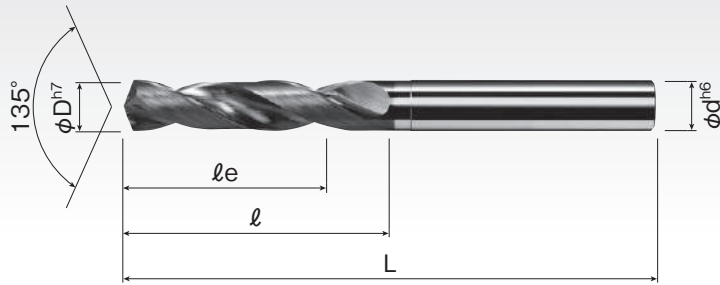


# SDOX3A

超硬鋼用ソリッドドリル(オイルホール付) 3D用  
Solid Carbide Drills for Steels (High Power Type)

先端角 Point Angle	表面処理 Surface Treatment	切削条件 Cutting Conditions
<b>135°</b>	<b>OK-A Premium</b>	<b>P81</b>



- 内部給油仕様 (OH付)  
Internal cooling
- 3D用  
3D type
- ステンレス鋼や難削材の加工に最適!  
Most suitable for the processing of stainless steel and difficult-to-cut materials!
- 新設計の先端形状と新型フルート形状によりスムーズな切粉排出を実現  
Newly-designed nose shape and a new flute shape, help Chip smoothly away.

品番 Product No.	寸法 Size					標準価格 Standard price ¥
	刃径 D	有効長さ le	溝長 l	全長 L	柄径 d	
SDOX3A030	3.0	9	18	68	3	6,100
SDOX3A031	3.1	11	20	72	4	6,400
SDOX3A032	3.2	11	20	72	4	6,400
SDOX3A033	3.3	11	20	72	4	6,400
SDOX3A034	3.4	10	20	72	4	6,400
SDOX3A035	3.5	10	20	72	4	6,400
SDOX3A036	3.6	13	23	72	4	6,600
SDOX3A037	3.7	13	23	72	4	6,600
SDOX3A038	3.8	13	23	72	4	6,600
SDOX3A0385	3.85	13	23	72	4	6,600
SDOX3A039	3.9	12	23	72	4	6,600
SDOX3A040	4.0	12	23	72	4	6,600
SDOX3A041	4.1	14	25	80	5	6,900
SDOX3A042	4.2	14	25	80	5	6,900
SDOX3A043	4.3	14	25	80	5	6,900
SDOX3A044	4.4	14	25	80	5	6,900
SDOX3A045	4.5	13	25	80	5	6,900
SDOX3A046	4.6	16	28	80	5	7,100
SDOX3A047	4.7	16	28	80	5	7,100
SDOX3A048	4.8	16	28	80	5	7,100
SDOX3A0485	4.85	16	28	80	5	7,100
SDOX3A049	4.9	16	28	80	5	7,100
SDOX3A050	5.0	16	28	80	5	7,100
SDOX3A051	5.1	17	30	82	6	8,200
SDOX3A052	5.2	17	30	82	6	8,200
SDOX3A053	5.3	17	30	82	6	8,200
SDOX3A054	5.4	17	30	82	6	8,200
SDOX3A055	5.5	17	30	82	6	8,200
SDOX3A056	5.6	18	32	82	6	8,800
SDOX3A057	5.7	18	32	82	6	8,800
SDOX3A058	5.8	18	32	82	6	8,800
SDOX3A0585	5.85	18	32	82	6	8,800
SDOX3A059	5.9	18	32	82	6	8,800
SDOX3A060	6.0	18	32	82	6	8,800
SDOX3A061	6.1	21	35	88	7	9,700
SDOX3A062	6.2	20	35	88	7	9,700

