

DWD - Indexable Drills · 3D

捨棄式鑽頭 · 3 倍深

Specification

- 3×D Cutting depth
- Internal Coolant
- Indexable Insert with 4 sides cutting edge
- High durable SKD holder body
- Use WDXT series inserts

規格

- 3 倍深
- 內冷卻孔
- 刀片含有 4 個切削角
- SKD 高耐久性刀體
- 使用 WDXT 刀片



Fig. 1

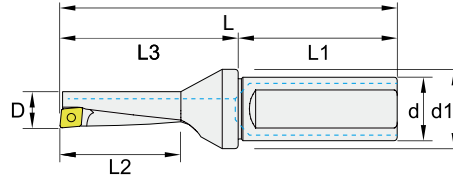
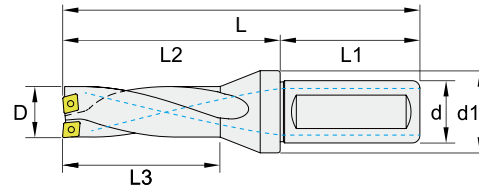


Fig. 2



Insert Brand : Winstar, Sumitomo, ...

Order No.	Dimensions, mm							T	Fig	Insert	Screw	Wrench	Stock					
	D	d	d1	L	L3	L2	L1											
IDWD100320T105	10	20	27	101	51	30	50	1	1	WDXT0525	ITS2003	ITK06	●					
IDWD120320T106	12			107	57	36				WDXT0630	ITS2205	ITK07	●					
IDWD130320T204	13	20	27	107	39	57	50	2	2	WDXT0420	ITS1801	ITK06	●					
IDWD135320T204	13.5			110	42	60							○					
IDWD140320T204	14			114	45	64							●					
IDWD145320T204	14.5			117	48	67							○					
IDWD150320T204	15			120	51	70							●					
IDWD155320T205	15.5			123	54	73				○								
IDWD160320T205	16			126	57	76				●								
IDWD165320T205	16.5			129	60	79				○								
IDWD170320T205	17			143	63	87				●								
IDWD175320T205	17.5			146	66	90				○								
IDWD180320T205	18	25	33	149	69	93	56	2	2	WDXT0630	ITS2203	ITK07	●					
IDWD185320T206	18.5			152	72	96							○					
IDWD190320T206	19			155	75	99							●					
IDWD195320T206	19.5			149	69	93							○					
IDWD200320T206	20			152	72	96							●					
IDWD205325T206	20.5			155	75	99				○								
IDWD210325T206	21			32	43	152				72	96	56	2	2	WDXT0735	ITS2511	ITK08	●
IDWD215325T206	21.5					155				75	99							○
IDWD220325T206	22					152				72	96							●
IDWD225332T206	22.5					155				75	99							○
IDWD230332T207	23	152	72			96	●											
IDWD235332T207	23.5	32	43	152	72	96	56	2	2	WDXT0735	ITS2511	ITK08	○					
IDWD240332T207	24			155	75	99							●					
IDWD245332T207	24.5			152	72	96							○					
IDWD250332T207	25	155	75	99	●													

● stock ○ by inquiry

Holemaking

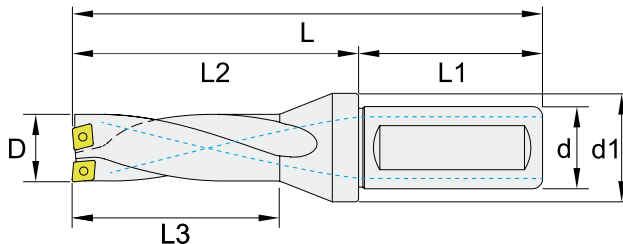
DWD - Indexable Drills · 4D 捨棄式鑽頭 · 4 倍深

Specification

- 4×D Cutting depth
- Internal Coolant
- Indexable Insert with 4 sides cutting edge
- High durable SKD holder body
- Use WDXT series inserts

規格

- 4 倍深
- 內冷卻孔
- 刀片含有 4 個切削角
- SKD 高耐久性刀體
- 使用 WDXT 刀片



Insert Brand : Winstar, Sumitomo, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock			
	D	d	d1	L	L3	L2	L1								
IDWD130420T204	13	20	27	120	52	70	50	2	WDXT0420	ITS1801	ITK06	●			
IDWD135420T204	13.5			124	56	74						○			
IDWD140420T204	14			129	60	79						●			
IDWD145420T204	14.5			133	64	83						○			
IDWD150420T204	15			137	68	87						●			
IDWD155420T205	15.5			141	72	91						○			
IDWD160420T205	16			145	76	95			●						
IDWD165420T205	16.5			149	80	99			○						
IDWD170420T205	17			164	84	108			●						
IDWD175420T205	17.5			168	88	112			○						
IDWD180420T205	18			172	92	116			●						
IDWD185420T206	18.5			176	96	120			○						
IDWD190420T206	19			180	100	124			●						
IDWD195420T206	19.5			25	33	164			84	108	56	2	WDXT0630	ITS2203	ITK07
IDWD200420T206	20	168	88				112	●							
IDWD205425T206	20.5	172	92				116	○							
IDWD210425T206	21	176	96				120	●							
IDWD215425T206	21.5	180	100				124	○							
IDWD220425T206	22	WDXT0735	ITS2511				ITK08	●							
IDWD225425T206	22.5							172					92	116	○
IDWD230425T207	23							176					96	120	●
IDWD235425T207	23.5							180					100	124	○
IDWD240425T207	24							180					100	124	●
IDWD245425T207	24.5										○				
IDWD250425T207	25										●				

