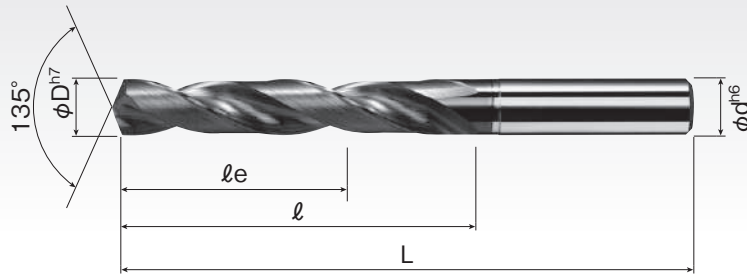


SDX4A

超硬鋼用ソリッドドリル(強力型) 4D用

Solid Carbide Drills for Steels (High Power Type) 4D Type



- 外部給油仕様
External cooling
- 4D用
4D type
- 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 ℓ _e	溝長 ℓ	全長 L	柄径 d	
SDX4A030	3.0	15	25	68	4	4,100
SDX4A031	3.1	15	25	68	4	5,100
SDX4A032	3.2	15	25	68	4	5,100
SDX4A033	3.3	15	25	68	4	5,100
SDX4A034	3.4	14	25	68	4	5,100
SDX4A035	3.5	14	25	68	4	5,100
SDX4A036	3.6	17	28	68	4	5,100
SDX4A037	3.7	17	28	68	4	5,100
SDX4A038	3.8	17	28	68	4	5,100
SDX4A0385	3.85	17	28	68	4	5,100
SDX4A039	3.9	17	28	68	4	5,100
SDX4A040	4.0	17	28	68	4	5,100
SDX4A041	4.1	20	32	75	5	5,300
SDX4A042	4.2	20	32	75	5	5,300
SDX4A043	4.3	20	32	75	5	5,300
SDX4A044	4.4	20	32	75	5	5,300
SDX4A045	4.5	20	32	75	5	5,300
SDX4A046	4.6	26	38	75	5	5,800
SDX4A047	4.7	25	38	75	5	5,800
SDX4A048	4.8	25	38	75	5	5,800
SDX4A0485	4.85	25	38	75	5	5,800
SDX4A049	4.9	25	38	75	5	5,800
SDX4A050	5.0	25	38	75	5	5,800
SDX4A051	5.1	31	44	79	6	6,300
SDX4A052	5.2	31	44	79	6	6,300
SDX4A053	5.3	31	44	79	6	6,300
SDX4A054	5.4	30	44	79	6	6,300
SDX4A055	5.5	30	44	79	6	6,300
SDX4A056	5.6	30	44	79	6	6,800
SDX4A057	5.7	30	44	79	6	6,800
SDX4A058	5.8	30	44	79	6	6,800
SDX4A0585	5.85	30	44	79	6	6,800
SDX4A059	5.9	30	44	79	6	6,800
SDX4A060	6.0	30	44	79	6	6,800
SDX4A061	6.1	35	50	88	7	7,200
SDX4A062	6.2	35	50	88	7	7,200

品番 Product No.	寸法 Size					標準価格 Standard price ¥
	刃径 D	有効長さ ℓ _e	溝長 ℓ	全長 L	柄径 d	
SDX4A063	6.3	35	50	88	7	7,200
SDX4A064	6.4	35	50	88	7	7,200
SDX4A065	6.5	35	50	88	7	7,200
SDX4A066	6.6	36	51	88	7	7,500
SDX4A067	6.7	35	51	88	7	7,500
SDX4A068	6.8	35	51	88	7	7,500
SDX4A0685	6.85	35	51	88	7	7,500
SDX4A069	6.9	35	51	88	7	7,500
SDX4A070	7.0	35	51	88	7	7,500
SDX4A071	7.1	36	52	88	8	8,000
SDX4A072	7.2	36	52	88	8	8,000
SDX4A073	7.3	36	52	88	8	8,000
SDX4A074	7.4	35	52	88	8	8,000
SDX4A075	7.5	35	52	88	8	8,000
SDX4A076	7.6	36	53	88	8	8,000
SDX4A077	7.7	36	53	88	8	8,000
SDX4A078	7.8	36	53	88	8	8,000
SDX4A0785	7.85	36	53	88	8	8,000
SDX4A079	7.9	36	53	88	8	8,000
SDX4A080	8.0	36	53	88	8	8,000
SDX4A081	8.1	43	61	98	9	9,000
SDX4A082	8.2	43	61	98	9	9,000
SDX4A083	8.3	43	61	98	9	9,000
SDX4A084	8.4	43	61	98	9	9,000
SDX4A085	8.5	43	61	98	9	9,000
SDX4A086	8.6	43	61	98	9	9,000
SDX4A087	8.7	42	61	98	9	9,000
SDX4A088	8.8	42	61	98	9	9,000
SDX4A0885	8.85	42	61	98	9	9,000
SDX4A089	8.9	42	61	98	9	9,000
SDX4A090	9.0	42	61	98	9	9,000
SDX4A091	9.1	42	61	98	10	10,100
SDX4A092	9.2	42	61	98	10	10,100
SDX4A093	9.3	42	61	98	10	10,100
SDX4A094	9.4	41	61	98	10	10,100
SDX4A095	9.5	41	61	98	10	10,100

