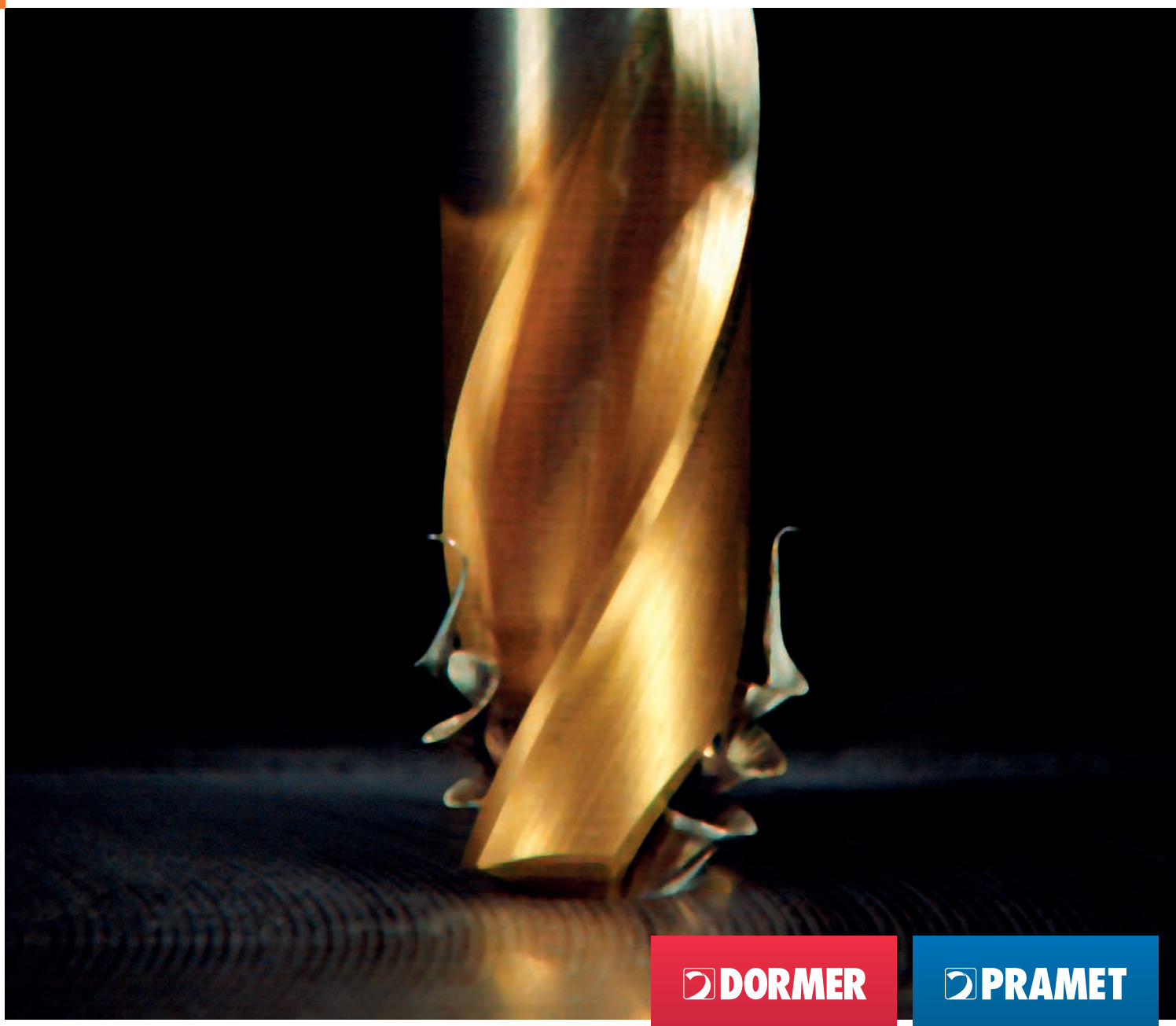
DORMER PRAMET

孔加工

2024



DORMER PRAMET

孔加工-通用信息

孔加工

用于基本制造、施工、维护、修理和大修的工具。通常与电动工具和传统机床一起使用。适用于低切削参数。	短刃钻头和定心钻	< 2.5 x D	7
	标准长度钻头	< 4 x D	17
	长钻和超长钻	< 10 x D	35
	航空航天钻头	NAS 907	41
	沉孔钻		59
	铰刀		73
	钻具和配件		90
用于混合制造的工具。通常与带机床进给和数控系统的传统机床配合使用。适合中等切削参数。	短刃钻头	< 3 x D	103
	标准长度钻头	< 5 x D	115
	长钻和超长钻	< 25 x D	125
	台阶钻和锪钻		135
	中心钻		147
	沉孔钻		157
	铰刀		167
提高工艺安全性和生产率的工具。通常用于 CNC 和自动化生产。适用于高切削参数。	整体硬质合倒角钻		181
	硬质合金钻头	< 8 x D	187
	天龙钻（可转位刀头）	1.5 – 12 x D	217
	可转位钻头（U 钻）	2 – 5 x D	235
	硬质合金铰刀		249

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DORMER

整体式圆刃刀具 – 目录 (字母顺序)

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A510	120
A520	105
A553	122
A620	107
A720	104
A723	8
A777	116
A900	126
A920	110
A940	128
A952	133
A976	130
A977	131
A978	132
B	
B100	74
B101	174
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B122	88
B161	173
B170	171
B180	169
B301	80
B400	250
B411	254
B441	253
B442	255
B481	251
B610	76
B620	78
B630	84
B640	177
B650	79

