



### Bodies

3xD

5xD

Universal Flat & Cylindrical

### Tips

.6299" - .8228"

(D16.0mm - D20.9mm)

### Geometry

3-Flute

FPC-Steel/Cast Iron

### Grade

IN2205

### Applications

Die & Mold

General Purpose

Aerospace

Ship Building

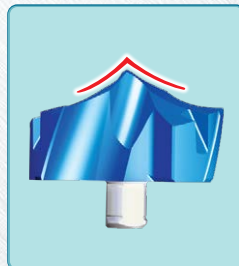
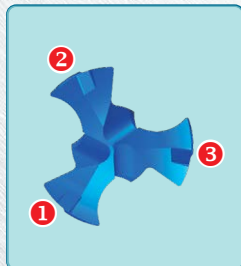
Heat Exchangers

Agriculture

## 3-Flute Quick Change Drill For Increased Productivity!

### Features & Benefits:

- 3-Flute geometry allows for increased productivity by more than 50%
- Diameter range: .6299"-.8228" (D16.0-D20.9mm)
- Can accommodate 3xD and 5xD applications
- Self-Centering geometry
  - Eliminates the need for piloting pre hole
  - Excellent hole precision and finish
  - Reduced spindle loads
- Multiple diameters accommodated with one, single body
- Coolant through for excellent chip evacuation
- New IN2205 grade for excellent tool life for steel and cast-iron applications
- Simplified tip replacement provides reduced downtime







# TWISTSPEED™



Ingersoll's GoldTwist product line, that has been meeting customer's needs with outstanding performance and productivity, is proud to introduce a 3-flute quick change drill with upgraded clamping mechanism designed to maximize productivity.

TwistSFeed utilizes a unique, self-centering feature that is unlike conventional 3-flute solid carbide drills to ensure phenomenal performance and stability for all applications. TwistSFeed provides optimal solutions for customers by reducing costs by improving tool life as well as achieving higher productivity due to multiple flutes and the latest coating technology.

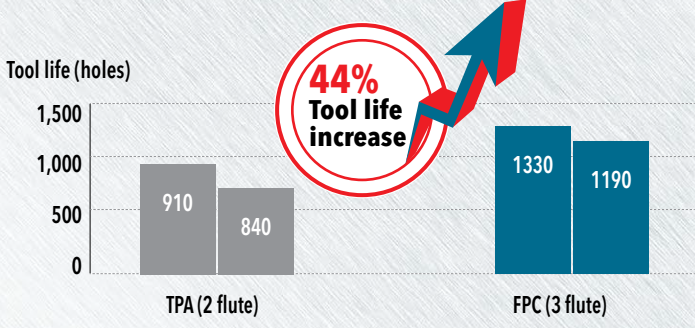
The clamping mechanism allows for the simple replacement of drill tips, as well as accommodating multiple diameters onto one drill body facilitating economical stock management for end users.





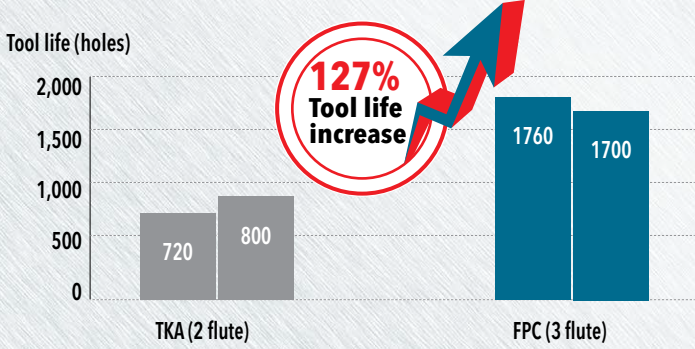
**TWISTSPEED™ CASE STUDY 1**

	Ingersoll		Ingersoll
Material	Alloy Steel 4140		
Drill	TD160008018R01		FD160008018R01
Head	TPA1600R01 IN2505		FPC1600R01 IN2205
Drilling depth (mm)	3.15"		3.15"
Cutting speed	V (sfm)	330	330
Feed	f (ipr)	.018"	.018"
Coolant	217 PSI		217 PSI
Tool life (holes)	910/840		1,330/1,190



