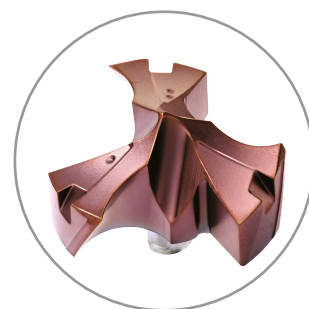


TWIST*S***FEED**

**8XD HOLDER FOR DEEP HOLE DRILLING
AND HEAD DIAMETER EXPANSION**

- ▶ Wider drill head diameter range: Ø12.0-25.5 mm
 - ▶ 3-flute geometry for improved productivity
- ▶ Self-centering geometry for high tolerance hole precision
- ▶ Head exchangeable drills reduce tooling downtime



PRODUCT OVERVIEW

Ingersoll has significantly expanded the 3-flutes head changeable **TwistSFeed** product line's diameter range with the introduction of a new 8xD drilling depth holder.

The **TwistSFeed** family of unique 3-flutes geometry drills, which improve productivity, can be applied to various industries with a wider diameter and drilling depths.

The drill diameter range has been expanded from Ø15.0-Ø20.9 mm to **Ø12.0-Ø25.5 mm**, and an **8xD holder** has been included for deep hole drilling, enabling the same high tolerance hole precision at various drilling depths.

Heads (FPC)	Holders (FD)
NEW Ø12,0 - Ø14,9 Ø15,0 - Ø20,9 Ø21,0 - Ø25,5 0.1 mm increments 0.5 mm increments	3xD 5xD 8xD NEW

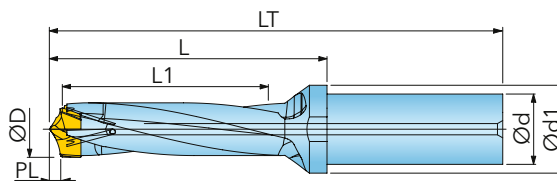
TECHNICAL FEATURES & ADVANTAGES

- Wider drill head diameter range: Ø12.0-25.5 mm
 - Ø12.0- Ø20.9: 0.1 mm increments
 - Ø21.0- Ø25.5: 0.5 mm increments
- Line expanded to 8xD following the current 3xD and 5xD depth holders
- 3-flute geometry for improved productivity
- Self-centering geometry for high tolerance hole precision
- Head exchangeable drills reduce tooling downtime



TWIST SPEED HEAD CHANGEABLE DRILL 3D Ø12,0-Ø25,9 Z=3 (A)

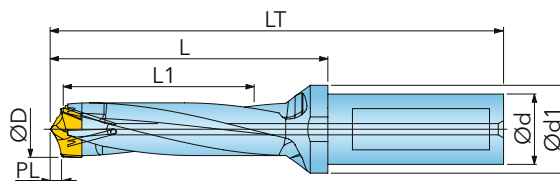
ADAPTION ACC. TO DIN 1835 A



Designation	D	D min.	D max.	d	d1	LT	L	L1	PL	Z	Bs	wrench	IK	kg
FD1200036T3R00	12	12,0	12,4	16	20	108,7	60,7	40,0	2,74	3	12	KFD12-13	✓	0,175
FD1250038T3R00	12,5	12,5	12,9	16	20	110,5	62,5	41,5	2,77	3	12	KFD12-13	✓	0,165
FD1300039T3R00	13	13,0	13,4	16	20	112,8	64,8	43,0	2,91	3	13	KFD12-13	✓	0,170
FD1350041T3R00	13,5	13,5	13,9	16	20	114,6	66,6	44,5	2,94	3	13	KFD12-13	✓	0,175
FD1400042T3R00	14	14,0	14,4	16	20	116,9	68,9	46,0	3,17	3	14	KFD14-15	✓	0,018
FD1450044T3R00	14,5	14,5	14,9	16	20	118,7	70,7	47,5	3,20	3	14	KFD14-15	✓	0,175
FD1500045T4R00	15	15,0	15,9	20	25	123,9	73,9	49,0	3,31	3	15	KFD14-15	✓	0,170
FD1600048T4R00	16	16,0	16,9	20	25	129,0	79,0	52,0	3,70	3	16	KFD16-17	✓	0,250
FD1700051T4R00	17	17,0	17,9	20	25	134,0	84,0	55,0	3,88	3	17	KFD16-17	✓	0,265
FD1800054T5R00	18	18,0	18,9	25	32	146,1	90,1	58,0	4,07	3	18	KFD18-19	✓	0,385
FD1900057T5R00	19	19,0	19,9	25	32	150,7	94,7	61,0	4,26	3	19	KFD18-19	✓	0,400
FD2000060T5R00	20	20,0	20,9	25	32	155,3	99,3	64,0	4,44	3	20	KFD20-21	✓	0,430
FD2100063T5R00	21	21,0	21,9	25	32	159,8	103,8	67,0	4,62	3	21	KFD20-21	✓	0,455
FD2200066T5R00	22	22,0	22,9	25	32	164,4	108,4	70,0	4,78	3	22	KFD22-23	✓	0,440
FD2300069U7R00	23	23,0	23,9	32	42	172,8	112,8	73,0	5,02	3	23	KFD22-23	✓	0,710
FD2400072U7R00	24	24,0	24,9	32	42	177,4	117,4	76,0	5,18	3	24	KFD24-25	✓	0,695
FD2500075U7R00	25	25,0	25,9	32	42	182,0	122,0	79,0	5,29	3	25	KFD24-25	✓	0,750

