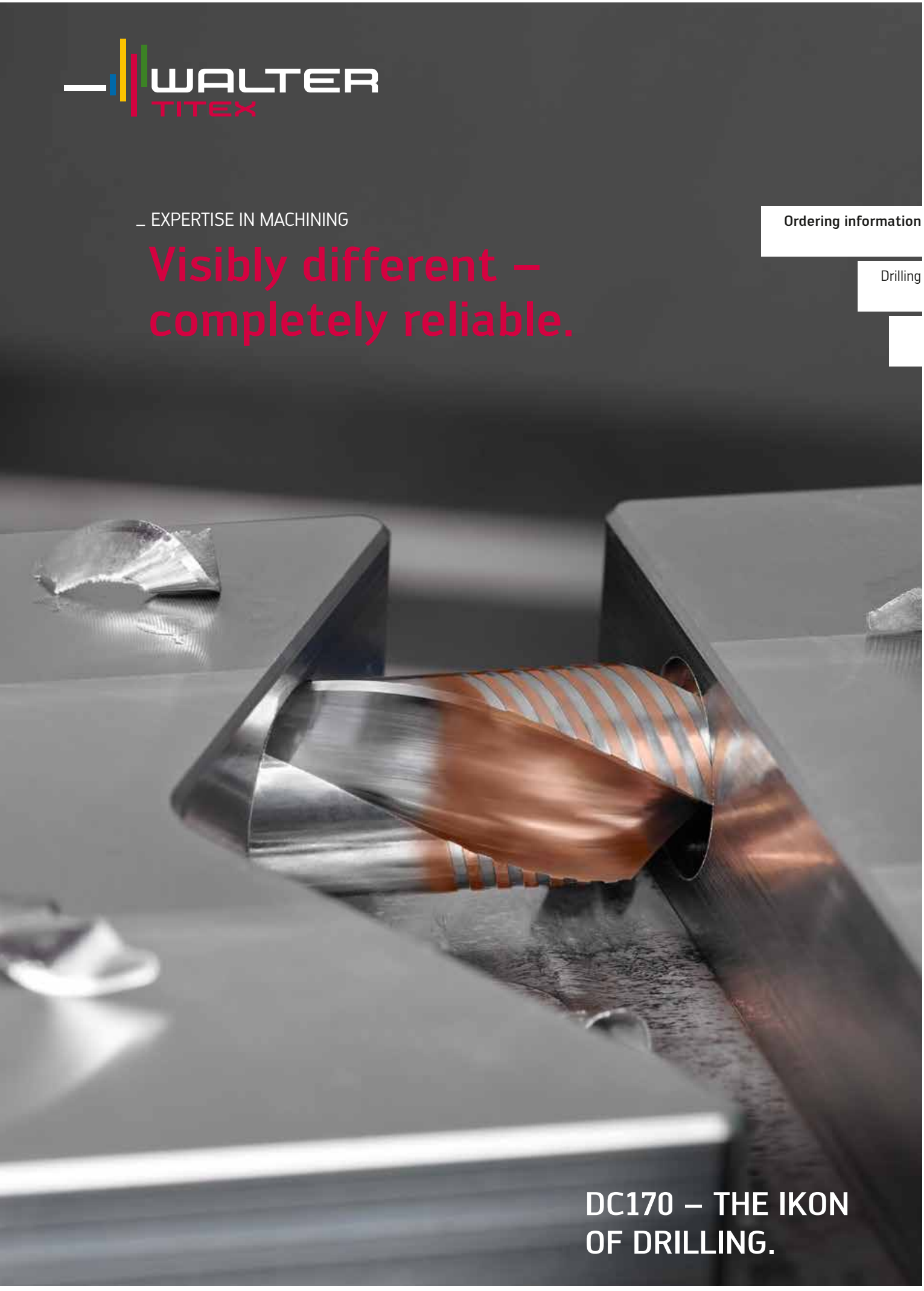
WALTER TITEX

_ EXPERTISE IN MACHINING

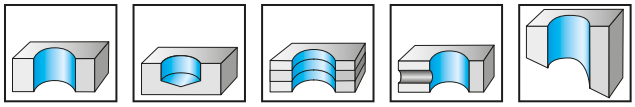
Visibly different – completely reliable.



DC170 – THE IKON OF DRILLING.