品番 Product No.	寸法 Size					標準価格 Standard price ¥
	刃径 D	有効長さ le	溝長 l	全長 L	柄径 d	
SDOX3A063	6.3	20	35	88	7	9,700
SDOX3A064	6.4	20	35	88	7	9,700
SDOX3A065	6.5	20	35	88	7	9,700
SDOX3A066	6.6	22	37	88	7	10,300
SDOX3A067	6.7	21	37	88	7	10,300
SDOX3A068	6.8	21	37	88	7	10,300
SDOX3A0685	6.85	21	37	88	7	10,300
SDOX3A069	6.9	21	37	88	7	10,300
SDOX3A070	7.0	21	37	88	7	10,300
SDOX3A071	7.1	24	40	94	8	10,900
SDOX3A072	7.2	24	40	94	8	10,900
SDOX3A073	7.3	24	40	94	8	10,900
SDOX3A074	7.4	23	40	94	8	10,900
SDOX3A075	7.5	23	40	94	8	10,900
SDOX3A076	7.6	24	41	94	8	12,400
SDOX3A077	7.7	24	41	94	8	12,400
SDOX3A078	7.8	24	41	94	8	12,400
SDOX3A0785	7.85	24	41	94	8	12,400
SDOX3A079	7.9	24	41	94	8	12,400
SDOX3A080	8.0	24	41	94	8	12,400
SDOX3A081	8.1	26	44	100	9	13,100
SDOX3A082	8.2	26	44	100	9	13,100
SDOX3A083	8.3	26	44	100	9	13,100
SDOX3A084	8.4	26	44	100	9	13,100
SDOX3A085	8.5	26	44	100	9	13,100
SDOX3A086	8.6	28	46	100	9	13,900
SDOX3A087	8.7	27	46	100	9	13,900
SDOX3A088	8.8	27	46	100	9	13,900
SDOX3A0885	8.85	27	46	100	9	13,900
SDOX3A089	8.9	27	46	100	9	13,900
SDOX3A090	9.0	27	46	100	9	13,900
SDOX3A091	9.1	29	48	106	10	14,800
SDOX3A092	9.2	29	48	106	10	14,800
SDOX3A093	9.3	29	48	106	10	14,800
SDOX3A094	9.4	28	48	106	10	14,800
SDOX3A095	9.5	28	48	106	10	14,800

品番 Product No.	寸法 Size					標準価格 Standard price ¥
	刃径 D	有効深さ ℓ <sub>e</sub>	溝長 ℓ	全長 L	柄径 d	
SDOX3A096	9.6	30	50	106	10	15,100
SDOX3A097	9.7	30	50	106	10	15,100
SDOX3A098	9.8	30	50	106	10	15,100
SDOX3A0985	9.85	30	50	106	10	15,100
SDOX3A099	9.9	30	50	106	10	15,100
SDOX3A100	10.0	30	50	106	10	15,100
SDOX3A101	10.1	32	53	116	11	17,500
SDOX3A102	10.2	32	53	116	11	17,500
SDOX3A103	10.3	32	53	116	11	17,500
SDOX3A104	10.4	32	53	116	11	17,500
SDOX3A105	10.5	32	53	116	11	17,500
SDOX3A106	10.6	34	55	116	11	18,300
SDOX3A107	10.7	33	55	116	11	18,300
SDOX3A108	10.8	33	55	116	11	18,300
SDOX3A1085	10.85	33	55	116	11	18,300
SDOX3A109	10.9	33	55	116	11	18,300
SDOX3A110	11.0	33	55	116	11	18,300
SDOX3A111	11.1	36	58	122	12	19,200
SDOX3A112	11.2	36	58	122	12	19,200

