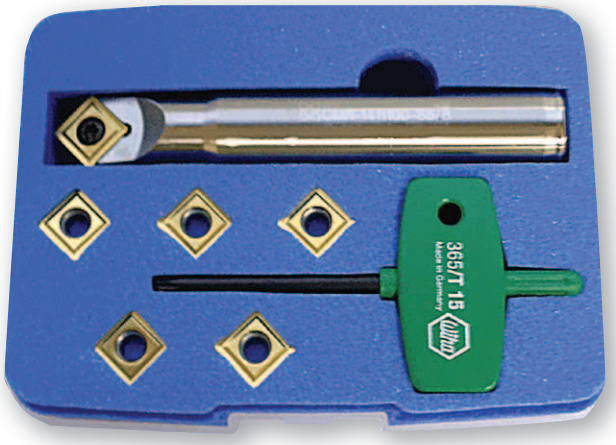
TECHLEADER® TOOLING INC.
3606 California Rd., Orchard Park, NY, 14127, USA
Phone: 716-662-6818 • 1-800-688-6810 • Fax: 1-716-662-8965
tools@Techleader.com • www.Techleader.com

INDEXABLE 90º SPOTTING DRILLS

Spot Drill, Chamfer, Engrave And Groove

All With One Tool!



ORDER NO. 111-250

STEEL INSERT SET

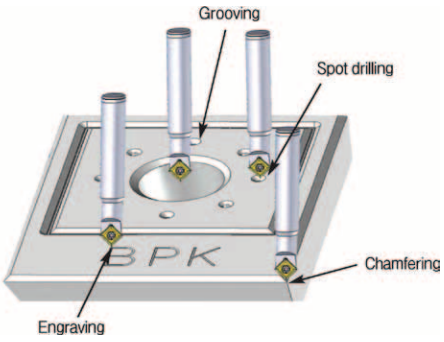
Limited Introductory Offer

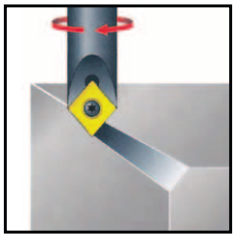
$155.00/SET

REGULAR PRICE: $199.50

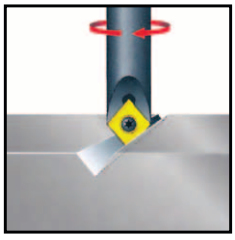
Maximum Versatility, Minimum Cycle Times

- For spotting, engraving, chamfering and grooving on CNC and conventional milling machines
- For spotting on CNC lathes
- Indexable carbide insert with 4 cutting edges provides great cost per edge and long tool life
- Insert fits both 1/2” and 5/8” diameter drill holders
- 5/8” Drill Holders up to 9” OAL

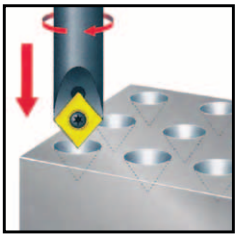




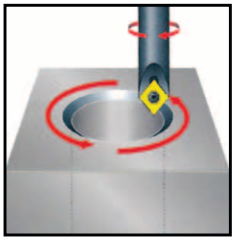
Chamfering



Grooving



Centering/Spot Drilling



Rounding

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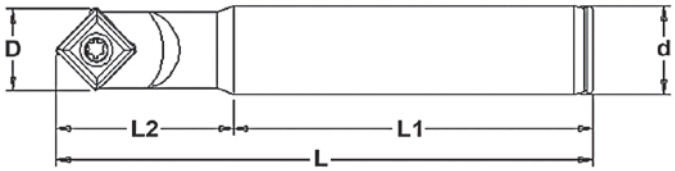


