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DRC - Straight flute, Internal Coolant, Ø3~Ø12mm.....B090
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DRN - Left spiral flute, External Coolant, Ø3~Ø12mm.....B092



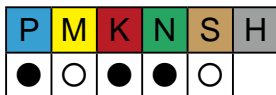
DRC, DRN



Features

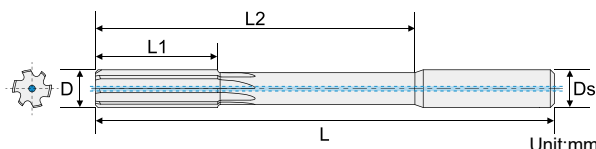
- Unique durable UNIX coating
- Specially for high accurate hole machining
- Superior hole surface finish
- Internal & external coolant available
- Customized available

DRC - Straight flute · Internal Coolant



Specification

- Internal
- Straight flute
- UNIX Coating
- Tolerance h7
- Unequal flute spacing
- Provides high degree of accuracy of leave smooth sides
- For blind hole using



| Order No. | D | L1 | L2 | L | Ds | F |
|-------------|-------|----|-----|-----|----|---|
| DRC03000901 | 3.00 | 15 | 35 | 60 | 4 | 4 |
| DRC03100901 | 3.10 | 15 | 35 | 60 | 4 | 4 |
| DRC03200901 | 3.20 | 15 | 35 | 60 | 4 | 4 |
| DRC03300901 | 3.30 | 15 | 35 | 60 | 4 | 4 |
| DRC03400901 | 3.40 | 15 | 35 | 60 | 4 | 4 |
| DRC03500901 | 3.50 | 18 | 35 | 60 | 4 | 4 |
| DRC03600901 | 3.60 | 18 | 35 | 60 | 4 | 4 |
| DRC03700901 | 3.70 | 18 | 35 | 60 | 4 | 4 |
| DRC03800901 | 3.80 | 18 | 35 | 60 | 4 | 4 |
| DRC03900901 | 3.90 | 18 | 35 | 60 | 4 | 4 |
| DRC04000901 | 4.00 | 19 | 50 | 75 | 4 | 4 |
| DRC04100901 | 4.10 | 19 | 50 | 75 | 6 | 4 |
| DRC04200901 | 4.20 | 19 | 50 | 75 | 6 | 4 |
| DRC04300901 | 4.30 | 19 | 50 | 75 | 6 | 4 |
| DRC04400901 | 4.40 | 19 | 50 | 75 | 6 | 4 |
| DRC04500901 | 4.50 | 21 | 50 | 75 | 6 | 4 |
| DRC04600901 | 4.60 | 21 | 50 | 75 | 6 | 4 |
| DRC04700901 | 4.70 | 21 | 50 | 75 | 6 | 4 |
| DRC04800901 | 4.80 | 21 | 50 | 75 | 6 | 4 |
| DRC04900901 | 4.90 | 21 | 50 | 75 | 6 | 4 |
| DRC05000901 | 5.00 | 23 | 50 | 75 | 6 | 6 |
| DRC05100901 | 5.10 | 23 | 50 | 75 | 6 | 6 |
| DRC05200901 | 5.20 | 23 | 50 | 75 | 6 | 6 |
| DRC05300901 | 5.30 | 23 | 50 | 75 | 6 | 6 |
| DRC05400901 | 5.40 | 23 | 50 | 75 | 6 | 6 |
| DRC05500901 | 5.50 | 26 | 50 | 75 | 6 | 6 |
| DRC05600901 | 5.60 | 26 | 50 | 75 | 6 | 6 |
| DRC05700901 | 5.70 | 26 | 50 | 75 | 6 | 6 |
| DRC05800901 | 5.80 | 26 | 50 | 75 | 6 | 6 |
| DRC05900901 | 5.90 | 26 | 50 | 75 | 6 | 6 |
| DRC06000901 | 6.00 | 26 | 65 | 100 | 6 | 6 |
| DRC06500901 | 6.50 | 28 | 65 | 100 | 8 | 6 |
| DRC07000901 | 7.00 | 31 | 70 | 109 | 8 | 6 |
| DRC07500901 | 7.50 | 31 | 70 | 109 | 8 | 6 |
| DRC08000901 | 8.00 | 33 | 80 | 109 | 8 | 6 |
| DRC08500901 | 8.50 | 33 | 80 | 125 | 10 | 6 |
| DRC09000901 | 9.00 | 36 | 85 | 125 | 10 | 6 |
| DRC09500901 | 9.50 | 36 | 85 | 125 | 10 | 6 |
| DRC10000901 | 10.00 | 38 | 85 | 125 | 10 | 6 |
| DRC10500901 | 10.50 | 38 | 85 | 125 | 12 | 6 |
| DRC11000901 | 11.00 | 41 | 100 | 150 | 12 | 6 |
| DRC11500901 | 11.50 | 41 | 100 | 150 | 12 | 6 |
| DRC12000901 | 12.00 | 44 | 100 | 150 | 12 | 6 |