**TWISTSPEED™ CASE STUDY 2**

	Ingersoll		Ingersoll
Material	Cast Iron		
Drill	TD160008018R01		FD160008018R01
Head	TKA1600R01 IN2505		FPC1600R01 IN2205
Drilling depth (mm)	1.97"		1.97"
Cutting speed	V (sfm)	530	530
Feed	f (ipr)	.024"	.024"
Coolant	217 PSI		217 PSI
Tool life (holes)	720/800		1,760/1,700

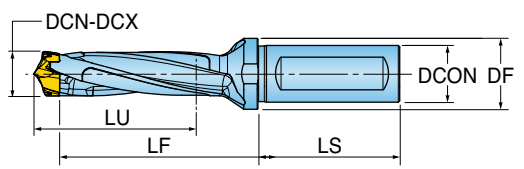
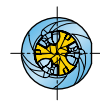






**TWISTSPEED™ SERIES FD (UNIVERSAL FLAT SHANK)**

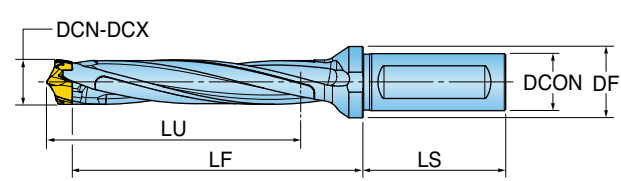
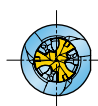
**3XD UNIVERSAL FLAT SHANKS**



Part Number	DCN Cutting Dia. Min.	DCX Cutting Dia. Max.	SSC Seat Size Code	LU Usable Length	LF Functional Length	LS Shank Length	DCON Shank Diameter	DF Flange Diameter	Key
FD160004818R01	0.6299 (16.00 mm)	0.6654 (16.90 mm)	16	2.05	2.76	1.97	0.750	0.98	KFD16-17
FD170005118R01	0.6693 (17.00 mm)	0.7047 (17.90 mm)	17	2.17	2.94	1.97	0.750	0.98	KFD16-17
FD1800054C8R01	0.7087 (18.00 mm)	0.7441 (18.90 mm)	18	2.28	3.15	2.20	1.000	1.26	KFD18-19
FD1900057C8R01	0.7480 (19.00 mm)	0.7835 (19.90 mm)	19	2.40	3.31	2.20	1.000	1.26	KFD18-19
FD2000060C8R01	0.7874 (20.00 mm)	0.8228 (20.90 mm)	20	2.52	3.47	2.20	1.000	1.26	KFD20-21

**TWISTSPEED™ SERIES FD (UNIVERSAL FLAT SHANK)**

**5XD UNIVERSAL FLAT SHANKS**



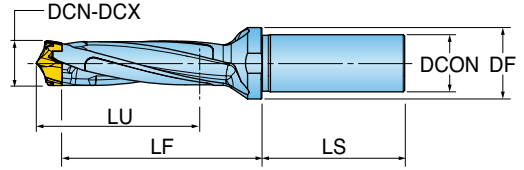
Part Number	DCN Cutting Dia. Min.	DCX Cutting Dia. Max.	SSC Seat Size Code	LU Usable Length	LF Functional Length	LS Shank Length	DCON Shank Diameter	DF Flange Diameter	Key
FD160008018R01	0.6299 (16.00 mm)	0.6654 (16.90 mm)	16	3.31	4.02	1.97	0.750	0.98	KFD16-17
FD170008518R01	0.6693 (17.00 mm)	0.6693 (17.90 mm)	17	3.50	4.28	1.97	0.750	0.98	KFD16-17
FD1800090C8R01	0.7087 (18.00 mm)	0.7441 (18.90 mm)	18	3.70	4.56	2.20	1.000	1.26	KFD18-19
FD1900095C8R01	0.7480 (19.00 mm)	0.7835 (19.90 mm)	19	3.90	4.80	2.20	1.000	1.26	KFD18-19
FD2000100C8R01	0.7874 (20.00 mm)	0.8228 (20.90 mm)	20	4.09	5.04	2.20	1.000	1.26	KFD20-21





