



PT. DHARMA PRECISION TOOLS

Precision Cutting Tools

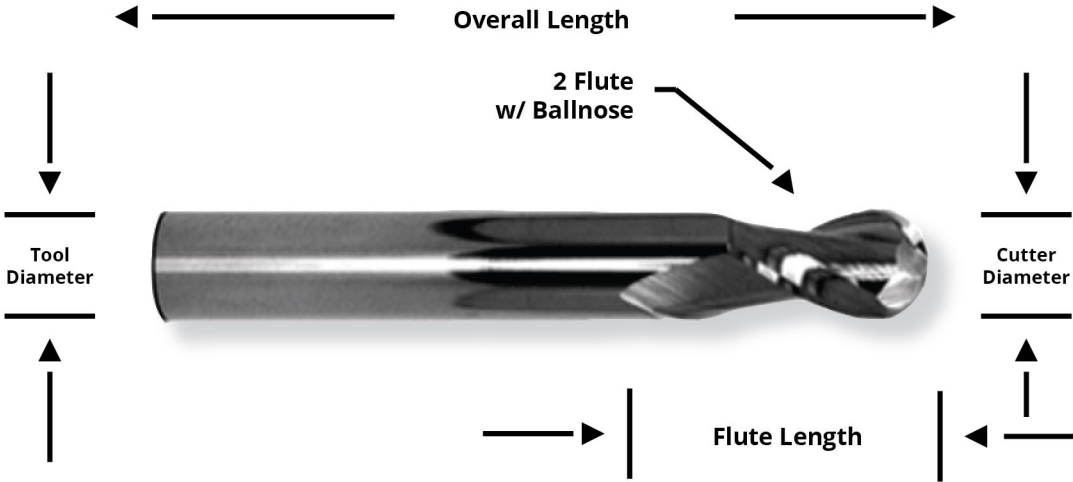
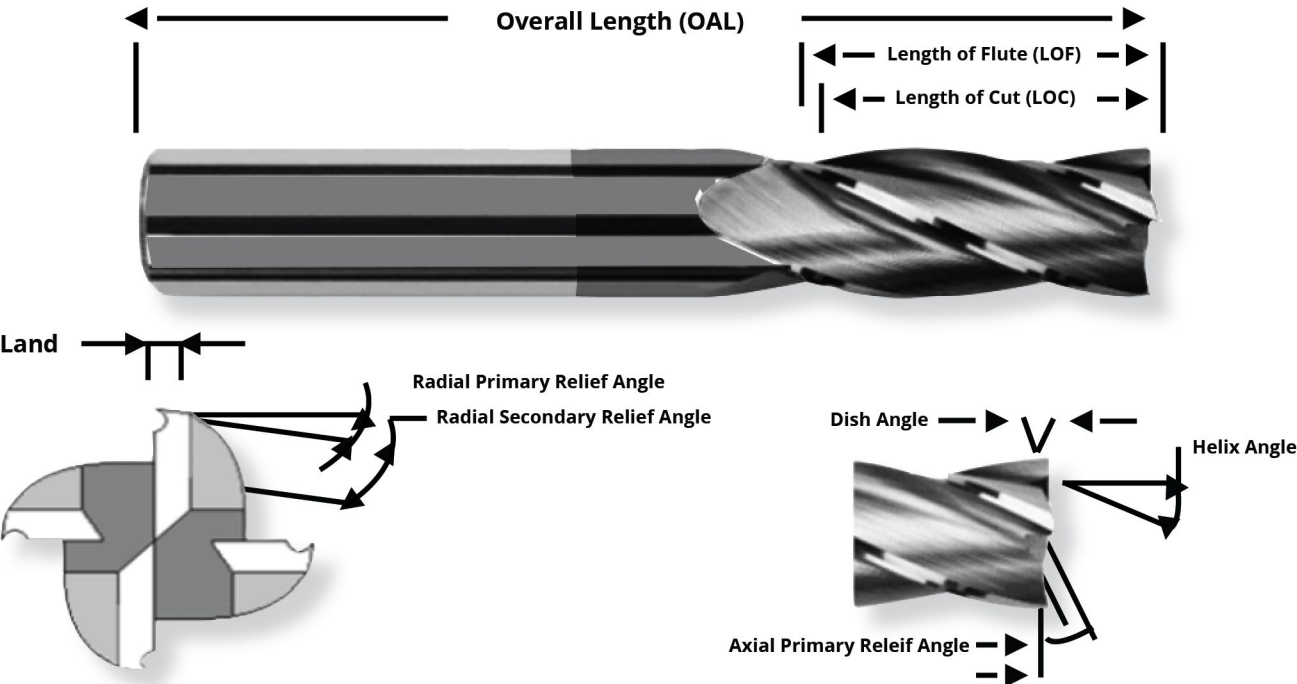


Established in 1994, as the first precision cutting tools in Indonesia,
PT Dharma Precision Tools has earned a prestigious standing.
Quality, efficiency and punctual delivery are our main concern.