TWIST SPEED HEAD CHANGEABLE DRILL 3D Ø12,0-Ø25,9 Z=3 (B)

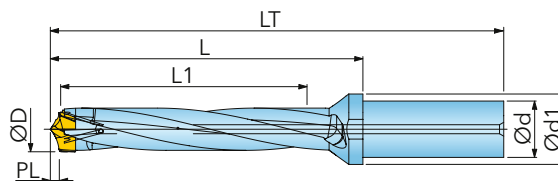
ADAPTION ACC. TO DIN 1835 B



Designation	D	D min.	D max.	d	d1	LT	L	L1	PL	Z	Bs	wrench	IK	kg
FD1200036JDR00	12	12,0	12,4	16	20	108,7	60,7	40,0	2,74	3	12	KFD12-13	✓	0,165
FD1250038JDR00	12,5	12,5	12,9	16	20	110,5	62,5	41,5	2,77	3	12	KFD12-13	✓	0,165
FD1300039JDR00	13	13,0	13,4	16	20	112,8	64,8	43,0	2,91	3	13	KFD12-13	✓	0,170
FD1350041JDR00	13,5	13,5	13,9	16	20	114,6	66,6	44,5	2,94	3	13	KFD12-13	✓	0,170
FD1400042JDR00	14	14,0	14,4	16	20	116,9	68,9	46,0	3,17	3	14	KFD14-15	✓	0,170
FD1450044JDR00	14,5	14,5	14,9	16	20	118,7	70,7	47,5	3,20	3	14	KFD14-15	✓	0,175
FD1500045JER00	15	15,0	15,9	20	25	123,9	73,9	49,0	3,31	3	15	KFD14-15	✓	0,210
FD1600048JER00	16	16,0	16,9	20	25	129,0	79,0	52,0	3,70	3	16	KFD16-17	✓	0,250
FD1700051JER00	17	17,0	17,9	20	25	134,0	84,0	55,0	3,88	3	17	KFD16-17	✓	0,260
FD1800054JFR00	18	18,0	18,9	25	32	146,1	90,1	58,0	4,07	3	18	KFD18-19	✓	0,380
FD1900057JFR00	19	19,0	19,9	25	32	150,7	94,7	61,0	4,26	3	19	KFD18-19	✓	0,390
FD2000060JFR00	20	20,0	20,9	25	32	155,3	99,3	64,0	4,44	3	20	KFD20-21	✓	0,420
FD2100063JFR00	21	21,0	21,9	25	32	159,8	103,8	67,0	4,62	3	21	KFD20-21	✓	0,385
FD2200066JFR00	22	22,0	22,9	25	32	164,4	108,4	70,0	4,78	3	22	KFD22-23	✓	0,450
FD2300069JGR00	23	23,0	23,9	32	42	172,8	112,8	73,0	5,02	3	23	KFD22-23	✓	0,540
FD2400072JGR00	24	24,0	24,9	32	42	177,4	117,4	76,0	5,18	3	24	KFD24-25	✓	0,675
FD2500075JGR00	25	25,0	25,9	32	42	182,0	122,0	79,0	5,29	3	25	KFD24-25	✓	0,710

TWIST[®]SPEED HEAD CHANGEABLE DRILL 5D Ø12,0-Ø25,9 Z=3 (A)

