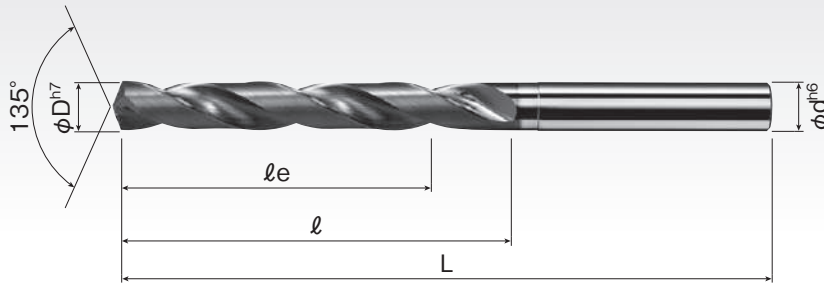


SDOX5A

超硬鋼用ソリッドドリル(オイルホール付) 5D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
135°	OK-A Premium	P83

- 内部給油仕様 (OH付)
Internal cooling
- 5D用
5D 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	
SDOX5A030	3.0	18	28	78	3	7,500
SDOX5A031	3.1	22	32	86	4	8,000
SDOX5A032	3.2	22	32	86	4	8,000
SDOX5A033	3.3	22	32	86	4	8,000
SDOX5A034	3.4	21	32	86	4	8,000
SDOX5A035	3.5	21	32	86	4	8,000
SDOX5A036	3.6	25	36	86	4	8,200
SDOX5A037	3.7	25	36	86	4	8,200
SDOX5A038	3.8	25	36	86	4	8,200
SDOX5A0385	3.85	25	36	86	4	8,200
SDOX5A039	3.9	25	36	86	4	8,200
SDOX5A040	4.0	25	36	86	4	8,200
SDOX5A041	4.1	28	40	98	5	8,500
SDOX5A042	4.2	28	40	98	5	8,500
SDOX5A043	4.3	28	40	98	5	8,500
SDOX5A044	4.4	28	40	98	5	8,500
SDOX5A045	4.5	28	40	98	5	8,500
SDOX5A046	4.6	32	44	98	5	8,700
SDOX5A047	4.7	31	44	98	5	8,700
SDOX5A048	4.8	31	44	98	5	8,700
SDOX5A0485	4.85	31	44	98	5	8,700
SDOX5A049	4.9	31	44	98	5	8,700
SDOX5A050	5.0	31	44	98	5	8,700
SDOX5A051	5.1	31	44	100	6	10,200
SDOX5A052	5.2	31	44	100	6	10,200
SDOX5A053	5.3	31	44	100	6	10,200
SDOX5A054	5.4	30	44	100	6	10,200
SDOX5A055	5.5	30	44	100	6	10,200
SDOX5A056	5.6	34	48	100	6	10,900
SDOX5A057	5.7	34	48	100	6	10,900
SDOX5A058	5.8	34	48	100	6	10,900
SDOX5A0585	5.85	34	48	100	6	10,900
SDOX5A059	5.9	34	48	100	6	10,900
SDOX5A060	6.0	34	48	100	6	10,900
SDOX5A061	6.1	37	52	109	7	11,400
SDOX5A062	6.2	37	52	109	7	11,400

