

DIT

# **DHANANJAY INDUSTRIES & TOOLS**



- **Offering Wide Range of Solid Carbide**
- **Micro Boring Bars,**
- **Rougher Endmill**
- **Finish Endmill**
- **Ball Nose Cutter**
- **Reamer**
- **Step Drill**
- **Form Tools & All Types of Solid Carbide Tools**
- **We are Modify with S. Carbide, HSS & Brazed Tools as per customer Requirement (Special Purpose Tools)**
- **Inserted Tool Holder & Spanner**



# PROFILE

Established in year 2012 & At Pune & Vadodara, Dhananjay Industries & Tools is a well – established firm engaged in manufacturing and Supplying high quality industrial cutting tools, Our product Range Includes Solid carbide endmill, Solid carbide ball nose end mill, Solid carbide reamer, Solid carbide T slot cutter , Solid carbide hall mill, Solide carbide square mill, Solid carbide step drill, Solid carbide burnishing drill, Solid Carbide Micro boring bar & Regrinding etc.

We use High grade Raw material and sophisticated technology for the manufacturing of this products as per the set quality standard. This products are cautiously manufactured using high quality raw material and are acknowledged for their features like durable finish ,high strength, user- friendliness, flawless performance & reliability. The offered collection is extensively used for different applications in various industries. We offer these products to our valuable clients in different models and specifications as per their different requirements.

We are committed toward ensuring premium grade industrial cutting tools. We use High grade raw material, modern machines and advanced technology for the manufacturing process the raw material is procured from some of the trustworthy and licensed vendor of the industry. further, we ensure that the used raw material is carefully examined by our vendors before use in manufacturing process





## MICRO GRAIN HP SOLID CARBIDE DRILLS (STUB SERIES)

More rigid design for improved drill accuracy with 30° helix & 140° point angle with self centering geometry. Suitable for drilling alloyed steel, gray iron, stainless steel etc.



## MICRO GRAIN SOLID CARBIDE JOBBER DRILLS



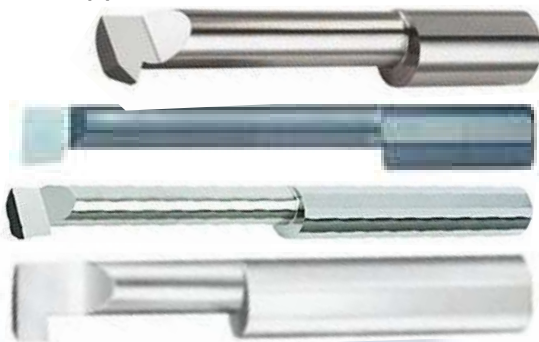
These drills are manufactured with 25° helix angle & 120° point angle for high feed rate & good chip removal. Recommended for drilling cast iron, Aluminium, Plastics & Other easily machined materials.



## MICRO GRAIN HP SOLID CARBIDE MICRO BORINGBARS



These Solid Carbide Micro Boring bar are Suitable for 2mm to 10mm Small Size Boring & Threading Operation. Materials can be used for mass production application.



## MICRO GRAIN HP SOLID CARBIDE INTERNAL COOLANT DRILLS

These drills are suitable where the drilling depth is more ( $L/D \geq 5$ ). These drills are designed for high feed rates & heavy chip removals. Suitable for machining cast iron, stainless steel & alloy steel etc.



## MICRO GRAIN HP SOLID CARBIDE REAMER

These drills are suitable where the drilling depth is more ( $L/D \geq 5$ ). These drills are designed for high feed rates & heavy chip removals. Suitable for machining cast iron, stainless steel & alloy steel etc.



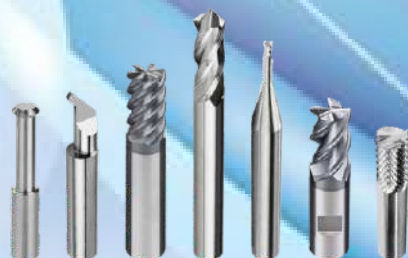


## RECOMMENDED CUTTING PARAMETER FOR SOLID CARBIDE END MILLS

Material	Hardness	Cutting Speed M/Min	Endmill/Feed mm/Revoultion				
			3 to 5	6 to 8	9 to 12	13 to 16	17 to 20
Structural Steel	>70 HRB	40-60	0.02	0.04	0.06	0.08	0.12
Carbon Tool Steel	100-180HRB	25-35	0.01	0.02	0.03	0.05	0.06
	160-200 HRB	20-25	0.01	0.02	0.02	0.03	0.04
Stainless Steel		20-30	0.02	0.03	0.05	0.08	0.10
Cast Iron	160-200 HRB	60-80	0.04	0.08	0.10	0.12	0.16
	>200 HRB	25-40	0.02	0.04	0.06	0.06	0.08
Cast Steel	<50 HRB	40-60	0.04	0.06	0.08	0.10	0.12
	<70 HRB	25-40	0.02	0.04	0.06	0.08	0.10
Copper		80-100	0.04	0.06	0.08	0.12	0.16
Gum Metal, Zinc Bronse, Brass		80-120	0.06	0.08	0.10	0.16	0.20
Aluminium Alloy		150-250	0.08	0.016	0.20	0.28	0.36

## RECOMMENDED CUTTING PARAMETER FOR SOLID CARBIDE DRILLS

Material	Cutting Speed M/Min	Endmill/Feed mm/Revoultion			
		Up to 6	7.0-12.0	13.0-19.0	20.0-25.0
Aluminium	140-300	0.05	0.10	0.15	0.20
Aluminium Alloy	240-300	0.05	0.10	0.15	0.20
Brass	75-100	0.05	0.08	0.10	0.13
Bronze	240-300	0.05	0.08	0.10	0.13
Copper & Its alloy	240-300	0.05	0.08	0.10	0.18
Cast Iron Soft	90-100	0.05	0.10	0.15	0.20
Hard	75-90	0.03	0.05	0.08	0.10
Malleable Iron	60-100	0.05	0.08	0.13	0.20
Plastics	220-300	0.08	0.015	0.25	0.38
Steel Low Carbon	100-180	0.03	0.08	0.13	0.15
Med. Carbon	60-120	0.03	0.08	0.013	0.15
Steel-Nickel	60-75	0.03	0.05	0.08	0.10
-40-45 RC	45-75	0.03	0.03	0.05	0.08
-46 - 50 RC	20-25	0.03	0.03	.0.05	0.08
51 - 55 RC	20-10	0.03	0.03	0.05	0.08
Stainless Steel - Fee Machining	90-120	0.03	0.05	0.10	0.15
Eork Hardening	60-90	0.03	0.03	0.08	0.13
titanium	20-50	0.03	0.05	0.10	0.15





# Special Purpose Carbide, Hss & Braze Tools as Customer Requirement





# Special Modify Inserted Tool Holder as Customer Requirement





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## **DHANANJAY INDUSTRIES & TOOLS**

495/9, GIDC Estate, Makarpura, Vadodara - 390010 (Gujarat)

Tel No. 9427453793, 8200734476, Email Id: [ghananjayindustries.tools@gmail.com](mailto:ghananjayindustries.tools@gmail.com)