

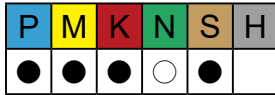
# DM Solid Carbide Drill for Superalloy & Stainless Steel

P	M	K	N	S	H
●	●	●	○	●	

- ***Suitable for Inconel, Titanium and Stainless Steel machining.***
- ***Special NR geometry design for excellent chip removal.***
- ***Optimized flute design and excellent polishing to enable efficiency.***
- ***Drill performance compete with international famous manufacturers.***

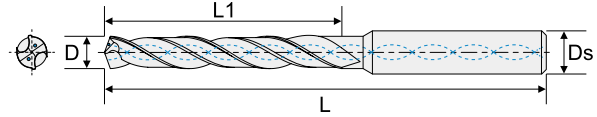


## DMC3 - 3xD (Internal Coolant)



### Product Specs

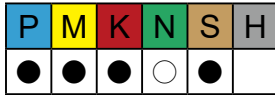
- 3xD Cutting depth
- SINIX Coating
- For High Temperature Alloy, Stainless Steel, Steel, Alloy Steel and Cast Iron.
- Reinforced Shank
- Tolerance h8
- 140° Tip Angle
- Double Margins Design
- Internal Coolant
- NR Tip Design



Unit:mm

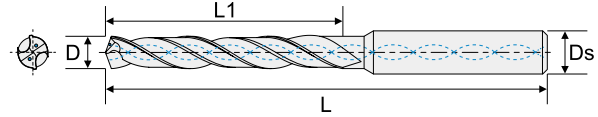
Order No.	D	L1	L	Ds	Order No.	D	L1	L	Ds
DMC304000302	4.00	24	66	6	DMC308300302	8.30	47	89	10
DMC304100302	4.10	24	66	6	DMC308400302	8.40	47	89	10
DMC304200302	4.20	24	66	6	DMC308500302	8.50	47	89	10
DMC304300302	4.30	24	66	6	DMC308600302	8.60	47	89	10
DMC304400302	4.40	24	66	6	DMC308700302	8.70	47	89	10
DMC304500302	4.50	24	66	6	DMC308800302	8.80	47	89	10
DMC304600302	4.60	24	66	6	DMC308900302	8.90	47	89	10
DMC304650302	4.65	24	66	6	DMC309000302	9.00	47	89	10
DMC304700302	4.70	24	66	6	DMC309100302	9.10	47	89	10
DMC304760302	4.76(3/16")	24	66	6	DMC309200302	9.20	47	89	10
DMC304800302	4.80	28	66	6	DMC309250302	9.25	47	89	10
DMC304900302	4.90	28	66	6	DMC309300302	9.30	47	89	10
DMC305000302	5.00	28	66	6	DMC309400302	9.40	47	89	10
DMC305100302	5.10	28	66	6	DMC309500302	9.50	47	89	10
DMC305200302	5.20	28	66	6	DMC309520302	9.52(3/8")	47	89	10