产品系列	📖
B660	85
B670	86
B680	87
B690	64
B901	168
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G106	67
G107	69
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G129	62
G132	63
G135	60
G136	66
G137	164
G138	165
G142	65
G149	159
G154	61
G171	163
G236	71
G314	136
G335	158
G338	166
G400	162
G506	68
G560	160
G570	161
G600	70
G702	138
G703	139
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产品系列	📖
G705	141
G706	142
H	
H851	218
H853	219
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H8512	224
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R463	213
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PRAMET

可转位刀具 – 目录 (字母顺序)

产品系列	📖
0	
802D	236
803D	238
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805D	243

可转位刀片 – 目录 (字母顺序)

产品系列	📖
S	
SCET	245
XPET	246

用于基本制造、施工、维护、修理和大修的工具。
通常与电动工具和传统机床一起使用。适用于低切削参数。

材料代码(BMC)	HSS-E	HSS	HSS	HSS	HSS	HSS
基本标准组(BSG)	DORMER	DIN 1897	DIN 1897	DIN 1897	DIN 1897	DIN ANSI
有用长度直径比 (ULDR)	1×D	1×D	1.25×D	1.5×D	2.5×D	2.5×D
应用角度	180°	90°/120°	120°	120°	135°	135°
涂层	Bronze	Bright	ST	ST	ST	TiN-Tip
柄部						
螺旋形式	λ 20-35°	λ 20-35°	λ 20-35°	λ 20-35°	λ 20-35°	λ 20-35°
旋向(切削方向)	R	R	R	R	R	R

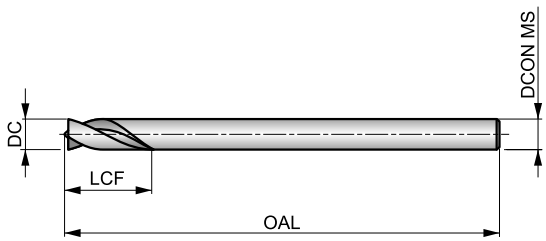
产品系列代码	A723	A122	A119	A123	A120	A022
PSF切削直径范围	6.00 - 8.00	6.00 - 20.00	3.30 - 5.10	3/32 - 1/4	0.50 - 25.00	0.50 - 16.00
	8	9	10	11	12	14
P P1	■	■	■	■	■	■
P2	◪	■	◪	■	■	■
P3	◪	◪	◪	◪	■	■
P4	◪	◪	◪	◪	◪	■
M M1		◪	◪	◪	■	■
M2		◪	◪	◪	■	■
M3		◪	◪	◪	◪	◪
M4		◪	◪	◪	◪	◪
K K1		◪			■	■
K2		◪			■	■
K3		◪			■	■
K4		◪			◪	◪
K5		◪			■	■
N N1		■	◪	■	◪	■
N2		◪	◪	◪	◪	■
N3		■	◪	■	◪	◪
N4		◪	◪	◪	◪	◪
N5						
S S1		◪	◪	◪	◪	◪
S2		◪	◪	◪	◪	◪
S3		◪	◪	◪	◪	◪
S4		◪	◪	◪	◪	◪
H H1						
H2						
H3						
H4						

■推荐使用 ◪可以使用

A723

DORMER

焊接含钴高速钢(5%钴)钻头，青铜色，表面回火处理
特别设计的外缘和钻尖，以去除或“钻出”焊点区域，通常用于在车辆修理厂去除焊缝。在手持式工具中使用时，较短的槽长使它更强壮且不易断裂，青铜色表面是一层薄薄的氧化层，也是含钴材料的标志。



HSS-E	DORMER	1×D
Bronze		λ 20-35°
R	DC h8	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

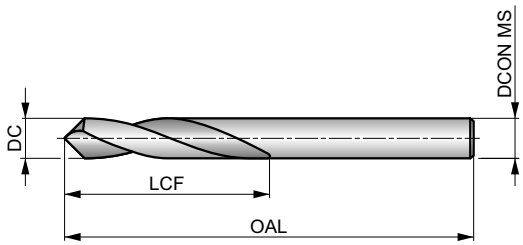
P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	P3.2	P4.1
33 D	37 D	38 D	28 D	25 C	20 C	20 C	20 C

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A7236.0X66	6.00	0.2362	18.0	66.0	6.00
A7236.0X93	6.00	0.2362	18.0	93.0	6.00
A7238.0X79	8.00	0.3150	24.0	79.0	8.00
A7238.0X117	8.00	0.3150	24.0	117.0	8.00

A122

DORMER

高速钢定心钻，表面光亮处理。
用于钻定心孔以确保定位精确，90°或120°的钻尖角提供两种不同的定心孔选择，表面光亮处理，适用于多种材料的切削。



HSS	DIN 1897	1×D
90°/120°	Bright	
λ20-35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

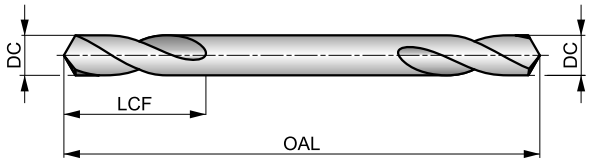
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■36 E	■40 E	■41 E	■31 E	■27 C	◪24 C	◪21 C	◪17 C	◪14 C	◪12 C	◪10 C	◪9 B	◪22 C	◪19 C
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪20 C	◪16 C	◪10 D	◪9 D	◪8 D	◪10 B	◪32 E	◪24 C	◪18 C	◪25 C	◪20 C	◪16 B	◪22 C	◪17 C
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 B	◪20 C	◪15 C	◪11 B	◪10 B	◪8 B	◪23 C	◪17 C	◪13 B	■33 E	■25 E	■17 E	◪46 D	◪42 D
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪30 D	■56 D	■33 E	■17 D	◪30 F	◪35 E	◪17 D	◪27 C	◪12 B	◪7 A	◪11 C	◪6 A	◪8 C	◪4 A
S4.1	S4.2												
◪6 C	◪3 A												

