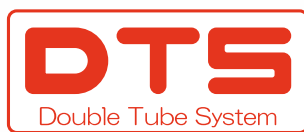
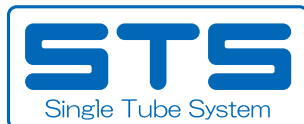




Member IMC Group

Drill Tube

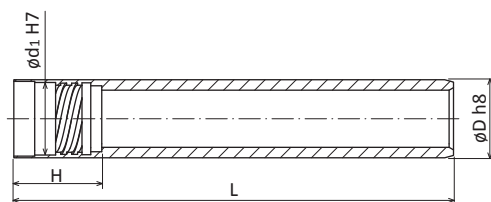
Single Tube System
Double Tube System



ST

Inner thread connection

Four start thread (for dia. 15.60 and above) / Two start thread (for dia. 15.59 and less)



Drill Range (mm)	Code	L (mm)			Dimensions (mm)			Drill Range (mm)	Code	L (mm)	Dimensions (mm)		
		1600	2600	Special Length	D	d1	H				D	d1	H
12.60 - 13.60	ST0094	●		○	11	9.6	22	65.00 - 66.99	ST14	○	56	52	75
13.61 - 14.60	ST0095	●		○	12	10.6	22	67.00 - 72.99	ST15	○	62	58	75
14.61 - 15.59	ST0096	●		○	13	11.6	22	73.00 - 79.99	ST16	○	68	63	75
15.60 - 16.70	ST0097	●		○	14	12.6	21	80.00 - 86.99	ST17	○	75	70	97
16.71 - 17.70	ST0098	●	●	○	15	13.6	21	87.00 - 99.99	ST18	○	82	77	97
17.71 - 18.90	ST0099	●	●	○	16	14.5	22	100.00 - 111.99	ST19	○	94	89	97
18.91 - 20.00	ST0000	●	●	○	17	15.5	22	112.00 - 123.99	ST20	○	106	101	118
20.01 - 21.80	ST00	●	●	○	18	16	27.5	124.00 - 135.99	ST21	○	118	113	118
21.81 - 24.10	ST01		●	○	20	18	30	136.00 - 147.99	ST22	○	130	125	118
24.11 - 26.40	ST02	●	●	○	22	19.5	30	148.00 - 159.99	ST23	○	142	137	139
26.41 - 28.70	ST03		●	○	24	21	30	160.00 - 171.99	ST24	○	154	149	139
28.71 - 31.00	ST04		●	○	26	23.5	33	172.00 - 183.99	ST25	○	166	161	139
31.01 - 33.30	ST05		●	○	28	25.5	33	184.00 - 195.99	ST26	○	178	173	144
33.31 - 36.20	ST06		●	○	30	28	33	196.00 - 207.99	ST27	○	190	185	144
36.21 - 39.60	ST07		●	○	33	30	40	208.00 - 219.99	ST28	○	202	197	144
39.61 - 43.00	ST08		●	○	36	33	40	220.00 - 231.99	ST29	○	214	208	164
43.01 - 47.00	ST09		●	○	39	36	40	232.00 - 243.99	ST30	○	226	220	164
47.01 - 51.70	ST10		●	○	43	39	40	244.00 - 255.99	ST31	○	238	232	164
51.71 - 56.20	ST11		●	○	47	43	44	256.00 - 267.99	ST32	○	250	244	184
56.21 - 60.60	ST12		●	○	51	47	44	268.00 - 279.99	ST33	○	262	256	184
60.61 - 65.00	ST13			○	56	51	44	280.00 - 291.99	ST34	○	274	268	184

- Please indicate the length (L) when ordering. Ordering example for drill dia. ø60.00 mm and drill tube length 2600 mm: ST12X2600
- Other lengths are available upon request. Please contact Unitac sales department for further information.

