



通用型钻头

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Solid Carbide Tools



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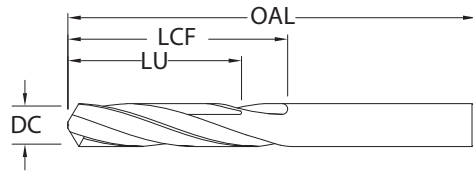
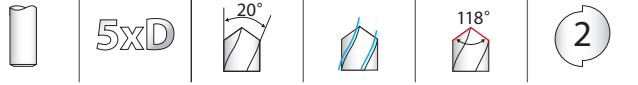
通用型钻头	系列	描述	页
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短型自定心钻头 (DIN6539)	108M Plus	2刃短柄DIN 6539	229
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通用型中心钻	系列	描述	页
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通用型铰刀	系列	描述	页
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刀具推荐转速和进给参见每个刀具系列后的列表

2刃钻头 • 公制: DIN 338



101
英制 & 公制系列

图示:
101系列钻头组合



刃径 DC	英制值	公制值	全长 OAL	槽长 LCF	刃长 LU	EDP订货号	
						无涂层	Ti-NAMITE-A (AITIN)
#80	0.0135	0.34	3/4	3/16	—	51080	57076
#79	0.0145	0.37	3/4	3/16	—	51079	57077
1/64	0.0156	0.40	3/4	3/16	—	51101	57078
#78	0.0160	0.41	3/4	3/16	—	51078	57079
#77	0.0180	0.46	3/4	3/16	—	51077	57080
#76	0.0200	0.51	7/8	1/4	—	51076	57081
#75	0.0210	0.53	7/8	1/4	—	51075	57082
#74	0.0225	0.57	7/8	1/4	—	51074	57083
#73	0.0240	0.61	7/8	1/4	—	51073	57084
#72	0.0250	0.64	1	5/16	—	51072	57085
#71	0.0260	0.66	1	5/16	—	51071	57086
0,7 mm	0.0276		28,0	9,0	—	61001	68268
#70	0.0280	0.71	1-1/4	1/2	—	51070	57087
#69	0.0292	0.74	1-1/4	1/2	—	51069	57088
#68	0.0310	0.79	1-1/4	1/2	—	51068	57089
1/32	0.0312	0.79	1-1/4	1/2	—	51102	57090
0,8 mm	0.0315		30,0	10,0	—	61003	68269
#67	0.0320	0.81	1-1/4	1/2	—	51067	57091
#66	0.0330	0.84	1-1/4	1/2	—	51066	57092
#65	0.0350	0.89	1-3/8	5/8	1/2	51065	57093
0,9 mm	0.0354		32,0	11,0	8,0	61005	68270
#64	0.0360	0.91	1-3/8	5/8	1/2	51064	57094
#63	0.0370	0.94	1-3/8	5/8	1/2	51063	57095
#62	0.0380	0.97	1-3/8	5/8	1/2	51062	57096
#61	0.0390	0.99	1-3/8	5/8	1/2	51061	57097
1,0 mm	0.0394		34,0	12,0	9,0	61007	68271
#60	0.0400	1.02	1-1/2	3/4	39/64	51060	57098
#59	0.0410	1.04	1-1/2	3/4	39/64	51059	57099
#58	0.0420	1.07	1-1/2	3/4	39/64	51058	57100
#57	0.0430	1.09	1-1/2	3/4	39/64	51057	57101
1,1 mm	0.0433		36,0	14,0	11,0	61052	68294
#56	0.0465	1.18	1-1/2	3/4	39/64	51056	57102
3/64	0.0469	1.19	1-1/2	3/4	39/64	51103	57103
1,2 mm	0.0472		38,0	16,0	12,0	61053	68295
1,3 mm	0.0512		38,0	16,0	12,0	61054	68296
#55	0.0520	1.32	1-1/2	3/4	39/64	51055	57104
#54	0.0550	1.40	1-1/2	3/4	39/64	51054	57105
1,4 mm	0.0551		40,0	18,0	14,0	61055	68297
1,5 mm	0.0591		40,0	18,0	14,0	61009	68272
#53	0.0595	1.51	1-1/2	3/4	39/64	51053	57106
*1/16	0.0625	1.59	1-1/2	3/4	39/64	51104	57107
1,6 mm	0.0630		43,0	20,0	16,0	61056	68298
#52	0.0635	1.61	1-1/2	3/4	39/64	51052	57108
1,7 mm	0.0669		43,0	20,0	17,0	61057	68299
#51	0.0670	1.70	1-1/2	3/4	39/64	51051	57109
#50	0.0700	1.78	1-3/4	7/8	45/64	51050	57110

公差 (inch)
DC = +0.0000/-0.0005

公差 (mm)
DC = +0.0000/-0.0127

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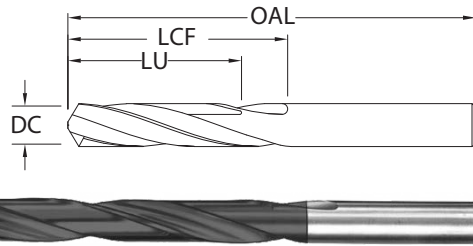
英制 & 公制系列

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刃径 DC	英制值	公制值	全长 OAL	槽长 LCF	刃长 LU	EDP订货号	
						无涂层	Ti-NAMITE-A (AlTiN)
1,8 mm	0.0709		46,0	22,0	17,0	61058	68300
#49	0.0730	1.85	1-3/4	7/8	45/64	51049	57111
1,9 mm	0.0748		46,0	22,0	17,0	61059	68301
#48	0.0760	1.93	1-3/4	7/8	45/64	51048	57112
5/64	0.0781	1.98	1-3/4	7/8	45/64	51105	57113
#47	0.0785	1.99	1-3/4	7/8	45/64	51047	57114
2,0 mm	0.0787		49,0	24,0	19,0	61011	68273
#46	0.0810	2.06	1-3/4	7/8	45/64	51046	57115
#45	0.0820	2.08	1-3/4	7/8	45/64	51045	57116
2,1 mm	0.0827		49,0	24,0	19,0	61060	68302
#44	0.0860	2.18	2	1	51/64	51044	57117
2,2 mm	0.0866		53,0	27,0	21,0	61061	68303
#43	0.0890	2.26	2	1	51/64	51043	57118
2,3 mm	0.0906		53,0	27,0	21,0	61062	68304
#42	0.0935	2.37	2	1	51/64	51042	57119
3/32	0.0938	2.38	2	1	51/64	51106	57120
2,4 mm	0.0945		57,0	30,0	24,0	61063	68305
#41	0.0960	2.44	2	1	51/64	51041	57121
#40	0.0980	2.49	2	1	51/64	51040	57122
2,5 mm	0.0984		57,0	30,0	24,0	61013	68274
#39	0.0995	2.53	2-1/4	1-1/4	1	51039	57123
#38	0.1015	2.58	2-1/4	1-1/4	1	51038	57124
2,6 mm	0.1024		57,0	30,0	24,0	61064	68306
#37	0.1040	2.64	2-1/4	1-1/4	1	51037	57125
2,7 mm	0.1063		61,0	33,0	26,0	61065	68307
#36	0.1065	2.71	2-1/4	1-1/4	1	51036	57126
7/64	0.1094	2.78	2-1/4	1-1/4	1	51107	57127
#35	0.1100	2.79	2-1/4	1-1/4	1	51035	57128
2,8 mm	0.1102		61,0	33,0	26,0	61066	68308
#34	0.1110	2.82	2-1/4	1-1/4	1	51034	57129
#33	0.1130	2.87	2-1/4	1-1/4	1	51033	57130
2,9 mm	0.1142		61,0	33,0	26,0	61067	68309
#32	0.1160	2.95	2-1/4	1-1/4	1	51032	57131
3,0 mm	0.1181		61,0	33,0	26,0	61015	68275
#31	0.1200	3.05	2-1/4	1-1/4	1	51031	57132
3,1 mm	0.1220		65,0	36,0	28,0	61068	68310
*1/8	0.1250	3.18	2-1/4	1-1/4	1	51108	57133
3,2 mm	0.1260		65,0	36,0	28,0	61069	68311
#30	0.1285	3.26	2-1/4	1-1/4	1	51030	57134
3,3 mm	0.1299		65,0	36,0	28,0	61070	68312
3,4 mm	0.1339		70,0	39,0	31,0	61071	68313
#29	0.1360	3.45	2-1/2	1-3/8	1-7/64	51029	57135
3,5 mm	0.1378		70,0	39,0	31,0	61017	68276
#28	0.1405	3.57	2-1/2	1-3/8	1-7/64	51028	57136
9/64	0.1406	3.57	2-1/2	1-3/8	1-7/64	51109	57137
3,6 mm	0.1417		70,0	39,0	31,0	61072	68314
#27	0.1440	3.66	2-1/2	1-3/8	1-7/64	51027	57138
3,7 mm	0.1457		70,0	39,0	31,0	61073	68315
#26	0.1470	3.73	2-1/2	1-3/8	1-7/64	51026	57139
#25	0.1495	3.80	2-1/2	1-3/8	1-7/64	51025	57140
3,8 mm	0.1496		75,0	43,0	34,0	61074	68316
#24	0.1520	3.86	2-1/2	1-3/8	1-7/64	51024	57141
3,9 mm	0.1535		75,0	43,0	34,0	61075	68317
#23	0.1540	3.91	2-1/2	1-3/8	1-7/64	51023	57142
5/32	0.1562	3.97	2-1/2	1-3/8	1-7/64	51110	57143
#22	0.1570	3.99	2-1/2	1-3/8	1-7/64	51022	57144

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2刃钻头 • 公制: DIN 338



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图示:
101系列钻头组合



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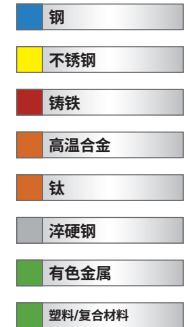
刃径 DC	英制值	公制值	全长 OAL	槽长 LCF	刃长 LU	EDP订货号	
						无涂层	Ti-NAMITE-A (AITIN)
4,0 mm	0.1575		75,0	43,0	34,0	61019	68277
#21	0.1590	4.04	2-1/2	1-3/8	1-7/64	51021	57145
#20	0.1610	4.09	2-1/2	1-3/8	1-7/64	51020	57146
4,1 mm	0.1614		75,0	43,0	34,0	61076	68318
4,2 mm	0.1654		75,0	43,0	34,0	61077	68319
#19	0.1660	4.22	2-1/2	1-5/8	1-19/64	51019	57147
4,3 mm	0.1693		80,0	47,0	37,0	61078	68320
#18	0.1695	4.31	2-3/4	1-5/8	1-19/64	51018	57148
11/64	0.1719	4.37	2-3/4	1-5/8	1-19/64	51111	57149
#17	0.1730	4.39	2-3/4	1-5/8	1-19/64	51017	57150
4,4 mm	0.1732		80,0	47,0	37,0	61079	68321
#16	0.1770	4.50	2-3/4	1-5/8	1-19/64	51016	57151
4,5 mm	0.1772		80,0	47,0	37,0	61021	68278
#15	0.1800	4.57	2-3/4	1-5/8	1-19/64	51015	57152
4,6 mm	0.1811		80,0	47,0	37,0	61080	68322
#14	0.1820	4.62	2-3/4	1-5/8	1-19/64	51014	57153
4,7 mm	0.1850		80,0	47,0	37,0	61081	68323
#13	0.1850	4.70	2-3/4	1-5/8	1-19/64	51013	57154
*3/16	0.1875	4.76	2-3/4	1-5/8	1-19/64	51112	57155
4,8 mm	0.1890		86,0	52,0	41,0	61082	68324
#12	0.1890	4.80	2-3/4	1-5/8	1-19/64	51012	57156
#11	0.1910	4.85	2-3/4	1-5/8	1-19/64	51011	57157
4,9 mm	0.1929		86,0	52,0	41,0	61083	68325
#10	0.1935	4.91	2-3/4	1-5/8	1-19/64	51010	57158
#9	0.1960	4.98	3	1-3/4	1-13/32	51009	57159
5,0 mm	0.1969		86,0	52,0	41,0	61023	68279
#8	0.1990	5.05	3	1-3/4	1-13/32	51008	57160
5,1 mm	0.2008		86,0	52,0	41,0	61084	68326
#7	0.2010	5.11	3	1-3/4	1-13/32	51007	57161
13/64	0.2031	5.16	3	1-3/4	1-13/32	51113	57162
#6	0.2040	5.18	3	1-3/4	1-13/32	51006	57163
5,2 mm	0.2047		86,0	52,0	41,0	61085	68327
#5	0.2055	5.22	3	1-3/4	1-13/32	51005	57164
5,3 mm	0.2087		86,0	52,0	41,0	61086	68328
#4	0.2090	5.31	3	1-3/4	1-13/32	51004	57165
5,4 mm	0.2126		93,0	57,0	45,0	61087	68329
#3	0.2130	5.41	3	1-3/4	1-13/32	51003	57166
5,5 mm	0.2165		93,0	57,0	45,0	61025	68280
7/32	0.2188	5.56	3	1-3/4	1-13/32	51114	57167
5,6 mm	0.2205		93,0	57,0	45,0	61088	68330
#2	0.2210	5.61	3	1-3/4	1-13/32	51002	57168
5,7 mm	0.2244		93,0	57,0	45,0	61089	68331
#1	0.2280	5.79	3	1-3/4	1-13/32	51001	57169
5,8 mm	0.2283		93,0	57,0	45,0	61090	68332
5,9 mm	0.2323		93,0	57,0	45,0	61091	68333
A	0.2340	5.94	3-1/4	2	1-39/64	51201	57170

公差 (inch)

DC = +0.0000/-0.0005

公差 (mm)

DC = +0.0000/-0.0127



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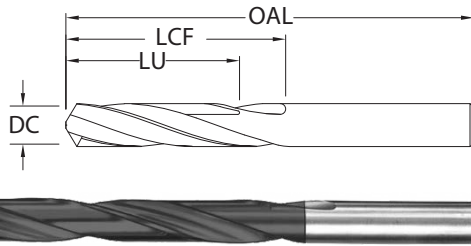
英制 & 公制系列