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1226.0X90	6.00	0.2362	30.0	66.0	6.00
A1226.0X120	6.00	0.2362	30.0	66.0	6.00
A1228.0X90	8.00	0.3150	33.0	79.0	8.00
A1228.0X120	8.00	0.3150	33.0	79.0	8.00
A12210.0X90	10.00	0.3937	35.0	89.0	10.00
A12210.0X120	10.00	0.3937	35.0	89.0	10.00
A12212.0X90	12.00	0.4724	40.0	102.0	12.00
A12212.0X120	12.00	0.4724	40.0	102.0	12.00
A12216.0X90	16.00	0.6299	40.0	115.0	16.00
A12216.0X120	16.00	0.6299	40.0	115.0	16.00
A12220.0X90	20.00	0.7874	55.0	131.0	20.00

A119

DORMER

短型双头高速钢钻头，表面蒸汽回火处理。
一种短的双头钻，用于在金属薄板的钻孔，两端均可使用，从而使刀具寿命提高一倍。一个120°的常规钻尖有助于自定心，适用于多种材料的切削，蒸汽回火处理能够留存切削液，防止刀具粘屑。



HSS	DIN 1897	1.25xD
120°	ST	
λ20-35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■31 C	■34 C	■35 C	■26 C	◪23 C	◪20 C	◪12 C	◪9 C	◪8 C	◪7 C	◪6 C	◪5 A	◪21 A	◪17 A
M2.1	**M2.2**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**
◪18 A	◪15 A	◪8 C	◪7 C	◪6 C	◪10 A	◪33 C	◪25 C	◪17 C	◪46 C	◪42 C	◪30 C	◪56 C	◪33 C
N3.3	**N4.1**	**N4.2**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**	**S3.1**	**S3.2**	**S4.1**	**S4.2**		
◪17 A	◪30 I	◪35 C	◪27 A	◪12 A	◪7 A	◪5 C	◪4 C	◪4 C	◪3 C	◪3 C	◪2 C		

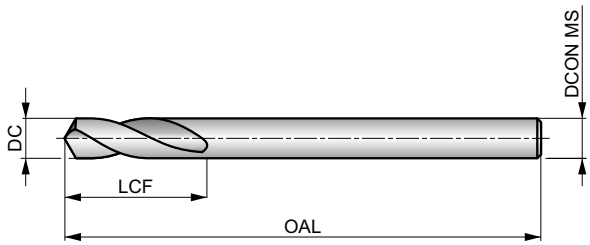
钣金钻

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1193.3	3.30	0.1299	11.0	49.0	3.30
A1193.6	3.60	0.1417	12.0	52.0	3.60
A1194.1	4.10	0.1614	14.0	55.0	4.10
A1194.2	4.20	0.1654	14.0	55.0	4.20
A1194.9	4.90	0.1929	17.0	62.0	4.90
A1195.1	5.10	0.2008	17.0	62.0	5.10

A123

DORMER

钣金专用短型高速钢钻头，蒸汽回火处理。
特殊的设计专用于薄板和层叠板的钻孔，120°的钻尖，蒸汽回火处理能够留存切削液，防止刀具粘屑，从而实现更好的孔径公差和更优的孔壁光洁度，适用于多种材料的切削。



HSS	DIN 1897	1.5×D
120°	ST	
λ20-35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■36 E	■40 E	■41 E	■31 E	■27 C	◪24 C	◪21 C	◪17 C	◪14 C	◪12 C	◪10 C	◪9 B	◪22 C	◪19 C
M2.1	**M2.2**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**
◪20 C	◪16 C	◪10 D	◪9 D	◪8 D	◪10 B	■33 E	■25 E	■17 E	◪46 D	◪42 D	◪30 D	■56 D	■33 E
N3.3	**N4.1**	**N4.2**	**N4.3**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**	**S3.1**	**S3.2**	**S4.1**	**S4.2**	
■17 D	◪30 F	◪35 E	◪17 D	◪27 C	◪12 B	◪7 A	◪11 C	◪6 A	◪8 C	◪4 A	◪6 C	◪3 A	

