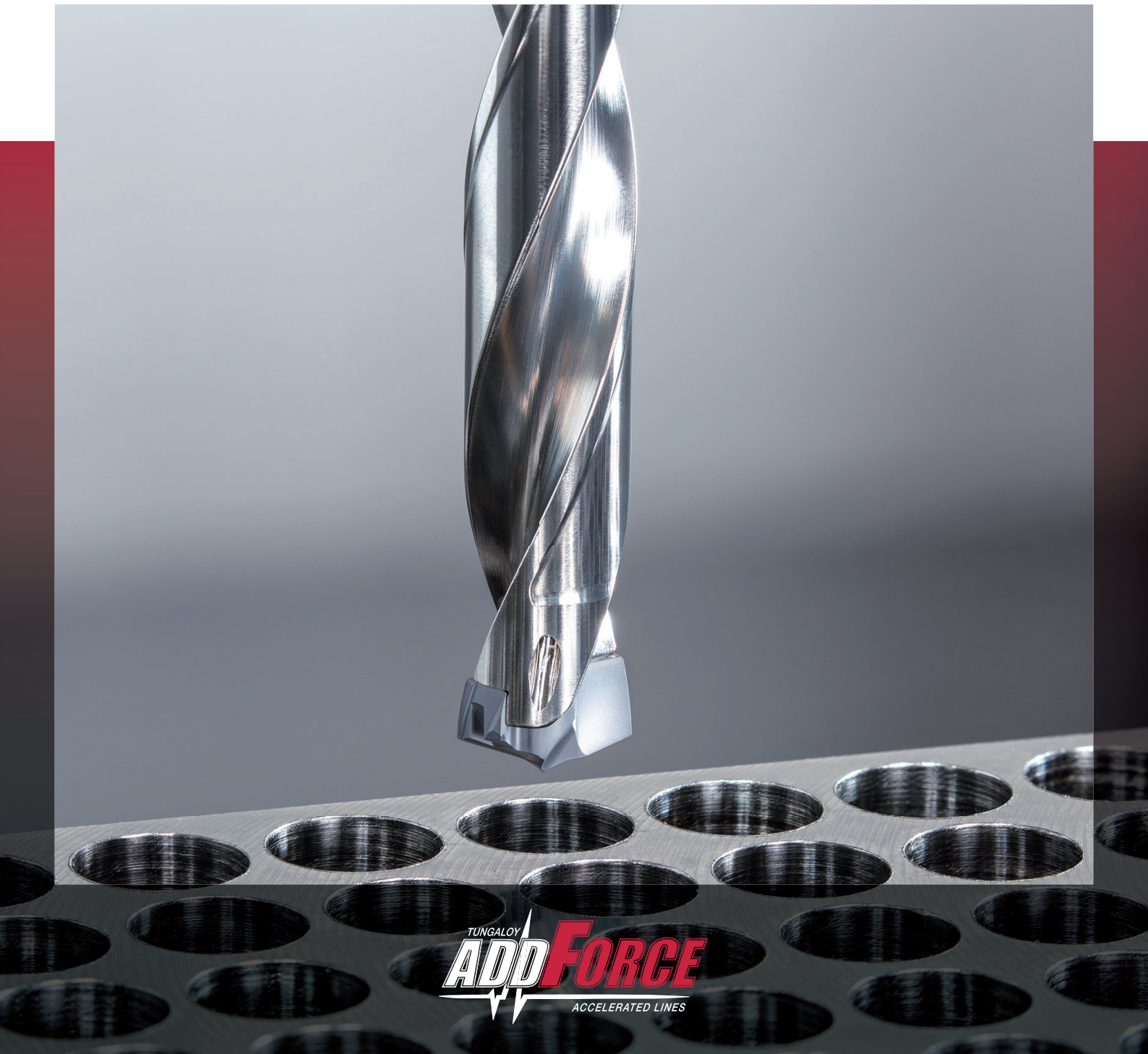


Exchangeable head drill

DRILLMEISTER / **ADD M** DRILL

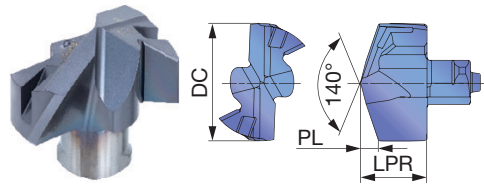
Tungaloy Report No. 412S7-US

Diameter expansion of DMP, DMC and DMF geometries with AH9130



DRILL HEADS

DMP General purpose



Tool diameter (inch)	Head diameter tolerance
ø0.236" - ø0.705"	+0.0007" / 0
ø0.709" - ø1.020"	+0.0008" / 0
Tool diameter (mm)	Head diameter tolerance
ø6 - ø17.9	+0.018 / 0
ø18 - ø25.9	+0.021 / 0



For more information

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

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

★ : First choice

Designation	DC (in)	DC (mm)	LPR (mm)	Coated		PL (mm)	Body
				AH9130			
New DMP060	0.236	6	3.85	●		1.09	TID*060...
New DMP061	0.240	6.1	3.85	●		1.11	TID*060...
New DMP062	0.244	6.2	3.85	●		1.13	TID*060...
New DMP063	0.248	6.3	3.85	●		1.14	TID*060...
New DMP064	0.252	6.4	3.85	●		1.16	TID*060...
New DMP065	0.256	6.5	4.15	●		1.27	TID*065...
New DMP066	0.260	6.6	4.15	●		1.29	TID*065...
New DMP067	0.264	6.7	4.15	●		1.31	TID*065...
DMP068	0.268	6.8	4.15	●		1.33	TID*065...
New DMP069	0.272	6.9	4.15	●		1.34	TID*065...
New DMP070	0.276	7	4.45	●		1.03	TID*070...
New DMP071	0.280	7.1	4.45	●		1.05	TID*070...
New DMP072	0.283	7.2	4.45	●		1.07	TID*070...
New DMP073	0.287	7.3	4.45	●		1.08	TID*070...
New DMP074	0.291	7.4	4.45	●		1.1	TID*070...
DMP075	0.295	7.5	4.45	●		1.12	TID*075...
New DMP076	0.299	7.6	4.45	●		1.14	TID*075...
New DMP077	0.303	7.7	4.45	●		1.16	TID*075...
New DMP078	0.307	7.8	4.45	●		1.18	TID*075...
New DMP079	0.311	7.9	4.45	●		1.19	TID*075...
DMP080	0.315	8	5.25	●		1.2	TID*080...
New DMP081	0.319	8.1	5.25	●		1.22	TID*080...
New DMP082	0.323	8.2	5.25	●		1.24	TID*080...
New DMP083	0.327	8.3	5.25	●		1.25	TID*080...
New DMP084	0.331	8.4	5.25	●		1.27	TID*080...
DMP085	0.335	8.5	5.25	●		1.29	TID*085...
New DMP086	0.339	8.6	5.25	●		1.31	TID*085...
New DMP087	0.343	8.7	5.25	●		1.33	TID*085...
New DMP088	0.346	8.8	5.25	●		1.35	TID*085...
New DMP089	0.350	8.9	5.25	●		1.36	TID*085...
DMP090	0.354	9	5.65	●		1.37	TID*090...
New DMP091	0.358	9.1	5.65	●		1.39	TID*090...
New DMP092	0.362	9.2	5.65	●		1.41	TID*090...
New DMP093	0.366	9.3	5.65	●		1.42	TID*090...
New DMP094	0.370	9.4	5.65	●		1.44	TID*090...
DMP095	0.374	9.5	5.65	●		1.46	TID*095...
New DMP096	0.378	9.6	5.65	●		1.48	TID*095...