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刃径 DC	英制值	公制值	全长 OAL	槽长 LCF	刃长 LU	EDP订货号	
						无涂层	Ti-NAMITE-A (AlTiN)
15/64	0.2344	5.95	3-1/4	2	1-39/64	51115	57171
6,0 mm	0.2362		93,0	57,0	45,0	61027	68281
B	0.2380	6.05	3-1/4	2	1-39/64	51202	57172
6,1 mm	0.2402		101,0	63,0	50,0	61092	68334
C	0.2420	6.15	3-1/4	2	1-39/64	51203	57173
6,2 mm	0.2441		101,0	63,0	50,0	61093	68335
D	0.2460	6.25	3-1/4	2	1-39/64	51204	57174
6,3 mm	0.2480		101,0	63,0	50,0	61094	68336
*1/4	0.2500	6.35	3-1/4	2	1-39/64	51116	57176
6,4 mm	0.2520		101,0	63,0	50,0	61095	68337
6,5 mm	0.2559		101,0	63,0	50,0	61029	68282
F	0.2570	6.53	3-1/4	2	1-39/64	51206	57177
6,6 mm	0.2598		101,0	63,0	50,0	61096	68338
G	0.2610	6.63	3-1/2	2-1/8	1-45/64	51207	57178
6,7 mm	0.2638		101,0	63,0	50,0	61097	68339
17/64	0.2656	6.75	3-1/2	2-1/8	1-45/64	51117	57179
H	0.2660	6.76	3-1/2	2-1/8	1-45/64	51208	57180
6,8 mm	0.2677		109,0	69,0	55,0	61098	68340
6,9 mm	0.2717		109,0	69,0	55,0	61099	68341
I	0.2720	6.91	3-1/2	2-1/8	1-45/64	51209	57181
7,0 mm	0.2756		109,0	69,0	55,0	61031	68283
J	0.2770	7.04	3-1/2	2-1/8	1-45/64	51210	57182
7,1 mm	0.2795		109,0	69,0	55,0	61100	68342
K	0.2810	7.14	3-1/2	2-1/8	1-45/64	51211	57183
9/32	0.2812	7.14	3-1/2	2-1/8	1-45/64	51118	57184
7,2 mm	0.2835		109,0	69,0	55,0	61101	68343
7,3 mm	0.2874		109,0	69,0	55,0	61102	68344
L	0.2900	7.37	3-1/2	2-1/8	1-45/64	51212	57185
7,4 mm	0.2913		109,0	69,0	55,0	61103	68345
M	0.2950	7.49	3-3/4	2-3/8	1-29/32	51213	57186
7,5 mm	0.2953		109,0	69,0	55,0	61033	68284
19/64	0.2969	7.54	3-3/4	2-3/8	1-29/32	51119	57187
7,6 mm	0.2992		117,0	75,0	60,0	61104	68346
N	0.3020	7.67	3-3/4	2-3/8	1-29/32	51214	57188
7,7 mm	0.3031		117,0	75,0	60,0	61105	68347
7,8 mm	0.3071		117,0	75,0	60,0	61106	68348
7,9 mm	0.3110		117,0	75,0	60,0	61107	68349
*5/16	0.3125	7.94	3-3/4	2-3/8	1-29/32	51120	57189
8,0 mm	0.3150		117,0	75,0	60,0	61035	68285
O	0.3160	8.03	3-3/4	2-3/8	1-29/32	51215	57190
8,1 mm	0.3189		117,0	75,0	60,0	61108	68350
8,2 mm	0.3228		117,0	75,0	60,0	61109	68351
P	0.3230	8.20	3-3/4	2-3/8	1-29/32	51216	57191
8,3 mm	0.3268		117,0	75,0	60,0	61110	68352
21/64	0.3281	8.33	4	2-1/2	2	51121	57192
8,4 mm	0.3307		117,0	75,0	60,0	61111	68353
Q	0.3320	8.43	4	2-1/2	2	51217	57193
8,5 mm	0.3346		117,0	75,0	60,0	61037	68286
8,6 mm	0.3386		125,0	81,0	64,0	61112	68354
R	0.3390	8.61	4	2-1/2	2	51218	57194
8,7 mm	0.3425		125,0	81,0	64,0	61113	68355
11/32	0.3438	8.73	4	2-1/2	2	51122	57195
8,8 mm	0.3465		125,0	81,0	64,0	61114	68356
S	0.3480	8.84	4	2-1/2	2	51219	57196
8,9 mm	0.3504		125,0	81,0	64,0	61115	68357
9,0 mm	0.3543		125,0	81,0	64,0	61039	68287

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2刃钻头 • 公制: DIN 338



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英制 & 公制系列

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刃径 DC	英制值	公制值	全长 OAL	槽长 LCF	刃长 LU	EDP订货号	
						无涂层	Ti-NAMITE-A (AITIN)
T	0.3580	9.09	4-1/4	2-3/4	2-13/64	51220	57197
9,1 mm	0.3583		125,0	81,0	64,0	61116	68358
23/64	0.3594	9.13	4-1/4	2-3/4	2-13/64	51123	57198
9,2 mm	0.3622		125,0	81,0	64,0	61117	68359
9,3 mm	0.3661		125,0	81,0	64,0	61118	68360
U	0.3680	9.35	4-1/4	2-3/4	2-13/64	51221	57199
9,4 mm	0.3701		125,0	81,0	64,0	61119	68361
9,5 mm	0.3740		125,0	81,0	64,0	61041	68288
*3/8	0.3750	9.53	4-1/4	2-3/4	2-13/64	51124	57200
V	0.3770	9.58	4-1/4	2-3/4	2-13/64	51222	57201
9,6 mm	0.3780		133,0	87,0	69,0	61120	68362
9,7 mm	0.3819		133,0	87,0	69,0	61121	68363
9,8 mm	0.3858		133,0	87,0	69,0	61122	68364
W	0.3860	9.80	4-1/2	2-7/8	2-19/64	51223	57202
9,9 mm	0.3898		133,0	87,0	69,0	61123	68365
25/64	0.3906	9.92	4-1/2	2-7/8	2-19/64	51125	57203
10,0 mm	0.3937		133,0	87,0	69,0	61043	68289
X	0.3970	10.08	4-1/2	2-7/8	2-19/64	51224	57204
10,2 mm	0.4016		133,0	87,0	69,0	61124	68366
Y	0.4040	10.26	4-1/2	2-7/8	2-19/64	51225	57205
13/32	0.4062	10.32	4-1/2	2-7/8	2-19/64	51126	57206
Z	0.4130	10.49	4-1/2	2-7/8	2-19/64	51226	57207
10,5 mm	0.4134		133,0	87,0	69,0	61045	68290
27/64	0.4219	10.72	4-1/2	2-7/8	2-19/64	51127	57208
11,0 mm	0.4331		142,0	94,0	75,0	61047	68291
7/16	0.4375	11.11	4-1/2	2-7/8	2-19/64	51128	57209
11,5 mm	0.4528		142,0	94,0	75,0	61049	68292
29/64	0.4531	11.51	4-3/4	3	2-13/32	51129	57210
15/32	0.4688	11.91	4-3/4	3	2-13/32	51130	57211
12,0 mm	0.4724		151,0	101,0	80,0	61051	68293
31/64	0.4844	12.30	4-3/4	3	2-13/32	51131	57212
1/2	0.5000	12.70	4-3/4	3	2-13/32	51132	57213
*101系列零件						61175	57351

图示:
101系列钻头组合

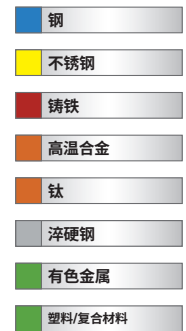


公差 (inch)

DC = +0.0000/-0.0005

公差 (mm)

DC = +0.0000/-0.0127

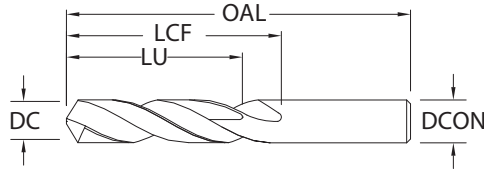


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短柄自定心钻头 • DIN 6539



3xD

**108M Plus**
公制系列

公差 (mm)

≤3 直径

DC = +0,000/-0,010

DCON = h₆

>3-6 直径

DC = +0,000/-0,012

DCON = h₆

>6-10 直径

DC = +0,000/-0,015

DCON = h₆

>10-18 直径

DC = +0,000/-0,018

DCON = h₆

钢

不锈钢

铸铁

高温合金

钛

淬硬钢

有色金属

塑料/复合材料

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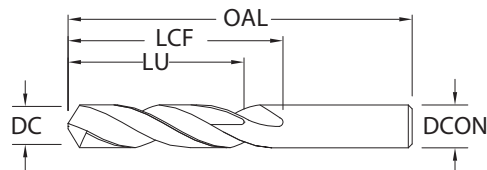
刃径 DC/DCON	mm			EDP订货号	
	全长 OAL	槽长 LCF	刃长 LU	无涂层	Ti-NAMITE-A (AlTiN)
0,5	20,0	3,0	-	62001	68643
0,55	21,0	3,5	-	62003	68644
0,6	21,0	3,5	-	62005	68645
0,65	22,0	4,0	-	62007	68646
0,7	23,0	4,5	-	62009	68647
0,75	23,0	4,5	-	62011	68648
0,8	24,0	5,0	-	62013	68649
0,85	24,0	5,0	-	62015	68650
0,9	25,0	5,5	4,0	62017	68651
0,95	25,0	5,5	4,0	62019	68652
1,0	26,0	6,0	4,7	62021	68653
1,05	26,0	6,0	4,7	62023	68654
1,1	28,0	7,0	5,4	62025	68655
1,15	28,0	7,0	5,4	62027	68656
1,2	30,0	8,0	6,0	62029	68657
1,25	30,0	8,0	6,0	62031	68658
1,3	30,0	8,0	6,0	62033	68659
1,35	32,0	9,0	7,0	62035	68660
1,4	32,0	9,0	7,0	62037	68661
1,45	32,0	9,0	7,0	62039	68662
1,5	32,0	9,0	7,0	62041	68663
1,6	34,0	10,0	7,0	62043	68664
1,7	34,0	10,0	7,0	62045	68665
1,8	36,0	11,0	8,0	62047	68666
1,9	36,0	11,0	8,0	62049	68667
2,0	38,0	12,0	9,0	62051	68668
2,1	38,0	12,0	9,0	62053	68669
2,2	40,0	13,0	10,0	62055	68670
2,3	40,0	13,0	10,0	62057	68671
2,4	43,0	14,0	11,0	62059	68672
2,5	43,0	14,0	11,0	62061	68673
2,6	43,0	14,0	11,0	62063	68674
2,7	46,0	16,0	12,0	62065	68675
2,8	46,0	16,0	12,0	62067	68676
2,9	46,0	16,0	12,0	62069	68677

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公制 短柄自定心钻头 • DIN 6539



108M Plus 公制系列



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刃径 DC/DCON	mm			EDP订货号	
	全长 OAL	槽长 LCF	刃长 LU	无涂层	Ti-NAMITE-A (AlTiN)
3,0	46,0	16,0	12,0	62071	68678
3,1	49,0	18,0	14,0	62073	68679
3,2	49,0	18,0	14,0	62075	68680
3,3	49,0	18,0	14,0	62077	68681
3,4	52,0	20,0	15,0	62079	68682
3,5	52,0	20,0	15,0	62081	68683
3,6	52,0	20,0	15,0	62083	68684
3,7	52,0	20,0	15,0	62085	68685
3,8	55,0	22,0	17,0	62087	68686
3,9	55,0	22,0	17,0	62089	68687
4,0	55,0	22,0	17,0	62091	68688
4,1	55,0	22,0	17,0	62093	68689
4,2	55,0	22,0	17,0	62095	68690
4,3	58,0	24,0	18,0	62097	68691
4,4	58,0	24,0	18,0	62099	68692
4,5	58,0	24,0	18,0	62101	68693
4,6	58,0	24,0	18,0	62103	68694
4,7	58,0	24,0	18,0	62105	68695
4,8	62,0	26,0	20,0	62107	68696
4,9	62,0	26,0	20,0	62109	68697
5,0	62,0	26,0	20,0	62111	68698
5,1	62,0	26,0	20,0	62113	68699
5,2	62,0	26,0	20,0	62115	68700
5,3	62,0	26,0	20,0	62117	68701
5,4	66,0	28,0	21,0	62119	68702
5,5	66,0	28,0	21,0	62121	68703
5,6	66,0	28,0	21,0	62123	68704
5,7	66,0	28,0	21,0	62125	68705
5,8	66,0	28,0	21,0	62127	68706
5,9	66,0	28,0	21,0	62129	68707
6,0	66,0	28,0	21,0	62131	68708
6,1	70,0	31,0	23,0	62133	68709
6,2	70,0	31,0	23,0	62135	68710

公差 (mm)

≤3 直径

DC = +0,000/-0,010

DCON = h₆

>3-6 直径

DC = +0,000/-0,012

DCON = h₆

>6-10 直径

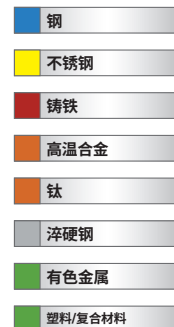
DC = +0,000/-0,015

DCON = h₆

>10-16 直径

DC = +0,000/-0,018

DCON = h₆



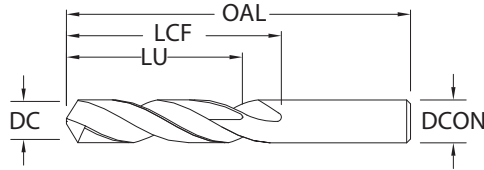
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3xD

**108M Plus**
公制系列

公差 (mm)

≤3 直径

DC = +0,000/-0,010

DCON = h₆

>3-6 直径

DC = +0,000/-0,012

DCON = h₆

>6-10 直径

DC = +0,000/-0,015

DCON = h₆

>10-16 直径

DC = +0,000/-0,018

DCON = h₆

钢

不锈钢

铸铁

高温合金

钛

淬硬钢

有色金属

塑料/复合材料

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刃径 DC/DCON	mm			EDP订货号	
	全长 OAL	槽长 LCF	刃长 LU	无涂层	Ti-NAMITE-A (AlTiN)
6,3	70,0	31,0	23,0	62137	68711
6,4	70,0	31,0	23,0	62139	68712
6,5	70,0	31,0	23,0	62141	68713
6,8	70,0	31,0	23,0	62142	68603
7,0	74,0	34,0	25,0	62143	68718
7,5	74,0	34,0	25,0	62145	68723
7,8	79,0	37,0	27,0	62146	68604
8,0	79,0	37,0	27,0	62147	68728
8,5	79,0	37,0	27,0	62149	68733
9,0	84,0	40,0	29,0	62151	68738
9,5	84,0	40,0	29,0	62153	68743
9,8	89,0	43,0	31,0	62154	68606
10,0	89,0	43,0	31,0	62155	68748
10,2	89,0	43,0	31,0	62156	68607
10,5	89,0	43,0	31,0	62066	68753
11,0	95,0	47,0	33,0	62157	68758
11,5	95,0	47,0	33,0	62084	68763
11,8	102,0	51,0	35,0	62158	68608
12,0	102,0	51,0	35,0	62159	68768
12,5	102,0	51,0	35,0	62102	68773
13,0	102,0	51,0	35,0	62112	68778
13,8	107,0	54,0	37,0	62164	68609
14,0	107,0	54,0	37,0	62116	68780
14,5	111,0	56,0	38,0	62166	68611
14,8	111,0	56,0	38,0	62167	68612
15,0	111,0	56,0	38,0	62168	68613
15,8	115,0	58,0	38,0	62170	68614
16,0	115,0	58,0	38,0	62171	68616

