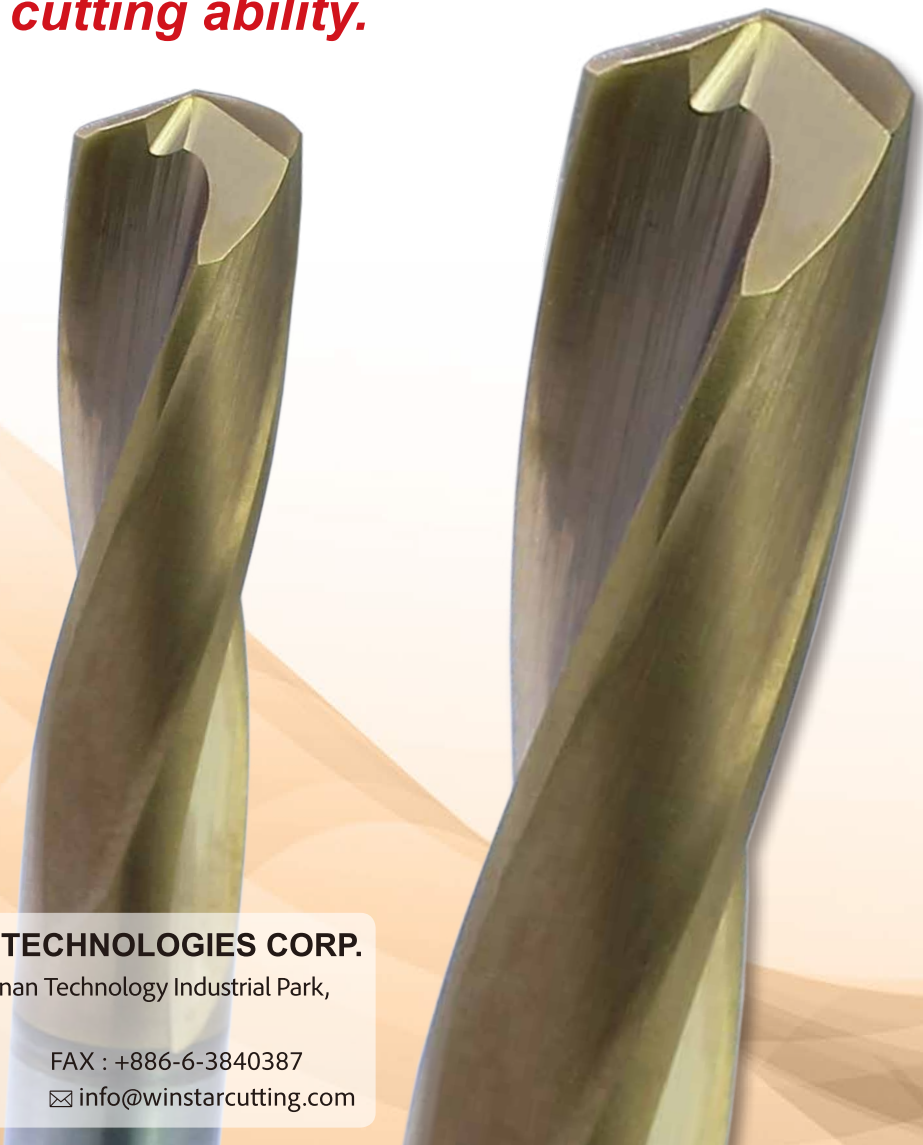


DH Solid Carbide Drill for Hardened Steel , HRC 45~60

P	M	K	N	S	H
○	○	○	○	●	●

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



WINSTAR CUTTING TECHNOLOGIES CORP.

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

TEL : +886-6-3840386

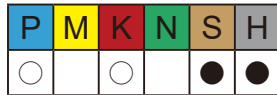
FAX : +886-6-3840387

www.winstarcutting.com

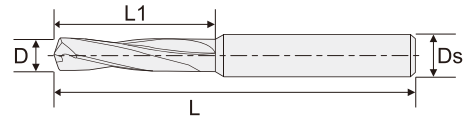
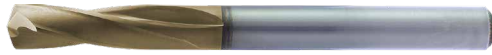
info@winstarcutting.com

WD1821E

DH Solid Carbide Drills - 3×D (External Coolant)



- Reinforced Shank
- 140° Tip Angle
- Helix : 12° ~ 20°
- SINIX Plus Coating
- Tolerance h8
- Double Margins
- RX Tip Design
- For Hardened steel and Pre-hardness steel.



Unit:mm

Order No.	D	L1	L	Ds	Order No.	D	L1	L	Ds
DHN04000307	4.00	24	66	6	DHN08000307	8.00	41	79	8
DHN04200307	4.20	24	66	6	DHN08500307	8.50	47	89	10
DHN04500307	4.50	24	66	6	DHN08800307	8.80	47	89	10
DHN04600307	4.60	24	66	6	DHN09000307	9.00	47	89	10
DHN04650307	4.65	24	66	6	DHN09250307	9.25	47	89	10
DHN04800307	4.80	28	66	6	DHN09300307	9.30	47	89	10
DHN05000307	5.00	28	66	6	DHN09500307	9.50	47	89	10
DHN05500307	5.50	28	66	6	DHN09800307	9.80	47	89	10
DHN05560307	5.56(7/32")	28	66	6	DHN10000307	10.00	47	89	10
DHN05700307	5.70	28	66	6	DHN10200307	10.20	55	102	12
DHN05800307	5.80	28	66	6	DHN10500307	10.50	55	102	12
DHN06000307	6.00	28	66	6	DHN10700307	10.70	55	102	12
DHN06350307	6.35(1/4")	34	79	8	DHN11000307	11.00	55	102	12
DHN06500307	6.50	34	79	8	DHN11200307	11.20	55	102	12
DHN06800307	6.80	34	79	8	DHN11500307	11.50	55	102	12
DHN07000307	7.00	34	79	8	DHN11700307	11.70	55	102	12
DHN07400307	7.40	41	79	8	DHN12000307	12.00	55	102	12
DHN07500307	7.50	41	79	8					
DHN07800307	7.80	41	79	8					

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



Recommended Cutting Conditions

Material	Hardened Steel / Pre-Hardened Steel						Nickel Alloy	
	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