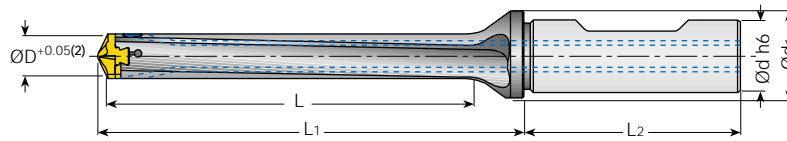


DCM INDEXABLE HEAD DRILLS

Drilling Depth 8xD

Range Ø10.0 to Ø20.0



DCM

ØD ⁽¹⁾ Range	L	Designation	d	d1	L1	L2	Pocket Size	Key	Drilling Heads
.394-.429	3.15	DCM 0394-315-063A-8D	.625	.79	3.70	1.89	10	K DCM-10	IDI
.433-.469	3.46	DCM 0433-346-063A-8D	.625	.79	4.06	1.89	11	K DCM-11	
.472-.508	3.78	DCM 0472-378-063A-8D	.625	.79	4.42	1.89	12	K DCM-12	
.512-.547	4.09	DCM 0512-409-063A-8D	.625	.79	4.78	1.89	13	K DCM-13	
.551-.587	4.41	DCM 0551-441-063A-8D	.625	.79	5.17	1.89	14	K DCM-14	
.591-.625	4.72	DCM 0591-472-075A-8D	.750	.98	5.54	1.97	15	K DCM-15	
.630-.665	5.04	DCM 0630-504-075A-8D	.750	.98	5.90	1.97	16	K DCM-16	
.669-.705	5.35	DCM 0669-535-075A-8D	.750	.98	6.24	1.97	17	K DCM-17	
.709-.744	5.67	DCM 0709-567-100A-8D	1.000	1.26	6.62	2.20	18	K DCM-18	
.748-.783	5.98	DCM 0478-598-100A-8D	1.000	1.26	6.98	2.20	19	K DCM-19	
.787-.823	6.30	DCM 0787-630-100A-8D	1.000	1.26	7.37	2.20	20	K DCM-20	

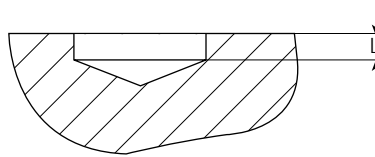
(1) Do not mount smaller drilling heads than specified range for drill body.

(2) Hole tolerance in average conditions; however, it can be higher or lower according to machine and tooling conditions.

For drilling heads, see Hole Making, turnPlus or Millus catalogs.

Centering Hole Data

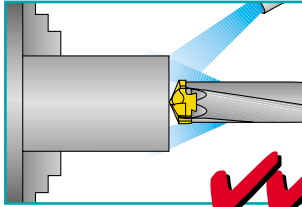
Drill Dia.	Designation	Pre Hole Depth - L	Centerinnng Drill
.394	DCM 0394-315-063A-8D	.197	DCM 0394-118-063A-3D
.433	DCM 0433-346-063A-8D	.197	DCM 0433-130-063A-3D
.472	DCM 0472-378-063A-8D	.197	DCM 0472-141-063A-3D
.512	DCM 0512-409-063A-8D	.197	DCM 0512-153-063A-3D
.551	DCM 0551-441-063A-8D	.197	DCM 0551-165-063A-3D
.591	DCM 0591-472-075A-8D	.197	DCM 0591-177-075A-3D
.630	DCM 0630-504-075A-8D	.197	DCM 0630-189-075A-3D
.669	DCM 0669-535-075A-8D	.197	DCM 0669-201-075A-3D
.709	DCM 0709-567-100A-8D	.197	DCM 0709-213-100A-3D
.748	DCM 0748-598-100A-8D	.197	DCM 0748-224-100A-3D
.787	DCM 0787-630-100A-8D	.197	DCM 0787-236-100A-3D



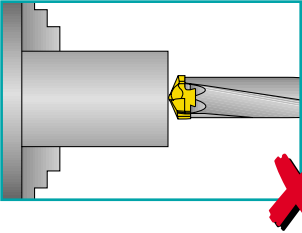
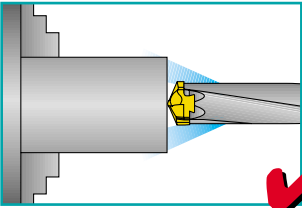
CHAMDRILL

User Guide

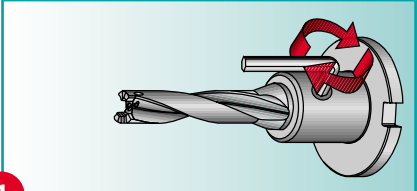
Coolant



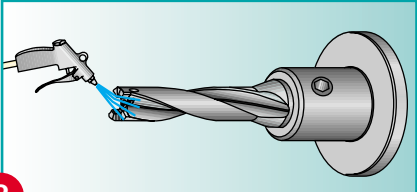
In stationary drill applications both through tool and external coolant supply is recommended.