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英制 2刃钻头

101 系列 英制	硬度	Vc (sfm)	DC · in								
			1/64	1/32	1/16	1/8	1/4	3/8	1/2		
P 碳素钢 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 175 Bhn 或 ≤ 7 HRc	265	RPM	64787	32394	16197	8098	4049	2699	2025	
		(212-318)	Fr	0.00021	0.0004	0.0008	0.0017	0.0033	0.0050	0.0067	
			进给 (ipm)	13.5	13.5	13.5	13.5	13.5	13.5	13.5	
	≤ 300 Bhn 或 ≤ 32 HRc	125	RPM	30560	15280	7640	3820	1910	1273	955	
		(100-150)	Fr	0.00020	0.0004	0.0008	0.0016	0.0031	0.0047	0.0063	
			进给 (ipm)	6.0	6.0	6.0	6.0	6.0	6.0	6.0	
	≤ 425 Bhn 或 ≤ 45 HRc	85	RPM	20781	10390	5195	2598	1299	866	649	
		(68-102)	Fr	0.00011	0.0002	0.0004	0.0008	0.0017	0.0025	0.0034	
			进给 (ipm)	2.2	2.2	2.2	2.2	2.2	2.2	2.2	
	M 合金钢 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	≤ 275 Bhn 或 ≤ 28 HRc	230	RPM	56230	28115	14058	7029	3514	2343	1757
			(184-276)	Fr	0.00019	0.0004	0.0007	0.0015	0.0030	0.0045	0.0060
				进给 (ipm)	10.5	10.5	10.5	10.5	10.5	10.5	10.5
≤ 375 Bhn 或 ≤ 40 HRc		145	RPM	35450	17725	8862	4431	2216	1477	1108	
		(116-174)	Fr	0.00019	0.0004	0.0007	0.0015	0.0030	0.0045	0.0060	
			进给 (ipm)	6.6	6.6	6.6	6.6	6.6	6.6	6.6	
≤ 450 Bhn 或 ≤ 48 HRc		60	RPM	14669	7334	3667	1834	917	611	458	
		(48-72)	Fr	0.00008	0.0002	0.0003	0.0007	0.0013	0.0020	0.0026	
			进给 (ipm)	1.2	1.2	1.2	1.2	1.2	1.2	1.2	
K 不锈钢 (易加工) 303, 416, 420F, 430F 440F		≤ 250 Bhn 或 ≤ 24 HRc	210	RPM	51341	25670	12835	6418	3209	2139	1604
			(168-252)	Fr	0.00015	0.0003	0.0006	0.0012	0.0024	0.0036	0.0048
				进给 (ipm)	7.7	7.7	7.7	7.7	7.7	7.7	7.7
	≤ 330 Bhn 或 ≤ 36 HRc	110	RPM	26893	13446	6723	3362	1681	1121	840	
		(88-132)	Fr	0.00009	0.0002	0.0004	0.0007	0.0015	0.0022	0.0030	
			进给 (ipm)	2.5	2.5	2.5	2.5	2.5	2.5	2.5	
	K 不锈钢 (难加工) 304, 316, 321, 13-8 PH, 15-5PH, 17-4 PH, Custom 450	≤ 275 Bhn 或 ≤ 28 HRc	65	RPM	15891	7946	3973	1986	993	662	497
			(52-78)	Fr	0.00010	0.0002	0.0005	0.0009	0.0018	0.0025	0.0035
				进给 (ipm)	1.7	1.7	1.7	1.7	1.7	1.7	1.7
		≤ 375 Bhn 或 ≤ 40 HRc	55	RPM	13446	6723	3362	1681	840	560	420
			(44-66)	Fr	0.00010	0.0002	0.0004	0.0008	0.0015	0.0023	0.0031
				进给 (ipm)	1.3	1.3	1.3	1.3	1.3	1.3	1.3
K 铸铁 灰铸铁, 可锻铸铁, 球墨铸铁		≤ 220 Bhn 或 ≤ 19 HRc	280	RPM	68454	34227	17114	8557	4278	2852	2139
			(224-336)	Fr	0.00026	0.0005	0.0010	0.0020	0.0041	0.0061	0.0082
				进给 (ipm)	17.5	17.5	17.5	17.5	17.5	17.5	17.5
		≤ 330 Bhn 或 ≤ 36 HRc	250	RPM	61120	30560	15280	7640	3820	2547	1910
			(200-300)	Fr	0.00025	0.0005	0.0010	0.0020	0.0041	0.0061	0.0081
				进给 (ipm)	15.5	15.5	15.5	15.5	15.5	15.5	15.5

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101 系列 英制	硬度	Vc (sfm)	DC · in								
			1/64	1/32	1/16	1/8	1/4	3/8	1/2		
N 铝合金 2017, 2024, 356, 6061, 7075	≤ 80 Bhn 或 ≤ 47 HRc	540 (432-648)	RPM	132019	66010	33005	16502	8251	5501	4126	
			Fr	0.00030	0.0006	0.0012	0.0024	0.0048	0.0073	0.0097	
			进给 (ipm)	40.0	40.0	40.0	40.0	40.0	40.0	40.0	
	≤ 150 Bhn 或 ≤ 7 HRc	455 (364-546)	RPM	111238	55619	27810	13905	6952	4635	3476	
			Fr	0.00031	0.0006	0.0013	0.0025	0.0050	0.0076	0.0101	
			进给 (ipm)	35.0	35.0	35.0	35.0	35.0	35.0	35.0	
	铜合金 铝青铜, C110, 蒙知黄铜	≤ 140 Bhn 或 ≤ 3 HRc	190 (152-228)	RPM	46451	23226	11613	5806	2903	1935	1452
				Fr	0.00015	0.0003	0.0006	0.0012	0.0024	0.0036	0.0048
				进给 (ipm)	7.0	7.0	7.0	7.0	7.0	7.0	7.0
		≤ 200 Bhn 或 ≤ 23 HRc	175 (140-210)	RPM	42784	21392	10696	5348	2674	1783	1337
				Fr	0.00015	0.0003	0.0006	0.0012	0.0024	0.0036	0.0048
				进给 (ipm)	6.4	6.4	6.4	6.4	6.4	6.4	6.4
塑料 聚碳酸酯, PVC	500 (400-600)	RPM	122240	61120	30560	15280	7640	5093	3820		
		Fr	0.00031	0.0006	0.0012	0.0025	0.0050	0.0075	0.0099		
		进给 (ipm)	38.0	38.0	38.0	38.0	38.0	38.0	38.0		
S 高温合金 (镍、钴、铁基) Inconel 601, 617, 625, Incoloy 800, 蒙乃尔 400, Rene, Waspaloy	≤ 220 Bhn 或 ≤ 19 HRc	40 (32-48)	RPM	9779	4890	2445	1222	611	407	306	
			Fr	0.00010	0.0002	0.0004	0.0008	0.0016	0.0025	0.0033	
			进给 (ipm)	1.0	1.0	1.0	1.0	1.0	1.0	1.0	
	≤ 320 Bhn 或 ≤ 34 HRc	25 (20-30)	RPM	6112	3056	1528	764	382	255	191	
			Fr	0.00010	0.0002	0.0004	0.0008	0.0016	0.0024	0.0031	
			进给 (ipm)	0.6	0.6	0.6	0.6	0.6	0.6	0.6	
	≤ 425 Bhn 或 ≤ 45 HRc	20 (16-24)	RPM	4890	2445	1222	611	306	204	153	
			Fr	0.00004	0.0001	0.0002	0.0003	0.0007	0.0010	0.0013	
			进给 (ipm)	0.2	0.2	0.2	0.2	0.2	0.2	0.2	
	钛合金 (难加工) 纯钛, Ti6Al4V, Ti6Al2Sn4Zr2Mo, Ti4Al4Mo2Sn0.5Si, Ti-6Al4V	≤ 275 Bhn 或 ≤ 28 HRc	85 (68-102)	RPM	20781	10390	5195	2598	1299	866	649
				Fr	0.00020	0.0004	0.0008	0.0016	0.0032	0.0049	0.0065
				进给 (ipm)	4.2	4.2	4.2	4.2	4.2	4.2	4.2
≤ 350 Bhn 或 ≤ 38 HRc		65 (52-78)	RPM	15891	7946	3973	1986	993	662	497	
			Fr	0.00011	0.0002	0.0004	0.0009	0.0017	0.0026	0.0034	
			进给 (ipm)	1.7	1.7	1.7	1.7	1.7	1.7	1.7	
≤ 440 Bhn 或 ≤ 47 HRc	55 (44-66)	RPM	13446	6723	3362	1681	840	560	420		
		Fr	0.00010	0.0002	0.0004	0.0008	0.0015	0.0023	0.0031		
		进给 (ipm)	1.3	1.3	1.3	1.3	1.3	1.3	1.3		
H 工具钢 A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 250 Bhn 或 ≤ 24 HRc	85 (68-102)	RPM	20781	10390	5195	2598	1299	866	649	
			Fr	0.00011	0.0002	0.0004	0.0009	0.0018	0.0027	0.0035	
			进给 (ipm)	2.3	2.3	2.3	2.3	2.3	2.3	2.3	
	≤ 375 Bhn 或 ≤ 40 HRc	55 (44-66)	RPM	13446	6723	3362	1681	840	560	420	
			Fr	0.00005	0.0001	0.0002	0.0004	0.0008	0.0012	0.0017	
			进给 (ipm)	0.7	0.7	0.7	0.7	0.7	0.7	0.7	
	≤ 475 Bhn 或 ≤ 50 HRc	40 (32-48)	RPM	9779	4890	2445	1222	611	407	306	
			Fr	0.00005	0.0001	0.0002	0.0004	0.0008	0.0012	0.0016	
			进给 (ipm)	0.5	0.5	0.5	0.5	0.5	0.5	0.5	

Bhn (布氏硬度) HRc (洛氏硬度) HRb (洛氏硬度)

$rpm = Vc \times 3.82 / DC$

$ipm = Fr \times rpm$

使用无涂层钻头时, 转速和进给应减小30%

加工更硬的材料时, 降低转速和进给

获取更多技术信息, 请参考SGS刀具向导SGS Tool Wizard® (www.kyocera.com.cn)

2刃钻头

短柄自定心钻头 • DIN 6539

101M, 108M 系列 公制	硬度	Vc (m/min)	DC • mm								
			1	3	6	8	10	12	16		
P 碳素钢 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 175 Bhn 或 ≤ 7 HRc	81	RPM	25690	8563	4282	3211	2569	2141	1606	
		(65-97)	Fr	0.014	0.041	0.082	0.109	0.136	0.163	0.218	
			进给(mm/min)	350	350	350	350	350	350	350	
	≤ 300 Bhn 或 ≤ 32 HRc	38	RPM	12118	4039	2020	1515	1212	1010	757	
		(30-46)	Fr	0.012	0.036	0.072	0.096	0.120	0.144	0.191	
			进给(mm/min)	145	145	145	145	145	145	145	
	≤ 425 Bhn 或 ≤ 45 HRc	26	RPM	8240	2747	1373	1030	824	687	515	
		(21-31)	Fr	0.007	0.020	0.040	0.053	0.067	0.080	0.107	
			进给(mm/min)	55	55	55	55	55	55	55	
	M 合金钢 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	≤ 275 Bhn 或 ≤ 28 HRc	70	RPM	22297	7432	3716	2787	2230	1858	1394
			(56-84)	Fr	0.012	0.036	0.073	0.097	0.121	0.145	0.194
				进给(mm/min)	270	270	270	270	270	270	270
≤ 375 Bhn 或 ≤ 40 HRc		44	RPM	14057	4686	2343	1757	1406	1171	879	
		(35-53)	Fr	0.012	0.036	0.073	0.097	0.121	0.145	0.194	
			进给(mm/min)	170	170	170	170	170	170	170	
≤ 450 Bhn 或 ≤ 48 HRc		18	RPM	5816	1939	969	727	582	485	364	
		(15-22)	Fr	0.005	0.015	0.030	0.040	0.050	0.060	0.080	
			进给(mm/min)	29	29	29	29	29	29	29	
K 不锈钢 (易加工) 303, 416, 420F, 430F 440F		≤ 250 Bhn 或 ≤ 24 HRc	64	RPM	20358	6786	3393	2545	2036	1696	1272
			(51-77)	Fr	0.010	0.029	0.059	0.079	0.098	0.118	0.157
				进给(mm/min)	200	200	200	200	200	200	200
	≤ 330 Bhn 或 ≤ 36 HRc	34	RPM	10664	3555	1777	1333	1066	889	666	
		(27-40)	Fr	0.006	0.017	0.034	0.045	0.056	0.068	0.090	
			进给(mm/min)	60	60	60	60	60	60	60	
	K 不锈钢 (难加工) 304, 316, 321, 13-8 PH, 15-5PH, 17-4 PH, Custom 450	≤ 275 Bhn 或 ≤ 28 HRc	20	RPM	6301	2100	1050	788	630	525	394
			(16-24)	Fr	0.007	0.021	0.043	0.057	0.071	0.086	0.114
				进给(mm/min)	45	45	45	45	45	45	45
		≤ 375 Bhn 或 ≤ 40 HRc	17	RPM	5332	1777	889	666	533	444	333
			(13-20)	Fr	0.007	0.020	0.039	0.053	0.066	0.079	0.105
				进给(mm/min)	35	35	35	35	35	35	35
K 铸铁 灰铸铁, 可锻铸铁, 球墨铸铁		≤ 220 Bhn 或 ≤ 19 HRc	85	RPM	27144	9048	4524	3393	2714	2262	1696
			(68-102)	Fr	0.016	0.049	0.097	0.130	0.162	0.195	0.259
				进给(mm/min)	440	440	440	440	440	440	440
		≤ 330 Bhn 或 ≤ 36 HRc	76	RPM	24235	8078	4039	3029	2424	2020	1515
			(61-91)	Fr	0.017	0.050	0.099	0.132	0.165	0.198	0.264
				进给(mm/min)	400	400	400	400	400	400	400

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2刃钻头

短柄自定心钻头 • DIN 6539

101M, 108M 系列 公制		硬度	Vc (m/min)	DC • mm							
				1	3	6	8	10	12	16	
N	铝合金 2017, 2024, 356, 6061, 7075	≤ 80 Bhn 或 ≤ 47 HRb	165 (132-198)	RPM	52348	17449	8725	6544	5235	4362	3272
				Fr	0.020	0.060	0.120	0.160	0.200	0.240	0.319
				进给(mm/min)	1045	1045	1045	1045	1045	1045	1045
		≤ 150 Bhn 或 ≤ 7 HRc	139 (111-166)	RPM	44108	14703	7351	5514	4411	3676	2757
				Fr	0.020	0.060	0.120	0.160	0.200	0.239	0.319
				进给(mm/min)	880	880	880	880	880	880	880
	铜合金 铝青铜, C110, 蒙知黄铜	≤ 140 Bhn 或 ≤ 3 HRc	58 (46-69)	RPM	18419	6140	3070	2302	1842	1535	1151
				Fr	0.010	0.030	0.060	0.080	0.100	0.121	0.161
				进给(mm/min)	185	185	185	185	185	185	185
		≤ 200 Bhn 或 ≤ 23 HRc	53 (43-64)	RPM	16965	5655	2827	2121	1696	1414	1060
				Fr	0.010	0.030	0.060	0.080	0.100	0.120	0.160
				进给(mm/min)	170	170	170	170	170	170	170
塑料 聚碳酸酯, PVC		152 (122-183)	RPM	48471	16157	8078	6059	4847	4039	3029	
			Fr	0.020	0.060	0.120	0.160	0.200	0.240	0.320	
			进给(mm/min)	970	970	970	970	970	970	970	
S	高温合金 (镍、钴、铁基) Inconel 601, 617, 625, Incoloy 800, 蒙乃尔 400, Rene, Waspaloy	≤ 220 Bhn 或 ≤ 19 HRc	12 (10-15)	RPM	3878	1293	646	485	388	323	242
				Fr	0.006	0.019	0.039	0.052	0.064	0.077	0.103
				进给(mm/min)	25	25	25	25	25	25	25
		≤ 320 Bhn 或 ≤ 34 HRc	8 (6-9)	RPM	2424	808	404	303	242	202	151
				Fr	0.006	0.019	0.037	0.050	0.062	0.074	0.099
				进给(mm/min)	15	15	15	15	15	15	15
S	钛合金 (难加工) 纯钛, Ti6Al4V, Ti6Al2Sn4Zr2Mo, Ti4Al4Mo2Sn0.5Si, Ti-6Al4V	≤ 275 Bhn 或 ≤ 28 HRc	26 (21-31)	RPM	8240	2747	1373	1030	824	687	515
				Fr	0.013	0.040	0.080	0.107	0.133	0.160	0.214
				进给(mm/min)	110	110	110	110	110	110	110
		≤ 350 Bhn 或 ≤ 38 HRc	20 (16-24)	RPM	6301	2100	1050	788	630	525	394
				Fr	0.007	0.021	0.043	0.057	0.071	0.086	0.114
				进给(mm/min)	45	45	45	45	45	45	45
H	工具钢 A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 440 Bhn 或 ≤ 47 HRc	17 (13-20)	RPM	5332	1777	889	666	533	444	333
				Fr	0.007	0.020	0.039	0.053	0.066	0.079	0.105
				进给(mm/min)	35	35	35	35	35	35	35
		≤ 250 Bhn 或 ≤ 24 HRc	26 (21-31)	RPM	8240	2747	1373	1030	824	687	515
				Fr	0.007	0.020	0.040	0.053	0.067	0.080	0.107
				进给(mm/min)	55	55	55	55	55	55	55
H	工具钢 A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 375 Bhn 或 ≤ 40 HRc	17 (13-20)	RPM	5332	1777	889	666	533	444	333
				Fr	0.003	0.010	0.020	0.027	0.034	0.041	0.054
				进给(mm/min)	18	18	18	18	18	18	18
		≤ 475 Bhn 或 ≤ 50 HRc	12 (10-15)	RPM	3878	1293	646	485	388	323	242
				Fr	0.003	0.009	0.019	0.025	0.031	0.037	0.050
				进给(mm/min)	12	12	12	12	12	12	12