● stock ○ by inquiry

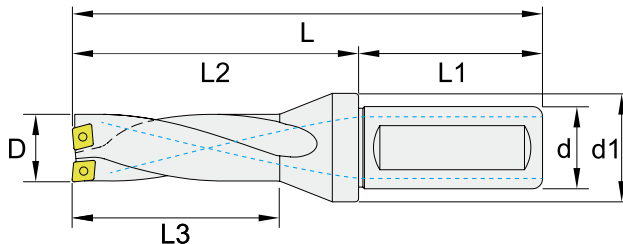
DWD - Indexable Drills · 5D 捨棄式鑽頭 · 5 倍深

Specification

- 5×D Cutting depth
- Internal Coolant
- Indexable Insert with 4 sides cutting edge
- High durable SKD holder body
- Use WDXT series inserts

規 格

- 5 倍深
- 內冷卻孔
- 刀片含有 4 個切削角
- SKD 高耐久性刀體
- 使用 WDXT 刀片



Insert Brand : Winstar, Sumitomo, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock
	D	d	d1	L	L3	L2	L1					
IDWD130520T204	13	20	25	133	65	83	50	2	WDXT0420	ITS1801	ITK06	●
IDWD140520T204	14			138	70	88						●
IDWD150520T204	15			144	75	94						●
IDWD160520T205	16			149	80	100						●
IDWD170520T205	17			154	85	105			●			
IDWD180520T205	18			159	90	110			●			
IDWD190520T206	19			164	95	115			●			
IDWD200520T206	20			169	100	120			●			
IDWD210525T206	21	25	33	185	105	125	56	2	WDXT0630	ITS2203	ITK07	●
IDWD220525T206	22			190	110	130						●
IDWD230525T207	23			195	115	140						●
IDWD240525T207	24			200	120	145			●			
IDWD250525T207	25			205	125	150				●		

● stock ○ by inquiry

Holemaking

DWD - Indexable Drill Inserts 捨棄式鑽頭刀片

Insert Specifications 刀片規格

Insert	Dimensions (mm)			
	A	r1	r2	S
WDXT042004	4.2	0.4	0.4	2.0
WDXT052504	5.0	0.4	0.4	2.5
WDXT063006	6.0	0.6	0.6	3.0
WDXT073506	7.5	0.6	0.6	3.5

Insert Geometry 刀片幾何

Shape 形狀	Chipbreaker 斷屑槽	Application 應用
	MG	Low cutting force for medium cutting in steel, stainless steel and cast iron. 低切削阻力的刀口設計，適用於鋼件、不鏽鋼和鑄鐵的中加工應用

Recommended Cutting Conditions 建議切削數據





DWD Series (3×D)

Work Material	Hardness	Vc (m/min)	Feed Rate (mm/rev)	
			Ø13-Ø18	Ø18.5-Ø25
P	Mild Steel (<180HB)	100~200	0.08~0.20	0.08~0.20
	Carbon Steel (180~280HB)	120~240	0.06~0.14	0.06~0.14
	Alloy Steel (280~350HB)	85~210	0.05~0.11	0.05~0.11
M	Stainless Steel (<200HB)	120~180	0.06~0.15	0.06~0.15
K	Cast Iron (<350Mpa)	120~200	0.09~0.27	0.10~0.30
	Ductile Cast Iron (<450Mpa)	90~150	0.09~0.27	0.10~0.30
N	Aluminum <12% Si	200~320	0.06~0.17	0.06~0.17
	Aluminum >12% Si	180~280	0.06~0.17	0.06~0.17
S	Heat Resistant Alloy	25~70	0.06~0.15	0.06~0.15

Apply for 4×D reduce 10%, 5×D reduce 15%.

DWD - Indexable Drill Inserts 捨棄式鑽頭刀片

Insert Designation 刀片型號

Insert	Order No.	Code-Chipbreaker-Grade	Working Material					
			P	M	K	N	S	H
	IWDXT042004MG33TX	WDXT042004-MG-CX33TX	●	●	●		●	●
	IWDXT052504MG33TX	WDXT052504-MG-CX33TX	●	●	●		●	●
	IWDXT052504MG43TX	WDXT052504-MG-CX43TX	●	●	●		●	
	IWDXT063006MG33TX	WDXT063006-MG-CX33TX	●	●	●		●	●
	IWDXT073506MG33TX	WDXT073506-MG-CX33TX	●	●	●		●	●