

**DMU - Modular Drills · 3D ~ 5D** 模組化鑽頭 · 3 ~ 5 倍深

**Specification**

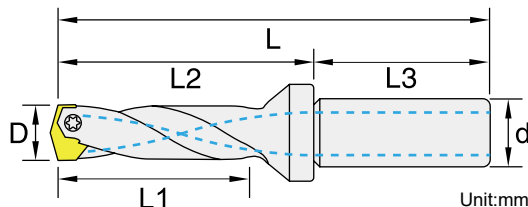
- 3×D ~ 5×D Cutting depth
- Internal Coolant

- High durable SKD holder body
- Use DMUA series inserts

**規格**

- 3 ~ 5 倍深
- 內冷卻孔

- SKD 高耐久性刀體
- 使用 DMUA 刀片



Unit:mm

**3D**

Insert Brand : Winstar

Order No.	Dimensions, mm						Insert	Screw	Wrench	Stock
	D (Applicable Insert Dia.)	L1	L2	L3	L	d				
IDMU3130020	13.0 ~ 13.99	46	65	50	115	20	DMUA13	IWCS2510	IPL20	○
IDMU3140020	14.0 ~ 14.99	49	70	50	120	20	DMUA14	IWCS3013	IPL25	○
IDMU3150020	15.0 ~ 15.99	52	73	50	123	20	DMUA15			○
IDMU3160020	16.0 ~ 16.99	56	77	50	127	20	DMUA16	IWCS3014	IPL25	○
IDMU3170020	17.0 ~ 17.99	60	81	50	131	20	DMUA17			○
IDMU3180020	18.0 ~ 18.99	63	86	50	136	20	DMUA18	IWCS4016	IPL30	○
IDMU3190020	19.0 ~ 19.99	67	90	50	140	20	DMUA19			○
IDMU3200020	20.0 ~ 20.99	72	98	56	154	25	DMUA20	IWCS4018	IPL30	○
IDMU3210020	21.0 ~ 21.99	75	101	56	157	25	DMUA21			○
IDMU3220020	22.0 ~ 22.99	79	105	56	161	25	DMUA22			○
IDMU3240020	24.0 ~ 25.40	86	114	56	170	25	DMUA2			○

**5D**

Order No.	Dimensions, mm						Insert	Screw	Wrench	Stock
	D (Applicable Insert Dia.)	L1	L2	L3	L	d				
IDMU5130020	13.0 ~ 13.99	72	91	50	141	20	DMUA13	IWCS2510	IPL20	●
IDMU5140020	14.0 ~ 14.99	77	98	50	148	20	DMUA14	IWCS3013	IPL25	●
IDMU5150020	15.0 ~ 15.99	82	103	50	153	20	DMUA15			●
IDMU5160020	16.0 ~ 16.99	88	109	50	159	20	DMUA16	IWCS3014	IPL25	●
IDMU5170020	17.0 ~ 17.99	94	115	50	165	20	DMUA17			●
IDMU5180020	18.0 ~ 18.99	99	122	50	172	20	DMUA18	IWCS4016	IPL30	●
IDMU5190020	19.0 ~ 19.99	105	128	50	178	20	DMUA19			●
IDMU5200020	20.0 ~ 20.99	112	138	56	194	25	DMUA20	IWCS4018	IPL30	●
IDMU5210020	21.0 ~ 21.99	117	143	56	199	25	DMUA21			●
IDMU5220020	22.0 ~ 22.99	123	149	56	205	25	DMUA22			●
IDMU5240020	24.0 ~ 25.40	134	162	56	218	25	DMUA2			●

● stock ○ by inquiry

Holemaking

**DMU - Modular Drills · 7D ~ 10D** 模組化鑽頭 · 7 ~ 10 倍深

**Specification**

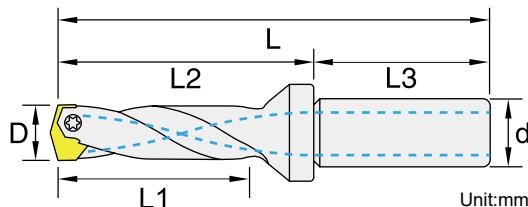
- 7×D ~ 10×D Cutting depth
- Internal Coolant

- High durable SKD holder body
- Use DMUA series inserts

**規格**

- 7 ~ 10 倍深
- 內冷卻孔

- SKD 高耐久性刀體
- 使用 DMUA 刀片



**7D**

Insert Brand : Winstar

Order No.	Dimensions, mm						Insert	Screw	Wrench	Stock
	D (Applicable Insert Dia.)	L1	L2	L3	L	d				
IDMU7130020	13.0 ~ 13.99	98	117	50	167	20	DMUA13	IWCS2510	IPL20	○
IDMU7140020	14.0 ~ 14.99	105	126	50	176	20	DMUA14	IWCS3013	IPL25	○
IDMU7150020	15.0 ~ 15.99	112	133	50	183	20	DMUA15			○
IDMU7160020	16.0 ~ 16.99	120	141	50	191	20	DMUA16	IWCS3014	IPL25	○
IDMU7170020	17.0 ~ 17.99	128	149	50	199	20	DMUA17			○
IDMU7180020	18.0 ~ 18.99	135	158	50	208	20	DMUA18	IWCS4016	IPL30	○
IDMU7190020	19.0 ~ 19.99	143	166	50	216	20	DMUA19			○
IDMU7200020	20.0 ~ 20.99	152	178	56	234	25	DMUA20	IWCS4018	IPL30	○
IDMU7210020	21.0 ~ 21.99	159	185	56	241	25	DMUA21			○
IDMU7220020	22.0 ~ 22.99	167	190	56	246	25	DMUA22			○
IDMU7240020	24.0 ~ 25.40	182	210	56	266	25	DMUA2	IWCS5020	IPL35	○

**10D**

Order No.	Dimensions, mm						Insert	Screw	Wrench	Stock
	D (Applicable Insert Dia.)	L1	L2	L3	L	d				
IDMU9130020	13.0 ~ 13.99	137	156	50	206	20	DMUA13	IWCS3013	IPL25	○
IDMU9140020	14.0 ~ 14.99	147	168	50	218	20	DMUA14			○
IDMU9150020	15.0 ~ 15.99	157	178	50	228	20	DMUA15	IWCS3014	IPL25	○
IDMU9160020	16.0 ~ 16.99	159	189	50	239	20	DMUA16			○
IDMU9170020	17.0 ~ 17.99	179	200	50	250	20	DMUA17	IWCS4016	IPL30	○
IDMU9180020	18.0 ~ 18.99	189	212	50	262	20	DMUA18			○
IDMU9190020	19.0 ~ 19.99	200	223	50	273	20	DMUA19	IWCS4018	IPL30	○
IDMU9200020	20.0 ~ 20.99	212	238	56	294	25	DMUA20			○
IDMU9210020	21.0 ~ 21.99	222	248	56	304	25	DMUA21			○
IDMU9220020	22.0 ~ 22.99	233	259	56	315	25	DMUA22	IWCS5020	IPL35	○
IDMU9240020	24.0 ~ 25.40	254	282	56	338	25	DMUA2			○

● stock ○ by inquiry

**DMU - Modular Drill Inserts** 模組化鑽頭刀片

**Recommended Cutting Conditions** 建議切削數據

Work Material	Vc (m/min)	fr (mm/rev)		
		13.0 ≤ ØD ≤ 15.9	16.0 ≤ ØD ≤ 19.9	20.0 ≤ ØD ≤ 25.4
P Carbon Steel	70 - 95 - 120	0.15 - 0.24 - 0.32	0.18 - 0.27 - 0.35	0.20 - 0.29 - 0.38
	Alloy Steel	60 - 85 - 110	0.15 - 0.23 - 0.30	0.17 - 0.25 - 0.32
M Stainless Steel	55 - 68 - 80	0.11 - 0.17 - 0.23	0.13 - 0.19 - 0.25	0.15 - 0.23 - 0.30
K Cast Iron	70 - 95 - 120	0.15 - 0.24 - 0.32	0.18 - 0.27 - 0.35	0.20 - 0.29 - 0.38
S High Temperature Alloy	35 - 50 - 65	0.08 - 0.13 - 0.18	0.10 - 0.15 - 0.20	0.12 - 0.17 - 0.22

**Insert Specifications** 刀片規格

Insert	Dimensions (mm)	
	A	S
DMUA1300	13.00	3.6
DMUA1350	13.50	3.6
DMUA1400	14.00	4.0
DMUA1450	14.50	4.0
DMUA1500	15.00	4.0
DMUA1550	15.50	4.0
DMUA1587	15.875 (5/8")	4.0
DMUA1600	16.00	4.0
DMUA1630	16.30	4.0
DMUA1650	16.50	4.0
DMUA1700	17.00	4.0
DMUA1800	18.00	5.0
DMUA1900	19.00	5.0
DMUA1905	19.05 (3/4")	5.0
DMUA2000	20.00	5.0
DUMA2100	21.00	6.0
DMUA2200	22.00	6.0
DMUA2222	22.225 (7/8")	6.0
DMUA2400	24.00	7.0
DMUA2500	25.00	7.0
DMUA2540	25.40 (1")	7.0