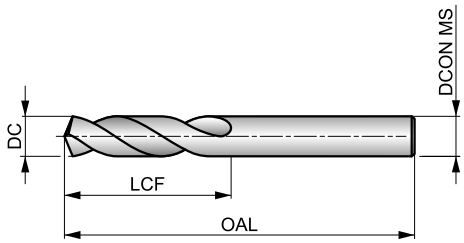
钣金钻

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1233/32S	3/32	2.38	0.0937	14.0	43.0	2.38
A1232.5S	–	2.50	0.0984	14.0	43.0	2.50
A1233.0S	–	3.00	0.1181	16.0	46.0	3.00
A1231/8S	1/8	3.18	0.1250	18.0	49.0	3.18
A1233.2S	–	3.20	0.1260	18.0	49.0	3.20
A1233.3S	–	3.30	0.1299	18.0	49.0	3.30
A1233.5S	–	3.50	0.1378	18.0	52.0	3.50
A1233.7S	–	3.70	0.1457	18.0	52.0	3.70
A1235/32S	5/32	3.97	0.1563	18.0	55.0	3.97
A1234.0S	–	4.00	0.1575	18.0	55.0	4.00
A1234.1S	–	4.10	0.1614	18.0	55.0	4.10
A1234.2S	–	4.20	0.1654	18.0	55.0	4.20
A1234.5S	–	4.50	0.1772	18.0	58.0	4.50
A1233/16S	3/16	4.76	0.1875	18.0	62.0	4.76
A1234.8S	–	4.80	0.1890	18.0	62.0	4.80
A1234.9S	–	4.90	0.1929	18.0	62.0	4.90
A1235.0S	–	5.00	0.1969	18.0	62.0	5.00
A1235.5S	–	5.50	0.2165	18.0	66.0	5.50
A1237/32S	7/32	5.56	0.2188	18.0	66.0	5.56
A1236.0S	–	6.00	0.2362	18.0	66.0	6.00
A1231/4S	1/4	6.35	0.2500	19.0	70.0	6.35

A120

DORMER

短型高速钢钻头，蒸汽回火处理。
多功能的钻头，135°钻尖角有助于降低钻孔切削力，也可防止钻头在材料表面打滑，蒸汽回火处理能够留存切削液，防止刀具粘屑，可用于手持式工具或机床，适用于多种材料的切削。



HSS	DIN 1897	2.5×D
135°	ST	
λ20-35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■36 J	■40 J	■41 J	■31 J	■27 G	◪24 F	■21 G	■17 G	◪14 F	■12 G	◪10 F	◪9 E	■22 F	■19 F
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■20 F	■16 F	◪10 H	◪9 H	◪8 H	◪10 D	■32 J	■24 G	■18 G	■25 F	■20 F	◪16 F	■22 F	■17 F
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 F	■20 F	■15 F	◪11 F	◪10 F	◪8 F	■23 F	■17 F	◪13 F	◪33 K	◪25 K	◪17 J	◪46 I	◪42 I
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪30 I	◪64 I	◪38 J	◪19 H	◪30 K	◪35 I	◪17 G	■27 G	◪16 E	◪8 C	◪11 F	◪6 B	◪8 F	◪4 B
S4.1	S4.2												
◪6 F	◪3 B												

DC <= 1mm 光亮表面; 2.9mm => DC >= 13.0mm 118° 钻尖

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A120.5	–	0.50	0.0197	3.0	20.0	0.50
A120.6	–	0.60	0.0236	3.5	21.0	0.60
A120.7	–	0.70	0.0276	4.5	23.0	0.70
A1201/32	1/32	0.79	0.0313	5.0	24.0	0.79
A120.8	–	0.80	0.0315	5.0	24.0	0.80
A120.9	–	0.90	0.0354	5.5	25.0	0.90
A1201.0	–	1.00	0.0394	6.0	26.0	1.00
A1201.1	–	1.10	0.0433	7.0	28.0	1.10
A1201.2	–	1.20	0.0472	8.0	30.0	1.20
A1201.3	–	1.30	0.0512	8.0	30.0	1.30
A1201.4	–	1.40	0.0551	9.0	32.0	1.40
A1201.5	–	1.50	0.0591	9.0	32.0	1.50
A1201/16	1/16	1.59	0.0625	10.0	34.0	1.59
A1201.6	–	1.60	0.0630	10.0	34.0	1.60
A1201.7	–	1.70	0.0669	10.0	34.0	1.70
A1201.8	–	1.80	0.0709	11.0	36.0	1.80
A1201.9	–	1.90	0.0748	11.0	36.0	1.90
A1205/64	5/64	1.98	0.0781	12.0	38.0	1.98
A1202.0	–	2.00	0.0787	12.0	38.0	2.00
A1202.1	–	2.10	0.0827	12.0	38.0	2.10
A1202.2	–	2.20	0.0866	13.0	40.0	2.20
A1202.25	–	2.25	0.0886	13.0	40.0	2.25
A1202.3	–	2.30	0.0906	13.0	40.0	2.30

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1203/32	3/32	2.38	0.0938	14.0	43.0	2.38
A1202.4	–	2.40	0.0945	14.0	43.0	2.40
A1202.5	–	2.50	0.0984	14.0	43.0	2.50
A1202.6	–	2.60	0.1024	14.0	43.0	2.60
A1202.7	–	2.70	0.1063	16.0	46.0	2.70
A1207/64	7/64	2.78	0.1094	16.0	46.0	2.78
A1202.8	–	2.80	0.1102	16.0	46.0	2.80
A1202.9	–	2.90	0.1142	16.0	46.0	2.90
A1203.0	–	3.00	0.1181	16.0	46.0	3.00
A1203.1	–	3.10	0.1220	18.0	49.0	3.10
A1201/8	1/8	3.18	0.1250	18.0	49.0	3.18
A1203.2	–	3.20	0.1260	18.0	49.0	3.20
A1203.25	–	3.25	0.1280	18.0	49.0	3.25
A1203.3	–	3.30	0.1299	18.0	49.0	3.30
A1203.4	–	3.40	0.1339	20.0	52.0	3.40
A1203.5	–	3.50	0.1378	20.0	52.0	3.50
A1209/64	9/64	3.57	0.1406	20.0	52.0	3.57
A1203.6	–	3.60	0.1417	20.0	52.0	3.60
A1203.7	–	3.70	0.1457	20.0	52.0	3.70
A1203.8	–	3.80	0.1496	22.0	55.0	3.80
A1203.9	–	3.90	0.1535	22.0	55.0	3.90
A1205/32	5/32	3.97	0.1563	22.0	55.0	3.97
A1204.0	–	4.00	0.1575	22.0	55.0	4.00

