

DRM Series



- DRM machine reamer suitable for through hole.
- Specially for high accurate hole machining.
- UNIX smooth coating.
- 左螺旋，右切設計螺旋機械鉋刀適用於通孔加工
- 高精度孔加工專用
- 高鋁鈦平滑塗層

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DRSC Series



- DRSC straight flute reamer with internal coolant.
- Suitable for blind / through hole.
- Specially for high accurate hole machining.
- UNIX smooth coating.
- 直刃內冷鉋刀
- 適用於盲孔 / 通孔加工
- 高精度孔加工專用
- 高鋁鈦平滑塗層

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DRSN Series

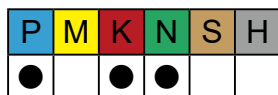


- DRSN straight flute reamer with external coolant.
- Suitable for blind / through hole.
- Specially for high accurate hole machining.
- UNIX smooth coating.
- 直刃外冷鉋刀
- 適用於盲孔 / 通孔加工
- 高精度孔加工專用
- 高鋁鈦平滑塗層

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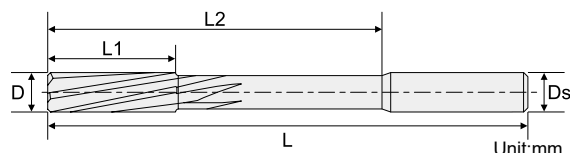
DRMN - Left spiral flute · External Coolant

螺旋機械外冷鉋刀



Specification

- External
- Left spiral flute
- New UNIX Smooth Coating
- Tolerance H7
- Provide high degree of accuracy to leave smooth sides.
- For through hole



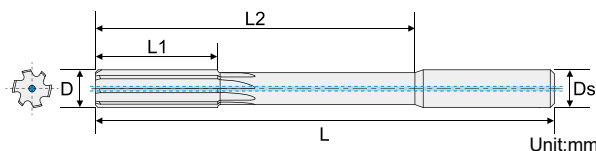
Order No. 訂購編碼	D	L1	L2	L	Ds	F
DRMN0299090UX	2.99	15	35	60	4	4
DRMN0300090UX	3.00	15	35	60	4	4
DRMN0301090UX	3.01	15	35	60	4	4
DRMN0302090UX	3.02	15	35	60	4	4
DRMN0310090UX	3.10	15	35	60	4	4
DRMN0320090UX	3.20	15	35	60	4	4
DRMN0330090UX	3.30	15	35	60	4	4
DRMN0340090UX	3.40	15	35	60	4	4
DRMN0350090UX	3.50	18	35	60	4	4
DRMN0360090UX	3.60	18	35	60	4	4
DRMN0370090UX	3.70	18	35	60	4	4
DRMN0380090UX	3.80	18	35	60	4	4
DRMN0390090UX	3.90	18	35	60	4	4
DRMN0399090UX	3.99	19	50	75	4	4
DRMN0400090UX	4.00	19	50	75	4	4
DRMN0401090UX	4.01	19	50	75	4	4
DRMN0402090UX	4.02	19	50	75	4	4
DRMN0410090UX	4.10	19	50	75	6	4
DRMN0420090UX	4.20	19	50	75	6	4
DRMN0430090UX	4.30	19	50	75	6	4
DRMN0440090UX	4.40	19	50	75	6	4
DRMN0450090UX	4.50	21	50	75	6	4
DRMN0460090UX	4.60	21	50	75	6	4
DRMN0470090UX	4.70	21	50	75	6	4
DRMN0480090UX	4.80	21	50	75	6	4
DRMN0490090UX	4.90	21	50	75	6	4
DRMN0499090UX	4.99	23	50	75	6	6
DRMN0500090UX	5.00	23	50	75	6	6
DRMN0501090UX	5.01	23	50	75	6	6
DRMN0502090UX	5.02	23	50	75	6	6
DRMN0510090UX	5.10	23	50	75	6	6
DRMN0520090UX	5.20	23	50	75	6	6
DRMN0530090UX	5.30	23	50	75	6	6
DRMN0540090UX	5.40	23	50	75	6	6
DRMN0550090UX	5.50	26	50	75	6	6
DRMN0560090UX	5.60	26	50	75	6	6
DRMN0570090UX	5.70	26	50	75	6	6
DRMN0580090UX	5.80	26	50	75	6	6
DRMN0590090UX	5.90	26	50	75	6	6
DRMN0599090UX	5.99	26	65	100	6	6
DRMN0600090UX	6.00	26	65	100	6	6
DRMN0601090UX	6.01	26	65	100	6	6
DRMN0602090UX	6.02	26	65	100	6	6
DRMN0650090UX	6.50	28	65	100	8	6
DRMN0699090UX	6.99	31	70	109	8	6
DRMN0700090UX	7.00	31	70	109	8	6
DRMN0701090UX	7.01	31	70	109	8	6
DRMN0702090UX	7.02	31	70	109	8	6

Order No. 訂購編碼	D	L1	L2	L	Ds	F
DRMN0750090UX	7.50	31	70	109	8	6
DRMN0799090UX	7.99	33	80	109	8	6
DRMN0800090UX	8.00	33	80	109	8	6
DRMN0801090UX	8.01	33	80	109	8	6
DRMN0802090UX	8.02	33	80	109	8	6
DRMN0850090UX	8.50	33	80	125	10	6
DRMN0899090UX	8.99	36	85	125	10	6
DRMN0900090UX	9.00	36	85	125	10	6
DRMN0901090UX	9.01	36	85	125	10	6
DRMN0902090UX	9.02	36	85	125	10	6
DRMN0950090UX	9.50	36	85	125	10	6
DRMN0999090UX	9.99	38	85	125	10	6
DRMN1000090UX	10.00	38	85	125	10	6
DRMN1001090UX	10.01	38	85	125	10	6
DRMN1002090UX	10.02	38	85	125	10	6
DRMN1050090UX	10.50	38	85	125	12	6
DRMN1099090UX	10.99	41	100	150	12	6
DRMN1100090UX	11.00	41	100	150	12	6
DRMN1101090UX	11.01	41	100	150	12	6
DRMN1102090UX	11.02	41	100	150	12	6
DRMN1150090UX	11.50	41	100	150	12	6
DRMN1199090UX	11.99	44	100	150	12	6
DRMN1200090UX	12.00	44	100	150	12	6
DRMN1201090UX	12.01	44	100	150	12	6
DRMN1202090UX	12.02	44	100	150	12	6

