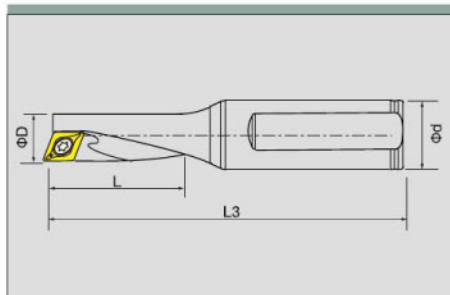


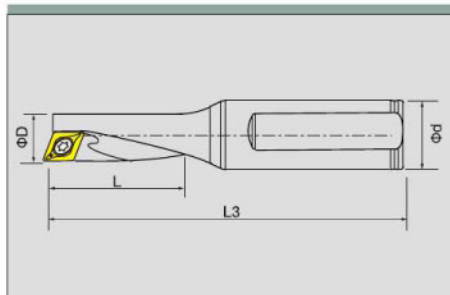
WD-function drill



Dx3

Cat. No	Size				Insert	Clamp screw	wrench
	D	d	L	L3			
WD-C25-SD13-3D-04	13	25	39	101	WDXT042004	M1.6x5	T6
WD-C25-SD14-3D-04	14	25	42	104			
WD-C25-SD15-3D-04	15	25	45	107			
WD-C25-SD16-3D-05	16	25	48	110	WDXT052504	M2x5	T6
WD-C25-SD17-3D-05	17	25	51	113			
WD-C25-SD18-3D-05	18	25	54	128			
WD-C25-SD19-3D-06	19	25	57	131	WDXT063006	M2.2x6	T7
WD-C25-SD20-3D-06	20	25	60	134			
WD-C25-SD21-3D-06	21	25	63	137			
WD-C25-SD22-3D-06	22	25	66	140	WDXT073506	M2.5x6	T8
WD-C25-SD23-3D-07	23	25	69	146			
WD-C25-SD24-3D-07	24	25	72	149			
WD-C25-SD25-3D-07	25	25	75	152	WDXT094008	M3.5x10	T15
WD-C32-SD26-3D-07	26	32	78	161			
WD-C32-SD27-3D-07	27	32	81	164			
WD-C32-SD28-3D-07	28	32	84	167	WDXT125012	M5x12	T20
WD-C32-SD29-3D-09	29	32	87	172			
WD-C40-SD30-3D-09	30	40	90	188			
WD-C40-SD31-3D-09	31	40	93	191	WDXT156012	M6x15	T20
WD-C40-SD32-3D-09	32	40	96	194			
WD-C40-SD33-3D-09	33	40	99	197			
WD-C40-SD34-3D-09	34	40	102	200	WDXT156012	M6x15	T20
WD-C40-SD35-3D-09	35	40	105	203			
WD-C40-SD36-3D-09	36	40	108	206			
WD-C40-SD37-3D-12	37	40	111	216	WDXT156012	M6x15	T20
WD-C40-SD38-3D-12	38	40	114	219			
WD-C40-SD39-3D-12	39	40	117	222			
WD-C40-SD40-3D-12	40	40	120	225	WDXT156012	M6x15	T20
WD-C40-SD41-3D-12	41	40	123	228			
WD-C40-SD42-3D-12	42	40	126	231			
WD-C40-SD43-3D-12	43	40	129	234	WDXT156012	M6x15	T20
WD-C40-SD44-3D-12	44	40	132	237			
WD-C40-SD45-3D-12	45	40	135	240			
WD-C40-SD46-3D-15	46	40	138	243	WDXT156012	M6x15	T20
WD-C40-SD47-3D-15	47	40	141	246			
WD-C40-SD48-3D-15	48	40	144	249			
WD-C40-SD49-3D-15	49	40	147	252	WDXT156012	M6x15	T20
WD-C40-SD50-3D-15	50	40	150	255			