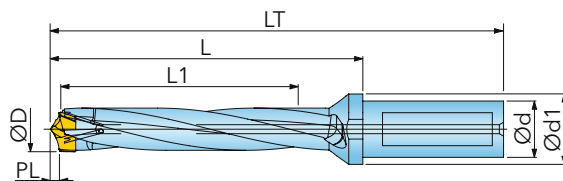
ADAPTION ACC. TO DIN 1835 A



Designation	D	D min.	D max.	d	d1	LT	L	L1	PL	Z	Bs	wrench	IK	kg
FD1200060T3R00	12	12,0	12,4	16	20	132,7	84,7	64,0	2,74	3	12	KFD12-13	✓	0,140
FD1250063T3R00	12,5	12,5	12,9	16	20	135,5	87,5	66,5	2,77	3	12	KFD12-13	✓	0,165
FD1300065T3R00	13	13,0	13,4	16	20	138,8	90,8	69,0	2,91	3	13	KFD12-13	✓	0,180
FD1350068T3R00	13,5	13,5	13,9	16	20	141,6	93,6	71,5	2,94	3	13	KFD12-13	✓	0,185
FD1400070T3R00	14	14,0	14,4	16	20	144,9	96,9	74,0	3,17	3	14	KFD14-15	✓	0,155
FD1450073T3R00	14,5	14,5	14,9	16	20	147,7	99,7	76,5	3,20	3	14	KFD14-15	✓	0,195
FD1500075T4R00	15	15,0	15,9	20	25	153,9	103,9	79,0	3,31	3	15	KFD14-15	✓	0,260
FD1600080T4R00	16	16,0	16,9	20	25	161,0	111,0	84,0	3,70	3	16	KFD16-17	✓	0,350
FD1700085T4R00	17	17,0	17,9	20	25	168,0	118,0	89,0	3,88	3	17	KFD16-17	✓	0,290
FD1800090T5R00	18	18,0	18,9	25	32	182,1	126,1	94,0	4,07	3	18	KFD18-19	✓	0,410
FD1900095T5R00	19	19,0	19,9	25	32	188,7	132,7	99,0	4,26	3	19	KFD18-19	✓	0,435
FD2000100T5R00	20	20,0	20,9	25	32	195,3	139,3	104,0	4,44	3	20	KFD20-21	✓	0,415
FD2100105T5R00	21	21,0	21,9	25	32	201,8	145,8	109,0	4,62	3	21	KFD20-21	✓	0,505
FD2200110T5R00	22	22,0	22,9	25	32	208,4	152,4	114,0	4,78	3	22	KFD22-23	✓	0,475
FD2300115U7R00	23	23,0	23,9	32	42	218,8	158,8	119,0	5,02	3	23	KFD22-23	✓	0,750
FD2400120U7R00	24	24,0	24,9	32	42	225,4	165,4	124,0	5,18	3	24	KFD24-25	✓	0,795
FD2500125U7R00	25	25,0	25,9	32	42	232,0	172,0	129,0	5,29	3	25	KFD24-25	✓	0,780

TWIST SPEED HEAD CHANGEABLE DRILL 5D Ø12,0-Ø25,9 Z=3 (B)

