

鎢鋼高速內冷鑽頭- 短刃型- 2刃(3倍長)

CARBIDE HIGH SPEED DRILLS- End Mill Shank- Coolant Hole- Short Flute- 2F(3×d)

· CDHC20000F

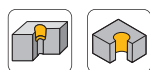


規格DIN6537

※ 有效加工深度 = 3倍刃徑。
Cutting effective length = 3xd

※ 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.
4.0	24	66	6	2	CDHC20400F
4.5	24	66	6	2	CDHC20450F
5.0	28	66	6	2	CDHC20500F
5.5	28	66	6	2	CDHC20550F
6.0	28	66	6	2	CDHC20600F
6.5	34	79	8	2	CDHC20650F
7.0	34	79	8	2	CDHC20700F
7.5	41	79	8	2	CDHC20750F
8.0	41	79	8	2	CDHC20800F
8.5	47	89	10	2	CDHC20850F
9.0	47	89	10	2	CDHC20900F
9.5	47	89	10	2	CDHC20950F
10.0	47	89	10	2	CDHC21000F
10.5	55	102	12	2	CDHC21050F
11.0	55	102	12	2	CDHC21100F
11.5	55	102	12	2	CDHC21150F
12.0	55	102	12	2	CDHC21200F
12.5	60	107	14	2	CDHC21250F
13.0	60	107	14	2	CDHC21300F
13.5	60	107	14	2	CDHC21350F
14.0	60	107	14	2	CDHC21400F
14.5	65	115	16	2	CDHC21450F
15.0	65	115	16	2	CDHC21500F
15.5	65	115	16	2	CDHC21550F
16.0	65	115	16	2	CDHC21600F
16.5	73	123	18	2	CDHC21650F
17.0	73	123	18	2	CDHC21700F
17.5	73	123	18	2	CDHC21750F
18.0	73	123	18	2	CDHC21800F
18.5	79	131	20	2	CDHC21850F
19.0	79	131	20	2	CDHC21900F
19.5	79	131	20	2	CDHC21950F
20.0	79	131	20	2	CDHC22000F

→ 切削條件表 P.562 Cutting Condition
→ 技術資料 P.630 Technical Data

Table 54

CDHC 鎢鋼短刃內冷型高速鑽頭- 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	150m/min		135m/min		70m/min		60m/min		160m/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	11,940	1,130	10,750	860	5,570	570	4,780	320	12,740	1,180
5mm	9,550	860	8,600	640	4,460	430	3,820	240	10,190	890
6mm	7,960	860	7,170	640	3,720	430	3,180	240	8,490	890
8mm	5,970	790	5,370	590	2,790	400	2,390	220	6,370	830
10mm	4,780	710	4,300	530	2,230	360	1,910	200	5,100	740
12mm	3,980	660	3,580	490	1,860	330	1,590	180	4,250	740
14mm	3,410	660	3,070	490	1,590	330	1,360	180	3,640	660
16mm	2,990	560	2,690	420	1,390	280	1,190	160	3,180	570
18mm	2,650	560	2,390	420	1,240	280	1,060	160	2,830	570
20mm	2,390	450	2,150	340	1,120	220	960	130	2,550	460
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(主軸轉速) = Vc(切削速度) × 1000 / D(外徑) / π (3.14) F(進給速度) = f(每轉進給量) × S(主軸轉速)

Table 55

CDHCF 鎢鋼標準內冷型高速鑽頭- 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		FC,FCD	
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		—		HRC<30	
切削速度 Vc	150m/min		135m/min		70m/min		60m/min		160m/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	11,940	1,020	10,750	770	5,570	510	4,780	280	12,740	1,060
5mm	9,550	770	8,600	570	4,460	380	3,820	210	10,190	800
6mm	7,960	770	7,170	570	3,720	380	3,180	210	8,490	800
8mm	5,970	720	5,370	540	2,790	350	2,390	200	6,370	740
10mm	4,780	640	4,300	490	2,230	320	1,910	180	5,100	660
12mm	3,980	570	3,580	430	1,860	290	1,590	160	4,250	610
14mm	3,410	570	3,070	430	1,590	290	1,360	160	3,640	610
16mm	2,990	490	2,690	380	1,390	260	1,190	140	3,180	530
18mm	2,650	490	2,390	380	1,240	260	1,060	140	2,830	530
20mm	2,390	390	2,150	300	1,120	210	960	110	2,550	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(主軸轉速) = Vc(切削速度) × 1000 / D(外徑) / π (3.14) F(進給速度) = f(每轉進給量) × S(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.