\* Customized sizes (two decimal places) are acceptable. 客製化尺寸可至小數點後 2 位

**Insert Geometry** 刀片幾何

Shape 形狀	Tip Design 鑽尖設計	Application 應用
	<b>SX</b>	<ul style="list-style-type: none"> <li>• Tip Angle : 140°, Universal</li> <li>• Low cutting force for steel, stainless steel, cast iron and high temperature alloy.</li> <li>• 鑽尖：140°，泛用</li> <li>• 低切削阻力的刀口設計，適用於鋼件、不鏽鋼、鑄鐵和高溫合金加工</li> </ul>

**DMU - Modular Drill Inserts** 模組化鑽頭刀片

**Insert Designation** 刀片型號

Insert	Order No.	Designation	Working Material					
			P	M	K	N	S	H
	IDMUA1300SX33TX	DMUA1300-SX-CX33TX	●	●	●		○	○
	IDMUA1350SX33TX	DMUA1350-SX-CX33TX	●	●	●		○	○
	IDMUA1400SX33TX	DMUA1400-SX-CX33TX	●	●	●		○	○
	IDMUA1450SX33TX	DMUA1450-SX-CX33TX	●	●	●		○	○
	IDMUA1500SX33TX	DMUA1500-SX-CX33TX	●	●	●		○	○
	IDMUA1550SX33TX	DMUA1550-SX-CX33TX	●	●	●		○	○
	IDMUA1587SX33TX	DMUA1587-SX-CX33TX	●	●	●		○	○
	IDMUA1600SX33TX	DMUA1600-SX-CX33TX	●	●	●		○	○
	IDMUA1630SX33TX	DMUA1630-SX-CX33TX	●	●	●		○	○
	IDMUA1650SX33TX	DMUA1650-SX-CX33TX	●	●	●		○	○
	IDMUA1700SX33TX	DMUA1700-SX-CX33TX	●	●	●		○	○
	IDMUA1800SX33TX	DMUA1800-SX-CX33TX	●	●	●		○	○
	IDMUA1900SX33TX	DMUA1900-SX-CX33TX	●	●	●		○	○
	IDMUA1905SX33TX	DMUA1905-SX-CX33TX	●	●	●		○	○
	IDMUA2000SX33TX	DMUA2000-SX-CX33TX	●	●	●		○	○
	IDUMA2100SX33TX	DUMA2100-SX-CX33TX	●	●	●		○	○
	IDMUA2200SX33TX	DMUA2200-SX-CX33TX	●	●	●		○	○
	IDMUA2222SX33TX	DMUA2222-SX-CX33TX	●	●	●		○	○
	IDMUA2400SX33TX	DMUA2400-SX-CX33TX	●	●	●		○	○
	IDMUA2500SX33TX	DMUA2500-SX-CX33TX	●	●	●		○	○
IDMUA2540SX33TX	DMUA2540-SX-CX33TX	●	●	●		○	○	

**Special Insert Order No.** 刀片特殊規格訂購編碼

Order No. 訂購編碼

IDMUA XXXX SX33TX → IDMUA1510SX33TX

EX: Insert Dia. = 15.1mm  
刀片直徑 = 15.1mm

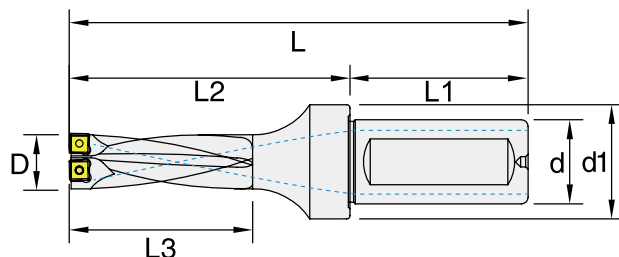
DSP - Indexable Drills · 2D 捨棄式鑽頭 · 2 倍深

**Specification**

- 2×D Cutting depth
- High durable SKD holder body
- Internal Coolant
- Use SPMG series inserts
- Indexable Insert with 4 sides cutting edge

**規格**

- 2 倍深
- 內冷卻孔
- 刀片含有 4 個切削角
- SKD 高耐久性刀體
- 使用 SPMG 刀片



Insert Brand : Winstar, Taegutec, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock
	D	d	d1	L	L3	L2	L1					
IDSP125220T205	12.5	20	27	94	26	44	50	2	SPMG0502	ITS2003	ITK06	○
IDSP130220T205	13			94	26	44		2				●
IDSP135220T205	13.5			96	28	46		2				○
IDSP140220T205	14			96	28	46		2				●
IDSP145220T205	14.5			99	30	49		2				○
IDSP150220T205	15			99	30	49		2				●
IDSP155225T206	15.5	25	33	108	32	52	56	2	SPMG0602	ITS2205	ITK06	○
IDSP160225T206	16			108	32	52		2				●
IDSP165225T206	16.5			110	34	54		2				○
IDSP170225T206	17			110	34	54		2				●
IDSP175225T206	17.5			113	36	57		2				○
IDSP180225T206	18			113	36	57		2				●
IDSP185225T206	18.5			115	38	59		2				○
IDSP190225T206	19			115	38	59		2				●
IDSP195225T206	19.5			119	40	63		2				○
IDSP200225T206	20			119	40	63		2				●
IDSP205225T206	20.5			121	42	65		2				○
IDSP210225T206	21			121	42	65		2				●
IDSP215225T206	21.5			123	44	67		2				○
IDSP220225T207	22			123	44	67		2				●
IDSP225232T207	22.5	32	43	131	46	71	60	2	SPMG07T308	ITS2511	ITK08	○
IDSP230232T207	23			131	46	71		2				●
IDSP235232T207	23.5			134	48	74		2				○
IDSP240232T207	24			134	48	74		2				●
IDSP245232T207	24.5			137	50	77		2				○
IDSP250232T207	25			137	50	77		2				●
IDSP255232T207	25.5			139	52	79		2				○
IDSP260232T207	26			139	52	79		2				●
IDSP265232T207	26.5			142	54	81		2				○
IDSP270232T207	27			142	54	81		2				●
IDSP275232T207	27.5	144	56	84	2	○						

● stock ○ by inquiry

Holemaking

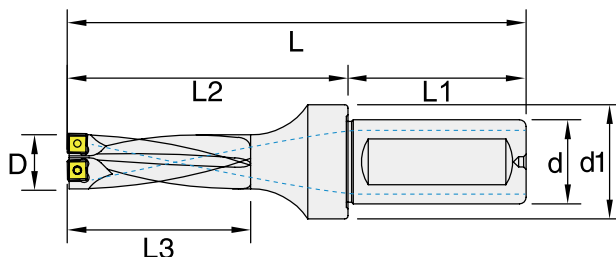
DSP - Indexable Drills · 2D 捨棄式鑽頭 · 2 倍深

**Specification**

- 2×D Cutting depth
- Internal Coolant
- Indexable Insert with 4 sides cutting edge
- High durable SKD holder body
- Use SPMG series inserts

**規格**

- 2 倍深
- 內冷卻孔
- 刀片含有 4 個切削角
- SKD 高耐久性刀體
- 使用 SPMG 刀片



Insert Brand : Winstar, Taegutec, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock
	D	d	d1	L	L3	L2	L1					
IDSP280232T209	28	32	43	144	56	84	60	2	SPMG090408	ITS3504	ITK15	●
IDSP285232T209	28.5			2	○							
IDSP290232T209	29			2	●							
IDSP295232T209	29.5			2	○							
IDSP300232T209	30			2	●							
IDSP305232T209	30.5			2	○							
IDSP310232T209	31			2	●							
IDSP315232T209	31.5			2	○							
IDSP320232T209	32			2	●							
IDSP325232T209	32.5			2	○							
IDSP330232T209	33			2	●							
IDSP340232T211	34			40	53	156		68				96
IDSP350232T211	35	2	●									
IDSP360232T211	36	2	●									
IDSP370232T211	37	2	●									
IDSP380232T211	38	2	●									
IDSP390232T211	39	2	●									
IDSP400240T211	40	2	●									
IDSP410240T211	41	2	○									

● stock ○ by inquiry

DSP - Indexable Drills · 3D

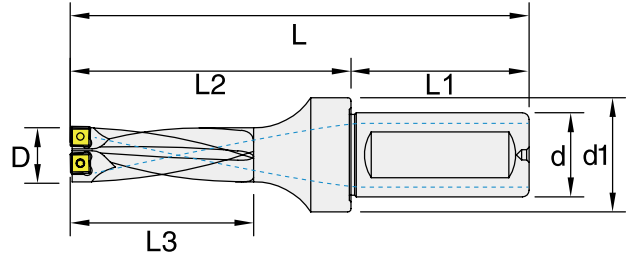
捨棄式鑽頭 · 3 倍深

Specification

- 3×D Cutting depth
- High durable SKD holder body
- Internal Coolant
- Use SPMG series inserts
- Indexable Insert with 4 sides cutting edge

