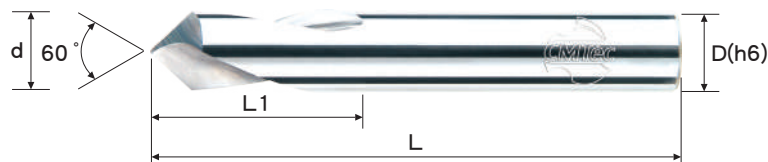


鎢鋼定點鑽60° - 標準型- 2刃

MICRO GRAIN CARBIDE SPOTTING DRILLS 60° - 2F

· CDP000060



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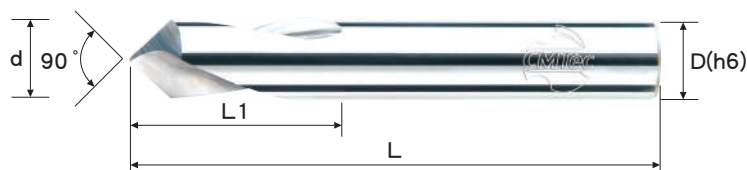


刃徑 d	溝長 L1	全長 L	柄徑 D	60° 白刀訂購編號 Uncoated Order No.	60° 鍍膜訂購編號 Coated Order No.
3.0	10	40	3	CDP030060	CDP030060A
4.0	12	50	4	CDP040060	CDP040060A
5.0	15	50	5	CDP050060	CDP050060A
6.0	20	50	6	CDP060060	CDP060060A
8.0	25	60	8	CDP080060	CDP080060A
10.0	25	75	10	CDP100060	CDP100060A
12.0	30	75	12	CDP120060	CDP120060A

鎢鋼定點鑽90° - 標準型- 2刃

MICRO GRAIN CARBIDE SPOTTING DRILLS 90° - 2F

· CDP000090



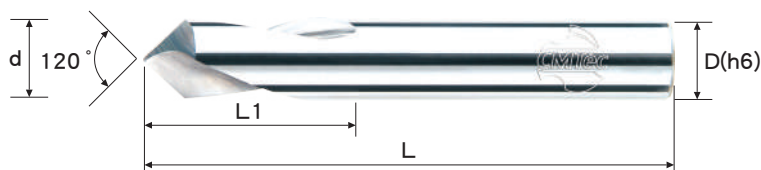
49

刃徑 d	溝長 L1	全長 L	柄徑 D	90° 白刀訂購編號 Uncoated Order No.	90° 鍍膜訂購編號 Coated Order No.
3.0	10	40	3	CDP030090	CDP030090A
4.0	12	50	4	CDP040090	CDP040090A
5.0	15	50	5	CDP050090	CDP050090A
6.0	20	50	6	CDP060090	CDP060090A
8.0	25	60	8	CDP080090	CDP080090A
10.0	25	75	10	CDP100090	CDP100090A
12.0	30	75	12	CDP120090	CDP120090A
16.0	35	100	16	CDP160090	CDP160090A

鎢鋼定點鑽120° - 標準型- 2刃

MICRO GRAIN CARBIDE SPOTTING DRILLS 120° - 2F

· CDP0000C0



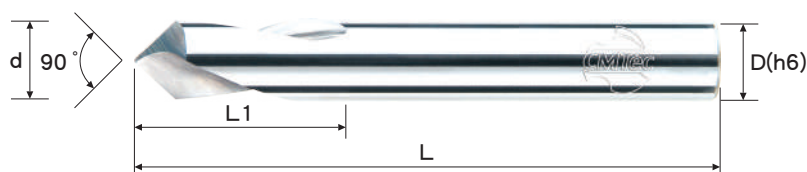
49

刃徑 d	溝長 L1	全長 L	柄徑 D	120° 白刀訂購編號 Uncoated Order No.	120° 鍍膜訂購編號 Coated Order No.
3.0	10	40	3	CDP0300C0	CDP0300C0A
4.0	12	50	4	CDP0400C0	CDP0400C0A
5.0	15	50	5	CDP0500C0	CDP0500C0A
6.0	20	50	6	CDP0600C0	CDP0600C0A
8.0	25	60	8	CDP0800C0	CDP0800C0A
10.0	25	75	10	CDP1000C0	CDP1000C0A
12.0	30	75	12	CDP1200C0	CDP1200C0A
16.0	35	100	16	CDP1600C0	CDP1600C0A

鎢鋼定點鑽90° - 長柄型- 2刃

MICRO GRAIN CARBIDE SPOTTING DRILLS 90° - Long Shank- 2F

· CDPL000090



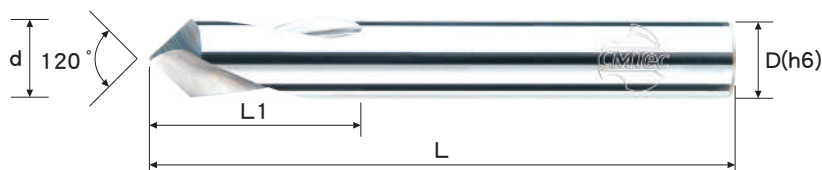
49

刃徑 d	溝長 L1	全長 L	柄徑 D	90° 白刀訂購編號 Uncoated Order No.	90° 鍍膜訂購編號 Coated Order No.
4.0	15	75	4	CDPL040090	CDPL040090A
5.0	15	75	5	CDPL050090	CDPL050090A
6.0	20	100	6	CDPL060090	CDPL060090A
8.0	25	125	8	CDPL080090	CDPL080090A
10.0	25	150	10	CDPL100090	CDPL100090A
12.0	30	150	12	CDPL120090	CDPL120090A
16.0	35	150	16	CDPL160090	CDPL160090A