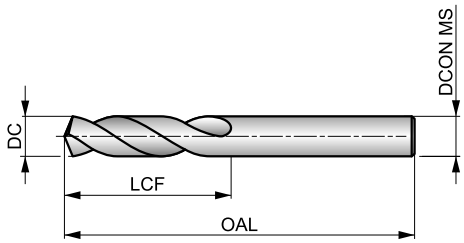
Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1204.1	–	4.10	0.1614	22.0	55.0	4.10
A1204.2	–	4.20	0.1654	22.0	55.0	4.20
A1204.3	–	4.30	0.1693	24.0	58.0	4.30
A12011/64	11/64	4.37	0.1719	24.0	58.0	4.37
A1204.4	–	4.40	0.1732	24.0	58.0	4.40
A1204.5	–	4.50	0.1772	24.0	58.0	4.50
A1204.6	–	4.60	0.1811	24.0	58.0	4.60
A1204.7	–	4.70	0.1850	24.0	58.0	4.70
A1203/16	3/16	4.76	0.1875	26.0	62.0	4.76
A1204.8	–	4.80	0.1890	26.0	62.0	4.80
A1204.9	–	4.90	0.1929	26.0	62.0	4.90
A1205.0	–	5.00	0.1969	26.0	62.0	5.00
A1205.1	–	5.10	0.2008	26.0	62.0	5.10
A12013/64	13/64	5.16	0.2031	26.0	62.0	5.16
A1205.2	–	5.20	0.2047	26.0	62.0	5.20
A1205.3	–	5.30	0.2087	26.0	62.0	5.30
A1205.4	–	5.40	0.2126	28.0	66.0	5.40
A1205.5	–	5.50	0.2165	28.0	66.0	5.50
A1207/32	7/32	5.56	0.2188	28.0	66.0	5.56
A1205.6	–	5.60	0.2205	28.0	66.0	5.60
A1205.7	–	5.70	0.2244	28.0	66.0	5.70
A1205.8	–	5.80	0.2283	28.0	66.0	5.80
A1205.9	–	5.90	0.2323	28.0	66.0	5.90
A12015/64	15/64	5.95	0.2344	28.0	66.0	5.95
A1206.0	–	6.00	0.2362	28.0	66.0	6.00
A1206.1	–	6.10	0.2402	31.0	70.0	6.10
A1206.2	–	6.20	0.2441	31.0	70.0	6.20
A1206.3	–	6.30	0.2480	31.0	70.0	6.30
A1201/4	1/4	6.35	0.2500	31.0	70.0	6.35
A1206.4	–	6.40	0.2520	31.0	70.0	6.40
A1206.5	–	6.50	0.2559	31.0	70.0	6.50
A1206.6	–	6.60	0.2598	31.0	70.0	6.60
A1206.7	–	6.70	0.2638	31.0	70.0	6.70
A1206.8	–	6.80	0.2677	34.0	74.0	6.80
A1206.9	–	6.90	0.2717	34.0	74.0	6.90
A1207.0	–	7.00	0.2756	34.0	74.0	7.00
A1207.1	–	7.10	0.2795	34.0	74.0	7.10
A1209/32	9/32	7.14	0.2813	34.0	74.0	7.14
A1207.2	–	7.20	0.2835	34.0	74.0	7.20
A1207.3	–	7.30	0.2874	34.0	74.0	7.30
A1207.4	–	7.40	0.2913	34.0	74.0	7.40
A1207.5	–	7.50	0.2953	34.0	74.0	7.50
A1207.6	–	7.60	0.2992	37.0	79.0	7.60
A1207.7	–	7.70	0.3031	37.0	79.0	7.70
A1207.8	–	7.80	0.3071	37.0	79.0	7.80
A1207.9	–	7.90	0.3110	37.0	79.0	7.90
A1205/16	5/16	7.94	0.3125	37.0	79.0	7.94
A1208.0	–	8.00	0.3150	37.0	79.0	8.00
A1208.1	–	8.10	0.3189	37.0	79.0	8.10
A1208.2	–	8.20	0.3228	37.0	79.0	8.20
A1208.3	–	8.30	0.3268	37.0	79.0	8.30
A1208.4	–	8.40	0.3307	37.0	79.0	8.40
A1208.5	–	8.50	0.3346	37.0	79.0	8.50
A1208.6	–	8.60	0.3386	40.0	84.0	8.60

