

**High Performance**  
**High CP Value**



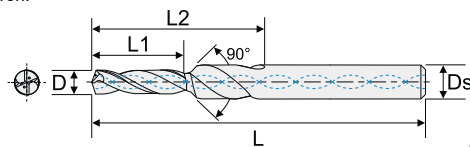
## **Features**

- For drill a hole with counterbore, countersink, or chamfer
- For steel, alloy steel, cast iron
- Customized Service
- 專為沉孔加工、導角加工設計
- 適用鋼、合金鋼、鑄鐵的孔加工
- 提供客製化服務



### Product Specs

- Reinforced Shank
  - For drill with a counterbore, countersink, or chamfer.
  - For Steel, Alloy Steel, Stainless Steel and Cast Iron.
- Internal Coolant
- UNIX Coating
  - Customizable
- Tolerance h8



Unit:mm

Order No. 訂購編碼	D	L1	L2	L	Ds
DZC03300301	3.30	12	26	62	6
DZC04200301	4.20	15	28	66	6
DZC05000301	5.00	18	36	79	8
DZC06800301	6.80	24	48	90	10
DZC08500301	8.50	30	55	102	12

Order No. 訂購編碼	D	L1	L2	L	Ds

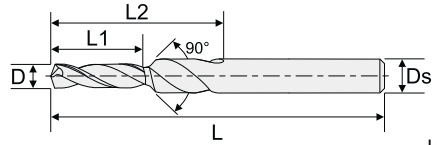
## DZN (for Step hole)

階梯整體硬質合金外冷鑽

P	M	K	N	S	H
●	○	●	□	□	□

### Product Specs

- Reinforced Shank
- External Coolant
- UNIX Coating
- Tolerance h8
- For drill with a counterbore, countersink, or chamfer.
- Customizable
- For Steel, Alloy Steel, Stainless Steel and Cast Iron.



Order No. 訂購編碼	D	L1	L2	L	Ds
DZN03300301	3.30	12	26	62	6
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Solid Carbide Drills

### DZC 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

### DZN 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