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0086 - 411 - 88530360

ADD: NO.16-3, 3rd Shengming Road DD Port, Dalian China

BELZ INC.

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DMF-HP

High Performance HSS-PM Drill (Reinforced Shank)

Product Features:

◆ Self-Centering Drill Point Design

- Eliminate the need for pre-drilling pilot holes, significantly reducing tool-changing and programming time.

◆ Premium HSS-PM Material

- Deliver over 2 x longer tool life compared to conventional HSS drill bits.

◆ Advanced Nano-Coating Technology

- Effectively isolate cutting heat, reducing thermal oxidation risks and further extending tool life.

◆ Optimized X-Shaped Cutting Edge & Dual Relief Angle Design

- Minimize cutting resistance and prevent built-up edge (BUE) formation.

◆ Rational Helix Angle & U-Shaped Flute Design

- Enhance chip evacuation, reducing chip clogging and entanglement.

◆ Excellent Versatility

- Suitable for machining stainless steel, carbon steel, non-ferrous metals, and more.

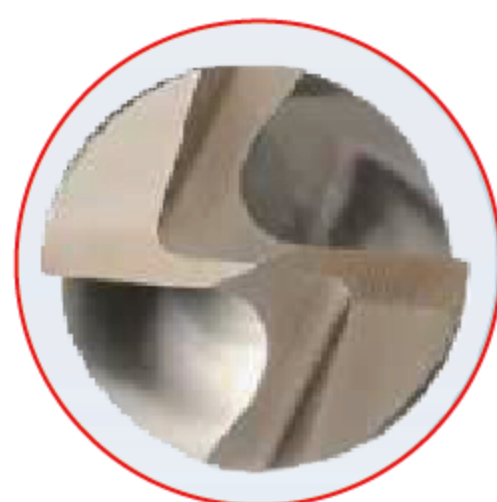
$D \leq 1.9$ Point Angle 118°

$D > 1.9$ Point Angle 135°

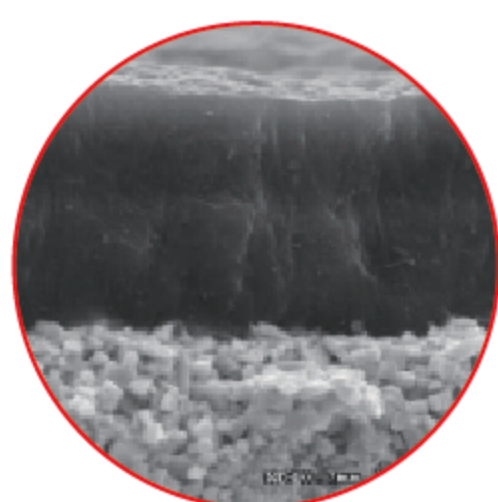


Enlarged Chip Flute

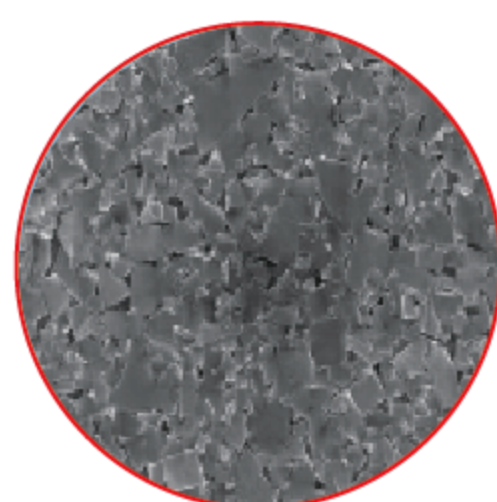
(Rational Helix Angle & U-Shaped Flute Design)



Self-Centering & Split Point Design

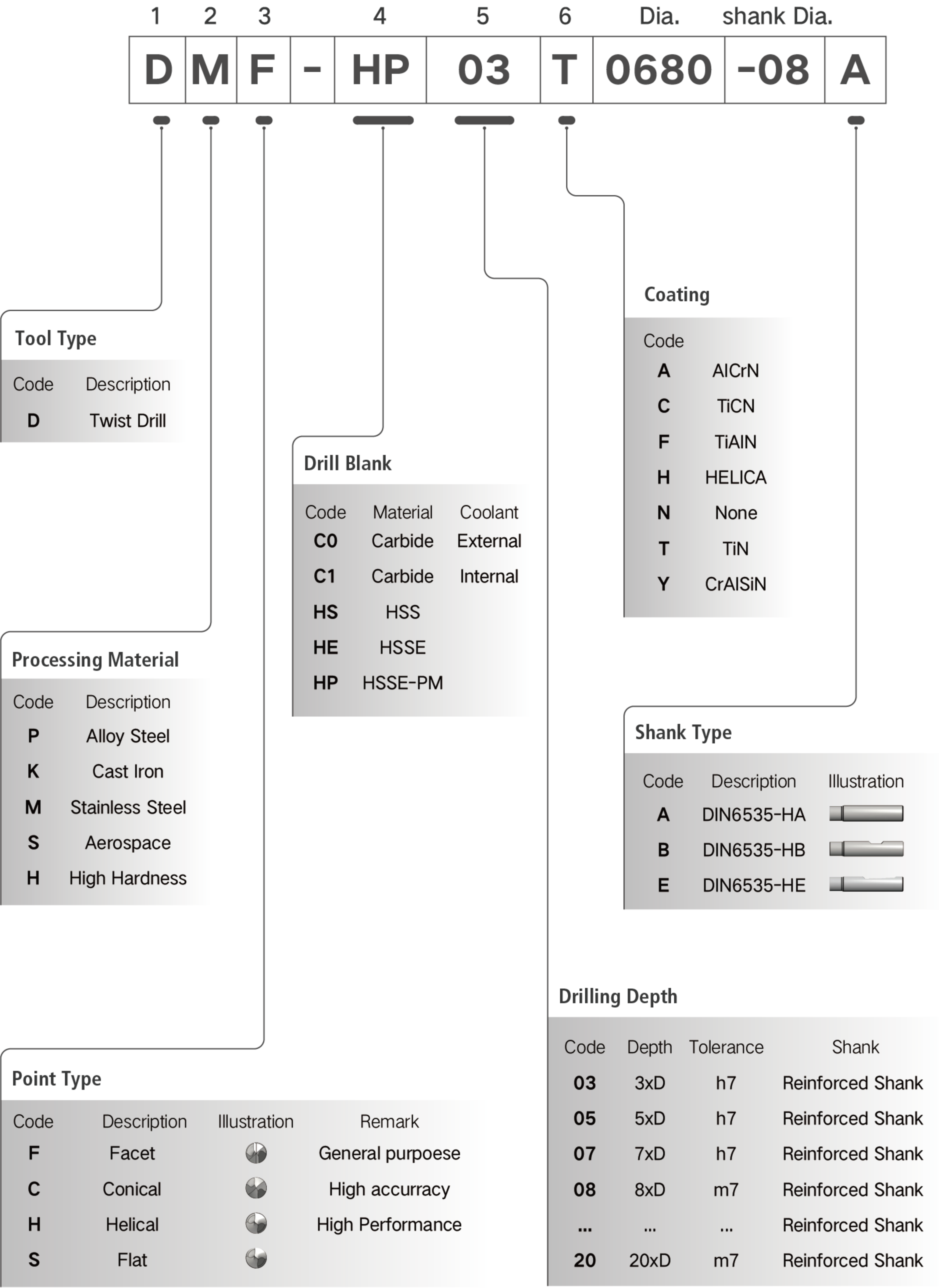


Nano-coating isolates cutting heat



Premium HSS-PM Material

Drill Bit Coding Rules



DMF-HP

High Performance HSS-PM Drill (Reinforced Shank)