Solid carbide coolant through drills
Supreme DC170

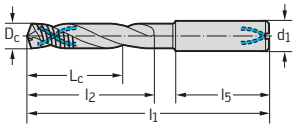
16 x D_c



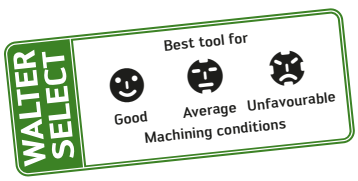
- 140° point angle
- Shank end accomodates minimum quantity lubrication; from D_c 6 mm according to DIN 69090

	P	M	K	N	S	H	O
WJ30EJ	●●		●●				

Shank DIN 6535 HA



Designation	D_c h7 mm	D_c inches/no.	L_c mm	l_1 mm	l_2 mm	l_5 mm	d_1 h6 mm	WJ30EJ
DC170-16-03.000A1-	3		52	89	57	28	4	●
DC170-16-03.175A1-	3,175	1/8"	60	98	66	28	4	●
DC170-16-03.500A1-	3,5		72	110	78	28	4	●
DC170-16-03.572A1-	3,572	9/64"	72	110	78	28	4	●
DC170-16-03.969A1-	3,969	5/32"	72	110	78	28	4	●
DC170-16-04.000A1-	4		72	110	78	28	4	●
DC170-16-04.500A1-	4,5		93	132	100	28	5	●
DC170-16-04.763A1-	4,763	3/16"	92	132	100	28	5	●
DC170-16-04.800A1-	4,8		92	132	100	28	5	●
DC170-16-05.000A1-	5		92	132	100	28	5	●
DC170-16-05.500A1-	5,5		101	150	110	36	6	●
DC170-16-05.556A1-	5,556	7/32"	111	160	120	36	6	●
DC170-16-05.800A1-	5,8		111	160	120	36	6	●
DC170-16-06.000A1-	6		111	160	120	36	6	●
DC170-16-06.100A1-	6,1		124	175	135	36	8	●
DC170-16-06.350A1-	6,35	1/4"	124	175	135	36	8	●
DC170-16-06.500A1-	6,5		124	175	135	36	8	●
DC170-16-06.800A1-	6,8		124	175	135	36	8	●
DC170-16-07.000A1-	7		124	175	135	36	8	●
DC170-16-07.144A1-	7,144	9/32"	140	192	152	36	8	●
DC170-16-07.400A1-	7,4		140	192	152	36	8	●
DC170-16-07.500A1-	7,5		140	192	152	36	8	●
DC170-16-07.938A1-	7,938	5/16"	140	192	152	36	8	●
DC170-16-08.000A1-	8		140	192	152	36	8	●
DC170-16-08.300A1-	8,3		148	206	162	40	10	●
DC170-16-08.500A1-	8,5		148	206	162	40	10	●
DC170-16-08.731A1-	8,731	11/32"	148	206	162	40	10	●
DC170-16-09.000A1-	9		148	206	162	40	10	●
DC170-16-09.525A1-	9,525	3/8"	165	224	180	40	10	●
DC170-16-09.800A1-	9,8		165	224	180	40	10	●
DC170-16-10.000A1-	10		165	224	180	40	10	●
DC170-16-10.200A1-	10,2		181	247	198	45	12	●
DC170-16-10.319A1-	10,319	13/32"	181	247	198	45	12	●
DC170-16-11.000A1-	11		181	247	198	45	12	●
DC170-16-11.113A1-	11,113	7/16"	198	265	216	45	12	●
DC170-16-11.500A1-	11,5		198	265	216	45	12	●
DC170-16-11.800A1-	11,8		198	265	216	45	12	●
DC170-16-11.906A1-	11,906	15/32"	198	265	216	45	12	●
DC170-16-12.000A1-	12		198	265	216	45	12	●
DC170-16-12.700A1-	12,7	1/2"	238	301	252	45	14	●
DC170-16-13.000A1-	13		238	301	252	45	14	●
DC170-16-14.000A1-	14		238	301	252	45	14	●
DC170-16-14.288A1-	14,288	9/16"	272	340	288	48	16	●
DC170-16-15.000A1-	15		272	340	288	48	16	●
DC170-16-16.000A1-	16		272	340	288	48	16	●

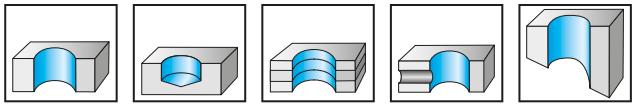


Ordering example: DC170 solid carbide twist drill with D_c 3 mm in the WJ30EJ grade
Ordering code: DC170-16-03.000A1-WJ30EJ