Bhn (布氏硬度) HRc (洛氏硬度) HRb (洛氏硬度)

 $rpm = (Vc \times 1000) / (DC \times 3.14)$ $mm/min = Fr \times rpm$

使用无涂层钻头时, 转速和进给应减小30%

加工更硬的材料时, 降低转速和进给

获取更多技术信息, 请参考SGS刀具向导SGS Tool Wizard® (www.kyocera.com.cn)

直槽钻头 · 公制: DIN 6539

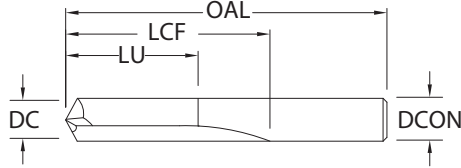


3xD



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英制 & 公制系列



刃径 DC/DCON	英制值	公制值	全长 OAL	槽长 LCF	刃长 LU	EDP订货号	
						无涂层	Ti-NAMITE-A (AlTiN)
1,0 mm	0.0394		26,0	6,0	4,5	66001	66002
#60	0.0400	1.02	1-1/2	1/2	13/32	56060	56269
#59	0.0410	1.04	1-1/2	1/2	13/32	56059	56268
#58	0.0420	1.07	1-1/2	1/2	13/32	56058	56267
#57	0.0430	1.09	1-1/2	1/2	13/32	56057	56266
#56	0.0465	1.18	1-1/2	1/2	13/32	56056	56265
3/64	0.0469	1.19	1-1/2	1/2	13/32	56103	56135
#55	0.0520	1.32	1-1/2	1/2	13/32	56055	56264
#54	0.0550	1.40	1-1/2	1/2	13/32	56054	56263
1,5 mm	0.0591		32,0	9,0	7,0	66003	66004
#53	0.0595	1.51	1-1/2	1/2	13/32	56053	56262
1/16	0.0625	1.59	1-1/2	5/8	1/2	56104	56136
#52	0.0635	1.61	1-11/16	11/16	35/64	56052	56261
#51	0.0670	1.70	1-11/16	11/16	35/64	56051	56260
#50	0.0700	1.78	1-11/16	11/16	35/64	56050	56259
#49	0.0730	1.85	1-11/16	11/16	35/64	56049	56258
#48	0.0760	1.93	1-11/16	11/16	35/64	56048	56257
5/64	0.0781	1.98	1-11/16	11/16	35/64	56105	56137
#47	0.0785	1.99	1-3/4	3/4	39/64	56047	56256
2,0 mm	0.0787		38,0	12,0	9,0	66005	66006
#46	0.0810	2.06	1-3/4	3/4	39/64	56046	56255
#45	0.0820	2.08	1-3/4	3/4	39/64	56045	56254
#44	0.0860	2.18	1-3/4	3/4	39/64	56044	56253
#43	0.0890	2.26	1-3/4	3/4	39/64	56043	56252
#42	0.0935	2.37	1-3/4	3/4	39/64	56042	56251
3/32	0.0938	2.38	1-3/4	3/4	39/64	56106	56138
#41	0.0960	2.44	1-13/16	13/16	21/32	56041	56250
#40	0.0980	2.49	1-13/16	13/16	21/32	56040	56249
2,5 mm	0.0984		43,0	14,0	11,0	66007	66008
#39	0.0995	2.53	1-13/16	13/16	21/32	56039	56248
#38	0.1015	2.58	1-13/16	13/16	21/32	56038	56247
#37	0.1040	2.64	1-13/16	13/16	21/32	56037	56246
#36	0.1065	2.71	1-13/16	13/16	21/32	56036	56245
7/64	0.1094	2.78	1-13/16	13/16	21/32	56107	56139
#35	0.1100	2.79	1-7/8	7/8	45/64	56035	56244
#34	0.1110	2.82	1-7/8	7/8	45/64	56034	56243
#33	0.1130	2.87	1-7/8	7/8	45/64	56033	56242

公差 (inch)

DC = +0.0000/-0.0005

DCON = h₆

公差 (mm)

DC = +0.0000/-0.0127

DCON = h₆

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刃径 DC/DCON	英制值	公制值	全长 OAL	槽长 LCF	刃长 LU	EDP订货号	
						无涂层	Ti-NAMITE-A (AlTiN)
#32	0.1160	2.95	1-7/8	7/8	45/64	56032	56241
3,0 mm	0.1181		46,0	16,0	12,0	66009	66010
#31	0.1200	3.05	1-7/8	7/8	45/64	56031	56240
1/8	0.1250	3.18	1-7/8	7/8	45/64	56108	56140
#30	0.1285	3.26	1-15/16	15/16	3/4	56030	56239
#29	0.1360	3.45	1-15/16	15/16	3/4	56029	56238
3,5 mm	0.1378		52,0	20,0	15,0	66011	66012
#28	0.1405	3.57	1-15/16	15/16	3/4	56028	56237
9/64	0.1406	3.57	1-15/16	15/16	3/4	56109	56141
#27	0.1440	3.66	2-1/16	1	51/64	56027	56236
#26	0.1470	3.73	2-1/16	1	51/64	56026	56235
#25	0.1495	3.80	2-1/16	1	51/64	56025	56234
#24	0.1520	3.86	2-1/16	1	51/64	56024	56233
#23	0.1540	3.91	2-1/16	1	51/64	56023	56232
5/32	0.1562	3.97	2-1/16	1	51/64	56110	56142
#22	0.1570	3.99	2-1/8	1-1/16	55/64	56022	56231
4,0 mm	0.1575		55,0	22,0	17,0	66013	66014
#21	0.1590	4.04	2-1/8	1-1/16	55/64	56021	56230
#20	0.1610	4.09	2-1/8	1-1/16	55/64	56020	56229
#19	0.1660	4.22	2-1/8	1-1/16	55/64	56019	56228
#18	0.1695	4.31	2-1/8	1-1/16	55/64	56018	56227
11/64	0.1719	4.37	2-1/8	1-1/16	55/64	56111	56143
#17	0.1730	4.39	2-3/16	1-1/8	29/32	56017	56226
#16	0.1770	4.50	2-3/16	1-1/8	29/32	56016	56225
4,5 mm	0.1772		58,0	24,0	18,0	66015	66016
#15	0.1800	4.57	2-3/16	1-1/8	29/32	56015	56224
#14	0.1820	4.62	2-3/16	1-1/8	29/32	56014	56223
#13	0.1850	4.70	2-3/16	1-1/8	29/32	56013	56222
3/16	0.1875	4.76	2-3/16	1-1/8	29/32	56112	56144
#12	0.1890	4.80	2-3/16	1-1/8	29/32	56012	56221
#11	0.1910	4.85	2-3/16	1-1/8	29/32	56011	56220
#10	0.1935	4.91	2-3/16	1-1/8	29/32	56010	56219
#9	0.1960	4.98	2-1/4	1-3/16	61/64	56009	56218
5,0 mm	0.1969		62,0	26,0	20,0	66017	66018
#8	0.1990	5.05	2-1/4	1-3/16	61/64	56008	56217
#7	0.2010	5.11	2-1/4	1-3/16	61/64	56007	56216
13/64	0.2031	5.16	2-1/4	1-3/16	61/64	56113	56145
#6	0.2040	5.18	2-3/8	1-1/4	1	56006	56215
#5	0.2055	5.22	2-3/8	1-1/4	1	56005	56214
#4	0.2090	5.31	2-3/8	1-1/4	1	56004	56213
#3	0.2130	5.41	2-3/8	1-1/4	1	56003	56212
5,5 mm	0.2165		66,0	28,0	21,0	66019	66020
7/32	0.2188	5.56	2-3/8	1-1/4	1	56114	56146
#2	0.2210	5.61	2-7/16	1-5/16	1-3/64	56002	56211
#1	0.2280	5.79	2-7/16	1-5/16	1-3/64	56001	56210
15/64	0.2344	5.95	2-7/16	1-5/16	1-3/64	56115	56147
6,0 mm	0.2362		66,0	28,0	21,0	66021	66045

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直槽钻头 • 公制: DIN 6539

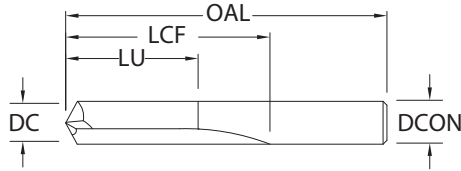


3xD



106

英制 & 公制系列



刃径 DC/DCON	英制值	公制值	全长 OAL	槽长 LCF	刃长 LU	EDP订货号	
						无涂层	Ti-NAMITE-A (AlTiN)
1/4	0.2500	6.35	2-1/2	1-3/8	1-7/64	56116	56148
6,5 mm	0.2559		70,0	31,0	23,0	66022	66046
17/64	0.2656	6.75	2-5/8	1-7/16	1-7/64	56117	56149
7,0 mm	0.2756		74,0	34,0	25,0	66023	66024
9/32	0.2812	7.14	2-11/16	1-1/2	1-13/64	56118	56150
7,5 mm	0.2953		74,0	34,0	25,0	66025	66026
19/64	0.2969	7.54	2-3/4	1-9/16	1-1/4	56119	56151
5/16	0.3125	7.94	2-13/16	1-5/8	1-19/64	56120	56152
8,0 mm	0.3150		79,0	37,0	27,0	66027	66028
21/64	0.3281	8.33	2-15/16	1-11/16	1-23/64	56121	56153
8,5 mm	0.3346		79,0	37,0	27,0	66029	66030
11/32	0.3438	8.73	3	1-11/16	1-23/64	56122	56154
9,0 mm	0.3543		84,0	40,0	29,0	66031	66032
23/64	0.3594	9.13	3-1/16	1-3/4	1-13/32	56123	56155
9,5 mm	0.3740		84,0	40,0	29,0	66033	66034
3/8	0.3750	9.53	3-1/8	1-13/16	1-29/64	56124	56156
25/64	0.3906	9.92	3-1/4	1-7/8	1-1/2	56125	56157
10,0 mm	0.3937		89,0	43,0	31,0	66035	66036
13/32	0.4062	10.32	3-5/16	1-15/16	1-35/64	56126	56158
10,5 mm	0.4134		89,0	43,0	31,0	66037	66038
27/64	0.4219	10.72	3-3/8	2	1-39/64	56127	56159
11,0 mm	0.4331		95,0	47,0	33,0	66039	66040
7/16	0.4375	11.11	3-7/16	2-1/16	1-21/32	56128	56160
11,5 mm	0.4528		95,0	47,0	33,0	66041	66042
29/64	0.4531	11.51	3-9/16	2-1/8	1-45/64	56129	56161
15/32	0.4688	11.91	3-5/8	2-1/8	1-45/64	56130	56162
12,0 mm	0.4724		102,0	51,0	35,0	66043	66044
31/64	0.4844	12.30	3-11/16	2-3/16	1-3/4	56131	56163
1/2	0.5000	12.70	3-3/4	2-1/4	1-51/64	56132	56164

公差 (inch)

DC = +0.0000/-0.0005

DCON = h₆

公差 (mm)

DC = +0.0000/-0.0127

DCON = h₆

钢

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106 系列 英制	硬度	Vc (sfm)	DC • in						
			1/16	1/8	3/16	1/4	3/8	1/2	
			RPM	Fr	进给 (ipm)	RPM	Fr	进给 (ipm)	RPM
P 合金钢 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	≤ 500 Bhn 或 ≤ 52 HRc	60	RPM	3667	1834	1222	917	611	458
		(48-72)	Fr	0.0004	0.0007	0.0011	0.0014	0.0021	0.0028
			进给 (ipm)	1.3	1.3	1.3	1.3	1.3	1.3
	≤ 615 Bhn 或 ≤ 58 HRc	50	RPM	3056	1528	1019	764	509	382
		(40-60)	Fr	0.0004	0.0008	0.0012	0.0016	0.0024	0.0031
			进给 (ipm)	1.2	1.2	1.2	1.2	1.2	1.2
K 铸铁 灰铸铁, 可锻铸铁, 球墨铸铁	≤ 220 Bhn 或 ≤ 19 HRc	250	RPM	15280	7640	5093	3820	2547	1910
		(200-300)	Fr	0.0010	0.0020	0.0030	0.0041	0.0061	0.0081
			进给 (ipm)	15.5	15.5	15.5	15.5	15.5	15.5
	≤ 330 Bhn 或 ≤ 36 HRc	195	RPM	11918	5959	3973	2980	1986	1490
		(156-234)	Fr	0.0010	0.0020	0.0030	0.0040	0.0060	0.0081
			进给 (ipm)	12.0	12.0	12.0	12.0	12.0	12.0
H 工具钢 A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 500 Bhn 或 ≤ 52 HRc	60	RPM	3667	1834	1222	917	611	458
		(48-72)	Fr	0.0004	0.0007	0.0011	0.0014	0.0021	0.0028
			进给 (ipm)	1.3	1.3	1.3	1.3	1.3	1.3
	≤ 615 Bhn 或 ≤ 58 HRc	50	RPM	3056	1528	1019	764	509	382
		(40-60)	Fr	0.0004	0.0008	0.0012	0.0016	0.0024	0.0031
			进给 (ipm)	1.2	1.2	1.2	1.2	1.2	1.2

Bhn (布氏硬度) HRc (洛氏硬度)

$$\text{rpm} = \text{Vc} \times 3.82 / \text{DC}$$

$$\text{ipm} = \text{Fr} \times \text{rpm}$$

使用无涂层钻头时, 转速和进给应减小30%

获取更多技术信息, 请参考SGS刀具向导SGS Tool Wizard® (www.kyocera.com.cn)

106M 系列 公制	硬度	Vc (m/min)	DC • mm						
			1	3	6	8	10	12	
			RPM	Fr	进给 (mm/min)	RPM	Fr	进给 (mm/min)	RPM
P 合金钢 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	≤ 500 Bhn 或 ≤ 52 HRc	18	RPM	5816	1939	969	727	582	485
		(15-22)	Fr	0.006	0.018	0.035	0.047	0.058	0.070
			进给 (mm/min)	34	34	34	34	34	34
	≤ 615 Bhn 或 ≤ 58 HRc	15	RPM	4847	1616	808	606	485	404
		(12-18)	Fr	0.006	0.017	0.033	0.045	0.056	0.067
			进给 (mm/min)	27	27	27	27	27	27
K 铸铁 灰铸铁, 可锻铸铁, 球墨铸铁	≤ 220 Bhn 或 ≤ 19 HRc	76	RPM	24235	8078	4039	3029	2424	2020
		(61-91)	Fr	0.016	0.048	0.096	0.128	0.160	0.192
			进给 (mm/min)	395	395	395	395	395	395
	≤ 330 Bhn 或 ≤ 36 HRc	59	RPM	18904	6301	3151	2363	1890	1575
		(48-71)	Fr	0.016	0.048	0.096	0.128	0.160	0.192
			进给 (mm/min)	305	305	305	305	305	305
H 工具钢 A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 500 Bhn 或 ≤ 52 HRc	18	RPM	5816	1939	969	727	582	485
		(15-22)	Fr	0.006	0.018	0.035	0.047	0.058	0.070
			进给 (mm/min)	34	34	34	34	34	34
	≤ 615 Bhn 或 ≤ 58 HRc	15	RPM	4847	1616	808	606	485	404
		(12-18)	Fr	0.006	0.017	0.033	0.045	0.056	0.067
			进给 (mm/min)	27	27	27	27	27	27