TiN

h7

HELIX
N

118°

D ≤ 1.9

135°

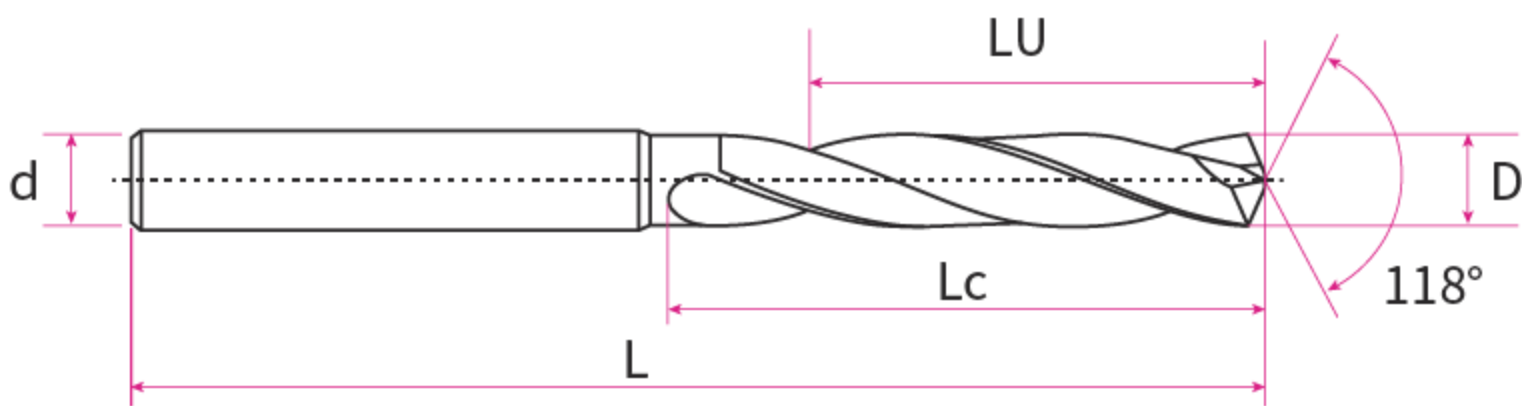
D > 1.9

3RAKE

D > 1.4

2RAKE

D ≤ 1.4



Max. Recommended Depth: LU=Lc-1.5D

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0050-03A	0.50	3	40	3	●
DMF-HP03T0051-03A	0.51	3	40	3	●
DMF-HP03T0052-03A	0.52	3	40	3	●
DMF-HP03T0053-03A	0.53	3	40	3	●
DMF-HP03T0054-03A	0.54	3	40	3	●
DMF-HP03T0055-03A	0.55	3	40	3	●
DMF-HP03T0056-03A	0.56	3	40	3	●
DMF-HP03T0057-03A	0.57	3	40	3	●
DMF-HP03T0058-03A	0.58	3	40	3	●
DMF-HP03T0059-03A	0.59	3	40	3	●
DMF-HP03T0060-03A	0.60	3.5	40	3	●
DMF-HP03T0061-03A	0.61	3.5	40	3	●
DMF-HP03T0062-03A	0.62	3.5	40	3	●
DMF-HP03T0063-03A	0.63	3.5	40	3	●
DMF-HP03T0064-03A	0.64	3.5	40	3	●
DMF-HP03T0065-03A	0.65	3.5	40	3	●
DMF-HP03T0066-03A	0.66	3.5	40	3	●
DMF-HP03T0067-03A	0.67	3.5	40	3	●
DMF-HP03T0068-03A	0.68	3.5	40	3	●
DMF-HP03T0069-03A	0.69	3.5	40	3	●
DMF-HP03T0070-03A	0.70	3.5	40	3	●
DMF-HP03T0071-03A	0.71	4.5	40	3	●
DMF-HP03T0072-03A	0.72	4.5	40	3	●
DMF-HP03T0073-03A	0.73	4.5	40	3	●
DMF-HP03T0074-03A	0.74	4.5	40	3	●
DMF-HP03T0075-03A	0.75	4.5	40	3	●
DMF-HP03T0076-03A	0.76	4.5	40	3	●
DMF-HP03T0077-03A	0.77	4.5	40	3	●
DMF-HP03T0078-03A	0.78	4.5	40	3	●
DMF-HP03T0079-03A	0.79	4.5	40	3	●
DMF-HP03T0080-03A	0.80	5	40	3	●
DMF-HP03T0081-03A	0.81	5	40	3	●
DMF-HP03T0082-03A	0.82	5	40	3	●
DMF-HP03T0083-03A	0.83	5	40	3	●
DMF-HP03T0084-03A	0.84	5	40	3	●

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0085-03A	0.85	5	40	3	●
DMF-HP03T0086-03A	0.86	5	40	3	●
DMF-HP03T0087-03A	0.87	5	40	3	●
DMF-HP03T0088-03A	0.88	5	40	3	●
DMF-HP03T0089-03A	0.89	5	40	3	●
DMF-HP03T0090-03A	0.90	5.5	40	3	●
DMF-HP03T0091-03A	0.91	5.5	40	3	●
DMF-HP03T0092-03A	0.92	5.5	40	3	●
DMF-HP03T0093-03A	0.93	5.5	40	3	●
DMF-HP03T0094-03A	0.94	5.5	40	3	●
DMF-HP03T0095-03A	0.95	5.5	40	3	●
DMF-HP03T0096-03A	0.96	5.5	40	3	●
DMF-HP03T0097-03A	0.97	5.5	40	3	●
DMF-HP03T0098-03A	0.98	5.5	40	3	●
DMF-HP03T0099-03A	0.99	5.5	40	3	●
DMF-HP03T0100-03A	1.00	6	40	3	●
DMF-HP03T0101-03A	1.01	6	40	3	●
DMF-HP03T0102-03A	1.02	6	40	3	●
DMF-HP03T0103-03A	1.03	6	40	3	●
DMF-HP03T0104-03A	1.04	6	40	3	●
DMF-HP03T0105-03A	1.05	6	40	3	●
DMF-HP03T0106-03A	1.06	6	40	3	●
DMF-HP03T0107-03A	1.07	7	40	3	●
DMF-HP03T0108-03A	1.08	7	40	3	●
DMF-HP03T0109-03A	1.09	7	40	3	●
DMF-HP03T0110-03A	1.10	7	40	3	●
DMF-HP03T0111-03A	1.11	7	40	3	●
DMF-HP03T0112-03A	1.12	7	40	3	●
DMF-HP03T0113-03A	1.13	7	40	3	●
DMF-HP03T0114-03A	1.14	7	40	3	●
DMF-HP03T0115-03A	1.15	7	40	3	●
DMF-HP03T0116-03A	1.16	7	40	3	●
DMF-HP03T0117-03A	1.17	7	40	3	●
DMF-HP03T0118-03A	1.18	7	40	3	●

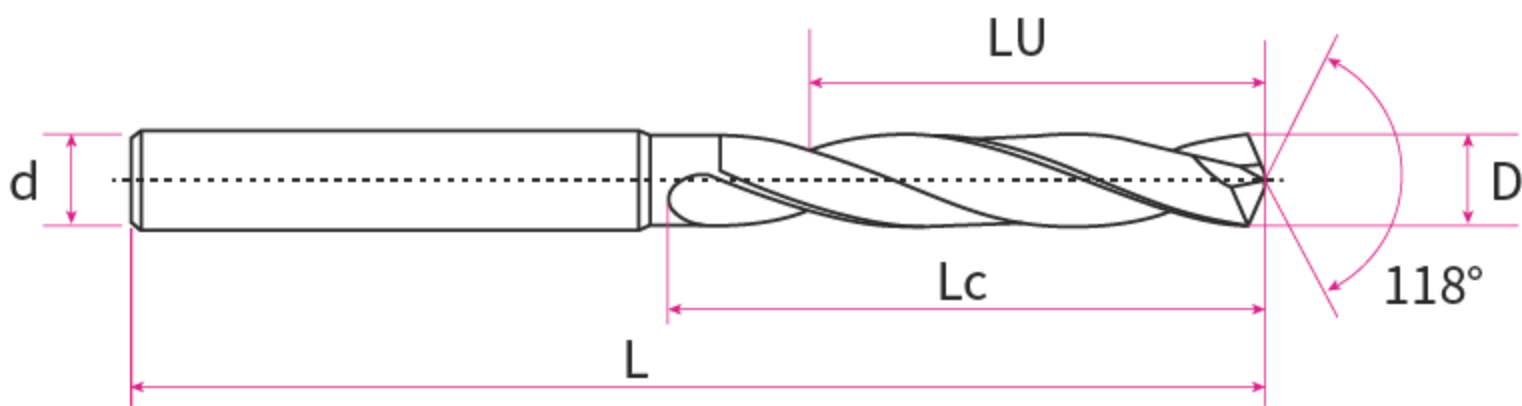
● Available ● Production to order

P		M	K	N			S	
CARBON STEELS	ALLOY STEELS	STAINLESS STEELS	GARY CAST IRON	Wrought Aluminum Alloy	COPPER ALLOYS	Composite Material	High-Temperature Alloy	Titanium Alloy
ALLOY STEELS	TOOL STEELS		DUCTILE CAST IRON	Cast Aluminum Alloy				
~35HRC	~48HRC			Si<12%	<HB200		<HB450	<400HB
○	○	○		○	○		○	○

○ Very suitable ○ Suitable

DMF-HP

High Performance HSS-PM Drill (Reinforced Shank)



Max. Recommended Depth: LU=Lc-1.5D

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0119-03A	1.19	8	40	3	●
DMF-HP03T0120-03A	1.20	8	40	3	●
DMF-HP03T0121-03A	1.21	8	40	3	●
DMF-HP03T0122-03A	1.22	8	40	3	●
DMF-HP03T0123-03A	1.23	8	40	3	●
DMF-HP03T0124-03A	1.24	8	40	3	●
DMF-HP03T0125-03A	1.25	8	40	3	●
DMF-HP03T0126-03A	1.26	8	40	3	●
DMF-HP03T0127-03A	1.27	8	40	3	●
DMF-HP03T0128-03A	1.28	8	40	3	●
DMF-HP03T0129-03A	1.29	8	40	3	●
DMF-HP03T0130-03A	1.30	8	40	3	●
DMF-HP03T0131-03A	1.31	8	40	3	●
DMF-HP03T0132-03A	1.32	8	40	3	●
DMF-HP03T0133-03A	1.33	9	45	3	●
DMF-HP03T0134-03A	1.34	9	45	3	●
DMF-HP03T0135-03A	1.35	9	45	3	●
DMF-HP03T0136-03A	1.36	9	45	3	●
DMF-HP03T0137-03A	1.37	9	45	3	●
DMF-HP03T0138-03A	1.38	9	45	3	●
DMF-HP03T0139-03A	1.39	9	45	3	●
DMF-HP03T0140-03A	1.40	9	45	3	●
DMF-HP03T0141-03A	1.41	9	45	3	●
DMF-HP03T0142-03A	1.42	9	45	3	●
DMF-HP03T0143-03A	1.43	9	45	3	●
DMF-HP03T0144-03A	1.44	9	45	3	●
DMF-HP03T0145-03A	1.45	9	45	3	●
DMF-HP03T0146-03A	1.46	9	45	3	●
DMF-HP03T0147-03A	1.47	9	45	3	●
DMF-HP03T0148-03A	1.48	9	45	3	●
DMF-HP03T0149-03A	1.49	9	45	3	●
DMF-HP03T0150-03A	1.50	9	45	3	●
DMF-HP03T0151-03A	1.51	10	45	3	●
DMF-HP03T0152-03A	1.52	10	45	3	●
DMF-HP03T0153-03A	1.53	10	45	3	●

