



WINSFEED

GOLD TWIST

EXTENSION WITH Ø4,0 - Ø5,9 MM
IN 3XD AND 5XD

HEAD-CHANGEABLE DRILLS WITH 4 - 5,9 MM DIAMETERS

- Diameter range from Ø4.0 mm to Ø5.9 mm in 0.1 mm increments
- Eliminates the need for extra set-up time
- Excellent machining performance
- Available in two holder depths: 3xD and 5xD
- Twisted coolant supply



GOLDTWIST HEAD-CHANGEABLE DRILLS 4 - 5,9 MM

Product Overview

Ingersoll introduces an interchangeable drill head line for small diameter hole-making.

Introducing the head-changeable **GoldTwist** line with a unique cutting edge design that improves productivity as well as reduces the cost for small hole applications.

The replaceable head design of the new **GoldTwist** products, which are available in 0.1 mm increments between 4-5.9 mm head diameters, eliminates the need for extra set-up time and increases productivity compared to the solid carbide drill option currently available. These features effectively make the **GoldTwist** family the innovative small-diameter hole machining solution.

Technical Features & Advantages

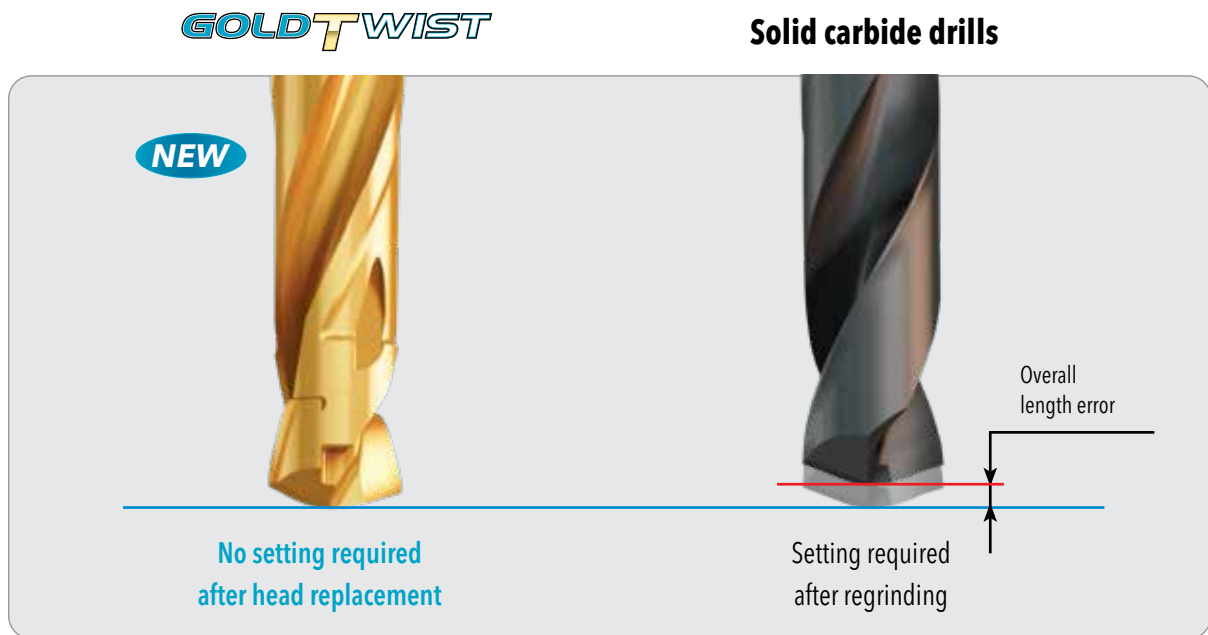
- Head-changeable drills for small diameter holes
- Drill Diameter range: 4-5.9 mm (0.1 mm increments)
- Available in two holder depths: 3xD and 5xD
- Excellent machining performance and high productivity
- No set-up time and no head change offsetting required



