CVD DIAMOND COATED DRILLS

DCSSS

Short, For non-ferrous material

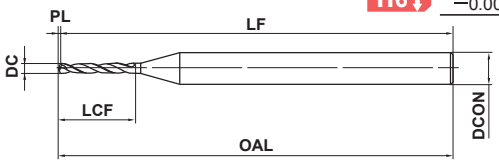
UWC | DC | 130° DC<1.5 | 135° DC≥1.5 | X Thinning DC≥1.5

P | M | K | **N** | S | H

Non-ferrous Metal

0.2≤DC≤2

h6 $^{0}_{-0.014}$ $^{0}_{-0.006}$



● The original CVD diamond coating technology provides excellent adhesion for coating layer and enables stable drilling without peeling or chipping.

Unit : mm

Order Number	DC	LCF	OAL	LF	PL	DCON	Stock
DCSSSD0020	0.2	2.05	38.05	38	0.05	3	●
DCSSSD0030	0.3	3.07	38.07	38	0.07	3	●
DCSSSD0040	0.4	4.09	38.09	38	0.09	3	●
DCSSSD0050	0.5	4.12	38.12	38	0.12	3	●
DCSSSD0060	0.6	5.14	38.14	38	0.14	3	●
DCSSSD0070	0.7	5.16	38.16	38	0.16	3	●
DCSSSD0080	0.8	6.19	38.19	38	0.19	3	●
DCSSSD0090	0.9	6.21	38.21	38	0.21	3	●
DCSSSD0100	1.0	8.2	38.2	38	0.2	3	●
DCSSSD0110	1.1	8.3	38.3	38	0.3	3	●

Order Number	DC	LCF	OAL	LF	PL	DCON	Stock
DCSSSD0120	1.2	8.3	38.3	38	0.3	3	●
DCSSSD0130	1.3	8.3	38.3	38	0.3	3	●
DCSSSD0140	1.4	8.3	38.3	38	0.3	3	●
DCSSSD0150	1.5	10.3	45.3	45	0.3	3	●
DCSSSD0160	1.6	10.3	45.3	45	0.3	3	●
DCSSSD0170	1.7	10.4	45.4	45	0.4	3	●
DCSSSD0180	1.8	10.4	45.4	45	0.4	3	●
DCSSSD0190	1.9	10.4	45.4	45	0.4	3	●
DCSSSD0200	2.0	12.4	45.4	45	0.4	3	●

DCSSM

Medium, For non-ferrous material

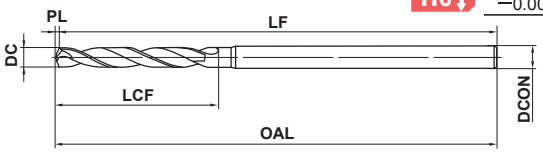
UWC | DC | 135° | X Thinning

P | M | K | **N** | S | H

Non-ferrous Metal

2.1≤DC≤3

h6 $^{0}_{-0.014}$ $^{0}_{-0.006}$



● The original CVD diamond coating technology provides excellent adhesion for coating layer and enables stable drilling without peeling or chipping.

Unit : mm

Order Number	DC	LCF	OAL	LF	PL	DCON	Stock
DCSSMD0210	2.1	17.4	60.4	60	0.4	3	●
DCSSMD0220	2.2	17.5	60.5	60	0.5	3	●
DCSSMD0230	2.3	17.5	60.5	60	0.5	3	●
DCSSMD0240	2.4	17.5	60.5	60	0.5	3	●
DCSSMD0250	2.5	21.5	60.5	60	0.5	3	●

Order Number	DC	LCF	OAL	LF	PL	DCON	Stock
DCSSMD0260	2.6	21.5	60.5	60	0.5	3	●
DCSSMD0270	2.7	21.6	60.6	60	0.6	3	●
DCSSMD0280	2.8	21.6	60.6	60	0.6	3	●
DCSSMD0290	2.9	21.6	60.6	60	0.6	3	●
DCSSMD0300	3.0	21.6	60.6	60	0.6	3	●

● : Inventory maintained in Japan.

RECOMMENDED CUTTING CONDITIONS

Work Material	Aluminium alloy		Aluminium alloy		Copper Copper alloy		Graphite Machineable Ceramics		MMC FRP	
Dia. **DC** (mm)	Revolution (min-1)	Feed rate (mm/rev)	Revolution (min-1)	Feed rate (mm/rev)	Revolution (min-1)	Feed rate (mm/rev)	Revolution (min-1)	Feed rate (mm/rev)	Revolution (min-1)	Feed rate (mm/rev)
0.2	20000	0.006	10000	0.003	20000	0.003	20000	0.01	10000	0.003
0.5	20000	0.02	10000	0.01	20000	0.01	20000	0.03	10000	0.01
1.0	20000	0.04	10000	0.02	20000	0.02	20000	0.05	10000	0.02
1.5	20000	0.05	10000	0.02	16000	0.02	16000	0.08	10000	0.02
2.0	20000	0.06	9000	0.03	11000	0.03	11000	0.10	9000	0.03
2.5	18500	0.08	7500	0.04	10000	0.04	10000	0.12	7500	0.04
3.0	17000	0.10	6000	0.05	8500	0.05	8500	0.15	6000	0.05

1) When drilling very hard work materials, reduce the feed.
2) Use water soluble coolant or grinding fluid when working.
3) When drilling deep holes, moderate the cutting conditions.
4) The revolution can be increased by using a high speed spindle.