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0154-03A	1.54	10	45	3	●
DMF-HP03T0155-03A	1.55	10	45	3	●
DMF-HP03T0156-03A	1.56	10	45	3	●
DMF-HP03T0157-03A	1.57	10	45	3	●
DMF-HP03T0158-03A	1.58	10	45	3	●
DMF-HP03T0159-03A	1.59	10	45	3	●
DMF-HP03T0160-03A	1.60	10	45	3	●
DMF-HP03T0161-03A	1.61	10	45	3	●
DMF-HP03T0162-03A	1.62	10	45	3	●
DMF-HP03T0163-03A	1.63	10	45	3	●
DMF-HP03T0164-03A	1.64	10	45	3	●
DMF-HP03T0165-03A	1.65	10	45	3	●
DMF-HP03T0166-03A	1.66	10	45	3	●
DMF-HP03T0167-03A	1.67	10	45	3	●
DMF-HP03T0168-03A	1.68	10	45	3	●
DMF-HP03T0169-03A	1.69	10	45	3	●
DMF-HP03T0170-03A	1.70	10	45	3	●
DMF-HP03T0171-03A	1.71	11	45	3	●
DMF-HP03T0172-03A	1.72	11	45	3	●
DMF-HP03T0173-03A	1.73	11	45	3	●
DMF-HP03T0174-03A	1.74	11	45	3	●
DMF-HP03T0175-03A	1.75	11	45	3	●
DMF-HP03T0176-03A	1.76	11	45	3	●
DMF-HP03T0177-03A	1.77	11	45	3	●
DMF-HP03T0178-03A	1.78	11	45	3	●
DMF-HP03T0179-03A	1.79	11	45	3	●
DMF-HP03T0180-03A	1.80	11	45	3	●
DMF-HP03T0181-03A	1.81	11	45	3	●
DMF-HP03T0182-03A	1.82	11	45	3	●
DMF-HP03T0183-03A	1.83	11	45	3	●
DMF-HP03T0184-03A	1.84	11	45	3	●
DMF-HP03T0185-03A	1.85	11	45	3	●
DMF-HP03T0186-03A	1.86	11	45	3	●
DMF-HP03T0187-03A	1.87	11	45	3	●

● Available ● Production to order

P		M	K	N			S	
CARBON STEELS	ALLOY STEELS	STAINLESS STEELS	GARY CAST IRON	Wrought Aluminum Alloy	COPPER ALLOYS	Composite Material	High-Temperature Alloy	Titanium Alloy
ALLOY STEELS	TOOL STEELS		DUCTILE CAST IRON	Cast Aluminum Alloy				
~35HRC	~48HRC			Si<12%	<HB200		<HB450	<400HB
○	○	○		○	○		○	○

○ Very suitable ○ Suitable

DMF-HP

High Performance HSS-PM Drill (Reinforced Shank)



TiN

h7

HELIX
N

118°

D≤1.9

135°

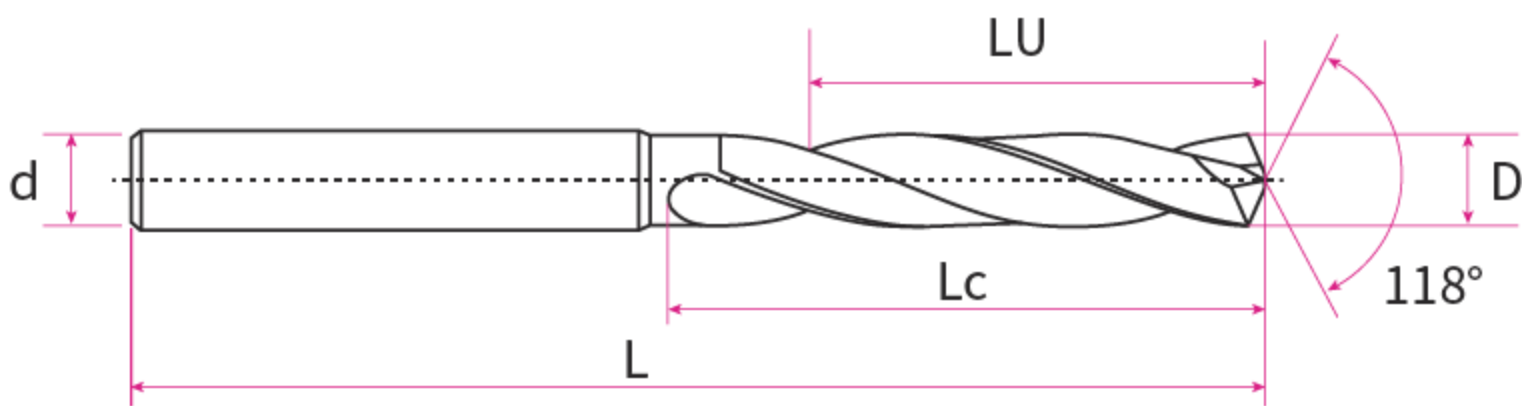
D>1.9

3RAKE

D>1.4

2RAKE

D≤1.4



Max. Recommended Depth: LU=Lc-1.5D

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0188-03A	1.88	11	45	3	●
DMF-HP03T0189-03A	1.89	11	45	3	●
DMF-HP03T0190-03A	1.90	11	45	3	●
DMF-HP03T0191-03A	1.91	12	45	3	●
DMF-HP03T0192-03A	1.92	12	45	3	●
DMF-HP03T0193-03A	1.93	12	45	3	●
DMF-HP03T0194-03A	1.94	12	45	3	●
DMF-HP03T0195-03A	1.95	12	45	3	●
DMF-HP03T0196-03A	1.96	12	45	3	●
DMF-HP03T0197-03A	1.97	12	45	3	●
DMF-HP03T0198-03A	1.98	12	45	3	●
DMF-HP03T0199-03A	1.99	12	45	3	●
DMF-HP03T0200-03A	2.00	12	45	3	●
DMF-HP03T0201-03A	2.01	12	45	3	●
DMF-HP03T0202-03A	2.02	12	45	3	●
DMF-HP03T0203-03A	2.03	12	45	3	●
DMF-HP03T0204-03A	2.04	12	45	3	●
DMF-HP03T0205-03A	2.05	12	45	3	●
DMF-HP03T0206-03A	2.06	12	45	3	●
DMF-HP03T0207-03A	2.07	12	45	3	●
DMF-HP03T0208-03A	2.08	12	45	3	●
DMF-HP03T0209-03A	2.09	12	45	3	●
DMF-HP03T0210-03A	2.10	12	45	3	●
DMF-HP03T0211-03A	2.11	12	45	3	●
DMF-HP03T0212-03A	2.12	12	45	3	●
DMF-HP03T0213-03A	2.13	13	45	3	●
DMF-HP03T0214-03A	2.14	13	45	3	●
DMF-HP03T0215-03A	2.15	13	45	3	●
DMF-HP03T0216-03A	2.16	13	45	3	●
DMF-HP03T0217-03A	2.17	13	45	3	●
DMF-HP03T0218-03A	2.18	13	45	3	●
DMF-HP03T0219-03A	2.19	13	45	3	●
DMF-HP03T0220-03A	2.20	13	45	3	●
DMF-HP03T0221-03A	2.21	13	45	3	●
DMF-HP03T0222-03A	2.22	13	45	3	●

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0223-03A	2.23	13	45	3	●
DMF-HP03T0224-03A	2.24	13	45	3	●
DMF-HP03T0225-03A	2.25	13	45	3	●
DMF-HP03T0226-03A	2.26	13	45	3	●
DMF-HP03T0227-03A	2.27	13	45	3	●
DMF-HP03T0228-03A	2.28	13	45	3	●
DMF-HP03T0229-03A	2.29	13	45	3	●
DMF-HP03T0230-03A	2.30	13	45	3	●
DMF-HP03T0231-03A	2.31	13	45	3	●
DMF-HP03T0232-03A	2.32	13	45	3	●
DMF-HP03T0233-03A	2.33	13	45	3	●
DMF-HP03T0234-03A	2.34	13	45	3	●
DMF-HP03T0235-03A	2.35	13	45	3	●
DMF-HP03T0236-03A	2.36	13	45	3	●
DMF-HP03T0237-03A	2.37	14	50	3	●
DMF-HP03T0238-03A	2.38	14	50	3	●
DMF-HP03T0239-03A	2.39	14	50	3	●
DMF-HP03T0240-03A	2.40	14	50	3	●
DMF-HP03T0241-03A	2.41	14	50	3	●
DMF-HP03T0242-03A	2.42	14	50	3	●
DMF-HP03T0243-03A	2.43	14	50	3	●
DMF-HP03T0244-03A	2.44	14	50	3	●
DMF-HP03T0245-03A	2.45	14	50	3	●
DMF-HP03T0246-03A	2.46	14	50	3	●
DMF-HP03T0247-03A	2.47	14	50	3	●
DMF-HP03T0248-03A	2.48	14	50	3	●
DMF-HP03T0249-03A	2.49	14	50	3	●
DMF-HP03T0250-03A	2.50	14	50	3	●
DMF-HP03T0251-03A	2.51	14	50	3	●
DMF-HP03T0252-03A	2.52	14	50	3	●
DMF-HP03T0253-03A	2.53	14	50	3	●
DMF-HP03T0254-03A	2.54	14	50	3	●
DMF-HP03T0255-03A	2.55	14	50	3	●
DMF-HP03T0256-03A	2.56	14	50	3	●