Designation	DC (in)	DC (mm)	LPR (mm)	Coated		PL (mm)	Body
				AH9130			
New DMP097	0.382	9.7	5.65	●		1.5	TID*095...
New DMP098	0.386	9.8	5.65	●		1.52	TID*095...
New DMP099	0.390	9.9	5.65	●		1.53	TID*095...
DMP100	0.394	10	6.05	●		1.47	TID*100...
DMP101	0.398	10.1	6.05	●		1.49	TID*100...
DMP102	0.402	10.2	6.05	●		1.51	TID*100...
DMP103	0.406	10.3	6.05	●		1.52	TID*100...
DMP104	0.409	10.4	6.05	●		1.54	TID*100...
DMP105	0.413	10.5	6.05	●		1.56	TID*105...
DMP106	0.417	10.6	6.05	●		1.58	TID*105...
DMP107	0.421	10.7	6.05	●		1.6	TID*105...
DMP108	0.425	10.8	6.05	●		1.62	TID*105...
DMP109	0.429	10.9	6.05	●		1.63	TID*105...
DMP110	0.433	11	6.45	●		1.67	TID*110...
DMP111	0.437	11.1	6.45	●		1.69	TID*110...
DMP112	0.441	11.2	6.45	●		1.71	TID*110...
DMP113	0.445	11.3	6.45	●		1.72	TID*110...
DMP114	0.449	11.4	6.45	●		1.74	TID*110...
DMP115	0.453	11.5	6.45	●		1.76	TID*115...
DMP116	0.457	11.6	6.45	●		1.78	TID*115...
DMP117	0.461	11.7	6.45	●		1.8	TID*115...
DMP118	0.465	11.8	6.45	●		1.82	TID*115...
DMP119	0.469	11.9	6.45	●		1.83	TID*115...
DMP120	0.472	12	6.8	●		1.82	TID*120...
DMP121	0.476	12.1	6.8	●		1.84	TID*120...
DMP122	0.480	12.2	6.8	●		1.86	TID*120...
DMP123	0.484	12.3	6.8	●		1.87	TID*120...
DMP124	0.488	12.4	6.8	●		1.89	TID*120...
DMP125	0.492	12.5	6.8	●		1.91	TID*125...
DMP126	0.496	12.6	6.8	●		1.93	TID*125...
DMP127	0.500	12.7	6.8	●		1.95	TID*125...
DMP128	0.504	12.8	6.8	●		1.97	TID*125...
DMP129	0.508	12.9	6.8	●		1.98	TID*125...
DMP130	0.512	13	7.4	●		1.96	TID*130...
DMP131	0.516	13.1	7.4	●		1.98	TID*130...
DMP132	0.520	13.2	7.4	●		2	TID*130...
DMP133	0.524	13.3	7.4	●		2.01	TID*130...

Package Quantity: 0.236" - 0.783" = 2 pcs.
0.787" - 1.020" = 1 pc.

● : New product
● : Line up

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

Designation	DC (in)	DC (mm)	LPR (mm)	Coated		PL (mm)	Body
				AH9130			
DMP134	0.528	13.4	7.4	●		2.03	TID*130...
DMP135	0.531	13.5	7.4	●		2.05	TID*135...
DMP136	0.535	13.6	7.4	●		2.07	TID*135...
DMP137	0.539	13.7	7.4	●		2.09	TID*135...
DMP138	0.543	13.8	7.4	●		2.11	TID*135...
DMP139	0.547	13.9	7.4	●		2.12	TID*135...
DMP140	0.551	14	7.95	●		2.12	TID*140...
DMP141	0.555	14.1	7.95	●		2.14	TID*140...
DMP142	0.559	14.2	7.95	●		2.16	TID*140...
DMP143	0.563	14.3	7.95	●		2.17	TID*140...
DMP144	0.567	14.4	7.95	●		2.19	TID*140...
DMP145	0.571	14.5	7.95	●		2.21	TID*145...
DMP146	0.575	14.6	7.95	●		2.23	TID*145...
DMP147	0.579	14.7	7.95	●		2.25	TID*145...
DMP148	0.583	14.8	7.95	●		2.27	TID*145...
DMP149	0.587	14.9	7.95	●		2.28	TID*145...
DMP150	0.591	15	8.53	●		2.27	TID*150...
DMP151	0.594	15.1	8.53	●		2.29	TID*150...
DMP152	0.598	15.2	8.53	●		2.31	TID*150...
DMP153	0.602	15.3	8.53	●		2.32	TID*150...
DMP154	0.606	15.4	8.53	●		2.34	TID*150...
DMP155	0.610	15.5	8.53	●		2.36	TID*150...
DMP156	0.614	15.6	8.53	●		2.38	TID*150...
DMP157	0.618	15.7	8.53	●		2.4	TID*150...
DMP158	0.622	15.8	8.53	●		2.42	TID*150...
DMP159	0.626	15.9	8.53	●		2.43	TID*150...
DMP160	0.630	16	9.1	●		2.42	TID*160...
DMP161	0.634	16.1	9.1	●		2.44	TID*160...
DMP162	0.638	16.2	9.1	●		2.46	TID*160...
DMP163	0.642	16.3	9.1	●		2.47	TID*160...
DMP164	0.646	16.4	9.1	●		2.49	TID*160...
DMP165	0.650	16.5	9.1	●		2.51	TID*160...
DMP166	0.654	16.6	9.1	●		2.53	TID*160...
DMP167	0.657	16.7	9.1	●		2.55	TID*160...
DMP168	0.661	16.8	9.1	●		2.57	TID*160...
DMP169	0.665	16.9	9.1	●		2.58	TID*160...
DMP170	0.669	17	9.7	●		2.59	TID*170...
DMP171	0.673	17.1	9.7	●		2.61	TID*170...
DMP172	0.677	17.2	9.7	●		2.63	TID*170...
DMP173	0.681	17.3	9.7	●		2.64	TID*170...
DMP174	0.685	17.4	9.7	●		2.66	TID*170...
DMP175	0.689	17.5	9.7	●		2.68	TID*170...
DMP176	0.693	17.6	9.7	●		2.7	TID*170...
DMP177	0.697	17.7	9.7	●		2.72	TID*170...
DMP178	0.701	17.8	9.7	●		2.74	TID*170...
DMP179	0.705	17.9	9.7	●		2.75	TID*170...
DMP180	0.709	18	10.3	●		2.73	TID*180...
DMP181	0.713	18.1	10.3	●		2.75	TID*180...
DMP182	0.717	18.2	10.3	●		2.77	TID*180...
DMP183	0.720	18.3	10.3	●		2.78	TID*180...
DMP184	0.724	18.4	10.3	●		2.8	TID*180...
DMP185	0.728	18.5	10.3	●		2.82	TID*180...
DMP186	0.732	18.6	10.3	●		2.84	TID*180...

Package Quantity: 0.236" - 0.783" = 2 pcs.
0.787" - 1.020" = 1 pc.