DMC305300302	5.30	28	66	6	DMC309600302	9.60	47	89	10
DMC305400302	5.40	28	66	6	DMC309700302	9.70	47	89	10
DMC305500302	5.50	28	66	6	DMC309800302	9.80	47	89	10
DMC305560302	5.56(7/32")	28	66	6	DMC309900302	9.90	47	89	10
DMC305700302	5.70	28	66	6	DMC310000302	10.00	47	89	10
DMC305800302	5.80	28	66	6	DMC310200302	10.20	55	102	12
DMC305900302	5.90	28	66	6	DMC310500302	10.50	55	102	12
DMC306000302	6.00	28	66	6	DMC310700302	10.70	55	102	12
DMC306100302	6.10	34	79	8	DMC311000302	11.00	55	102	12
DMC306200302	6.20	34	79	8	DMC311200302	11.20	55	102	12
DMC306300302	6.30	34	79	8	DMC311500302	11.50	55	102	12
DMC306350302	6.35(1/4")	34	79	8	DMC311700302	11.70	55	102	12
DMC306400302	6.40	34	79	8	DMC312000302	12.00	55	102	12
DMC306500302	6.50	34	79	8	DMC312500302	12.50	60	107	14
DMC306600302	6.60	34	79	8	DMC312700302	12.70(1/2")	60	107	14
DMC306700302	6.70	34	79	8	DMC313000302	13.00	60	107	14
DMC306800302	6.80	34	79	8	DMC313500302	13.50	60	107	14
DMC306900302	6.90	34	79	8	DMC313700302	13.70	60	107	14
DMC307000302	7.00	34	79	8	DMC314000302	14.00	60	107	14
DMC307100302	7.10	41	79	8	DMC314500302	14.50	65	115	16
DMC307140302	7.14(9/32")	41	79	8	DMC314700302	14.70	65	115	16
DMC307200302	7.20	41	79	8	DMC315000302	15.00	65	115	16
DMC307300302	7.30	41	79	8	DMC315500302	15.50	65	115	16
DMC307400302	7.40	41	79	8	DMC315700302	15.70	65	115	16
DMC307500302	7.50	41	79	8	DMC316000302	16.00	65	115	16
DMC307600302	7.60	41	79	8	DMC318000302	18.00	73	123	18
DMC307700302	7.70	41	79	8	DMC319000302	19.00	79	131	20
DMC307800302	7.80	41	79	8	DMC320000302	20.00	79	131	20
DMC307900302	7.90	41	79	8					
DMC307940302	7.94(5/16")	41	79	8					
DMC308000302	8.00	41	79	8					
DMC308100302	8.10	47	89	10					
DMC308200302	8.20	47	89	10					

