

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 flutes design and excellent polishing to enable efficiency chips evacuation.*



WINSTAR CUTTING TECHNOLOGIES CORP.

No. 10, Gongye 6th Road, Tainan Technology Industrial Park,
Tainan City 709, Taiwan

TEL : +886-6-3840386

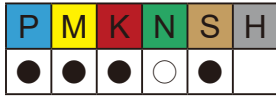
FAX : +886-6-3840387

www.winstarcutting.com

info@winstarcutting.com

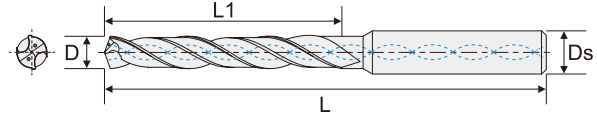
WD1819E

DMC Solid Carbide Drills - 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
DMC04000302	4.00	24	66	6
DMC04200302	4.20	24	66	6
DMC04500302	4.50	24	66	6
DMC04600302	4.60	24	66	6
DMC04650302	4.65	24	66	6
DMC04800302	4.80	28	66	6
DMC05000302	5.00	28	66	6
DMC05500302	5.50	28	66	6
DMC05560302	5.56(7/32")	28	66	6
DMC05700302	5.70	28	66	6
DMC05800302	5.80	28	66	6
DMC06000302	6.00	28	66	6
DMC06350302	6.35(1/4")	34	79	8
DMC06500302	6.50	34	79	8
DMC06800302	6.80	34	79	8
DMC07000302	7.00	34	79	8
DMC07400302	7.40	41	79	8
DMC07500302	7.50	41	79	8
DMC07800302	7.80	41	79	8
DMC08000302	8.00	41	79	8
DMC08500302	8.50	47	89	10
DMC08800302	8.80	47	89	10
DMC09000302	9.00	47	89	10
DMC09250302	9.25	47	89	10
DMC09300302	9.30	47	89	10
DMC09500302	9.50	47	89	10
DMC09800302	9.80	47	89	10
DMC10000302	10.00	47	89	10
DMC10200302	10.20	55	102	12
DMC10500302	10.50	55	102	12
DMC10700302	10.70	55	102	12
DMC11000302	11.00	55	102	12
DMC11200302	11.20	55	102	12
DMC11500302	11.50	55	102	12
DMC11700302	11.70	55	102	12

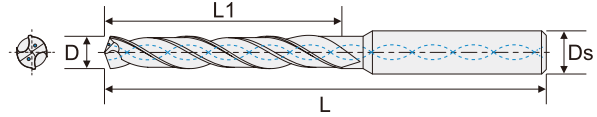
Order No.	D	L1	L	Ds
DMC12000302	12.00	55	102	12
DMC12500302	12.50	60	107	14
DMC12700302	12.70	60	107	14
DMC13000302	13.00	60	107	14
DMC13500302	13.50	60	107	14
DMC13700302	13.70	60	107	14
DMC14000302	14.00	60	107	14
DMC14500302	14.50	65	115	16
DMC14700302	14.70	65	115	16
DMC15000302	15.00	65	115	16
DMC15500302	15.50	65	115	16
DMC15700302	15.70	65	115	16
DMC16000302	16.00	65	115	16
DMC18000302	18.00	73	123	18
DMC19000302	19.00	79	131	20
DMC20000302	20.00	79	131	20

DMC Solid Carbide Drills - 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
DMC04000502	4.00	36	74	6
DMC04200502	4.20	36	74	6
DMC04500502	4.50	36	74	6
DMC04600502	4.60	36	74	6
DMC04650502	4.65	36	74	6
DMC04800502	4.80	44	82	6
DMC05000502	5.00	44	82	6
DMC05500502	5.50	44	82	6
DMC05550502	5.55	44	82	6
DMC05800502	5.80	44	82	6
DMC06000502	6.00	44	82	6
DMC06500502	6.50	53	91	8
DMC06800502	6.80	53	91	8
DMC07000502	7.00	53	91	8
DMC07400502	7.40	53	91	8
DMC07500502	7.50	53	91	8
DMC07800502	7.80	53	91	8
DMC08000502	8.00	53	91	8
DMC08500502	8.50	61	103	10
DMC08800502	8.80	61	103	10
DMC09000502	9.00	61	103	10
DMC09000502	9.25	61	103	10
DMC09300502	9.30	61	103	10
DMC09500502	9.50	61	103	10
DMC09800502	9.80	61	103	10
DMC10000502	10.00	61	103	10
DMC10200502	10.20	71	118	12
DMC10500502	10.50	71	118	12
DMC10700502	10.70	71	118	12
DMC11000502	11.00	71	118	12
DMC11200502	11.20	71	118	12
DMC11500502	11.50	71	118	12
DMC11700502	11.70	71	118	12

