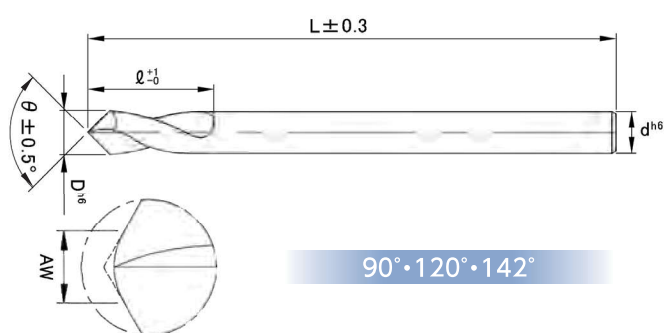
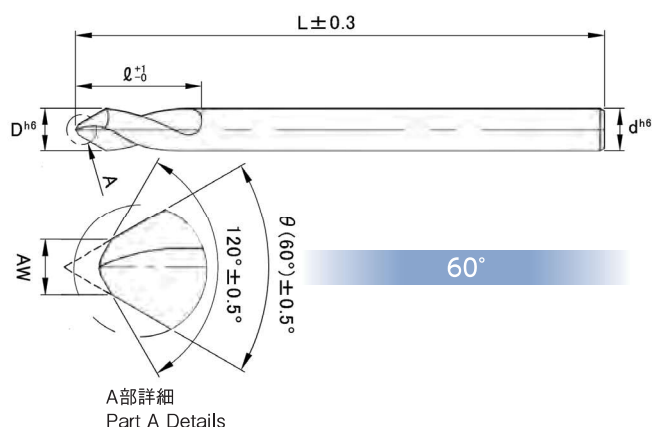




超硬 ロングシャンクポイントセットドリル

Coated Solid Carbide Long Shank Point Set Drills



特長 Feature

- 独自の刃先設計により、溝が深く低抵抗で切り屑の排出がスムーズ
- 切り屑残りが少なく、高速加工でも安定した性能を発揮
- 加工中の熱でも硬化しにくい材料、長寿命で切削精度も良好
- モミツケに最適

- Unique cutting edge design with deep grooves and low resistance is adopted to enable smooth chip evacuation.
- Cutting chips are less likely to remain, providing stable performance even during high-speed machining.
- It does not harden easily even with the heat generated during machining, achieving excellent cutting accuracy and a long tool life.
- Ideal for spot cutting.

単位: mm

商品コード Item Code	θ	D	D公差 Tolerance of D	AW (MAX)	ℓ	L	d
C-DJ-PSD-V 3X60°	60°	3	0~-0.006	0.75	10	60	3
C-DJ-PSD-V 4X60°	60°	4	0~-0.008	1.00	12	75	4
C-DJ-PSD-V 5X60°	60°	5	0~-0.008	1.20	14	75	5
C-DJ-PSD-V 6X60°	60°	6	0~-0.008	1.40	16	100	6
C-DJ-PSD-V 8X60°	60°	8	0~-0.009	1.85	20	100	8
C-DJ-PSD-V 10X60°	60°	10	0~-0.009	2.25	25	120	10
C-DJ-PSD-V 12X60°	60°	12	0~-0.011	3.00	30	120	12
C-DJ-PSD-V 16X60°	60°	16	0~-0.011	3.50	35	150	16
C-DJ-PSD-V 3X90°	90°	3	0~-0.006	0.85	10	60	3
C-DJ-PSD-V 4X90°	90°	4	0~-0.008	1.10	12	75	4
C-DJ-PSD-V 5X90°	90°	5	0~-0.008	1.25	14	75	5
C-DJ-PSD-V 6X90°	90°	6	0~-0.008	1.50	16	100	6
C-DJ-PSD-V 8X90°	90°	8	0~-0.009	2.00	20	100	8
C-DJ-PSD-V 10X90°	90°	10	0~-0.009	2.50	25	120	10
C-DJ-PSD-V 12X90°	90°	12	0~-0.011	3.00	30	120	12
C-DJ-PSD-V 16X90°	90°	16	0~-0.011	4.00	35	150	16

