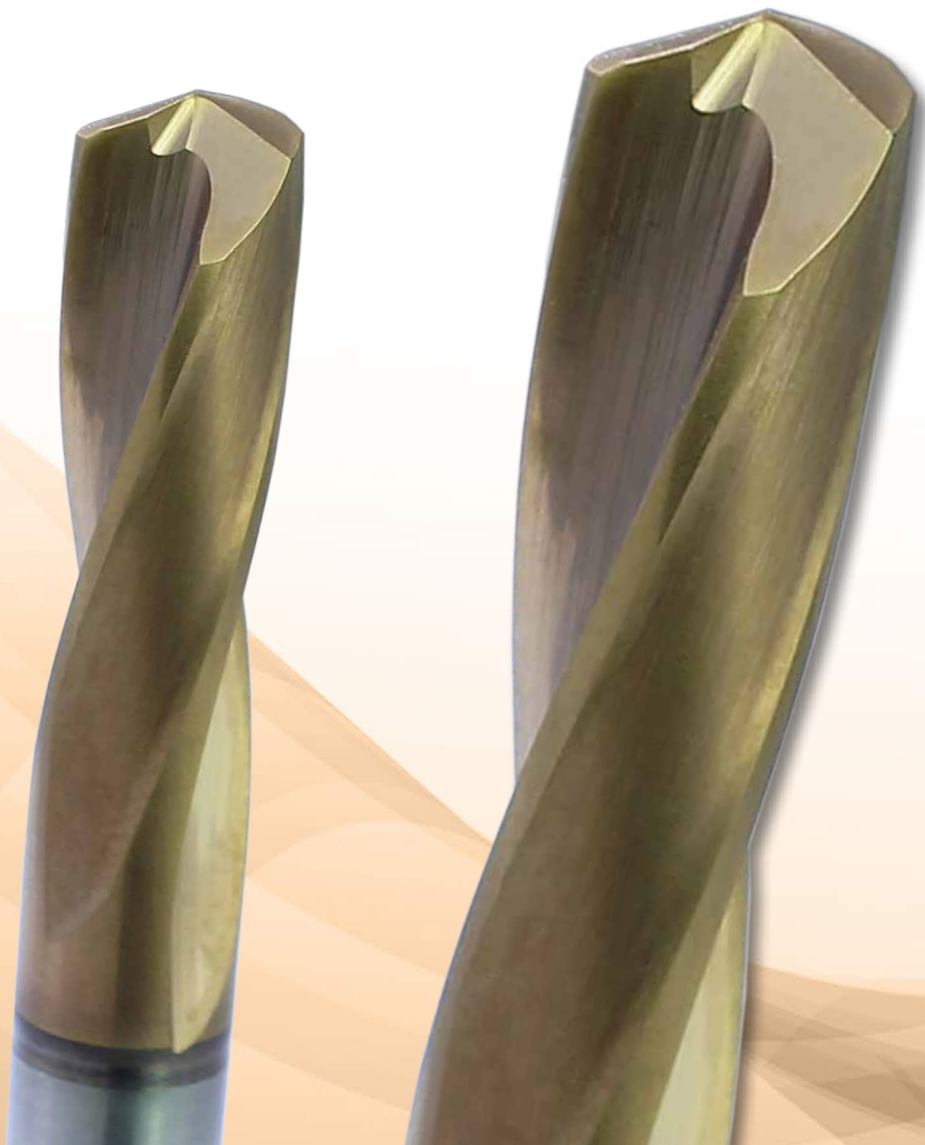


DH Solid Carbide Drill for Superalloy & Hardened Steel , HRC 45~60

P	M	K	N	S	H
○	○	○		●	●

- *Suitable for Superalloy and Hardened steel machining.*
- *Special RX geometry design for tip protecting.*
- *Low helix and special coating with efficiency cutting ability.*



DHN Solid Carbide Drills

Recommended Cutting Conditions

Material	Hardened Steel / Pre-Hardened Steel						Nickel Alloy	
Hardness	HRC 40 ~ 45		HRC 45 ~ 50		HRC 50 ~ 60		HRC 38 ~ 45	
VC	30 ~ 50 m/min		20 ~ 30 m/min		20 ~ 30 m/min		15 ~ 30 m/min	
Dia (mm)	RPM	Feed(mm/rev)	RPM	Feed(mm/rev)	RPM	Feed(mm/rev)	RPM	Feed(mm/rev)
4	3200	0.04 ~ 0.08	2000	0.04 ~ 0.08	2000	0.03 ~ 0.06	1600	0.04 ~ 0.08
5	2500	0.05 ~ 0.10	1600	0.05 ~ 0.10	1600	0.04 ~ 0.08	1300	0.05 ~ 0.10
6	2100	0.06 ~ 0.12	1300	0.06 ~ 0.12	1300	0.05 ~ 0.09	1100	0.06 ~ 0.12
7	1800	0.07 ~ 0.14	1100	0.07 ~ 0.14	1100	0.06 ~ 0.11	900	0.07 ~ 0.14
8	1600	0.08 ~ 0.16	1000	0.08 ~ 0.16	1000	0.06 ~ 0.12	800	0.08 ~ 0.16
9	1400	0.09 ~ 0.18	900	0.09 ~ 0.18	900	0.07 ~ 0.14	700	0.09 ~ 0.18
10	1300	0.10 ~ 0.20	800	0.10 ~ 0.20	800	0.08 ~ 0.15	600	0.10 ~ 0.20
11	1150	0.11 ~ 0.22	720	0.11 ~ 0.22	720	0.09 ~ 0.17	600	0.11 ~ 0.22
12	1100	0.12 ~ 0.24	700	0.12 ~ 0.24	700	0.10 ~ 0.18	500	0.12 ~ 0.24

Cutting Test

Material	Diameter	Coolant
Steel HRC 50	Ø6 mm	External

VC	S	Vf	fn	ap
30 m/min	1592 rpm	76 mm/min	0.05 mm/rev	6 mm



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