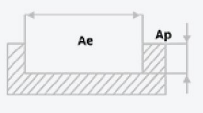
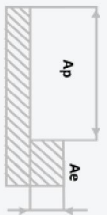
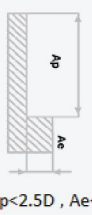
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Basic Info



Recommended Cutting Condition

Work Material Cutting Condition Diameter (D)	Machine Structural Carbon Steel (S45C ~ S55C)		Alloy Tool Steel, Heat-Threated Steel (SKD11,SUS,SCM,CENA)		Heat-Threatment Steel (Ti Alloy)		Heat-Threatment Steel (Ni Based Alloy)		Non Ferrous (Al,Si Alloy)			
	(HRC < 30)		(30~40 HRC)		(~50 HRC)		(~55 HRC)		Standard			
	Rotational Speed (min-1)	Feed /Fz (mm/teeth)	Rotational Speed (min-1)	Feed /Fz (mm/teeth)	Rotational Speed (min-1)	Feed /Fz (mm/teeth)	Rotational Speed (min-1)	Feed /Fz (mm/teeth)	Rotational Speed (min-1)	Feed /Fz (mm/teeth)		
6	6900	0,03	4200	0,03	1400	0,03	1400	0,03	7400	0,03		
8	5200	0,04	3200	0,04	1100	0,04	1100	0,04	5500	0,04		
10	4200	0,05	2500	0,05	900	0,05	900	0,05	4500	0,05		
12	3400	0,06	2100	0,06	550	0,06	550	0,06	3700	0,06		
Coating	TiAlN		TiAlN		TiAlN		Aldura		TiAlN			
Max. Cutting Data	Ap<0.25D  Ap<0.25D Axial Depth of Cut				Ap<0.1D  Ap<0.1D Axial Depth of Cut				Ap=0.5D  Ap=0.5D Axial Depth of Cut			
	Ap<1.0D , Ae<0.05D  Ap<1.0D , Ae<0.05D Radial Depth of Cut				Ap<2.5D , Ae<0.1D  Ap<2.5D , Ae<0.1D							

Cutting Speed $V_c = \frac{\pi \times D \times n}{1,000}$

Spindle Speed $n = V_c \div \pi \div D \times 1,000$

Feed $V_f = n \times f_z \times Z$

Feed per Tooth $f_z = \frac{V_f}{n \times Z}$

V_c = Cutting Speed (m/min)

π = 3.14 [The Circular Constant]

D = Diameter (mm)

n = Spindle Speed (min⁻¹)

V_f = Feed (mm/min)

f_z = Feed per Tooth (mm/tooth)

Z = Number of Flutes

Size STD Cutting tools

DESCRIPTION	PICTURE	CODE (STANDARD)	CODE (HARD MATERIAL)
ENDMILL CARBIDE		EMS6 - 4 F - 60L	EMS6 - 4 F - 60L - H
		EMS6 - 4 F - 80L	EMS6 - 4 F - 80L - H
		EMS8 - 4 F - 60L	EMS8 - 4 F - 60L - H
		EMS8 - 4 F - 80L	EMS8 - 4 F - 80L - H
		EMS8 - 4 F - 100L	EMS8 - 4 F - 100L - H
		EMS10 - 4 F - 75L	EMS10 - 4 F - 75L - H
		EMS10 - 4 F - 100L	EMS10 - 4 F - 100L - H
		EMS12 - 4 F - 75L	EMS12 - 4 F - 75L - H
		EMS12 - 4 F - 100L	EMS12 - 4 F - 100L - H
BALLNOSE CARBIDE		EBR3 - 2 F - 60L	EBR3 - 2 F - 60L - H
		EBR3 - 2 F - 80L	EBR3 - 2 F - 80L - H
		EBR4 - 2 F - 60L	EBR4 - 2 F - 60L - H
		EBR4 - 2 F - 80L	EBR4 - 2 F - 80L - H
		EBR4 - 2 F - 100L	EBR4 - 2 F - 100L - H
		EBR5 - 2 F - 75L	EBR5 - 2 F - 75L - H
		EBR5 - 2 F - 100L	EBR5 - 2 F - 100L - H
		EBR6 - 2 F - 75L	EBR6 - 2 F - 75L - H
		EBR6 - 2 F - 100L	EBR6 - 2 F - 100L - H

FACILITY



CNC Milling 4 Axis



Haimer Tools
Balancer



CMM Brown & Sharp



CNC Grinding



CNC Milling Makino



Tools Master
PWB



CNC Lathe



PT. DHARMA PRECISION TOOLS

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