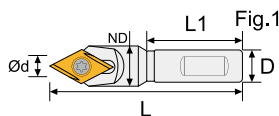


**DTS60 - Indexable Spotting Drills** 60° 捨棄式定位鑽頭

**DTS60 - Spotting Drills** 定位鑽頭



Insert Brand 建議刀片 : Winstar

DTS 60 - DCEX11T3

Order No.	D	ND	L	L1	Fig	Insert	Screw	Wrench	Stock
IDTS1006006011	10	12	60	30	1	DCEX11T3	ITS3520	ITK15	●
IDTS1210006011	12	12	100	-	2				●

● stock ○ by inquiry

**Recommended Cutting Conditions** 建議切削數據

DTS 60 Chamfering / Countersinking

Material	Vc (m/min)	fr (mm/rev)
Carbon steel	12 ~ 180	0.05 ~ 0.15
Alloy steel	12 ~ 180	0.05 ~ 0.15
Stainless steel	12 ~ 180	0.05 ~ 0.15
Cast iron	12 ~ 180	0.05 ~ 0.15
Aluminum	12 ~ 180	0.10 ~ 0.20
Hardened steel	12 ~ 180	0.03 ~ 0.10

DTS 60 Grooving / Engraving

Material	Vc (m/min)	fr (mm/rev)
Carbon steel	10 ~ 170	0.005 ~ 0.05
Alloy steel	10 ~ 170	0.005 ~ 0.03
Stainless steel	10 ~ 170	0.005 ~ 0.05
Cast iron	10 ~ 170	0.005 ~ 0.03
Aluminum	10 ~ 170	0.005 ~ 0.08
Hardened steel	10 ~ 170	0.005 ~ 0.02

DTS 60 Cutting Depth of Passes

No. of Passes	ap of one pass (mm)					
	Aluminum	Cast iron	Carbon steel	Alloy steel	Stainless steel	Hardened steel
1	1.0	0.8	0.8	0.6	0.5	0.2
2	0.8	0.7	0.6	0.5	0.4	0.2
3	0.2	0.3	0.3	0.3	0.3	0.15
4		0.2	0.2	0.3	0.3	0.15
5			0.1	0.2	0.2	0.1
6				0.1	0.2	0.1
7					0.1	0.1

※ Max ap is 2mm

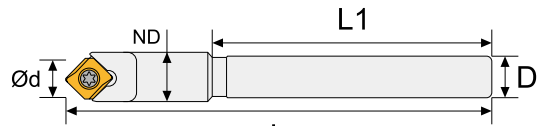
**Insert Designation** 刀片型號

Insert	Order No.	Designation	r	Engraving Ød	P	M	K	N	S	H
	IDCEX11T301SG32HS	DCEX11T301-SG-CX32HS	0.1	0.2 ~ 1	●	●	●	●	●	
	IDCEX11T302SG32HS	DCEX11T302-SG-CX32HS	0.2	0.4 ~ 2	●	●	●	●	●	
	IDCEX11T304SG32HS	DCEX11T304-SG-CX32HS	0.4	0.8 ~ 3	●	●	●	●	●	
	IDCEX11T30132HS	DCEX11T301-CX32HS	0.1	0.8 ~ 3	●	●	●		●	●
	IDCEX11T30232HS	DCEX11T302-CX32HS	0.2	0.8 ~ 3	●	●	●		●	●
	IDCEX11T30432HS	DCEX11T304-CX32HS	0.4	0.8 ~ 3	●	●	●		●	●
	IDCEX11T30832HS	DCEX11T308-CX32HS	0.8	0.8 ~ 3	●	●	●		●	●

**DTS90 - Indexable Spotting Drills**

90° 捨棄式定位鑽頭

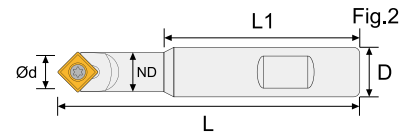
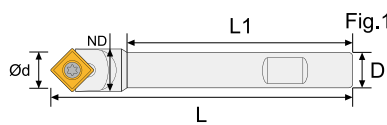
**DTS90 - Spotting Drills** 定位鑽頭



DTS90 - SDMX05T1 (for small lathe 適用於小型車床)

Insert Brand 建議刀片 : Winstar

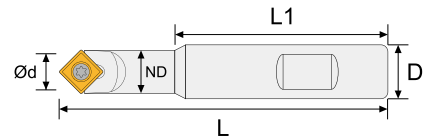
Order No.	D	L	ND	L1	Spotting $\varnothing d$	Engraving $\varnothing d$	Insert	Screw	Wrench	Stock
IDTS0604009005	6	40	7	20	1 ~ 5	0.8 ~ 1.5	SDMX05T1	ITS1801	ITK06	●
IDTS0606009005	6	60	7	40						●



DTS90 - SCGX09T3, SCM09T3

Insert Brand 建議刀片 : Winstar

Order No.	D	L	ND	L1	Fig	Spotting $\varnothing d$	Engraving $\varnothing d$	Insert	Screw	Wrench	Stock
IDTS1010009009	10	100	12.2	71	1	2 ~ 11	0.8 ~ 2.5	SCGX09T3 SCMX09T3	ITS3520	ITK15	●
IDTS1210009009	12	100	12.2	71							●
IDTS1610009009	16	100	12.2	71	2						●
IDTS1613009009	16	130	12.2	101							●