Bhn (布氏硬度) HRc (洛氏硬度)

$$\text{rpm} = (\text{Vc} \times 1000) / (\text{DC} \times 3.14)$$

$$\text{mm/min} = \text{Fr} \times \text{rpm}$$

使用无涂层钻头时, 转速和进给应减小30%

获取更多技术信息, 请参考SGS刀具向导SGS Tool Wizard® (www.kyocera.com.cn)

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3xD
(mm)

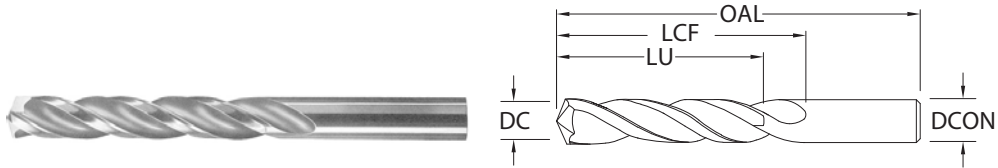
5xD
(inch)



3

103

英制 & 公制系列



刃径 DC/DCON	英制值	公制值	全长 OAL	槽长 LCF	刃长 LU	EDP订货号	
						无涂层	Ti-NAMITE-A (AlTiN)
#36	0.1065	2.71	2-1/4	1-1/4	1	53036	58011
7/64	0.1094	2.78	2-1/4	1-1/4	1	53107	58012
#35	0.1100	2.79	2-1/4	1-1/4	1	53035	58013
#34	0.1110	2.82	2-1/4	1-1/4	1	53034	58014
#33	0.1130	2.87	2-1/4	1-1/4	1	53033	58015
#32	0.1160	2.95	2-1/4	1-1/4	1	53032	58016
3,0 mm	0.1181		46,0	16,0	12,0	63000	68965
#31	0.1200	3.05	2-1/4	1-1/4	1	53031	58017
3,1 mm	0.1220		49,0	18,0	14,0	63044	68966
1/8	0.1250	3.18	2-1/4	1-1/4	1	53108	58018
3,2 mm	0.1260		49,0	18,0	14,0	63045	68967
#30	0.1285	3.26	2-1/4	1-1/4	1	53030	58019
3,3 mm	0.1299		49,0	18,0	14,0	63001	68968
3,4 mm	0.1339		52,0	20,0	15,0	63046	68969
#29	0.1360	3.45	2-1/2	1-3/8	1-7/64	53029	58020
3,5 mm	0.1378		52,0	20,0	15,0	63002	68970
#28	0.1405	3.57	2-1/2	1-3/8	1-7/64	53028	58021
9/64	0.1406	3.57	2-1/2	1-3/8	1-7/64	53109	58022
3,6 mm	0.1417		52,0	20,0	15,0	63047	68971
#27	0.1440	3.66	2-1/2	1-3/8	1-7/64	53027	58023
3,7 mm	0.1457		52,0	20,0	15,0	63003	68972
#26	0.1470	3.73	2-1/2	1-3/8	1-7/64	53026	58024
#25	0.1495	3.80	2-1/2	1-3/8	1-7/64	53025	58025
3,8 mm	0.1496		55,0	22,0	17,0	63048	68973
#24	0.1520	3.86	2-1/2	1-3/8	1-7/64	53024	58026
3,9 mm	0.1535		55,0	22,0	17,0	63049	68974
#23	0.1540	3.91	2-1/2	1-3/8	1-7/64	53023	58027
5/32	0.1562	3.97	2-1/2	1-3/8	1-7/64	53110	58028
#22	0.1570	3.99	2-1/2	1-3/8	1-7/64	53022	58029
4,0 mm	0.1575		55,0	22,0	17,0	63004	68975
#21	0.1590	4.04	2-1/2	1-3/8	1-7/64	53021	58030
#20	0.1610	4.09	2-1/2	1-3/8	1-7/64	53020	58031
4,1 mm	0.1614		55,0	22,0	17,0	63050	68976
4,2 mm	0.1654		55,0	22,0	17,0	63005	68977
#19	0.1660	4.22	2-3/4	1-5/8	1-19/64	53019	58032
4,3 mm	0.1693		58,0	24,0	18,0	63051	68978
#18	0.1695	4.31	2-3/4	1-5/8	1-19/64	53018	58033
11/64	0.1719	4.37	2-3/4	1-5/8	1-19/64	53111	58034
#17	0.1730	4.39	2-3/4	1-5/8	1-19/64	53017	58035
4,4 mm	0.1732		58,0	24,0	18,0	63052	68979
#16	0.1770	4.50	2-3/4	1-5/8	1-19/64	53016	58036

公差 (inch)

DC = +0.0000/-0.0005

DCON = h₆

公差 (mm)

DC = +0.0000/-0.0127

DCON = h₆

- 钢
- 铸铁
- 淬硬钢
- 有色金属

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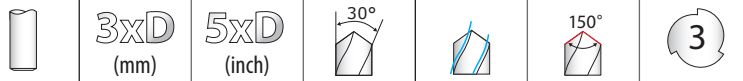
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刃径 DC/DCON	英制值	公制值	全长 OAL	槽长 LCF	刃长 LU	EDP订货号	
						无涂层	Ti-NAMITE-A (AlTiN)
4,5 mm	0.1772		58,0	24,0	18,0	63006	68980
#15	0.1800	4.57	2-3/4	1-5/18	1-19/64	53015	58037
4,6 mm	0.1811		58,0	24,0	18,0	63053	68981
#14	0.1820	4.62	2-3/4	1-5/8	1-19/64	53014	58038
#13	0.1850	4.70	2-3/4	1-5/8	1-19/64	53013	58039
4,7 mm	0.1850		58,0	24,0	18,0	63054	68982
3/16	0.1875	4.76	2-3/4	1-5/8	1-19/64	53112	58040
#12	0.1890	4.80	2-3/4	1-5/8	1-19/64	53012	58041
4,8 mm	0.1890		62,0	26,0	20,0	63055	68983
#11	0.1910	4.85	2-3/4	1-5/8	1-19/64	53011	58042
4,9 mm	0.1929		62,0	26,0	20,0	63056	68984
#10	0.1935	4.91	2-3/4	1-5/8	1-19/64	53010	58043
#9	0.1960	4.98	3	1-3/4	1-13/32	53009	58044
5,0 mm	0.1969		62,0	26,0	20,0	63007	68985
#8	0.1990	5.05	3	1-3/4	1-13/32	53008	58045
5,1 mm	0.2008		62,0	26,0	20,0	63057	68986
#7	0.2010	5.11	3	1-3/4	1-13/32	53007	58046
13/64	0.2031	5.16	3	1-3/4	1-13/32	53113	58047
#6	0.2040	5.18	3	1-3/4	1-13/32	53006	58048
5,2 mm	0.2047		62,0	26,0	20,0	63008	68987
#5	0.2055	5.22	3	1-3/4	1-13/32	53005	58049
5,3 mm	0.2087		62,0	26,0	20,0	63058	68988
#4	0.2090	5.31	3	1-3/4	1-13/32	53004	58050
5,4 mm	0.2126		66,0	28,0	21,0	63059	68989
#3	0.2130	5.41	3	1-3/4	1-13/32	53003	58051
5,5 mm	0.2165		66,0	28,0	21,0	63009	68990
7/32	0.2188	5.56	3	1-3/4	1-13/32	53114	58052
5,6 mm	0.2205		66,0	28,0	21,0	63060	68991
#2	0.2210	5.61	3	1-3/4	1-13/32	53002	58053
5,7 mm	0.2244		66,0	28,0	21,0	63061	68992
#1	0.2280	5.79	3	1-3/4	1-13/32	53001	58054
5,8 mm	0.2283		66,0	28,0	21,0	63062	68993
5,9 mm	0.2323		66,0	28,0	21,0	63063	68994
A	0.2340	5.94	3-1/4	2	1-39/64	53201	58055
15/64	0.2344	5.95	3-1/4	2	1-39/64	53115	58056
6,0 mm	0.2362		66,0	28,0	21,0	63010	68995
B	0.2380	6.05	3-1/4	2	1-39/64	53202	58057
6,1 mm	0.2402		70,0	31,0	23,0	63064	68996
C	0.2420	6.15	3-1/4	2	1-39/64	53203	58058
6,2 mm	0.2441		70,0	31,0	23,0	63011	68997
D	0.2460	6.25	3-1/4	2	1-39/64	53204	58059
6,3 mm	0.2480		70,0	31,0	23,0	63065	68998
1/4	0.2500	6.35	3-1/4	2	1-39/64	53116	58061
6,4 mm	0.2520		70,0	31,0	23,0	63066	68999
6,5 mm	0.2559		70,0	31,0	23,0	63012	69000
F	0.2570	6.53	3-1/4	2	1-39/64	53206	58062
6,6 mm	0.2598		70,0	31,0	23,0	63067	69001
G	0.2610	6.63	3-1/2	2-1/8	1-45/64	53207	58063
6,7 mm	0.2638		70,0	31,0	23,0	63068	69002
17/64	0.2656	6.75	3-1/2	2-1/8	1-45/64	53117	58064
H	0.2660	6.76	3-1/2	2-1/8	1-45/64	53208	58065
6,8 mm	0.2677		74,0	34,0	25,0	63013	69003

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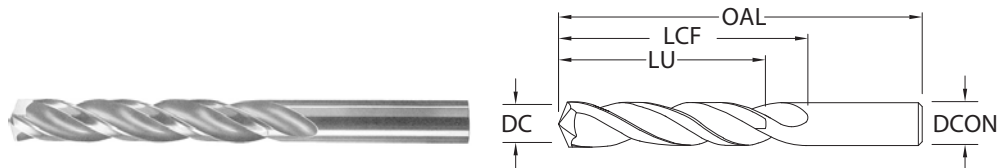
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3刃钻头 • 公制: DIN 6539



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英制 & 公制系列



刃径 DC/DCON	英制值	公制值	全长 OAL	槽长 LCF	刃长 LU	EDP订货号	
						无涂层	Ti-NAMITE-A (AlTiN)
6,9 mm	0.2717		74,0	34,0	25,0	63069	69004
I	0.2720	6.91	3-1/2	2-1/8	1-45/64	53209	58066
7,0 mm	0.2756		74,0	34,0	25,0	63014	69005
J	0.2770	7.04	3-1/2	2-1/8	1-45/64	53210	58067
7,1 mm	0.2795		74,0	34,0	25,0	63070	69006
K	0.2810	7.14	3-1/2	2-1/8	1-45/64	53211	58068
9/32	0.2812	7.14	3-1/2	2-1/8	1-45/64	53118	58069
7,2 mm	0.2835		74,0	34,0	25,0	63015	69007
7,3 mm	0.2874		74,0	34,0	25,0	63071	69008
L	0.2900	7.37	3-1/2	2-1/8	1-45/64	53212	58070
7,4 mm	0.2913		74,0	34,0	25,0	63072	69009
M	0.2950	7.49	3-3/4	2-3/8	1-29/32	53213	58071
7,5 mm	0.2953		74,0	34,0	25,0	63016	69010
19/64	0.2969	7.54	3-3/4	2-3/8	1-29/32	53119	58072
7,6 mm	0.2992		79,0	37,0	27,0	63073	69011
N	0.3020	7.67	2-3/8	2-3/8	1-29/32	53214	58073
7,7 mm	0.3031		79,0	37,0	27,0	63074	69012
7,8 mm	0.3071		79,0	37,0	27,0	63075	69013
7,9 mm	0.3110		79,0	37,0	27,0	63076	69014
5/16	0.3125	7.94	3-3/4	2-3/8	1-29/32	53120	58074
8,0 mm	0.3150		79,0	37,0	27,0	63017	69015
O	0.3160	8.03	3-3/4	2-3/8	1-29/32	53215	58075
8,1 mm	0.3189		79,0	37,0	27,0	63077	69016
8,2 mm	0.3228		79,0	37,0	27,0	63018	69017
P	0.3230	8.20	3-3/4	2-3/8	1-29/32	53216	58076
8,3 mm	0.3268		79,0	37,0	27,0	63078	69018
21/64	0.3281	8.33	4	2-1/2	2	53121	58077
8,4 mm	0.3307		79,0	37,0	27,0	63019	69019
Q	0.3320	8.43	4	2-1/2	2	53217	58078
8,5 mm	0.3346		79,0	37,0	27,0	63020	69020
8,6 mm	0.3386		84,0	40,0	29,0	63021	69021
R	0.3390	8.61	4	2-1/2	2	53218	58079
8,7 mm	0.3425		84,0	40,0	29,0	63079	69022
11/32	0.3438	8.73	4	2-1/2	2	53122	58080
8,8 mm	0.3465		84,0	40,0	29,0	63022	69023
S	0.3480	8.84	4	2-1/2	2	53219	58081
8,9 mm	0.3504		84,0	40,0	29,0	63080	69024
9,0 mm	0.3543		84,0	40,0	29,0	63023	69025
T	0.3580	9.09	4-1/4	2-3/4	2-13/64	53220	58082
9,1 mm	0.3583		84,0	40,0	29,0	63081	69026
23/64	0.3594	9.13	4-1/4	2-3/4	2-13/64	53123	58083
9,2 mm	0.3622		84,0	40,0	29,0	63024	69027
9,3 mm	0.3661		84,0	40,0	29,0	63082	69028

公差 (inch)

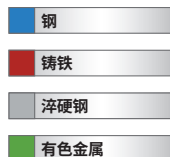
DC = +0.0000/-0.0005

DCON = h₆

公差 (mm)