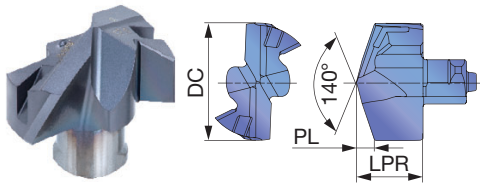
P	Steel	★		
M	Stainless	★		
K	Cast iron	★		
N	Non-ferrous			
S	Superalloys	★		
H	Hard materials	★		

★ : First choice

Designation	DC (in)	DC (mm)	LPR (mm)	Coated		PL (mm)	Body
				AH9130			
DMP187	0.736	18.7	10.3	●		2.86	TID*180...
DMP188	0.740	18.8	10.3	●		2.88	TID*180...
DMP189	0.744	18.9	10.3	●		2.89	TID*180...
DMP190	0.748	19	10.8	●		2.88	TID*190...
DMP1905	0.750	19.05	10.8	●		2.89	TID*190...
DMP191	0.752	19.1	10.8	●		2.9	TID*190...
DMP192	0.756	19.2	10.8	●		2.92	TID*190...
DMP193	0.760	19.3	10.8	●		2.93	TID*190...
DMP194	0.764	19.4	10.8	●		2.95	TID*190...
DMP195	0.768	19.5	10.8	●		2.97	TID*190...
DMP196	0.772	19.6	10.8	●		2.99	TID*190...
DMP197	0.776	19.7	10.8	●		3.01	TID*190...
DMP198	0.780	19.8	10.8	●		3.03	TID*190...
DMP199	0.783	19.9	10.8	●		3.04	TID*190...
DMP200	0.787	20	11.4	●		3.02	TID*200...
DMP201	0.791	20.1	11.4	●		3.04	TID*200...
DMP202	0.795	20.2	11.4	●		3.06	TID*200...
DMP203	0.799	20.3	11.4	●		3.07	TID*200...
DMP204	0.803	20.4	11.4	●		3.09	TID*200...
DMP205	0.807	20.5	11.4	●		3.11	TID*200...
DMP206	0.811	20.6	11.4	●		3.13	TID*200...
DMP207	0.815	20.7	11.4	●		3.15	TID*200...
DMP208	0.819	20.8	11.4	●		3.17	TID*200...
DMP209	0.823	20.9	11.4	●		3.18	TID*200...
DMP210	0.827	21	11.98	●		3.18	TID*210...
DMP211	0.831	21.1	11.98	●		3.2	TID*210...
DMP212	0.835	21.2	11.98	●		3.22	TID*210...
DMP213	0.839	21.3	11.98	●		3.23	TID*210...
DMP214	0.843	21.4	11.98	●		3.25	TID*210...
DMP215	0.846	21.5	11.98	●		3.27	TID*210...
DMP216	0.850	21.6	11.98	●		3.29	TID*210...
DMP217	0.854	21.7	11.98	●		3.31	TID*210...
DMP218	0.858	21.8	11.98	●		3.33	TID*210...
DMP219	0.862	21.9	11.98	●		3.34	TID*210...
DMP220	0.866	22	12.56	●		3.32	TID*220...
DMP221	0.870	22.1	12.56	●		3.34	TID*220...
DMP222	0.874	22.2	12.56	●		3.36	TID*220...
DMP223	0.878	22.3	12.56	●		3.37	TID*220...
DMP224	0.882	22.4	12.56	●		3.39	TID*220...
DMP225	0.886	22.5	12.56	●		3.41	TID*220...
DMP226	0.890	22.6	12.56	●		3.43	TID*220...
DMP227	0.894	22.7	12.56	●		3.45	TID*220...
DMP228	0.898	22.8	12.56	●		3.47	TID*220...
DMP229	0.902	22.9	12.56	●		3.48	TID*220...
DMP230	0.906	23	13.13	●		3.46	TID*230...
DMP231	0.909	23.1	13.13	●		3.48	TID*230...
DMP232	0.913	23.2	13.13	●		3.5	TID*230...
DMP233	0.917	23.3	13.13	●		3.51	TID*230...
DMP234	0.921	23.4	13.13	●		3.53	TID*230...
DMP235	0.925	23.5	13.13	●		3.55	TID*230...
DMP236	0.929	23.6	13.13	●		3.57	TID*230...
DMP237	0.933	23.7	13.13	●		3.59	TID*230...
DMP238	0.937	23.8	13.13	●		3.61	TID*230...

● : Line up

DMP General purpose



Tool diameter (inch)	Head diameter tolerance
ø0.236" - ø0.705"	+0.0007" / 0
ø0.709" - ø1.020"	+0.0008" / 0
Tool diameter (mm)	Head diameter tolerance
ø6 - ø17.9	+0.018 / 0
ø18 - ø25.9	+0.021 / 0

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

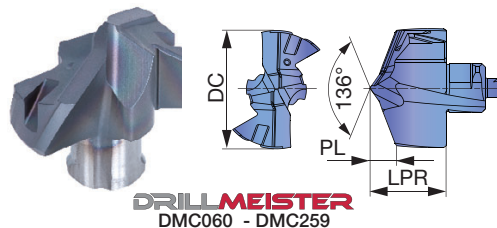
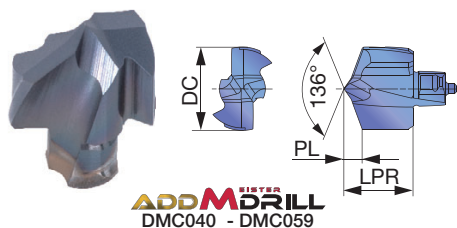
★ : First choice

Designation	DC (in)	DC (mm)	LPR (mm)	Coated		PL (mm)	Body
				AH9130			
DMP239	0.941	23.9	13.13	●		3.62	TID*230...
DMP240	0.945	24	13.7	●		3.62	TID*240...
DMP241	0.949	24.1	13.7	●		3.64	TID*240...
DMP242	0.953	24.2	13.7	●		3.66	TID*240...
DMP243	0.957	24.3	13.7	●		3.67	TID*240...
DMP244	0.961	24.4	13.7	●		3.69	TID*240...
DMP245	0.965	24.5	13.7	●		3.71	TID*240...
DMP246	0.969	24.6	13.7	●		3.73	TID*240...
DMP247	0.972	24.7	13.7	●		3.75	TID*240...
DMP248	0.976	24.8	13.7	●		3.77	TID*240...
DMP249	0.980	24.9	13.7	●		3.78	TID*240...
DMP250	0.984	25	14.3	●		3.8	TID*250...
DMP251	0.988	25.1	14.3	●		3.82	TID*250...
DMP252	0.992	25.2	14.3	●		3.84	TID*250...
DMP253	0.996	25.3	14.3	●		3.85	TID*250...
DMP254	1.000	25.4	14.3	●		3.87	TID*250...
DMP255	1.004	25.5	14.3	●		3.89	TID*250...
DMP256	1.008	25.6	14.3	●		3.91	TID*250...
DMP2567	1.011	25.67	14.3	●		3.92	TID*250...
DMP257	1.012	25.7	14.3	●		3.93	TID*250...
DMP258	1.016	25.8	14.3	●		3.95	TID*250...
DMP259	1.020	25.9	14.3	●		3.96	TID*250...

Package Quantity: 0.236" - 0.783" = 2 pcs.
0.787" - 1.020" = 1 pc.

