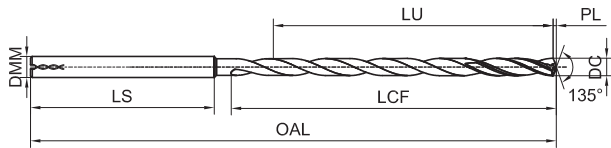


D938-A25C NEW



D938 25D Deep Hole Twist Drill for Plain Steel Machining



Order No.	DC (h7)	LCF	OAL	DMM (h6)	LS	LU	PL	In Stock
D938-A25C-0300	3.00	85	125	6	36	80.5	0.62	○
D938-A25C-0310	3.10	101	141	6	36	96.4	0.64	○
D938-A25C-0350	3.50	116	156	6	36	110.8	0.72	○
D938-A25C-0380	3.80	116	156	6	36	110.3	0.79	○
D938-A25C-0400	4.00	116	156	6	36	110.0	0.83	●
D938-A25C-0420	4.20	143	183	6	36	136.7	0.87	○
D938-A25C-0450	4.50	143	183	6	36	136.3	0.93	○
D938-A25C-0500	5.00	143	183	6	36	135.5	1.04	●
D938-A25C-0510	5.10	170	210	6	36	162.4	1.06	○
D938-A25C-0550	5.50	170	210	6	36	161.8	1.14	●
D938-A25C-0595	5.95	170	210	6	36	161.1	1.23	○
D938-A25C-0600	6.00	170	210	6	36	161.0	1.24	●
D938-A25C-0630	6.30	197	237	8	36	187.6	1.30	○
D938-A25C-0635	6.35	197	237	8	36	187.5	1.32	○
D938-A25C-0650	6.50	197	237	8	36	187.3	1.35	●

Order No.	DC (h7)	LCF	OAL	DMM (h6)	LS	LU	PL	In Stock
D938-A25C-0675	6.75	197	237	8	36	186.9	1.40	○
D938-A25C-0700	7.00	197	237	8	36	186.5	1.45	●
D938-A25C-0750	7.50	223	263	8	36	211.8	1.55	○
D938-A25C-0800	8.00	223	263	8	36	211.0	1.66	●
D938-A25C-0820	8.20	250	294	10	40	237.7	1.70	○
D938-A25C-0850	8.50	250	294	10	40	237.3	1.76	○
D938-A25C-0900	9.00	250	294	10	40	236.5	1.86	○
D938-A25C-0910	9.10	277	321	10	40	263.4	1.88	○
D938-A25C-0950	9.50	277	321	10	40	262.8	1.97	○
D938-A25C-1000	10.00	277	321	10	40	262.0	2.07	○
D938-A25C-1050	10.50	310	359	12	45	294.3	2.17	○
D938-A25C-1080	10.80	310	359	12	45	293.8	2.24	○
D938-A25C-1100	11.00	310	359	12	45	293.5	2.28	○
D938-A25C-1150	11.50	337	386	12	45	319.8	2.38	○
D938-A25C-1200	12.00	337	386	12	45	319.0	2.49	○

● Stock ○ Available Upon Order

Notes: Non-standard customization is available for D3-D12 tools

Unit (mm)

Notes: The depth drill uses a drill bit of the same specification as D938-A3C as a pilot drill.

Range of Sizes	DC(h7)	DMM(h6)
≤3	0.000/-0.010	0.000/-0.006
>3—6	0.000/-0.012	0.000/-0.008
>6—10	0.000/-0.015	0.000/-0.009
>10—18	0.000/-0.018	0.000/-0.011
>18—20	0.000/-0.021	0.000/-0.013

Workpiece Material													
P			M	K		N				S	H		
1 2 3 4	5	6 7	1 2 3	1 2	3	1 2	3	4	5	1 2 3	4	1	2
Carbon Steel, Alloy Steel	Alloy Steel, Tool Steel	PH and Ferritic/Martensitic Steel	Stainless Steel	Gray Cast Iron, Nodular Cast Iron	High Alloy Cast Iron	Forged Aluminum Alloy, Cast Aluminum Alloy	Cast Aluminum Alloy	Copper Alloy	Composite Material	High-temperature Alloy	Titanium Alloy	Hardened Steel	Hardened Steel
<35HRC	35-48HRC			<32HRC	35-45HRC	Si<12%	Si>12%	<HB200		<HB450	<HB400	45-55HRC	55-60HRC
○	○	○	○	○	○								

