

Features

- Multiple application
- Counter boring, Slope, Curve, Cross hole, Thin plate
- Pre-hole
- Hole correction
- Reduce manufacturing procedure
- 適用多種加工場景
- 搪孔加工、斜面鑽孔、曲面鑽孔、跨孔鑽孔、薄板鑽孔
- 導引孔加工
- 孔位校正
- 有效減少加工程序

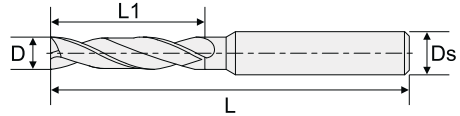
DFN3 - 3xD (with Flat tip)

平底整體硬質合金外冷鑽



Product Specs

- 3xD Cutting depth
- Reinforced Shank
- Flat tip
- External Coolant
- SINIX Coating
- Tolerance h8
- FX Design
- For Steel, Alloy Steel, Stainless Steel (Martensitic), Cast iron, Non-ferrous metal.



Unit:mm

Order No. 訂購編碼	D	L1	L	Ds
DFN303000342	3.00	20	60	4
DFN303100342	3.10	20	60	4
DFN303170342	3.17(1/8")	20	60	4
DFN303200342	3.20	20	60	4
DFN303250342	3.25(5/39")	20	60	4
DFN303300342	3.30	20	60	4
DFN303400342	3.40	20	60	4
DFN303500342	3.50	20	60	4
DFN303600342	3.60	20	60	4
DFN303700342	3.70	20	60	4
DFN303800342	3.80	24	60	4
DFN303900342	3.90	24	60	4
DFN303970342	3.97(5/32")	24	60	4
DFN303000302	3.00	20	62	6
DFN303100302	3.10	20	62	6
DFN303200302	3.20	20	62	6
DFN303250302	3.25(5/39")	20	62	6
DFN303300302	3.30	20	62	6
DFN303400302	3.40	20	62	6
DFN303500302	3.50	20	62	6
DFN303600302	3.60	20	62	6
DFN303700302	3.70	20	62	6
DFN303800302	3.80	24	66	6
DFN303900302	3.90	24	66	6
DFN303970302	3.97(5/32")	24	66	6
DFN304000302	4.00	24	66	6
DFN304100302	4.10	24	66	6
DFN304200302	4.20	24	66	6
DFN304300302	4.30	24	66	6
DFN304400302	4.40	24	66	6
DFN304500302	4.50	24	66	6
DFN304600302	4.60	24	66	6
DFN304650302	4.65(13/71")	24	66	6
DFN304700302	4.70	24	66	6
DFN304800302	4.80	28	66	6
DFN304900302	4.90	28	66	6
DFN305000302	5.00	28	66	6
DFN305100302	5.10	28	66	6
DFN305200302	5.20	28	66	6
DFN305300302	5.30	28	66	6
DFN305400302	5.40	28	66	6
DFN305500302	5.50	28	66	6
DFN305560302	5.56(7/32")	28	66	6
DFN305600302	5.60	28	66	6
DFN305700302	5.70	28	66	6
DFN305800302	5.80	28	66	6
DFN305900302	5.90	28	66	6

Order No. 訂購編碼	D	L1	L	Ds
DFN306000302	6.00	28	66	6
DFN306100302	6.10	34	79	8
DFN306200302	6.20	34	79	8
DFN306300302	6.30	34	79	8
DFN306350302	6.35	34	79	8
DFN306400302	6.40	34	79	8
DFN306500302	6.50	34	79	8
DFN306600302	6.60	34	79	8
DFN306700302	6.70	34	79	8
DFN306800302	6.80	34	79	8
DFN306900302	6.90	34	79	8
DFN307000302	7.00	34	79	8
DFN307100302	7.10	41	79	8
DFN307200302	7.20	41	79	8
DFN307300302	7.30	41	79	8
DFN307400302	7.40	41	79	8
DFN307500302	7.50	41	79	8
DFN307600302	7.60	41	79	8
DFN307700302	7.70	41	79	8
DFN307800302	7.80	41	79	8
DFN307900302	7.90	41	79	8
DFN308000302	8.00	41	79	8
DFN308100302	8.10	47	89	10
DFN308200302	8.20	47	89	10
DFN308300302	8.30	47	89	10
DFN308400302	8.40	47	89	10
DFN308500302	8.50	47	89	10
DFN308600302	8.60	47	89	10
DFN308700302	8.70	47	89	10
DFN308800302	8.80	47	89	10
DFN308900302	8.90	47	89	10
DFN309000302	9.00	47	89	10
DFN309100302	9.10	47	89	10
DFN309200302	9.20	47	89	10
DFN309250302	9.25(23/64")	47	89	10
DFN309300302	9.30	47	89	10
DFN309400302	9.40	47	89	10
DFN309500302	9.50	47	89	10
DFN309600302	9.60	47	89	10
DFN309700302	9.70	47	89	10
DFN309800302	9.80	47	89	10
DFN309900302	9.90	47	89	10