## DMC5 - 5×D (Internal Coolant)



### Product Specs

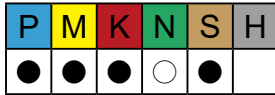
- 5×D Cutting depth
- SINIX Coating
- For High Temperature Alloy, Stainless Steel, Steel, Alloy Steel and Cast Iron.
- Reinforced Shank
- Tolerance h8
- 140° Tip Angle
- Double Margins Design
- Internal Coolant
- NR Tip Design



Unit:mm

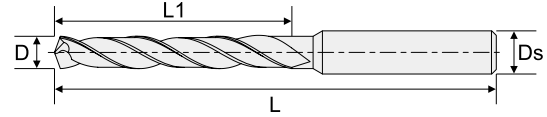
Order No.	D	L1	L	Ds	Order No.	D	L1	L	Ds
DMC543400502	3.40	28	60	4	DMC508000502	8.00	53	91	8
DMC543800502	3.80	36	74	4	DMC508100502	8.10	61	103	10
DMC504000502	4.00	36	74	6	DMC508200502	8.20	61	103	10
DMC504100502	4.10	36	74	6	DMC508300502	8.30	61	103	10
DMC504200502	4.20	36	74	6	DMC508400502	8.40	61	103	10
DMC504300502	4.30	36	74	6	DMC508500502	8.50	61	103	10
DMC504400502	4.40	36	74	6	DMC508600502	8.60	61	103	10
DMC504500502	4.50	36	74	6	DMC508700502	8.70	61	103	10
DMC504600502	4.60	36	74	6	DMC508800502	8.80	61	103	10
DMC504650502	4.65	36	74	6	DMC508900502	8.90	61	103	10
DMC504700502	4.70	36	74	6	DMC509000502	9.00	61	103	10
DMC504760502	4.76(3/16")	36	74	6	DMC509100502	9.10	61	103	10
DMC504800502	4.80	44	82	6	DMC509200502	9.20	61	103	10
DMC504900502	4.90	44	82	6	DMC509250502	9.25	61	103	10
DMC505000502	5.00	44	82	6	DMC509300502	9.30	61	103	10
DMC505100502	5.10	44	82	6	DMC509400502	9.40	61	103	10
DMC505200502	5.20	44	82	6	DMC509500502	9.50	61	103	10
DMC505300502	5.30	44	82	6	DMC509520502	9.52(3/8")	61	103	10
DMC505400502	5.40	44	82	6	DMC509600502	9.60	61	103	10
DMC505500502	5.50	44	82	6	DMC509700502	9.70	61	103	10
DMC505550502	5.55(7/32")	44	82	6	DMC509800502	9.80	61	103	10
DMC505600502	5.60	44	82	6	DMC509900502	9.90	61	103	10
DMC505700502	5.70	44	82	6	DMC510000502	10.00	61	103	10
DMC505800502	5.80	44	82	6	DMC510200502	10.20	71	118	12
DMC505900502	5.90	44	82	6	DMC510500502	10.50	71	118	12
DMC506000502	6.00	44	82	6	DMC510700502	10.70	71	118	12
DMC506100502	6.10	53	91	8	DMC511000502	11.00	71	118	12
DMC506200502	6.20	53	91	8	DMC511200502	11.20	71	118	12
DMC506300502	6.30	53	91	8	DMC511500502	11.50	71	118	12
DMC506350502	6.35(1/4")	53	91	8	DMC511700502	11.70	71	118	12
DMC506400502	6.40	53	91	8	DMC512000502	12.00	71	118	12
DMC506500502	6.50	53	91	8	DMC512500502	12.50	77	124	14
DMC506600502	6.60	53	91	8	DMC512700502	12.70(1/2")	77	124	14
DMC506700502	6.70	53	91	8	DMC513000502	13.00	77	124	14
DMC506800502	6.80	53	91	8	DMC513500502	13.50	77	124	14
DMC506900502	6.90	53	91	8	DMC513700502	13.70	77	124	14
DMC507000502	7.00	53	91	8	DMC514000502	14.00	77	124	14
DMC507100502	7.10	53	91	8	DMC514500502	14.50	83	133	16
DMC507140502	7.14(9/32")	53	91	8	DMC514700502	14.70	83	133	16
DMC507200502	7.20	53	91	8	DMC515000502	15.00	83	133	16
DMC507300502	7.30	53	91	8	DMC515500502	15.50	83	133	16
DMC507400502	7.40	53	91	8	DMC515700502	15.70	83	133	16
DMC507500502	7.50	53	91	8	DMC516000502	16.00	83	133	16
DMC507600502	7.60	53	91	8	DMC518000502	18.00	93	143	18
DMC507700502	7.70	53	91	8	DMC519000502	19.00	101	153	20
DMC507800502	7.80	53	91	8	DMC520000502	20.00	101	153	20
DMC507900502	7.90	53	91	8					
DMC507940502	7.94(5/16")	53	91	8					

## DMN3 - 3×D (External Coolant)



### Product Specs

- 3×D Cutting depth
- SINIX Coating
- For High Temperature Alloy, Stainless Steel, Steel, Alloy Steel and Cast Iron.
- Reinforced Shank
- Tolerance h8
- 140° Tip Angle
- Double Margins Design
- External Coolant
- NR Tip Design