品番 Product No.	寸法 Size					標準価格 Standard price ¥
	刃径 D	有効深さ ℓ <sub>e</sub>	溝長 ℓ	全長 L	柄径 d	
SDOX3A113	11.3	36	58	122	12	19,200
SDOX3A114	11.4	35	58	122	12	19,200
SDOX3A115	11.5	35	58	122	12	19,200
SDOX3A116	11.6	37	60	122	12	20,200
SDOX3A117	11.7	37	60	122	12	20,200
SDOX3A118	11.8	37	60	122	12	20,200
SDOX3A1185	11.85	37	60	122	12	20,200
SDOX3A119	11.9	37	60	122	12	20,200
SDOX3A120	12.0	37	60	122	12	20,200
SDOX3A121	12.1	39	63	128	13	21,700
SDOX3A122	12.2	39	63	128	13	21,700
SDOX3A123	12.3	39	63	128	13	21,700
SDOX3A124	12.4	39	63	128	13	21,700
SDOX3A125	12.5	39	63	128	13	21,700
SDOX3A126	12.6	41	65	128	13	22,600
SDOX3A127	12.7	40	65	128	13	22,600
SDOX3A128	12.8	40	65	128	13	22,600
SDOX3A129	12.9	40	65	128	13	22,600
SDOX3A130	13.0	40	65	128	13	22,600

リーマ
エンドミル
ドリル
面取り/ 座ぐり
メタルソー
カッター

### SDOX3A:推奨切削条件

#### Recommended Drilling Conditions for SDOX3A

被削材 Work Material	一般構造用鋼・炭素鋼・ダイス鋼・ねずみ鉄 Structural Steels, Carbon Steels, Cast Iron SS400,S55C,SK,SKD,FC						合金鋼・ダクタイル鑄鉄 Alloy Steels, Ductile Cast Iron (SCM,NAK,FC)		オーステナイト系ステンレス鋼 Austenitic Stainless Steels (SUS302,304)	
	~30HRC		30~45HRC		45~55HRC		70~100 m/min		40~80 m/min	
切削速度 Cutting Speed	100~130 m/min		60~80 m/min		30~40 m/min		70~100 m/min		40~80 m/min	
切削条件 Cutting Condition φD (mm)	回転数 Spindle Speed (rpm)	送り Feed (mm/rev)	回転数 Spindle Speed (rpm)	送り Feed (mm/rev)	回転数 Spindle Speed (rpm)	送り Feed (mm/rev)	回転数 Spindle Speed (rpm)	送り Feed (mm/rev)	回転数 Spindle Speed (rpm)	送り Feed (mm/rev)
	3	12,700	0.09	7,500	0.09	3,700	0.07	9,600	0.09	6,400
4	9,600	0.12	5,600	0.12	2,800	0.08	7,200	0.12	4,800	0.10
6	6,400	0.16	3,700	0.16	1,850	0.12	4,800	0.18	3,200	0.15
8	4,800	0.22	2,800	0.22	1,400	0.16	3,600	0.22	2,400	0.19
10	3,800	0.25	2,250	0.25	1,100	0.18	2,900	0.25	1,900	0.21
12	3,200	0.25	1,850	0.25	940	0.22	2,400	0.25	1,600	0.23

### タップ下穴表 DRILL DIAMETERS FOR TAPPING

#### メートル並目ネジ Metric coarse thread

ネジサイズ Nominal	ドリル径 Drill diameter
M4x0.7	3.3
M5x0.8	4.2
M6x1.0	5.0
M7x1.0	6.0
M8x1.25	6.8
M9x1.25	7.8
M10x1.5	8.5
M11x1.5	9.5
M12x1.75	10.3
M14x2.0	12.0

#### メートル細目ネジ Metric fine screw thread

ネジサイズ Nominal	ドリル径 Drill diameter
M4x0.5	3.5
M5x0.5	4.5
M6x0.75	5.3
M7x0.75	6.3
M8x1.0	7.0
M8x0.75	7.3
M9x1.0	8.0
M9x0.75	8.3
M10x1.25	8.8
M10x1.0	9.0

ネジサイズ Nominal	ドリル径 Drill diameter
M10x0.75	9.3
M11x1.0	10.0
M11x0.75	10.3
M12x1.5	10.5
M12x1.25	10.8
M12x1.0	11.0
M14x1.5	12.5
M14x1.0	13.0