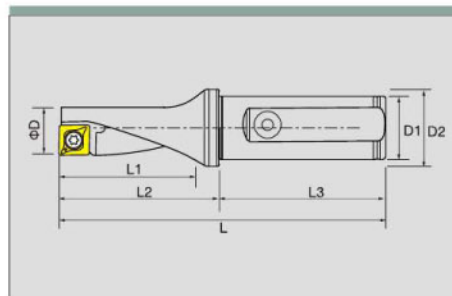
WD-function drill



Dx4

Cat. No	Size				Insert	Clamp screw	wrench
	D	d	L	L3			
WD-C25-SD13-4D-04	13	25	52	114	WDXT042004	M1.6x5	T6
WD-C25-SD14-4D-04	14	25	56	118			
WD-C25-SD15-4D-04	15	25	60	122			
WD-C25-SD16-4D-05	16	25	64	126	WDXT052504	M2x5	T6
WD-C25-SD17-4D-05	17	25	68	130			
WD-C25-SD18-4D-05	18	25	72	146			
WD-C25-SD19-4D-06	19	25	76	150	WDXT063006	M2.2x6	T7
WD-C25-SD20-4D-06	20	25	80	154			
WD-C25-SD21-4D-06	21	25	84	158			
WD-C25-SD22-4D-06	22	25	88	162	WDXT073506	M2.5x6	T8
WD-C25-SD23-4D-07	23	25	92	169			
WD-C25-SD24-4D-07	24	25	96	173			
WD-C25-SD25-4D-07	25	25	100	177	WDXT094008	M3.5x10	T15
WD-C32-SD26-4D-07	26	32	104	187			
WD-C32-SD27-4D-07	27	32	108	191			
WD-C32-SD28-4D-07	28	32	112	195	WDXT125012	M5x12	T20
WD-C32-SD29-4D-09	29	32	116	201			
WD-C40-SD30-4D-09	30	40	120	218			
WD-C40-SD31-4D-09	31	40	124	222	WDXT156012	M6x15	T20
WD-C40-SD32-4D-09	32	40	128	226			
WD-C40-SD33-4D-09	33	40	132	230			
WD-C40-SD34-4D-09	34	40	136	234	WDXT156012	M6x15	T20
WD-C40-SD35-4D-09	35	40	140	238			
WD-C40-SD36-4D-09	36	40	144	242			
WD-C40-SD37-4D-12	37	40	148	253	WDXT156012	M6x15	T20
WD-C40-SD38-4D-12	38	40	152	257			
WD-C40-SD39-4D-12	39	40	156	261			
WD-C40-SD40-4D-12	40	40	160	265	WDXT156012	M6x15	T20
WD-C40-SD41-4D-12	41	40	164	269			
WD-C40-SD42-4D-12	42	40	168	273			
WD-C40-SD43-4D-12	43	40	172	277	WDXT156012	M6x15	T20
WD-C40-SD44-4D-12	44	40	176	281			
WD-C40-SD45-4D-12	45	40	180	285			
WD-C40-SD46-4D-15	46	40	184	289	WDXT156012	M6x15	T20
WD-C40-SD47-4D-15	47	40	188	293			
WD-C40-SD48-4D-15	48	40	192	297			
WD-C40-SD49-4D-15	49	40	196	301	WDXT156012	M6x15	T20
WD-C40-SD50-4D-15	50	40	200	235			

SP Disposable rapid drilling tools



Cat. No	Size						
	D	D1	D2	L3	L2	L1	L
SP-C20-SD12.5-4D-05	12.5	20	25	50	70	52	120
SP-C20-SD13-4D-05	13.0			50	70	52	120
SP-C20-SD13.5-4D-05	13.5			50	74	56	124
SP-C20-SD14-4D-05	14.0			50	74	56	124
SP-C20-SD14.5-4D-05	14.5			50	79	60	129
SP-C20-SD15-4D-05	15.0			50	79	60	129
SP-C25-SD15.5-4D-06	15.5	25	32	56	84	64	140
SP-C25-SD16-4D-06	16.0			56	84	64	140
SP-C25-SD16.5-4D-06	16.5			56	88	68	144
SP-C25-SD17-4D-06	17.0			56	88	68	144
SP-C25-SD17.5-4D-06	17.5			56	93	72	149
SP-C25-SD18-4D-06	18.0			56	93	72	149
SP-C25-SD18.5-4D-06	18.5			56	97	76	153
SP-C25-SD19-4D-06	19.0			56	97	76	153
SP-C25-SD19.5-4D-06	19.5			56	103	80	159
SP-C25-SD20-4D-06	20.0			56	103	80	159
SP-C25-SD20.5-4D-06	20.5			56	107	84	163
SP-C25-SD21-4D-06	21.0			56	107	84	163
SP-C25-SD21.5-4D-06	21.5			56	111	88	167
SP-C25-SD22-4D-07	22.0	25	32	56	111	88	168
SP-C25-SD22.5-4D-07	22.5	25	45	56	117	92	173
SP-C32-SD22.5-4D-07		32		60	117	92	177
SP-C25-SD23-4D-07	23.0	25		56	117	92	173
SP-C32-SD23-4D-07		32		60	117	92	177
SP-C25-SD23.5-4D-07	23.5	25		56	122	96	178
SP-C32-SD23.5-4D-07		32		60	122	96	182
SP-C25-SD24-4D-07	24.0	25		56	122	96	178
SP-C32-SD24-4D-07		32		60	122	96	182
SP-C25-SD24.5-4D-07	24.5	25		56	127	100	183
SP-C32-SD24.5-4D-07		32		60	127	100	187
SP-C25-SD25-4D-07	25.0	25		56	127	100	183
SP-C32-SD25-4D-07		32		60	127	100	187
SP-C25-SD25.5-4D-07	25.5	25		56	131	104	187
SP-C32-SD25.5-4D-07		32		60	131	104	191
SP-C25-SD26-4D-07	26.0	25		56	131	104	187
SP-C32-SD26-4D-07		32		60	131	104	191
SP-C25-SD26.5-4D-07	26.5	25		56	135	108	191
SP-C32-SD26.5-4D-07		32		60	135	108	195
SP-C25-SD27-4D-07	27.0	25		56	135	108	191
SP-C32-SD27-4D-07		32		60	135	108	195
SP-C25-SD27.5-4D-07	27.5	25		56	140	112	196
SP-C32-SD27.5-4D-07		32		60	140	112	200