規格

- 3 倍深
- 內冷卻孔
- 刀片含有 4 個切削角
- SKD 高耐久性刀體
- 使用 SPMG 刀片



Insert Brand : Winstar, Taegutec, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock
	D	d	d1	L	L3	L2	L1					
IDSP125320T205	12.5	20	25	107	39	57	50	2	SPMG0502	ITS2003	ITK06	○
IDSP130320T205	13			110	42	60		2				○
IDSP135320T205	13.5			110	42	60		2				○
IDSP140320T205	14			110	42	60		2				○
IDSP145320T205	14.5			110	42	60		2				○
IDSP150320T205	15			110	42	60		2				○
IDSP155325T206	15.5	25	33	124	48	68	56	2	SPMG0602	ITS2205	ITK06	○
IDSP160325T206	16			127	51	71		2				○
IDSP165325T206	16.5			127	51	71		2				○
IDSP170325T206	17			127	51	71		2				○
IDSP175325T206	17.5			131	54	75		2				○
IDSP180325T206	18			131	54	75		2				○
IDSP185325T206	18.5			134	57	78		2				○
IDSP190325T206	19			134	57	78		2				○
IDSP195325T206	19.5			139	60	83		2				○
IDSP200325T206	20			139	60	83		2				○
IDSP205325T206	20.5			142	63	86		2				○
IDSP210325T206	21			142	63	86		2				○
IDSP215325T206	21.5			145	66	89		2				○
IDSP220325T207	22			145	66	89		2				○
IDSP225332T207	22.5	32	43	154	69	94	60	2	SPMG07T3	ITS2511	ITK08	○
IDSP230332T207	23			158	72	98		2				○
IDSP235332T207	23.5			158	72	98		2				○
IDSP240332T207	24			162	75	102		2				○
IDSP245332T207	24.5			162	75	102		2				○
IDSP250332T207	25			165	78	105		2				○
IDSP255332T207	25.5			165	78	105		2				○
IDSP260332T207	26			169	81	108		2				○
IDSP265332T207	26.5			169	81	108		2				○
IDSP270332T207	27			172	84	112		2				○
IDSP275332T207	27.5	172	84	112	2	○						

● stock ○ by inquiry

Holemaking

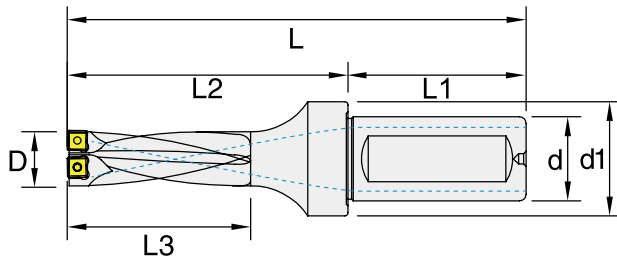
DSP - Indexable Drills · 3D 捨棄式鑽頭 · 3 倍深

Specification

- 3×D Cutting depth
- High durable SKD holder body
- Internal Coolant
- Use SPMG series inserts
- Indexable Insert with 4 sides cutting edge

規格

- 3 倍深
- 內冷卻孔
- 刀片含有 4 個切削角
- SKD 高耐久性刀體
- 使用 SPMG 刀片



Insert Brand : Winstar, Taegutec, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock
	D	d	d1	L	L3	L2	L1					
IDSP280332T209	28	32	43	172	84	112	60	2	SPMG0904	ITS3504	ITK15	●
IDSP285332T209	28.5			175	87	115		2				
IDSP290332T209	29			178	90	118		2				
IDSP295332T209	29.5			181	93	121		2				
IDSP300332T209	30			184	96	124		2				
IDSP305332T209	30.5			187	99	127		2				
IDSP310332T209	31			190	102	130		2				
IDSP315332T209	31.5			193	105	133		2				
IDSP320332T209	32			196	108	136		2				
IDSP325332T209	32.5			199	111	139		2				
IDSP330332T209	33			202	114	142		2				
IDSP340332T211	34			205	117	145		2				
IDSP350332T211	35			225	120	155		2				
IDSP360332T211	36			228	123	158		2				
IDSP370332T211	37											
IDSP380332T211	38											●
IDSP390332T211	39											●
IDSP400340T211	40	40	53									●
IDSP410340T211	41											○

● stock ○ by inquiry



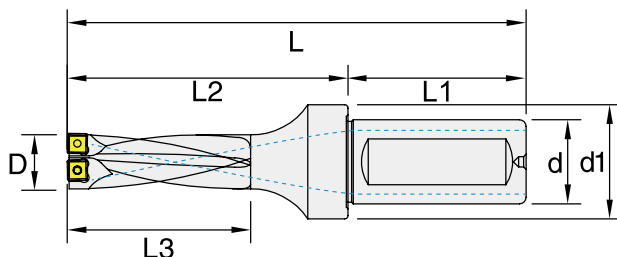
DSP - Indexable Drills · 4D 捨棄式鑽頭 · 4 倍深

**Specification**

- 4×D Cutting depth
- High durable SKD holder body
- Internal Coolant
- Use SPMG series inserts
- Indexable Insert with 4 sides cutting edge

**規格**

- 4 倍深
- 內冷卻孔
- 刀片含有 4 個切削角
- SKD 高耐久性刀體
- 使用 SPMG 刀片



Insert Brand : Winstar, Taegutec, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock
	D	d	d1	L	L3	L2	L1					
IDSP125420T205	12.5	20	27	120	52	70	50	2	SPMG0502	ITS2003	ITK06	○
IDSP130420T205	13			120	52	70		2				●
IDSP135420T205	13.5			124	56	74		2				○
IDSP140420T205	14			124	56	74		2				●
IDSP145420T205	14.5			129	60	79		2				○
IDSP150420T205	15			129	60	79		2				●
IDSP155425T206	15.5	25	33	140	64	84	56	2	SPMG0602	ITS2205	ITK06	○
IDSP160425T206	16			140	64	84		2				●
IDSP165425T206	16.5			144	68	88		2				○
IDSP170425T206	17			144	68	88		2				●
IDSP175425T206	17.5			148	72	92		2				○
IDSP180425T206	18			148	72	92		2				●
IDSP185425T206	18.5			152	76	96		2				○
IDSP190425T206	19			152	76	96		2				●
IDSP195425T206	19.5			156	80	100		2				○
IDSP200425T206	20			156	80	100		2				●
IDSP205425T206	20.5			160	84	104		2				○
IDSP210425T206	21			160	84	104		2				●
IDSP215425T206	21.5			164	88	108		2				○
IDSP220425T207	22			164	88	108		2				●
IDSP225432T207	22.5	32	43	177	92	117	60	2	SPMG07T3	ITS2511	ITK08	○
IDSP230432T207	23			177	92	117		2				●
IDSP235432T207	23.5			181	96	121		2				○
IDSP240432T207	24			181	96	121		2				●
IDSP245432T207	24.5			185	100	125		2				○
IDSP250432T207	25			185	100	125		2				●
IDSP255432T207	25.5			189	104	129		2				○
IDSP260432T207	26			189	104	129		2				●
IDSP265432T207	26.5			196	108	136		2				○
IDSP270432T207	27			196	108	136		2				●
IDSP275432T207	27.5	200	112	140	2	○						

● stock ○ by inquiry

Holemaking

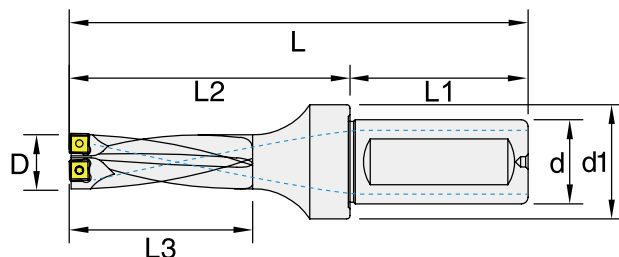
**DSP - Indexable Drills · 4D** 捨棄式鑽頭 · 4 倍深

**Specification**

- 4×D Cutting depth
- Internal Coolant
- Indexable Insert with 4 sides cutting edge
- High durable SKD holder body
- Use SPMG series inserts