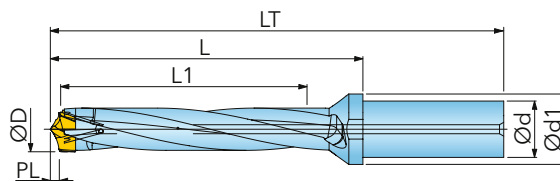
ADAPTION ACC. TO DIN 1835 B



Designation	D	D min.	D max.	d	d1	LT	L	L1	PL	Z	Bs	wrench	IK	kg
FD1200060JDR00	12	12,0	12,4	16	20	132,7	84,7	64,0	2,74	3	12	KFD12-13	✓	0,115
FD1250063JDR00	12,5	12,5	12,9	16	20	135,5	87,5	66,5	2,77	3	12	KFD12-13	✓	0,115
FD1300065JDR00	13	13,0	13,4	16	20	138,8	90,8	69,0	2,91	3	13	KFD12-13	✓	0,180
FD1350068JDR00	13,5	13,5	13,9	16	20	141,6	93,6	71,5	2,94	3	13	KFD12-13	✓	0,185
FD1400070JDR00	14	14,0	14,4	16	20	144,9	96,9	74,0	3,17	3	14	KFD14-15	✓	0,190
FD1450073JDR00	14,5	14,5	14,9	16	20	147,7	99,7	76,5	3,20	3	14	KFD14-15	✓	0,210
FD1500075JER00	15	15,0	15,9	20	25	153,9	103,9	79,0	3,31	3	15	KFD14-15	✓	0,250
FD1600080JER00	16	16,0	16,9	20	25	161,0	111,0	84,0	3,70	3	16	KFD16-17	✓	0,250
FD1700085JER00	17	17,0	17,9	20	25	168,0	118,0	89,0	3,88	3	17	KFD16-17	✓	0,285
FD1800090JFR00	18	18,0	18,9	25	32	182,1	126,1	94,0	4,07	3	18	KFD18-19	✓	0,410
FD1900095JFR00	19	19,0	19,9	25	32	188,7	132,7	99,0	4,26	3	19	KFD18-19	✓	0,425
FD2000100JFR00	20	20,0	20,9	25	32	195,3	139,3	104,0	4,44	3	20	KFD20-21	✓	0,460
FD2100105JFR00	21	21,0	21,9	25	32	201,8	145,8	109,0	4,62	3	21	KFD20-21	✓	0,490
FD2200110JFR00	22	22,0	22,9	25	32	208,4	152,4	114,0	4,78	3	22	KFD22-23	✓	0,750
FD2300115JGR00	23	23,0	23,9	32	42	218,8	158,8	119,0	5,02	3	23	KFD22-23	✓	0,765
FD2400120JGR00	24	24,0	24,9	32	42	225,4	165,4	124,0	5,18	3	24	KFD24-25	✓	0,775
FD2500125JGR00	25	25,0	25,9	32	42	232,0	172,0	129,0	5,29	3	25	KFD24-25	✓	0,815

TWIST[®]SPEED HEAD CHANGEABLE DRILL 8D Ø12,0-Ø25,9 Z=3 (A)

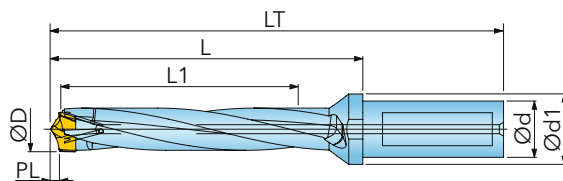
ADAPTION ACC. TO DIN 1835 A



Designation	D	D min.	D max.	d	d1	LT	L	L1	PL	Z	Bs	wrench	IK	kg
FD1200096T3R00	12	12,0	12,4	16	20	168,7	120,7	100,0	2,74	3	12	KFD12-13	✓	0,190
FD1250100T3R00	12,5	12,5	12,9	16	20	173,0	125,0	104,0	2,77	3	12	KFD12-13	✓	0,190
FD1300104T3R00	13	13,0	13,4	16	20	177,8	129,8	108,0	2,91	3	13	KFD12-13	✓	0,195
FD1350108T3R00	13,5	13,5	13,9	16	20	182,1	134,1	112,0	2,94	3	13	KFD12-13	✓	0,205
FD1400112T3R00	14	14,0	14,4	16	20	186,9	138,9	116,0	3,17	3	14	KFD14-15	✓	0,210
FD1450116T3R00	14,5	14,5	14,9	16	20	191,2	143,2	120,0	3,20	3	14	KFD14-15	✓	0,215
FD1500120T4R00	15	15,0	15,9	20	25	198,9	148,9	124,0	3,31	3	15	KFD14-15	✓	0,280
FD1600128T4R00	16	16,0	16,9	20	25	209,0	159,0	132,0	3,70	3	16	KFD16-17	✓	0,430
FD1700136T4R00	17	17,0	17,9	20	25	219,0	169,0	140,0	3,88	3	17	KFD16-17	✓	0,340
FD1800144T5R00	18	18,0	18,9	25	32	236,1	180,1	148,0	4,07	3	18	KFD18-19	✓	0,470
FD1900152T5R00	19	19,0	19,9	25	32	245,7	189,7	156,0	4,26	3	19	KFD18-19	✓	0,500
FD2000160T5R00	20	20,0	20,9	25	32	255,3	199,3	164,0	4,44	3	20	KFD20-21	✓	0,560
FD2100168T5R00	21	21,0	21,9	25	32	264,8	208,8	172,0	4,62	3	21	KFD20-21	✓	0,560
FD2200176T5R00	22	22,0	22,9	25	32	274,4	218,4	180,0	4,78	3	22	KFD22-23	✓	0,585
FD2300184U7R00	23	23,0	23,9	32	42	287,8	227,8	188,0	5,02	3	23	KFD22-23	✓	0,850
FD2400192U7R00	24	24,0	24,9	32	42	297,4	237,4	196,0	5,18	3	24	KFD24-25	✓	0,980
FD2500200U7R00	25	25,0	25,9	32	42	307,0	247,0	204,0	5,29	3	25	KFD24-25	✓	1,055