GOLDTWIST HEAD-CHANGEABLE DRILLS 4 - 5,9 MM

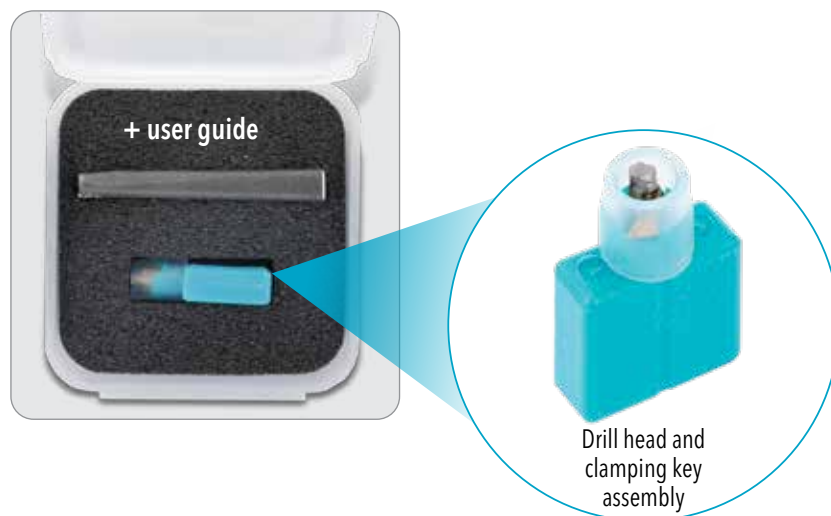
Mounting line-up

- Head replacement eliminates tool setting after regrinding (which can cause length errors).
 - Machining downtime is minimized

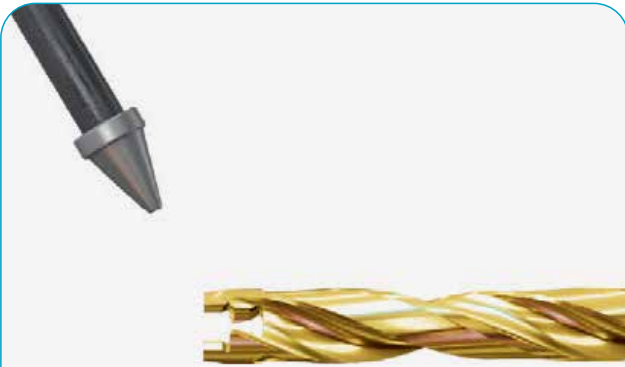


Packaging Details

For convenient indexing of the smaller sized **GoldTwist** products, the head is assembled with the clamping key and a user guide is also enclosed.



Drilling Head Mounting Procedure



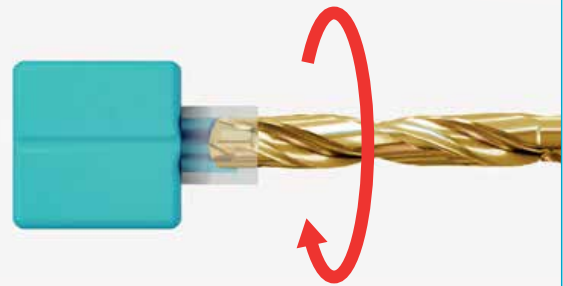
1 Clean the drill pocket with an air gun.



2 If possible, put oil in the pocket.



3 Check the drill head inside the clamping key.



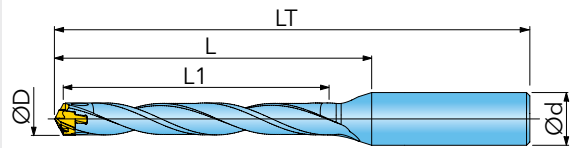
4 Insert the clamping key with drill head into the drill pocket and turn clockwise to tighten.