● Available ● Production to order

P		M	K	N			S	
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ALLOY STEELS	TOOL STEELS		DUCTILE CAST IRON	Cast Aluminum Alloy				
~35HRC	~48HRC			Si<12%	<HB200		<HB450	<400HB
○	○	○		○	○		○	○

○ Very suitable ○ Suitable

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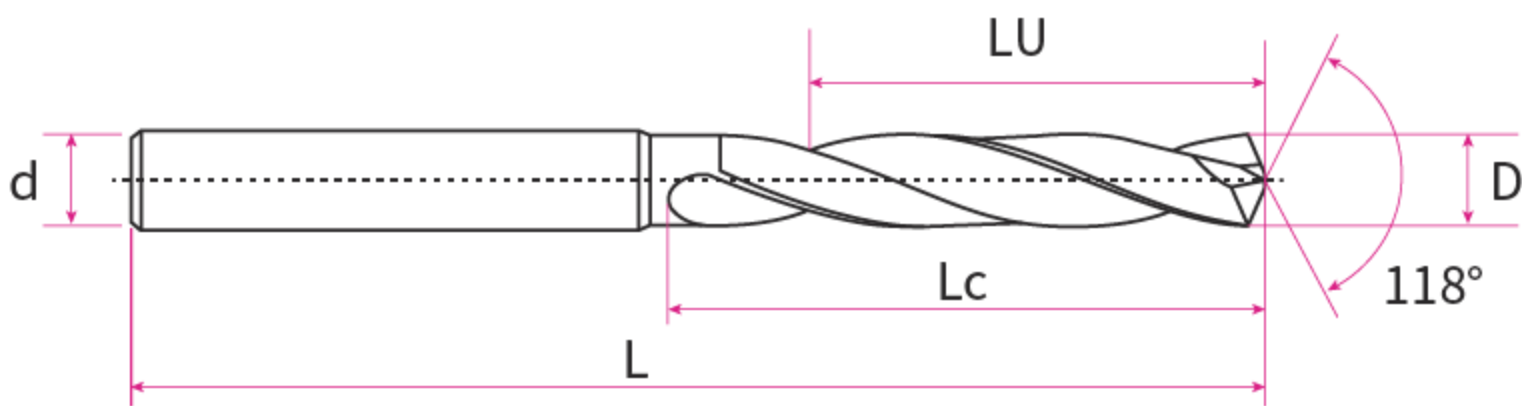
D > 1.9

3RAKE

D > 1.4

2RAKE

D ≤ 1.4



Max. Recommended Depth: LU=Lc-1.5D

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0257-03A	2.57	14	50	3	●
DMF-HP03T0258-03A	2.58	14	50	3	●
DMF-HP03T0259-03A	2.59	14	50	3	●
DMF-HP03T0260-03A	2.60	14	50	3	●
DMF-HP03T0261-03A	2.61	14	50	3	●
DMF-HP03T0262-03A	2.62	14	50	3	●
DMF-HP03T0263-03A	2.63	14	50	3	●
DMF-HP03T0264-03A	2.64	14	50	3	●
DMF-HP03T0265-03A	2.65	14	50	3	●
DMF-HP03T0266-03A	2.66	16	50	3	●
DMF-HP03T0267-03A	2.67	16	50	3	●
DMF-HP03T0268-03A	2.68	16	50	3	●
DMF-HP03T0269-03A	2.69	16	50	3	●
DMF-HP03T0270-03A	2.70	16	50	3	●
DMF-HP03T0271-03A	2.71	16	50	3	●
DMF-HP03T0272-03A	2.72	16	50	3	●
DMF-HP03T0273-03A	2.73	16	50	3	●
DMF-HP03T0274-03A	2.74	16	50	3	●
DMF-HP03T0275-03A	2.75	16	50	3	●
DMF-HP03T0276-03A	2.76	16	50	3	●
DMF-HP03T0277-03A	2.77	16	50	3	●
DMF-HP03T0278-03A	2.78	16	50	3	●
DMF-HP03T0279-03A	2.79	16	50	3	●
DMF-HP03T0280-03A	2.80	16	50	3	●
DMF-HP03T0281-03A	2.81	16	50	3	●
DMF-HP03T0282-03A	2.82	16	50	3	●
DMF-HP03T0283-03A	2.83	16	50	3	●
DMF-HP03T0284-03A	2.84	16	50	3	●
DMF-HP03T0285-03A	2.85	16	50	3	●
DMF-HP03T0286-03A	2.86	16	50	3	●
DMF-HP03T0287-03A	2.87	16	50	3	●
DMF-HP03T0288-03A	2.88	16	50	3	●
DMF-HP03T0289-03A	2.89	16	50	3	●
DMF-HP03T0290-03A	2.90	16	50	3	●
DMF-HP03T0291-03A	2.91	16	50	3	●

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0292-03A	2.92	16	50	3	●
DMF-HP03T0293-03A	2.93	16	50	3	●
DMF-HP03T0294-03A	2.94	16	50	3	●
DMF-HP03T0295-03A	2.95	16	50	3	●
DMF-HP03T0296-03A	2.96	16	50	3	●
DMF-HP03T0297-03A	2.97	16	50	3	●
DMF-HP03T0298-03A	2.98	16	50	3	●
DMF-HP03T0299-03A	2.99	16	50	3	●
DMF-HP03T0300-03A	3.00	16	50	3	●
DMF-HP03T0301-04A	3.01	18	55	4	●
DMF-HP03T0302-04A	3.02	18	55	4	●
DMF-HP03T0303-04A	3.03	18	55	4	●
DMF-HP03T0304-04A	3.04	18	55	4	●
DMF-HP03T0305-04A	3.05	18	55	4	●
DMF-HP03T0306-04A	3.06	18	55	4	●
DMF-HP03T0307-04A	3.07	18	55	4	●
DMF-HP03T0308-04A	3.08	18	55	4	●
DMF-HP03T0309-04A	3.09	18	55	4	●
DMF-HP03T0310-04A	3.10	18	55	4	●
DMF-HP03T0311-04A	3.11	18	55	4	●
DMF-HP03T0312-04A	3.12	18	55	4	●
DMF-HP03T0313-04A	3.13	18	55	4	●
DMF-HP03T0314-04A	3.14	18	55	4	●
DMF-HP03T0315-04A	3.15	18	55	4	●
DMF-HP03T0316-04A	3.16	18	55	4	●
DMF-HP03T0317-04A	3.17	18	55	4	●
DMF-HP03T0318-04A	3.18	18	55	4	●
DMF-HP03T0319-04A	3.19	18	55	4	●
DMF-HP03T0320-04A	3.20	18	55	4	●
DMF-HP03T0321-04A	3.21	18	55	4	●
DMF-HP03T0322-04A	3.22	18	55	4	●
DMF-HP03T0323-04A	3.23	18	55	4	●
DMF-HP03T0324-04A	3.24	18	55	4	●
DMF-HP03T0325-04A	3.25	18	55	4	●

● Available ● Production to order

P		M	K	N			S	
CARBON STEELS	ALLOY STEELS	STAINLESS STEELS	GARY CAST IRON	Wrought Aluminum Alloy	COPPER ALLOYS	Composite Material	High-Temperature Alloy	Titanium Alloy
ALLOY STEELS	TOOL STEELS		DUCTILE CAST IRON	Cast Aluminum Alloy				
~35HRC	~48HRC			Si<12%	<HB200		<HB450	<400HB
○	○	○		○	○		○	○

○ Very suitable ○ Suitable

DMF-HP

High Performance HSS-PM Drill (Reinforced Shank)