TWIST SPEED HEAD CHANGEABLE DRILL 8D Ø12,0-Ø25,9 Z=3 (B)

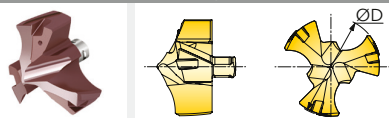
ADAPTION ACC. TO DIN 1835 B



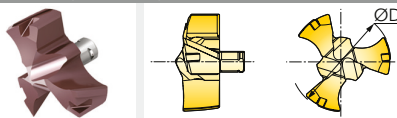
Designation	D	D min.	D max.	d	d1	LT	L	L1	PL	Z	Bs	wrench	IK	kg
FD1200096JDR00	12	12,0	12,4	16	20	168,7	120,7	100,0	2,74	3	12	KFD12-13	✓	0,185
FD1250100JDR00	12,5	12,5	12,9	16	20	173,0	125,0	104,0	2,77	3	12	KFD12-13	✓	0,190
FD1300104JDR00	13	13,0	13,4	16	20	177,8	129,8	108,0	2,91	3	13	KFD12-13	✓	0,135
FD1350108JDR00	13,5	13,5	13,9	16	20	182,1	134,1	112,0	2,94	3	13	KFD12-13	✓	0,205
FD1400112JDR00	14	14,0	14,4	16	20	186,9	138,9	116,0	3,17	3	14	KFD14-15	✓	0,205
FD1450116JDR00	14,5	14,5	14,9	16	20	191,2	143,2	120,0	3,20	3	14	KFD14-15	✓	0,215
FD1500120JER00	15	15,0	15,9	20	25	198,9	148,9	124,0	3,31	3	15	KFD14-15	✓	0,275
FD1600128JER00	16	16,0	16,9	20	25	209,0	159,0	132,0	3,70	3	16	KFD16-17	✓	0,315
FD1700136JER00	17	17,0	17,9	20	25	219,0	169,0	140,0	3,88	3	17	KFD16-17	✓	0,340
FD1800144JFR00	18	18,0	18,9	25	32	236,1	180,1	148,0	4,07	3	18	KFD18-19	✓	0,465
FD1900152JFR00	19	19,0	19,9	25	32	245,7	189,7	156,0	4,26	3	19	KFD18-19	✓	0,495
FD2000160JFR00	20	20,0	20,9	25	32	255,3	199,3	164,0	4,44	3	20	KFD20-21	✓	0,530
FD2100168JFR00	21	21,0	21,9	25	32	264,8	208,8	172,0	4,62	3	21	KFD20-21	✓	0,555
FD2200176JFR00	22	22,0	22,9	25	32	274,4	218,4	180,0	4,78	3	22	KFD22-23	✓	0,585
FD2300184JGR00	23	23,0	23,9	32	42	287,8	227,8	188,0	5,02	3	23	KFD22-23	✓	0,850
FD2400192UJG00	24	24,0	24,9	32	42	297,4	237,4	196,0	5,18	3	24	KFD24-25	✓	0,980
FD2500200UJG00	25	25,0	25,9	32	42	307,0	247,0	204,0	5,29	3	25	KFD24-25	✓	1,055

