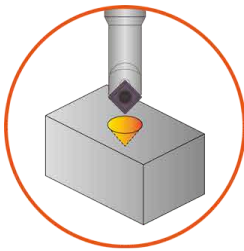
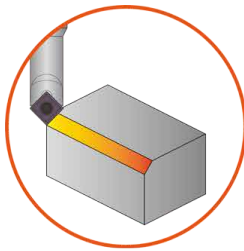


DTS Series

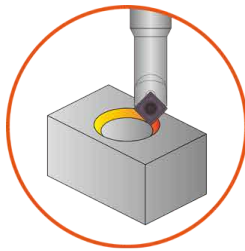
90° Indexable Spotting Drills



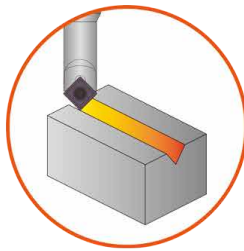
Spotting



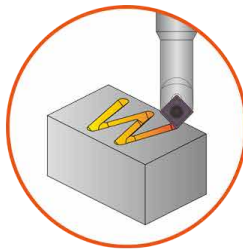
Chamfering



Countersinking



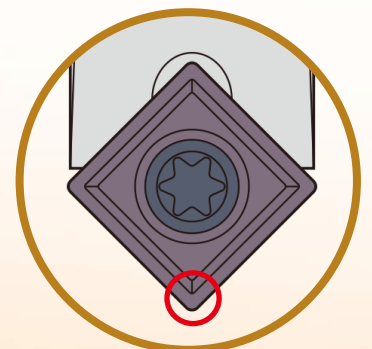
Grooving



Engraving

- **Multiple-function in one tool.**
- **3 or 4 cutting edges insert for better cost efficiency.**
- **Working size up to 20mm.**

| P | M | K | N | S | H |
|---|---|---|---|---|---|
| ● | ● | ● | ○ | ○ | ○ |

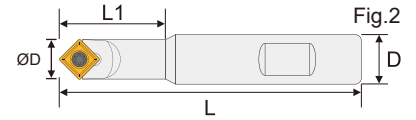
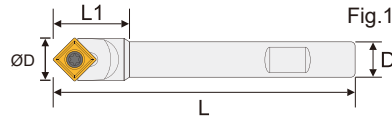


Radius protection design

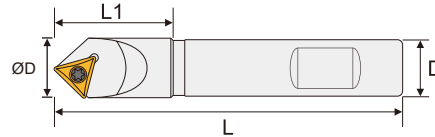
90° Indexable Spotting drill

DTS / SCM09T3, TCMX16T3

DTS Series



| Order No. | ØD | Flute (L1) | OAL (L) | Shank (Ds) | Degree | Fig | Insert |
|-----------------|--------|------------|---------|------------|--------|-----|----------|
| IDTS10100090-09 | 2 ~ 11 | 29 | 100 | 10 | 90° | 1 | SCMX09T3 |
| IDTS12100090-09 | 2 ~ 11 | 29 | 100 | 12 | 90° | 2 | |
| IDTS16100090-09 | 2 ~ 11 | 29 | 100 | 16 | 90° | 2 | |
| IDTS16130090-09 | 2 ~ 11 | 29 | 130 | 16 | 90° | 2 | |



| Order No. | ØD | Flute (L1) | OAL (L) | Shank (Ds) | Degree | Insert |
|-----------------|--------|------------|---------|------------|--------|----------|
| IDTS20120090-16 | 3 ~ 20 | 42 | 120 | 20 | 90° | TCMX16T3 |

| Insert | Order No. | Recommend working materials | | | | | | Figure |
|--------|----------------------|-----------------------------|---|---|---|---|---|--------|
| | | P | M | K | N | S | H | |
| | SCMX09T304-SP-CX31NA | ● | ● | ● | ○ | ○ | ○ | |
| | TCMX16T308-MP-CX31NA | ● | ● | ● | ○ | ○ | ○ | |

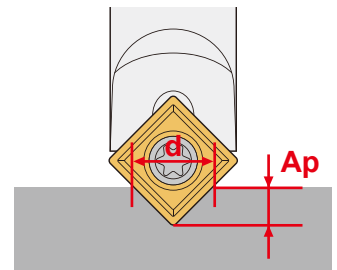
Recommended Cutting Conditions

Spotting

| Material | VC (m/min) | Fr (mm/rev) |
|--------------------------|------------|-------------|
| P Carbon steel | 60~220 | 0.05~0.10 |
| Alloy steel | 50~180 | 0.04~0.08 |
| M Stainless steel | 30~120 | 0.03~0.06 |
| K Cast iron | 40~130 | 0.05~0.10 |
| H Pre-hardened | 20~60 | 0.03~0.08 |

Chamfering / Countersinking / Grooving

| Material | VC (m/min) | Fr (mm/rev) |
|--------------------------|------------|-------------|
| P Carbon steel | 60~270 | 0.15~0.24 |
| Alloy steel | 50~220 | 0.12~0.20 |
| M Stainless steel | 35~120 | 0.10~0.20 |
| K Cast iron | 60~220 | 0.15~0.25 |
| H Pre-hardened | 20~60 | 0.03~0.08 |



$$d \cong (A_p + 0.3) \times 2$$

$$S = \frac{V_c \times 1000}{d \times \pi}$$

Working Demonstration

DTS Indexable 90° Spotting drill



| Cutting parameter | |
|-------------------|---|
| Material | SUS304 |
| RPM | 4500 rpm |
| Feed | 800 mm |
| Process | Porcess spotting and chamfering by one tool |

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