○ Most Suitable ○ Suitable

Recommended Cutting Data ※ P129

Recommended Cutting Data

D938 Deep Holemaking Twist Drill 8D/12D/15D/20D/25D

Workpiece Material		Cutting Speed Vc (m/min)	Feed Fn (mm/rev)			
			Φ3	Φ4	Φ6	Φ8
P	Low-carbon Steel, Long Chips (<125HB)	140-100-60	0.10-0.15-0.20	0.10-0.15-0.20	0.14-0.19-0.25	0.16-0.22-0.32
	Low-carbon Steel, Short Chips, Free Cutting Steel (<125HB)	140-100-60	0.10-0.15-0.20	0.10-0.15-0.20	0.14-0.19-0.25	0.16-0.22-0.32
	High-carbon Steel and Medium-carbon Steel (<25HRC)	120-80-60	0.10-0.15-0.20	0.10-0.15-0.20	0.14-0.19-0.25	0.16-0.22-0.30
	Alloy Steel, Tool Steel (<35HRC)	110-80-60	0.09-0.13-0.16	0.09-0.13-0.16	0.12-0.17-0.23	0.14-0.20-0.28
	Alloy Steel, Tool Steel (35-48HRC)	90-60-35	0.08-0.11-0.14	0.08-0.11-0.14	0.08-0.14-0.20	0.09-0.16-0.25
	PH and Ferritic, Martensitic Steel (<35HRC)	90-60-30	0.05-0.08-0.11	0.05-0.08-0.11	0.07-0.12-0.17	0.08-0.14-0.20
	High Strength PH and Ferritic, Martensitic Steel (35-48HRC)	80-50-30	0.04-0.06-0.08	0.04-0.06-0.08	0.06-0.10-0.14	0.08-0.13-0.18
M	Austenitic Stainless Steels (130- 200HB)	60-50-40	0.04-0.08-0.10	0.04-0.08-0.10	0.06-0.10-0.12	0.06-0.10-0.12
	High Strength Austenitic and Cast Stainless Steel (<25HRC)	60-50-40	0.04-0.06-0.08	0.04-0.06-0.08	0.06-0.08-0.10	0.06-0.08-0.10
	Duplex Stainless Steel (<30HRC)	50-40-30	0.04-0.06-0.08	0.04-0.06-0.08	0.06-0.08-0.10	0.06-0.08-0.10
K	Gray cast iron (<32HRC)	160-120-60	0.13-0.17-0.20	0.15-0.20-0.23	0.17-0.25-0.30	0.20-0.27-0.35
	Alloy Cast Iron with Medium Machining Difficulty, Nodular Cast Iron (<28HRC)	140-100-60	0.11-0.15-0.18	0.13-0.17-0.20	0.15-0.20-0.25	0.17-0.25-0.32
	Difficult-to-machine High Alloy Cast Iron, Nodular Cast Iron (<45HRC)	100-80-50	0.06-0.09-0.11	0.08-0.10-0.13	0.10-0.13-0.16	0.12-0.16-0.20

[Notes]

1. Please use a machine with relatively high rigidity. It is recommended to adopt hydraulic tool holders, thermal expansion tool holders and powerful handles with spring collets.
2. When installing the tool, it is necessary to ensure that the radial bounce of the drill bit tip is less than 0.02mm.
3. This standard cutting condition table is suitable for water-soluble cutting fluids
4. For the tool edge diameter specifications not listed in the table, please refer to the closest edge diameter specifications in the table to select the cutting data. Meanwhile, during the machining process, please adjust the cutting data appropriately according to the actual machining situation.

Recommended Cutting Data

D938 Deep Holemaking Twist Drill 8D/12D/15D/20D/25D

Workpiece Material		Cutting Speed Vc (m/min)	Feed Fn (mm/rev)			
			Φ10	Φ12	Φ14	Φ16
P	Low-carbon Steel, Long Chips (<125HB)	140-100-60	0.16-0.22-0.35	0.18-0.28-0.40	0.22-0.32-0.45	0.22-0.32-0.45
	Low-carbon Steel, Short Chips, Free Cutting Steel (<125HB)	140-100-60	0.16-0.22-0.35	0.18-0.28-0.40	0.22-0.32-0.45	0.22-0.32-0.45
	High-carbon Steel and medium-carbon Steel (<25HRC)	120-80-60	0.16-0.22-0.32	0.18-0.28-0.38	0.22-0.32-0.45	0.22-0.32-0.45
	Alloy Steel, Tool Steel (<35HRC)	110-80-60	0.14-0.20-0.30	0.15-0.23-0.34	0.18-0.25-0.38	0.18-0.25-0.38
	Alloy Steel, Tool Steel (35-48HRC)	90-60-35	0.09-0.16-0.28	0.11-0.19-0.30	0.12-0.22-0.32	0.12-0.22-0.32
	Ph and Ferritic, Martensitic Steel (<35HRC)	90-60-30	0.08-0.14-0.23	0.10-0.18-0.28	0.12-0.20-0.30	0.12-0.20-0.30
	High Strength PH and Ferritic, Martensitic Steel (35-48HRC)	80-50-30	0.08-0.13-0.20	0.10-0.18-0.28	0.12-0.20-0.30	0.12-0.20-0.30
M	Austenitic Stainless Steels (130-200HB)	60-50-40	0.08-0.12-0.16	0.08-0.12-0.16	0.10-0.14-0.18	0.10-0.14-0.18
	High Strength Austenitic and Cast Stainless Steel (<25HRC)	60-50-40	0.08-0.10-0.12	0.08-0.10-0.12	0.10-0.12-0.14	0.10-0.12-0.14
	Duplex Stainless Steel (<30HRC)	50-40-30	0.08-0.10-0.12	0.08-0.10-0.12	0.10-0.12-0.14	0.10-0.12-0.14
K	Gray Cast Iron (<32HRC)	160-120-60	0.23-0.30-0.40	0.25-0.33-0.45	0.28-0.36-0.48	0.30-0.40-0.50
	Alloy Cast Iron with Medium Machining Difficulty, Nodular Cast Iron (<28HRC)	140-100-60	0.20-0.28-0.36	0.22-0.30-0.42	0.24-0.33-0.45	0.25-0.35-0.48
	Difficult-to-machine High Alloy Cast Iron, Nodular Cast Iron (<45HRC)	100-80-50	0.14-0.20-0.26	0.16-0.22-0.28	0.18-0.24-0.30	0.20-0.26-0.32

[Notes]

1. Please use a machine with relatively high rigidity. It is recommended to adopt hydraulic tool holders, thermal expansion tool holders and powerful handles with spring collets.
2. When installing the tool, it is necessary to ensure that the radial bounce of the drill bit tip is less than 0.02mm.
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