TiN

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HELIX
N

118°

D≤1.9

135°

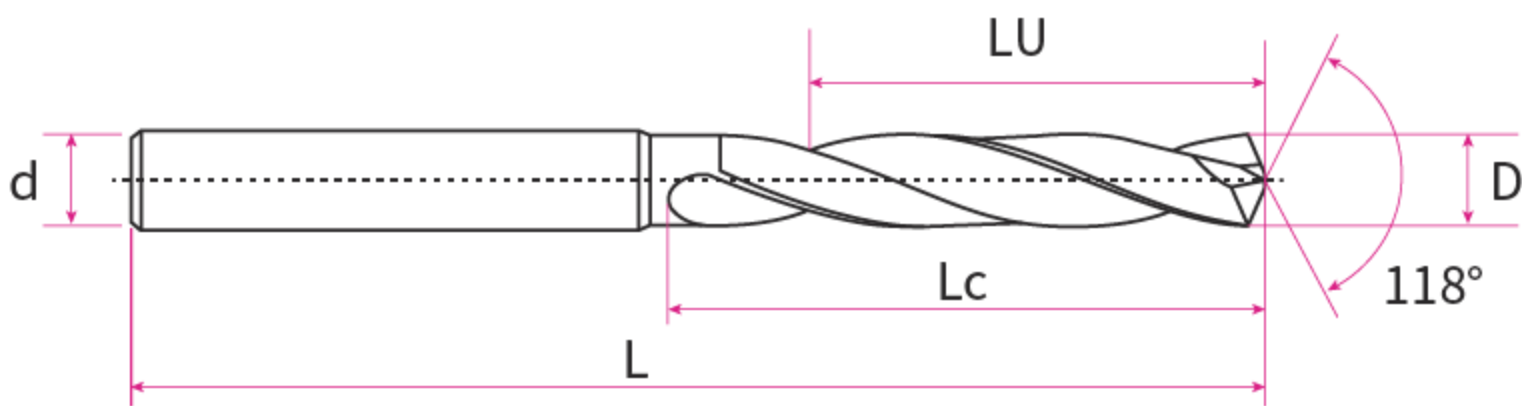
D>1.9

3RAKE

D>1.4

2RAKE

D≤1.4



Max. Recommended Depth: LU=Lc-1.5D

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0326-04A	3.26	18	55	4	●
DMF-HP03T0327-04A	3.27	18	55	4	●
DMF-HP03T0328-04A	3.28	18	55	4	●
DMF-HP03T0329-04A	3.29	18	55	4	●
DMF-HP03T0330-04A	3.30	18	55	4	●
DMF-HP03T0331-04A	3.31	18	55	4	●
DMF-HP03T0332-04A	3.32	18	55	4	●
DMF-HP03T0333-04A	3.33	18	55	4	●
DMF-HP03T0334-04A	3.34	18	55	4	●
DMF-HP03T0335-04A	3.35	18	55	4	●
DMF-HP03T0336-04A	3.36	20	55	4	●
DMF-HP03T0337-04A	3.37	20	55	4	●
DMF-HP03T0338-04A	3.38	20	55	4	●
DMF-HP03T0339-04A	3.39	20	55	4	●
DMF-HP03T0340-04A	3.40	20	55	4	●
DMF-HP03T0341-04A	3.41	20	55	4	●
DMF-HP03T0342-04A	3.42	20	55	4	●
DMF-HP03T0343-04A	3.43	20	55	4	●
DMF-HP03T0344-04A	3.44	20	55	4	●
DMF-HP03T0345-04A	3.45	20	55	4	●
DMF-HP03T0346-04A	3.46	20	55	4	●
DMF-HP03T0347-04A	3.47	20	55	4	●
DMF-HP03T0348-04A	3.48	20	55	4	●
DMF-HP03T0349-04A	3.49	20	55	4	●
DMF-HP03T0350-04A	3.50	20	55	4	●
DMF-HP03T0351-04A	3.51	20	55	4	●
DMF-HP03T0352-04A	3.52	20	55	4	●
DMF-HP03T0353-04A	3.53	20	55	4	●
DMF-HP03T0354-04A	3.54	20	55	4	●
DMF-HP03T0355-04A	3.55	20	55	4	●
DMF-HP03T0356-04A	3.56	20	55	4	●
DMF-HP03T0357-04A	3.57	20	55	4	●
DMF-HP03T0358-04A	3.58	20	55	4	●
DMF-HP03T0359-04A	3.59	20	55	4	●
DMF-HP03T0360-04A	3.60	20	55	4	●

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0361-04A	3.61	20	55	4	●
DMF-HP03T0362-04A	3.62	20	55	4	●
DMF-HP03T0363-04A	3.63	20	55	4	●
DMF-HP03T0364-04A	3.64	20	55	4	●
DMF-HP03T0365-04A	3.65	20	55	4	●
DMF-HP03T0366-04A	3.66	20	55	4	●
DMF-HP03T0367-04A	3.67	20	55	4	●
DMF-HP03T0368-04A	3.68	20	55	4	●
DMF-HP03T0369-04A	3.69	20	55	4	●
DMF-HP03T0370-04A	3.70	20	55	4	●
DMF-HP03T0371-04A	3.71	20	55	4	●
DMF-HP03T0372-04A	3.72	20	55	4	●
DMF-HP03T0373-04A	3.73	20	55	4	●
DMF-HP03T0374-04A	3.74	20	55	4	●
DMF-HP03T0375-04A	3.75	20	55	4	●
DMF-HP03T0376-04A	3.76	22	55	4	●
DMF-HP03T0377-04A	3.77	22	55	4	●
DMF-HP03T0378-04A	3.78	22	55	4	●
DMF-HP03T0379-04A	3.79	22	55	4	●
DMF-HP03T0380-04A	3.80	22	55	4	●
DMF-HP03T0381-04A	3.81	22	55	4	●
DMF-HP03T0382-04A	3.82	22	55	4	●
DMF-HP03T0383-04A	3.83	22	55	4	●
DMF-HP03T0384-04A	3.84	22	55	4	●
DMF-HP03T0385-04A	3.85	22	55	4	●
DMF-HP03T0386-04A	3.86	22	55	4	●
DMF-HP03T0387-04A	3.87	22	55	4	●
DMF-HP03T0388-04A	3.88	22	55	4	●
DMF-HP03T0389-04A	3.89	22	55	4	●
DMF-HP03T0390-04A	3.90	22	55	4	●
DMF-HP03T0391-04A	3.91	22	55	4	●
DMF-HP03T0392-04A	3.92	22	55	4	●
DMF-HP03T0393-04A	3.93	22	55	4	●
DMF-HP03T0394-04A	3.94	22	55	4	●

● Available ● Production to order

P		M	K	N			S	
CARBON STEELS	ALLOY STEELS	STAINLESS STEELS	GARY CAST IRON	Wrought Aluminum Alloy	COPPER ALLOYS	Composite Material	High-Temperature Alloy	Titanium Alloy
ALLOY STEELS	TOOL STEELS		DUCTILE CAST IRON	Cast Aluminum Alloy				
~35HRC	~48HRC			Si<12%	<HB200		<HB450	<400HB
○	○	○		○	○		○	○

○ Very suitable ○ Suitable

DMF-HP

High Performance HSS-PM Drill (Reinforced Shank)



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HELIX
N

118°

D ≤ 1.9

135°

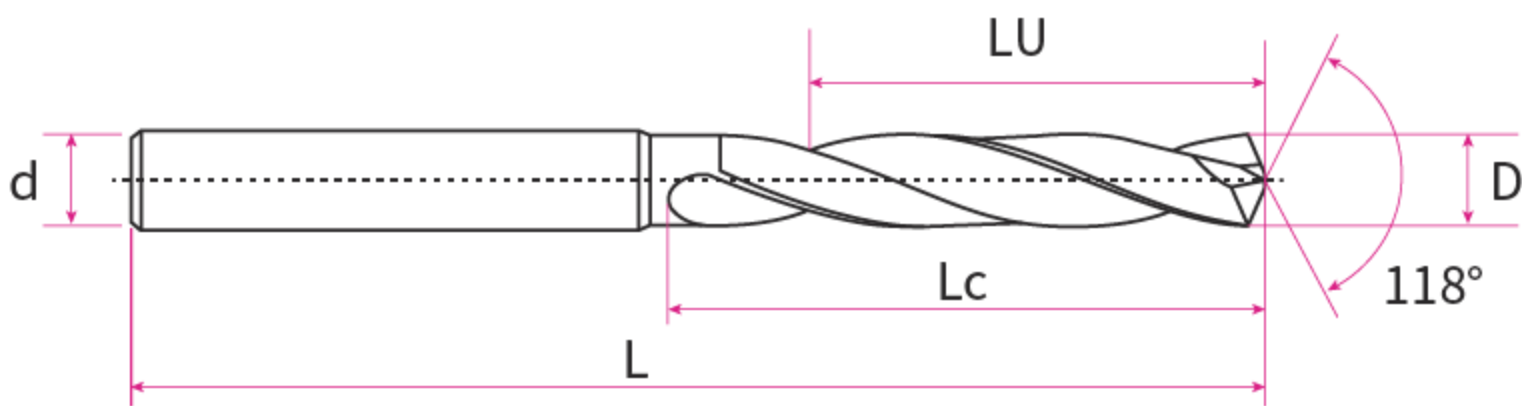
D > 1.9

3RAKE

D > 1.4

2RAKE

D ≤ 1.4



Max. Recommended Depth: LU=Lc-1.5D

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0395-04A	3.95	22	55	4	●
DMF-HP03T0396-04A	3.96	22	55	4	●
DMF-HP03T0397-04A	3.97	22	55	4	●
DMF-HP03T0398-04A	3.98	22	55	4	●
DMF-HP03T0399-04A	3.99	22	55	4	●
DMF-HP03T0400-04A	4.00	22	55	4	●
DMF-HP03T0401-06A	4.01	22	68	6	●
DMF-HP03T0402-06A	4.02	22	68	6	●
DMF-HP03T0403-06A	4.03	22	68	6	●
DMF-HP03T0404-06A	4.04	22	68	6	●
DMF-HP03T0405-06A	4.05	22	68	6	●
DMF-HP03T0406-06A	4.06	22	68	6	●
DMF-HP03T0407-06A	4.07	22	68	6	●
DMF-HP03T0408-06A	4.08	22	68	6	●
DMF-HP03T0409-06A	4.09	22	68	6	●
DMF-HP03T0410-06A	4.10	22	68	6	●
DMF-HP03T0411-06A	4.11	22	68	6	●
DMF-HP03T0412-06A	4.12	22	68	6	●
DMF-HP03T0413-06A	4.13	22	68	6	●
DMF-HP03T0414-06A	4.14	22	68	6	●
DMF-HP03T0415-06A	4.15	22	68	6	●
DMF-HP03T0416-06A	4.16	22	68	6	●
DMF-HP03T0417-06A	4.17	22	68	6	●
DMF-HP03T0418-06A	4.18	22	68	6	●
DMF-HP03T0419-06A	4.19	22	68	6	●
DMF-HP03T0420-06A	4.20	22	68	6	●
DMF-HP03T0421-06A	4.21	22	68	6	●
DMF-HP03T0422-06A	4.22	22	68	6	●
DMF-HP03T0423-06A	4.23	22	68	6	●
DMF-HP03T0424-06A	4.24	22	68	6	●
DMF-HP03T0425-06A	4.25	22	68	6	●
DMF-HP03T0426-06A	4.26	24	68	6	●
DMF-HP03T0427-06A	4.27	24	68	6	●
DMF-HP03T0428-06A	4.28	24	68	6	●
DMF-HP03T0429-06A	4.29	24	68	6	●

