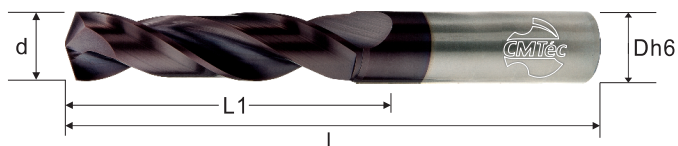


鎢鋼高速鑽頭- 標準型- 2刃(5倍長)

MICRO GRAIN CARBIDE HIGH SPEED DRILL- End mill Shank- Standard- 2F (5 × d)

· **CDHF20000F**



DIN6537

- ★有效加工深度=5倍刃徑
- ★CUTTING EFFECTED LENGTH=5xd

※其它刃徑公差規格依需求生產。
 ※Special Tolerance(φ) is on request.



刃徑 d	溝長 L1	全長 L	柄徑 D	刃數 F	鍍膜訂購編號 coated Order No.
3.0	28.0	66	6	2	CDHF20300F
3.1	28.0	66	6	2	CDHF20310F
3.2	28.0	66	6	2	CDHF20320F
3.3	28.0	66	6	2	CDHF20330F
3.4	28.0	66	6	2	CDHF20340F
3.5	28.0	66	6	2	CDHF20350F
3.6	28.0	66	6	2	CDHF20360F
3.7	28.0	66	6	2	CDHF20370F
3.8	36.0	74	6	2	CDHF20380F
3.9	36.0	74	6	2	CDHF20390F
4.0	36.0	74	6	2	CDHF20400F
4.1	36.0	74	6	2	CDHF20410F
4.2	36.0	74	6	2	CDHF20420F
4.3	36.0	74	6	2	CDHF20430F
4.4	36.0	74	6	2	CDHF20440F
4.5	36.0	74	6	2	CDHF20450F
4.6	36.0	74	6	2	CDHF20460F
4.7	36.0	74	6	2	CDHF20470F
4.8	44.0	82	6	2	CDHF20480F
4.9	44.0	82	6	2	CDHF20490F
5.0	44.0	82	6	2	CDHF20500F
5.1	44.0	82	6	2	CDHF20510F
5.2	44.0	82	6	2	CDHF20520F
5.3	44.0	82	6	2	CDHF20530F
5.4	44.0	82	6	2	CDHF20540F
5.5	44.0	82	6	2	CDHF20550F
5.6	44.0	82	6	2	CDHF20560F
5.7	44.0	82	6	2	CDHF20570F
5.8	44.0	82	6	2	CDHF20580F
5.9	44.0	82	6	2	CDHF20590F
6.0	44.0	82	6	2	CDHF20600F
6.1	53.0	91	8	2	CDHF20610F
6.2	53.0	91	8	2	CDHF20620F
6.3	53.0	91	8	2	CDHF20630F

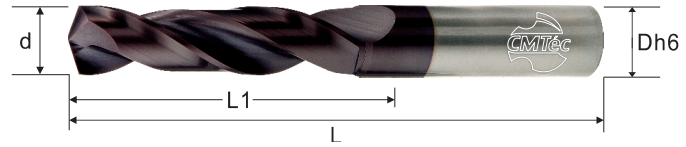
→ 切削條件表 P.253
 Cutting Condition

→ 參考資料 P.214
 Technical Data

鎢鋼高速鑽頭-標準型-2刃(5倍長)

MICRO GRAIN CARBIDE HIGH SPEED DRILL- End mill Shank-Standard- 2F (5×d)

· **CDHF20000F**



DIN6537

- ★有效加工深度=5倍刃徑
- ★CUTTING EFFECTED LENGTH=5xd



- ※其它刃徑公差規格依需求生產。
- ※Special Tolerance(ϕ) is on request.