鎢鋼定點鑽120° - 長柄型- 2刃

MICRO GRAIN CARBIDE SPOTTING DRILLS 120° - Long Shank- 2F

· **CDPL0000C0**



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刃徑 d	溝長 L1	全長 L	柄徑 D	120° 白刀訂購編號 Uncoated Order No.	120° 鍍膜訂購編號 Coated Order No.
4.0	15	75	4	CDPL0400C0	CDPL0400C0A
5.0	15	75	5	CDPL0500C0	CDPL0500C0A
6.0	20	100	6	CDPL0600C0	CDPL0600C0A
8.0	25	125	8	CDPL0800C0	CDPL0800C0A
10.0	25	150	10	CDPL1000C0	CDPL1000C0A
12.0	30	150	12	CDPL1200C0	CDPL1200C0A
16.0	35	150	16	CDPL1600C0	CDPL1600C0A

→ 切削條件表
Cutting Condition **P.559**

→ 技術資料
Technical Data **P.630**

Table 49

鎢鋼定點鑽頭- 2刃(白刀) 切削條件表

SOLID CARBIDE DRILLS- DRILLING CONDITION TABLE

加工材質 Material	碳素鋼 Carbon Steels		合金鋼 Alloy Steels		不銹鋼 Stainless Steels		鑄鐵 Cast Iron		高溫合金 High-Temp Alloys	
工件料號 Material Code	S35C,S45C,S50C		SCM,SKT,SKD		SUS304		FC,FCD		Ti-6Al-4V	
硬度 Hardness	HRC<20		HRC20~30		—		HRC<30		HRC<30	
切削速度 Vc	48m/min		40m/min		28m/min		40m/min		24m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
4mm	3,820	310	3,180	220	2,230	160	3,180	220	1,910	110
5mm	3,060	240	2,550	180	1,780	120	2,550	180	1,530	90
6mm	2,550	200	2,120	150	1,490	100	2,120	150	1,270	80
8mm	1,910	210	1,590	140	1,110	100	1,590	140	960	80
10mm	1,530	240	1,270	170	890	120	1,270	170	760	80
12mm	1,270	360	1,060	220	740	160	1,060	220	640	130
16mm	960	310	800	190	560	130	800	190	480	120
備註 Remarks										

※ 切削公式 Cutting Formula : $S(\text{主軸轉速}) = Vc(\text{切削速度}) \times 1000 / D(\text{外徑}) / \pi (3.14)$ $F(\text{進給速度}) = f(\text{每轉進給量}) \times S(\text{主軸轉速})$

Table 50

CDM 鎢鋼微徑鑽頭- 2刃(鍍膜) 切削條件表

SOLID CARBIDE DRILLS- DRILLING CONDITION TABLE

加工材質 Material	碳素鋼 Carbon Steels		合金鋼 Alloy Steels		不銹鋼 Stainless Steels		鑄鐵 Cast Iron	
工件料號 Material Code	S35C,S45C,S50C		SCM,SKT,SKD		SUS304		FC,FCD	
硬度 Hardness	HRC<20		HRC20~30		—		HRC<30	
切削速度 Vc	60m/min		40m/min		20m/min		50m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
0.50mm	38,220	630	25,480	400	12,740	70	31,850	550
0.95mm	20,110	700	13,410	450	6,710	80	16,760	610
1.00mm	19,110	630	12,740	380	6,370	70	15,920	550
1.45mm	13,180	670	8,790	450	4,390	60	10,980	610
1.50mm	12,740	640	8,490	400	4,250	70	10,620	550
1.95mm	9,800	700	6,530	450	3,270	80	8,170	620
2.00mm	9,550	640	6,370	380	3,190	70	7,960	560
2.45mm	7,800	700	5,200	440	2,600	80	6,500	510
2.50mm	7,640	630	5,100	410	2,550	70	6,370	540
2.95mm	6,480	700	4,320	450	2,160	80	5,400	610
備註 Remarks								

※ 切削公式 Cutting Formula : $S(\text{主軸轉速}) = Vc(\text{切削速度}) \times 1000 / D(\text{外徑}) / \pi (3.14)$ $F(\text{進給速度}) = f(\text{每轉進給量}) \times S(\text{主軸轉速})$

1. 當加工聲音尖銳時，請調降主軸轉速(S) (10~40%)。When the sound is piercing, please lower the spindle speed(S) (10~40%).
2. 當機台震動太大時，請調降進給速度(F) (10~40%)。When the machine is vibrating, please decrease the feed rate(F) (10~40%).
3. 當主軸負載太大時，請調降進給速度(F) (10~40%)。When the spindle load is high, please decrease the feed rate(F) (10~40%).
4. 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.