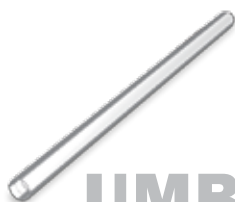
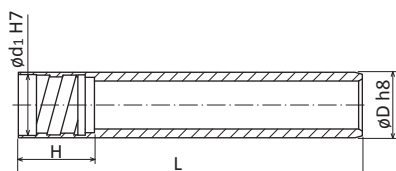
● : Standard Stock item
○ : Special length

UMBB

Inner thread connection

Single start thread

For MBU Drill Head


MBU Drill Head

Refer to UNITAC Brazed tools catalog for detail.

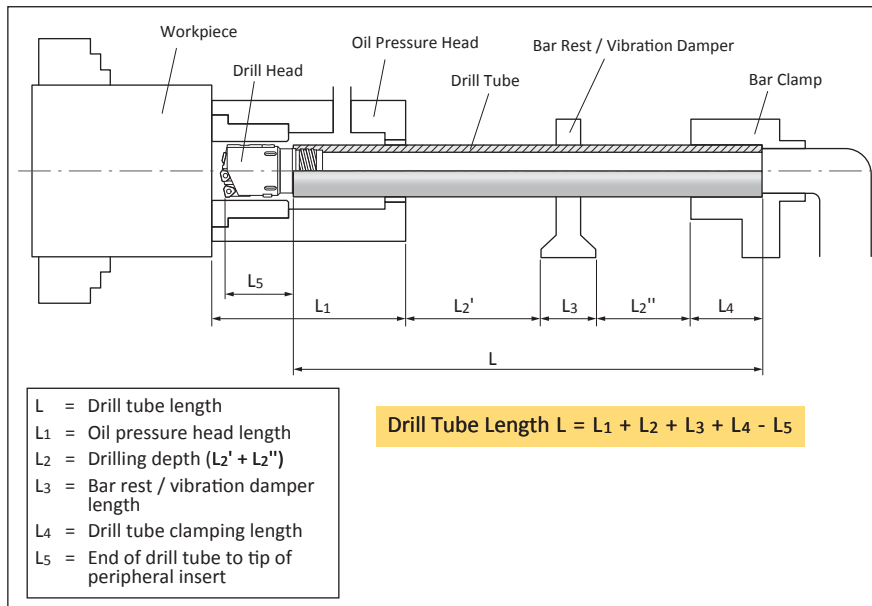
Drill Range (mm)	Code	L (mm)		Dimensions (mm)		
		Special Length		D	d1	H
8.00 - 8.99	UMBB071		○	7.1	6	16
9.00 - 9.99	UMBB083		○	8.3	7.2	16
10.00 - 10.99	UMBB090		○	9	7.6	16
11.00 - 11.99	UMBB100		○	10	8.6	16
12.00 - 13.49	UMBB110		○	11	9.1	16
13.50 - 14.79	UMBB120		○	12	10.8	16

○ : Special length

- Please indicate the length (L) when ordering. Ordering example for drill dia. ø11.00 mm and drill tube length 1000 mm: UMBB100X1000

Calculation of special length tube

Drill tubes with other length than standard item are available upon request.
Please calculate the tube length as below according to your machine.



BTU



Dia. øDc (mm)	L5 (mm)
12.60 - 17.70	20
17.71 - 19.20	23
19.21 - 21.80	22
21.81 - 24.10	23
24.11 - 28.70	24
28.71 - 33.30	27
33.31 - 36.20	26
36.21 - 40.60	29
40.61 - 43.00	28
43.01 - 47.00	30
47.01 - 51.70	29
51.71 - 56.20	32
56.21 - 58.40	34
58.41 - 65.00	33

FINE BEAM



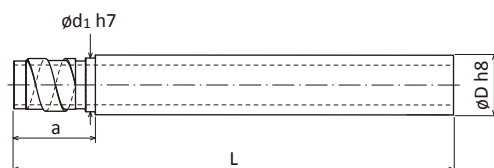
Dia. øDc (mm)	L5 (mm)
25.00 - 28.70	40
28.71 - 33.30	42
33.31 - 36.20	47
36.21 - 39.60	50
39.61 - 43.00	55
43.01 - 51.70	60
51.71 - 56.20	66
56.21 - 65.00	71