DRILL HEADS FOR TWISTSPEED DRILLS

Steel and cast iron machining



Machining with flat ground



D	designation		grade
	steel / cast iron	flat ground	
12,0	FPC1200R01	FPF1200R01	IN 2205
12,1	FPC1210R01		IN 2205
12,2	FPC1220R01		IN 2205
12,3	FPC1230R01		IN 2205
12,4	FPC1240R01		IN 2205
12,5	FPC1250R01	FPF1250R01	IN 2205
12,6	FPC1260R01		IN 2205
12,7	FPC1270R01		IN 2205
12,8	FPC1280R01		IN 2205
12,9	FPC1290R01		IN 2205
13,0	FPC1300R01	FPF1300R01	IN 2205
13,1	FPC1310R01		IN 2205
13,2	FPC1320R01		IN 2205
13,3	FPC1330R01		IN 2205
13,4	FPC1340R01		IN 2205
13,5	FPC1350R01	FPF1350R01	IN 2205
13,6	FPC1360R01		IN 2205
13,7	FPC1370R01		IN 2205
13,8	FPC1380R01		IN 2205
13,9	FPC1390R01		IN 2205
14,0	FPC1400R01	FPF1400R01	IN 2205
14,1	FPC1410R01		IN 2205
14,2	FPC1420R01		IN 2205
14,3	FPC1430R01		IN 2205
14,4	FPC1440R01		IN 2205
14,5	FPC1450R01	FPF1450R01	IN 2205
14,6	FPC1460R01		IN 2205
14,7	FPC1470R01		IN 2205
14,8	FPC1480R01		IN 2205
14,9	FPC1490R01		IN 2205
15,0	FPC1500R01	FPF1500R01	IN 2205
15,1	FPC1510R01		IN 2205
15,2	FPC1520R01		IN 2205
15,3	FPC1530R01		IN 2205
15,4	FPC1540R01		IN 2205
15,5	FPC1550R01	FPF1550R01	IN 2205
15,6	FPC1560R01		IN 2205
15,7	FPC1570R01		IN 2205
15,8	FPC1580R01		IN 2205
15,9	FPC1590R01		IN 2205
16,0	FPC1600R01	FPF1600R01	IN 2205
16,1	FPC1610R01		IN 2205
16,2	FPC1620R01		IN 2205
16,3	FPC1630R01		IN 2205
16,4	FPC1640R01		IN 2205
16,5	FPC1650R01	FPF1650R01	IN 2205

D	designation		grade
	steel / cast iron	flat ground	
16,6	FPC1660R01		IN 2205
16,7	FPC1670R01		IN 2205
16,8	FPC1680R01		IN 2205
16,9	FPC1690R01		IN 2205
17,0	FPC1700R01	FPF1700R01	IN 2205
17,1	FPC1710R01		IN 2205
17,2	FPC1720R01		IN 2205
17,3	FPC1730R01		IN 2205
17,4	FPC1740R01		IN 2205
17,5	FPC1750R01	FPF1750R01	IN 2205
17,6	FPC1760R01		IN 2205
17,7	FPC1770R01		IN 2205
17,8	FPC1780R01		IN 2205
17,9	FPC1790R01		IN 2205
18,0	FPC1800R01	FPF1800R01	IN 2205
18,1	FPC1810R01		IN 2205
18,2	FPC1820R01		IN 2205
18,3	FPC1830R01		IN 2205
18,4	FPC1840R01		IN 2205
18,5	FPC1850R01	FPF1850R01	IN 2205
18,6	FPC1860R01		IN 2205
18,7	FPC1870R01		IN 2205
18,8	FPC1880R01		IN 2205
18,9	FPC1890R01		IN 2205
19,0	FPC1900R01	FPF1900R01	IN 2205
19,1	FPC1910R01		IN 2205
19,2	FPC1920R01		IN 2205
19,3	FPC1930R01		IN 2205
19,4	FPC1940R01		IN 2205
19,5	FPC1950R01	FPF1950R01	IN 2205
19,6	FPC1960R01		IN 2205
19,7	FPC1970R01		IN 2205
19,8	FPC1980R01		IN 2205
19,9	FPC1990R01		IN 2205
20,0	FPC2000R01	FPF2000R01	IN 2205
20,1	FPC2010R01		IN 2205
20,2	FPC2020R01		IN 2205
20,3	FPC2030R01		IN 2205
20,4	FPC2040R01		IN 2205
20,5	FPC2050R01	FPF2050R01	IN 2205
20,6	FPC2060R01		IN 2205
20,7	FPC2070R01		IN 2205
20,8	FPC2080R01		IN 2205
20,9	FPC2090R01		IN 2205
21,0	FPC2100R01	FPF2100R01	IN 2205
21,5	FPC2150R01	FPF2150R01	IN 2205

DRILL HEADS FOR TWISTSPEED DRILLS

D	Artikel-Nr.		
	steel / cast iron	flat ground	grade
22,0	FPC2200R01	FPF2200R01	IN 2205
22,5	FPC2250R01	FPF2250R01	IN 2205
23,0	FPC2300R01	FPF2300R01	IN 2205
23,5	FPC2350R01	FPF2350R01	IN 2205
24,0	FPC2400R01	FPF2400R01	IN 2205
24,5	FPC2450R01	FPF2450R01	IN 2205
25,0	FPC2500R01	FPF2500R01	IN 2205
25,5	FPC2550R01	FPF2550R01	IN 2205

D	Artikel-Nr.		
	steel / cast iron	flat ground	grade

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