**規格**

- 4 倍深
- 內冷卻孔
- 刀片含有 4 個切削角
- SKD 高耐久性刀體
- 使用 SPMG 刀片



Insert Brand : Winstar, Taegutec, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock
	D	d	d1	L	L3	L2	L1					
IDSP280432T209	28	32	43	200	112	140	60	2	SPMG0904	TS3504	TK15	●
IDSP285432T209	28.5			2	○							
IDSP290432T209	29			2	●							
IDSP295432T209	29.5			2	○							
IDSP300432T209	30			2	●							
IDSP305432T209	30.5			2	○							
IDSP310432T209	31			2	●							
IDSP315432T209	31.5			2	○							
IDSP320432T209	32			2	●							
IDSP325432T209	32.5			2	○							
IDSP330432T209	33			2	●							
IDSP340432T211	34			2	●							
IDSP350432T211	35			2	●							
IDSP360432T211	36			2	●							
IDSP370432T211	37			2	●							
IDSP380432T211	38	2	●									
IDSP390432T211	39	2	●									
IDSP400440T211	40	40	53	265	160	195	2	SPMG1104	TS4006	TK15	●	
IDSP410440T211	41			269	164	199	2				○	

● stock ○ by inquiry

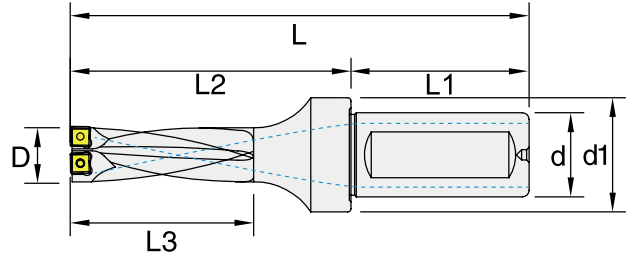
DSP - Indexable Drills · 5D 捨棄式鑽頭 · 5 倍深

Specification

- 5×D Cutting depth
- High durable SKD holder body
- Internal Coolant
- Use SPMG series inserts
- Indexable Insert with 4 sides cutting edge

規格

- 5 倍深
- 內冷卻孔
- 刀片含有 4 個切削角
- SKD 高耐久性刀體
- 使用 SPMG 刀片



Insert Brand : Winstar, Taegutec, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock			
	D	d	d1	L	L3	L2	L1								
IDSP130520T205	13	20	27	133	65	83	50	2	SPMG0502	ITS2003	ITK06	<input type="radio"/>			
IDSP140520T205	14			138	70	88		2				<input type="radio"/>			
IDSP150520T205	15			144	75	94		2				<input type="radio"/>			
IDSP160525T206	16	25	33	156	80	100	56	2	SPMG0602	ITS2205	ITK06	<input type="radio"/>			
IDSP170525T206	17			161	85	105		2				<input type="radio"/>			
IDSP180525T206	18			166	90	110		2				<input type="radio"/>			
IDSP190525T206	19			171	95	115		2				<input type="radio"/>			
IDSP200525T206	20			176	100	120		2				<input type="radio"/>			
IDSP210525T206	21			181	105	125		2				<input type="radio"/>			
IDSP220525T207	22			186	110	130		2				<input type="radio"/>			
IDSP230532T207	23			200	115	140		2				<input type="radio"/>			
IDSP240532T207	24	205	120	145	2	SPMG07T3	ITS2511	ITK08	<input type="radio"/>						
IDSP250532T207	25	210	125	150	2				<input type="radio"/>						
IDSP260532T207	26	215	130	155	2				<input type="radio"/>						
IDSP270532T207	27	223	135	163	2	<input type="radio"/>									
IDSP280532T209	28	32	43	228	140	168	60	2	SPMG0904	ITS3504	ITK15	<input type="radio"/>			
IDSP290532T209	29			233	145	173		2				<input type="radio"/>			
IDSP300532T209	30			238	150	178		2				<input type="radio"/>			
IDSP310532T209	31			243	155	183		2				<input type="radio"/>			
IDSP320532T209	32			248	160	188		2				<input type="radio"/>			
IDSP330532T209	33			253	165	193		2				<input type="radio"/>			
IDSP340532T211	34			258	170	198		2				SPMG1104	ITS4006	ITK15	<input type="radio"/>
IDSP350532T211	35			263	175	203		2							<input type="radio"/>
IDSP360532T211	36			268	180	208		2							<input type="radio"/>

● stock ○ by inquiry

Holemaking

**DSP - Indexable Drill Inserts** 捨棄式鑽頭刀片

**Insert Specifications** 刀片規格

Insert	Dimensions (mm)				
	A	B	S	r	d1
SPG050204	5.00	2.38	0.4	2.30	2.8
SPG060204	6.00	2.38	0.4	2.65	3.0
SPG07T308	7.94	3.97	0.8	2.85	3.4
SPG090408	9.80	4.3	0.8	4.05	4.0
SPG110408	11.50	4.8	0.8	4.45	4.3

**Insert Geometry** 刀片幾何

Shape 形狀	Chipbreaker 斷屑槽	Application 應用
	<b>SG</b>	Sharp geometry design for semi-finishing cutting in stainless steel and non-ferrous materials. 鋒利的刀口設計，適用於不鏽鋼及非鐵金屬的半精加工應用
	<b>MG</b>	Low cutting force for medium cutting in steel, stainless steel and cast iron. 低切削阻力的刀口設計，適用於鋼件、不鏽鋼和鑄鐵的中加工應用

**Recommended Cutting Conditions** 建議切削數據

DSP Series (2×D, 3×D)

Work Material	Hardness	Vc (m/min)	Feed Rate (mm/rev)				
			SPMG05 Ø13-Ø15	SPMG06 Ø16-Ø21	SPMG07 Ø22-Ø27	SPMG09 Ø28-Ø33	SPMG11 Ø34-Ø41
<b>P</b>	Mild Steel (<180HB)	120~250	0.04~0.08	0.05~0.10	0.06~0.13	0.07~0.15	0.08~0.18
	Carbon Steel (180~280HB)	100~150	0.04~0.08	0.05~0.09	0.06~0.12	0.07~0.13	0.08~0.15
	Alloy Steel (280~350HB)	80~140	0.04~0.07	0.05~0.08	0.05~0.09	0.06~0.12	0.07~0.14
<b>M</b>	Stainless Steel (<200HB)	80~180	0.04~0.08	0.05~0.09	0.05~0.10	0.06~0.12	0.07~0.14
<b>K</b>	Cast Iron (<350Mpa)	110~190	0.05~0.09	0.07~0.12	0.08~0.15	0.09~0.17	0.12~0.20
	Ductile Cast Iron (<450Mpa)	100~160	0.05~0.08	0.06~0.11	0.07~0.13	0.08~0.15	0.10~0.18
<b>N</b>	Aluminum <12% Si	300~400	0.05~0.11	0.07~0.13	0.08~0.15	0.09~0.20	0.12~0.25
	Aluminum >12% Si	200~330	0.04~0.08	0.05~0.10	0.06~0.13	0.07~0.15	0.08~0.18
<b>S</b>	Heat Resistant Alloy	30~60	0.02~0.04	0.03~0.05	0.03~0.05	0.04~0.06	0.05~0.08
<b>H</b>	Hardened Material 40~60HRC	30~60	0.02~0.04	0.03~0.05	0.03~0.05	0.04~0.06	0.05~0.08

Apply for 4×D reduce 10%, 5×D reduce 15%.

DSP - Indexable Drill Inserts 捨棄式鑽頭刀片

Insert Designation 刀片型號

Insert	Order No.	Code-Chipbreaker-Grade	Working Material					
			P	M	K	N	S	H
	ISPGG050204SG33TX	SPGG050204-SG-CX33TX	○	●	○	●	○	
	ISPGG060204SG33TX	SPGG060204-SG-CX33TX	○	●	○	●	○	
	ISPGG07T304SG33TX	SPGG070304-SG-CX33TX	○	●	○	●	○	
	ISPGG090408SG33TX	SPGG090408-SG-CX33TX	○	●	○	●	○	
	ISPGG110408SG33TX	SPGG110408-SG-CX33TX	○	●	○	●	○	
	ISPMG050204MG32HS	SPMG050204-MG-CX32HS	●	○	●			
	ISPMG050204MG33TX	SPMG050204-MG-CX33TX	●	○	●		○	●
	ISPMG050204MG43TX	SPMG050204-MG-CX43TX	●	●	○		●	
	ISPMG060204MG32HS	SPMG060204-MG-CX32HS	●	○	●			
	ISPMG060204MG33TX	SPMG060204-MG-CX33TX	●	○	●		○	●
	ISPMG060204MG43TX	SPMG060204-MG-CX43TX	●	●	○		●	
	ISPMG07T308MG32HS	SPMG07T308-MG-CX32HS	●	○	●			
	ISPMG07T308MG33TX	SPMG07T308-MG-CX33TX	●	○	●		○	●
	ISPMG07T308MG43TX	SPMG07T308-MG-CX43TX	●	●	○		●	
	ISPMG090408MG32HS	SPMG090408-MG-CX32HS	●	○	●			
	ISPMG090408MG33TX	SPMG090408-MG-CX33TX	●	○	●		○	●
	ISPMG090408MG43TX	SPMG090408-MG-CX43TX	●	●	○		●	
	ISPMG110408MG32HS	SPMG110408-MG-CX32HS	●	○	●			
	ISPMG110408MG33TX	SPMG110408-MG-CX33TX	●	○	●		○	●
	ISPMG110408MG43TX	SPMG110408-MG-CX43TX	●	●	○		●	

