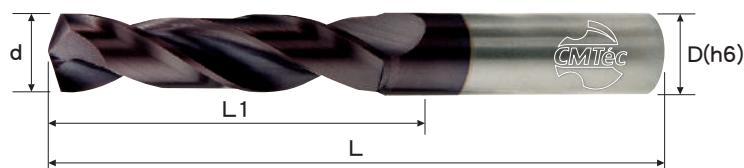


鎢鋼高速鑽頭- 標準型- 2刃(5倍長)

CARBIDE HIGH SPEED DRILLS- End Mill Shank- Standard- 2F(5×d)

· CDHF20000F



規格DIN6537

※ 有效加工深度 = 5倍刃徑。
Cutting effective length = 5xd

※ 其他刃徑公差規格依需求生產。
Special tolerance(ϕ) is on request.

刃徑 d	公差 Tolerance
ϕ	h7



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	66	6	2	CDHF20300F
3.1	28	66	6	2	CDHF20310F
3.2	28	66	6	2	CDHF20320F
3.3	28	66	6	2	CDHF20330F
3.4	28	66	6	2	CDHF20340F
3.5	28	66	6	2	CDHF20350F
3.6	28	66	6	2	CDHF20360F
3.7	28	66	6	2	CDHF20370F
3.8	36	74	6	2	CDHF20380F
3.9	36	74	6	2	CDHF20390F
4.0	36	74	6	2	CDHF20400F
4.1	36	74	6	2	CDHF20410F
4.2	36	74	6	2	CDHF20420F
4.3	36	74	6	2	CDHF20430F
4.4	36	74	6	2	CDHF20440F
4.5	36	74	6	2	CDHF20450F
4.6	36	74	6	2	CDHF20460F
4.7	36	74	6	2	CDHF20470F
4.8	44	82	6	2	CDHF20480F
4.9	44	82	6	2	CDHF20490F
5.0	44	82	6	2	CDHF20500F
5.1	44	82	6	2	CDHF20510F
5.2	44	82	6	2	CDHF20520F
5.3	44	82	6	2	CDHF20530F
5.4	44	82	6	2	CDHF20540F
5.5	44	82	6	2	CDHF20550F
5.6	44	82	6	2	CDHF20560F
5.7	44	82	6	2	CDHF20570F
5.8	44	82	6	2	CDHF20580F
5.9	44	82	6	2	CDHF20590F
6.0	44	82	6	2	CDHF20600F
6.1	53	91	8	2	CDHF20610F
6.2	53	91	8	2	CDHF20620F
6.3	53	91	8	2	CDHF20630F

→ 切削條件表
Cutting Condition

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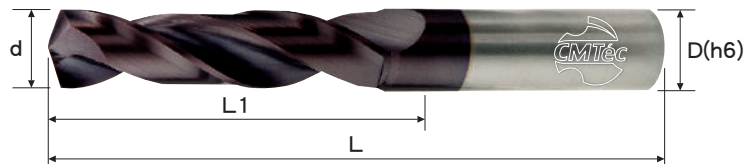
→ 技術資料
Technical Data

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鎢鋼高速鑽頭- 標準型- 2刃(5倍長)

CARBIDE HIGH SPEED DRILLS- End Mill Shank- Standard- 2F(5×d)

· CDHF20000F



規格DIN6537

※ 有效加工深度 = 5倍刃徑。
Cutting effective length = 5xd

※ 其他刃徑公差規格依需求生產。
Special tolerance(φ) is on request.