**TWISTSPEED™ SERIES FD (CYLINDRICAL SHANK)**

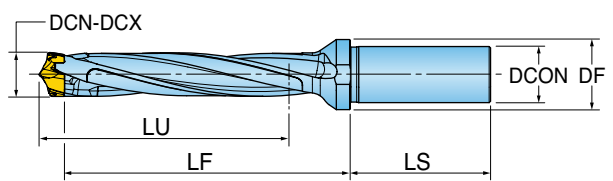
3XD CYLINDRICAL SHANKS



Part Number	DCN Cutting Dia. Min.	DCX Cutting Dia. Max.	SSC Seat Size Code	LU Usable Length	LF Functional Length	LS Shank Length	DCON Shank Diameter	DF Flange Diameter	Key
FD1600048S7R01	0.6299 (16.00 mm)	0.6654 (16.90 mm)	16	2.05	2.76	1.97	0.750	0.98	KFD16-17
FD1700051S7R01	0.6693 (17.00 mm)	0.6693 (17.90 mm)	17	2.17	2.94	1.97	0.750	0.98	KFD16-17
FD1800054S1R01	0.7087 (18.00 mm)	0.7441 (18.90 mm)	18	2.28	3.15	2.20	1.000	1.26	KFD18-19
FD1900057S1R01	0.7480 (19.00 mm)	0.7835 (19.90 mm)	19	2.40	3.31	2.20	1.000	1.26	KFD18-19
FD2000060S1R01	0.7874 (20.00 mm)	0.8228 (20.90 mm)	20	2.52	3.47	2.20	1.000	1.26	KFD20-21

**TWISTSPEED™ SERIES FD (CYLINDRICAL SHANK)**

5XD CYLINDRICAL SHANKS



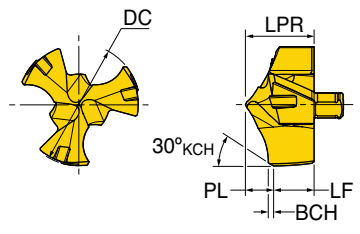
Part Number	DCN Cutting Dia. Min.	DCX Cutting Dia. Max.	SSC Seat Size Code	LU Usable Length	LF Functional Length	LS Shank Length	DCON Shank Diameter	DF Flange Diameter	Key
FD1600080S7R01	0.6299 (16.00 mm)	0.6654 (16.90 mm)	16	3.31	4.02	1.97	0.750	0.98	KFD16-17
FD1700085S7R01	0.6693 (17.00 mm)	0.6693 (17.90 mm)	17	3.50	4.28	1.97	0.750	0.98	KFD16-17
FD1800090S1R01	0.7087 (18.00 mm)	0.7441 (18.90 mm)	18	3.70	4.56	2.20	1.000	1.26	KFD18-19
FD1900095S1R01	0.7480 (19.00 mm)	0.7835 (19.90 mm)	19	3.90	4.80	2.20	1.000	1.26	KFD18-19
FD2000100S1R01	0.7874 (20.00 mm)	0.8228 (20.90 mm)	20	4.09	5.04	2.20	1.000	1.26	KFD20-21