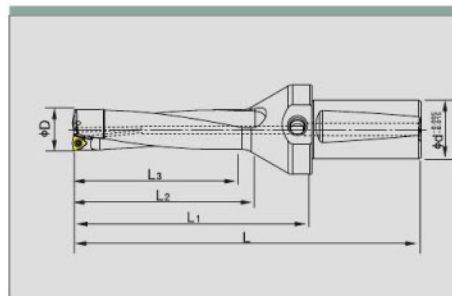
SP Disposable rapid drilling tools

Cat. No	Size						
	D	D1	D2	L3	L2	L1	L
SP-C25-SD28-4D-09	28.0	25	45	56	140	112	196
SP-C32-SD28-4D-09		32		60	140	112	200
SP-C25-SD28.5-4D-09	28.5	25		56	144	116	200
SP-C32-SD28.5-4D-09		32		60	144	116	204
SP-C25-SD29-4D-09	29.0	25		56	144	116	200
SP-C32-SD29-4D-09		32		60	144	116	204
SP-C32-SD29.5-4D-09	29.5	32	55	60	151	120	211
SP-C40-SD29.5-4D-09		40		70	151	120	221
SP-C32-SD30-4D-09	30.0	32		60	151	120	211
SP-C40-SD30-4D-09		40		70	151	120	221
SP-C32-SD31-4D-09	31.0	32		60	156	124	216
SP-C40-SD31-4D-09		40		70	156	124	226
SP-C32-SD32-4D-09	32.0	32		60	160	128	220
SP-C40-SD32-4D-09		40		70	160	128	230
SP-C32-SD33-4D-09	33.0	32		60	165	132	225
SP-C40-SD33-4D-09		40		70	165	132	235
SP-C32-SD34-4D-11	34.0	32	55	60	169	136	229
SP-C40-SD34-4D-11		40		70	169	136	239
SP-C32-SD35-4D-11	35.0	32		60	174	140	234
SP-C40-SD35-4D-11		40		70	174	140	244
SP-C32-SD36-4D-11	36.0	32		60	179	144	239
SP-C40-SD36-4D-11		40		70	179	144	249
SP-C32-SD37-4D-11	37.0	32		60	184	148	244
SP-C40-SD37-4D-11		40		70	184	148	254
SP-C32-SD38-4D-11	38.0	32		60	189	152	249
SP-C40-SD38-4D-11		40		70	189	152	259
SP-C32-SD39-4D-11	39.0	32	60	60	193	156	253
SP-C40-SD39-4D-11		40		70	193	156	263
SP-C32-SD40-4D-11	40.0	32		60	198	160	258
SP-C40-SD40-4D-11		40		70	198	160	268
SP-C40-SD41-4D-11	41.0	40		70	203	164	273
SP-C40-SD42-4D-14	42.0	40	60	70	207	168	277
SP-C40-SD43-4D-14	43.0			70	212	172	282
SP-C40-SD44-4D-14	44.0			70	216	176	286
SP-C40-SD45-4D-14	45.0			70	222	180	292
SP-C40-SD46-4D-14	46.0			70	227	184	297
SP-C40-SD47-4D-14	47.0			70	231	188	301
SP-C40-SD48-4D-14	48.0			70	236	192	306
SP-C40-SD49-4D-14	49.0			70	240	196	310
SP-C40-SD50-4D-14	50.0			70	245	200	315