● ● ● New addition to the product range

Solid carbide coolant through drills
Supreme DC170

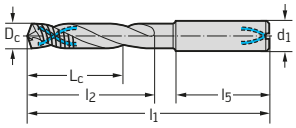
20 x D_c



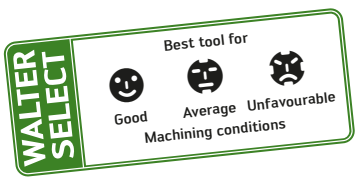
- 140° point angle
- Shank end accomodates minimum quantity lubrication; from D_c 6 mm according to DIN 69090

	P	M	K	N	S	H	O
WJ30EJ	●●		●●				

Shank DIN 6535 HA



Designation	D_c h7 mm	D_c inches/no.	L_c mm	l_1 mm	l_2 mm	l_5 mm	d_1 h6 mm	WJ30EJ
DC170-20-03.000A1-	3		60	97	65	28	4	●
DC170-20-03.175A1-	3,175	1/8"	74	112	80	28	4	●
DC170-20-03.500A1-	3,5		86	124	92	28	4	●
DC170-20-03.572A1-	3,572	9/64"	86	124	92	28	4	●
DC170-20-03.969A1-	3,969	5/32"	86	124	92	28	4	●
DC170-20-04.000A1-	4		86	124	92	28	4	●
DC170-20-04.500A1-	4,5		111	150	118	28	5	●
DC170-20-04.763A1-	4,763	3/16"	110	150	118	28	5	●
DC170-20-04.800A1-	4,8		110	150	118	28	5	●
DC170-20-05.000A1-	5		110	150	118	28	5	●
DC170-20-05.500A1-	5,5		123	170	132	36	6	●
DC170-20-05.556A1-	5,556	7/32"	135	182	144	36	6	●
DC170-20-05.800A1-	5,8		135	182	144	36	6	●
DC170-20-06.000A1-	6		135	182	144	36	6	●
DC170-20-06.100A1-	6,1		151	200	162	36	8	●
DC170-20-06.350A1-	6,35	1/4"	151	200	162	36	8	●
DC170-20-06.500A1-	6,5		151	200	162	36	8	●
DC170-20-06.800A1-	6,8		151	200	162	36	8	●
DC170-20-07.000A1-	7		151	200	162	36	8	●
DC170-20-07.144A1-	7,144	9/32"	172	222	184	36	8	●
DC170-20-07.400A1-	7,4		172	222	184	36	8	●
DC170-20-07.500A1-	7,5		172	222	184	36	8	●
DC170-20-07.938A1-	7,938	5/16"	172	222	184	36	8	●
DC170-20-08.000A1-	8		172	222	184	36	8	●
DC170-20-08.300A1-	8,3		184	240	198	40	10	●
DC170-20-08.500A1-	8,5		184	240	198	40	10	●
DC170-20-08.731A1-	8,731	11/32"	184	240	198	40	10	●
DC170-20-09.000A1-	9		184	240	198	40	10	●
DC170-20-09.525A1-	9,525	3/8"	205	262	220	40	10	●
DC170-20-09.800A1-	9,8		205	262	220	40	10	●
DC170-20-10.000A1-	10		205	262	220	40	10	●
DC170-20-10.200A1-	10,2		225	289	242	45	12	●
DC170-20-10.319A1-	10,319	13/32"	225	289	242	45	12	●
DC170-20-11.000A1-	11		225	289	242	45	12	●
DC170-20-11.113A1-	11,113	7/16"	246	311	264	45	12	●
DC170-20-11.500A1-	11,5		246	311	264	45	12	●
DC170-20-11.800A1-	11,8		246	311	264	45	12	●
DC170-20-11.906A1-	11,906	15/32"	246	311	264	45	12	●
DC170-20-12.000A1-	12		246	311	264	45	12	●
DC170-20-12.700A1-	12,7	1/2"	294	357	308	45	14	●
DC170-20-13.000A1-	13		294	357	308	45	14	●
DC170-20-14.000A1-	14		294	357	308	45	14	●
DC170-20-14.288A1-	14,288	9/16"	336	404	352	48	16	●
DC170-20-15.000A1-	15		336	404	352	48	16	●
DC170-20-16.000A1-	16		336	404	352	48	16	●



Ordering example: DC170 solid carbide twist drill with D_c 3 mm in the WJ30EJ grade
Ordering code: DC170-20-03.000A1-WJ30EJ