Unit:mm

Order No.	D	L1	L	Ds	Order No.	D	L1	L	Ds
DMN304000302	4.00	24	66	6	DMN308200302	8.20	47	89	10
DMN304100302	4.10	24	66	6	DMN308300302	8.30	47	89	10
DMN304200302	4.20	24	66	6	DMN308400302	8.40	47	89	10
DMN304300302	4.30	24	66	6	DMN308500302	8.50	47	89	10
DMN304400302	4.40	24	66	6	DMN308600302	8.60	47	89	10
DMN304500302	4.50	24	66	6	DMN308700302	8.70	47	89	10
DMN304600302	4.60	24	66	6	DMN308800302	8.80	47	89	10
DMN304650302	4.65	24	66	6	DMN308900302	8.90	47	89	10
DMN304700302	4.70	24	66	6	DMN309000302	9.00	47	89	10
DMN304760302	4.76(3/16")	24	66	6	DMN309100302	9.10	47	89	10
DMN304800302	4.80	28	66	6	DMN309200302	9.20	47	89	10
DMN304900302	4.90	28	66	6	DMN309250302	9.25	47	89	10
DMN305000302	5.00	28	66	6	DMN309300302	9.30	47	89	10
DMN305100302	5.10	28	66	6	DMN309400302	9.40	47	89	10
DMN305200302	5.20	28	66	6	DMN309500302	9.50	47	89	10
DMN305300302	5.30	28	66	6	DMN309520302	9.52(3/8")	47	89	10
DMN305400302	5.40	28	66	6	DMN309600302	9.60	47	89	10
DMN305500302	5.50	28	66	6	DMN309700302	9.70	47	89	10
DMN305560302	5.56(7/32")	28	66	6	DMN309800302	9.80	47	89	10
DMN305600302	5.60	28	66	6	DMN309900302	9.90	47	89	10
DMN305700302	5.70	28	66	6	DMN310000302	10.00	47	89	10
DMN305800302	5.80	28	66	6	DMN310200302	10.20	55	102	12
DMN305900302	5.90	28	66	6	DMN310500302	10.50	55	102	12
DMN306000302	6.00	28	66	6	DMN310700302	10.70	55	102	12
DMN306100302	6.10	34	79	8	DMN311000302	11.00	55	102	12
DMN306200302	6.20	34	79	8	DMN311200302	11.20	55	102	12
DMN306300302	6.30	34	79	8	DMN311500302	11.50	55	102	12
DMN306350302	6.35(1/4")	34	79	8	DMN311700302	11.70	55	102	12
DMN306400302	6.40	34	79	8	DMN312000302	12.00	55	102	12
DMN306500302	6.50	34	79	8	DMN312500302	12.50	60	107	14
DMN306600302	6.60	34	79	8	DMN312700302	12.70(1/2)	60	107	14
DMN306700302	6.70	34	79	8	DMN313000302	13.00	60	107	14
DMN306800302	6.80	34	79	8	DMN313500302	13.50	60	107	14
DMN306900302	6.90	34	79	8	DMN313700302	13.70	60	107	14
DMN307000302	7.00	34	79	8	DMN314000302	14.00	60	107	14
DMN307100302	7.10	41	79	8	DMN314500302	14.50	65	115	16
DMN307140302	7.14(9/32")	41	79	8	DMN314700302	14.70	65	115	16
DMN307200302	7.20	41	79	8	DMN315000302	15.00	65	115	16
DMN307300302	7.30	41	79	8	DMN315500302	15.50	65	115	16
DMN307400302	7.40	41	79	8	DMN315700302	15.70	65	115	16
DMN307500302	7.50	41	79	8	DMN316000302	16.00	65	115	16
DMN307600302	7.60	41	79	8	DMN318000302	18.00	73	123	18
DMN307700302	7.70	41	79	8	DMN319000302	19.00	79	131	20
DMN307800302	7.80	41	79	8	DMN320000302	20.00	79	131	20
DMN307900302	7.90	41	79	8					
DMN307940302	7.94(5/16")	41	79	8					
DMN308000302	8.00	41	79	8					
DMN308100302	8.10	47	89	10					

