



Bass Tool & Supply, Inc.
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TUNGDRILLTWISTED

- 2 x D
- 3 x D
- 4 x D
- 5 x D

INDEXABLE - DRILLS PROMO
PURCHASE ANY DRILL + 10 INSERTS
AT A SPECIAL PROMO PRICING

USE
PROMO
CODE
K11

Highest Productivity with Maximum Performance!

*Range extended with new "AH725" grade,
for steels and stainless steels!*





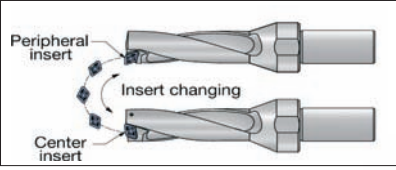
TUNGDRILLTWISTED

**INDEXABLE
DRILLS**

Excellent Surface Finish Stable Chip Evacuation Coolant Holes

Highly economical

Stable and efficient machining can be achieved by using four corners of the proven parallelogram shaped insert.



2 x D

3 x D

4 x D

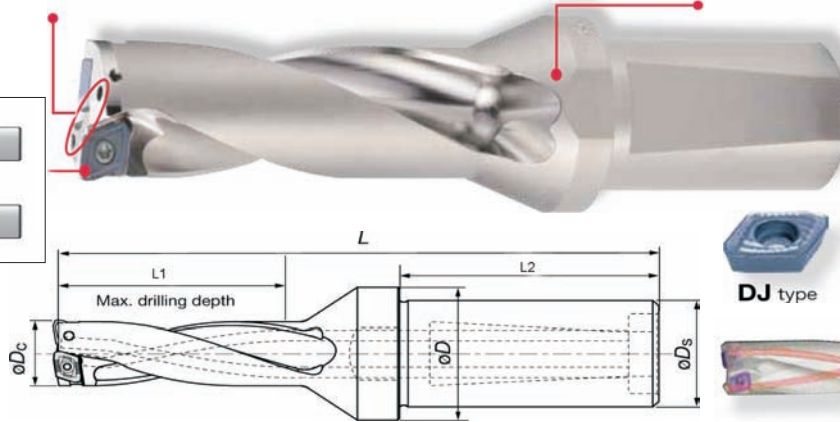
5 x D

Excellent chip evacuation!

The twisted coolant hole in the drill body increases flow by 1.5 times.

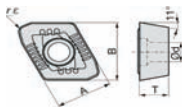
Improved drilling durability!

Long tool life due to specialized drill body coating that is hardened to improve rigidity. Eight insert types can be applied to various machining applications and work materials on anything from lathes to machining centers.



DIAMETER		DIMENSIONS			2 x D			3 x D			4 x D			5 x D			INSERT
FRAC.	DEC.	Ds	D	L2	DRILL	L	L1	DRILL	L	L1	DRILL	L	L1	DRILL	L	L1	
1/2"	0.500	0.750	1.25	2.000	TDXU-0500-02	3.776	1.000	TDXU-0500-03	4.276	1.500	TDXU-0500-04	4.913	2.000	TDXU-0500-05	5.386	2.500	XPMT040104R
17/32"	0.531				TDXU-0531-02	3.869	1.062	TDXU-0531-03	4.401	1.593	TDXU-0531-04	5.071	2.124	TDXU-0531-05	5.583	2.655	
9/16"	0.562				TDXU-0562-02	3.963	1.124	TDXU-0562-03	4.526	1.686	TDXU-0562-04	5.189	2.248	TDXU-0562-05	5.78	2.810	
5/8"	0.625	1.000	1.457	2.280	TDXU-0625-02	4.151	1.250	TDXU-0625-03	4.776	1.875	TDXU-0625-04	5.504	2.500	TDXU-0625-05	6.134	3.125	XPMT050204R
11/16"	0.687				TDXU-0687-02	4.618	1.374	TDXU-0687-03	5.306	2.061	TDXU-0687-04	6.099	2.748	TDXU-0687-05	6.808	3.435	
3/4"	0.750				TDXU-0750-02	4.806	1.500	TDXU-0750-03	5.556	2.250	TDXU-0750-04	6.414	3.000	TDXU-0750-05	7.162	3.750	
13/16"	0.812	1.250	1.575	2.688	TDXU-0812-02	4.993	1.624	TDXU-0812-03	5.806	2.436	TDXU-0812-04	6.729	3.248	TDXU-0812-05	7.516	4.060	XPMT06X308R
7/8"	0.875				TDXU-0875-02	5.181	1.750	TDXU-0875-03	6.056	2.625	TDXU-0875-04	7.004	3.500	TDXU-0875-05	7.871	4.375	
15/16"	0.937				TDXU-0937-02	5.368	1.874	TDXU-0937-03	6.306	2.811	TDXU-0937-04	7.28	3.748	TDXU-0937-05	8.225	4.685	
1"	1.000	1.500	1.969	2.688	TDXU-1000-02	5.556	2.000	TDXU-1000-03	6.556	3.000	TDXU-1000-04	7.595	4.000	TDXU-1000-05	8.579	5.000	XPMT07H308R
1.1/16"	1.062				TDXU-1062-02	5.743	2.124	TDXU-1062-03	6.806	3.186	TDXU-1062-04	7.91	4.248	TDXU-1062-05	8.973	5.310	
1.1/8"	1.125				TDXU-1125-02	5.931	2.250	TDXU-1125-03	7.056	3.375	TDXU-1125-04	8.225	4.500	TDXU-1125-05	9.367	5.625	
1.3/16"	1.187	1.500	2.165	2.688	TDXU-1187-02	6.118	2.374	TDXU-1187-03	7.306	3.561	TDXU-1187-04	8.5	4.748	TDXU-1187-05	9.721	5.935	XPMT08T308R
1.1/4"	1.250				TDXU-1250-02	6.306	2.500	TDXU-1250-03	7.556	3.750	TDXU-1250-04	8.815	5.000	TDXU-1250-05	10.036	6.250	
1.5/16"	1.312				TDXU-1312-02	6.901	2.624	TDXU-1312-03	8.213	3.936	TDXU-1312-04	9.577	5.248	TDXU-1312-05	10.876	6.560	
1.3/8"	1.375	1.500	1.969	2.688	TDXU-1375-02	7.088	2.750	TDXU-1375-03	8.463	4.125	TDXU-1375-04	9.892	5.500	TDXU-1375-05	11.27	6.875	XPMT110412R
1.7/16"	1.437				TDXU-1437-02	7.276	2.874	TDXU-1437-03	8.713	4.311	TDXU-1437-04	10.168	5.748	TDXU-1437-05	11.585	7.185	
1.1/2"	1.500				TDXU-1500-02	7.463	3.000	TDXU-1500-03	8.963	4.500	TDXU-1500-04	10.483	6.000	TDXU-1500-05	11.979	7.500	
1.9/16"	1.562	1.500	2.165	2.688	TDXU-1562-02	7.651	3.124	TDXU-1562-03	9.213	4.686	TDXU-1562-04	10.758	6.248	TDXU-1562-05	12.294	7.810	XPMT150512R
1.5/8"	1.625				TDXU-1625-02	7.838	3.250	TDXU-1625-03	9.463	4.875	TDXU-1625-04	11.113	6.500	TDXU-1625-05	12.727	8.125	
1.11/16"	1.687				TDXU-1687-02	8.026	3.374	TDXU-1687-03	9.713	5.061	TDXU-1687-04	11.388	6.748	TDXU-1687-05	13.081	8.435	
1.3/4"	1.750	1.500	2.165	2.688	TDXU-1750-02	8.213	3.500	TDXU-1750-03	9.963	5.250	TDXU-1750-04	11.703	7.000	TDXU-1750-05	13.436	8.750	XPMT150512R
1.13/16"	1.812				TDXU-1812-02	8.401	3.624	TDXU-1812-03	10.213	5.436	TDXU-1812-04	12.018	7.248	TDXU-1812-05	13.829	9.060	
1.7/8"	1.875				TDXU-1875-02	8.588	3.750	TDXU-1875-03	10.463	5.625	TDXU-1875-04	12.294	7.500	TDXU-1875-05	14.184	9.375	
1.15/16"	1.937	2.000			TDXU-1937-02	8.776	3.874	TDXU-1937-03	10.713	5.811	TDXU-1937-04	12.609	7.748	TDXU-1937-05	14.538	9.685	
2"	2.000				TDXU-2000-02	8.963	4.000	TDXU-2000-03	10.963	6.000	TDXU-2000-04	12.884	8.000	TDXU-2000-05	14.892	10.000	