● ● ● New addition to the product range

Cutting data

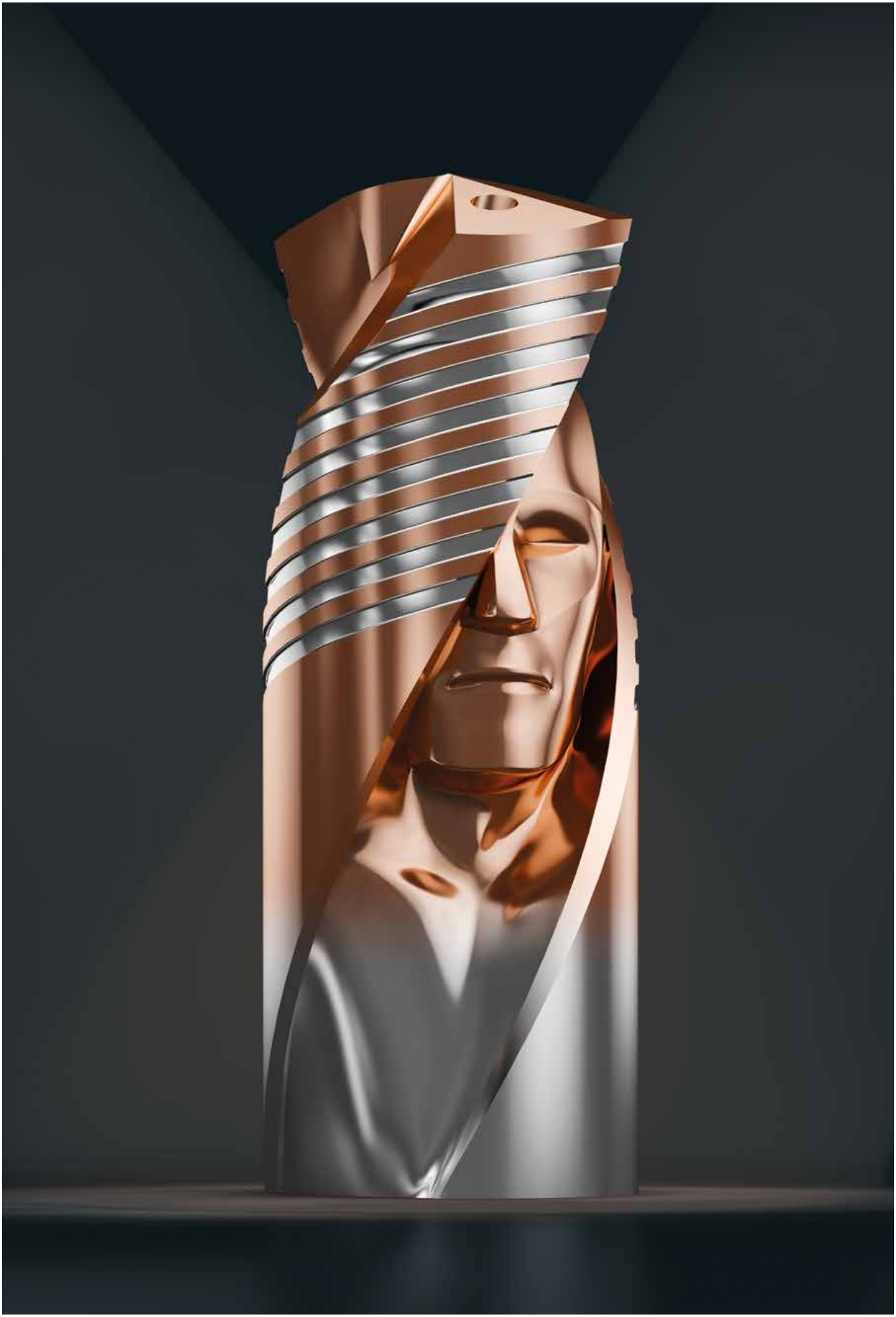
The specified cutting data are average recommended values.
For special applications, adjustment is recommended.