刃徑 d	溝長 L1	全長 L	柄徑 D	刃數 F	鍍膜訂購編號 Coated Order No.
6.4	53.0	91	8	2	CDHF20640F
6.5	53.0	91	8	2	CDHF20650F
6.6	53.0	91	8	2	CDHF20660F
6.7	53.0	91	8	2	CDHF20670F
6.8	53.0	91	8	2	CDHF20680F
6.9	53.0	91	8	2	CDHF20690F
7.0	53.0	91	8	2	CDHF20700F
7.1	53.0	91	8	2	CDHF20710F
7.2	53.0	91	8	2	CDHF20720F
7.3	53.0	91	8	2	CDHF20730F
7.4	53.0	91	8	2	CDHF20740F
7.5	53.0	91	8	2	CDHF20750F
7.6	53.0	91	8	2	CDHF20760F
7.7	53.0	91	8	2	CDHF20770F
7.8	53.0	91	8	2	CDHF20780F
7.9	53.0	91	8	2	CDHF20790F
8.0	53.0	91	8	2	CDHF20800F
8.1	61.0	103	10	2	CDHF20810F
8.2	61.0	103	10	2	CDHF20820F
8.3	61.0	103	10	2	CDHF20830F
8.4	61.0	103	10	2	CDHF20840F
8.5	61.0	103	10	2	CDHF20850F
8.6	61.0	103	10	2	CDHF20860F
8.7	61.0	103	10	2	CDHF20870F
8.8	61.0	103	10	2	CDHF20880F
8.9	61.0	103	10	2	CDHF20890F
9.0	61.0	103	10	2	CDHF20900F
9.1	61.0	103	10	2	CDHF20910F
9.2	61.0	103	10	2	CDHF20920F
9.3	61.0	103	10	2	CDHF20930F
9.4	61.0	103	10	2	CDHF20940F
9.5	61.0	103	10	2	CDHF20950F
9.6	61.0	103	10	2	CDHF20960F
9.7	61.0	103	10	2	CDHF20970F
9.8	61.0	103	10	2	CDHF20980F
9.9	61.0	103	10	2	CDHF20990F
10.0	61.0	103	10	2	CDHF21000F

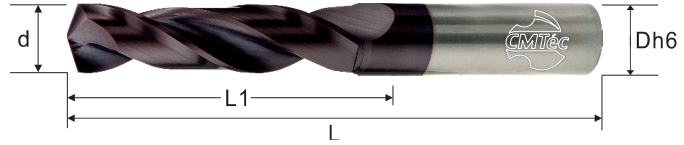
→ 切削條件表 P.253
Cutting Condition

→ 參考資料 P.214
Technical Data

鎢鋼高速鑽頭-標準型-2刃(5倍長)

MICRO GRAIN CARBIDE HIGH SPEED DRILL- End mill Shank- Standard- 2F (5× d)

· **CDHF20000F**



DIN6537

- ★有效加工深度=5倍刃徑
- ★CUTTING EFFECTED LENGTH=5xd

※其它刃徑公差規格依需求生產。
 ※Special Tolerance(φ) is on request.



刃徑 d	溝長 L1	全長 L	柄徑 D	刃數 F	鍍膜訂購編號 Coated Order No.
10.1	71.0	118	12	2	CDHF21010F
10.2	71.0	118	12	2	CDHF21020F
10.3	71.0	118	12	2	CDHF21030F
10.4	71.0	118	12	2	CDHF21040F
10.5	71.0	118	12	2	CDHF21050F
10.6	71.0	118	12	2	CDHF21060F
10.7	71.0	118	12	2	CDHF21070F
10.8	71.0	118	12	2	CDHF21080F
10.9	71.0	118	12	2	CDHF21090F
11.0	71.0	118	12	2	CDHF21100F
11.1	71.0	118	12	2	CDHF21110F
11.2	71.0	118	12	2	CDHF21120F
11.3	71.0	118	12	2	CDHF21130F
11.4	71.0	118	12	2	CDHF21140F
11.5	71.0	118	12	2	CDHF21150F
11.6	71.0	118	12	2	CDHF21160F
11.7	71.0	118	12	2	CDHF21170F
11.8	71.0	118	12	2	CDHF21180F
11.9	71.0	118	12	2	CDHF21190F
12.0	71.0	118	12	2	CDHF21200F
12.5	77.0	124	14	2	CDHF21250F
13.0	77.0	124	14	2	CDHF21300F
13.5	77.0	124	14	2	CDHF21350F
14.0	77.0	124	14	2	CDHF21400F
14.5	83.0	133	16	2	CDHF21450F
15.0	83.0	133	16	2	CDHF21500F
15.5	83.0	133	16	2	CDHF21550F
16.0	83.0	133	16	2	CDHF21600F