Holemaking

DWC - Indexable Drills · 2D

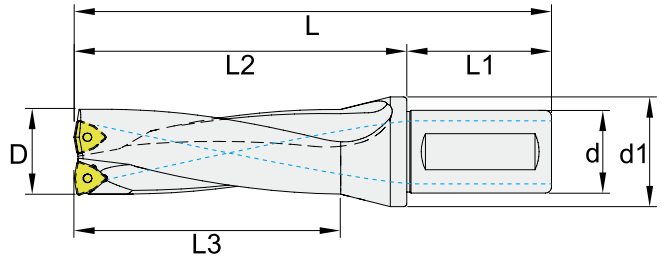
捨棄式鑽頭 · 2 倍深

Specification

- 2×D Cutting depth
- Internal Coolant
- Indexable Insert with 3 sides cutting edge
- High durable SKD holder body
- Use WCMT series inserts

規格

- 2 倍深
- 內冷卻孔
- 刀片含有 3 個切削角
- SKD 高耐久性刀體
- 使用 WCMT 刀片



Insert Brand : Winstar, Sandvik, Korloy, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock
	D	d	d1	L	L3	L2	L1					
IDWC140225T203	14	25	38	114	28	58	56	2	WCMT0302	ITS2502	ITK08	●
IDWC145225T203	14.5			2	●							
IDWC150225T203	15			2	●							
IDWC155225T203	15.5			2	○							
IDWC160225T203	16			2	●							
IDWC165225T203	16.5			2	○							
IDWC170225T203	17			2	●							
IDWC175225T203	17.5			2	○							
IDWC180225T203	18			2	●							
IDWC185225T203	18.5			2	○							
IDWC190225T203	19			2	●							
IDWC195225T203	19.5			2	○							
IDWC200225T203	20			2	●							
IDWC205225T203	20.5	2	○									
IDWC210225T204	21	32	43	126	40	70	60	2	WCMT0402	ITS2507	ITK08	●
IDWC215225T204	21.5			2	○							
IDWC220232T204	22			2	●							
IDWC225232T204	22.5			2	○							
IDWC230232T204	23			2	●							
IDWC235232T204	23.5			2	○							
IDWC240232T204	24			2	●							
IDWC245232T204	24.5			2	○							
IDWC250232T204	25			2	●							
IDWC255232T204	25.5			2	○							
IDWC260232T205	26			2	●							
IDWC270232T205	27			2	○							
IDWC280232T205	28			2	●							
IDWC290232T205	29	2	○									
IDWC300232T205	30	2	●									

● stock ○ by inquiry

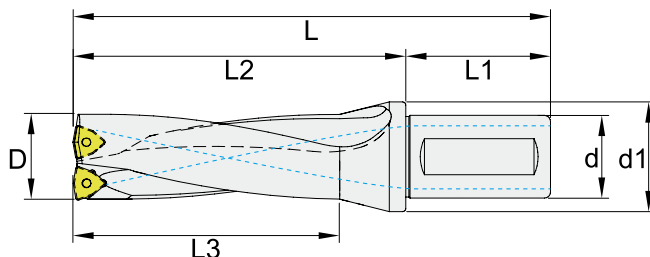
**DWC - Indexable Drills · 2D** 捨棄式鑽頭 · 2 倍深

**Specification**

- 2×D Cutting depth
- Internal Coolant
- Indexable Insert with 3 sides cutting edge
- High durable SKD holder body
- Use WCMT series inserts

**規格**

- 2 倍深
- 內冷卻孔
- 刀片含有 3 個切削角
- SKD 高耐久性刀體
- 使用 WCMT 刀片



Insert Brand : Winstar, Sandvik, Korloy, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock
	D	d	d1	L	L3	L2	L1					
IDWC310232T206	31	32	43	154	62	94	60	2	WCMT06T3	ITS3504		●
IDWC320232T206	32			156	64	96		2				
IDWC330232T206	33			159	66	99		2				
IDWC340232T206	34			160	68	100		2				
IDWC350232T206	35			162	70	102		2				
IDWC360232T206	36			164	72	104		2				
IDWC370232T206	37			166	74	106		2				
IDWC380232T206	38			168	76	106		2				
IDWC390232T206	39			170	78	110		2				
IDWC400240T206	40			40	54	185		80				115
IDWC410240T206	41	187	82			117	2					
IDWC420240T208	42	189	84			119	2					
IDWC430240T208	43	191	86			121	2					
IDWC440240T208	44	194	88			124	2					
IDWC450240T208	45	195	90			125	2					
IDWC460240T208	46	197	92			127	2					
IDWC470240T208	47	199	94			129	2					
IDWC480240T208	48	201	96			131	2					
IDWC490240T208	49	202	98			132	2					
IDWC500240T208	50	204	100			134	2					
IDWC510240T208	51	206	102			136	2					
IDWC520240T208	52	208	104			138	2					
IDWC530240T208	53	210	106			140	2					
IDWC540240T208	54	212	108			142	2					
IDWC550240T208	55	215	110			145	2					
IDWC560240T208	56	217	112			147	2					
IDWC570240T208	57	219	114			149	2					
IDWC580240T208	58	221	116			151	2					
IDWC590240T208	59	223	118			153	2					
IDWC600240T208	60	225	120	155	2	2	○					

● stock ○ by inquiry

Holemaking

DWC - Indexable Drills · 3D

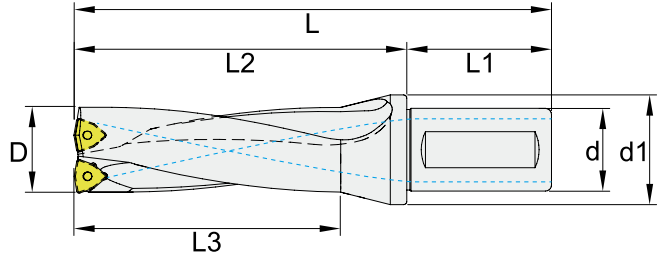
捨棄式鑽頭 · 3 倍深

Specification

- 3×D Cutting depth
- Internal Coolant
- Indexable Insert with 3 sides cutting edge
- High durable SKD holder body
- Use WCMT series inserts

規格

- 3 倍深
- 內冷卻孔
- 刀片含有 3 個切削角
- SKD 高耐久性刀體
- 使用 WCMT 刀片



Insert Brand : Winstar, Sandvik, Korloy, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock				
	D	d	d1	L	L3	L2	L1									
IDWC140325T203	14	25	38	128	42	72	56	WCMT0302	ITS2502	ITK08	●					
IDWC145325T203	14.5										○					
IDWC150325T203	15										●					
IDWC155325T203	15.5										○					
IDWC160325T203	16										●					
IDWC165325T203	16.5										○					
IDWC170325T203	17										●					
IDWC175325T203	17.5			○												
IDWC180325T203	18			●												
IDWC185325T203	18.5			○												
IDWC190325T203	19			●												
IDWC195325T203	19.5			○												
IDWC200325T203	20			●												
IDWC205325T203	20.5			○												
IDWC210325T204	21	32	43	149	63	93	60	WCMT0402	ITS2507	ITK08	●					
IDWC215325T204	21.5										○					
IDWC220332T204	22										●					
IDWC225332T204	22.5										○					
IDWC230332T204	23										●					
IDWC235332T204	23.5										○					
IDWC240332T204	24										●					
IDWC245332T204	24.5			○												
IDWC250332T204	25			●												
IDWC255332T204	25.5			○												
IDWC260332T205	26			170	78	110	81				113	60	WCMT0503	ITS3007	ITK10	●
IDWC270332T205	27															○
IDWC280332T205	28															●
IDWC290332T205	29															○
IDWC300332T205	30	●														
IDWC305332T206	30.5	○														
IDWC310332T206	31	●														
IDWC310332T206	31			185	93	125		WCMT06T3	ITS3504	ITK15	○					

● stock ○ by inquiry



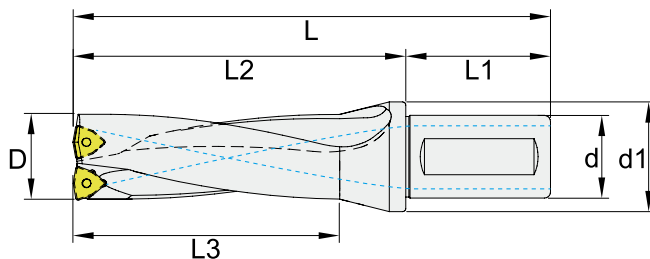
**DWC - Indexable Drills · 3D** 捨棄式鑽頭 · 3 倍深