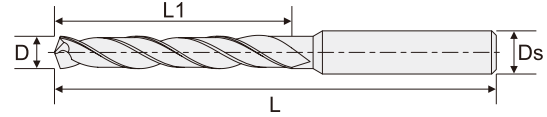
Order No.	D	L1	L	Ds
DMC12000502	12.00	71	118	12
DMC12500502	12.50	77	124	14
DMC12700502	12.70	77	124	14
DMC13000502	13.00	77	124	14
DMC13500502	13.50	77	124	14
DMC13700502	13.70	77	124	14
DMC14000502	14.00	77	124	14
DMC14500502	14.50	83	133	16
DMC14700502	14.70	83	133	16
DMC15000502	15.00	83	133	16
DMC15500502	15.50	83	133	16
DMC15700502	15.70	83	133	16
DMC16000502	16.00	83	133	16
DMC18000502	18.00	93	143	18
DMC19000502	19.00	101	153	20
DMC20000502	20.00	101	153	20

DMN Solid Carbide Drills - 3xD (External Coolant)



Product Specs

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



Unit:mm

Order No.	D	L1	L	Ds	Order No.	D	L1	L	Ds
DMN04000302	4.00	24	66	6	DMN09800302	9.80	47	89	10
DMN04200302	4.20	24	66	6	DMN10000302	10.00	47	89	10
DMN04500302	4.50	24	66	6	DMN10200302	10.20	55	102	12
DMN04600302	4.60	24	66	6	DMN10500302	10.50	55	102	12
DMN04650302	4.65	24	66	6	DMN10700302	10.70	55	102	12
DMN04800302	4.80	28	66	6	DMN11000302	11.00	55	102	12
DMN05000302	5.00	28	66	6	DMN11200302	11.20	55	102	12
DMN05500302	5.50	28	66	6	DMN11500302	11.50	55	102	12
DMN05560302	5.56(7/32")	28	66	6	DMN11700302	11.70	55	102	12
DMN05700302	5.70	28	66	6	DMN12000302	12.00	55	102	12
DMN05800302	5.80	28	66	6	DMN12500302	12.50	60	107	14
DMN06000302	6.00	28	66	6	DMN12700302	12.70	60	107	14
DMN06350302	6.35(1/4")	34	79	8	DMN13000302	13.00	60	107	14
DMN06500302	6.50	34	79	8	DMN13500302	13.50	60	107	14
DMN06800302	6.80	34	79	8	DMN13700302	13.70	60	107	14
DMN07000302	7.00	34	79	8	DMN14000302	14.00	60	107	14
DMN07400302	7.40	41	79	8	DMN14500302	14.50	65	115	16
DMN07500302	7.50	41	79	8	DMN14700302	14.70	65	115	16
DMN07800302	7.80	41	79	8	DMN15000302	15.00	65	115	16
DMN08000302	8.00	41	79	8	DMN15500302	15.50	65	115	16
DMN08500302	8.50	47	89	10	DMN15700302	15.70	65	115	16
DMN08800302	8.80	47	89	10	DMN16000302	16.00	65	115	16
DMN09000302	9.00	47	89	10	DMN18000302	18.00	73	123	18
DMN09250302	9.25	47	89	10	DMN19000302	19.00	79	131	20
DMN09300302	9.30	47	89	10	DMN20000302	20.00	79	131	20
DMN09500302	9.50	47	89	10					

Recommended Cutting Conditions - DMC, DMN

Material	Stainless Steel				Titanium Alloy		Nickel Alloy	
	≤ HB 200		> HB 200		HB 280 ~ 340		HRC 38 ~ 45	
VC	60 ~ 100 m/min		40 ~ 80 m/min		20 ~ 40 m/min		10 ~ 30 m/min	
Dia (mm)	RPM	Feed(mm/rev)	RPM	Feed(mm/rev)	RPM	Feed(mm/rev)	RPM	Feed(mm/rev)
4	6400	0.06 ~ 0.12	4800	0.06 ~ 0.12	3200	0.05 ~ 0.08	1600	0.05 ~ 0.08
6	4200	0.09 ~ 0.18	3200	0.09 ~ 0.18	2100	0.07 ~ 0.12	1100	0.07 ~ 0.12
8	3200	0.12 ~ 0.24	2400	0.12 ~ 0.24	1600	0.10 ~ 0.16	800	0.10 ~ 0.16
10	2500	0.17 ~ 0.27	1900	0.17 ~ 0.27	1300	0.12 ~ 0.20	640	0.12 ~ 0.20
12	2100	0.19 ~ 0.30	1600	0.19 ~ 0.30	1100	0.14 ~ 0.24	530	0.14 ~ 0.24
16	1600	0.22 ~ 0.32	1200	0.22 ~ 0.32	800	0.19 ~ 0.32	400	0.19 ~ 0.32
20	1300	0.28 ~ 0.40	1000	0.28 ~ 0.40	600	0.24 ~ 0.40	320	0.24 ~ 0.40

* The feed rate of DMC can increase 20% than DMN.