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1208.7	–	8.70	0.3425	40.0	84.0	8.70
A12011/32	11/32	8.73	0.3438	40.0	84.0	8.73
A1208.8	–	8.80	0.3465	40.0	84.0	8.80
A1208.9	–	8.90	0.3504	40.0	84.0	8.90
A1209.0	–	9.00	0.3543	40.0	84.0	9.00
A1209.1	–	9.10	0.3583	40.0	84.0	9.10
A1209.2	–	9.20	0.3622	40.0	84.0	9.20
A1209.3	–	9.30	0.3661	40.0	84.0	9.30
A1209.4	–	9.40	0.3701	40.0	84.0	9.40
A1209.5	–	9.50	0.3740	40.0	84.0	9.50
A1203/8	3/8	9.52	0.3750	43.0	89.0	9.52
A1209.6	–	9.60	0.3780	43.0	89.0	9.60
A1209.7	–	9.70	0.3819	43.0	89.0	9.70
A1209.8	–	9.80	0.3858	43.0	89.0	9.80
A1209.9	–	9.90	0.3898	43.0	89.0	9.90
A12010.0	–	10.00	0.3937	43.0	89.0	10.00
A12010.1	–	10.10	0.3976	43.0	89.0	10.10
A12010.2	–	10.20	0.4016	43.0	89.0	10.20
A12010.3	–	10.30	0.4055	43.0	89.0	10.30
A12010.5	–	10.50	0.4134	43.0	89.0	10.50
A12010.8	–	10.80	0.4252	47.0	95.0	10.80
A12011.0	–	11.00	0.4331	47.0	95.0	11.00
A1207/16	7/16	11.11	0.4375	47.0	95.0	11.11
A12011.3	–	11.30	0.4449	47.0	95.0	11.30
A12011.5	–	11.50	0.4528	47.0	95.0	11.50
A12011.7	–	11.70	0.4606	47.0	95.0	11.70
A12011.8	–	11.80	0.4646	47.0	95.0	11.80
A12012.0	–	12.00	0.4724	51.0	102.0	12.00
A12012.1	–	12.10	0.4764	51.0	102.0	12.10
A12012.2	–	12.20	0.4803	51.0	102.0	12.20
A12012.5	–	12.50	0.4921	51.0	102.0	12.50
A1201/2	1/2	12.70	0.5000	51.0	102.0	12.70
A12013.0	–	13.00	0.5118	51.0	102.0	13.00
A12013.5	–	13.50	0.5315	54.0	107.0	13.50
A12014.0	–	14.00	0.5512	54.0	107.0	14.00
A1209/16	9/16	14.29	0.5625	56.0	111.0	14.29
A12014.5	–	14.50	0.5709	56.0	111.0	14.50
A12015.0	–	15.00	0.5906	56.0	111.0	15.00
A12015.5	–	15.50	0.6102	58.0	115.0	15.50
A1205/8	5/8	15.88	0.6250	58.0	115.0	15.88
A12016.0	–	16.00	0.6299	58.0	115.0	16.00
A12016.5	–	16.50	0.6496	60.0	119.0	16.50
A12017.0	–	17.00	0.6693	60.0	119.0	17.00
A12011/16	11/16	17.46	0.6875	62.0	123.0	17.46
A12017.5	–	17.50	0.6890	62.0	123.0	17.50
A12018.0	–	18.00	0.7087	62.0	123.0	18.00
A12018.5	–	18.50	0.7283	64.0	127.0	18.50
A12019.0	–	19.00	0.7480	64.0	127.0	19.00
A12020.0	–	20.00	0.7874	66.0	131.0	20.00
A12020.5	–	20.50	0.8071	68.0	136.0	20.50
A12013/16	13/16	20.64	0.8125	68.0	136.0	20.64
A12021.0	–	21.00	0.8268	68.0	136.0	21.00
A12022.0	–	22.00	0.8661	70.0	141.0	22.00
A12025.0	–	25.00	0.9843	75.0	151.0	25.00

A022

DORMER

短型高速钢钻头，头部氮化钛涂层。
多功能的钻头，特殊设计的135°钻尖角，有助于在使用手持式工具时自定心，在加床加工时确保更高的精度和更好的表面质量，头部氮化钛涂层提高了切削性能并延长了刀具寿命，适用于多种材料的切削。



HSS	DIN ANSI	2.5×D
135°	TiN-Tip	
λ20-35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■33 K	■37 K	■38 K	■28 K	■25 I	■22 G	■24 H	■19 H	■16 G	■14 H	■12 G	◪10 E	■21 G	■17 G
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■18 G	■15 G	◪9 I	◪8 I	◪7 I	◪9 E	■32 K	■24 I	■18 I	■25 G	■20 G	◪16 G	■22 G	■17 G
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 G	■20 G	■15 G	◪11 G	◪10 G	◪8 G	■23 G	■17 G	◪13 G	■40 F	■30 F	■20 K	■49 J	■44 J
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
■32 J	◪64 I	◪38 K	◪19 H	◪30 K	◪35 I	◪17 G	■25 I	◪14 F	◪8 C	◪11 F	◪6 B	◪8 F	◪4 B
S4.1	S4.2												
◪6 F	◪3 B												

DC < 2mm 光亮表面; DC >= 2mm 端部涂 TiN 的分离式钻尖
该系列产品有配套提供，请参阅A088

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A022.5	–	0.50	0.0197	3.0	20.0	0.50
A022.6	–	0.60	0.0236	3.5	21.0	0.60
A022.7	–	0.70	0.0276	4.5	23.0	0.70
A0221/32	1/32	0.79	0.0313	13.0	35.0	0.79
A022.8	–	0.80	0.0315	5.0	24.0	0.80
A022.9	–	0.90	0.0354	5.5	25.0	0.90
A0221.0	–	1.00	0.0394	6.0	26.0	1.00
A0221.1	–	1.10	0.0433	7.0	28.0	1.10
A0223/64	3/64	1.19	0.0469	13.0	35.0	1.19
A0221.2	–	1.20	0.0472	8.0	30.0	1.20
A0221.3	–	1.30	0.0512	8.0	30.0	1.30
A0221.4	–	1.40	0.0551	9.0	32.0	1.40
A0221.5	–	1.50	0.0591	9.0	32.0	1.50
A0221/16	1/16	1.59	0.0625	16.0	41.0	1.59
A0221.6	–	1.60	0.0630	10.0	34.0	1.60
A0221.7	–	1.70	0.0669	10.0	34.0	1.70
A0221.8	–	1.80	0.0709	11.0	36.0	1.80
A0221.9	–	1.90	0.0748	11.0	36.0	1.90
A0225/64	5/64	1.98	0.0781	17.0	43.0	1.98
A0222.0	–	2.00	0.0787	12.0	38.0	2.00
A0222.1	–	2.10	0.0827	12.0	38.0	2.10
A0222.2	–	2.20	0.0866	13.0	40.0	2.20

