

DrillLine

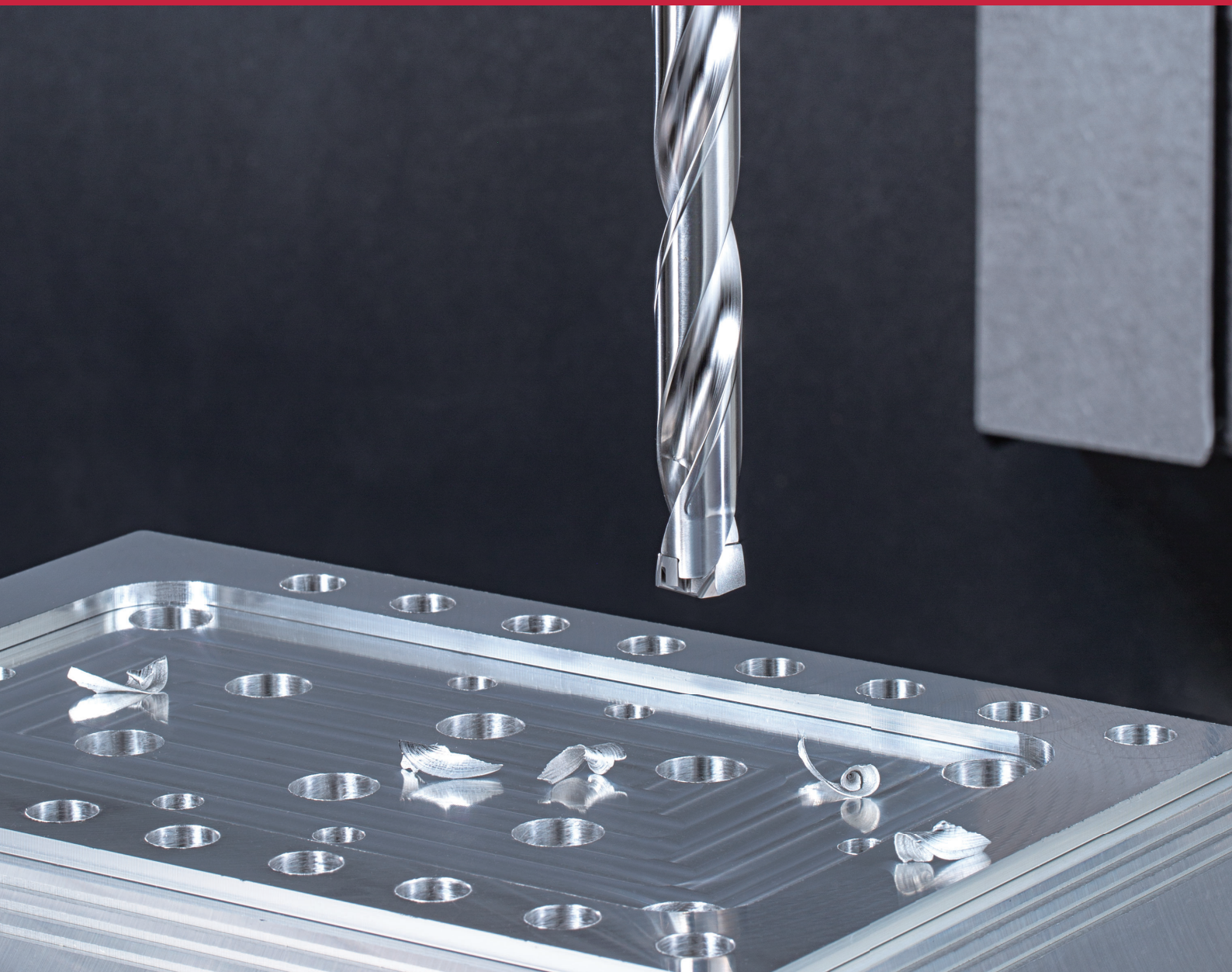


DRILLMEISTER

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Tungaloy Report No. 412S4-G

New DMN geometry dedicated for non-ferrous applications with diameter range of 10 - 19.9 mm

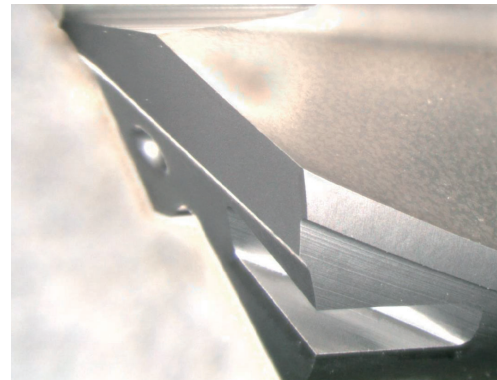


INDUSTRY 4.0
FEED the SPEED!



