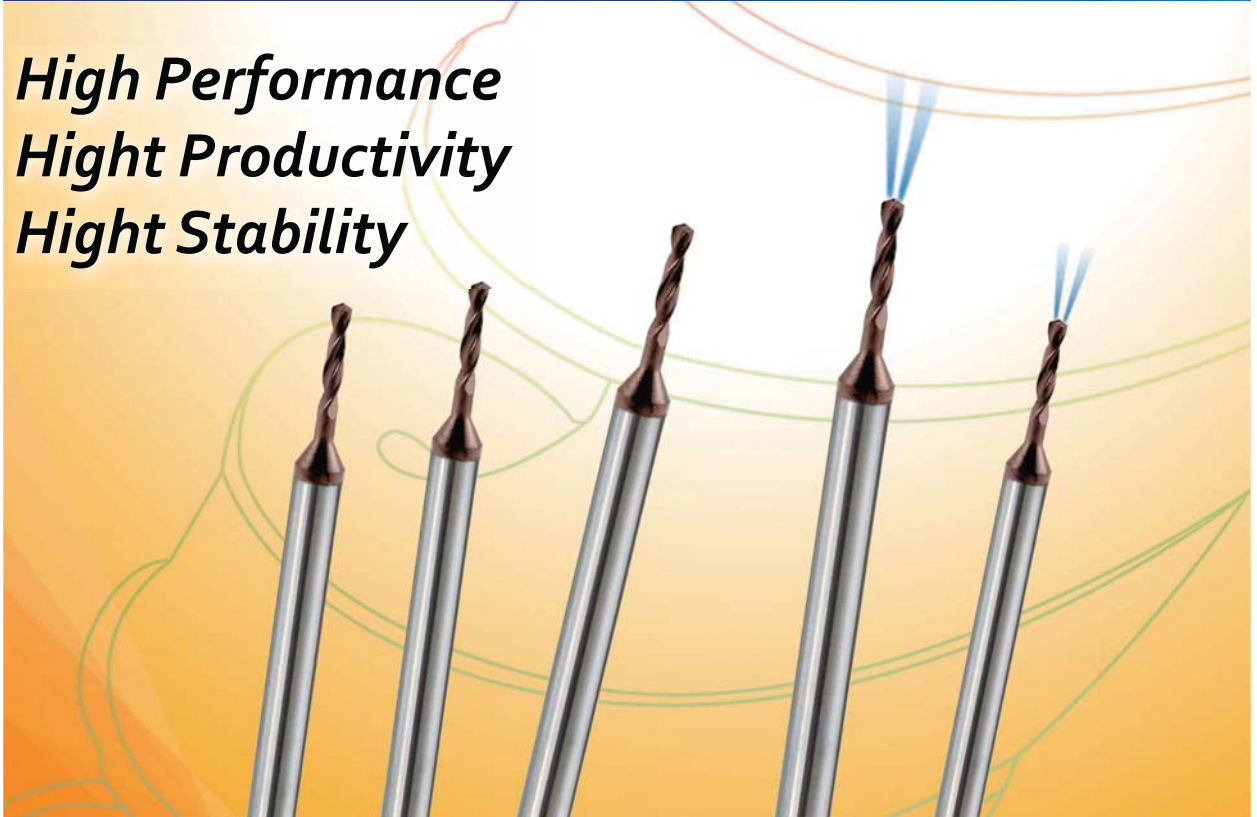


**High Performance**  
**High Productivity**  
**High Stability**



Solid Carbide Drills

## Features

- Internal coolant design
- Unique UNIX coating improves tool life
- Optimized flute improves drilling efficiency
- Customized available
- Diameter 0.2-3.9mm
- 高效內冷孔
- **UNIX** 鍍膜提升刀具壽命
- 優化排屑槽，提升刀具效能與壽命
- 提供客製化服務
- 尺寸範圍 0.2-3.9mm



# Solid Carbide Drills

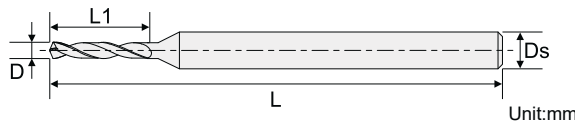
## DLN - 3xD (for Mini hole)

小孔用整體硬質合金外冷鑽



### Product Specs

- 3xD Cutting depth
- Reinforced Shank
- 130° Tip Angle
- External Coolant
- UNIX Coating
- Tolerance h8
- NX Design
- For Alloy Steel and Cast Iron.



Order No. 訂購編碼	D	L1	L	Ds
DLN00200301	0.20	1.5	38	3
DLN00300301	0.30	2	38	3
DLN00400301	0.40	3	38	3
DLN00500301	0.50	3	38	3
DLN00600301	0.60	3	38	3
DLN00700301	0.70	3	38	3
DLN00800301	0.80	4	38	3
DLN00900301	0.90	4	38	3
DLN01000301	1.00	4	38	3
DLN01100301	1.10	6	38	3
DLN01200301	1.20	6	38	3
DLN01300301	1.30	6	38	3
DLN01400301	1.40	6	38	3
DLN01500301	1.50	6	38	3
DLN01600301	1.60	8	38	3
DLN01700301	1.70	8	38	3
DLN01800301	1.80	8	38	3
DLN01900301	1.90	8	38	3
DLN02000301	2.00	8	38	3
DLN02100301	2.10	8	38	3
DLN02200301	2.20	8	38	3
DLN02300301	2.30	8	38	3
DLN02400301	2.40	8	38	3
DLN02500301	2.50	8	38	3
DLN02600301	2.60	8	38	3
DLN02700301	2.70	8	38	3
DLN02800301	2.80	8	38	3
DLN02900301	2.90	8	38	3

Order No. 訂購編碼	D	L1	L	Ds

Solid Carbide Drills

### DLC Series (Internal Coolant)

Work Material		Drill Diameter	Ø3-6mm		Ø6.1~10mm		Ø10.1-16mm	
		Hardness	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)
P	Mild Steel	(<180HB)	60~100	0.1~0.2	80~120	0.15~0.3	100~140	0.25~0.4
	Carbon Steel	(180~280HB)	60~90	0.1~0.2	80~110	0.15~0.3	100~130	0.25~0.4
	Alloy Steel	(280~350HB)	50~80	0.08~0.18	60~100	0.15~0.27	70~110	0.22~0.35
M	Stainless Steel	(<200HB)	30~50	0.06~0.15	40~70	0.1~0.25	50~90	0.2~0.3
K	Cast Iron	(<350Mpa)	70~100	0.1~0.2	80~120	0.15~0.3	90~140	0.25~0.4
	Ductile Cast Iron	(<450Mpa)	50~80	0.1~0.2	60~90	0.15~0.3	70~110	0.25~0.4
N	Aluminum <12% Si	-	70~120	0.1~0.25	80~140	0.15~0.35	90~160	0.3~0.45
	Aluminum >12% Si	-	60~100	0.1~0.25	70~120	0.15~0.35	90~140	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

### DLN Series (External Coolant)

Work Material		Drill Diameter	Ø3-6mm		Ø6.1~10mm		Ø10.1-16mm	
		Hardness	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)
P	Mild Steel	(<180HB)	35~60	0.1~0.2	45~75	0.15~0.3	50~85	0.25~0.4
	Carbon Steel	(180~280HB)	30~55	0.1~0.2	40~70	0.15~0.3	45~80	0.25~0.4
	Alloy Steel	(280~350HB)	25~50	0.08~0.18	35~65	0.15~0.27	40~75	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

Note: for DLN please use 3-6mm table, for smaller size please reduce 20%.