INSERTS



INSERT	DIMENSIONS (in)				
	A	B	T	d	r
XPMT040104R	.169	.177	.063	.091	.016
XPMT050204R	.205	.213	.094	.091	.016
XPMT06X308R	.236	.276	.118	.098	.031
XPMT07H308R	.276	.323	.142	.110	.031
XPMT08T308R	.335	.390	.156	.134	.031
XPMT110412R	.441	.492	.187	.173	.047
XPMT150512R	.591	.634	.219	.217	.047

CHIPBREAKERS

	General purpose chipbreaker usable for almost all applications. Features low cutting forces and allows stable drilling.
	Creates excellent chip control for gummy materials such as stainless steels and low carbon steels. Sharp cutting edges.
	Wiper Design In comparison with conventional inserts, this chipbreaker allows higher feeds and produces superior surface finishes.

RECOMMENDED GRADES & CHIPBREAKERS

WORK MATERIALS	FIRST CHOICE	HIGH FEED	HIGH SPEED
Low carbon steels (C<3) JIS SS400, SM490, S25C, etc.	DS AH725		
Carbon steels (C<3) JIS S45C, S55C, etc.	DJ AH725	DW AH725	DS AH120
Low alloy steels JIS SCM415, etc.	DS AH725		
Alloy steels JIS SCM440, SCr420, etc.	DJ AH725	DW AH725	DS AH120
Stainless steels Austenitic JIS SUS304, SUS316, etc.	DS AH725		
Stainless steels Martensitic and ferritic JIS SUS430, SUS416, etc.	DS AH725		
Stainless steels Precipitation hardening JIS SUS630, etc.	DS AH725		
Gray cast irons JIS FC250, etc.	DJ T1015	DJ AH725	
Ductile cast irons JIS FCD700, etc.	DJ T1015	DJ AH725	
Aluminum alloys JIS A2017, ADC12, etc.	DW AH725		
Super Alloys & Titanium	DS AH120		

GRADES

AH725 PVD coated carbide
First choice: for steels and stainless steels
Improved wear and fracture resistance combined with new (Ti, Al)N coating and well-balanced substrate.

AH120 PVD coated carbide
For stainless & super alloys
By combining a highly reliable carbide substrate with "Flashcoat", this grade provides superior impact resistance and wear resistance in high-speed machining. Suitable for drilling stainless steels & super alloys

AH740 PVD coated carbide
General purpose grade
By combining an ultra fine grain cemented carbide with "Flashcoat", this grade provides both wear resistance and impact resistance. Can be used for a wide range of applications.

T1015 CVD coated carbide
For cast irons
By combining a specially designed hard carbide substrate with newly developed multilayer compound coatings, this grade provides excellent wear resistance in machining cast irons.