Material group	Structure of main material groups and code letters			Brinell hardness HB	Tensile strength R_m N/mm²	Machining group [1]	Drilling depth	16 x D_c				20 x D_c			
	= Cutting data for wet machining						Product family	DC170				DC170			
	= Dry machining is possible, cutting data must be selected from Walter GPS						Dimensions	Walter standard				Walter standard			
	E = Emulsion **O** = Oil **M** = MQL **L** = Dry						Dia. range (mm)	3,00 – 16,00				3,00 – 16,00			
							Cooling	Internal cooling				Internal cooling			
	v_c = Cutting speed **VRR** = Feed rate chart						Grade	WJ30EJ				WJ30EJ			
	Workpiece material							v_c	VRR			v_c	VRR		
P	Non-alloyed steel	C ≤ 0.25%	Annealed	125	428	P1		150	12	E O	M L	143	12	E O	M L
		C > 0.25 to ≤ 0.55%	Annealed	190	639	P2		135	12	E O	M L	130	12	E O	M L
		C > 0.25 to ≤ 0.55%	Heat-treated	210	708	P3		130	12	E O	M L	125	12	E O	M L
		C > 0.55%	Annealed	190	639	P4		135	12	E O	M L	130	12	E O	M L
		C > 0.55%	Heat-treated	300	1013	P5		105	9	E O	M L	100	9	E O	M L
		Free cutting steel (short-chipping)	Annealed	220	745	P6		150	12	E O	M L	138	10	E O	M L
	Low-alloyed steel	Annealed		175	591	P7		135	12	E O		125	10	E O	
		Heat-treated		300	1013	P8		105	9	E O		100	9	E O	
		Heat-treated		380	1282	P9		63	7	O E		60	7	O E	
		Heat-treated		430	1477	P10		45	6	O E		40	6	O E	
	High-alloyed steel and high-alloyed tool steel	Annealed		200	675	P11		72	9	E O		68	9	E O	
		Hardened and tempered		300	1013	P12		90	8	E O		85	8	E O	
		Hardened and tempered		400	1361	P13		45	6	O E		40	6	O E	
	Stainless steel	Ferritic/martensitic, annealed		200	675	P14		71	8	E O		67	8	E O	
		Martensitic, heat-treated		330	1114	P15		41	7	E O		38	7	E O	
K	Malleable cast iron	Ferritic		200	675	K1		100	16	E O	M L	95	16	E O	M L
		Pearlitic		260	867	K2		75	12	E O	M L	70	12	E O	M L
	Grey cast iron	Low tensile strength		180	602	K3		120	16	E O	M L	115	16	E O	M L
		High tensile strength/austenitic		245	825	K4		100	16	E O	M L	95	16	E O	M L
	Cast iron with spheroidal graphite	Ferritic		155	518	K5		120	16	E O	M L	113	16	E O	M L
		Pearlitic		265	885	K6		95	12	E O	M L	90	12	E O	M L
	GGV (CGI)			200	675	K7		110	16	E O	M L	103	16	E O	M L

[1] The classification of the machining groups can be found in the Walter General Catalogue 2012 from page H 8 onwards.

VRR: Feed rate charts

VRR	Feed rate f (mm/rev) for Ø (mm)							
	3	5	6	8	10	12	15	20
1	0,013	0,017	0,018	0,021	0,024	0,026	0,029	0,033
2	0,027	0,033	0,037	0,042	0,047	0,052	0,058	0,067
3	0,040	0,050	0,055	0,063	0,071	0,077	0,087	0,10
4	0,053	0,067	0,073	0,084	0,094	0,10	0,12	0,13
5	0,067	0,083	0,091	0,11	0,12	0,13	0,14	0,17
6	0,080	0,10	0,11	0,13	0,14	0,15	0,17	0,20
7	0,093	0,12	0,13	0,15	0,16	0,18	0,20	0,23
8	0,11	0,13	0,15	0,17	0,19	0,21	0,23	0,27
9	0,12	0,15	0,16	0,19	0,21	0,23	0,26	0,30
10	0,13	0,17	0,18	0,21	0,24	0,26	0,29	0,33
12	0,16	0,20	0,22	0,25	0,28	0,31	0,35	0,40
16	0,21	0,27	0,29	0,34	0,38	0,41	0,46	0,53
20	0,27	0,33	0,37	0,42	0,47	0,52	0,58	0,67



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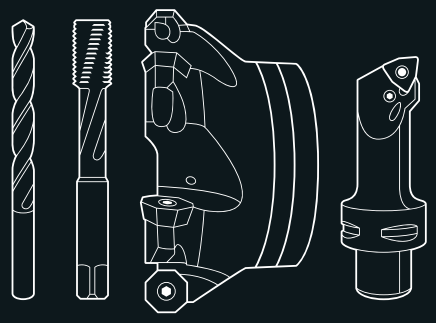

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