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0430-06A	4.30	24	68	6	●
DMF-HP03T0431-06A	4.31	24	68	6	●
DMF-HP03T0432-06A	4.32	24	68	6	●
DMF-HP03T0433-06A	4.33	24	68	6	●
DMF-HP03T0434-06A	4.34	24	68	6	●
DMF-HP03T0435-06A	4.35	24	68	6	●
DMF-HP03T0436-06A	4.36	24	68	6	●
DMF-HP03T0437-06A	4.37	24	68	6	●
DMF-HP03T0438-06A	4.38	24	68	6	●
DMF-HP03T0439-06A	4.39	24	68	6	●
DMF-HP03T0440-06A	4.40	24	68	6	●
DMF-HP03T0441-06A	4.41	24	68	6	●
DMF-HP03T0442-06A	4.42	24	68	6	●
DMF-HP03T0443-06A	4.43	24	68	6	●
DMF-HP03T0444-06A	4.44	24	68	6	●
DMF-HP03T0445-06A	4.45	24	68	6	●
DMF-HP03T0446-06A	4.46	24	68	6	●
DMF-HP03T0447-06A	4.47	24	68	6	●
DMF-HP03T0448-06A	4.48	24	68	6	●
DMF-HP03T0449-06A	4.49	24	68	6	●
DMF-HP03T0450-06A	4.50	24	68	6	●
DMF-HP03T0451-06A	4.51	24	68	6	●
DMF-HP03T0452-06A	4.52	24	68	6	●
DMF-HP03T0453-06A	4.53	24	68	6	●
DMF-HP03T0454-06A	4.54	24	68	6	●
DMF-HP03T0455-06A	4.55	24	68	6	●
DMF-HP03T0456-06A	4.56	24	68	6	●
DMF-HP03T0457-06A	4.57	24	68	6	●
DMF-HP03T0458-06A	4.58	24	68	6	●
DMF-HP03T0459-06A	4.59	24	68	6	●
DMF-HP03T0460-06A	4.60	24	68	6	●
DMF-HP03T0461-06A	4.61	24	68	6	●
DMF-HP03T0462-06A	4.62	24	68	6	●
DMF-HP03T0463-06A	4.63	24	68	6	●

● Available ● Production to order

P		M	K	N			S	
CARBON STEELS	ALLOY STEELS	STAINLESS STEELS	GARY CAST IRON	Wrought Aluminum Alloy	COPPER ALLOYS	Composite Material	High-Temperature Alloy	Titanium Alloy
ALLOY STEELS	TOOL STEELS		DUCTILE CAST IRON	Cast Aluminum Alloy				
~35HRC	~48HRC			Si<12%	<HB200		<HB450	<400HB
○	○	○		○	○		○	○

○ Very suitable ○ Suitable

DMF-HP

High Performance HSS-PM Drill (Reinforced Shank)



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HELIX
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118°

D≤1.9

135°

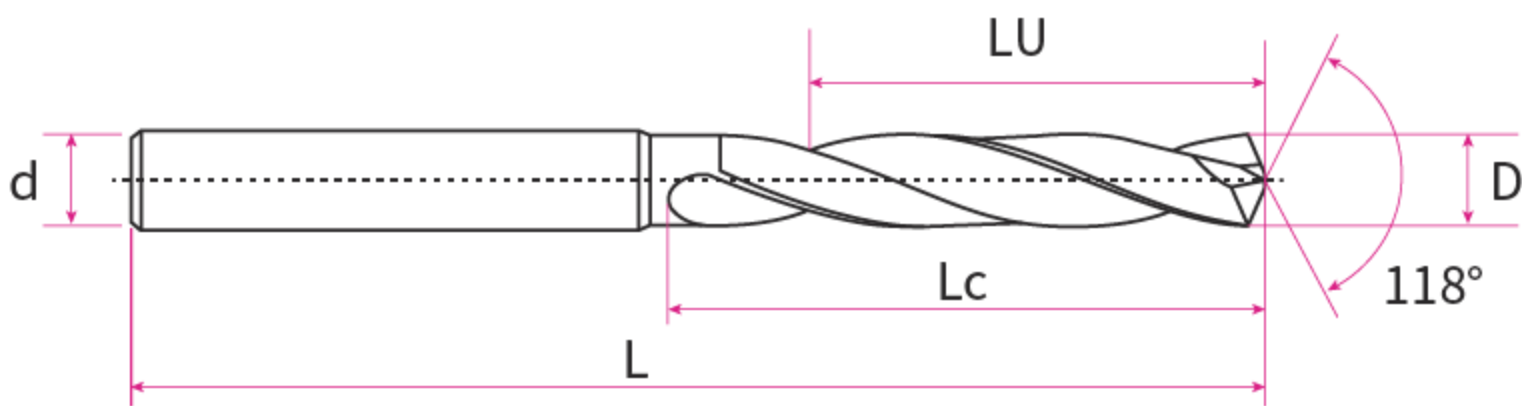
D>1.9

3RAKE

D>1.4

2RAKE

D≤1.4



Max. Recommended Depth: LU=Lc-1.5D

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0464-06A	4.64	24	68	6	●
DMF-HP03T0465-06A	4.65	24	68	6	●
DMF-HP03T0466-06A	4.66	24	68	6	●
DMF-HP03T0467-06A	4.67	24	68	6	●
DMF-HP03T0468-06A	4.68	24	68	6	●
DMF-HP03T0469-06A	4.69	24	68	6	●
DMF-HP03T0470-06A	4.70	24	68	6	●
DMF-HP03T0471-06A	4.71	24	68	6	●
DMF-HP03T0472-06A	4.72	24	68	6	●
DMF-HP03T0473-06A	4.73	24	68	6	●
DMF-HP03T0474-06A	4.74	24	68	6	●
DMF-HP03T0475-06A	4.75	24	68	6	●
DMF-HP03T0476-06A	4.76	26	72	6	●
DMF-HP03T0477-06A	4.77	26	72	6	●
DMF-HP03T0478-06A	4.78	26	72	6	●
DMF-HP03T0479-06A	4.79	26	72	6	●
DMF-HP03T0480-06A	4.80	26	72	6	●
DMF-HP03T0481-06A	4.81	26	72	6	●
DMF-HP03T0482-06A	4.82	26	72	6	●
DMF-HP03T0483-06A	4.83	26	72	6	●
DMF-HP03T0484-06A	4.84	26	72	6	●
DMF-HP03T0485-06A	4.85	26	72	6	●
DMF-HP03T0486-06A	4.86	26	72	6	●
DMF-HP03T0487-06A	4.87	26	72	6	●
DMF-HP03T0488-06A	4.88	26	72	6	●
DMF-HP03T0489-06A	4.89	26	72	6	●
DMF-HP03T0490-06A	4.90	26	72	6	●
DMF-HP03T0491-06A	4.91	26	72	6	●
DMF-HP03T0492-06A	4.92	26	72	6	●
DMF-HP03T0493-06A	4.93	26	72	6	●
DMF-HP03T0494-06A	4.94	26	72	6	●
DMF-HP03T0495-06A	4.95	26	72	6	●
DMF-HP03T0496-06A	4.96	26	72	6	●
DMF-HP03T0497-06A	4.97	26	72	6	●
DMF-HP03T0498-06A	4.98	26	72	6	●

