

Position Drill 定位鑽

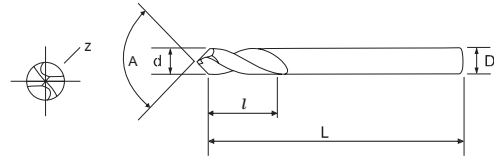
600
Nano

HRC
▶ 45

切削
條件表
P184
Cutting Condition

Micro Grain Carbide

WC=90 Co=10 HV30=1571 Rupture=3750N/mm² Grain Size=0.6μm



MODE 型號		Dimension 規格				
Coating 塗層		Diameter	Flute Length	Full Length	Shank Diameter	Tip Angle
Uncoated 無塗層	ZrN-A	d 刃徑	l 刃長	L 全長	D 柄徑	A 前端角
PDST030900	PDST030900T	3	10	50	3	90°
PDST030120	PDST030120T	3	10	50	3	120°
PDST040900	PDST040900T	4	12	50	4	90°
PDST040120	PDST040120T	4	12	50	4	120°
PDST050900	PDST050900T	5	15	50	5	90°
PDST050120	PDST050120T	5	15	50	5	120°
PDST060900	PDST060900T	6	20	60	6	90°
PDST060120	PDST060120T	6	20	60	6	120°
PDST080900	PDST080900T	8	25	60	8	90°
PDST080120	PDST080120T	8	25	60	8	120°
PDST100900	PDST100900T	10	25	75	10	90°
PDST100120	PDST100120T	10	25	75	10	120°
PDST120900	PDST120900T	12	30	75	12	90°
PDST120120	PDST120120T	12	30	75	12	120°
PDST160900	PDST160900T	16	35	100	16	90°
PDST160120	PDST160120T	16	35	100	16	120°
PDST200900	PDST200900T	20	40	100	20	90°
PDST200120	PDST200120T	20	40	100	20	120°

Application 適用材質：

★ Perfect 最推薦 ◎ Excellent 適合 ○ Good 佳

Coating 塗層	carbon steel, Alloy steel 炭素鋼,合金鋼	Pre-hardened steel 預硬鋼	High-hardened 高硬度鋼					Stainless steel 不鏽鋼	Titanium ally 鈦合金	Nickel/Inconel alloy 鎳基合金	Copper alloy 銅合金,銅	Aluminum alloy 鋁合金
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC						
	○	◎	○								○	○
ZrN-A	○	◎	◎	○			○	○	○	○	○	○

Position Drill 定位鑽

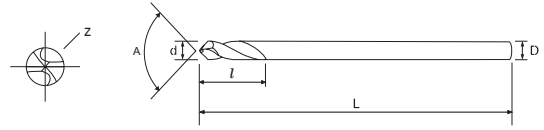
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MODE 型號		Dimension 規格				
Coating 塗層		Diameter	Flute Length	Full Length	Shank Diameter	Tip Angle
Uncoated 無塗層	ZrN-A	d 刃徑	l 刃長	L 全長	D 柄徑	A 前端角
PDST040901	PDST040901T	4	12	100	4	90°
PDST040121	PDST040121T	4	12	100	4	120°
PDST060901	PDST060901T	6	20	100	6	90°
PDST060121	PDST060121T	6	20	100	6	120°
PDST080901	PDST080901T	8	25	100	8	90°
PDST080121	PDST080121T	8	25	100	8	120°
PDST100901	PDST100901T	10	25	150	10	90°
PDST100121	PDST100121T	10	25	150	10	120°
PDST120901	PDST120901T	12	30	150	12	90°
PDST120121	PDST120121T	12	30	150	12	120°
PDST160901	PDST160901T	16	35	150	16	90°
PDST160121	PDST160121T	16	35	150	16	120°
PDST200901	PDST200901T	20	40	150	20	90°
PDST200121	PDST200121T	20	40	150	20	120°

Application 適用材質：

★ Perfect 最推薦 ◎ Excellent 適合 ○ Good 佳

Coating 塗層	carbon steel, Alloy steel 炭素鋼,合金鋼	Pre-harden steel 預硬鋼	High-hardened 高硬度鋼				Stainless steel 不鏽鋼	Titanium ally 鈦合金	Nickel/Inconel ally 鎳基合金	Copper alloy 銅合金,銅	Aluminum alloy 鋁合金
		~45HRC	~50HRC	~55HRC	~60HRC	~65HRC					
	○	◎	○							○	○
ZrN-A	○	◎	◎	○			○	○	○	○	○

PDST Series Cutting Condition
標準切削

產品規格表 **P132-133**
Specification page

Work Material 被削材	Mild steels, Carbon steels, cast iron		Alloy steels, Tool steels, SCM, SKT, SKS, SKD ~HRC30		鑄鐵 FC250等 一般構造鋼, 碳素鋼		Aluminum alloy, expanding material	
	Diameter 直徑 (mm)	Speed 迴轉速 (min ⁻¹)	Feed Rate 進給速度 (mm/min)	Speed 迴轉速 (min ⁻¹)	Feed Rate 進給速度 (mm/min)	Speed 迴轉速 (min ⁻¹)	Feed Rate 進給速度 (mm/min)	Speed 迴轉速 (min ⁻¹)
3	5300	160	3200	95	5300	160	8000	300
4	4000	160	2400	90	4000	160	6000	300
5	3200	160	1900	90	3200	160	4800	300
6	2600	160	1600	85	2700	160	4000	300
8	2000	150	1200	75	2000	150	3000	300
10	1600	145	960	65	1600	145	2400	300
12	1300	130	800	60	1300	130	2000	300
16	1000	120	600	60	1000	120	1500	300
20	800	110	480	55	800	110	1200	300