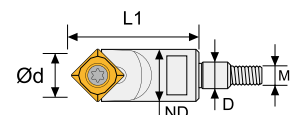


DTS90 - SDMX11T3

Insert Brand 建議刀片 : Winstar

Order No.	D	L	ND	L1	Spotting $\varnothing d$	Engraving $\varnothing d$	Insert	Screw	Wrench	Stock
IDTS1610009011	16	100	14.1	71	3 ~ 14	1.6 ~ 4.0	SDMX11T3	ITS3521	ITK15	●

**DTS90 - Modular Spotting Drill Heads** 定位鑽刀頭



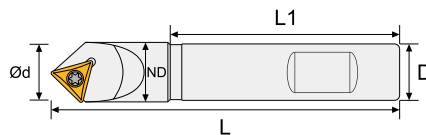
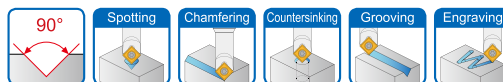
Insert Brand 建議刀片 : Winstar

Order No.	L1	ND	D	M	Spotting $\varnothing d$	Engraving $\varnothing d$	Insert	Screw	Wrench	Stock
IDTSM603009009	30	12.4	6.5	M6	2 ~ 11	0.8 ~ 2.5	SCMX09T3	ITS3520	ITK15	○

● stock ○ by inquiry

**DTS90 - Indexable Spotting Drills** 90° 捨棄式定位鑽頭

**DTS90 - Spotting Drills** 定位鑽頭



DTS90 - TCMX16T3

Insert Brand 建議刀片 : Winstar

Order No.	D	L	ND	L1	Spotting Ød	Engraving Ød	Insert	Screw	Wrench	Stock
IDTS2012009016	20	120	21.2	78	3 ~ 20	1.6 ~ 4.0	TCMX16T3	ITS3521	ITK15	●

● stock ○ by inquiry

**Recommended Cutting Conditions** 建議切削數據

DTS 90 Spotting

Material	Vc (m/min)		Fr (mm/rev)	
	Ød = 2 ~ 4.9 mm	Ød ≥ 5 mm	Ød = 2 ~ 4.9 mm	Ød ≥ 5 mm
Carbon steel	60 ~ 120	90 ~ 220	0.04 ~ 0.08	0.06 ~ 0.10
Alloy steel	50 ~ 100	75 ~ 180	0.03 ~ 0.06	0.05 ~ 0.08
Stainless steel	30 ~ 60	45 ~ 120	0.02 ~ 0.04	0.04 ~ 0.06
Cast iron	40 ~ 80	60 ~ 130	0.04 ~ 0.08	0.06 ~ 0.10
Hardened steel	20 ~ 40	30 ~ 60	0.02 ~ 0.04	0.04 ~ 0.08

DTS 90 Chamfering / Countersinking

Material	Vc (m/min)	Fr (mm/rev)
Carbon steel	60 ~ 270	0.15 ~ 0.24
Alloy steel	50 ~ 220	0.12 ~ 0.20
Stainless steel	35 ~ 120	0.10 ~ 0.20
Cast iron	60 ~ 220	0.15 ~ 0.25
Hardened steel	20 ~ 60	0.03 ~ 0.08

DTS 90 Grooving / Engraving

Material	Vc (m/min)	Fr (mm/rev)
Carbon steel	40 ~ 140	0.12 ~ 0.18
Alloy steel	35 ~ 120	0.10 ~ 0.14
Stainless steel	25 ~ 70	0.08 ~ 0.12
Cast iron	30 ~ 100	0.12 ~ 0.18
Hardened steel	20 ~ 50	0.02 ~ 0.04

**DTS90 - Indexable Spotting Drills** 90° 捨棄式定位鑽頭

**Insert Designation** 刀片型號

Insert	Order No.	Designation	r	Spotting Ød	Engraving Ød	P	M	K	N	S	H
	ISCGX09T304AG10	SCGX09T304-AG-CX10	0.4	2 ~ 11	0.8 ~ 2.5				●		
	ISCGX09T304FG13TX	SCGX09T304-FG-CX13TX	0.4	2 ~ 11	0.8 ~ 2.5	●	●	●	○	●	●
	ISCMX09T304SM32HS	SCMX09T304-SM-CX32HS	0.4	2 ~ 11	0.8 ~ 2.5	●	●	●	○	●	○
	ISDMX05T104FG13TX	SDMX05T104-FG-CX13TX	0.4	1 ~ 5	0.8 ~ 1.5	●	●	●	○	●	●
	ISDMX05T104FG33TX	SDMX05T104-FG-CX33TX	0.4	1 ~ 5	0.8 ~ 1.5	●	●	●	○	●	●
	ISDMX11T308SG33TX	SDMX11T308-SG-CX33TX	0.8	3 ~ 14	1.6 ~ 4.0	●	●	●		●	●
	ITCMX16T308SM32HS	TCMX16T308-SM-CX32HS	0.8	3 ~ 20	1.6 ~ 4.0	●	●	●	○	●	●

Holemaking