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

品番 Product No.	寸法 Size					標準価格 Standard price ¥
	刃径 D	有効深さ ℓe	溝長 ℓ	全長 L	柄径 d	
SDX4A096	9.6	41	61	98	10	10,100
SDX4A097	9.7	41	61	98	10	10,100
SDX4A098	9.8	41	61	98	10	10,100
SDX4A0985	9.85	41	61	98	10	10,100
SDX4A099	9.9	41	61	98	10	10,100
SDX4A100	10.0	41	61	98	10	10,100
SDX4A101	10.1	50	71	120	11	11,700
SDX4A102	10.2	50	71	120	11	11,700
SDX4A103	10.3	50	71	120	11	11,700
SDX4A104	10.4	50	71	120	11	11,700
SDX4A105	10.5	50	71	120	11	11,700
SDX4A106	10.6	50	71	120	11	11,700
SDX4A107	10.7	49	71	120	11	11,700
SDX4A108	10.8	49	71	120	11	11,700
SDX4A1085	10.85	49	71	120	11	11,700
SDX4A109	10.9	49	71	120	11	11,700
SDX4A110	11.0	49	71	120	11	11,700
SDX4A111	11.1	52	74	120	12	13,200
SDX4A112	11.2	52	74	120	12	13,200
SDX4A113	11.3	52	74	120	12	13,200
SDX4A114	11.4	51	74	120	12	13,200
SDX4A115	11.5	51	74	120	12	13,200
SDX4A116	11.6	51	74	120	12	13,200
SDX4A117	11.7	51	74	120	12	13,200
SDX4A118	11.8	51	74	120	12	13,200
SDX4A1185	11.85	51	74	120	12	13,200

品番 Product No.	寸法 Size					標準価格 Standard price ¥
	刃径 D	有効深さ ℓe	溝長 ℓ	全長 L	柄径 d	
SDX4A119	11.9	51	74	120	12	13,200
SDX4A120	12.0	51	74	120	12	13,200
SDX4A121	12.1	56	80	130	13	16,000
SDX4A122	12.2	56	80	130	13	16,000
SDX4A123	12.3	56	80	130	13	16,000
SDX4A124	12.4	56	80	130	13	16,000
SDX4A125	12.5	56	80	130	13	16,000
SDX4A126	12.6	56	80	130	13	16,000
SDX4A127	12.7	55	80	130	13	16,000
SDX4A128	12.8	55	80	130	13	16,000
SDX4A129	12.9	55	80	130	13	16,000
SDX4A130	13.0	55	80	130	13	16,000
SDX4A135	13.5	60	86	140	14	17,500
SDX4A140	14.0	60	86	140	14	18,200
SDX4A145	14.5	65	92	150	15	18,900
SDX4A150	15.0	64	92	150	15	19,400
SDX4A155	15.5	69	98	155	16	20,000
SDX4A160	16.0	69	98	155	16	20,600
SDX4A165	16.5	72	102	160	17	23,000
SDX4A170	17.0	71	102	160	17	24,800
SDX4A175	17.5	74	106	165	18	27,200
SDX4A180	18.0	74	106	165	18	29,500
SDX4A185	18.5	78	111	170	19	32,200
SDX4A190	19.0	77	111	170	19	33,000
SDX4A195	19.5	80	115	175	20	34,100
SDX4A200	20.0	80	115	175	20	35,200

SDX4A:推奨切削条件
Recommended Drilling Conditions for SDX4A

被削材 Work Material	一般構造用鋼・炭素鋼・合金鋼・鋳鉄 Structural Steels, Carbon Steels, Alloy Steels, Cast Iron SS400,S55C,SCM,SK,SKD,FCI						球状黒鉛鋳鉄 Ductile Cast Iron (FCD600)	
	~30HRC		30~45HRC		45~55HRC			
切削速度 Cutting Speed	60~100 m/min		40~50 m/min		15~20 m/min		50~70 m/min	
切削条件 Drilling Condition	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)
刃径 Dia. (mm)								
3	6,400	0.15	4,200	0.07	1,600	0.07	5,300	0.15
4	5,200	0.17	3,800	0.08	1,200	0.07	4,400	0.17
6	4,000	0.20	2,700	0.09	800	0.07	3,400	0.20
8	3,200	0.23	2,000	0.10	600	0.08	2,600	0.23
10	2,500	0.25	1,600	0.12	480	0.08	2,100	0.25
12	2,100	0.25	1,250	0.12	400	0.08	1,750	0.25
14	1,900	0.27	1,150	0.13	400	0.08	1,500	0.27
16	1,800	0.27	1,000	0.13	400	0.08	1,300	0.28
18	1,650	0.30	900	0.14	350	0.08	1,200	0.30
20	1,500	0.30	800	0.15	320	0.10	1,100	0.30