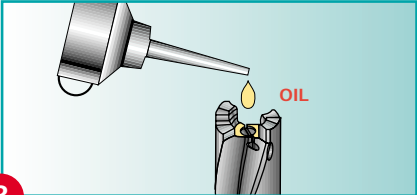
Drilling Heads Mounting Procedure



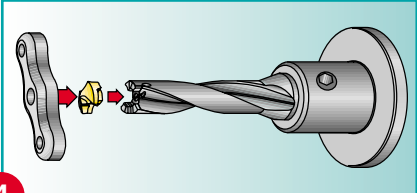
1



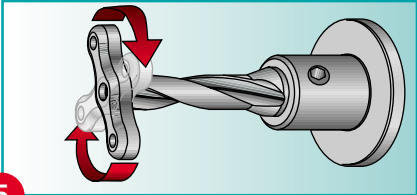
2



3



4



5

Machining Data

Following is machining data for the DCM drills.

ISO	Material	Condition	Hardness HB	Cutting Speed Vc sfm	Feed vs. Drill Diameter inch/rev						
					D=.315-.394	D=.433-.472	D=.512-.551	D=.591-.630	D=.669-.787	D=.827-.984	
P	Non-alloy steel and cast steel, free cutting steel	<0.25%	Annealed	125	160-430	.005-.008	.006-.010	.008-.012	.010-.014	.010-.018	.010-.018
		>=0.25%	Annealed	190	330-400						
		< 0.55%	Quenched and tempered	250	290-360						
		>=0.55%	Annealed	220	290-400						
			Quenched and tempered	300	230-290						
	Low alloy steel and cast steel (less than 5% alloying elements)	Annealed	200	260-430	.005-.008	.006-.010	.008-.012	.010-.014	.012-.016	.012-.018	
			275	230-360							
		Quenched and tempered	300	190-290							
High alloyed steel, cast steel, and tool steel	Annealed	200	160-260	.005-.008	.005-.009	.006-.010	.008-.011	.010-.013	.010-.014		
		Quenched and tempered	325							130-230	
M	Stainless steel and cast steel	Ferritic/martensitic	200	60-170	.003-.006	.004-.006	.005-.007	.006-.008	.006-.009	.006-.011	
		Martensitic	240	60-170							
		Austenitic	180	60-170							
K	Cast iron nodular (GGG)	Ferritic/pearlitic	180	290-460	.005-.012	.010-.014	.012-.016	.014-.018	.016-.020	.016-.024	
		Pearlitic	260	260-430							
	Grey cast iron (GG)	Ferritic	160	330-590							
		Pearlitic	250								
	Malleable cast iron	Ferritic	130								
Pearlitic		230									
N	Aluminum-wrought alloy <=12% Si	Not cureable	60	290-530	.005-.014	.010-.016	.012-.018	.014-.020	.016-.024	.016-.026	
		Cured	100								
		Not cureable	75								
	Aluminum-cast, alloyed >12% Si	Cured	90	260-400							
		High temperature	130								
	Copper alloys >1% Pb	Free cutting	110								
		Brass	90	290-530							
Non metallic	Electrolytic copper	100									
	Duroplastics, fiber plastics										
S	High temp. alloys Fe based	Annealed	200	100-170	.002-.004	.003-.005	.004-.006	.005-.007	.005-.008	.005-.009	
		Cured	280								
		Super alloys Ni or Co based	Annealed	250							60-130
			Cured	350							
	Titanium Ti alloys	Cast	320								
Alpha+beta alloys cured			60-170								
H	Hardened steel	Hardened	55 HRC	60-170	.002-.005	.004-.006	.005-.007	.006-.008	.006-.009	.006-.010	
		Hardened	60 HRC								
	Chilled cast iron	Cast	400								
	Cast iron	Hardened	55 HRC								

* Grades: first choice IC908.

* For material group number please refer to our general catalog instructions.

* This table refers to 3/5xD drills ratio usage, for 8xD ratio decrease cutting data by 20%.

* Chipformer should be selected based on our geometry range recommendations.

* When using external coolant supply only, reduce cutting speed by 10%.

* Use internal coolant supply when machining austenitic stainless steel.