DC = +0.0000/-0.0127

DCON = h₆



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刃径 DC/DCON	英制值	公制值	全长 OAL	槽长 LCF	刃长 LU	EDP订货号	
						无涂层	Ti-NAMITE-A (AlTiN)
U	0.3680	9.35	4-1/4	2-3/4	2-13/64	53221	58084
9,4 mm	0.3701		84,0	40,0	29,0	63083	69029
9,5 mm	0.3740		84,0	40,0	29,0	63025	69030
3/8	0.3750	9.53	4-1/4	2-3/4	2-13/64	53124	58085
V	0.3770	9.58	4-1/4	2-3/4	2-13/64	53222	58086
9,6 mm	0.3780		89,0	43,0	31,0	63084	69031
9,7 mm	0.3819		89,0	43,0	31,0	63085	69032
9,8 mm	0.3858		89,0	43,0	31,0	63086	69033
W	0.3860	9.80	4-1/2	2-7/8	2-19/64	53223	58087
9,9 mm	0.3898		89,0	43,0	31,0	63087	69034
25/64	0.3906	9.92	4-1/2	2-7/8	2-19/64	53125	58088
10,0 mm	0.3937		89,0	43,0	31,0	63026	69035
X	0.3970	10.08	4-1/2	2-7/8	2-19/64	53224	58089
10,1 mm	0.3976		89,0	43,0	31,0	63088	69036
10,2 mm	0.4016		89,0	43,0	31,0	63027	69037
Y	0.4040	10.26	4-1/2	2-7/8	2-19/64	53225	58090
13/32	0.4062	10.32	4-1/2	2-7/8	2-19/64	53126	58091
10,4 mm	0.4094		89,0	43,0	31,0	63028	69038
Z	0.4130	10.49	4-1/2	2-7/8	2-19/64	53226	58092
10,5 mm	0.4134		89,0	43,0	31,0	63029	69039
10,7 mm	0.4213		95,0	47,0	33,0	63030	69040
27/64	0.4219	10.72	4-1/2	2-7/8	2-19/64	53127	58093
10,8 mm	0.4252		95,0	47,0	33,0	63031	69041
11,0 mm	0.4331		95,0	47,0	33,0	63032	69042
7/16	0.4375	11.11	4-1/2	2-7/8	2-19/64	53128	58094
11,5 mm	0.4528		95,0	47,0	33,0	63033	69043
29/64	0.4531	11.51	4-3/4	3	2-13/32	53129	58095
15/32	0.4688	11.91	4-3/4	3	2-13/32	53130	58096
12,0 mm	0.4724		102,0	51,0	35,0	63034	69044
31/64	0.4844	12.30	4-3/4	3	2-13/32	53131	58097
12,5 mm	0.4921		102,0	51,0	35,0	63035	69045
1/2	0.5000	12.70	4-3/4	3	2-13/32	53132	58098
12,8 mm	0.5039		102,0	51,0	35,0	63036	69046
13,0 mm	0.5118		102,0	51,0	35,0	63089	69047
33/64	0.5156	13.10	4-3/4	3	2-13/32	53135	58099
13,1 mm	0.5157		102,0	51,0	35,0	63037	69048
13,5 mm	0.5315		107,0	54,0	37,0	63090	69049
14,0 mm	0.5512		107,0	54,0	37,0	63038	69050
9/16	0.5625	14.29	4-3/4	3	2-13/32	53136	58100
14,3 mm	0.5630		111,0	56,0	38,0	63039	69051
14,5 mm	0.5709		111,0	56,0	38,0	63040	69052
15,0 mm	0.5906		111,0	56,0	38,0	63091	69053
5/8	0.6250	15.88	5-3/4	3-1/2	2-51/64	53133	58101
11/16	0.6875	17.46	5-3/4	3-1/2	2-51/64	53137	58102
17,5 mm	0.6890		123,0	62,0	40,0	63041	69054
3/4	0.7500	19.05	5-3/4	4-1/4	3 13/32	53134	58103
19,5 mm	0.7677		131,0	66,0	42,0	63042	69055
20,0 mm	0.7874		131,0	66,0	42,0	63043	69056

3刃钻头

103 系列 英制	硬度	Vc (sfm)	DC • in							
			1/8	1/4	3/8	1/2	5/8	3/4		
P 碳素钢 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 175 Bhn 或 ≤ 7 HRc	295 (236-354)	RPM	9015	4508	3005	2254	1803	1503	
			Fr	0.0026	0.0051	0.0077	0.0102	0.0128	0.0153	
			进给 (ipm)	23.0	23.0	23.0	23.0	23.0	23.0	
	≤ 300 Bhn 或 ≤ 32 HRc	260 (208-312)	RPM	7946	3973	2649	1986	1589	1324	
			Fr	0.0023	0.0045	0.0068	0.0091	0.0113	0.0136	
			进给 (ipm)	18.0	18.0	18.0	18.0	18.0	18.0	
	≤ 425 Bhn 或 ≤ 45 HRc	150 (120-180)	RPM	4584	2292	1528	1146	917	764	
			Fr	0.0013	0.0026	0.0039	0.0052	0.0065	0.0079	
			进给 (ipm)	6.0	6.0	6.0	6.0	6.0	6.0	
	K 合金钢 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	≤ 275 Bhn 或 ≤ 28 HRc	230 (184-276)	RPM	7029	3514	2343	1757	1406	1171
				Fr	0.0019	0.0038	0.0058	0.0077	0.0096	0.0115
				进给 (ipm)	13.5	13.5	13.5	13.5	13.5	13.5
≤ 375 Bhn 或 ≤ 40 HRc		145 (116-174)	RPM	4431	2216	1477	1108	886	739	
			Fr	0.0019	0.0038	0.0058	0.0077	0.0096	0.0115	
			进给 (ipm)	8.5	8.5	8.5	8.5	8.5	8.5	
≤ 450 Bhn 或 ≤ 48 HRc		115 (92-138)	RPM	3514	1757	1171	879	703	586	
			Fr	0.0005	0.0010	0.0015	0.0020	0.0026	0.0031	
			进给 (ipm)	1.8	1.8	1.8	1.8	1.8	1.8	
N 铸铁 灰铸铁, 可锻铸铁, 球墨铸铁		≤ 220 Bhn 或 ≤ 19 HRc	250 (200-300)	RPM	7640	3820	2547	1910	1528	1273
				Fr	0.0026	0.0052	0.0079	0.0105	0.0131	0.0157
				进给 (ipm)	20.0	20.0	20.0	20.0	20.0	20.0
	≤ 330 Bhn 或 ≤ 36 HRc	195 (156-234)	RPM	5959	2980	1986	1490	1192	993	
			Fr	0.0026	0.0052	0.0078	0.0104	0.0130	0.0156	
			进给 (ipm)	15.5	15.5	15.5	15.5	15.5	15.5	
	H 铝合金 2017, 2024, 356, 6061, 7075	≤ 80 Bhn 或 ≤ 47 HRb	540 (432-648)	RPM	16502	8251	5501	4126	3300	2750
				Fr	0.0032	0.0064	0.0096	0.0128	0.0161	0.0193
				进给 (ipm)	53.0	53.0	53.0	53.0	53.0	53.0
		≤ 150 Bhn 或 ≤ 7 HRc	455 (364-546)	RPM	13905	6952	4635	3476	2781	2317
				Fr	0.0032	0.0065	0.0097	0.0129	0.0162	0.0194
				进给 (ipm)	45.0	45.0	45.0	45.0	45.0	45.0
H 铜合金 铝青铜, C110, 蒙知黄铜		≤ 140 Bhn 或 ≤ 3 HRc	305 (244-366)	RPM	9321	4660	3107	2330	1864	1553
				Fr	0.0019	0.0039	0.0058	0.0077	0.0097	0.0116
				进给 (ipm)	18.0	18.0	18.0	18.0	18.0	18.0
		≤ 200 Bhn 或 ≤ 23 HRc	160 (128-192)	RPM	4890	2445	1630	1222	978	815
				Fr	0.0016	0.0033	0.0049	0.0065	0.0082	0.0098
				进给 (ipm)	8.0	8.0	8.0	8.0	8.0	8.0
	H 工具钢 A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 250 Bhn 或 ≤ 24 HRc	85 (68-102)	RPM	2598	1299	866	649	520	433
				Fr	0.0013	0.0026	0.0039	0.0052	0.0065	0.0079
				进给 (ipm)	3.4	3.4	3.4	3.4	3.4	3.4
		≤ 375 Bhn 或 ≤ 40 HRc	65 (52-78)	RPM	1986	993	662	497	397	331
				Fr	0.0007	0.0013	0.0020	0.0026	0.0033	0.0039
				进给 (ipm)	1.3	1.3	1.3	1.3	1.3	1.3
≤ 475 Bhn 或 ≤ 50 HRc		50 (40-60)	RPM	1528	764	509	382	306	255	
			Fr	0.0007	0.0013	0.0020	0.0026	0.0033	0.0039	
			进给 (ipm)	1.0	1.0	1.0	1.0	1.0	1.0	

Bhn (布氏硬度) HRc (洛氏硬度) HRb (洛氏硬度)

rpm = Vc x 3.82 / DC

ipm = Fr x rpm

使用无涂层钻头时, 转速和进给应减小30%

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103M 系列 公制	硬度	Vc (m/min)	DC • mm							
			3	6	10	12	16	20		
P 碳素钢 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 175 Bhn 或 ≤ 7 Hrc	90	RPM	9533	4766	2860	2383	1787	1430	
		(72-108)	Fr	0.062	0.124	0.206	0.248	0.330	0.413	
			进给(mm/min)	590	590	590	590	590	590	
	≤ 300 Bhn 或 ≤ 32 Hrc	79	RPM	8402	4201	2520	2100	1575	1260	
		(63-95)	Fr	0.055	0.110	0.183	0.219	0.292	0.365	
			进给(mm/min)	460	460	460	460	460	460	
	≤ 425 Bhn 或 ≤ 45 Hrc	46	RPM	4847	2424	1454	1212	909	727	
		(37-55)	Fr	0.032	0.064	0.107	0.128	0.171	0.213	
			进给(mm/min)	155	155	155	155	155	155	
	K 合金钢 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	≤ 275 Bhn 或 ≤ 28 Hrc	70	RPM	7432	3716	2230	1858	1394	1115
			(56-84)	Fr	0.046	0.093	0.155	0.186	0.248	0.309
				进给(mm/min)	345	345	345	345	345	345
≤ 375 Bhn 或 ≤ 40 Hrc		44	RPM	4686	2343	1406	1171	879	703	
		(35-53)	Fr	0.046	0.092	0.153	0.184	0.245	0.306	
			进给(mm/min)	215	215	215	215	215	215	
≤ 450 Bhn 或 ≤ 48 Hrc		35	RPM	3716	1858	1115	929	697	557	
		(28-42)	Fr	0.012	0.024	0.040	0.048	0.065	0.081	
			进给(mm/min)	45	45	45	45	45	45	
N 铸铁 灰铸铁, 可锻铸铁, 球墨铸铁		≤ 220 Bhn 或 ≤ 19 Hrc	76	RPM	8078	4039	2424	2020	1515	1212
			(61-91)	Fr	0.063	0.126	0.210	0.253	0.337	0.421
				进给(mm/min)	510	510	510	510	510	510
	≤ 330 Bhn 或 ≤ 36 Hrc	59	RPM	6301	3151	1890	1575	1181	945	
		(48-71)	Fr	0.052	0.105	0.175	0.209	0.279	0.349	
			进给(mm/min)	330	330	330	330	330	330	
N 铝合金 2017, 2024, 356, 6061, 7075	≤ 80 Bhn 或 ≤ 47 HRb	165	RPM	17449	8725	5235	4362	3272	2617	
		(132-198)	Fr	0.078	0.156	0.260	0.312	0.416	0.520	
			进给(mm/min)	1360	1360	1360	1360	1360	1360	
	≤ 150 Bhn 或 ≤ 7 Hrc	139	RPM	14703	7351	4411	3676	2757	2205	
		(111-166)	Fr	0.078	0.156	0.261	0.313	0.417	0.521	
			进给(mm/min)	1150	1150	1150	1150	1150	1150	
N 铜合金 铝青铜, C110, 蒙知黄铜	≤ 140 Bhn 或 ≤ 3 Hrc	93	RPM	9856	4928	2957	2464	1848	1478	
		(74-112)	Fr	0.047	0.094	0.157	0.189	0.252	0.315	
			进给(mm/min)	465	465	465	465	465	465	
	≤ 200 Bhn 或 ≤ 23 Hrc	49	RPM	5170	2585	1551	1293	969	776	
		(39-59)	Fr	0.039	0.077	0.129	0.155	0.206	0.258	
			进给(mm/min)	200	200	200	200	200	200	
H 工具钢 A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 250 Bhn 或 ≤ 24 Hrc	26	RPM	2747	1373	824	687	515	412	
		(21-31)	Fr	0.031	0.062	0.103	0.124	0.165	0.206	
			进给(mm/min)	85	85	85	85	85	85	
	≤ 375 Bhn 或 ≤ 40 Hrc	20	RPM	2100	1050	630	525	394	315	
		(16-24)	Fr	0.017	0.033	0.056	0.067	0.089	0.111	
			进给(mm/min)	35	35	35	35	35	35	
	≤ 475 Bhn 或 ≤ 50 Hrc	15	RPM	1616	808	485	404	303	242	
		(12-18)	Fr	0.015	0.031	0.052	0.062	0.083	0.103	
			进给(mm/min)	25	25	25	25	25	25	

Bhn (布氏硬度) Hrc (洛氏硬度) HRb (洛氏硬度)

rpm = (Vc x 1000) / (DC x 3.14)

mm/min = Fr x rpm

使用无涂层钻头时, 转速和进给应减小30%

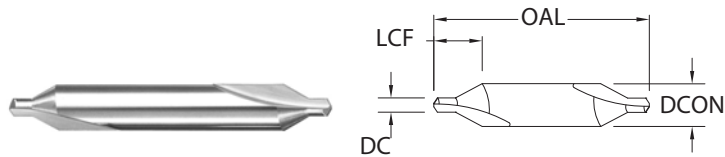
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公制 中心钻



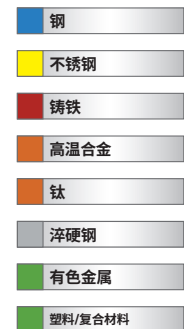
301M 公制系列



mm				EDP订货号	
钻头直径 DC	本体直径 DCON	全长 OAL	槽长 LCF	无涂层	Ti-NAMITE-A (AlTiN)
0,5	3,15	20,0	3,0	67005	67035
0,8	3,15	20,0	3,5	67007	67037
1	3,15	31,5	3,5	67009	67039
1,25	3,15	31,5	4,0	67011	67041
1,6	4,0	35,5	5,0	67013	67043
2	5,0	40,0	6,0	67015	67045
2,5	6,3	45,0	7,0	67017	67047
3,15	8,0	50,0	9,0	67019	67049
4	10,0	56,0	11,0	67021	67051
5	12,5	63,0	14,0	67023	67053

公差 (mm)

DC = +0,076/-0,000
DCON = -0,0025/-0,0127



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301M 系列 公制	硬度	Vc (m/min)	DC · mm						
			1	1.6	2.5	4	5		
P 碳素钢 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 175 Bhn 或 ≤ 7 HRc	81	RPM	8155	6422	4078	2569	2055	
		(65-97)	Fr	0.017	0.022	0.034	0.054	0.068	
			进给(mm/min)	139	139	139	139	139	
	≤ 300 Bhn 或 ≤ 32 HRc	38	RPM	3847	3029	1923	1212	969	
		(30-46)	Fr	0.016	0.020	0.032	0.051	0.064	
			进给(mm/min)	62	62	62	62	62	
	≤ 425 Bhn 或 ≤ 45 HRc	26	RPM	2616	2060	1308	824	659	
		(21-31)	Fr	0.010	0.013	0.020	0.032	0.039	
			进给(mm/min)	26	26	26	26	26	
	M 合金钢 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	≤ 275 Bhn 或 ≤ 28 HRc	70	RPM	7078	5574	3539	2230	1784
			(56-84)	Fr	0.016	0.020	0.032	0.051	0.063
				进给(mm/min)	113	113	113	113	113
≤ 375 Bhn 或 ≤ 40 HRc		44	RPM	4462	3514	2231	1406	1125	
		(35-53)	Fr	0.015	0.019	0.030	0.048	0.060	
			进给(mm/min)	67	67	67	67	67	
≤ 450 Bhn 或 ≤ 48 HRc		18	RPM	1847	1454	923	582	465	
		(15-22)	Fr	0.007	0.009	0.014	0.022	0.028	
			进给(mm/min)	13	13	13	13	13	
K 不锈钢 (易加工) 303, 416, 420F, 430F 440F		≤ 250 Bhn 或 ≤ 24 HRc	64	RPM	6463	5089	3231	2036	1629
			(51-77)	Fr	0.012	0.015	0.024	0.038	0.048
				进给(mm/min)	78	78	78	78	78
	≤ 330 Bhn 或 ≤ 36 HRc	34	RPM	3385	2666	1693	1066	853	
		(27-40)	Fr	0.007	0.009	0.014	0.023	0.028	
			进给(mm/min)	24	24	24	24	24	
	K 不锈钢 (难加工) 304, 316, 321, 13-8 PH, 15-5PH, 17-4 PH, Custom 450	≤ 275 Bhn 或 ≤ 28 HRc	20	RPM	2000	1575	1000	630	504
			(16-24)	Fr	0.009	0.011	0.018	0.029	0.036
				进给(mm/min)	18	18	18	18	18
		≤ 375 Bhn 或 ≤ 40 HRc	17	RPM	1693	1333	846	533	427
			(13-20)	Fr	0.008	0.011	0.017	0.026	0.033
				进给(mm/min)	14	14	14	14	14
K 铸铁 灰铸铁, 可锻铸铁, 球墨铸铁		≤ 220 Bhn 或 ≤ 19 HRc	85	RPM	8617	6786	4309	2714	2171
			(68-102)	Fr	0.021	0.027	0.042	0.067	0.083
				进给(mm/min)	181	181	181	181	181
		≤ 330 Bhn 或 ≤ 36 HRc	76	RPM	7694	6059	3847	2424	1939
			(61-91)	Fr	0.021	0.027	0.042	0.067	0.084
				进给(mm/min)	162	162	162	162	162