● : Line up

DMC High precision hole making



Tool diameter (inch)	Head diameter tolerance
ø0.157" - ø0.705"	+0.0007" / 0
ø0.709" - ø1.020"	+0.0008" / 0

Tool diameter (mm)	Head diameter tolerance
ø4 - ø17.9	+0.018 / 0
ø18 - ø25.9	+0.021 / 0

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

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

★ : First choice
☆ : Second choice

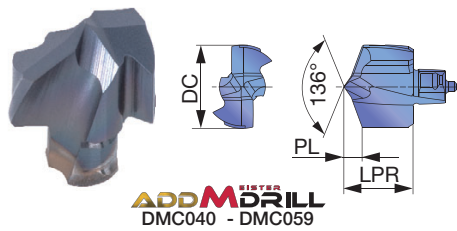
Designation	DC (in)	DC (mm)	LPR (mm)	Coated		PL (mm)	Body
				AH9130			
New DMC040	0.157	4	3.51	●		0.86	TID*040...
New DMC041	0.161	4.1	3.51	●		0.88	TID*040...
New DMC042	0.165	4.2	3.51	●		0.9	TID*040...
New DMC043	0.169	4.3	3.51	●		0.92	TID*040...
New DMC044	0.173	4.4	3.51	●		0.94	TID*040...
New DMC045	0.177	4.5	3.81	●		0.97	TID*045...
New DMC046	0.181	4.6	3.81	●		0.99	TID*045...
New DMC047	0.185	4.7	3.81	●		1.01	TID*045...
New DMC048	0.189	4.8	3.81	●		1.03	TID*045...
New DMC049	0.193	4.9	3.81	●		1.05	TID*045...
DMC050	0.197	5	4.14	●		1.09	TID*050...
DMC051	0.201	5.1	4.14	●		1.11	TID*050...
DMC052	0.205	5.2	4.14	●		1.13	TID*050...
DMC053	0.209	5.3	4.14	●		1.15	TID*050...
DMC054	0.213	5.4	4.14	●		1.17	TID*050...
DMC055	0.217	5.5	4.17	●		1.22	TID*055...
DMC056	0.220	5.6	4.17	●		1.24	TID*055...
DMC057	0.224	5.7	4.17	●		1.26	TID*055...
DMC058	0.228	5.8	4.17	●		1.28	TID*055...
DMC059	0.232	5.9	4.17	●		1.3	TID*055...
DMC060	0.236	6	4	●		1.24	TID*060...
DMC061	0.240	6.1	4	●		1.26	TID*060...
DMC062	0.244	6.2	4	●		1.28	TID*060...
DMC063	0.248	6.3	4	●		1.3	TID*060...
DMC064	0.252	6.4	4	●		1.32	TID*060...
DMC065	0.256	6.5	4.3	●		1.33	TID*065...
DMC066	0.260	6.6	4.3	●		1.35	TID*065...
DMC067	0.264	6.7	4.3	●		1.37	TID*065...
DMC068	0.268	6.8	4.3	●		1.39	TID*065...
DMC069	0.272	6.9	4.3	●		1.41	TID*065...
DMC070	0.276	7	4.9	●		1.48	TID*070...
DMC071	0.280	7.1	4.9	●		1.5	TID*070...
DMC072	0.283	7.2	4.9	●		1.52	TID*070...
DMC073	0.287	7.3	4.9	●		1.54	TID*070...
DMC074	0.291	7.4	4.9	●		1.56	TID*070...
DMC075	0.295	7.5	4.9	●		1.58	TID*075...
DMC076	0.299	7.6	4.9	●		1.6	TID*075...
DMC077	0.303	7.7	4.9	●		1.62	TID*075...

Designation	DC (in)	DC (mm)	LPR (mm)	Coated		PL (mm)	Body
				AH9130			
DMC078	0.307	7.8	4.9	●		1.64	TID*075...
DMC079	0.311	7.9	4.9	●		1.66	TID*075...
DMC080	0.315	8	5.4	●		1.62	TID*080...
DMC081	0.319	8.1	5.4	●		1.64	TID*080...
DMC082	0.323	8.2	5.4	●		1.66	TID*080...
DMC083	0.327	8.3	5.4	●		1.68	TID*080...
DMC084	0.331	8.4	5.4	●		1.7	TID*080...
DMC085	0.335	8.5	5.4	●		1.72	TID*085...
DMC086	0.339	8.6	5.4	●		1.74	TID*085...
DMC087	0.343	8.7	5.4	●		1.76	TID*085...
DMC088	0.346	8.8	5.4	●		1.78	TID*085...
DMC089	0.350	8.9	5.4	●		1.8	TID*085...
DMC090	0.354	9	5.8	●		1.91	TID*090...
DMC091	0.358	9.1	5.8	●		1.93	TID*090...
DMC092	0.362	9.2	5.8	●		1.95	TID*090...
DMC093	0.366	9.3	5.8	●		1.97	TID*090...
DMC094	0.370	9.4	5.8	●		1.99	TID*090...
DMC095	0.374	9.5	5.8	●		2.01	TID*095...
DMC096	0.378	9.6	5.8	●		2.03	TID*095...
DMC097	0.382	9.7	5.8	●		2.05	TID*095...
DMC098	0.386	9.8	5.8	●		2.07	TID*095...
DMC099	0.390	9.9	5.8	●		2.09	TID*095...
DMC100	0.394	10	6.67	●		2.09	TID*100...
DMC101	0.398	10.1	6.67	●		2.11	TID*100...
DMC102	0.402	10.2	6.67	●		2.13	TID*100...
DMC103	0.406	10.3	6.67	●		2.15	TID*100...
DMC104	0.409	10.4	6.67	●		2.17	TID*100...
DMC105	0.413	10.5	6.67	●		2.19	TID*105...
DMC106	0.417	10.6	6.67	●		2.21	TID*105...
DMC107	0.421	10.7	6.67	●		2.23	TID*105...
DMC108	0.425	10.8	6.67	●		2.25	TID*105...
DMC109	0.429	10.9	6.67	●		2.27	TID*105...
DMC110	0.433	11	7.1	●		2.32	TID*110...
DMC111	0.437	11.1	7.1	●		2.34	TID*110...
DMC112	0.441	11.2	7.1	●		2.36	TID*110...
DMC113	0.445	11.3	7.1	●		2.38	TID*110...
DMC114	0.449	11.4	7.1	●		2.4	TID*110...
DMC115	0.453	11.5	7.1	●		2.42	TID*115...

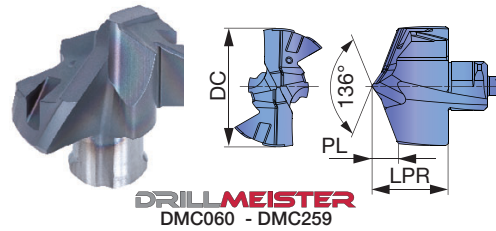
Package Quantity: 0.157" - 0.783" = 2 pcs.
0.787" - 1.020" = 1 pc.