Recommended Cutting Data

ISO	Material	Condition	Tensile Strength (N/mm ²)	Hardness HB	Cutting speed Vc(m/min)	Feed (mm/rev) vs. drill diameter		
						Ø4 - Ø4.9	Ø5 - Ø5.9	
P	Non-alloy steel and cast steel, free cutting steel	<0.25%C	Annealed	420	125	80-140	0,04-0,08	0,07-0,11
		≥0.25%C	Annealed	650	190	80-130	0,04-0,08	0,07-0,11
		<0.55%C	Quenched + tempered	850	250	80-120	0,04-0,08	0,07-0,11
		≥0.55%C	Annealed	750	220	70-110	0,04-0,08	0,07-0,11
		≥0.55%C	Quenched + tempered	1000	300	50-90	0,04-0,08	0,07-0,11
	Low alloy steel and cast steel (less than 5% of alloying elements)	Annealed		600	200	70-120	0,04-0,08	0,07-0,13
				930	275	70-110	0,04-0,08	0,07-0,13
		Quenched and tempered		1000	300	50-90	0,04-0,08	0,07-0,13
				1200	350	40-70	0,04-0,08	0,07-0,13
	High alloy steel, cast steel and tool steel	Annealed		680	200	50-90	0,06-0,08	0,07-0,11
Quenched + tempered			1100	325	40-80	0,06-0,08	0,07-0,11	
M	Stainless steel and cast steel	Ferritic / martensitic		680	200	40-70	0,05-0,07	0,06-0,08
		Martensitic		820	240	40-70	0,05-0,07	0,06-0,08
		Austenitic		600	180	30-70	0,05-0,07	0,06-0,08
K	Grey cast iron (GG)	Ferritic		-	160	90-160	0,04-0,08	0,10-0,15
		Pearlitic		-	250	80-140	0,04-0,08	0,10-0,15
	Cast iron nodular (GGG)	Ferritic		-	180	90-180	0,04-0,08	0,10-0,15
		Pearlitic		-	260	80-140	0,04-0,08	0,10-0,15
	Malleable cast iron	Ferritic		-	130	90-160	0,04-0,08	0,10-0,15
		Pearlitic		-	230	80-140	0,04-0,08	0,10-0,15

GOLDTWIST EXCHANGEABLE HEAD DRILL 3D Ø4,0-Ø5,9 (A)

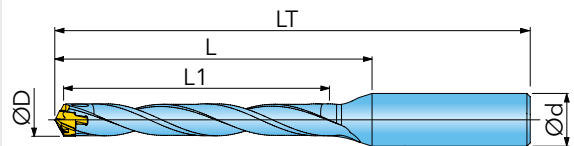
ADAPTION ACC. TO DIN 1835 A



Designation	D min.	D max.	d	LT	L	L1	Z	Bs	wrench		
TD0400012T7R00	4,0	4,4	6	57,7	22,7	13	2	4	KTD4.0-4.9	✓	0,02
TD0450014T7R00	4,5	4,9	6	59,7	24,7	14	2	4,5	KTD4.0-4.9	✓	0,02
TD0500015T7R00	5,0	5,4	6	61,3	26,3	16	2	5	KTD5.0-5.9	✓	0,02
TD0550017T7R00	5,5	5,9	6	63,2	28,2	17	2	5,5	KTD5.0-5.9	✓	0,02

GOLDTWIST EXCHANGEABLE HEAD DRILL 5D Ø4,0-Ø5,9 (A)

ADAPTION ACC. TO DIN 1835 A

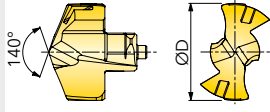


Designation	D min.	D max.	d	LT	L	L1	Z	Bs	wrench		
TD0400020T7R00	4,0	4,4	6	65,7	30,7	21	2	4	KTD4.0-4.9	✓	0,03
TD0450023T7R00	4,5	4,9	6	68,7	33,7	23	2	4,5	KTD4.0-4.9	✓	0,03
TD0500025T7R00	5,0	5,4	6	71,3	36,3	26	2	5	KTD5.0-5.9	✓	0,03
TD0550028T7R00	5,5	5,9	6	74,2	39,2	28	2	5,5	KTD5.0-5.9	✓	0,03

GOLDT WIST DRILL HEADS

DRILL HEADS FOR GOLDTWIST DRILLS

Steel machining



D	Designation steel	grade
4,0	TPA0400R01	IN 2505
4,1	TPA0410R01	IN 2505
4,2	TPA0420R01	IN 2505
4,3	TPA0430R01	IN 2505
4,4	TPA0440R01	IN 2505
4,5	TPA0450R01	IN 2505
4,6	TPA0460R01	IN 2505
4,7	TPA0470R01	IN 2505
4,8	TPA0480R01	IN 2505
4,9	TPA0490R01	IN 2505
5,0	TPA0500R01	IN 2505
5,1	TPA0510R01	IN 2505
5,2	TPA0520R01	IN 2505
5,3	TPA0530R01	IN 2505
5,4	TPA0540R01	IN 2505
5,5	TPA0550R01	IN 2505
5,6	TPA0560R01	IN 2505
5,8	TPA0580R01	IN 2505
5,9	TPA0590R01	IN 2505

D	Designation steel	grade
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