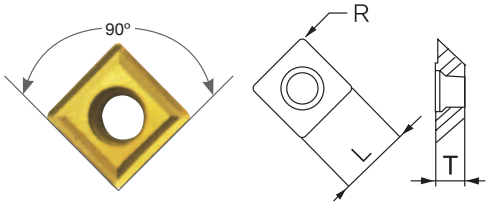
INDIVIDUAL HOLDERS

Description	Insert Reference	Screw Reference	Key Reference	D (Inch)	d (Inch)	L (Inch)	L1 (Inch)	L2 (Inch)	Code	Price
1/2" x 3.94"	XDBP11T308	TSB-3508	Torx® 15	0.551	0.500	3.94" (100 mm)	2.64"	1.30"	111-200	$50.00
5/8" x 3.94"				0.551	0.625	3.94" (100 mm)	2.64"	1.30"	111-205	$50.00
5/8" x 5.90"				0.551	0.625	5.90" (150 mm)	4.60"	1.30"	111-210	$70.00
5/8" x 8.66"				0.551	0.625	8.66" (220 mm)	7.36"	1.30"	111-215	$70.00

REPLACEMENT INSERTS – 90 DEGREE

Description	Material/Grade	L (Inch)	T (Inch)	R (Inch)	Code	Price Per Insert
XDBP11T308-P*	Carbide for Steel	0.433	0.156	0.031	111-220	$24.00/ea
XDBP11T308-S*	Carbide for Stainless Steel	0.433	0.156	0.031	111-225	$24.00/ea

* SOLD IN PACKAGES OF 10

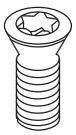


INDEXABLE SPOTTING DRILL SETS

Description	Grade	Code	Reg. Price	SPECIAL
5/8" x 4" Holder, 6 Carbide Inserts and a Torx® 15 Key	Steel	111-250	~~$199.50~~	$155.00

SPARE SCREWS

Description	Code	Price
TSB-3508 (Torx® 15)	111-270	$5.25



RECOMMENDED CUTTING DATA

Inch

$$RPM = \frac{SFM \times 3.82}{D}$$

F = RPM x Inch/Rev x # of Flutes

Metric

$$RPM = \frac{1000 \times SFM}{x\ D}$$

F = RPM x mm/Rev x # of Flutes

RECOMMENDED CUTTING DATA FOR MATERIALS

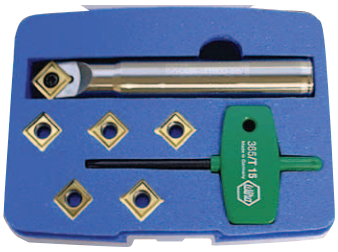
Material	Cutting Speed		Feed/Revolution	
	ft./min.	m/min.	inch/rev.	mm/rev.
Carbon Steel	400-500	120-150	0.002	0.05
Alloy Steel	330-400	100-120	0.0015	0.04
High Alloy Steel	200-260	60-80	0.001	0.03
Hard Steel < HRC40	200-260	60-80	0.001	0.03
Hard Steel, 40	165-200	50-60	0.001	0.03
Stainless Steel	165-200	50-60	0.001	0.03
Gray Cast Iron	260-332	80-102	0.002	0.05

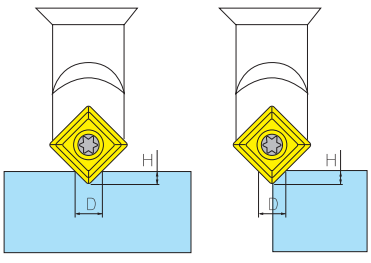
α Point angle 90°
H = Centering depth
D = Effective diameter
Vc = Cutting speed: ft./min. or m/min.
S = Spindle speed
F = Feed rate
f = Feed/Rev.: inch/rev. or mm/rev.
Ff = Feed rate factor

Maximum H

Centering..... 0.28" (7mm)
Grooving..... 0.20" (5mm)
Chamfering... 0.28" (7mm)

- Prices In USD.
- FOB: Orchard Park, NY, USA
- Prices subject to change without notice.





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