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0499-06A	4.99	26	72	6	●
DMF-HP03T0500-06A	5.00	26	72	6	●
DMF-HP03T0501-06A	5.01	26	72	6	●
DMF-HP03T0502-06A	5.02	26	72	6	●
DMF-HP03T0503-06A	5.03	26	72	6	●
DMF-HP03T0504-06A	5.04	26	72	6	●
DMF-HP03T0505-06A	5.05	26	72	6	●
DMF-HP03T0506-06A	5.06	26	72	6	●
DMF-HP03T0507-06A	5.07	26	72	6	●
DMF-HP03T0508-06A	5.08	26	72	6	●
DMF-HP03T0509-06A	5.09	26	72	6	●
DMF-HP03T0510-06A	5.10	26	72	6	●
DMF-HP03T0511-06A	5.11	26	72	6	●
DMF-HP03T0512-06A	5.12	26	72	6	●
DMF-HP03T0513-06A	5.13	26	72	6	●
DMF-HP03T0514-06A	5.14	26	72	6	●
DMF-HP03T0515-06A	5.15	26	72	6	●
DMF-HP03T0516-06A	5.16	26	72	6	●
DMF-HP03T0517-06A	5.17	26	72	6	●
DMF-HP03T0518-06A	5.18	26	72	6	●
DMF-HP03T0519-06A	5.19	26	72	6	●
DMF-HP03T0520-06A	5.20	26	72	6	●
DMF-HP03T0521-06A	5.21	26	72	6	●
DMF-HP03T0522-06A	5.22	26	72	6	●
DMF-HP03T0523-06A	5.23	26	72	6	●
DMF-HP03T0524-06A	5.24	26	72	6	●
DMF-HP03T0525-06A	5.25	26	72	6	●
DMF-HP03T0526-06A	5.26	26	72	6	●
DMF-HP03T0527-06A	5.27	26	72	6	●
DMF-HP03T0528-06A	5.28	26	72	6	●
DMF-HP03T0529-06A	5.29	26	72	6	●
DMF-HP03T0530-06A	5.30	26	72	6	●
DMF-HP03T0531-06A	5.31	28	72	6	●
DMF-HP03T0532-06A	5.32	28	72	6	●

● Available ● Production to order

P		M	K	N			S	
CARBON STEELS	ALLOY STEELS	STAINLESS STEELS	GARY CAST IRON	Wrought Aluminum Alloy	COPPER ALLOYS	Composite Material	High-Temperature Alloy	Titanium Alloy
ALLOY STEELS	TOOL STEELS		DUCTILE CAST IRON	Cast Aluminum Alloy				
~35HRC	~48HRC			Si<12%	<HB200		<HB450	<400HB
○	○	○		○	○		○	○

○ Very suitable ○ Suitable

DMF-HP

High Performance HSS-PM Drill (Reinforced Shank)



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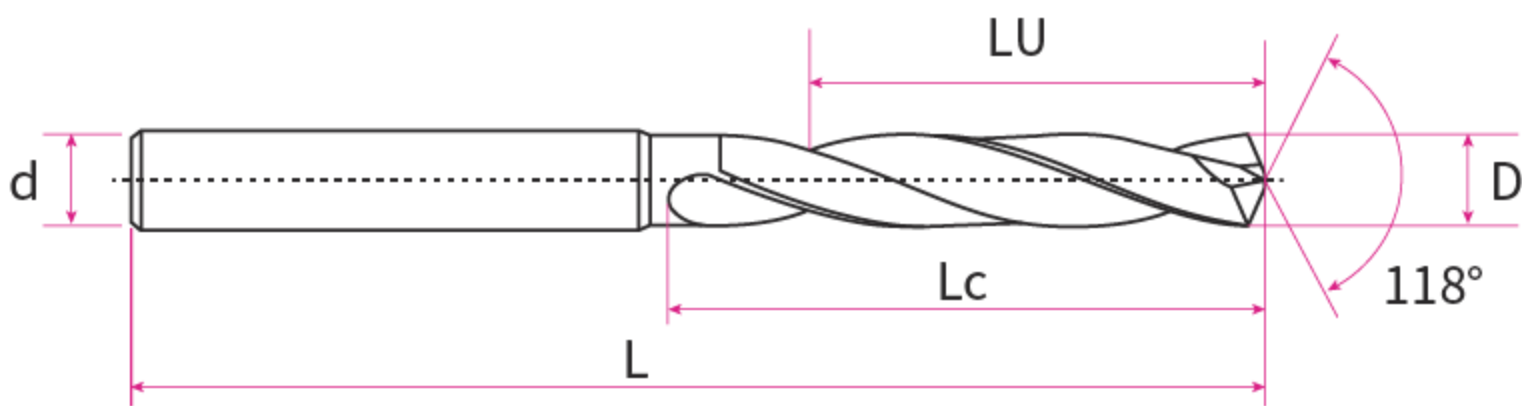
HELIX
N

118°
D≤1.9

135°
D>1.9

3RAKE
D>1.4

2RAKE
D≤1.4



Max. Recommended Depth: LU=Lc-1.5D

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0533-06A	5.33	28	72	6	●
DMF-HP03T0534-06A	5.34	28	72	6	●
DMF-HP03T0535-06A	5.35	28	72	6	●
DMF-HP03T0536-06A	5.36	28	72	6	●
DMF-HP03T0537-06A	5.37	28	72	6	●
DMF-HP03T0538-06A	5.38	28	72	6	●
DMF-HP03T0539-06A	5.39	28	72	6	●
DMF-HP03T0540-06A	5.40	28	72	6	●
DMF-HP03T0541-06A	5.41	28	72	6	●
DMF-HP03T0542-06A	5.42	28	72	6	●
DMF-HP03T0543-06A	5.43	28	72	6	●
DMF-HP03T0544-06A	5.44	28	72	6	●
DMF-HP03T0545-06A	5.45	28	72	6	●
DMF-HP03T0546-06A	5.46	28	72	6	●
DMF-HP03T0547-06A	5.47	28	72	6	●
DMF-HP03T0548-06A	5.48	28	72	6	●
DMF-HP03T0549-06A	5.49	28	72	6	●
DMF-HP03T0550-06A	5.50	28	72	6	●
DMF-HP03T0551-06A	5.51	28	72	6	●
DMF-HP03T0552-06A	5.52	28	72	6	●
DMF-HP03T0553-06A	5.53	28	72	6	●
DMF-HP03T0554-06A	5.54	28	72	6	●
DMF-HP03T0555-06A	5.55	28	72	6	●
DMF-HP03T0556-06A	5.56	28	72	6	●
DMF-HP03T0557-06A	5.57	28	72	6	●
DMF-HP03T0558-06A	5.58	28	72	6	●
DMF-HP03T0559-06A	5.59	28	72	6	●
DMF-HP03T0560-06A	5.60	28	72	6	●
DMF-HP03T0561-06A	5.61	28	72	6	●
DMF-HP03T0562-06A	5.62	28	72	6	●
DMF-HP03T0563-06A	5.63	28	72	6	●
DMF-HP03T0564-06A	5.64	28	72	6	●
DMF-HP03T0565-06A	5.65	28	72	6	●
DMF-HP03T0566-06A	5.66	28	72	6	●
DMF-HP03T0567-06A	5.67	28	72	6	●

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0568-06A	5.68	28	72	6	●
DMF-HP03T0569-06A	5.69	28	72	6	●
DMF-HP03T0570-06A	5.70	28	72	6	●
DMF-HP03T0571-06A	5.71	28	72	6	●
DMF-HP03T0572-06A	5.72	28	72	6	●
DMF-HP03T0573-06A	5.73	28	72	6	●
DMF-HP03T0574-06A	5.74	28	72	6	●
DMF-HP03T0575-06A	5.75	28	72	6	●
DMF-HP03T0576-06A	5.76	28	72	6	●
DMF-HP03T0577-06A	5.77	28	72	6	●
DMF-HP03T0578-06A	5.78	28	72	6	●
DMF-HP03T0579-06A	5.79	28	72	6	●
DMF-HP03T0580-06A	5.80	28	72	6	●
DMF-HP03T0581-06A	5.81	28	72	6	●
DMF-HP03T0582-06A	5.82	28	72	6	●
DMF-HP03T0583-06A	5.83	28	72	6	●
DMF-HP03T0584-06A	5.84	28	72	6	●
DMF-HP03T0585-06A	5.85	28	72	6	●
DMF-HP03T0586-06A	5.86	28	72	6	●
DMF-HP03T0587-06A	5.87	28	72	6	●
DMF-HP03T0588-06A	5.88	28	72	6	●
DMF-HP03T0589-06A	5.89	28	72	6	●
DMF-HP03T0590-06A	5.90	28	72	6	●
DMF-HP03T0591-06A	5.91	28	72	6	●
DMF-HP03T0592-06A	5.92	28	72	6	●
DMF-HP03T0593-06A	5.93	28	72	6	●
DMF-HP03T0594-06A	5.94	28	72	6	●
DMF-HP03T0595-06A	5.95	28	72	6	●
DMF-HP03T0596-06A	5.96	28	72	6	●
DMF-HP03T0597-06A	5.97	28	72	6	●
DMF-HP03T0598-06A	5.98	28	72	6	●
DMF-HP03T0599-06A	5.99	28	72	6	●
DMF-HP03T0600-06A	6.00	28	72	6	●
DMF-HP03T0610-08A	6.10	31	75	8	●

● Available ● Production to order

P		M	K	N			S	
CARBON STEELS	ALLOY STEELS	STAINLESS STEELS	GARY CAST IRON	Wrought Aluminum Alloy	COPPER ALLOYS	Composite Material	High-Temperature Alloy	Titanium Alloy
ALLOY STEELS	TOOL STEELS		DUCTILE CAST IRON	Cast Aluminum Alloy				
~35HRC	~48HRC			Si<1 2%	<HB200		<HB450	<400HB
○	○	○		○	○		○	○

○ Very suitable ○ Suitable

DMF-HP

High Performance HSS-PM Drill (Reinforced Shank)