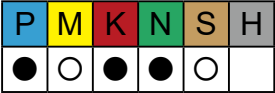
直刃内冷鉋刀



- Internal
- Straight flute
- New UNIX Smooth Coating
- Tolerance H7
- Unequal flute spacing
- Provides high degree of accuracy of leave smooth sides
- For blind hole / through hole

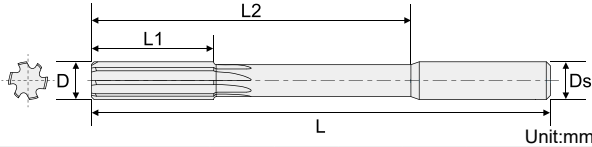


DRSN - Straight flute · External Coolant 直刃外冷鉋刀



Specification

- External
- Straight flute
- New UNIX Smooth Coating
- Tolerance H7
- Unequal flute spacing
- Provides high degree of accuracy of leave smooth sides
- For blind hole / through hole



Order No. 訂購編碼	D	L1	L2	L	Ds	F
DRSN0299090UX	2.99	15	35	60	4	4
DRSN0300090UX	3.00	15	35	60	4	4
DRSN0301090UX	3.01	15	35	60	4	4
DRSN0302090UX	3.02	15	35	60	4	4
DRSN0310090UX	3.10	15	35	60	4	4
DRSN0320090UX	3.20	15	35	60	4	4
DRSN0330090UX	3.30	15	35	60	4	4
DRSN0340090UX	3.40	15	35	60	4	4
DRSN0350090UX	3.50	18	35	60	4	4
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DRSN0401090UX	4.01	19	50	75	4	4
DRSN0402090UX	4.02	19	50	75	4	4
DRSN0410090UX	4.10	19	50	75	6	4
DRSN0420090UX	4.20	19	50	75	6	4
DRSN0430090UX	4.30	19	50	75	6	4
DRSN0440090UX	4.40	19	50	75	6	4
DRSN0450090UX	4.50	21	50	75	6	4
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DRSN0499090UX	4.99	23	50	75	6	6
DRSN0500090UX	5.00	23	50	75	6	6
DRSN0501090UX	5.01	23	50	75	6	6
DRSN0502090UX	5.02	23	50	75	6	6
DRSN0510090UX	5.10	23	50	75	6	6
DRSN0520090UX	5.20	23	50	75	6	6
DRSN0530090UX	5.30	23	50	75	6	6
DRSN0540090UX	5.40	23	50	75	6	6
DRSN0550090UX	5.50	26	50	75	6	6
DRSN0560090UX	5.60	26	50	75	6	6
DRSN0570090UX	5.70	26	50	75	6	6
DRSN0580090UX	5.80	26	50	75	6	6
DRSN0590090UX	5.90	26	50	75	6	6
DRSN0599090UX	5.99	26	65	100	6	6
DRSN0600090UX	6.00	26	65	100	6	6
DRSN0601090UX	6.01	26	65	100	6	6
DRSN0602090UX	6.02	26	65	100	6	6
DRSN0650090UX	6.50	28	65	100	8	6
DRSN0699090UX	6.99	31	70	109	8	6
DRSN0700090UX	7.00	31	70	109	8	6
DRSN0701090UX	7.01	31	70	109	8	6
DRSN0702090UX	7.02	31	70	109	8	6

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DRSN0750090UX	7.50	31	70	109	8	6
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DRSN0801090UX	8.01	33	80	109	8	6
DRSN0802090UX	8.02	33	80	109	8	6
DRSN0850090UX	8.50	33	80	125	10	6
DRSN0899090UX	8.99	36	85	125	10	6
DRSN0900090UX	9.00	36	85	125	10	6
DRSN0901090UX	9.01	36	85	125	10	6
DRSN0902090UX	9.02	36	85	125	10	6
DRSN0950090UX	9.50	36	85	125	10	6
DRSN0999090UX	9.99	38	85	125	10	6
DRSN1000090UX	10.00	38	85	125	10	6
DRSN1001090UX	10.01	38	85	125	10	6
DRSN1002090UX	10.02	38	85	125	10	6
DRSN1050090UX	10.50	38	85	125	12	6
DRSN1099090UX	10.99	41	100	150	12	6
DRSN1100090UX	11.00	41	100	150	12	6
DRSN1101090UX	11.01	41	100	150	12	6
DRSN1102090UX	11.02	41	100	150	12	6
DRSN1150090UX	11.50	41	100	150	12	6
DRSN1199090UX	11.99	44	100	150	12	6
DRSN1200090UX	12.00	44	100	150	12	6
DRSN1201090UX	12.01	44	100	150	12	6
DRSN1202090UX	12.02	44	100	150	12	6

Recommended Cutting Conditions

建議切削數據

DRMN, DRSN Series (External Coolant 外冷)

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	-	-	-	-	-	-	-

DRSC Series (Internal Coolant 內冷)

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	-	-	-	-	-	-	-