**Specification**

- 3×D Cutting depth
- Internal Coolant
- Indexable Insert with 3 sides cutting edge
- High durable SKD holder body
- Use WCMT series inserts

**規格**

- 3 倍深
- 內冷卻孔
- 刀片含有 3 個切削角
- SKD 高耐久性刀體
- 使用 WCMT 刀片



Insert Brand : Winstar, Sandvik, Korloy, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock
	D	d	d1	L	L3	L2	L1					
IDWC315332T206	31.5	32	43	185	93	125	60	2	WCMT06T3	ITS3504		○
IDWC320332T206	32			188	96	128		2				●
IDWC325332T206	32.5			188	96	128		2				○
IDWC330332T206	33			191	99	131		2				●
IDWC340332T206	34			194	102	134		2				●
IDWC350332T206	35			197	105	137		2				●
IDWC360332T206	36			200	108	140		2				●
IDWC370332T206	37			203	111	143		2				●
IDWC380332T206	38			206	114	146		2				●
IDWC390332T206	39			209	117	149		2				●
IDWC400340T206	40	40	54	225	120	155	70	2	WCMT0804	ITS4004	ITK15	○
IDWC410340T206	41			228	123	158		2				○
IDWC420340T208	42			231	126	161		2				○
IDWC430340T208	43			234	129	164		2				○
IDWC440340T208	44			238	132	168		2				○
IDWC450340T208	45			240	135	170		2				○
IDWC460340T208	46			243	138	173		2				○
IDWC470340T208	47			246	141	176		2				○
IDWC480340T208	48			249	144	179		2				○
IDWC490340T208	49			253	147	182		2				○
IDWC500340T208	50	254	150	184	2	○						
IDWC510340T208	51	257	153	187	2	○						
IDWC520340T208	52	260	156	190	2	○						
IDWC530340T208	53	263	159	193	2	○						
IDWC540340T208	54	266	162	196	2	○						
IDWC550340T208	55	270	165	200	2	○						
IDWC560340T208	56	58	58	273	168	203	2	○				
IDWC570340T208	57			276	171	205	2	○				
IDWC580340T208	58	59	59	279	174	209	2	○				
IDWC590340T208	59			282	177	212	2	○				
IDWC600340T208	60			63	285	180	215	2	○			

● stock ○ by inquiry

Holemaking

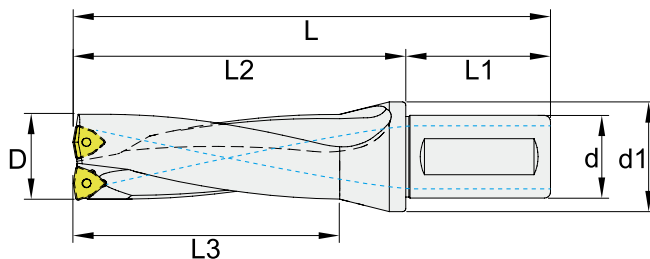
**DWC - Indexable Drills · 4D** 捨棄式鑽頭 · 4 倍深

**Specification**

- 4×D Cutting depth
- Internal Coolant
- Indexable Insert with 3 sides cutting edge
- High durable SKD holder body
- Use WCMT series inserts

**規格**

- 4 倍深
- 內冷卻孔
- 刀片含有 3 個切削角
- SKD 高耐久性刀體
- 使用 WCMT 刀片



Insert Brand : Winstar, Sandvik, Korloy, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock
	D	d	d1	L	L3	L2	L1					
IDWC140425T203	14	25	38	142	56	86	56	2	WCMT0302	ITS2502	ITK08	●
IDWC150425T203	15			146	60	90		2				
IDWC160425T203	16			150	64	94		2				
IDWC170425T203	17			154	68	98		2				
IDWC180425T203	18			158	72	102		2				
IDWC190425T203	19			162	76	106		2				
IDWC200425T203	20			166	80	110		2				
IDWC210425T204	21			170	84	114		2				
IDWC220432T204	22			32	43	180		88				120
IDWC230432T204	23	184	92			124	2					
IDWC240432T204	24	188	96			128	2					
IDWC250432T204	25	192	100			132	2					
IDWC260432T205	26	196	104			136	2					
IDWC270432T205	27	200	108			140	2					
IDWC280432T205	28	204	112			144	2					
IDWC290432T205	29	208	116			148	2					
IDWC300432T205	30	212	120			152	2					
IDWC310432T206	31	216	124			156	2					
IDWC320432T206	32	220	128	160	2							
IDWC330432T206	33	224	132	164	2							
IDWC340432T206	34	228	136	168	2							
IDWC350432T206	35	232	140	172	2							
IDWC360432T206	36	236	144	176	2							
IDWC370432T206	37	240	148	180	2							
IDWC380432T206	38	244	152	184	2							
IDWC390432T206	39	248	156	188	2							
IDWC400440T206	40	40	54	265	160	195	70	2	WCMT06T3	ITS3504	ITK15	●
IDWC410440T206	41			269	164	199		2				

● stock ○ by inquiry

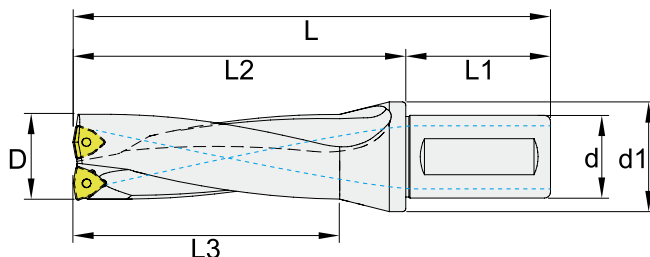
**DWC - Indexable Drills · 4D** 捨棄式鑽頭 · 4 倍深

**Specification**

- 4×D Cutting depth
- Internal Coolant
- Indexable Insert with 3 sides cutting edge
- High durable SKD holder body
- Use WCMT series inserts

**規格**

- 4 倍深
- 內冷卻孔
- 刀片含有 3 個切削角
- SKD 高耐久性刀體
- 使用 WCMT 刀片



Insert Brand : Winstar, Sandvik, Korloy, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock	
	D	d	d1	L	L3	L2	L1						
IDWC420440T208	42	40	54	273	168	203	70	2	WCMT0804	ITS4004	ITK15	○	
IDWC430440T208	43			277	172	207		2				○	
IDWC440440T208	44			282	176	212		2				○	
IDWC450440T208	45			285	180	215		2				○	
IDWC460440T208	46			289	184	219		2				○	
IDWC470440T208	47			293	188	223		2				○	
IDWC480440T208	48			297	192	227		2				○	
IDWC490440T208	49			301	196	231		2				○	
IDWC500440T208	50			305	200	235		2				○	
IDWC510440T208	51			309	204	239		2				○	
IDWC520440T208	52			313	208	243		2				○	
IDWC530440T208	53			317	212	247		2				○	
IDWC540440T208	54			320	216	250		2				○	
IDWC550440T208	55			325	220	255		2				○	
IDWC560440T208	56			58	329	224		259				2	○
IDWC570440T208	57				333	228		263				2	○
IDWC580440T208	58				59	337		232				267	2
IDWC590440T208	59			341		236		271				2	○
IDWC600440T208	60	63	345	240	275	2	○						

● stock ○ by inquiry

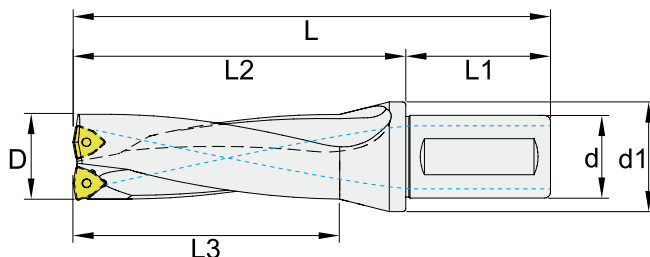
**DWC - Indexable Drills · 5D** 捨棄式鑽頭 · 5 倍深

**Specification**

- 5×D Cutting depth
- Internal Coolant
- Indexable Insert with 3 sides cutting edge
- High durable SKD holder body
- Use WCMT series inserts