商品コード Item Code	θ	D	D公差 Tolerance of D	AW (MAX)	ℓ	L	d
C-DJ-PSD-V 3X120°	120°	3	0~-0.006	1.10	10	60	3
C-DJ-PSD-V 4X120°	120°	4	0~-0.008	1.30	12	75	4
C-DJ-PSD-V 5X120°	120°	5	0~-0.008	1.50	14	75	5
C-DJ-PSD-V 6X120°	120°	6	0~-0.008	1.80	16	100	6
C-DJ-PSD-V 8X120°	120°	8	0~-0.009	2.40	20	100	8
C-DJ-PSD-V 10X120°	120°	10	0~-0.009	3.00	25	120	10
C-DJ-PSD-V 12X120°	120°	12	0~-0.011	3.50	30	120	12
C-DJ-PSD-V 16X120°	120°	16	0~-0.011	4.50	35	150	16
C-DJ-PSD-V 3X142°	142°	3	0~-0.006	1.10	10	60	3
C-DJ-PSD-V 4X142°	142°	4	0~-0.008	1.30	12	75	4
C-DJ-PSD-V 5X142°	142°	5	0~-0.008	1.50	14	75	5
C-DJ-PSD-V 6X142°	142°	6	0~-0.008	1.80	16	100	6
C-DJ-PSD-V 8X142°	142°	8	0~-0.009	2.40	20	100	8
C-DJ-PSD-V 10X142°	142°	10	0~-0.009	3.00	25	120	10
C-DJ-PSD-V 12X142°	142°	12	0~-0.011	3.50	30	120	12
C-DJ-PSD-V 16X142°	142°	16	0~-0.011	4.50	35	150	16



■標準切削条件表 (モミツケ) Recommended cutting conditions (Spot Cutting)

被削材 Work	一般鋼 SS400/S50C (HB≤200)		合金鋼 SCM400 (20~30HRC)		工具鋼 SKD61/NAK/HPM (30~40HRC)		ステンレス鋼 SUS304/SUS316		アルミ合金/非鉄金属 Aluminum Nonferrous Alloy	
	回転数 n(min ⁻¹)	送り速度 F(mm/rev)	回転数 n(min ⁻¹)	送り速度 F(mm/rev)	回転数 n(min ⁻¹)	送り速度 F(mm/rev)	回転数 n(min ⁻¹)	送り速度 F(mm/rev)	回転数 n(min ⁻¹)	送り速度 F(mm/rev)
D										
3	4,770	290	2,880	170	1,440	65	1,440	65	7,200	540
4	3,600	290	2,160	160	1,080	65	1,080	65	5,400	540
5	2,880	290	1,710	160	860	60	860	60	4,320	540
6	2,430	290	1,440	150	720	60	720	60	3,600	540
8	1,800	270	1,080	140	540	60	540	60	2,700	540
10	1,440	260	864	120	430	60	430	60	2,160	430
12	1,170	230	720	110	360	50	360	50	1,800	400
16	900	220	540	100	270	50	270	50	1,350	350

■標準切削条件表 (面取り) Recommended cutting conditions (Chamfering)

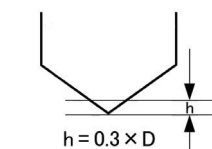
被削材 Work	一般鋼 SS400/S50C (HB≤200)		合金鋼 SCM400 (20~30HRC)		工具鋼 SKD61/NAK/HPM (30~40HRC)		ステンレス鋼 SUS304/SUS316		アルミ合金/非鉄金属 Aluminum Nonferrous Alloy	
	回転数 n(min ⁻¹)	送り速度 F(mm/rev)	回転数 n(min ⁻¹)	送り速度 F(mm/rev)	回転数 n(min ⁻¹)	送り速度 F(mm/rev)	回転数 n(min ⁻¹)	送り速度 F(mm/rev)	回転数 n(min ⁻¹)	送り速度 F(mm/rev)
D										
3	4,770	180	2,880	90	1,440	40	1,440	40	7,200	360
4	3,600	180	2,160	90	1,080	40	1,080	40	5,400	360
5	2,880	180	1,710	90	860	40	860	40	4,320	360
6	2,430	180	1,440	90	720	40	720	40	3,600	360
8	1,800	180	1,080	90	540	40	540	40	2,700	360
10	1,440	180	864	90	430	40	430	40	2,160	360
12	1,170	180	720	90	360	40	360	40	1,800	360
16	900	160	540	90	270	40	270	40	1,350	360

※切削条件はあくまでも目安です。使用される機械、チャックの剛性や切削油等の状況によって変動致します。

These conditions are for general guidance. Therefore they are subject to change to the situation of the machine used, the tool hold rigidity, cutting oil, etc.

■横走り時の加工範囲の目安

Guideline for machining range during side cutting



形状が出ないため、
先端からh以上の位置から使用してください。
(MAX取代: 3mm以下)

As it will not form the correct shape,
please use it from a position at least h from the tip.
(MAX cutting depth: 3mm or less)

一般鋼/鋳鉄 S45C, FC HRC ≤ 20	合金鋼/調質鋼 SCM400 HRC 20 ~ 30	工具鋼/熱処理鋼 SKD61, NAK HRC 30 ~ 40	ステンレス鋼 Stainless Steel	アルミ合金 Aluminum Rolled
◎	◎	○	○	○