350	-G/TE -G/TE	70-100 60-100	0.18-0.30 0.16-0.30
	P3.0.Z.HT (03.22)	Hardened steel, others	3100	250-450	-G/TE	60-100	0.16-0.30
	P1.5.C.UT (06.1)	Castings Unalloyed	1400	90-225	-G/TE	50-100	0.15-0.30
M	P2.6.C.UT (06.2)	Low alloyed (alloying elements < 5%)	1600	150-250	-G/TE	50-100	0.15-0.30
	P5.0.Z.AN (05.11)	Rolled/forged Ferritic/Martensitic, non hardened	1800	150-270	-G/TE	50-90	0.15-0.30
	M1.0.Z.AQ (05.21)	Austenitic	1950	150-275	-L/TE	50-90	0.15-0.30
K	K1.1.C.NS (07.1)	Malleable Ferritic	790	110-145	-G/TE	80-100	0.18-0.30
	K1.1.C.NS (07.2)	Pearlitic	900	150-270	-G/TE	80-100	0.18-0.30
	K2.1.C.UT (08.1)	Grey Low tensile strength	890	150-220	-G/TE	60-100	0.16-0.35
	K2.2.C.UT (08.2)	High tensile strength	1100	200-330	-G/TE	60-100	0.16-0.35
	K3.1.C.UT (09.1)	Nodular Ferritic	900	125-230	-G/TE	50-100	0.16-0.35
	K3.3.C.UT (09.2)	Pearlitic	1350	200-300	-G/TE	50-100	0.16-0.35
N	(30.11)	Aluminium alloys Wrought or wrought and coldworked, non- aging	400	30-100	-L/TE	65-130	0.10-0.30
	N1.2.Z.AG (30.12)	Wrought or wrought and aged	650	30-150	-L/TE	65-130	0.10-0.30
	N1.3.C.UT (30.21)	Cast, non aging	600	40-100	-L/TE	65-130	0.10-0.30
	N1.3.C.AG (30.22)	Cast or cast and aged	700	70-140	-L/TE	65-130	0.10-0.30
	N3.3.U.UT (33.1)	Copper and copper alloys Free cutting alloys (Pb > 1%)	550	70-160	-L/TE	65-130	0.10-0.30
	N3.2.C.UT (33.2)	Brass and leaded alloys (Pb < 1%)	550	50-200	-L/TE	65-130	0.10-0.30
S	(20.11)	Iron base Annealed or solution treated	2400	180-230	-G/TE	20-65	0.15-0.30
	S2.0.Z.AN (20.21)	Nickel base Annealed or solution treated	2650	140-300	-L/TE	20-65	0.15-0.30
	(20.31)	Cobalt alloys Annealed or solution treated	2700	180-230	-L/TE	20-65	0.15-0.30
	S4.2.Z.AN (23.21)	Titanium Alfa- , near Alfa- and Alfa + Beta alloys annealed	1400	600-1100	-L/TE -L/TE	30-60 30-100	0.15-0.30 0.15-0.30

Sunnen’s SHDD Series Deep Hole Drills
Easy-to-use, efficient, heavy-duty



- Available in three standard models
 - 2-meter maximum part length (SHDD-2500)
 - 4-meter maximum part length (SHDD-4500)
 - 6-meter maximum part length (SHDD-6500)
- Large 394 mm (15.5 in) color HMI with intuitive controls for ease of use.
- Heavy-duty Bosch-Rexroth 55 mm (2.16 in) linear rails for maximum durability.
- Standard safety system with a combination of multiple E-stops, light curtains, interlocked guarding and fencing.
- 67 kw (90 hp) tool motor with headstock drive for optimum power.
- Beckhoff servo driven heavy-duty ball screws for tool feed.
 - 80 mm ball screw (3.15 in) SHDD-2500/SHDD-4500
 - 100 mm ball screw (3.84 in) SHDD-6500
- Electrical enclosure air conditioning unit standard to protect critical electronics in high temperature environments.
- Heavy-duty welded base.
- Heavy-duty 3-jaw chucks standard.
- Automatic lubrication system for ball screw, rack and pinion, and linear rails standard.
- Heavy-duty servo rack and pinion driven work piece positioning and clamping.
- Spindle carriage control station for ease of driveshaft installation.
- Sunnen is the complete system supplier ... machines, tools, chip management, cooling systems and cutting fluids.
- Standard 38 kw (50 HP) workpiece headstock drive (counter rotation).



More Deep Hole Drilling Solutions from Sunnen

Sunnen offers additional Solid Drilling tool solutions, including a Sandvik Corodril 800® Style product offering. Trepanning, Counter Boring, Form Cutting, Bottle Boring and Gun Drilling solutions are also available.



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SUNNEN WORLDWIDE



With world headquarters in St. Louis, Missouri, Sunnen is the largest fully integrated company in the world specializing in precision bore creation, sizing and finishing equipment. A Sunnen solution might include honing, lapping, skiving/roller burnishing or deep hole machining...or a combination of those processes.

Our 13 international subsidiaries and over 40 authorized distributors allow us to deliver top quality Sunnen machines, tools, service and training wherever they are needed around the globe.

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