Table 52 CDH2-F 鎢鋼高速鑽頭-短刃型-2刃(鍍膜) 切削條件表

SOLID CARBIDE DRILLS-DRILLING CONDITION TABLE

加工材質 WORKING MATERIAL	碳素鋼/合金鋼 CARBON STEEL / ALLOY STEEL		合金鋼/工具鋼 ALLOY STEEL / TOOL STEEL		軟灰鑄鐵 SOFT GREY CAST IRON		硬灰鑄鐵 HARD GREY CAST IRON		不鏽鋼 STAINLESS STEELS	
MATERIAL CODE	(S45C,S50C,SCM)		(SCM,SKT,SKD)		(GG25)		(GG40)		(SUS304)	
HARDNESS GRADE	HRC <20		HRC 20~30		>HB240		>HB300		—	
切削速度 Vc	120M/min		100M/min		200M/min		130M/min		40M/min	
外徑 DIAMETER	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)
3MM	12740	1660	10620	1380	21230	2760	13800	1790	4250	300
4MM	9550	1340	7960	1110	15920	2230	10350	1450	3180	250
5MM	7640	1150	6370	960	12740	1910	8280	1240	2550	230
6MM	6370	1080	5310	900	10620	1810	6900	1170	2120	210
8MM	4780	1000	3980	840	7960	1670	5180	1090	1590	190
10MM	3820	960	3180	800	6370	1590	4140	1040	1270	190
12MM	3180	860	2650	720	5310	1430	3450	930	1060	180
14MM	2730	790	2270	660	4550	1320	2960	860	910	170
16MM	2390	740	1990	620	3980	1230	2590	800	800	170
18MM	2120	700	1770	580	3540	1170	2300	760	710	160
20MM	1910	670	1590	560	3180	1110	2070	720	640	160
備註 Remarks	※未鍍膜鑽頭，請依照上表，減少30%左右轉速和進給量。 ※Uncoated Drills Reduce 30% RPM & FEED From Coating One.									

Table 53 CDHF2-F 鎢鋼高速鑽頭-標準型-2刃(鍍膜) 切削條件表

SOLID CARBIDE DRILLS-DRILLING CONDITION TABLE

加工材質 WORKING MATERIAL	碳素鋼/合金鋼 CARBON STEEL / ALLOY STEEL		合金鋼/工具鋼 ALLOY STEEL / TOOL STEEL		軟灰鑄鐵 SOFT GREY CAST IRON		硬灰鑄鐵 HARD GREY CAST IRON		不鏽鋼 STAINLESS STEELS	
MATERIAL CODE	(S45C,S50C,SCM)		(SCM,SKT,SKD)		(GG25)		(GG40)		(SUS304)	
HARDNESS GRADE	HRC <20		HRC 20~30		>HB240		>HB300		—	
切削速度 Vc	120M/min		100M/min		200M/min		130M/min		40M/min	
外徑 DIAMETER	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)	R.P.M	FEED (mm/min)
3MM	12740	1410	10620	1170	21230	2350	13800	1520	4250	250
4MM	9550	1140	7960	950	15920	1890	10350	1230	3180	220
5MM	7640	970	6370	810	12740	1620	8280	1060	2550	200
6MM	6370	920	5310	770	10620	1530	6900	1000	2120	180
8MM	4780	850	3980	710	7960	1420	5180	920	1590	160
10MM	3820	810	3180	680	6370	1350	4140	880	1270	160
12MM	3180	730	2650	610	5310	1220	3450	790	1060	150
14MM	2730	670	2270	560	4550	1120	2960	730	910	150
16MM	2390	630	1990	520	3980	1050	2590	680	800	140
18MM	2120	590	1770	500	3540	990	2300	650	710	140
20MM	1910	570	1590	470	3180	950	2070	620	640	140
備註 Remarks	※未鍍膜鑽頭，請依照上表，減少30%左右轉速和進給量。 ※Uncoated Drills Reduce 30% RPM & FEED From Coating One.									

以上數據為建議值，適當的條件仍需視機台狀況，夾治具品質，潤滑冷卻系統...等而改變。

These are recommended values which depend on the condition of the machine, fixture, lubricating & cooling systems... etc. They may have to be adapted.