| Order No. | D | L1 | L2 | L | Ds | F |
|-----------|---|----|----|---|----|---|
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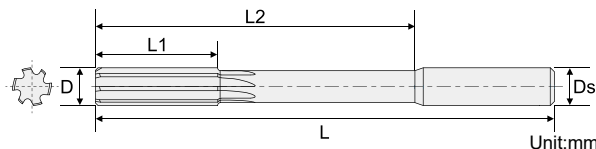
Holermaking
Solid Carbide Reamers

DRN - Straight flute · External Coolant

| | | | | | |
|----------|----------|----------|----------|----------|----------|
| P | M | K | N | S | H |
| ● | ○ | ● | ● | ○ | |

Specification

- External
- Straight flute
- UNIX Coating
- Tolerance h7
- Unequal flute spacing
- Provides high degree of accuracy of leave smooth sides
- For blind hole using



| Order No. | D | L1 | L2 | L | Ds | F |
|-------------|-------|----|-----|-----|----|---|
| DRN03000901 | 3.00 | 15 | 35 | 60 | 4 | 4 |
| DRN03100901 | 3.10 | 15 | 35 | 60 | 4 | 4 |
| DRN03200901 | 3.20 | 15 | 35 | 60 | 4 | 4 |
| DRN03300901 | 3.30 | 15 | 35 | 60 | 4 | 4 |
| DRN03400901 | 3.40 | 15 | 35 | 60 | 4 | 4 |
| DRN03500901 | 3.50 | 18 | 35 | 60 | 4 | 4 |
| DRN03600901 | 3.60 | 18 | 35 | 60 | 4 | 4 |
| DRN03700901 | 3.70 | 18 | 35 | 60 | 4 | 4 |
| DRN03800901 | 3.80 | 18 | 35 | 60 | 4 | 4 |
| DRN03900901 | 3.90 | 18 | 35 | 60 | 4 | 4 |
| DRN04000901 | 4.00 | 19 | 50 | 75 | 4 | 4 |
| DRN04100901 | 4.10 | 19 | 50 | 75 | 6 | 4 |
| DRN04200901 | 4.20 | 19 | 50 | 75 | 6 | 4 |
| DRN04300901 | 4.30 | 19 | 50 | 75 | 6 | 4 |
| DRN04400901 | 4.40 | 19 | 50 | 75 | 6 | 4 |
| DRN04500901 | 4.50 | 21 | 50 | 75 | 6 | 4 |
| DRN04600901 | 4.60 | 21 | 50 | 75 | 6 | 4 |
| DRN04700901 | 4.70 | 21 | 50 | 75 | 6 | 4 |
| DRN04800901 | 4.80 | 21 | 50 | 75 | 6 | 4 |
| DRN04900901 | 4.90 | 21 | 50 | 75 | 6 | 4 |
| DRN05000901 | 5.00 | 23 | 50 | 75 | 6 | 6 |
| DRN05100901 | 5.10 | 23 | 50 | 75 | 6 | 6 |
| DRN05200901 | 5.20 | 23 | 50 | 75 | 6 | 6 |
| DRN05300901 | 5.30 | 23 | 50 | 75 | 6 | 6 |
| DRN05400901 | 5.40 | 23 | 50 | 75 | 6 | 6 |
| DRN05500901 | 5.50 | 26 | 50 | 75 | 6 | 6 |
| DRN05600901 | 5.60 | 26 | 50 | 75 | 6 | 6 |
| DRN05700901 | 5.70 | 26 | 50 | 75 | 6 | 6 |
| DRN05800901 | 5.80 | 26 | 50 | 75 | 6 | 6 |
| DRN05900901 | 5.90 | 26 | 50 | 75 | 6 | 6 |
| DRN06000901 | 6.00 | 26 | 65 | 100 | 6 | 6 |
| DRN06500901 | 6.50 | 28 | 65 | 100 | 8 | 6 |
| DRN07000901 | 7.00 | 31 | 70 | 109 | 8 | 6 |
| DRN07500901 | 7.50 | 31 | 70 | 109 | 8 | 6 |
| DRN08000901 | 8.00 | 33 | 80 | 109 | 8 | 6 |
| DRN08500901 | 8.50 | 33 | 80 | 125 | 10 | 6 |
| DRN09000901 | 9.00 | 36 | 85 | 125 | 10 | 6 |
| DRN09500901 | 9.50 | 36 | 85 | 125 | 10 | 6 |
| DRN10000901 | 10.00 | 38 | 85 | 125 | 10 | 6 |
| DRN10500901 | 10.50 | 38 | 85 | 125 | 12 | 6 |
| DRN11000901 | 11.00 | 41 | 100 | 150 | 12 | 6 |
| DRN11500901 | 11.50 | 41 | 100 | 150 | 12 | 6 |
| DRN12000901 | 12.00 | 44 | 100 | 150 | 12 | 6 |