● : New product
● : Line up

DMC High precision hole making



ADDMEISTER
DMC040 - DMC059



DRILLMEISTER
DMC060 - DMC259

Tool diameter (inch)	Head diameter tolerance
ø0.157" - ø0.705"	+0.0007" / 0
ø0.709" - ø1.020"	+0.0008" / 0
Tool diameter (mm)	Head diameter tolerance
ø4 - ø17.9	+0.018 / 0
ø18 - ø25.9	+0.021 / 0

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

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

★ : First choice
☆ : Second choice

Designation	DC (in)	DC (mm)	LPR (mm)	Coated		PL (mm)	Body
				AH9130			
DMC116	0.457	11.6	7.1	●		2.44	TID*115...
DMC117	0.461	11.7	7.1	●		2.46	TID*115...
DMC118	0.465	11.8	7.1	●		2.48	TID*115...
DMC119	0.469	11.9	7.1	●		2.5	TID*115...
DMC120	0.472	12	7.43	●		2.45	TID*120...
DMC121	0.476	12.1	7.43	●		2.47	TID*120...
DMC122	0.480	12.2	7.43	●		2.49	TID*120...
DMC123	0.484	12.3	7.43	●		2.51	TID*120...
DMC124	0.488	12.4	7.43	●		2.53	TID*120...
DMC125	0.492	12.5	7.43	●		2.55	TID*125...
DMC126	0.496	12.6	7.43	●		2.57	TID*125...
DMC127	0.500	12.7	7.43	●		2.59	TID*125...
DMC128	0.504	12.8	7.43	●		2.61	TID*125...
DMC129	0.508	12.9	7.43	●		2.63	TID*125...
DMC130	0.512	13	8.15	●		2.71	TID*130...
DMC131	0.516	13.1	8.15	●		2.73	TID*130...
DMC132	0.520	13.2	8.15	●		2.75	TID*130...
DMC133	0.524	13.3	8.15	●		2.77	TID*130...
DMC134	0.528	13.4	8.15	●		2.79	TID*130...
DMC135	0.531	13.5	8.15	●		2.81	TID*135...
DMC136	0.535	13.6	8.15	●		2.83	TID*135...
DMC137	0.539	13.7	8.15	●		2.85	TID*135...
DMC138	0.543	13.8	8.15	●		2.87	TID*135...
DMC139	0.547	13.9	8.15	●		2.89	TID*135...
DMC140	0.551	14	8.76	●		2.93	TID*140...
DMC141	0.555	14.1	8.76	●		2.95	TID*140...
DMC142	0.559	14.2	8.76	●		2.97	TID*140...
DMC143	0.563	14.3	8.76	●		2.99	TID*140...
DMC144	0.567	14.4	8.76	●		3.01	TID*140...
DMC145	0.571	14.5	8.76	●		3.03	TID*145...
DMC146	0.575	14.6	8.76	●		3.05	TID*145...
DMC147	0.579	14.7	8.76	●		3.07	TID*145...
DMC148	0.583	14.8	8.76	●		3.09	TID*145...
DMC149	0.587	14.9	8.76	●		3.11	TID*145...
DMC150	0.591	15	9.44	●		3.18	TID*150...
DMC151	0.594	15.1	9.44	●		3.2	TID*150...
DMC152	0.598	15.2	9.44	●		3.22	TID*150...
DMC153	0.602	15.3	9.44	●		3.24	TID*150...
DMC154	0.606	15.4	9.44	●		3.26	TID*150...

Designation	DC (in)	DC (mm)	LPR (mm)	Coated		PL (mm)	Body
				AH9130			
DMC155	0.610	15.5	9.44	●		3.28	TID*150...
DMC156	0.614	15.6	9.44	●		3.3	TID*150...
DMC157	0.618	15.7	9.44	●		3.32	TID*150...
DMC158	0.622	15.8	9.44	●		3.34	TID*150...
DMC159	0.626	15.9	9.44	●		3.36	TID*150...
DMC160	0.630	16	10.07	●		3.39	TID*160...
DMC161	0.634	16.1	10.07	●		3.41	TID*160...
DMC162	0.638	16.2	10.07	●		3.43	TID*160...
DMC163	0.642	16.3	10.07	●		3.45	TID*160...
DMC164	0.646	16.4	10.07	●		3.47	TID*160...
DMC165	0.650	16.5	10.07	●		3.49	TID*160...
DMC166	0.654	16.6	10.07	●		3.51	TID*160...
DMC167	0.657	16.7	10.07	●		3.53	TID*160...
DMC168	0.661	16.8	10.07	●		3.55	TID*160...
DMC169	0.665	16.9	10.07	●		3.57	TID*160...
DMC170	0.669	17	10.68	●		3.57	TID*170...
DMC171	0.673	17.1	10.68	●		3.59	TID*170...
DMC172	0.677	17.2	10.68	●		3.61	TID*170...
DMC173	0.681	17.3	10.68	●		3.63	TID*170...
DMC174	0.685	17.4	10.68	●		3.65	TID*170...
DMC175	0.689	17.5	10.68	●		3.67	TID*170...
DMC176	0.693	17.6	10.68	●		3.69	TID*170...
DMC177	0.697	17.7	10.68	●		3.71	TID*170...
DMC178	0.701	17.8	10.68	●		3.73	TID*170...
DMC179	0.705	17.9	10.68	●		3.75	TID*170...
DMC180	0.709	18	11.35	●		3.78	TID*180...
DMC181	0.713	18.1	11.35	●		3.8	TID*180...
DMC182	0.717	18.2	11.35	●		3.82	TID*180...
DMC183	0.720	18.3	11.35	●		3.84	TID*180...
DMC184	0.724	18.4	11.35	●		3.86	TID*180...
DMC185	0.728	18.5	11.35	●		3.88	TID*180...
DMC186	0.732	18.6	11.35	●		3.9	TID*180...
DMC187	0.736	18.7	11.35	●		3.92	TID*180...
DMC188	0.740	18.8	11.35	●		3.94	TID*180...
DMC189	0.744	18.9	11.35	●		3.96	TID*180...
DMC190	0.748	19	11.91	●		3.99	TID*190...
DMC191	0.752	19.1	11.91	●		4.01	TID*190...
DMC192	0.756	19.2	11.91	●		4.03	TID*190...
DMC1927	0.759	19.27	11.91	●		4.04	TID*190...

Package Quantity: 0.157" - 0.783" = 2 pcs.
0.787" - 1.020" = 1 pc.