Mating

Cat. No.	Insert	Clamp screw	wrench
SP12.5-SP15	SPMG050204 DG	M2.0x4	T6
SP15.5-SP21.5	SPMG060204 DG	M2.2x5	T7
SP22-SP27.5	SPMG06T308 DG	M2.5x6	T8
SP28-SP33	SPMG090408 DG	M3.5x8	T15
SP34-SP41	SPMG110408 DG	M4x9	T15
SP42-SP50	SPMG140512 DG	M5x10	T20

WC Disposable rapid drilling tools



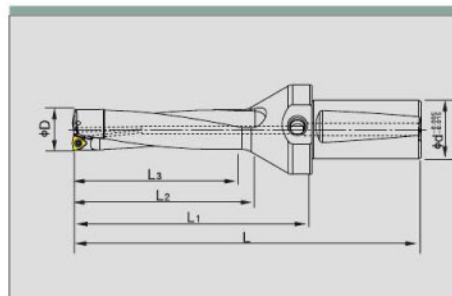
Dx3

Cat. No	Size					d
	D	L	L1	L2	L3	
WC-C25-SD14-3D-03	14	139	79	59	42	25
WC-C25-SD15-3D-03	15	143	83	62	45	
WC-C25-SD16-3D-03	16	146	90	69	48	
WC-C25-SD17-3D-03	17	150	94	73	51	
WC-C25-SD18-3D-03	18	155	99	77	54	
WC-C25-SD19-3D-03	19	159	103	81	57	
WC-C32-SD20-3D-03	20	165	108	86	60	32
WC-C32-SD21-3D-04	21	169	113	89	63	
WC-C32-SD22-3D-04	22	173	117	93	66	
WC-C32-SD23-3D-04	23	178	122	97	69	
WC-C32-SD24-3D-04	24	183	127	102	72	
WC-C32-SD25-3D-04	25	188	132	106	75	
WC-C32-SD26-3D-05	26	196	136	109	78	
WC-C32-SD27-3D-05	27	200	140	113	81	
WC-C32-SD28-3D-05	28	205	145	117	84	
WC-C32-SD29-3D-05	29	209	149	121	87	
WC-C32-SD30-3D-05	30	215	155	126	90	
WC-C32-SD31-3D-06	31	220	160	130	93	
WC-C32-SD32-3D-06	32	224	164	134	96	
WC-C32-SD33-3D-06	33	229	169	138	99	
WC-C32-SD34-3D-06	34	233	173	142	102	
WC-C32-SD35-3D-06	35	238	178	146	105	
WC-C32-SD36-3D-06	36	241	181	149	108	
WC-C32-SD37-3D-06	37	244	184	152	111	
WC-C32-SD38-3D-06	38	247	187	155	114	
WC-C32-SD39-3D-06	39	256	196	162	117	
WC-C40-SD40-3D-06	40	260	200	166	120	40
WC-C40-SD41-3D-06	41	265	205	170	123	
WC-C40-SD42-3D-08	42	269	209	174	126	
WC-C40-SD43-3D-08	43	274	214	178	129	
WC-C40-SD44-3D-08	44	289	219	182	132	

◇ Use, high-pressure center as far as possible the water, increase blade life and BTA sex.

◇ When used in CNC lathe, the tool center point to be parallel with the machine spindle center.