UNIDEX



Dia. øDc (mm)	L5 (mm)
38.00 - 43.00	45
43.01 - 51.70	55
51.71 - 56.20	56
56.21 - 65.00	66
65.00 - 79.99	75
80.00 - 111.99	83
112.00 - 147.99	87
148.00 - 183.99	86
184.00 - 255.99	101
256.00 - 291.99	106

UB Outer thread connection Single start thread

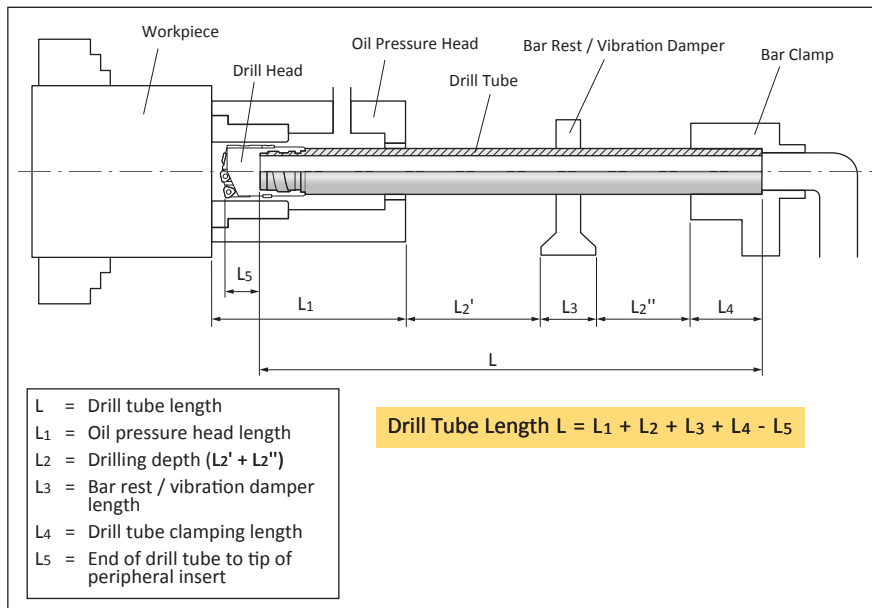


Drill Range (mm)	Code	L (mm)	Dimensions (mm)			Drill Range (mm)	Code	L (mm)	Dimensions (mm)		
		Special Length	D	d ₁	a			Special Length	D	d ₁	a
14.50 - 15.00	UB12-1	○	12	11.5	23	61.00 - 67.99	UB56	○	56	53	41
15.01 - 15.50	UB12-2	○	12	11.8	23	68.00 - 74.99	UB62	○	62	59	41
15.51 - 16.00	UB13-1	○	13	12.4	23	75.00 - 80.99	UB68	○	68	65	71
16.01 - 16.50	UB13-2	○	13	12.7	23	81.00 - 90.99	UB75	○	75	71	71
16.51 - 17.25	UB14-1	○	14	13.4	23	91.00 - 98.99	UB82	○	82	79	71
17.26 - 18.00	UB14-2	○	14	13.7	23	99.00 - 110.99	UB94	○	94	90	71
18.01 - 19.00	UB15	○	15	14.4	23	111.00 - 122.99	UB106	○	106	102	71
19.01 - 19.99	UB16.5	○	16.5	15.4	23	123.00 - 134.99	UB118	○	118	114	71
20.00 - 21.99	UB18	○	18	16.5	26	135.00 - 148.99	UB130	○	130	126	71
22.00 - 24.99	UB20	○	20	19	26	149.00 - 161.99	UB142	○	142	139	71
25.00 - 26.99	UB22	○	22	20	26	162.00 - 173.99	UB154	○	154	151	86
27.00 - 29.99	UB24	○	24	22	26	174.00 - 185.99	UB166	○	166	163	86
30.00 - 31.99	UB26	○	26	24	26	186.00 - 197.99	UB178	○	178	175	86
32.00 - 33.99	UB28	○	28	26	26	198.00 - 209.99	UB190	○	190	187	86
34.00 - 36.99	UB30	○	30	27	41	210.00 - 221.99	UB202	○	202	199	86
37.00 - 39.99	UB33	○	33	30	41	222.00 - 233.99	UB214	○	214	211	86
40.00 - 43.99	UB36	○	36	33	41	234.00 - 245.99	UB226	○	226	223	86
44.00 - 46.99	UB39	○	39	37	41	246.00 - 257.99	UB238	○	238	235	86
47.00 - 51.99	UB43	○	43	41	41	258.00 - 269.99	UB250	○	250	247	121
52.00 - 56.99	UB47	○	47	44	41	270.00 - 281.99	UB262	○	262	259	121
57.00 - 60.99	UB51	○	51	49	41	282.00 - 293.99	UB274	○	274	271	121