续下一页

公制 中心钻

301M 系列 公制	硬度	Vc (m/min)	DC • mm						
			1	1.6	2.5	4	5		
N 铝合金 2017, 2024, 356, 6061, 7075	≤ 80 Bhn 或 ≤ 47 HRb	165	RPM	16619	13087	8309	5235	4188	
		(132-198)	Fr	0.025	0.032	0.050	0.079	0.099	
			进给(mm/min)	415	415	415	415	415	
	≤ 150 Bhn 或 ≤ 7 HRc	139	RPM	14003	11027	7001	4411	3529	
		(111-166)	Fr	0.025	0.032	0.050	0.079	0.099	
			进给(mm/min)	350	350	350	350	350	
	铜合金 铝青铜, C110, 蒙知黄铜	≤ 140 Bhn 或 ≤ 3 HRc	58	RPM	5847	4605	2924	1842	1474
			(46-69)	Fr	0.012	0.015	0.024	0.038	0.048
				进给(mm/min)	70	70	70	70	70
		≤ 200 Bhn 或 ≤ 23 HRc	53	RPM	5386	4241	2693	1696	1357
			(43-64)	Fr	0.012	0.015	0.024	0.038	0.048
				进给(mm/min)	65	65	65	65	65
塑料 聚碳酸酯, PVC	152 (122-183)	RPM	15388	12118	7694	4847	3878		
		Fr	0.025	0.032	0.050	0.079	0.099		
		进给(mm/min)	385	385	385	385	385		
S 高温合金 (镍、钴、铁基) Inconel 601, 617, 625, Incoloy 800, 蒙乃尔 400, Rene, Waspaloy	≤ 220 Bhn 或 ≤ 19 HRc	12	RPM	1231	969	616	388	310	
		(10-15)	Fr	0.009	0.011	0.018	0.028	0.035	
			进给(mm/min)	11	11	11	11	11	
	≤ 320 Bhn 或 ≤ 34 HRc	8	RPM	769	606	385	242	194	
		(6-9)	Fr	0.008	0.010	0.016	0.025	0.031	
			进给(mm/min)	6	6	6	6	6	
	≤ 425 Bhn 或 ≤ 45 HRc	6	RPM	616	485	308	194	155	
		(5-7)	Fr	0.003	0.004	0.006	0.010	0.013	
			进给(mm/min)	2	2	2	2	2	
	钛合金 (难加工) 纯钛, Ti6Al4V, Ti6Al2Sn4Zr2Mo, Ti4Al4Mo2Sn0.5Si, Ti-6Al4V	≤ 275 Bhn 或 ≤ 28 HRc	26	RPM	2616	2060	1308	824	659
			(21-31)	Fr	0.016	0.020	0.032	0.051	0.064
				进给(mm/min)	42	42	42	42	42
≤ 350 Bhn 或 ≤ 38 HRc		20	RPM	2000	1575	1000	630	504	
		(16-24)	Fr	0.009	0.011	0.018	0.029	0.036	
			进给(mm/min)	18	18	18	18	18	
≤ 440 Bhn 或 ≤ 47 HRc	17	RPM	1693	1333	846	533	427		
	(13-20)	Fr	0.008	0.011	0.017	0.026	0.033		
		进给(mm/min)	14	14	14	14	14		
H 工具钢 A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 250 Bhn 或 ≤ 24 HRc	26	RPM	2616	2060	1308	824	659	
		(21-31)	Fr	0.009	0.012	0.018	0.029	0.036	
			进给(mm/min)	24	24	24	24	24	
	≤ 375 Bhn 或 ≤ 40 HRc	17	RPM	1693	1333	846	533	427	
		(13-20)	Fr	0.004	0.005	0.008	0.013	0.016	
			进给(mm/min)	7	7	7	7	7	
	≤ 475 Bhn 或 ≤ 50 HRc	12	RPM	1231	969	616	388	310	
		(10-15)	Fr	0.004	0.005	0.008	0.013	0.016	
进给(mm/min)			5	5	5	5	5		

Bhn (布氏硬度) HRc (洛氏硬度) HRb (洛氏硬度)

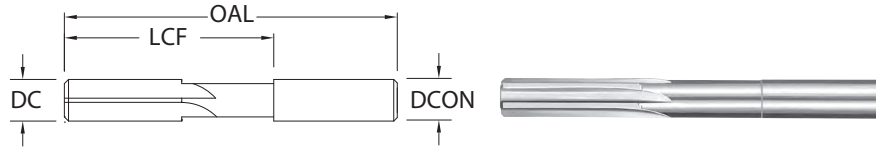
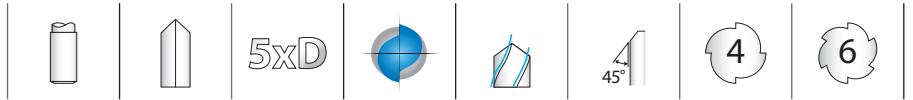
$\text{rpm} = (\text{Vc} \times 1000) / (\text{DCON} \times 3.14)$

$\text{mm/min} = \text{Fr} \times \text{rpm}$

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200
英制系列

公差 (inch)

DC = +0.0002/-0.0000
DCON = +0.0002/-0.0000

- 钢
- 不锈钢
- 铸铁
- 高温合金
- 钛
- 有色金属
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inch					EDP订货号
刃径 DC	柄径 DCON	最大铰孔深度 LCF	全长 OAL	刃数	无涂层
3/64	3/64	3/4	1-1/2	4	70003
1/16	1/16	3/4	1-1/2	4	70004
5/64	5/64	1	2	4	70005
3/32	3/32	1-1/4	2-1/4	4	70006
7/64	7/64	1-1/4	2-1/4	4	70007
1/8	1/8	1-1/4	2-1/4	4	70008
9/64	9/64	1-1/2	2-1/2	4	70009
5/32	5/32	1-1/2	2-1/2	4	70010
11/64	11/64	1-3/4	2-3/4	4	70011
3/16	3/16	1-3/4	2-3/4	4	70012
13/64	13/64	2	3	4	70013
7/32	7/32	2	3	4	70014
15/64	15/64	2	3	4	70015
1/4	1/4	2	3	4	70016
17/64	17/64	2-1/4	3-1/4	6	70017
9/32	9/32	2-1/4	3-1/4	6	70018
19/64	19/64	2-1/4	3-1/4	6	70019
5/16	5/16	2-1/4	3-1/4	6	70020
21/64	21/64	2-3/8	3-1/2	6	70021
11/32	11/32	2-3/8	3-1/2	6	70022
23/64	23/64	2-3/8	3-1/2	6	70023
3/8	3/8	2-3/8	3-1/2	6	70024
25/64	25/64	2-7/8	4	6	70025
13/32	13/32	2-7/8	4	6	70026
27/64	27/64	2-7/8	4	6	70027
7/16	7/16	2-7/8	4	6	70028
29/64	29/64	2-7/8	4	6	70029
15/32	15/32	2-7/8	4	6	70030
31/64	31/64	2-7/8	4	6	70031
1/2	1/2	2-7/8	4	6	70032

续下一页

英制 直槽精密铰刀



200 英制系列

续上一页

刃径 DC	inch			刃数
	柄径 DCON	最大铰孔深度 LCF	全长 OAL	
.0470 – .0625	1/16	3/4	1-1/2	4
.0626 – .0781	5/64	1	2	4
.0782 – .0938	3/32	1-1/4	2-1/4	4
.0939 – .1094	7/64	1-1/4	2-1/4	4
.1095 – .1250	1/8	1-1/4	2-1/4	4
.1251 – .1406	9/64	1-1/2	2-1/2	4
.1407 – .1562	5/32	1-1/2	2-1/2	4
.1563 – .1719	11/64	1-3/4	2-3/4	4
.1720 – .1875	3/16	1-3/4	2-3/4	4
.1876 – .2031	13/64	2	3	4
.2032 – .2188	7/32	2	3	4
.2189 – .2344	15/64	2	3	4
.2345 – .2500	1/4	2	3	4
.2501 – .2656	17/64	2-1/4	3-1/4	6
.2657 – .2812	9/32	2-1/4	3-1/4	6
.2813 – .2969	19/64	2-1/4	3-1/4	6
.2970 – .3125	5/16	2-1/4	3-1/4	6
.3126 – .3281	21/64	2-3/8	3-1/2	6
.3282 – .3438	11/32	2-3/8	3-1/2	6
.3439 – .3594	23/64	2-3/8	3-1/2	6
.3595 – .3750	3/8	2-3/8	3-1/2	6
.3751 – .3906	25/64	2-7/8	4	6
.3907 – .4062	13/32	2-7/8	4	6
.4063 – .4219	27/64	2-7/8	4	6
.4220 – .4375	7/16	2-7/8	4	6
.4376 – .4531	29/64	2-7/8	4	6
.4532 – .4688	15/32	2-7/8	4	6
.4689 – .4844	31/64	2-7/8	4	6
.4845 – .5000	1/2	2-7/8	4	6

公差 (inch)

DC = +0.0002/-0.0000

DCON = +0.0002/-0.0000

SER 200英制铰刀可根据刃径DC的规格范围订购特定直径的铰刀, 请如下订购:

- 200英制格式的刃径规格
 - 即 200.0492
 - 描述: 200系列规格0.0492
 - 对于公制规格转换为英制规格(即: $\div 25.4$)
 - 上述示例为1.25mm规格($1.25 \div 25.4 = 0.0492$)
- 每个表格所示的所有其他尺寸均为英制, 包括柄径。

200 系列 英制	硬度	Vc (sfm)	DC · in								
			1/16	1/8	3/16	1/4	5/16	3/8	1/2		
P 碳素钢 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 175 Bhn 或 ≤ 7 HRc	150	RPM	9168	4584	3056	2292	1834	1528	1146	
		(120-180)	Fr	0.0018	0.0035	0.0053	0.0071	0.0088	0.0106	0.0141	
			进给 (ipm)	16.5	16.0	16.2	16.3	16.1	16.2	16.2	
	≤ 300 Bhn 或 ≤ 32 HRc	75	RPM	4584	2292	1528	1146	917	764	573	
		(60-90)	Fr	0.0016	0.0031	0.0047	0.0062	0.0078	0.0093	0.0124	
			进给 (ipm)	7.3	7.1	7.2	7.1	7.2	7.1	7.1	
	≤ 425 Bhn 或 ≤ 45 HRc	55	RPM	3362	1681	1121	840	672	560	420	
		(44-66)	Fr	0.0009	0.0019	0.0028	0.0037	0.0046	0.0056	0.0074	
			进给 (ipm)	3.0	3.2	3.1	3.1	3.1	3.1	3.1	
	M 合金钢 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	≤ 275 Bhn 或 ≤ 28 HRc	115	RPM	7029	3514	2343	1757	1406	1171	879
			(92-138)	Fr	0.0015	0.0030	0.0045	0.0060	0.0075	0.0090	0.0120
				进给 (ipm)	10.5	10.5	10.5	10.5	10.5	10.5	10.5
≤ 375 Bhn 或 ≤ 40 HRc		70	RPM	4278	2139	1426	1070	856	713	535	
		(56-84)	Fr	0.0015	0.0030	0.0045	0.0060	0.0075	0.0090	0.0120	
			进给 (ipm)	6.4	6.4	6.4	6.4	6.4	6.4	6.4	
≤ 450 Bhn 或 ≤ 48 HRc		45	RPM	2750	1375	917	688	550	458	344	
		(36-54)	Fr	0.0009	0.0019	0.0028	0.0037	0.0046	0.0056	0.0074	
			进给 (ipm)	2.5	2.6	2.6	2.5	2.5	2.6	2.5	
K 不锈钢 (易加工) 303, 416, 420F, 430F 440F		≤ 250 Bhn 或 ≤ 24 HRc	75	RPM	4584	2292	1528	1146	917	764	573
			(60-90)	Fr	0.0010	0.0020	0.0029	0.0039	0.0049	0.0059	0.0078
				进给 (ipm)	4.6	4.6	4.4	4.5	4.5	4.5	4.5
	≤ 330 Bhn 或 ≤ 36 HRc	55	RPM	3362	1681	1121	840	672	560	420	
		(44-66)	Fr	0.0008	0.0015	0.0023	0.0030	0.0038	0.0045	0.0060	
			进给 (ipm)	2.7	2.5	2.6	2.5	2.6	2.5	2.5	
	N 不锈钢 (难加工) 304, 316, 321, 13-8 PH, 15-5PH, 17-4 PH, Custom 450	≤ 275 Bhn 或 ≤ 28 HRc	35	RPM	2139	1070	713	535	428	357	267
			(28-42)	Fr	0.0010	0.0020	0.0029	0.0039	0.0049	0.0059	0.0078
				进给 (ipm)	2.1	2.1	2.1	2.1	2.1	2.1	2.1
		≤ 375 Bhn 或 ≤ 40 HRc	25	RPM	1528	764	509	382	306	255	191
			(20-30)	Fr	0.0006	0.0013	0.0019	0.0025	0.0031	0.0038	0.0050
				进给 (ipm)	0.9	1.0	1.0	1.0	0.9	1.0	1.0
K 铸铁 灰铸铁, 可锻铸铁, 球墨铸铁		≤ 220 Bhn 或 ≤ 19 HRc	125	RPM	7640	3820	2547	1910	1528	1273	955
			(100-150)	Fr	0.0020	0.0040	0.0060	0.0081	0.0101	0.0121	0.0161
				进给 (ipm)	15.3	15.3	15.3	15.5	15.4	15.4	15.4
		≤ 330 Bhn 或 ≤ 36 HRc	95	RPM	5806	2903	1935	1452	1161	968	726
			(76-114)	Fr	0.0020	0.0040	0.0060	0.0081	0.0101	0.0121	0.0161
				进给 (ipm)	11.6	11.6	11.6	11.8	11.7	11.7	11.7
	N 铝合金 2017, 2024, 356, 6061, 7075	≤ 80 Bhn 或 ≤ 47 HRb	270	RPM	16502	8251	5501	4126	3300	2750	2063
			(216-324)	Fr	0.0025	0.0050	0.0075	0.0100	0.0125	0.0150	0.0200
				进给 (ipm)	41.3	41.3	41.3	41.3	41.3	41.3	41.3
		≤ 150 Bhn 或 ≤ 7 HRc	230	RPM	14058	7029	4686	3514	2812	2343	1757
			(184-276)	Fr	0.0025	0.0050	0.0075	0.0100	0.0125	0.0150	0.0200
				进给 (ipm)	35.1	35.1	35.1	35.1	35.1	35.1	35.1
N 铜合金 铝青铜, C110, 蒙知黄铜		≤ 140 Bhn 或 ≤ 3 HRc	115	RPM	7029	3514	2343	1757	1406	1171	879
			(92-138)	Fr	0.0013	0.0026	0.0038	0.0051	0.0064	0.0077	0.0102
				进给 (ipm)	9.1	9.1	8.9	9.0	9.0	9.0	9.0
		≤ 200 Bhn 或 ≤ 23 HRc	95	RPM	5806	2903	1935	1452	1161	968	726
			(76-114)	Fr	0.0013	0.0026	0.0038	0.0051	0.0064	0.0077	0.0102
				进给 (ipm)	7.5	7.5	7.4	7.4	7.4	7.5	7.4