WC Disposable rapid drilling tools



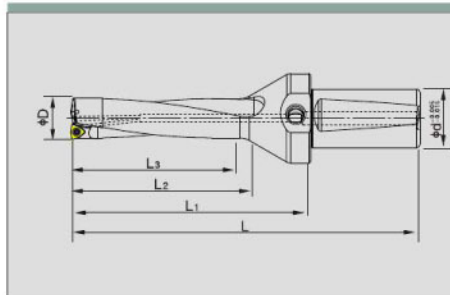
Dx3

Cat. No	Size					
	D	L	L ₁	L ₂	L ₃	d
WC-C40-SD45-3D-08	45	294	223	186	135	40
WC-C40-SD46-3D-08	46	299	227	190	138	
WC-C40-SD47-3D-08	47	303	231	194	141	
WC-C40-SD48-3D-08	48	307	235	198	144	
WC-C40-SD49-3D-08	49	313	239	202	147	
WC-C40-SD50-3D-08	50	315	243	206	150	
WC-C40-SD51-3D-08	51	319	247	210	153	
WC-C40-SD52-3D-08	52	323	251	214	156	
WC-C40-SD53-3D-08	53	327	255	218	159	
WC-C40-SD54-3D-08	54	331	259	222	162	
WC-C40-SD55-3D-08	55	335	263	226	165	
WC-C40-SD56-3D-08	56	339	267	230	168	
WC-C40-SD57-3D-08	57	343	271	234	171	
WC-C40-SD58-3D-08	58	347	275	238	174	
WC-C40-SD59-3D-08	59	351	279	242	177	
WC-C40-SD60-3D-08	60	355	283	246	180	

Mating

Cat. No.	Insert	Clamp screw	wrench
WC14-WC20	WCMX030208	M2.5x6.5	T8
WC21-WC25	WCMX040208	M2.5x6.5	T8
WC26-WC30	WCMX050308	M3.0x7	T8
WC31-WC41	WCMX06T308	M3.5x8	T15
WC42-WC60	WCMX080408	M4.0x11.5	T15

WC Disposable rapid drilling tools



Dx4

Cat. No	Size					d
	D	L	L1	L2	L3	
WC-C25-SD14-4D-03	14	139	79	59	56	25
WC-C25-SD15-4D-03	15	143	83	62	60	
WC-C25-SD16-4D-03	16	146	90	69	64	
WC-C25-SD17-4D-03	17	150	94	73	68	
WC-C25-SD18-4D-03	18	155	99	77	72	
WC-C25-SD19-4D-03	19	159	103	81	76	
WC-C32-SD20-4D-03	20	165	108	86	80	32
WC-C32-SD21-4D-04	21	169	113	89	84	
WC-C32-SD22-4D-04	22	173	117	93	88	
WC-C32-SD23-4D-04	23	178	122	97	92	
WC-C32-SD24-4D-04	24	183	127	102	96	
WC-C32-SD25-4D-04	25	188	132	106	100	
WC-C32-SD26-4D-05	26	196	136	109	104	
WC-C32-SD27-4D-05	27	200	140	113	108	
WC-C32-SD28-4D-05	28	205	145	117	112	
WC-C32-SD29-4D-05	29	209	149	121	116	
WC-C32-SD30-4D-05	30	215	155	126	120	
WC-C32-SD31-4D-06	31	220	160	130	124	
WC-C32-SD32-4D-06	32	224	164	134	128	
WC-C32-SD33-4D-06	33	229	169	138	132	
WC-C32-SD34-4D-06	34	233	173	142	136	
WC-C32-SD35-4D-06	35	238	178	146	140	
WC-C32-SD36-4D-06	36	241	181	149	144	
WC-C32-SD37-4D-06	37	244	184	152	148	
WC-C32-SD38-4D-06	38	247	187	155	152	
WC-C32-SD39-4D-06	39	256	196	162	156	
WC-C40-SD40-4D-06	40	260	200	166	160	40
WC-C40-SD41-4D-06	41	265	205	170	164	
WC-C40-SD42-4D-08	42	269	209	174	168	
WC-C40-SD43-4D-08	43	274	214	178	172	
WC-C40-SD44-4D-08	44	289	219	182	176	

◇ Use, high-pressure center as far as possible the water, increase blade life and BTA sex.

◇ When used in CNC lathe, the tool center point to be parallel with the machine spindle center.

WC Disposable rapid drilling tools

Dx4

Cat. No	Size					
	D	L	L ₁	L ₂	L ₃	d
WC-C40-SD45-4D-08	45	294	223	186	180	40
WC-C40-SD46-4D-08	46	299	227	190	184	
WC-C40-SD47-4D-08	47	303	231	194	188	
WC-C40-SD48-4D-08	48	307	235	198	192	
WC-C40-SD49-4D-08	49	313	239	202	196	
WC-C40-SD50-4D-08	50	315	243	206	200	
WC-C40-SD51-4D-08	51	319	247	210	204	
WC-C40-SD52-4D-08	52	323	251	214	208	
WC-C40-SD53-4D-08	53	327	255	218	212	
WC-C40-SD54-4D-08	54	331	259	222	216	
WC-C40-SD55-4D-08	55	335	263	226	220	
WC-C40-SD56-4D-08	56	339	267	230	224	
WC-C40-SD57-4D-08	57	343	271	234	228	
WC-C40-SD58-4D-08	58	347	275	238	232	
WC-C40-SD59-4D-08	59	351	279	242	236	
WC-C40-SD60-4D-08	60	355	283	246	240	