**規格**

- 5 倍深
- 內冷卻孔
- 刀片含有 3 個切削角
- SKD 高耐久性刀體
- 使用 WCMT 刀片



Insert Brand : Winstar, Sandvik, Korloy, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock
	D	d	d1	L	L3	L2	L1					
IDWC160525T203	16	25	38	166	80	110	56	2	WCMT0302	ITS2507	ITK08	<input type="radio"/>
IDWC170525T203	17	25	38	171	85	115	56	2				<input type="radio"/>
IDWC180525T203	18	25	38	176	90	120	56	2				<input type="radio"/>
IDWC190525T203	19	25	38	181	95	125	56	2				<input type="radio"/>
IDWC200525T203	20	25	38	186	100	130	56	2				<input type="radio"/>
IDWC210525T203	21	25	38	191	105	135	56	2				<input type="radio"/>
IDWC220525T203	22	25	38	196	110	140	56	2				<input type="radio"/>
IDWC230532T204	23	32	43	207	115	147	60	2	WCMT0402	ITS2507	ITK08	<input type="radio"/>
IDWC240532T204	24	32	43	212	120	152	60	2				<input type="radio"/>
IDWC250532T204	25	32	43	217	125	157	60	2				<input type="radio"/>
IDWC260532T205	26	32	43	222	130	162	60	2	WCMT0503	ITS3007	ITK10	<input type="radio"/>
IDWC270532T205	27	32	43	227	135	167	60	2				<input type="radio"/>
IDWC280532T205	28	32	43	232	140	172	60	2				<input type="radio"/>
IDWC290532T205	29	32	43	237	145	177	60	2				<input type="radio"/>
IDWC300532T205	30	32	43	242	150	182	60	2				<input type="radio"/>
IDWC310532T206	31	32	43	247	155	187	60	2				WCMT06T3
IDWC320532T206	32	32	43	252	160	192	60	2	<input type="radio"/>			
IDWC330532T206	33	32	43	257	165	197	60	2	<input type="radio"/>			
IDWC340532T206	34	32	43	262	170	202	60	2	<input type="radio"/>			
IDWC350532T206	35	32	43	267	175	207	60	2	<input type="radio"/>			
IDWC360532T206	36	32	43	272	180	212	60	2	<input type="radio"/>			
IDWC440540T208	44	40	54	326	220	256	70	2	WCMT0804	ITS4004	ITK15	

● stock   ○ by inquiry

**DWC - Indexable Drill Inserts** 捨棄式鑽頭刀片

**Insert Specifications** 刀片規格

Insert	Dimensions (mm)				
	A	B	S	r	d1
WCMT030208	3.8	5.56	2.38	0.8	2.8
WCMT040208	4.3	6.35	2.38	0.8	3.0
WCMT050308	5.4	7.94	3.18	0.8	3.4
WCMT06T308	6.5	9.53	3.97	0.8	4.0
WCMT080412	8.7	12.7	4.76	1.2	4.3

**Insert Geometry** 刀片幾何

Shape 形狀	Chipbreaker 斷屑槽	Application 應用
	<b>SG</b>	Sharp geometric design, easy to chip breaking, for steel, stainless steel and cast iron. 鋒利的刀口設計，易於斷屑，適用於鋼件、不鏽鋼和鑄鐵加工
	<b>MG</b>	Low cutting force for medium cutting in steel, stainless steel and cast iron. 低切削阻力的刀口設計，適用於鋼件、不鏽鋼和鑄鐵的中加工應用

**Recommended Cutting Conditions** 建議切削數據

DWC Series (2×D, 3×D)

Work Material	Hardness	Vc (m/min)	Feed Rate (mm/rev)				
			WCMT03 Ø14-Ø20.5	WCMT04 Ø22-Ø25.5	WCMT05 Ø26-Ø30	WCMT06 Ø31-Ø39	WCMT08 Ø40-Ø60
<b>P</b>	Mild Steel (<180HB)	110~220	0.06~0.09	0.06~0.11	0.07~0.13	0.08~0.18	0.10~0.25
	Carbon Steel (180~280HB)	90~140	0.06~0.09	0.06~0.11	0.07~0.13	0.08~0.18	0.10~0.25
	Alloy Steel (280~350HB)	70~120	0.05~0.07	0.05~0.09	0.06~0.11	0.07~0.14	0.08~0.17
<b>M</b>	Stainless Steel (<200HB)	60~140	0.05~0.09	0.05~0.10	0.06~0.13	0.07~0.15	0.08~0.18
<b>K</b>	Cast Iron (<350Mpa)	100~160	0.07~0.11	0.07~0.13	0.08~0.15	0.09~0.18	0.11~0.22
	Ductile Cast Iron (<450Mpa)	90~120	0.06~0.10	0.06~0.12	0.07~0.14	0.08~0.16	0.10~0.20
<b>N</b>	Aluminum <12% Si	200~360	0.06~0.11	0.08~0.13	0.09~0.15	0.11~0.18	0.12~0.25
	Aluminum >12% Si	150~250	0.06~0.11	0.08~0.13	0.09~0.15	0.11~0.18	0.12~0.25
<b>S</b>	Heat Resistant Alloy	25~50	0.03~0.05	0.03~0.06	0.04~0.08	0.05~0.10	0.06~0.12
<b>H</b>	Hardened Material	-	-	-	-	-	-

Apply for 4×D reduce 10%, 5×D reduce 15%.

**DWC - Indexable Drill Inserts** 捨棄式鑽頭刀片

**Insert Designation** 刀片型號

Insert	Order No.	Code-Chipbreaker-Grade	Working Material					
			P	M	K	N	S	H
	IWCMT030208SG32HS	WCMT030208-SG-CX32HS	●	●	●		○	○
	IWCMT030208SG33TX	WCMT030208-SG-CX33TX	●	●	●		●	●
	IWCMT030208SG43TX	WCMT030208-SG-CX43TX	●	●	●		●	
	IWCMT030208MG32HS	WCMT030208-MG-CX32HS	●	●	●		○	○
	IWCMT030208MG33TX	WCMT030208-MG-CX33TX	●	●	●		●	●
	IWCMT030208MG43TX	WCMT030208-MG-CX43TX	●	●	●		●	
	IWCMT040208SG32HS	WCMT040208-SG-CX32HS	●	●	●		○	○
	IWCMT040208SG33TX	WCMT040208-SG-CX33TX	●	●	●		●	●
	IWCMT040208SG43TX	WCMT040208-SG-CX43TX	●	●	●		●	
	IWCMT040208MG32HS	WCMT040208-MG-CX32HS	●	●	●		○	○
	IWCMT040208MG33TX	WCMT040208-MG-CX33TX	●	●	●		●	●
	IWCMT040208MG43TX	WCMT040208-MG-CX43TX	●	●	●		●	
	IWCMT050308SG32HS	WCMT050308-SG-CX32HS	●	●	●		○	○
	IWCMT050308SG33TX	WCMT050308-SG-CX33TX	●	●	●		●	●
	IWCMT050308SG43TX	WCMT050308-SG-CX43TX	●	●	●		●	
	IWCMT050308MG32HS	WCMT050308-MG-CX32HS	●	●	●		○	○
	IWCMT050308MG33TX	WCMT050308-MG-CX33TX	●	●	●		●	●
	IWCMT050308MG43TX	WCMT050308-MG-CX43TX	●	●	●		●	
	IWCMT06T308SG32HS	WCMT06T308-SG-CX32HS	●	●	●		○	○
	IWCMT06T308SG33TX	WCMT06T308-SG-CX33TX	●	●	●		●	●
	IWCMT06T308SG43TX	WCMT06T308-SG-CX43TX	●	●	●		●	
	IWCMT06T308MG32HS	WCMT06T308-MG-CX32HS	●	●	●		○	○
	IWCMT06T308MG33TX	WCMT06T308-MG-CX33TX	●	●	●		●	●
	IWCMT06T308MG43TX	WCMT06T308-MG-CX43TX	●	●	●		●	
	IWCMT080412SG32HS	WCMT080412-SG-CX32HS	●	●	●		○	○
	IWCMT080412SG33TX	WCMT080412-SG-CX33TX	●	●	●		●	●
	IWCMT080412SG43TX	WCMT080412-SG-CX43TX	●	●	●		●	
	IWCMT080412MG32HS	WCMT080412-MG-CX32HS	●	●	●		○	○
	IWCMT080412MG33TX	WCMT080412-MG-CX33TX	●	●	●		●	●
	IWCMT080412MG43TX	WCMT080412-MG-CX43TX	●	●	●		●	

DWD - Indexable Drills · 3D

捨棄式鑽頭 · 3 倍深

Specification

- 3×D Cutting depth
- Internal Coolant
- Indexable Insert with 4 sides cutting edge
- High durable SKD holder body
- Use WDXT series inserts

規格

- 3 倍深
- 內冷卻孔
- 刀片含有 4 個切削角
- SKD 高耐久性刀體
- 使用 WDXT 刀片



Fig. 1

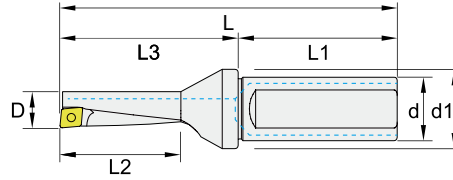
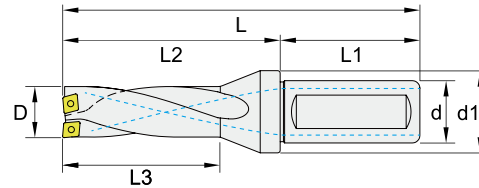


Fig. 2



Insert Brand : Winstar, Sumitomo, ...

