

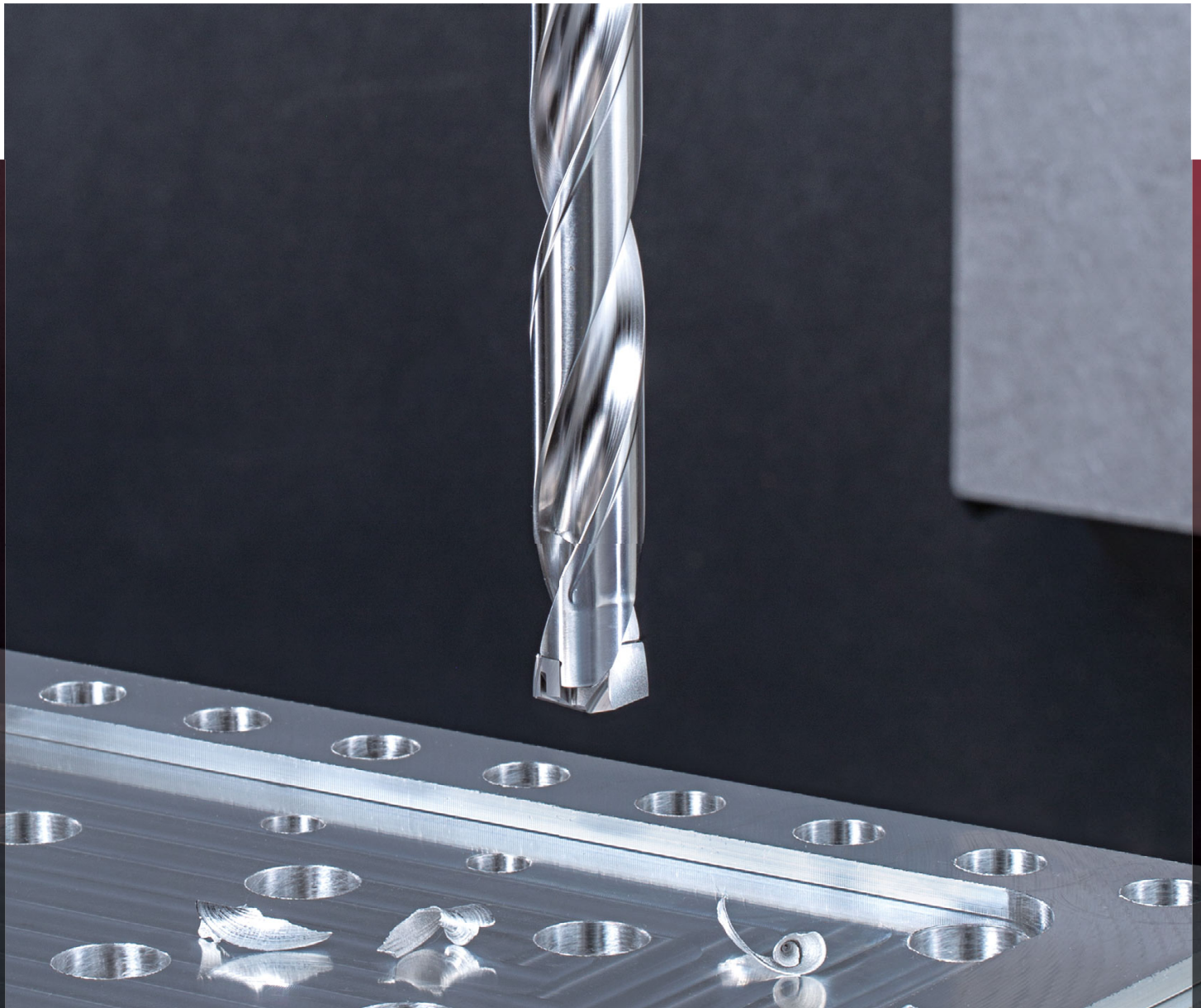


Exchangeable head drill

DRILLMEISTER

Tungaloy Report No. 412S11-US

Expansion of **DMN** geometry for non-ferrous metals in **ø0.268" - 0.374"**



DMN - Sharp edge design for non-ferrous metals



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

CHIP CONTROL



Aluminum alloy
(5052)

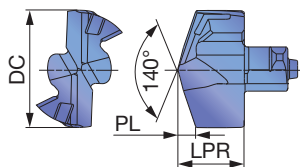


Aluminum alloy casting
(ADC12)