## Recommended Cutting Conditions

### DMC Series (Internal Coolant)

Material	Stainless Steel				Titanium Alloy		Nickel Alloy		Carbon Steel / Alloy Steel	
Hardness	< HRC 20		≥ HRC 20		HRC 33 ~ 45		HRC 33 ~ 45		< HRC 35	
VC	60 ~ 100 m/min		40 ~ 80 m/min		20 ~ 40 m/min		18 ~ 30 m/min		60 ~ 100 m/min	
Dia (mm)	RPM	Feed (mm/rev)	RPM	Feed (mm/rev)	RPM	Feed (mm/rev)	RPM	Feed (mm/rev)	RPM	Feed (mm/rev)
4	4800 ~ 8000	0.06 ~ 0.11	3200 ~ 6400	0.06 ~ 0.11	1600 ~ 3200	0.05 ~ 0.08	1400 ~ 2400	0.05 ~ 0.08	4800 ~ 8000	0.07 ~ 0.12
6	3200 ~ 5300	0.09 ~ 0.17	2100 ~ 4200	0.09 ~ 0.17	1000 ~ 2100	0.07 ~ 0.12	1000 ~ 1600	0.07 ~ 0.12	3200 ~ 5300	0.11 ~ 0.18
8	2400 ~ 4000	0.12 ~ 0.22	1600 ~ 3200	0.12 ~ 0.22	800 ~ 1600	0.10 ~ 0.16	700 ~ 1200	0.10 ~ 0.16	2400 ~ 4000	0.14 ~ 0.24
10	1900 ~ 3200	0.17 ~ 0.28	1300 ~ 2500	0.17 ~ 0.28	600 ~ 1300	0.12 ~ 0.20	600 ~ 1000	0.12 ~ 0.20	1900 ~ 3200	0.18 ~ 0.30
12	1600 ~ 2700	0.19 ~ 0.33	1000 ~ 2100	0.19 ~ 0.33	500 ~ 1100	0.14 ~ 0.24	500 ~ 800	0.14 ~ 0.24	1600 ~ 2700	0.21 ~ 0.36
16	1200 ~ 2000	0.22 ~ 0.32	800 ~ 1600	0.22 ~ 0.32	400 ~ 800	0.19 ~ 0.32	400 ~ 600	0.19 ~ 0.32	1200 ~ 2000	0.28 ~ 0.40
20	1000 ~ 1600	0.28 ~ 0.40	600 ~ 1300	0.28 ~ 0.40	300 ~ 600	0.24 ~ 0.40	300 ~ 500	0.24 ~ 0.40	1000 ~ 1600	0.35 ~ 0.50

### DMN Series (External Coolant)

Material	Stainless Steel				Titanium Alloy		Nickel Alloy		Carbon Steel / Alloy Steel	
Hardness	< HRC 20		≥ HRC 20		HRC 33 ~ 45		HRC 33 ~ 45		< HRC 35	
VC	60 ~ 100 m/min		40 ~ 80 m/min		20 ~ 40 m/min		18 ~ 30 m/min		60 ~ 100 m/min	
Dia (mm)	RPM	Feed (mm/rev)	RPM	Feed (mm/rev)	RPM	Feed (mm/rev)	RPM	Feed (mm/rev)	RPM	Feed (mm/rev)
4	4800 ~ 8000	0.05 ~ 0.08	3200 ~ 6400	0.05 ~ 0.08	1600 ~ 3200	0.05 ~ 0.07	1400 ~ 2400	0.05 ~ 0.07	4800 ~ 8000	0.06 ~ 0.10
6	3200 ~ 5300	0.08 ~ 0.12	2100 ~ 4200	0.08 ~ 0.12	1000 ~ 2100	0.06 ~ 0.11	1000 ~ 1600	0.06 ~ 0.11	3200 ~ 5300	0.09 ~ 0.15
8	2400 ~ 4000	0.10 ~ 0.16	1600 ~ 3200	0.10 ~ 0.16	800 ~ 1600	0.09 ~ 0.14	700 ~ 1200	0.09 ~ 0.14	2400 ~ 4000	0.12 ~ 0.20
10	1900 ~ 3200	0.13 ~ 0.20	1300 ~ 2500	0.13 ~ 0.20	600 ~ 1300	0.11 ~ 0.18	600 ~ 1000	0.11 ~ 0.18	1900 ~ 3200	0.15 ~ 0.25
12	1600 ~ 2700	0.15 ~ 0.24	1000 ~ 2100	0.15 ~ 0.24	500 ~ 1100	0.13 ~ 0.22	500 ~ 800	0.13 ~ 0.22	1600 ~ 2700	0.18 ~ 0.30
16	1200 ~ 2000	0.20 ~ 0.32	800 ~ 1600	0.20 ~ 0.32	400 ~ 800	0.17 ~ 0.29	400 ~ 600	0.17 ~ 0.29	1200 ~ 2000	0.24 ~ 0.40
20	1000 ~ 1600	0.25 ~ 0.40	600 ~ 1300	0.25 ~ 0.40	300 ~ 600	0.22 ~ 0.36	300 ~ 500	0.22 ~ 0.36	1000 ~ 1600	0.30 ~ 0.50

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