TiN

h7

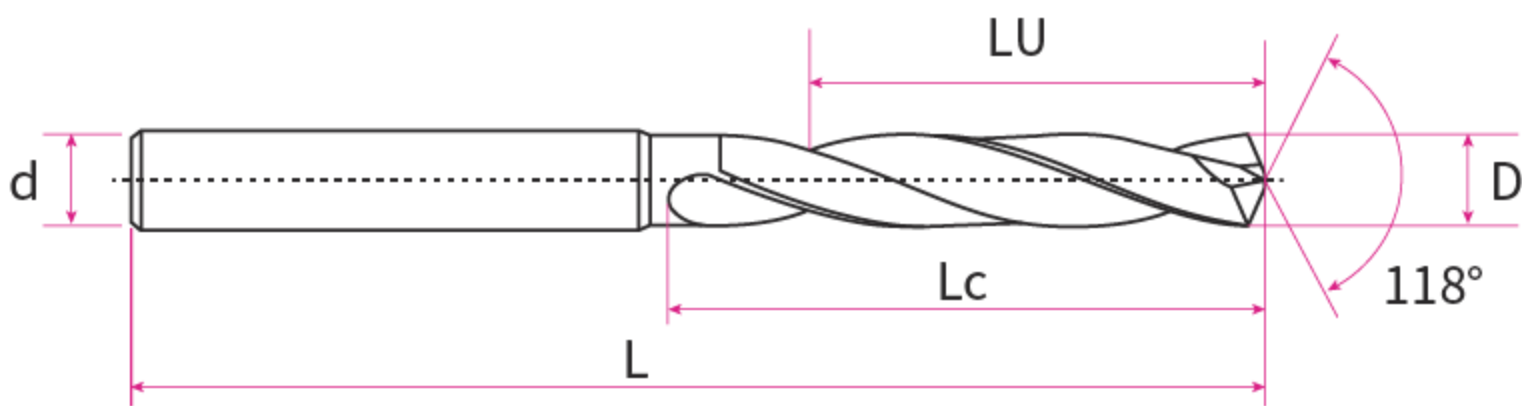
HELIX
N

118°
D ≤ 1.9

135°
D > 1.9

3RAKE
D > 1.4

2RAKE
D ≤ 1.4



Max. Recommended Depth: LU=Lc-1.5D

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0620-08A	6.20	31	75	8	●
DMF-HP03T0630-08A	6.30	31	75	8	●
DMF-HP03T0640-08A	6.40	31	75	8	●
DMF-HP03T0650-08A	6.50	31	75	8	●
DMF-HP03T0660-08A	6.60	31	75	8	●
DMF-HP03T0670-08A	6.70	31	75	8	●
DMF-HP03T0680-08A	6.80	34	78	8	●
DMF-HP03T0690-08A	6.90	34	78	8	●
DMF-HP03T0700-08A	7.00	34	78	8	●
DMF-HP03T0710-08A	7.10	34	78	8	●
DMF-HP03T0720-08A	7.20	34	78	8	●
DMF-HP03T0730-08A	7.30	34	78	8	●
DMF-HP03T0740-08A	7.40	34	78	8	●
DMF-HP03T0750-08A	7.50	34	78	8	●
DMF-HP03T0760-08A	7.60	37	81	8	●
DMF-HP03T0770-08A	7.70	37	81	8	●
DMF-HP03T0780-08A	7.80	37	81	8	●
DMF-HP03T0790-08A	7.90	37	81	8	●
DMF-HP03T0800-08A	8.00	37	81	8	●
DMF-HP03T0810-10A	8.10	37	87	10	●
DMF-HP03T0820-10A	8.20	37	87	10	●
DMF-HP03T0830-10A	8.30	37	87	10	●
DMF-HP03T0840-10A	8.40	37	87	10	●
DMF-HP03T0850-10A	8.50	37	87	10	●
DMF-HP03T0860-10A	8.60	40	90	10	●
DMF-HP03T0870-10A	8.70	40	90	10	●
DMF-HP03T0880-10A	8.80	40	90	10	●
DMF-HP03T0890-10A	8.90	40	90	10	●
DMF-HP03T0900-10A	9.00	40	90	10	●
DMF-HP03T0910-10A	9.10	40	90	10	●
DMF-HP03T0920-10A	9.20	40	90	10	●
DMF-HP03T0930-10A	9.30	40	90	10	●
DMF-HP03T0940-10A	9.40	40	90	10	●
DMF-HP03T0950-10A	9.50	40	90	10	●
DMF-HP03T0960-10A	9.60	43	93	10	●

Order Code	Diameter	Length of cut	Overall Length	Shank Dia.	Stock
	ΦD	Lc	L	Φd	
DMF-HP03T0970-10A	9.70	43	93	10	●
DMF-HP03T0980-10A	9.80	43	93	10	●
DMF-HP03T0990-10A	9.90	43	93	10	●
DMF-HP03T1000-10A	10.00	43	93	10	●
DMF-HP03T1010-12A	10.10	43	100	12	●
DMF-HP03T1020-12A	10.20	43	100	12	●
DMF-HP03T1030-12A	10.30	43	100	12	●
DMF-HP03T1040-12A	10.40	43	100	12	●
DMF-HP03T1050-12A	10.50	43	100	12	●
DMF-HP03T1060-12A	10.60	43	100	12	●
DMF-HP03T1070-12A	10.70	47	104	12	●
DMF-HP03T1080-12A	10.80	47	104	12	●
DMF-HP03T1090-12A	10.90	47	104	12	●
DMF-HP03T1100-12A	11.00	47	104	12	●
DMF-HP03T1110-12A	11.10	47	104	12	●
DMF-HP03T1120-12A	11.20	47	104	12	●
DMF-HP03T1130-12A	11.30	47	104	12	●
DMF-HP03T1140-12A	11.40	47	104	12	●
DMF-HP03T1150-12A	11.50	47	104	12	●
DMF-HP03T1160-12A	11.60	47	104	12	●
DMF-HP03T1170-12A	11.70	47	104	12	●
DMF-HP03T1180-12A	11.80	47	104	12	●
DMF-HP03T1190-12A	11.90	51	108	12	●
DMF-HP03T1200-12A	12.00	51	108	12	●
DMF-HP03T1210-14A	12.10	51	108	14	●
DMF-HP03T1220-14A	12.20	51	108	14	●
DMF-HP03T1230-14A	12.30	51	108	14	●
DMF-HP03T1240-14A	12.40	51	108	14	●
DMF-HP03T1250-14A	12.50	51	108	14	●
DMF-HP03T1260-14A	12.60	51	108	14	●
DMF-HP03T1270-14A	12.70	51	108	14	●
DMF-HP03T1280-14A	12.80	51	108	14	●
DMF-HP03T1290-14A	12.90	51	108	14	●
DMF-HP03T1300-14A	13.00	51	108	14	●

● Available ● Production to order

P		M	K	N			S	
CARBON STEELS	ALLOY STEELS	STAINLESS STEELS	GARY CAST IRON	Wrought Aluminum Alloy	COPPER ALLOYS	Composite Material	High-Temperature Alloy	Titanium Alloy
ALLOY STEELS	TOOL STEELS		DUCTILE CAST IRON	Cast Aluminum Alloy				
~35HRC	~48HRC			Si<12%	<HB200		<HB450	<400HB
○	○	○		○	○		○	○

○ Very suitable ○ Suitable

Cutting Parameter

DMF-HP

Workplace	CARBON STEEL (~200HB)		ALLOY STEEL TEMPERED STEEL (20-30HRC)		MOLD STEEL PRE-HARDENED STEEL (30-40HRC)		STAINLESS STEEL	
Dia.	Spindle Speed RPM	Feed mm/min	Spindle Speed RPM	Feed mm/min	Spindle Speed RPM	Feed mm/min	Spindle Speed RPM	Feed mm/min
0.5	16000	240	13000	150	9500	80	5100	50
1	9500	250	8000	190	6400	140	3500	65
2	5700	360	4600	240	3200	160	1900	80
3	4200	460	3400	320	2100	170	1300	85
5	2500	430	2000	290	1250	165	760	80
8	1600	370	1300	250	800	150	480	75
10	1300	340	1000	230	650	140	380	73
12	1100	310	850	210	530	130	320	70
16	800	290	640	200	400	120	240	63
20	640	260	510	180	320	110	190	57
25	510	240	410	160	250	95	150	50
32	400	160	320	120	200	70	120	40

Workplace	CAST IRON		ALUMINUM ALLOY COPPER ALLOY		Heat-resistant and Corrosion-resistant Alloys, Titanium Alloys,Nickel-Chromium-Iron Alloys (30-40HRC)	
Dia.	Spindle Speed RPM	Feed mm/min	Spindle Speed RPM	Feed mm/min	Spindle Speed RPM	Feed mm/min
0.5	20000	300	23000	300	2500	18
1	12000	400	15000	500	1600	25
2	6300	490	9700	760	800	27
3	4700	640	7200	980	530	29
5	2800	600	4300	920	320	28
8	1800	530	2700	790	200	26
10	1400	460	2200	730	160	26
12	1200	430	1800	670	130	25
16	880	390	1400	610	100	23
20	700	350	1100	550	80	21
25	560	330	870	510	64	19
32	440	250	680	380	50	16

Cutting Parameter Formulas

Cutting speed (Vc) = $\frac{D \times \pi \times n}{1000}$ (m/min)

Feed (f) = $\frac{Vf}{n}$ (mm/rev)

Feed rate = $\frac{f}{D}$ (%)