● : Line up

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

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

★ : First choice
☆ : Second choice

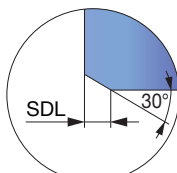
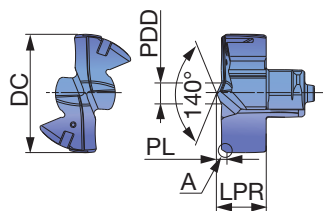
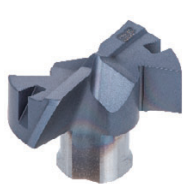
Designation	DC (in)	DC (mm)	LPR (mm)	Coated		PL (mm)	Body
				AH9130			
DMC193	0.760	19.3	11.91	●		4.05	TID*190...
DMC194	0.764	19.4	11.91	●		4.07	TID*190...
DMC195	0.768	19.5	11.91	●		4.09	TID*190...
DMC196	0.772	19.6	11.91	●		4.11	TID*190...
DMC197	0.776	19.7	11.91	●		4.13	TID*190...
DMC198	0.780	19.8	11.91	●		4.15	TID*190...
DMC199	0.783	19.9	11.91	●		4.17	TID*190...
DMC200	0.787	20	12.62	●		4.24	TID*200...
DMC201	0.791	20.1	12.62	●		4.26	TID*200...
New DMC202	0.795	20.2	12.62	●		4.28	TID*200...
New DMC203	0.799	20.3	12.62	●		4.3	TID*200...
New DMC204	0.803	20.4	12.62	●		4.32	TID*200...
DMC205	0.807	20.5	12.62	●		4.34	TID*200...
DMC206	0.811	20.6	12.62	●		4.36	TID*200...
New DMC207	0.815	20.7	12.62	●		4.38	TID*200...
New DMC208	0.819	20.8	12.62	●		4.4	TID*200...
New DMC209	0.823	20.9	12.62	●		4.42	TID*200...
DMC210	0.827	21	13.2	●		4.4	TID*210...
DMC211	0.831	21.1	13.2	●		4.42	TID*210...
New DMC212	0.835	21.2	13.2	●		4.44	TID*210...
New DMC213	0.839	21.3	13.2	●		4.46	TID*210...
New DMC214	0.843	21.4	13.2	●		4.48	TID*210...
DMC215	0.846	21.5	13.2	●		4.5	TID*210...
New DMC216	0.850	21.6	13.2	●		4.52	TID*210...
DMC217	0.854	21.7	13.2	●		4.54	TID*210...
DMC218	0.858	21.8	13.2	●		4.56	TID*210...
New DMC219	0.862	21.9	13.2	●		4.58	TID*210...
DMC220	0.866	22	13.84	●		4.6	TID*220...
DMC221	0.870	22.1	13.84	●		4.62	TID*220...
DMC222	0.874	22.2	13.84	●		4.64	TID*220...
DMC223	0.878	22.3	13.84	●		4.66	TID*220...
New DMC224	0.882	22.4	13.84	●		4.68	TID*220...
DMC225	0.886	22.5	13.84	●		4.7	TID*220...
New DMC226	0.890	22.6	13.84	●		4.72	TID*220...
New DMC227	0.894	22.7	13.84	●		4.74	TID*220...
New DMC228	0.898	22.8	13.84	●		4.76	TID*220...
New DMC229	0.902	22.9	13.84	●		4.78	TID*220...
DMC230	0.906	23	14.51	●		4.84	TID*230...
New DMC231	0.909	23.1	14.51	●		4.84	TID*220...
New DMC232	0.913	23.2	14.51	●		4.86	TID*230...
New DMC233	0.917	23.3	14.51	●		4.88	TID*220...
New DMC234	0.921	23.4	14.51	●		4.9	TID*230...
DMC235	0.925	23.5	14.51	●		4.94	TID*230...
New DMC236	0.929	23.6	14.51	●		4.94	TID*230...
New DMC237	0.933	23.7	14.51	●		4.96	TID*230...
New DMC238	0.937	23.8	14.51	●		4.98	TID*230...
New DMC239	0.941	23.9	14.51	●		5	TID*230...
DMC240	0.945	24	15.11	●		5.03	TID*240...
New DMC241	0.949	24.1	15.11	●		5.24	TID*240...
New DMC243	0.957	24.3	15.11	●		5.28	TID*240...
New DMC244	0.961	24.4	15.11	●		5.3	TID*240...
DMC245	0.965	24.5	15.11	●		5.13	TID*240...
New DMC246	0.969	24.6	15.11	●		5.34	TID*240...

Package Quantity: 0.157" - 0.783" = 2 pcs.
0.787" - 1.020" = 1 pc.

Designation	DC (in)	DC (mm)	LPR (mm)	Coated		PL (mm)	Body
				AH9130			
New DMC247	0.972	24.7	15.11	●		5.36	TID*240...
New DMC248	0.976	24.8	15.11	●		5.38	TID*240...
New DMC249	0.980	24.9	15.11	●		5.4	TID*240...
DMC250	0.984	25	15.78	●		5.28	TID*250...
New DMC251	0.988	25.1	15.78	●		5.71	TID*250...
New DMC252	0.992	25.2	15.78	●		5.73	TID*250...
DMC253	0.996	25.3	15.78	●		5.34	TID*250...
New DMC254	1.000	25.4	15.78	●		5.77	TID*250...
DMC255	1.004	25.5	15.78	●		5.38	TID*250...
New DMC256	1.008	25.6	15.78	●		5.81	TID*250...
DMC2567	1.011	25.67	15.78	●		5.42	TID*250...
New DMC257	1.012	25.7	15.78	●		5.83	TID*250...
New DMC258	1.016	25.8	15.78	●		5.85	TID*250...
DMC259	1.020	25.9	15.78	●		5.46	TID*250...

● : New product
● : Line up

DMF Flat geometry head



Detail in A

Tool diameter (inch)	Head diameter tolerance
ø0.236" - ø0.705"	+0.0007" / 0
ø0.709" - ø1.020"	+0.0008" / 0

Tool diameter (mm)	Head diameter tolerance
ø6 - ø17.9	+0.018 / 0
ø18 - ø25.9	+0.021 / 0

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

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

★ : First choice
☆ : Second choice

Designation	DC (in)	DC (mm)	LPR (mm)	Coated		SDL (mm)	PL (mm)	PDD (mm)	Body
				AH9130					
DMF060	0.236	6	3.01	●		0.4	0.61	1.15	TID*060...
DMF061	0.240	6.1	3.01	●		0.4	0.61	1.15	TID*060...
DMF062	0.244	6.2	3.01	●		0.4	0.61	1.15	TID*060...
DMF063	0.248	6.3	3.01	●		0.4	0.61	1.15	TID*060...
DMF064	0.252	6.4	3.01	●		0.4	0.61	1.15	TID*060...
DMF065	0.256	6.5	3.28	●		0.4	0.68	1.54	TID*065...
DMF066	0.260	6.6	3.28	●		0.4	0.68	1.54	TID*065...
DMF067	0.264	6.7	3.28	●		0.4	0.68	1.54	TID*065...
DMF068	0.268	6.8	3.28	●		0.4	0.68	1.54	TID*065...
DMF069	0.272	6.9	3.28	●		0.4	0.68	1.54	TID*065...
DMF070	0.276	7	3.58	●		0.4	0.68	1.54	TID*070...
DMF071	0.280	7.1	3.58	●		0.4	0.68	1.54	TID*070...
DMF072	0.283	7.2	3.58	●		0.4	0.68	1.54	TID*070...
DMF073	0.287	7.3	3.58	●		0.4	0.68	1.54	TID*070...
DMF074	0.291	7.4	3.58	●		0.4	0.68	1.54	TID*070...
DMF075	0.295	7.5	3.58	●		0.4	0.68	1.54	TID*075...
DMF076	0.299	7.6	3.58	●		0.4	0.68	1.54	TID*075...
DMF078	0.307	7.8	3.58	●		0.4	0.68	1.54	TID*075...
DMF079	0.311	7.9	3.58	●		0.4	0.68	1.54	TID*075...
DMF080	0.315	8	4.39	●		0.7	1.09	2.44	TID*080...
DMF081	0.319	8.1	4.39	●		0.7	1.09	2.44	TID*080...
DMF082	0.323	8.2	4.39	●		0.7	1.09	2.44	TID*080...
DMF083	0.327	8.3	4.39	●		0.7	1.09	2.44	TID*080...
DMF084	0.331	8.4	4.39	●		0.7	1.09	2.44	TID*080...
DMF085	0.335	8.5	4.39	●		0.7	1.09	2.44	TID*085...
DMF086	0.339	8.6	4.39	●		0.7	1.09	2.44	TID*085...
DMF087	0.343	8.7	4.39	●		0.7	1.09	2.44	TID*085...
DMF088	0.346	8.8	4.39	●		0.7	1.09	2.44	TID*085...
DMF089	0.350	8.9	4.39	●		0.7	1.09	2.44	TID*085...
DMF090	0.354	9	4.61	●		0.7	1.11	2.55	TID*090...
DMF091	0.358	9.1	4.61	●		0.7	1.11	2.55	TID*090...
DMF092	0.362	9.2	4.61	●		0.7	1.11	2.55	TID*090...
DMF093	0.366	9.3	4.61	●		0.7	1.11	2.55	TID*090...
DMF094	0.370	9.4	4.61	●		0.7	1.11	2.55	TID*090...
DMF095	0.374	9.5	4.61	●		0.7	1.11	2.55	TID*095...
DMF096	0.378	9.6	4.61	●		0.7	1.11	2.55	TID*095...
DMF097	0.382	9.7	4.61	●		0.7	1.11	2.55	TID*095...
DMF098	0.386	9.8	4.61	●		0.7	1.11	2.55	TID*095...
DMF099	0.390	9.9	4.61	●		0.7	1.11	2.55	TID*095...