For more information

Excellent welding resistance for non-ferrous metals



Sharp and uncoated cutting edge design prevents built-up edge and provides good chip evacuation during drilling of non-ferrous metal.

Chip control



Aluminium alloy
(A5052)



Aluminium alloy casting
(ADC12)

N Tool : $\varnothing 13.7$ mm, L/D = 5
 Drill head : DMN137
 Grade : KS15F
 Cutting speed : $V_c = 200$ m/min
 Feed : $f = 0.4$ mm/rev
 Hole depth : $H = 40$ mm
 Coolant : Wet

STANDARD CUTTING CONDITIONS

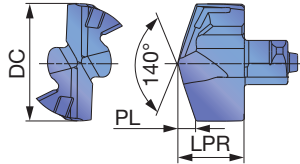
ISO	Workpiece materials	Cutting speed V_c (m/min)	Feed: f (mm/rev)			
			DC (mm)			
			$\varnothing 10 - \varnothing 11.9$	$\varnothing 12 - \varnothing 13.9$	$\varnothing 14 - \varnothing 15.9$	$\varnothing 16 - \varnothing 19.9$
N	Aluminium alloys ADC12, etc.	80 - 220	0.25 - 0.4	0.3 - 0.45	0.35 - 0.5	0.4 - 0.6

Note: DMN heads can be mounted on standard TID bodies without additional processing

DRILL HEAD

DMN Non-ferrous metals drilling

New



Tool diameter	Head diameter tolerance
ø10 - ø17.5	+0.01 / 0
ø18 - ø19.9	+0.012 / 0

P Steel									
M Stainless									
K Cast iron									
N Non-ferrous		★							
S Superalloys									
H Hard materials									

★ : First choice

Designation	DC	LPR	Uncoated							PL	SSC	Pocket Size	Body
			KS15F										
DMN100	10	6.1	●							1.47	10	10	TID*100...
DMN102	10.2	6.1	●							1.52	10	10	TID*100...
DMN105	10.5	6.1	●							1.56	10	10	TID*105...
DMN108	10.8	6.1	●							1.62	10	10	TID*105...
DMN110	11	6.5	●							1.67	11	11	TID*110...
DMN115	11.5	6.5	●							1.76	11	11	TID*115...
DMN120	12	6.8	●							1.82	12	12	TID*120...
DMN123	12.3	6.8	●							1.87	12	12	TID*120...
DMN125	12.5	6.8	●							1.91	12	12	TID*125...
DMN126	12.6	6.8	●							1.93	12	12	TID*125...
DMN127	12.7	6.8	●							1.95	12	12	TID*125...
DMN130	13	7.4	●							1.96	13	13	TID*130...
DMN135	13.5	7.4	●							2.05	13	13	TID*135...
DMN138	13.8	7.4	●							2.11	13	13	TID*135...
DMN140	14	8	●							2.12	14	14	TID*140...
DMN142	14.2	8	●							2.16	14	14	TID*140...
DMN145	14.5	8	●							2.21	14	14	TID*145...
DMN150	15	8.5	●							2.27	15	15	TID*150...
DMN152	15.2	8.5	●							2.31	15	15	TID*150...
DMN155	15.5	8.5	●							2.36	15	15	TID*150...
DMN158	15.8	8.5	●							2.42	15	15	TID*150...
DMN159	15.9	8.5	●							2.43	15	15	TID*150...
DMN160	16	9.1	●							2.42	16	16	TID*160...
DMN163	16.3	9.1	●							2.47	16	16	TID*160...
DMN165	16.5	9.1	●							2.51	16	16	TID*160...
DMN170	17	9.7	●							2.59	17	17	TID*170...
DMN175	17.5	9.7	●							2.68	17	17	TID*170...
DMN180	18	10.3	●							2.73	18	18	TID*180...
DMN185	18.5	10.3	●							2.82	18	18	TID*180...
DMN190	19	10.8	●							2.88	19	19	TID*190...
DMN195	19.5	10.8	●							2.97	19	19	TID*190...

● : New lineup

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