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A0222.25	–	2.25	0.0886	13.0	40.0	2.25
A0222.3	–	2.30	0.0906	13.0	40.0	2.30
A0223/32	3/32	2.38	0.0938	20.0	45.0	2.38
A0222.4	–	2.40	0.0945	14.0	43.0	2.40
A0222.5	–	2.50	0.0984	14.0	43.0	2.50
A0222.6	–	2.60	0.1024	14.0	43.0	2.60
A0222.65	–	2.65	0.1043	14.0	43.0	2.65
A0222.7	–	2.70	0.1063	16.0	46.0	2.70
A0227/64	7/64	2.78	0.1094	22.0	47.0	2.78
A0222.8	–	2.80	0.1102	16.0	46.0	2.80
A0222.9	–	2.90	0.1142	16.0	46.0	2.90
A0223.0	–	3.00	0.1181	16.0	46.0	3.00
A0223.1	–	3.10	0.1220	18.0	49.0	3.10
A0221/8	1/8	3.18	0.1250	23.0	49.0	3.18
A0223.2	–	3.20	0.1260	18.0	49.0	3.20
A0223.25	–	3.25	0.1280	18.0	49.0	3.25
A0223.3	–	3.30	0.1299	18.0	49.0	3.30
A0223.4	–	3.40	0.1339	20.0	52.0	3.40
A0223.5	–	3.50	0.1378	20.0	52.0	3.50
A0229/64	9/64	3.57	0.1406	25.0	50.0	3.57
A0223.6	–	3.60	0.1417	20.0	52.0	3.60
A0223.7	–	3.70	0.1457	20.0	52.0	3.70

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A0223.8	–	3.80	0.1496	22.0	55.0	3.80
A0223.9	–	3.90	0.1535	22.0	55.0	3.90
A0225/32	5/32	3.97	0.1563	26.0	53.0	3.97
A0224.0	–	4.00	0.1575	22.0	55.0	4.00
A0224.1	–	4.10	0.1614	22.0	55.0	4.10
A0224.2	–	4.20	0.1654	22.0	55.0	4.20
A0224.3	–	4.30	0.1693	24.0	58.0	4.30
A02211/64	11/64	4.37	0.1719	28.0	55.0	4.37
A0224.4	–	4.40	0.1732	24.0	58.0	4.40
A0224.5	–	4.50	0.1772	24.0	58.0	4.50
A0224.6	–	4.60	0.1811	24.0	58.0	4.60
A0224.7	–	4.70	0.1850	24.0	58.0	4.70
A0223/16	3/16	4.76	0.1875	30.0	57.0	4.76
A0224.8	–	4.80	0.1890	26.0	62.0	4.80
A0224.9	–	4.90	0.1929	26.0	62.0	4.90
A0225.0	–	5.00	0.1969	26.0	62.0	5.00
A0225.1	–	5.10	0.2008	26.0	62.0	5.10
A02213/64	13/64	5.16	0.2031	31.0	58.0	5.16
A0225.2	–	5.20	0.2047	26.0	62.0	5.20
A0225.3	–	5.30	0.2087	26.0	62.0	5.30
A0225.4	–	5.40	0.2126	28.0	66.0	5.40
A0225.5	–	5.50	0.2165	28.0	66.0	5.50
A0227/32	7/32	5.56	0.2188	33.0	61.0	5.56
A0225.6	–	5.60	0.2205	28.0	66.0	5.60
A0225.7	–	5.70	0.2244	28.0	66.0	5.70
A0225.8	–	5.80	0.2283	28.0	66.0	5.80
A0225.9	–	5.90	0.2323	28.0	66.0	5.90
A02215/64	15/64	5.95	0.2344	34.0	63.0	5.95
A0226.0	–	6.00	0.2362	28.0	66.0	6.00
A0226.1	–	6.10	0.2402	31.0	70.0	6.10
A0226.2	–	6.20	0.2441	31.0	70.0	6.20
A0226.3	–	6.30	0.2480	31.0	70.0	6.30
A0221/4	1/4	6.35	0.2500	36.0	65.0	6.35
A0226.4	–	6.40	0.2520	31.0	70.0	6.40
A0226.5	–	6.50	0.2559	31.0	70.0	6.50
A0226.6	–	6.60	0.2598	31.0	70.0	6.60
A0226.7	–	6.70	0.2638	31.0	70.0	6.70
A0226.8	–	6.80	0.2677	34.0	74.0	6.80
A0226.9	–	6.90	0.2717	34.0	74.0	6.90
A0227.0	–	7.00	0.2756	34.0	74.0	7.00
A0227.1	–	7.10	0.2795	34.0	74.0	7.10
A0229/32	9/32	7.14	0.2813	40.0	70.0	7.14
A0227.2	–	7.20	0.2835	34.0	74.0	7.20
A0227.3	–	7.30	0.2874	34.0	74.0	7.30
A0227.4	–	7.40	0.2913	34.0	74.0	7.40
A0227.5	–	7.50	0.2953	34.0	74.0	7.50
A0227.6	–	7.60	0.2992	37.0	79.0	7.60
A0227.7	–	7.70	0.3031	37.0	79.0	7.70
A0227.8	–	7.80	0.3071	37.0	79.0	7.80
A0227.9	–	7.90	0.3110	37.0	79.0	7.90
A0225/16	5/16	7.94	0.3125	43.0	73.0	7.94
A0228.0	–	8.00	0.3150	37.0	79.0	8.00
A0228.1	–	8.10	0.3189	37.0	79.0	8.10