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英制 直槽精密铰刀

200 系列 英制	硬度	Vc (sfm)	DC • in								
			1/16	1/8	3/16	1/4	5/16	3/8	1/2		
S 高温合金 (镍、钴、铁基) Inconel 601, 617, 625, Incoloy 800, 蒙乃尔 400, Rene, Waspaloy	≤ 220 Bhn 或 ≤ 19 HRc	20 (16-24)	RPM	1222	611	407	306	244	204	153	
			Fr	0.0008	0.0015	0.0023	0.0030	0.0038	0.0045	0.0060	
			进给 (ipm)	1.0	0.9	0.9	0.9	0.9	0.9	0.9	
	≤ 320 Bhn 或 ≤ 34 HRc	15 (12-18)	RPM	917	458	306	229	183	153	115	
			Fr	0.0006	0.0013	0.0019	0.0025	0.0031	0.0038	0.0050	
			进给 (ipm)	0.6	0.6	0.6	0.6	0.6	0.6	0.6	
	≤ 425 Bhn 或 ≤ 45 HRc	10 (8-12)	RPM	611	306	204	153	122	102	76	
			Fr	0.0004	0.0007	0.0011	0.0015	0.0018	0.0022	0.0029	
			进给 (ipm)	0.2	0.2	0.2	0.2	0.2	0.2	0.2	
	H 钛合金 纯钛, Ti6Al4V, Ti6Al2Sn4Zr2Mo, Ti4Al4Mo2Sn0.5Si, Ti-6Al4V	≤ 275 Bhn 或 ≤ 28 HRc	45 (36-54)	RPM	2750	1375	917	688	550	458	344
				Fr	0.0015	0.0030	0.0045	0.0060	0.0075	0.0090	0.0120
				进给 (ipm)	4.1	4.1	4.1	4.1	4.1	4.1	4.1
≤ 350 Bhn 或 ≤ 38 HRc		35 (28-42)	RPM	2139	1070	713	535	428	357	267	
			Fr	0.0010	0.0020	0.0029	0.0039	0.0049	0.0059	0.0078	
			进给 (ipm)	2.1	2.1	2.1	2.1	2.1	2.1	2.1	
≤ 440 Bhn 或 ≤ 47 HRc		25 (20-30)	RPM	1528	764	509	382	306	255	191	
			Fr	0.0006	0.0013	0.0019	0.0025	0.0031	0.0038	0.0050	
			进给 (ipm)	0.9	1.0	1.0	1.0	0.9	1.0	1.0	
H 工具钢 A2, D2, H13, L2, M2, P20, S7, T15, W2		≤ 250 Bhn 或 ≤ 24 HRc	40 (32-48)	RPM	2445	1222	815	611	489	407	306
				Fr	0.0010	0.0020	0.0029	0.0039	0.0049	0.0059	0.0078
				进给 (ipm)	2.4	2.4	2.4	2.4	2.4	2.4	2.4
	≤ 375 Bhn 或 ≤ 40 HRc	25 (20-30)	RPM	1528	764	509	382	306	255	191	
			Fr	0.0006	0.0013	0.0019	0.0025	0.0031	0.0038	0.0050	
			进给 (ipm)	0.9	1.0	1.0	1.0	0.9	1.0	1.0	
	≤ 475 Bhn 或 ≤ 50 HRc	20 (16-24)	RPM	1222	611	407	306	244	204	153	
			Fr	0.0004	0.0008	0.0012	0.0016	0.0019	0.0023	0.0031	
			进给 (ipm)	0.5	0.5	0.5	0.5	0.5	0.5	0.5	
	≤ 655 Bhn 或 ≤ 60 HRc	14 (11-17)	RPM	856	428	285	214	171	143	107	
			Fr	0.0003	0.0007	0.0011	0.0014	0.0018	0.0021	0.0028	
			进给 (ipm)	0.3	0.3	0.3	0.3	0.3	0.3	0.3	

Bhn (布氏硬度) HRc (洛氏硬度) HRb (洛氏硬度)

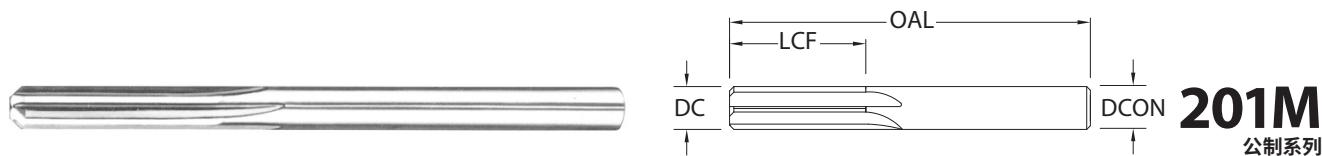
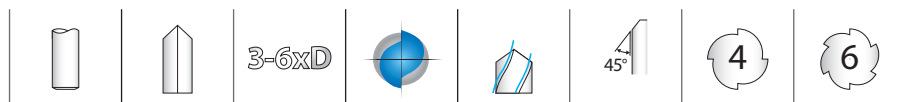
$\text{rpm} = \text{Vc} \times 3.82 / \text{DC}$

$\text{ipm} = \text{Fr} \times \text{rpm}$

使用带涂层铰刀时, 转速和进给应提高30%

加工更硬的材料时, 降低转速和进给

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公差 (mm)

1-6 直径

DC = +0,008/-0,000

>6-10 直径

DC = +0,010/-0,000

- 钢
- 不锈钢
- 铸铁
- 高温合金
- 钛
- 有色金属
- 淬硬钢

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mm					EDP订货号	
刃径 DC	柄径 DCON	最大铰孔深度 LCF	全长 OAL	刃数	无涂层	
1,0	1,0	6,0	32,0	4	81001	
1,5	1,5	9,5	38,0	4	81003	
2,0	2,0	12,7	44,0	4	81005	
2,5	2,5	12,7	50,0	4	81007	
3,0	3,0	16,0	57,0	4	81009	
3,5	3,5	19,0	63,0	4	81011	
4,0	4,0	19,0	63,0	4	81013	
4,5	4,5	22,0	70,0	4	81015	
5,0	5,0	25,0	75,0	4	81017	
5,5	5,5	25,0	75,0	4	81019	
6,0	6,0	25,0	75,0	4	81021	
7,0	7,0	28,0	82,0	6	81023	
8,0	8,0	28,0	82,0	6	81025	
9,0	9,0	31,0	89,0	6	81027	
10,0	10,0	31,0	89,0	6	81029	

公制 直槽铰刀

201M 系列 公制	硬度	Vc (m/min)	DC • mm								
			1	2	3	4	6	8	10		
碳素钢 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 175 Bhn 或 ≤ 7 HRc	46	RPM	14541	7271	4847	3635	2424	1818	1454	
		(37-55)	Fr	0.028	0.056	0.085	0.113	0.169	0.226	0.282	
			进给(mm/min)	410	410	410	410	410	410	410	
	≤ 300 Bhn 或 ≤ 32 HRc	23	RPM	7271	3635	2424	1818	1212	909	727	
		(18-27)	Fr	0.025	0.050	0.074	0.099	0.149	0.198	0.248	
			进给(mm/min)	180	180	180	180	180	180	180	
	≤ 425 Bhn 或 ≤ 45 HRc	17	RPM	5332	2666	1777	1333	889	666	533	
		(13-20)	Fr	0.015	0.030	0.044	0.059	0.089	0.119	0.148	
			进给(mm/min)	79	79	79	79	79	79	79	
	合金钢 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	≤ 275 Bhn 或 ≤ 28 HRc	35	RPM	11148	5574	3716	2787	1858	1394	1115
			(28-42)	Fr	0.024	0.048	0.072	0.096	0.144	0.192	0.240
				进给(mm/min)	268	268	268	268	268	268	268
≤ 375 Bhn 或 ≤ 40 HRc		21	RPM	6786	3393	2262	1696	1131	848	679	
		(17-26)	Fr	0.024	0.048	0.072	0.096	0.144	0.192	0.240	
			进给(mm/min)	163	163	163	163	163	163	163	
≤ 450 Bhn 或 ≤ 48 HRc		14	RPM	4362	2181	1454	1091	727	545	436	
		(11-16)	Fr	0.015	0.030	0.045	0.060	0.089	0.119	0.149	
			进给(mm/min)	65	65	65	65	65	65	65	
不锈钢 (易加工) 303, 416, 420F, 430F 440F		≤ 250 Bhn 或 ≤ 24 HRc	23	RPM	7271	3635	2424	1818	1212	909	727
			(18-27)	Fr	0.015	0.030	0.045	0.059	0.089	0.119	0.149
				进给(mm/min)	108	108	108	108	108	108	108
	≤ 330 Bhn 或 ≤ 36 HRc	17	RPM	5332	2666	1777	1333	889	666	533	
		(13-20)	Fr	0.012	0.024	0.036	0.048	0.072	0.096	0.120	
			进给(mm/min)	64	64	64	64	64	64	64	
不锈钢 (难加工) 304, 316, 321, 13-8 PH, 15-5PH, 17-4 PH, Custom 450	≤ 275 Bhn 或 ≤ 28 HRc	11	RPM	3393	1696	1131	848	565	424	339	
		(9-13)	Fr	0.015	0.029	0.044	0.059	0.088	0.118	0.147	
			进给(mm/min)	50	50	50	50	50	50	50	
	≤ 375 Bhn 或 ≤ 40 HRc	8	RPM	2424	1212	808	606	404	303	242	
		(6-9)	Fr	0.010	0.020	0.030	0.040	0.059	0.079	0.099	
			进给(mm/min)	24	24	24	24	24	24	24	

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201M 系列 公制	硬度	Vc (m/min)	DC • mm							
			1	2	3	4	6	8	10	
K 铸铁 灰铸铁, 可锻铸铁, 球墨铸铁	≤ 220 Bhn 或 ≤ 19 HRc	38	RPM	12118	6059	4039	3029	2020	1515	1212
		(30-46)	Fr	0.032	0.064	0.097	0.129	0.193	0.257	0.322
			进给(mm/min)	390	390	390	390	390	390	390
	≤ 330 Bhn 或 ≤ 36 HRc	29	RPM	9209	4605	3070	2302	1535	1151	921
		(23-35)	Fr	0.032	0.064	0.096	0.128	0.192	0.256	0.320
			进给(mm/min)	295	295	295	295	295	295	295
N 铝合金 2017, 2024, 356, 6061, 7075	≤ 80 Bhn 或 ≤ 47 HRb	82	RPM	26174	13087	8725	6544	4362	3272	2617
		(66-99)	Fr	0.040	0.080	0.120	0.160	0.240	0.320	0.400
			进给(mm/min)	1047	1047	1047	1047	1047	1047	1047
	≤ 150 Bhn 或 ≤ 7 HRc	70	RPM	22297	11148	7432	5574	3716	2787	2230
		(56-84)	Fr	0.040	0.080	0.120	0.160	0.240	0.320	0.400
			进给(mm/min)	892	892	892	892	892	892	892
铜合金 铝青铜, C110, 蒙知黄铜	≤ 140 Bhn 或 ≤ 3 HRc	35	RPM	11148	5574	3716	2787	1858	1394	1115
		(28-42)	Fr	0.020	0.041	0.061	0.081	0.122	0.163	0.204
			进给(mm/min)	227	227	227	227	227	227	227
	≤ 200 Bhn 或 ≤ 23 HRc	29	RPM	9209	4605	3070	2302	1535	1151	921
		(23-35)	Fr	0.020	0.041	0.061	0.082	0.122	0.163	0.204
			进给(mm/min)	188	188	188	188	188	188	188

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公制 直槽铰刀

201M 系列 公制	硬度	Vc (m/min)	DC • mm							
			1	2	3	4	6	8	10	
高温合金 (镍、钴、铁基) Inconel 601, 617, 625, Incoloy 800, 蒙乃尔 400, Rene, Waspaloy	≤ 220 Bhn 或 ≤ 19 HRc	6	RPM	1939	969	646	485	323	242	194
		(5-7)	Fr	0.012	0.024	0.036	0.047	0.071	0.095	0.119
			进给(mm/min)	23	23	23	23	23	23	23
	≤ 320 Bhn 或 ≤ 34 HRc	5	RPM	1454	727	485	364	242	182	145
		(4-5)	Fr	0.010	0.021	0.031	0.041	0.062	0.083	0.103
			进给(mm/min)	15	15	15	15	15	15	15
	≤ 425 Bhn 或 ≤ 45 HRc	3	RPM	969	485	323	242	162	121	97
		(2-4)	Fr	0.006	0.012	0.019	0.025	0.037	0.050	0.062
			进给(mm/min)	6	6	6	6	6	6	6
钛合金 纯钛, Ti6Al4V, Ti6Al2Sn4Zr2Mo, Ti4Al4Mo2Sn0.5Si, Ti-6Al4V	≤ 275 Bhn 或 ≤ 28 HRc	14	RPM	4362	2181	1454	1091	727	545	436
		(11-16)	Fr	0.024	0.048	0.072	0.096	0.144	0.193	0.241
			进给(mm/min)	105	105	105	105	105	105	105
	≤ 350 Bhn 或 ≤ 38 HRc	11	RPM	3393	1696	1131	848	565	424	339
		(9-13)	Fr	0.015	0.029	0.044	0.059	0.088	0.118	0.147
			进给(mm/min)	50	50	50	50	50	50	50
	≤ 440 Bhn 或 ≤ 47 HRc	8	RPM	2424	1212	808	606	404	303	242
		(6-9)	Fr	0.010	0.020	0.030	0.040	0.059	0.079	0.099
			进给(mm/min)	24	24	24	24	24	24	24

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201M 系列 公制	硬度	Vc (m/min)	DC • mm							
			1	2	3	4	6	8	10	
H 工具钢 A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 250 Bhn 或 ≤ 24 HRC	12	RPM	3878	1939	1293	969	646	485	388
		(10-15)	Fr	0.015	0.031	0.046	0.062	0.093	0.124	0.155
			进给(mm/min)	60	60	60	60	60	60	60
	≤ 375 Bhn 或 ≤ 40 HRC	8	RPM	2424	1212	808	606	404	303	242
		(6-9)	Fr	0.010	0.020	0.030	0.040	0.059	0.079	0.099
			进给(mm/min)	24	24	24	24	24	24	24
	≤ 475 Bhn 或 ≤ 50 HRC	6	RPM	1939	969	646	485	323	242	194
		(5-7)	Fr	0.006	0.012	0.019	0.025	0.037	0.050	0.062
			进给(mm/min)	12	12	12	12	12	12	12
	≤ 655 Bhn 或 ≤ 60 HRC	4	RPM	1272	636	424	318	212	159	127
		(3-5)	Fr	0.006	0.013	0.019	0.025	0.038	0.050	0.063
			进给(mm/min)	8	8	8	8	8	8	8

Bhn (布氏硬度) HRC (洛氏硬度) HRb (洛氏硬度)

$rpm = (Vc \times 1000) / (DC \times 3.14)$

$mm/min = Fr \times rpm$

使用带涂层铰刀时, 转速和进给应提高30%

加工更硬的材料时, 降低转速和进给

获取更多技术信息, 请参考SGS刀具向导SGS Tool Wizard® (www.kyocera.com.cn)