Package Quantity: 0.236" - 0.780" = 2 pcs.
0.787" - 1.020" = 1 pc.

Designation	DC (in)	DC (mm)	LPR (mm)	Coated		SDL (mm)	PL (mm)	PDD (mm)	Body
				AH9130					
DMF100	0.394	10	4.72	●		0.7	1.17	2.89	TID*100...
DMF101	0.398	10.1	4.72	●		0.7	1.17	2.89	TID*100...
New DMF102	0.402	10.2	4.72	●		0.7	1.17	2.89	TID*100...
DMF103	0.406	10.3	4.72	●		0.7	1.17	2.89	TID*100...
DMF104	0.409	10.4	4.72	●		0.7	1.17	2.89	TID*100...
DMF105	0.413	10.5	4.72	●		0.7	1.17	2.89	TID*105...
DMF106	0.417	10.6	4.72	●		0.7	1.17	2.89	TID*105...
DMF107	0.421	10.7	4.72	●		0.7	1.17	2.89	TID*105...
DMF108	0.425	10.8	4.72	●		0.7	1.17	2.89	TID*105...
New DMF109	0.429	10.9	4.72	●		0.7	1.17	2.89	TID*105...
DMF110	0.433	11	4.9	●		0.7	1.25	2.98	TID*110...
New DMF111	0.437	11.1	4.9	●		0.7	1.25	2.98	TID*110...
New DMF112	0.441	11.2	4.9	●		0.7	1.25	2.98	TID*110...
New DMF113	0.445	11.3	4.9	●		0.7	1.25	2.98	TID*110...
New DMF114	0.449	11.4	4.9	●		0.7	1.25	2.98	TID*110...
DMF115	0.453	11.5	4.9	●		0.7	1.25	2.98	TID*115...
New DMF116	0.457	11.6	4.9	●		0.7	1.25	2.98	TID*115...
DMF117	0.461	11.7	4.9	●		0.7	1.25	2.98	TID*115...
New DMF118	0.465	11.8	4.9	●		0.7	1.25	2.98	TID*115...
New DMF119	0.469	11.9	4.9	●		0.7	1.25	2.98	TID*115...
DMF120	0.472	12	5.21	●		0.7	1.26	3.13	TID*120...
DMF121	0.476	12.1	5.21	●		0.7	1.26	3.13	TID*120...
DMF122	0.480	12.2	5.21	●		0.7	1.26	3.13	TID*120...
DMF123	0.484	12.3	5.21	●		0.7	1.26	3.13	TID*120...
DMF124	0.488	12.4	5.21	●		0.7	1.26	3.13	TID*120...
DMF125	0.492	12.5	5.21	●		0.7	1.26	3.13	TID*125...
DMF126	0.496	12.6	5.21	●		0.7	1.26	3.13	TID*125...
DMF127	0.500	12.7	5.21	●		0.7	1.26	3.13	TID*125...
New DMF128	0.504	12.8	5.21	●		0.7	1.26	3.13	TID*125...
New DMF129	0.508	12.9	5.21	●		0.7	1.26	3.13	TID*125...
DMF130	0.512	13	5.53	●		0.7	1.28	3.52	TID*130...
DMF131	0.516	13.1	5.53	●		0.7	1.28	3.52	TID*130...
New DMF132	0.520	13.2	5.53	●		0.7	1.28	3.52	TID*130...
DMF133	0.524	13.3	5.53	●		0.7	1.28	3.52	TID*130...
New DMF134	0.528	13.4	5.53	●		0.7	1.28	3.52	TID*130...
DMF135	0.531	13.5	5.53	●		0.7	1.28	3.52	TID*135...
New DMF136	0.535	13.6	5.53	●		0.7	1.28	3.52	TID*135...
DMF137	0.539	13.7	5.53	●		0.7	1.28	3.52	TID*135...
DMF138	0.543	13.8	5.53	●		0.7	1.28	3.52	TID*135...

● : New product
● : Line up

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

★ : First choice
☆ : Second choice

Designation	DC (in)	DC (mm)	LPR (mm)	Coated		SDL (mm)	PL (mm)	PDD (mm)	Body
				AH9130					
DMF139	0.547	13.9	5.53	●		0.7	1.28	3.52	TID*135...
DMF140	0.551	14	5.96	●		0.7	1.31	3.81	TID*140...
DMF141	0.555	14.1	5.96	●		0.7	1.31	3.81	TID*140...
DMF142	0.559	14.2	5.96	●		0.7	1.31	3.81	TID*140...
DMF143	0.563	14.3	5.96	●		0.7	1.31	3.81	TID*140...
DMF144	0.567	14.4	5.96	●		0.7	1.31	3.81	TID*140...
DMF145	0.571	14.5	5.96	●		0.7	1.31	3.81	TID*145...
DMF150	0.591	15	6.43	●		0.7	1.35	4.24	TID*150...
DMF152	0.598	15.2	6.43	●		0.7	1.35	4.24	TID*150...
DMF155	0.610	15.5	6.43	●		0.7	1.35	4.24	TID*150...
DMF157	0.618	15.7	6.43	●		0.7	1.35	4.24	TID*150...
DMF158	0.622	15.8	6.43	●		0.7	1.35	4.24	TID*150...
DMF160	0.630	16	6.84	●		0.7	1.39	4.06	TID*160...
DMF161	0.634	16.1	6.84	●		0.7	1.39	4.06	TID*160...
DMF165	0.650	16.5	6.84	●		0.7	1.39	4.06	TID*160...
DMF167	0.657	16.7	6.84	●		0.7	1.39	4.06	TID*160...
DMF170	0.669	17	7.15	●		0.7	1.4	4.14	TID*170...
DMF175	0.689	17.5	7.15	●		0.7	1.4	4.14	TID*170...
DMF179	0.705	17.9	7.15	●		0.7	1.4	4.14	TID*170...
DMF180	0.709	18	7.45	●		0.7	1.42	4.16	TID*180...
DMF185	0.728	18.5	7.45	●		0.7	1.42	4.16	TID*180...
DMF190	0.748	19	7.79	●		0.7	1.44	4.25	TID*190...
DMF195	0.768	19.5	7.79	●		0.7	1.44	4.25	TID*190...
DMF198	0.780	19.8	7.79	●		0.7	1.44	4.25	TID*190...
DMF200	0.787	20	9.12	●		0.7	1.77	6.56	TID*200...
DMF205	0.807	20.5	9.12	●		0.7	1.77	6.56	TID*200...
DMF210	0.827	21	9.54	●		0.7	1.79	6.92	TID*210...
DMF215	0.846	21.5	9.54	●		0.7	1.79	6.92	TID*210...
DMF218	0.858	21.8	9.54	●		0.7	1.79	6.92	TID*210...
DMF220	0.866	22	9.86	●		0.7	1.81	7.13	TID*220...
DMF225	0.886	22.5	9.86	●		0.7	1.81	7.13	TID*220...
DMF230	0.906	23	10.28	●		0.7	1.83	7.42	TID*230...
DMF235	0.925	23.5	10.28	●		0.7	1.83	7.42	TID*230...
DMF240	0.945	24	10.71	●		0.7	1.86	7.45	TID*240...
DMF245	0.965	24.5	10.71	●		0.7	1.86	7.45	TID*240...
DMF250	0.984	25	11.15	●		0.7	1.9	7.54	TID*250...
DMF254	1.000	25.4	11.15	●		0.7	1.9	7.54	TID*250...
DMF255	1.004	25.5	11.15	●		0.7	1.9	7.54	TID*250...
DMF259	1.020	25.9	11.15	●		0.7	1.9	7.54	TID*250...