刃徑 d	公差 Tolerance
φ	h7



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	91	8	2	CDHF20640F
6.5	53	91	8	2	CDHF20650F
6.6	53	91	8	2	CDHF20660F
6.7	53	91	8	2	CDHF20670F
6.8	53	91	8	2	CDHF20680F
6.9	53	91	8	2	CDHF20690F
7.0	53	91	8	2	CDHF20700F
7.1	53	91	8	2	CDHF20710F
7.2	53	91	8	2	CDHF20720F
7.3	53	91	8	2	CDHF20730F
7.4	53	91	8	2	CDHF20740F
7.5	53	91	8	2	CDHF20750F
7.6	53	91	8	2	CDHF20760F
7.7	53	91	8	2	CDHF20770F
7.8	53	91	8	2	CDHF20780F
7.9	53	91	8	2	CDHF20790F
8.0	53	91	8	2	CDHF20800F
8.1	61	103	10	2	CDHF20810F
8.2	61	103	10	2	CDHF20820F
8.3	61	103	10	2	CDHF20830F
8.4	61	103	10	2	CDHF20840F
8.5	61	103	10	2	CDHF20850F
8.6	61	103	10	2	CDHF20860F
8.7	61	103	10	2	CDHF20870F
8.8	61	103	10	2	CDHF20880F
8.9	61	103	10	2	CDHF20890F
9.0	61	103	10	2	CDHF20900F
9.1	61	103	10	2	CDHF20910F
9.2	61	103	10	2	CDHF20920F
9.3	61	103	10	2	CDHF20930F
9.4	61	103	10	2	CDHF20940F
9.5	61	103	10	2	CDHF20950F
9.6	61	103	10	2	CDHF20960F
9.7	61	103	10	2	CDHF20970F
9.8	61	103	10	2	CDHF20980F
9.9	61	103	10	2	CDHF20990F
10.0	61	103	10	2	CDHF21000F

→ 切削條件表
Cutting Condition

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→ 技術資料
Technical Data

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CARBIDE HIGH SPEED DRILLS- End Mill Shank- Standard- 2F(5×d)

Technical drawing of a double-flute drill bit. The drawing shows the bit's profile with the following dimensions labeled:

- d : Diameter of the drill bit.
- L_1 : Length of the cutting edge.
- L : Total length of the drill bit.
- $D(h6)$: Diameter of the shank, indicating a tolerance of h6.

The brand logo "CMTEC" is visible on the shank.

刃徑 d	公差 Tolerance
Φ	h7



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→ 切削條件表 P.561
Cutting Condition

➡ 技術資料
Technical Data

Table 52

CDH 鎢鋼短刃型高速鑽頭- 2刃(3倍長)(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		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		SCM,SKT,SKD		SUS304		FC,FCD	
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		—		HRC<30	
切削速度 Vc	120m/min		100m/min		60m/min		40m/min		130m/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)
3mm	12,740	1,040	10,620	770	6,370	510	4,250	290	13,800	1,080
4mm	9,550	1,040	7,960	770	4,780	510	3,180	290	10,350	1,080
5mm	7,640	780	6,370	590	3,820	380	2,550	220	8,280	810
6mm	6,370	780	5,310	590	3,190	350	2,120	220	6,900	810
8mm	4,780	720	3,980	540	2,390	350	1,590	200	5,180	760
10mm	3,820	640	3,180	490	1,910	320	1,270	180	4,140	680
12mm	3,180	600	2,650	430	1,590	290	1,060	160	3,450	610
14mm	2,730	600	2,270	430	1,370	290	910	160	2,960	610
16mm	2,390	490	1,990	380	1,190	260	800	140	2,590	530
18mm	2,120	490	1,770	380	1,060	260	710	140	2,300	530
20mm	1,910	390	1,590	300	960	210	640	110	2,070	420
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.									

※ 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 53

CDHF 鎢鋼標準型高速鑽頭- 2刃(5倍長)(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		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		SCM,SKT,SKD		SUS304		GG40	
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		—		HRC<30	
切削速度 Vc	120m/min		100m/min		60m/min		40m/min		130m/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)
3mm	12,740	930	10,620	690	6,370	470	4,250	260	13,800	970
4mm	9,550	930	7,960	690	4,780	470	3,180	260	10,350	970
5mm	7,640	700	6,370	520	3,820	350	2,550	200	8,280	730
6mm	6,370	700	5,310	520	3,190	350	2,120	200	6,900	730
8mm	4,780	660	3,980	490	2,390	320	1,590	180	5,180	680
10mm	3,820	580	3,180	430	1,910	280	1,270	160	4,140	610
12mm	3,180	530	2,650	390	1,590	270	1,060	150	3,450	550
14mm	2,730	530	2,270	390	1,370	270	910	150	2,960	550
16mm	2,390	450	1,990	350	1,190	240	800	130	2,590	470
18mm	2,120	450	1,770	350	1,060	240	710	130	2,300	470
20mm	1,910	360	1,590	280	960	190	640	100	2,070	380
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.									

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

- 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%).
- 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%).
- 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%).
- 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.