



## Features

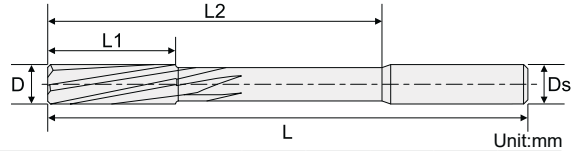
- Unique durable UNIX coating
- Specially for high accurate hole machining
- Superior hole surface finish
- Internal & external coolant available
- Customized available
- 高耐久 UNIX 鍍膜技術
- 專為高精度的孔加工設計
- 加工表面品質優異
- 內冷孔與外冷產品可供選擇
- 提供客製化服務





### Product Specs

- External
- Left Helix Angle
- UNIX Coating
- Tolerance h7
- Provide high degree of accuracy to leave smooth sides.
- For through hole using
- For Steel, Alloy Steel, Cast Iron, Aluminum Alloy.



Solid Carbide Reamers

Order No. 訂購編碼	D	L1	L2	L	Ds	F
DRN03000901	3.00	15	35	60	4	4
DRN03100901	3.10	15	35	60	4	4
DRN03200901	3.20	15	35	60	4	4
DRN03300901	3.30	15	35	60	4	4
DRN03400901	3.40	15	35	60	4	4
DRN03500901	3.50	18	35	60	4	4
DRN03600901	3.60	18	35	60	4	4
DRN03700901	3.70	18	35	60	4	4
DRN03800901	3.80	18	35	60	4	4
DRN03900901	3.90	18	35	60	4	4
DRN04000901	4.00	19	50	75	4	4
DRN04100901	4.10	19	50	75	6	4
DRN04200901	4.20	19	50	75	6	4
DRN04300901	4.30	19	50	75	6	4
DRN04400901	4.40	19	50	75	6	4
DRN04500901	4.50	21	50	75	6	4
DRN04600901	4.60	21	50	75	6	4
DRN04700901	4.70	21	50	75	6	4
DRN04800901	4.80	21	50	75	6	4
DRN04900901	4.90	21	50	75	6	4
DRN05000901	5.00	23	50	75	6	6
DRN05100901	5.10	23	50	75	6	6
DRN05200901	5.20	23	50	75	6	6
DRN05300901	5.30	23	50	75	6	6
DRN05400901	5.40	23	50	75	6	6
DRN05500901	5.50	26	50	75	6	6
DRN05600901	5.60	26	50	75	6	6
DRN05700901	5.70	26	50	75	6	6
DRN05800901	5.80	26	50	75	6	6
DRN05900901	5.90	26	50	75	6	6
DRN06000901	6.00	26	65	100	6	6
DRN06500901	6.50	28	65	100	8	6
DRN07000901	7.00	31	70	109	8	6
DRN07500901	7.50	31	70	109	8	6
DRN08000901	8.00	33	80	109	8	6
DRN08500901	8.50	33	80	125	10	6
DRN09000901	9.00	36	85	125	10	6
DRN09500901	9.50	36	85	125	10	6
DRN10000901	10.00	38	85	125	10	6
DRN10500901	10.50	38	85	125	12	6
DRN11000901	11.00	41	100	150	12	6
DRN11500901	11.50	41	100	150	12	6
DRN12000901	12.00	44	100	150	12	6

Order No. 訂購編碼	D	L1	L2	L	Ds	F

### DRC Series (Internal Coolant)

Work Material		Drill Diameter	Ø3-6mm		Ø6.1~10mm		Ø10.1-12mm	
		Hardness	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)
P	Mild Steel	(<180HB)	40~70	0.1~0.2	40~70	0.1~0.24	40~70	0.1~0.3
	Carbon Steel	(180~280HB)	25~50	0.1~0.2	25~50	0.1~0.24	25~50	0.1~0.3
	Alloy Steel	(280~350HB)	15~25	0.08~0.16	15~25	0.08~0.2	15~25	0.08~0.24
M	Stainless Steel	(<200HB)	8~15	0.08~0.16	8~15	0.08~0.18	8~15	0.08~0.2
K	Cast Iron	(<350Mpa)	35~60	0.1~0.32	35~60	0.1~0.36	35~60	0.1~0.4
	Ductile Cast Iron	(<450Mpa)	20~45	0.1~0.24	20~45	0.1~0.28	20~45	0.1~0.32
N	Aluminum <12% Si	-	110~195	0.12~0.32	110~195	0.12~0.36	110~195	0.12~0.4
	Aluminum >12% Si	-	105~180	0.12~0.32	105~180	0.12~0.36	105~180	0.12~0.4
S	Heat Resistant Alloy	-	8~15	0.08~0.16	8~15	0.08~0.18	8~15	0.08~0.2
H	Hardened Material	-	-	-	-	-	-	-

### DRN Series (External Coolant)

Work Material		Drill Diameter	Ø3-6mm		Ø6.1~10mm		Ø10.1-12mm	
		Hardness	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)
P	Mild Steel	(<180HB)	10~20	0.03~0.12	10~20	0.06~0.2	10~20	0.1~0.22
	Carbon Steel	(180~280HB)	10~16	0.03~0.12	10~16	0.06~0.2	10~16	0.1~0.22
	Alloy Steel	(280~350HB)	8~12	0.03~0.12	8~12	0.06~0.2	8~12	0.1~0.22
M	Stainless Steel	-	-	-	-	-	-	-
K	Cast Iron	(<350Mpa)	8~16	0.03~0.12	8~16	0.06~0.02	8~16	0.1~0.22
	Ductile Cast Iron	(<450Mpa)	8~16	0.03~0.12	8~16	0.06~0.02	8~16	0.1~0.22
N	Aluminum <12% Si	-	20~30	0.03~0.13	20~30	0.07~0.23	20~30	0.1~0.28
	Aluminum >12% Si	-	20~30	0.03~0.13	20~30	0.07~0.23	20~30	0.1~0.28
S	Heat Resistant Alloy	-	-	-	-	-	-	-
H	Hardened Material	-	-	-	-	-	-	-