N

Tool : $\varnothing 0.543"$, L/D = 5
Drill head : DMN138
Grade : KS15F
Cutting speed : $V_c = 656$ sfm
Feed : $f = 0.016$ ipr
Hole depth : $H = 1.575"$
Coolant : Wet

DMN Non-ferrous metals drilling



Tool diameter (inch)	Head diameter tolerance
ø0.268" - ø0.689"	+0.0004" / 0
ø0.709" - ø0.768"	+0.0005" / 0

Tool diameter (mm)	Head diameter tolerance
ø6.8 - ø17.5	+0.01 / 0
ø18 - ø19.5	+0.012 / 0

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

★ : First choice

Designation	DC (mm)	DC (in)	LPR (in)	Coated		PL (in)	Body	
				KS15F			Metric	Inch
New DMN068	6.8	0.268	0.163	●		0.052	TID*065...	-
New DMN078	7.8	0.307	0.175	●		0.046	TID*075...	-
New DMN080	8	0.315	0.207	●		0.047	TID*080...	-
New DMN085	8.5	0.335	0.207	●		0.051	TID*085...	-
New DMN088	8.8	0.346	0.207	●		0.053	TID*085...	-
New DMN095	9.5	0.374	0.222	●		0.057	TID*095...	-
DMN100	10	0.394	0.238	●		0.058	TID*100...	TIDU0394...
DMN102	10.2	0.402	0.238	●		0.059	TID*100...	TIDU0394...
DMN105	10.5	0.413	0.238	●		0.061	TID*105...	TIDU0413...
DMN108	10.8	0.425	0.238	●		0.064	TID*105...	TIDU0413...
DMN110	11	0.433	0.254	●		0.066	TID*110...	TIDU0433...
DMN115	11.5	0.453	0.254	●		0.069	TID*115...	TIDU0453...
DMN120	12	0.472	0.268	●		0.072	TID*120...	TIDU0472...
DMN123	12.3	0.484	0.268	●		0.074	TID*120...	TIDU0472...
DMN125	12.5	0.492	0.268	●		0.075	TID*125...	TIDU0492...
DMN126	12.6	0.496	0.268	●		0.076	TID*125...	TIDU0492...
DMN127	12.7	0.500	0.268	●		0.077	TID*125...	TIDU0492...
DMN130	13	0.512	0.291	●		0.077	TID*130...	TIDU0512...
DMN135	13.5	0.532	0.291	●		0.081	TID*135...	TIDU0532...
DMN138	13.8	0.543	0.291	●		0.083	TID*135...	TIDU0532...
DMN140	14	0.551	0.313	●		0.083	TID*140...	TIDU0551...
DMN142	14.2	0.559	0.313	●		0.085	TID*140...	TIDU0551...
DMN145	14.5	0.571	0.313	●		0.087	TID*145...	TIDU0571...
DMN150	15	0.591	0.336	●		0.089	TID*150...	TIDU0591...
DMN152	15.2	0.598	0.336	●		0.091	TID*150...	TIDU0591...
DMN155	15.5	0.610	0.336	●		0.093	TID*150...	TIDU0591...
DMN158	15.8	0.622	0.336	●		0.095	TID*150...	TIDU0591...
DMN159	15.9	0.626	0.336	●		0.096	TID*150...	TIDU0591...
DMN160	16	0.630	0.358	●		0.095	TID*160...	TIDU0630...
DMN163	16.3	0.642	0.358	●		0.097	TID*160...	TIDU0630...
DMN165	16.5	0.650	0.358	●		0.099	TID*160...	TIDU0630...
DMN170	17	0.669	0.382	●		0.102	TID*170...	TIDU0669...
DMN175	17.5	0.689	0.382	●		0.106	TID*170...	TIDU0689...
DMN180	18	0.709	0.406	●		0.107	TID*180...	TIDU0709...
DMN185	18.5	0.728	0.406	●		0.111	TID*180...	TIDU0709...
DMN190	19	0.748	0.425	●		0.113	TID*190...	TIDU0748...
DMN195	19.5	0.768	0.425	●		0.117	TID*190...	TIDU0748...

ø0.268" - ø0.768" = 2 pieces per package

● : New
● : Line up

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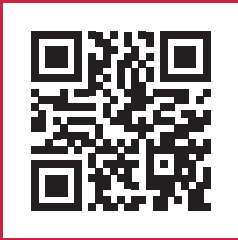
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