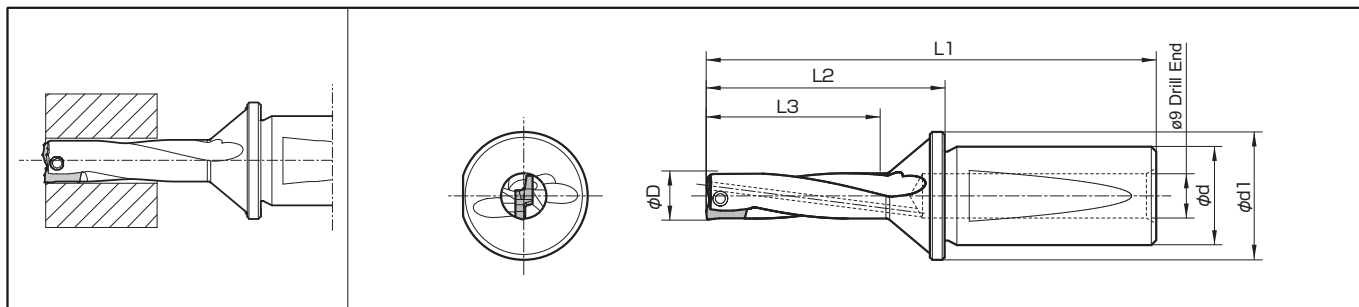


DRS



Toolholder Dimensions

Description	Std.	Number of Flutes	Dimension (mm)						Radial Direction Offset Applicable Range (mm)	Spare Parts			Applicable Insert K37
			øD	L1	L2	L3	ød	ød1		Clamp Screw	Wrench	Wrench	
S20-DRS10035	●	1	10.0	92	49	35.0	20	26	+0.2	SB-2080TR	FT-6	-	DS100
-DRS10336	●	1	10.3	92	49	36.0			+0.1				DS105
-DRS10537	●	1	10.5	93	50	37.0			+0.2				DS110
-DRS11038	●	1	11.0	96	53	38.5			+0.2	SB-2290TR	-	DT-7	DS115
-DRS11540	●	1	11.5	97	54	40.5			+0.2				DS120
-DRS12042	●	1	12.0	99	56	42.0			+0.4	SB-25100TR	-	DT-7	DS120
-DRS12544	●	1	12.5	101	58	44.0			+0.2				

Cutting Conditions by Application

(Workpiece: C50)

Applications	Flat Surface	Slanted Surface	Half Cylindrical	Hole Expansion	Concave Surface	Pre-drilled Surface	Stacked Plates
Workpiece Shape							
DRS Type							
Cutting speed (m/min)	80	80	Not recommended	Not recommended	80	Not recommended	Not Available
Feed Rate (mm/rev)	0.08	0.04	Not recommended	Not recommended	Concave part 0.04 Continuous part 0.08	Not recommended	Not Available
Coolant (Internal)	Yes	Yes	-	-	Yes	-	Not Available

When machining with outer coolant, Max. depth should be 1.5 times (1.5XD) of the cutting diameter (øD) because chip evacuation performance drops.

DRS type Recommended Cutting Conditions (Coolant)

Workpiece Material	Recommended Insert Grade (Cutting Speed : m/min)		Feed Rate (mm/rev)
	PVD Coated Carbide		
	PR660	PR510	
Low Carbon Steel	★ 80~100		0.06
Carbon Steel	★ 80~100		0.08~0.1
Alloy Steel	★ 80		0.04~0.06
Mold Steel	★ 80		0.04~0.06
Stainless Steel (Austenitic related)	★ 70~80		0.05~0.06
Gray Cast Iron		★ 80~100	0.08~0.1

★ : 1st Recommendation

1. Apply a sufficient amount of coolant.
2. If cutting speed is decreased too much from above condition, chip evacuation performance will deteriorate.
If the feed rate is increased too much from above condition, inner edge chip evacuation will deteriorate.
If the feed rate is decreased too much from above condition, outer edge chip evacuation will deteriorate.
3. If chips are too long when low carbon steel cutting, increased the cutting speed to 120~150m/min.
If this does not solve the problem, try peck feeding.
[How to peck feed] ① Cut 1~2mm ② Return 0.1mm ③ Repeat ① and ②

DRS type Hole Bottom Shape (mm)

øD	A	B	C
10.0	2.2	2.80	0.2
10.3	2.3	2.85	0.2
10.5	2.3	2.95	0.2
11.0	2.4	3.10	0.2
11.5	2.5	3.25	0.2
12.0	2.8	3.20	0.3
12.5	2.9	3.35	0.4