**TWIST SPEED™ SERIES FPC**

**3-FLUTE DRILL TIPS**



Part Number	DC Cutting Diameter	SSC Seat Size Code	PL Point Length	LPR Projection Length	LF Functional Length	BCH Chamfer Length	Grade IN2205
FPC1600R01	0.6299 (16.00 mm)	16	0.146	0.354	0.208	0.028	•
FPC1650R01	0.6496 (16.50 mm)	16	0.146	0.354	0.208	0.028	•
FPC1670R01	0.6575 (16.70 mm)	16	0.146	0.354	0.208	0.028	•
FPC1700R01	0.6693 (17.00 mm)	17	0.154	0.374	0.221	0.028	•
FPC1750R01	0.6890 (17.50 mm)	17	0.153	0.374	0.221	0.028	•
FPC1800R01	0.7087 (18.00 mm)	18	0.160	0.398	0.237	0.028	•
FPC1850R01	0.7283 (18.50 mm)	18	0.161	0.398	0.237	0.028	•
FPC1900R01	0.7480 (19.00 mm)	19	0.168	0.421	0.254	0.028	•
FPC1905R01	0.7500 (19.05 mm)	19	0.168	0.421	0.254	0.028	•
FPC1950R01	0.7677 (19.50 mm)	19	0.168	0.421	0.253	0.028	•
FPC2000R01	0.7874 (20.00 mm)	20	0.175	0.445	0.270	0.028	•
FPC2020R01	0.7952 (20.20 mm)	20	0.175	0.445	0.270	0.028	•
FPC2050R01	0.8071 (20.50 mm)	20	0.175	0.445	0.270	0.028	•

• : Standard items



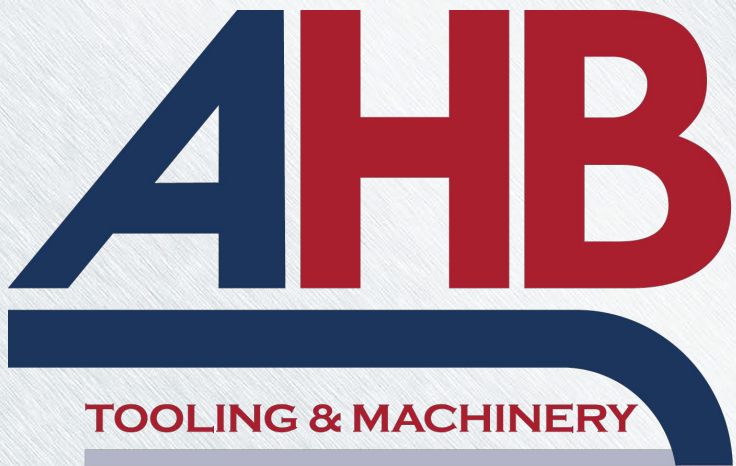


**TWISTSPEED™ OPERATING GUIDELINES**

ISO	Material	Condition	Tensile Strength (N/mm²)	Hardness HB	Material Group No	Cutting Speed Vc (sfm)	Feed vs. Drill Diameter	
							D=Ø.6299- Ø.8228	
							IPR (inches/rev)	
P	Non-alloy steel and cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	260-460	.014-.022
		>=0.25%C	Annealed	650	190	2	260-430	.014-.022
		<0.55%C	Quenched and tempered	850	250	3	260-400	.014-.022
		>=0.55%C	Annealed	750	220	4	230-369	.014-.022
			Quenched and tempered	1000	300	5	165-300	.014-.022
	Low alloy steel and cast steel (less than 5% of alloying elements)		Annealed	600	200	6	260-400	.012-.020
			Quenched and tempered	930	275	7	230-365	.012-.020
				1000	300	8	165-300	.012-.020
				1200	350	9	130-230	.012-.020
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	165-300	.012-.018
			Quenched and tempered	1100	325	11	130-260	.012-.018
K	Grey cast iron (GG)		Ferritic / pearlitic	-	180	15	300-530	.018-.026
			Pearlitic	-	260	16	260-460	.018-.026
	Cast iron nodular (GGG)		Ferritic	-	160	17	300-595	.016-.024
			Pearlitic	-	250	18	260-460	.016-.024
	Malleable cast iron		Ferritic	-	130	19	300-530	.016-.024
			Pearlitic	-	230	20	260-460	.016-.024

■ Steel ■ Cast iron

Note: Feed rates are based on Three Effective - DO NOT TRIPLE\*



**COMPLETE METALWORKING SOLUTIONS**

**(800) 991-4225**  
www.ahbinc.com  
ISO Certified  
customerservice@ahbinc.com