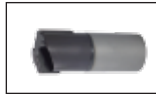
• Please indicate the length (L) when ordering. Ordering example for drill dia. ø60.00 mm and drill tube length 2600 mm: UB51X2600 ○ : Special length

Calculation of special length tube

Please calculate the tube length as below according to your machine.



TU



Dia. øDc (mm)	L5 (mm)
14.50 - 19.99	28
20.00 - 24.99	34
25.00 - 29.99	41
30.00 - 31.99	46
32.00 - 33.99	56
34.00 - 39.99	41
40.00 - 43.99	42
44.00 - 65.00	52

FINE BEAM



Dia. øDc (mm)	L5 (mm)
25.00 - 29.99	45
30.00 - 36.99	50
37.00 - 39.99	55
40.00 - 43.99	60
44.00 - 51.99	65
52.00 - 56.99	70
57.00 - 65.00	75

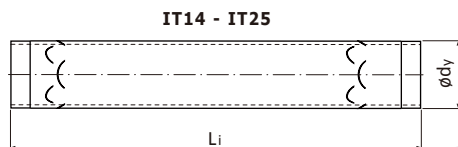
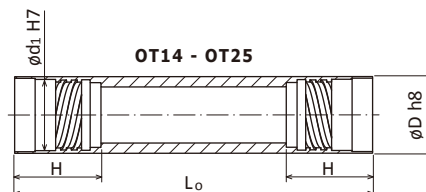
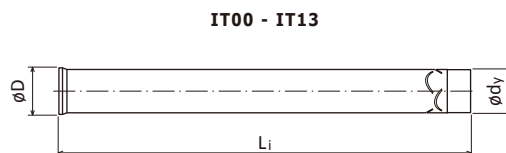
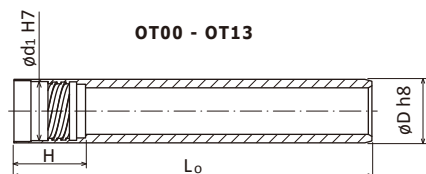
UNIDEX



Dia. øDc (mm)	L5 (mm)
38.00 - 43.99	40
44.00 - 51.99	50
52.00 - 56.99	60
57.00 - 67.99	70
68.00 - 161.99	80
162.00 - 257.99	105
258.00 - 293.99	90