Order No.	Dimensions, mm							T	Fig	Insert	Screw	Wrench	Stock					
	D	d	d1	L	L3	L2	L1											
IDWD100320T105	10	20	27	101	51	30	50	1	1	WDXT0525	ITS2003	ITK06	●					
IDWD120320T106	12			107	57	36				●								
IDWD130320T204	13	20	27	107	39	57	50	2	2	WDXT0420	ITS1801	ITK06	●					
IDWD135320T204	13.5			110	42	60							○					
IDWD140320T204	14			114	45	64							●					
IDWD145320T204	14.5			117	48	67							○					
IDWD150320T204	15			120	51	70							●					
IDWD155320T205	15.5			123	54	73				○								
IDWD160320T205	16			126	57	76				●								
IDWD165320T205	16.5			129	60	79				○								
IDWD170320T205	17			143	63	87				●								
IDWD175320T205	17.5			146	66	90				○								
IDWD180320T205	18	25	33	149	69	93	56	2	2	WDXT0630	ITS2203	ITK07	●					
IDWD185320T206	18.5			152	72	96							○					
IDWD190320T206	19			155	75	99							●					
IDWD195320T206	19.5			143	63	87							○					
IDWD200320T206	20			146	66	90							●					
IDWD205325T206	20.5			149	69	93				○								
IDWD210325T206	21			152	72	96				●								
IDWD215325T206	21.5			155	75	99				○								
IDWD220325T206	22			32	43	152				72	96	56	2	2	WDXT0735	ITS2511	ITK08	●
IDWD225332T206	22.5					155				75	99							○
IDWD230332T207	23	152	72			96	●											
IDWD235332T207	23.5	155	75			99	○											
IDWD240332T207	24	152	72			96	●											
IDWD245332T207	24.5	155	75	99	○													
IDWD250332T207	25	152	72	96	●													

● stock ○ by inquiry

Holemaking

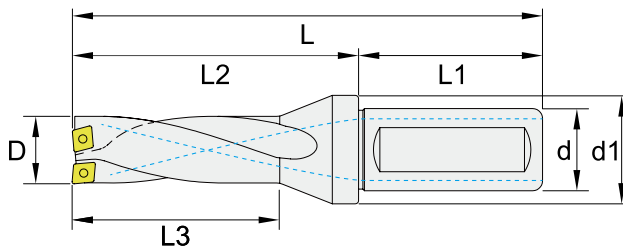
**DWD - Indexable Drills · 4D** 捨棄式鑽頭 · 4 倍深

**Specification**

- 4×D Cutting depth
- Internal Coolant
- Indexable Insert with 4 sides cutting edge
- High durable SKD holder body
- Use WDXT series inserts

**規格**

- 4 倍深
- 內冷卻孔
- 刀片含有 4 個切削角
- SKD 高耐久性刀體
- 使用 WDXT 刀片



Insert Brand : Winstar, Sumitomo, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock			
	D	d	d1	L	L3	L2	L1								
IDWD130420T204	13	20	27	120	52	70	50	2	WDXT0420	ITS1801	ITK06	●			
IDWD135420T204	13.5			124	56	74						○			
IDWD140420T204	14			129	60	79						●			
IDWD145420T204	14.5			133	64	83						○			
IDWD150420T204	15			137	68	87						●			
IDWD155420T205	15.5			141	72	91						○			
IDWD160420T205	16			145	76	95			●						
IDWD165420T205	16.5			149	80	99			○						
IDWD170420T205	17			164	84	108			●						
IDWD175420T205	17.5			168	88	112			○						
IDWD180420T205	18			172	92	116			●						
IDWD185420T206	18.5			176	96	120			○						
IDWD190420T206	19			180	100	124			●						
IDWD195420T206	19.5			25	33	172			92	116	56	2	WDXT0630	ITS2203	ITK07
IDWD200420T206	20	176	96				120	●							
IDWD205425T206	20.5	180	100				124	○							
IDWD210425T206	21	WDXT0735	ITS2511				ITK08	○							
IDWD215425T206	21.5							176							
IDWD220425T206	22							180					100	124	○
IDWD225425T206	22.5							172					92	116	●
IDWD230425T207	23							176					96	120	○
IDWD235425T207	23.5	180	100				124	●							
IDWD240425T207	24	25	33				172	92					116	56	2
IDWD245425T207	24.5			176	96	120			●						
IDWD250425T207	25			180	100	124			○						
IDWD250425T207	25			172	92	116			●						

● stock ○ by inquiry



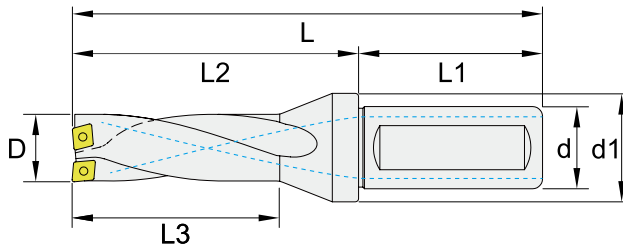
DWD - Indexable Drills · 5D 捨棄式鑽頭 · 5 倍深

Specification

- 5×D Cutting depth
- Internal Coolant
- Indexable Insert with 4 sides cutting edge
- High durable SKD holder body
- Use WDXT series inserts

規格

- 5 倍深
- 內冷卻孔
- 刀片含有 4 個切削角
- SKD 高耐久性刀體
- 使用 WDXT 刀片



Insert Brand : Winstar, Sumitomo, ...

Order No.	Dimensions, mm							T	Insert	Screw	Wrench	Stock
	D	d	d1	L	L3	L2	L1					
IDWD130520T204	13	20	25	133	65	83	50	2	WDXT0420	ITS1801	ITK06	●
IDWD140520T204	14			138	70	88						●
IDWD150520T204	15			144	75	94						●
IDWD160520T205	16			149	80	100						●
IDWD170520T205	17			154	85	105			●			
IDWD180520T205	18			159	90	110			●			
IDWD190520T206	19			164	95	115			●			
IDWD200520T206	20			169	100	120			●			
IDWD210525T206	21	25	33	185	105	125	56	2	WDXT0630	ITS2203	ITK07	●
IDWD220525T206	22			190	110	130						●
IDWD230525T207	23			195	115	140						●
IDWD240525T207	24			200	120	145			●			
IDWD250525T207	25			205	125	150				●		

● stock ○ by inquiry

Holemaking

**DWD - Indexable Drill Inserts** 捨棄式鑽頭刀片

**Insert Specifications** 刀片規格

Insert	Dimensions (mm)			
	A	r1	r2	S
WDXT042004	4.2	0.4	0.4	2.0
WDXT052504	5.0	0.4	0.4	2.5
WDXT063006	6.0	0.6	0.6	3.0
WDXT073506	7.5	0.6	0.6	3.5

**Insert Geometry** 刀片幾何

Shape 形狀	Chipbreaker 斷屑槽	Application 應用
	<b>MG</b>	Low cutting force for medium cutting in steel, stainless steel and cast iron. 低切削阻力的刀口設計，適用於鋼件、不鏽鋼和鑄鐵的中加工應用

**Recommended Cutting Conditions** 建議切削數據





DWD Series (3×D)

Work Material	Hardness	Vc (m/min)	Feed Rate (mm/rev)	
			Ø13-Ø18	Ø18.5-Ø25
<b>P</b> Mild Steel	<180HB)	100~200	0.08~0.20	0.08~0.20
	(180~280HB)	120~240	0.06~0.14	0.06~0.14
	(280~350HB)	85~210	0.05~0.11	0.05~0.11
<b>M</b> Stainless Steel	<200HB)	120~180	0.06~0.15	0.06~0.15
<b>K</b> Cast Iron	<350Mpa)	120~200	0.09~0.27	0.10~0.30
	<450Mpa)	90~150	0.09~0.27	0.10~0.30
<b>N</b> Aluminum <12% Si	-	200~320	0.06~0.17	0.06~0.17
	-	180~280	0.06~0.17	0.06~0.17
<b>S</b> Heat Resistant Alloy	-	25~70	0.06~0.15	0.06~0.15

Apply for 4×D reduce 10%, 5×D reduce 15%.

**DWD - Indexable Drill Inserts** 捨棄式鑽頭刀片

**Insert Designation** 刀片型號

Insert	Order No.	Code-Chipbreaker-Grade	Working Material					
			P	M	K	N	S	H
	IWDXT042004MG33TX	WDXT042004-MG-CX33TX	●	●	●		●	●
	IWDXT052504MG33TX	WDXT052504-MG-CX33TX	●	●	●		●	●
	IWDXT052504MG43TX	WDXT052504-MG-CX43TX	●	●	●		●	
	IWDXT063006MG33TX	WDXT063006-MG-CX33TX	●	●	●		●	●
	IWDXT073506MG33TX	WDXT073506-MG-CX33TX	●	●	●		●	●