POINT SPECIFICATION

Cat. No	Size					
	D	L	L ₁	L ₂	L ₃	d
WC-C25-SD16.5-4D-03	16.5	146	90	69	64	25
WC-C25-SD17.5-4D-03	17.5	150	94	73	68	25
WC-C25-SD18.5-4D-03	18.5	155	99	77	72	
WC-C25-SD19.5-4D-03	19.5	159	103	81	76	
WC-C32-SD20.5-4D-03	20.5	165	108	85	80	32
WC-C32-SD21.5-4D-04	21.5	169	113	89	84	
WC-C32-SD22.5-4D-04	22.5	173	117	93	88	
WC-C32-SD23.5-4D-04	23.5	178	122	97	92	
WC-C32-SD24.5-4D-04	24.5	183	127	102	96	
WC-C32-SD25.5-4D-05	25.5	188	131	106	100	
WC-C32-SD26.5-4D-05	26.5	193	136	110	104	

Mating

Cat. No.	Insert	Clamp screw	wrench
WC14-WC20	WCMX030208	M2.5x6.5	T8
WC21-WC25	WCMX040208	M2.5x6.5	T8
WC26-WC30	WCMX050308	M3.0x7	T8
WC31-WC41	WCMX06T308	M3.5x8	T15
WC42-WC60	WCMX080408	M4.0x11.5	T15

Recommended cutting conditions

	(m/min)	(mm/rev)						
		Φ14-Φ22	Φ23-Φ29	Φ30-Φ36	Φ37-Φ43	Φ44-Φ50	Φ51-Φ54	Φ60-Φ70
低碳鋼 (~0.3%C) Low alloy steel	180-250	0.05~0.08	0.06~0.10	0.06~0.12	0.07~0.13	0.08~0.15	0.08~0.16	0.08~0.12
碳鋼(0.3%C~) Carbon steel	160-220	0.06~0.12	0.08~0.15	0.10~0.18	0.12~0.22	0.12~0.24	0.13~0.25	0.12~0.18
低合金鋼 (~HRC32) Low carbon steel	150-220	0.06~0.12	0.08~0.14	0.10~0.18	0.12~0.22	0.12~0.23	0.13~0.24	0.10~0.18
高合金鋼 (HRC32~) High alloy steel	130-180	0.06~0.10	0.08~0.15	0.10~0.20	0.12~0.23	0.12~0.24	0.13~0.25	0.10~0.15
不銹鋼 Stainless steel	170-240	0.05~0.10	0.06~0.12	0.08~0.15	0.09~0.16	0.10~0.17	0.11~0.19	0.08~0.15
鑄鐵 Cast Iron	180-250	0.06~0.12	0.08~0.16	0.12~0.20	0.15~0.25	0.16~0.28	0.18~0.30	0.15~0.22
球墨鑄件 Ductile cast Iron	130-200	0.06~0.10	0.08~0.15	0.10~0.18	0.12~0.20	0.15~0.23	0.16~0.25	0.10~0.20
鋁合金 Aluminium	330-380	0.06~0.14	0.08~0.15	0.10~0.20	0.12~0.22	0.14~0.23	0.15~0.26	0.15~0.25
鈦合金 Ti6Al	30-60	0.05~0.10	0.06~0.14	0.08~0.18	0.11~0.22	0.14~0.23	0.15~0.24	0.12~0.16

- ★ Initial drilling, to recommend the use of cutting conditions in the middle range, followed by (in accordance with wear) to adjust the cutting parameters to achieve the best cutting effect.
- ★ The above cutting parameters is for 3D, 4D drilling tools, the cutting parameters need to decrease 15%.
- ★ Cooling mode using only cold outside, cutting speed should be reduced by 10%.
- ★ It must adopt inner cooling mode for austenitic stainless steel machining.
- ★ Drilling on the slope or the parts have pre-drilling hole or intersection hole, The drilling feedrate must decrease to 1/3 of the recommended data.

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