OT & IT

Outer Tube & Inner Tube



OT & IT



Drill Range (mm)	Outer Tube (OT)					Inner Tube (IT)				
	Code	L_o (mm)	Dimensions (mm)			Code	L_i (mm)	Dimensions (mm)		
			D	d_1	H			D	d_y	
		Special Length					Special Length			
18.40 - 20.00	OT00	○	18	16	27.5	IT00	○	12	10	
20.01 - 21.80	OT01	○	19.5	18	30	IT01	○	14	12	
21.81 - 24.10	OT02	○	21.5	19.5	30	IT02	○	15	13	
24.11 - 26.40	OT03	○	23.5	21	30	IT03	○	16	14	
26.41 - 28.70	OT04	○	26	23.5	33	IT04	○	18	16	
28.71 - 31.00	OT05	○	28	25.5	33	IT05	○	20	18	
31.01 - 33.30	OT06	○	30.5	28	33	IT06	○	22	20	
33.31 - 36.20	OT07	○	33	30	40	IT07	○	24	22	
36.21 - 39.60	OT08	○	35.5	33	40	IT08	○	26	24	
39.61 - 43.00	OT09	○	39	36	40	IT09	○	29	27	
43.01 - 47.00	OT10	○	42.5	39	40	IT10	○	32	30	
47.01 - 51.70	OT11	○	46.5	43	44	IT11	○	35	32	
51.71 - 56.20	OT12	○	51	47	44	IT12	○	39	36	
56.21 - 65.00	OT13	○	55.5	51	44	IT13	○	43	40	
65.00 - 66.99	OT14	○	56	52	75	IT14	○	-	40	
67.00 - 72.99	OT15	○	62	58	75	IT15	○	-	44	
73.00 - 79.99	OT16	○	68	63	75	IT16	○	-	48	
80.00 - 86.99	OT17	○	75	70	97	IT17	○	-	54	
87.00 - 99.99	OT18	○	82	77	97	IT18	○	-	60	
100.00 - 111.99	OT19	○	94	89	97	IT19	○	-	70	
112.00 - 123.99	OT20	○	106	101	118	IT20	○	-	80	
124.00 - 135.99	OT21	○	118	113	118	IT21	○	-	80	
136.00 - 147.99	OT22	○	130	125	118	IT22	○	-	95	
148.00 - 159.99	OT23	○	142	137	139	IT23	○	-	100	
160.00 - 171.99	OT24	○	154	149	139	IT24	○	-	120	
172.00 - 183.99	OT25	○	166	161	139	IT25	○	-	130	

• Please indicate the length (L) when ordering. Ordering example for drill dia. $\phi 60.00$ mm and tube length 1070 mm: OT13X1070

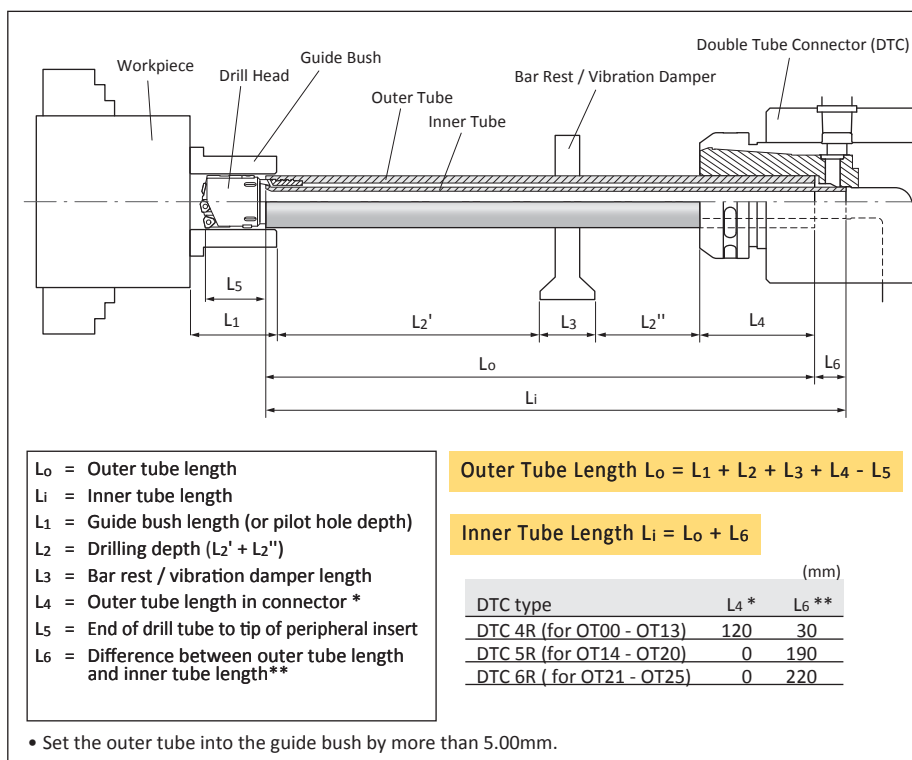
○ : Special length

• Inner Tube length (L_i) should be ordered as follows.

- ▶ For ranges 18.40 - 65.00 (OT00 - OT13) Inner Tube length (L_i) = Outer Tube length (L_o) + 30 mm
- ▶ For ranges 65.00 - 123.99 (OT14 - OT20) Inner Tube length (L_i) = Outer Tube length (L_o) + 190 mm
- ▶ For ranges 124.00 - 183.99 (OT21 - OT25) Inner Tube length (L_i) = Outer Tube length (L_o) + 220 mm

Calculation of special length tube

Drill tubes with other length than standard item are available upon request.