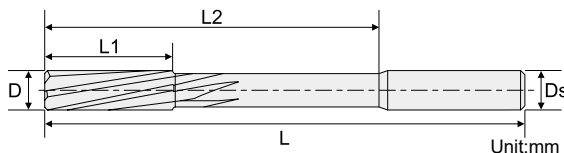
| Order No. | D | L1 | L2 | L | Ds | F |
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DRN - Left spiral flute · External Coolant

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| P | M | K | N | S | H |
| ● | | ● | ● | | |

Specification

- External
- Left spiral flute
- UNIX Coating
- Tolerance h7
- Provide high degree of accuracy to leave smooth sides.
- For through hole using



| Order No. | D | L1 | L2 | L | Ds | F |
|---------------|-------|----|-----|-----|----|---|
| * DRN03000911 | 3.00 | 15 | 35 | 60 | 4 | 4 |
| * DRN03100911 | 3.10 | 15 | 35 | 60 | 4 | 4 |
| * DRN03200911 | 3.20 | 15 | 35 | 60 | 4 | 4 |
| * DRN03300911 | 3.30 | 15 | 35 | 60 | 4 | 4 |
| * DRN03400911 | 3.40 | 15 | 35 | 60 | 4 | 4 |
| * DRN03500911 | 3.50 | 18 | 35 | 60 | 4 | 4 |
| * DRN03600911 | 3.60 | 18 | 35 | 60 | 4 | 4 |
| * DRN03700911 | 3.70 | 18 | 35 | 60 | 4 | 4 |
| * DRN03800911 | 3.80 | 18 | 35 | 60 | 4 | 4 |
| * DRN03900911 | 3.90 | 18 | 35 | 60 | 4 | 4 |
| * DRN04000911 | 4.00 | 19 | 50 | 75 | 4 | 4 |
| * DRN04100911 | 4.10 | 19 | 50 | 75 | 6 | 4 |
| * DRN04200911 | 4.20 | 19 | 50 | 75 | 6 | 4 |
| * DRN04300911 | 4.30 | 19 | 50 | 75 | 6 | 4 |
| * DRN04400911 | 4.40 | 19 | 50 | 75 | 6 | 4 |
| * DRN04500911 | 4.50 | 21 | 50 | 75 | 6 | 4 |
| * DRN04600911 | 4.60 | 21 | 50 | 75 | 6 | 4 |
| * DRN04700911 | 4.70 | 21 | 50 | 75 | 6 | 4 |
| * DRN04800911 | 4.80 | 21 | 50 | 75 | 6 | 4 |
| * DRN04900911 | 4.90 | 21 | 50 | 75 | 6 | 4 |
| * DRN05000911 | 5.00 | 23 | 50 | 75 | 6 | 6 |
| * DRN05100911 | 5.10 | 23 | 50 | 75 | 6 | 6 |
| * DRN05200911 | 5.20 | 23 | 50 | 75 | 6 | 6 |
| * DRN05300911 | 5.30 | 23 | 50 | 75 | 6 | 6 |
| * DRN05400911 | 5.40 | 23 | 50 | 75 | 6 | 6 |
| * DRN05500911 | 5.50 | 26 | 50 | 75 | 6 | 6 |
| * DRN05600911 | 5.60 | 26 | 50 | 75 | 6 | 6 |
| * DRN05700911 | 5.70 | 26 | 50 | 75 | 6 | 6 |
| * DRN05800911 | 5.80 | 26 | 50 | 75 | 6 | 6 |
| * DRN05900911 | 5.90 | 26 | 50 | 75 | 6 | 6 |
| * DRN06000911 | 6.00 | 26 | 65 | 100 | 6 | 6 |
| * DRN06500911 | 6.50 | 28 | 65 | 100 | 8 | 6 |
| * DRN07000911 | 7.00 | 31 | 70 | 109 | 8 | 6 |
| * DRN07500911 | 7.50 | 31 | 70 | 109 | 8 | 6 |
| * DRN08000911 | 8.00 | 33 | 80 | 109 | 8 | 6 |
| * DRN08500911 | 8.50 | 33 | 80 | 125 | 10 | 6 |
| * DRN09000911 | 9.00 | 36 | 85 | 125 | 10 | 6 |
| * DRN09500911 | 9.50 | 36 | 85 | 125 | 10 | 6 |
| * DRN10000911 | 10.00 | 38 | 85 | 125 | 10 | 6 |
| * DRN10500911 | 10.50 | 38 | 85 | 125 | 12 | 6 |
| * DRN11000911 | 11.00 | 41 | 100 | 150 | 12 | 6 |
| * DRN11500911 | 11.50 | 41 | 100 | 150 | 12 | 6 |
| * DRN12000911 | 12.00 | 44 | 100 | 150 | 12 | 6 |