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	
SDOX5A063	6.3	37	52	109	7	11,400
SDOX5A064	6.4	37	52	109	7	11,400
SDOX5A065	6.5	37	52	109	7	11,400
SDOX5A066	6.6	41	56	109	7	12,000
SDOX5A067	6.7	40	56	109	7	12,000
SDOX5A068	6.8	40	56	109	7	12,000
SDOX5A0685	6.85	40	56	109	7	12,000
SDOX5A069	6.9	40	56	109	7	12,000
SDOX5A070	7.0	40	56	109	7	12,000
SDOX5A071	7.1	44	60	118	8	12,800
SDOX5A072	7.2	44	60	118	8	12,800
SDOX5A073	7.3	44	60	118	8	12,800
SDOX5A074	7.4	43	60	118	8	12,800
SDOX5A075	7.5	43	60	118	8	12,800
SDOX5A076	7.6	47	64	118	8	14,500
SDOX5A077	7.7	47	64	118	8	14,500
SDOX5A078	7.8	47	64	118	8	14,500
SDOX5A0785	7.85	47	64	118	8	14,500
SDOX5A079	7.9	47	64	118	8	14,500
SDOX5A080	8.0	47	64	118	8	14,500
SDOX5A081	8.1	50	68	127	9	15,300
SDOX5A082	8.2	50	68	127	9	15,300
SDOX5A083	8.3	50	68	127	9	15,300
SDOX5A084	8.4	50	68	127	9	15,300
SDOX5A085	8.5	50	68	127	9	15,300
SDOX5A086	8.6	54	72	127	9	16,300
SDOX5A087	8.7	53	72	127	9	16,300
SDOX5A088	8.8	53	72	127	9	16,300
SDOX5A0885	8.85	53	72	127	9	16,300
SDOX5A089	8.9	53	72	127	9	16,300
SDOX5A090	9.0	53	72	127	9	16,300
SDOX5A091	9.1	57	76	136	10	17,300
SDOX5A092	9.2	57	76	136	10	17,300
SDOX5A093	9.3	57	76	136	10	17,300
SDOX5A094	9.4	56	76	136	10	17,300
SDOX5A095	9.5	56	76	136	10	17,300

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	
SDOX5A096	9.6	60	80	136	10	17,800
SDOX5A097	9.7	60	80	136	10	17,800
SDOX5A098	9.8	60	80	136	10	17,800
SDOX5A0985	9.85	60	80	136	10	17,800
SDOX5A099	9.9	60	80	136	10	17,800
SDOX5A100	10.0	60	80	136	10	17,800
SDOX5A101	10.1	63	84	149	11	20,500
SDOX5A102	10.2	63	84	149	11	20,500
SDOX5A103	10.3	63	84	149	11	20,500
SDOX5A104	10.4	63	84	149	11	20,500
SDOX5A105	10.5	63	84	149	11	20,500
SDOX5A106	10.6	67	88	149	11	21,500
SDOX5A107	10.7	66	88	149	11	21,500
SDOX5A108	10.8	66	88	149	11	21,500
SDOX5A1085	10.85	66	88	149	11	21,500
SDOX5A109	10.9	66	88	149	11	21,500
SDOX5A110	11.0	66	88	149	11	21,500
SDOX5A111	11.1	70	92	158	12	22,500
SDOX5A112	11.2	70	92	158	12	22,500

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	
SDOX5A113	11.3	70	92	158	12	22,500
SDOX5A114	11.4	69	92	158	12	22,500
SDOX5A115	11.5	69	92	158	12	22,500
SDOX5A116	11.6	73	96	158	12	23,700
SDOX5A117	11.7	73	96	158	12	23,700
SDOX5A118	11.8	73	96	158	12	23,700
SDOX5A1185	11.85	73	96	158	12	23,700
SDOX5A119	11.9	73	96	158	12	23,700
SDOX5A120	12.0	73	96	158	12	23,700
SDOX5A121	12.1	76	100	167	13	25,500
SDOX5A122	12.2	76	100	167	13	25,500
SDOX5A123	12.3	76	100	167	13	25,500
SDOX5A124	12.4	76	100	167	13	25,500
SDOX5A125	12.5	76	100	167	13	25,500
SDOX5A126	12.6	80	104	167	13	26,600
SDOX5A127	12.7	79	104	167	13	26,600
SDOX5A128	12.8	79	104	167	13	26,600
SDOX5A129	12.9	79	104	167	13	26,600
SDOX5A130	13.0	79	104	167	13	26,600

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

SDOX5A:推奨切削条件

Recommended Drilling Conditions for SDOX5A

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・ダクタイル鉄 Alloy Steels, Ductile Cast Iron (SCM, NAK, FCD)		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