

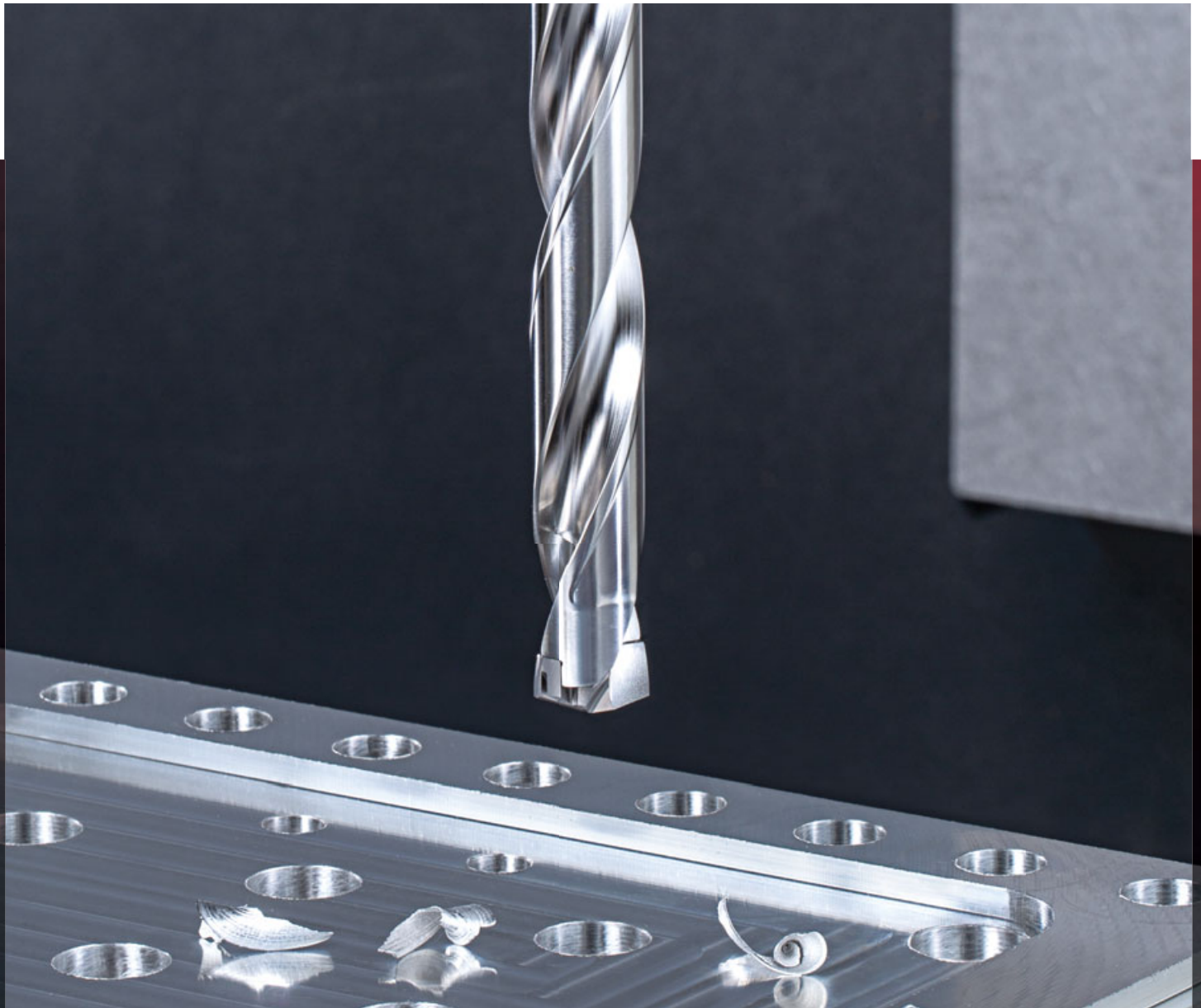


Exchangeable head drill

DRILLMEISTER

Tungaloy Report No. 412S11-G

Expansion of **DMN** geometry for non-ferrous metals in **ø6.8 - 9.5 mm**



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



Aluminium alloy
(A5052)

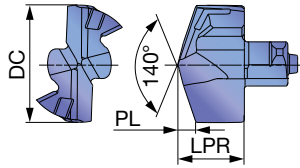


Aluminium alloy casting
(ADC12)

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

DMN Non-ferrous metals drilling



Tool diameter	Head diameter tolerance
ø6.8 - 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
☆ : Second choice

Designation	DC	LPR	Coated		PL	Body
			KS15F			
New DMN068	6.8	4.15	●		1.33	TID*065...
New DMN078	7.8	4.45	●		1.18	TID*075...
New DMN080	8	5.25	●		1.2	TID*080...
New DMN085	8.5	5.25	●		1.29	TID*085...
New DMN088	8.8	5.25	●		1.35	TID*085...
New DMN095	9.5	5.65	●		1.46	TID*095...
DMN100	10	6.05	●		1.47	TID*100...
DMN102	10.2	6.05	●		1.51	TID*100...
DMN105	10.5	6.05	●		1.56	TID*105...
DMN108	10.8	6.05	●		1.62	TID*105...
DMN110	11	6.45	●		1.67	TID*110...
DMN115	11.5	6.45	●		1.76	TID*115...
DMN120	12	6.8	●		1.82	TID*120...
DMN123	12.3	6.8	●		1.87	TID*120...
DMN125	12.5	6.8	●		1.91	TID*125...
DMN126	12.6	6.8	●		1.93	TID*125...
DMN127	12.7	6.8	●		1.95	TID*125...
DMN130	13	7.4	●		1.96	TID*130...
DMN135	13.5	7.4	●		2.05	TID*135...
DMN138	13.8	7.4	●		2.11	TID*135...
DMN140	14	7.95	●		2.12	TID*140...
DMN142	14.2	7.95	●		2.16	TID*140...
DMN145	14.5	7.95	●		2.21	TID*145...
DMN150	15	8.53	●		2.27	TID*150...
DMN152	15.2	8.53	●		2.31	TID*150...
DMN155	15.5	8.53	●		2.36	TID*150...
DMN158	15.8	8.53	●		2.42	TID*150...
DMN159	15.9	8.53	●		2.43	TID*150...
DMN160	16	9.1	●		2.42	TID*160...
DMN163	16.3	9.1	●		2.47	TID*160...
DMN165	16.5	9.1	●		2.51	TID*160...
DMN170	17	9.7	●		2.59	TID*170...
DMN175	17.5	9.7	●		2.68	TID*170...
DMN180	18	10.3	●		2.73	TID*180...
DMN185	18.5	10.3	●		2.82	TID*180...
DMN190	19	10.8	●		2.88	TID*190...
DMN195	19.5	10.8	●		2.97	TID*190...

ø6.8 - ø19.5 = 2 pieces per package

● : New
● : Line up

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