ETU



Dia. øDc (mm)	L5 (mm)
18.40 - 20.00	20
20.01 - 24.10	23
24.11 - 28.70	24
28.71 - 33.30	27
33.31 - 36.20	26
36.21 - 40.60	29
40.61 - 43.00	28
43.01 - 47.00	30
47.01 - 51.70	29
51.71 - 56.20	32
56.21 - 58.40	34
58.41 - 65.00	33

FINE BEAM



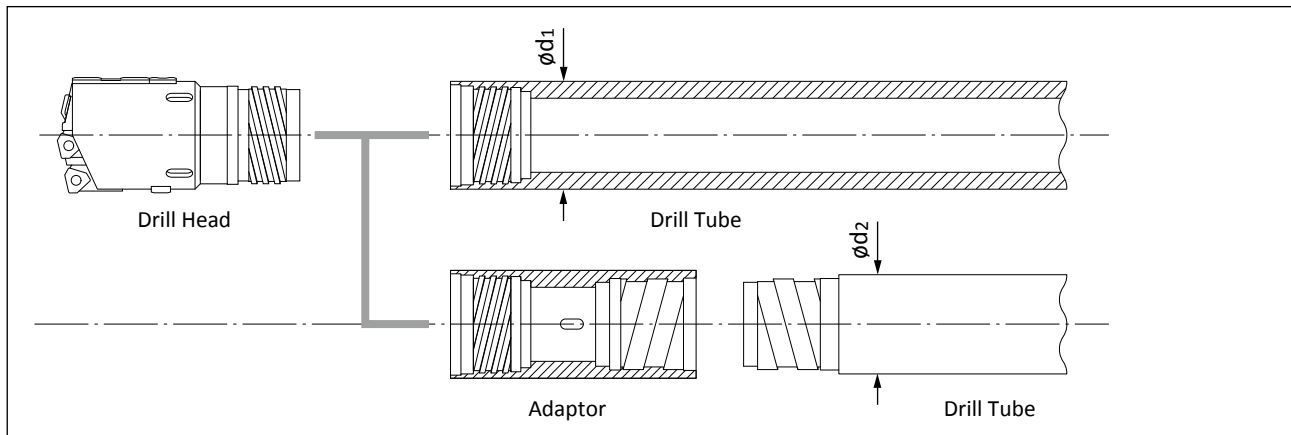
Dia. øDc (mm)	L5 (mm)
25.00 - 26.40	40
26.41 - 31.00	42
31.01 - 33.30	47
33.31 - 36.20	50
36.21 - 39.60	55
39.61 - 47.00	60
47.01 - 51.70	66
51.71 - 65.00	71

UNIDEX



Dia. øDc (mm)	L5 (mm)
38.00 - 43.00	45
43.01 - 47.00	55
47.01 - 51.70	51
51.71 - 56.20	56
56.21 - 65.00	66
65.00 - 79.99	75
80.00 - 111.99	83
112.00 - 147.99	87
148.00 - 183.99	86

for converting from external to internal tube threads



ϕd_1 : Tube diameter which fits your drill head

ϕd_2 : Tube diameter which is to be used with the adaptor

The diagram illustrates the ADPT- (Asynchronous Dynamic Process Transfer) architecture. It shows two parallel processing paths, labeled $\emptyset d_1$ and $\emptyset d_2$. Each path starts with a vertical stack of three boxes: SS (Single Start), TS (Two Start), and FS (Four Start). These boxes are connected to a central vertical line. This line then branches into two horizontal lines, each leading to a box labeled F (Female Thread) and M (Male Thread). The paths are separated by a slash (/) in the center.

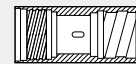
Ordering example:

For ST11 to UB47

ADPT-F47FS/F47SS

ST1:

UB47



Adaptors converting different tube size threads are available upon request. Please contact Unitac sales department for further information.



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Tool specifications are subject to change without notice for the purpose of improvement of the products.