| Order No. | D | L1 | L2 | L | Ds | F |
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Holermaking

Solid Carbide Reamers

Recommended Cutting Conditions

DRC Series (Internal Coolant)

| Work Material | | Drill Diameter | Ø3-6mm | | Ø6.1~10mm | | Ø10.1-12mm | |
|---------------|----------------------|----------------|------------|---------------|------------|---------------|------------|---------------|
| | | Hardness | Vc (m/min) | Feed (mm/rev) | Vc (m/min) | Feed (mm/rev) | Vc (m/min) | Feed (mm/rev) |
| P | Mild Steel | (<180HB) | 40~70 | 0.1~0.2 | 40~70 | 0.1~0.24 | 40~70 | 0.1~0.3 |
| | Carbon Steel | (180~280HB) | 25~50 | 0.1~0.2 | 25~50 | 0.1~0.24 | 25~50 | 0.1~0.3 |
| | Alloy Steel | (280~350HB) | 15~25 | 0.08~0.16 | 15~25 | 0.08~0.2 | 15~25 | 0.08~0.24 |
| M | Stainless Steel | (<200HB) | 8~15 | 0.08~0.16 | 8~15 | 0.08~0.18 | 8~15 | 0.08~0.2 |
| K | Cast Iron | (<350Mpa) | 35~60 | 0.1~0.32 | 35~60 | 0.1~0.36 | 35~60 | 0.1~0.4 |
| | Ductile Cast Iron | (<450Mpa) | 20~45 | 0.1~0.24 | 20~45 | 0.1~0.28 | 20~45 | 0.1~0.32 |
| N | Aluminum <12% Si | - | 110~195 | 0.12~0.32 | 110~195 | 0.12~0.36 | 110~195 | 0.12~0.4 |
| | Aluminum >12% Si | - | 105~180 | 0.12~0.32 | 105~180 | 0.12~0.36 | 105~180 | 0.12~0.4 |
| S | Heat Resistant Alloy | - | 8~15 | 0.08~0.16 | 8~15 | 0.08~0.18 | 8~15 | 0.08~0.2 |
| H | Hardened Material | - | - | - | - | - | - | - |

DRN Series (External Coolant)

| Work Material | | Drill Diameter | Ø3-6mm | | Ø6.1~10mm | | Ø10.1-12mm | |
|---------------|----------------------|----------------|------------|---------------|------------|---------------|------------|---------------|
| | | Hardness | Vc (m/min) | Feed (mm/rev) | Vc (m/min) | Feed (mm/rev) | Vc (m/min) | Feed (mm/rev) |
| P | Mild Steel | (<180HB) | 10~20 | 0.03~0.12 | 10~20 | 0.06~0.2 | 10~20 | 0.1~0.22 |
| | Carbon Steel | (180~280HB) | 10~16 | 0.03~0.12 | 10~16 | 0.06~0.2 | 10~16 | 0.1~0.22 |
| | Alloy Steel | (280~350HB) | 8~12 | 0.03~0.12 | 8~12 | 0.06~0.2 | 8~12 | 0.1~0.22 |
| M | Stainless Steel | - | - | - | - | - | - | - |
| K | Cast Iron | (<350Mpa) | 8~16 | 0.03~0.12 | 8~16 | 0.06~0.02 | 8~16 | 0.1~0.22 |
| | Ductile Cast Iron | (<450Mpa) | 8~16 | 0.03~0.12 | 8~16 | 0.06~0.02 | 8~16 | 0.1~0.22 |
| N | Aluminum <12% Si | - | 20~30 | 0.03~0.13 | 20~30 | 0.07~0.23 | 20~30 | 0.1~0.28 |
| | Aluminum >12% Si | - | 20~30 | 0.03~0.13 | 20~30 | 0.07~0.23 | 20~30 | 0.1~0.28 |
| S | Heat Resistant Alloy | - | - | - | - | - | - | - |
| H | Hardened Material | - | - | - | - | - | - | - |