Package Quantity: 0.236" - 0.780" = 2 pcs.
0.787" - 1.020" = 1 pc.

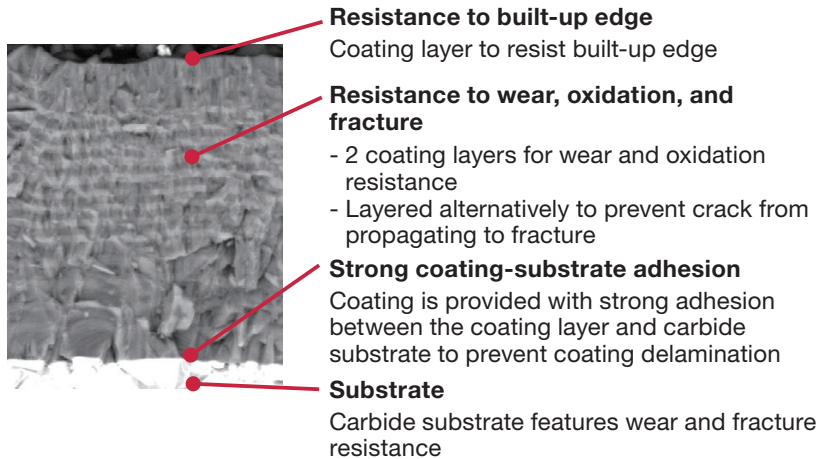
● : Line up

GRADE

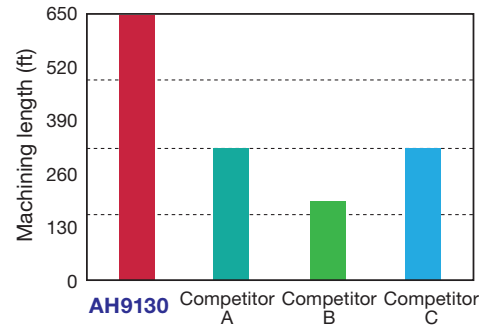
Latest coating optimized for extended tool life

AH9130

- Unique nano-multilayered coating is made possible by Tungaloy's latest coating technology, providing 3 principal features
- This coating achieves highly-balanced wear resistance and chipping resistance, also has acid resistance, resistance to dissolution, and high adhesion strength



Tool life machining carbon steel (1055)



P Tool : $\phi 0.551"$, L/D = 5
 Cutting speed : $V_c = 328$ sfm
 Feed : $f = 0.010$ ipr
 Hole depth : $H = 2.362"$ (Blind hole)

STANDARD CUTTING CONDITIONS

ISO	Workpiece material	Cutting speed Vc (sfm)	Feed: f (ipr)									
			Tool diameter: DC (in)									
			$\phi 0.157" - \phi 0.173"$	$\phi 0.177" - \phi 0.193"$	$\phi 0.197" - \phi 0.232"$	$\phi 0.236" - \phi 0.311"$	$\phi 0.315" - \phi 0.390"$	$\phi 0.394" - \phi 0.469"$	$\phi 0.472" - \phi 0.547"$	$\phi 0.551" - \phi 0.626"$	$\phi 0.630" - \phi 0.783"$	$\phi 0.787" - \phi 1.020"$
P	Low carbon steels (C < 0.3) 1018, 1020, 1026, etc.	262 - 459	0.002 - 0.003	0.002 - 0.003	0.003 - 0.005	0.004 - 0.005	0.005 - 0.010	0.006 - 0.011	0.007 - 0.012	0.008 - 0.014	0.010 - 0.018	0.010 - 0.018
	High carbon steels (C > 0.3) 1045, 1055, etc.	230 - 394	0.002 - 0.003	0.002 - 0.003	0.003 - 0.005	0.004 - 0.005	0.005 - 0.010	0.006 - 0.011	0.007 - 0.012	0.008 - 0.014	0.010 - 0.018	0.010 - 0.018
	Low alloy steels 4140, etc.	230 - 394	0.002 - 0.002	0.002 - 0.003	0.003 - 0.005	0.003 - 0.005	0.004 - 0.010	0.006 - 0.011	0.006 - 0.013	0.007 - 0.014	0.009 - 0.016	0.010 - 0.018
	Alloy steels 8620, etc.	131 - 295	0.002 - 0.003	0.002 - 0.003	0.003 - 0.005	0.003 - 0.005	0.004 - 0.010	0.006 - 0.011	0.006 - 0.013	0.007 - 0.014	0.009 - 0.016	0.010 - 0.018
M	Stainless steels 304SS, 316SS, etc.	98 - 230	-	-	0.002 - 0.003	0.003 - 0.004	0.004 - 0.006	0.005 - 0.007	0.006 - 0.008	0.006 - 0.009	0.006 - 0.010	0.007 - 0.012
K	Gray cast irons Class 25, etc.	262 - 591	0.002 - 0.003	0.002 - 0.003	0.004 - 0.006	0.005 - 0.007	0.006 - 0.012	0.008 - 0.014	0.010 - 0.016	0.012 - 0.018	0.014 - 0.022	0.014 - 0.024
	Ductile cast irons 100-70-03, etc.	262 - 459	0.002 - 0.003	0.002 - 0.003	0.004 - 0.006	0.005 - 0.007	0.006 - 0.012	0.008 - 0.014	0.010 - 0.016	0.012 - 0.018	0.014 - 0.022	0.014 - 0.024
N	Aluminum alloys	262 - 722	-	-	-	0.004 - 0.008	0.008 - 0.014	0.010 - 0.016	0.012 - 0.018	0.014 - 0.02	0.016 - 0.024	0.020 - 0.030
S	Titanium alloys Ti-6Al-4V, etc.	66 - 164	-	-	-	0.002 - 0.003	0.002 - 0.005	0.003 - 0.006	0.004 - 0.011	0.005 - 0.008	0.006 - 0.009	0.007 - 0.011
	Nickel-based alloys	66 - 164	-	-	-	0.002 - 0.003	0.002 - 0.004	0.003 - 0.005	0.004 - 0.006	0.005 - 0.007	0.005 - 0.009	0.006 - 0.009
H	Hardened steel	66 - 164	-	-	-	0.002 - 0.003	0.002 - 0.005	0.003 - 0.006	0.004 - 0.007	0.005 - 0.008	0.006 - 0.009	0.006 - 0.010

- Cutting conditions in the above table show standard cutting conditions
 - Cutting conditions may change due to the rigidity and power of the machine and the workpiece material
 - Machined hole diameter may change depending upon the rigidity of the machine tool or cutting conditions

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Jun. 2022 (TJ)