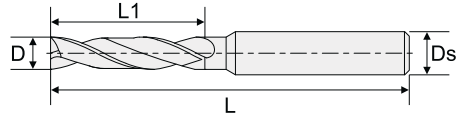
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Unit:mm

Order No. 訂購編碼	D	L1	L	Ds
DFN310000302	10.00	47	89	10
DFN310100302	10.10	55	102	12
DFN310200302	10.20	55	102	12
DFN310300302	10.30	55	102	12
DFN310400302	10.40	55	102	12
DFN310500302	10.50	55	102	12
DFN310600302	10.60	55	102	12
DFN310700302	10.70	55	102	12
DFN310800302	10.80	55	102	12
DFN310900302	10.90	55	102	12
DFN311000302	11.00	55	102	12
DFN311100302	11.10	55	102	12
DFN311200302	11.20	55	102	12
DFN311300302	11.30	55	102	12
DFN311400302	11.40	55	102	12
DFN311500302	11.50	55	102	12
DFN311600302	11.60	55	102	12
DFN311700302	11.70	55	102	12
DFN311800302	11.80	55	102	12
DFN311900302	11.90	55	102	12
DFN312000302	12.00	55	102	12
DFN312100302	12.10	60	107	14
DFN312200302	12.20	60	107	14
DFN312300302	12.30	60	107	14
DFN312400302	12.40	60	107	14
DFN312500302	12.50	60	107	14
DFN312600302	12.60	60	107	14
DFN312700302	12.70(1/2")	60	107	14
DFN312800302	12.80	60	107	14
DFN312900302	12.90	60	107	14
DFN313000302	13.00	60	107	14
DFN313200302	13.20	60	107	14
DFN313300302	13.30	60	107	14
DFN313500302	13.50	60	107	14
DFN313700302	13.70	60	107	14
DFN313800302	13.80	60	107	14
DFN314000302	14.00	60	107	14
DFN314200302	14.20	65	115	16
DFN314300302	14.30	65	115	16
DFN314400302	14.40	65	115	16
DFN314500302	14.50	65	115	16
DFN314700302	14.70	65	115	16

Order No. 訂購編碼	D	L1	L	Ds
DFN315000302	15.00	65	115	16
DFN315200302	15.20	65	115	16
DFN315500302	15.50	65	115	16
DFN315600302	15.60	65	115	16
DFN315700302	15.70	65	115	16
DFN315800302	15.80	65	115	16
DFN316000302	16.00	65	115	16
DFN316500302	16.50	73	123	18
DFN317000302	17.00	73	123	18
DFN317500302	17.50	73	123	18
DFN318000302	18.00	73	123	18
DFN318500302	18.50	79	131	20
DFN319000302	19.00	79	131	20
DFN319500302	19.50	79	131	20
DFN320000302	20.00	79	131	20

Solid Carbide Drills

DFN Series (External Coolant)

Work Material		Drill Diameter	Ø3-6mm		Ø6.1~10mm		Ø10.1-16mm	
		Hardness	Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)	Cutting Speed (m/min)	Feed (mm/rev)
P	Mild Steel	(<180HB)	40~70	0.1~0.2	55~85	0.15~0.3	60~100	0.25~0.4
	Carbon Steel	(180~280HB)	35~65	0.1~0.2	50~80	0.15~0.3	55~90	0.25~0.4
	Alloy Steel	(280~350HB)	30~60	0.08~0.18	40~75	0.15~0.27	50~85	0.22~0.35
M	Stainless Steel	(<200HB)	20~40	0.06~0.15	25~50	0.1~0.25	30~60	0.2~0.3
K	Cast Iron	(<350Mpa)	40~60	0.1~0.2	50~75	0.15~0.3	55~85	0.25~0.4
	Ductile Cast Iron	(<450Mpa)	35~55	0.1~0.2	45~70	0.15~0.3	50~80	0.25~0.4
N	Aluminum <12% Si	-	60~100	0.1~0.25	65~115	0.15~0.35	70~130	0.3~0.45
	Aluminum >12% Si	-	50~90	0.1~0.25	60~110	0.15~0.35	65~120	0.3~0.45
S	Heat Resistant Alloy	-	15~30	0.02~0.08	20~40	0.04~0.1	25~45	0.06~0.12
H	Hardened Material	40~60HRC	10~25	0.02~0.08	15~35	0.04~0.1	20~40	0.06~0.12

Warning :For slope drilling, please adjust cutting data according to inclined angle

1. For inclined angle under 20 degree, reduce the feed to 50%
2. For inclined angle between 20 to 50 degree, reduce the feed to 40%, and reduce rotation to 70%
3. For inclined angle between 50 to 65 degree, reduce the feed to 30%, and reduce rotation to 70%
4. Not recommend to side milling