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A0228.2	–	8.20	0.3228	37.0	79.0	8.20
A0228.3	–	8.30	0.3268	37.0	79.0	8.30
A0228.4	–	8.40	0.3307	37.0	79.0	8.40
A0228.5	–	8.50	0.3346	37.0	79.0	8.50
A0228.6	–	8.60	0.3386	40.0	84.0	8.60
A0228.7	–	8.70	0.3425	40.0	84.0	8.70
A02211/32	11/32	8.73	0.3438	45.0	78.0	8.73
A0228.8	–	8.80	0.3465	40.0	84.0	8.80
A0228.9	–	8.90	0.3504	40.0	84.0	8.90
A0229.0	–	9.00	0.3543	40.0	84.0	9.00
A0229.1	–	9.10	0.3583	40.0	84.0	9.10
A0229.2	–	9.20	0.3622	40.0	84.0	9.20
A0229.3	–	9.30	0.3661	40.0	84.0	9.30
A0229.4	–	9.40	0.3701	40.0	84.0	9.40
A0229.5	–	9.50	0.3740	40.0	84.0	9.50
A0223/8	3/8	9.52	0.3750	48.0	81.0	9.52
A0229.6	–	9.60	0.3780	43.0	89.0	9.60
A0229.7	–	9.70	0.3819	43.0	89.0	9.70
A0229.8	–	9.80	0.3858	43.0	89.0	9.80
A0229.9	–	9.90	0.3898	43.0	89.0	9.90
A02210.0	–	10.00	0.3937	43.0	89.0	10.00
A02210.1	–	10.10	0.3976	43.0	89.0	10.10
A02210.2	–	10.20	0.4016	43.0	89.0	10.20
A02210.3	–	10.30	0.4055	43.0	89.0	10.30
A02213/32	13/32	10.32	0.4063	51.0	86.0	10.32
A02210.4	–	10.40	0.4094	43.0	89.0	10.40
A02210.5	–	10.50	0.4134	43.0	89.0	10.50
A02210.6	–	10.60	0.4173	43.0	89.0	10.60
A02210.8	–	10.80	0.4252	47.0	95.0	10.80
A02211.0	–	11.00	0.4331	47.0	95.0	11.00
A02211.1	–	11.10	0.4370	47.0	95.0	11.10
A0227/16	7/16	11.11	0.4375	54.0	89.0	11.11
A02211.2	–	11.20	0.4409	47.0	95.0	11.20
A02211.3	–	11.30	0.4449	47.0	95.0	11.30
A02211.5	–	11.50	0.4528	47.0	95.0	11.50
A02211.7	–	11.70	0.4606	47.0	95.0	11.70
A02211.8	–	11.80	0.4646	47.0	95.0	11.80
A02211.9	–	11.90	0.4685	51.0	102.0	11.90
A02212.0	–	12.00	0.4724	51.0	102.0	12.00
A02212.1	–	12.10	0.4764	51.0	102.0	12.10
A02212.2	–	12.20	0.4803	51.0	102.0	12.20
A02212.5	–	12.50	0.4921	51.0	102.0	12.50
A0221/2	1/2	12.70	0.5000	60.0	98.0	12.70
A02213.0	–	13.00	0.5118	51.0	102.0	13.00
A02213.5	–	13.50	0.5315	54.0	107.0	13.50
A02214.0	–	14.00	0.5512	54.0	107.0	14.00
A0229/16	9/16	14.29	0.5625	67.0	105.0	14.29
A02214.5	–	14.50	0.5709	56.0	111.0	14.50
A02215.0	–	15.00	0.5906	56.0	111.0	15.00
A02215.5	–	15.50	0.6102	58.0	115.0	15.50
A0225/8	5/8	15.88	0.6250	73.0	111.0	15.88
A02216.0	–	16.00	0.6299	58.0	115.0	16.00

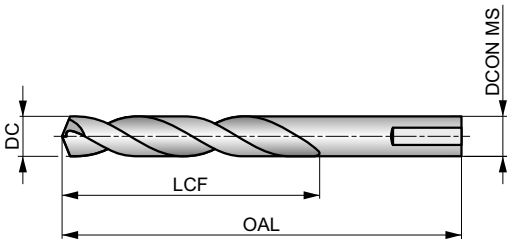
材料代码(BMC)	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS
基本标准组(BSG)	DORMER	DIN 338	DIN 338	DORMER	DIN 345	DIN 338	DIN 338	DIN 338
有用长度直径比 (ULDR)	3.5×D	4×D	4×D	4×D	4×D	4×D	4×D	4×D
应用角度	135°	118°	118°	118°	118°	118°	118°	135°
涂层	ST Bronze	ST	ST	ST	ST	TiN-Tip	TiN-Tip	ST
柄部								
螺旋形式		λ 20-35°	λ 20-35°	λ 20-35°	λ 20-35°	λ 20-35°	λ 20-35°	λ >35°
旋向(切削方向)	R	R	L	R	R	R	R	R
	NEW							
产品系列代码	A321	A100	A101	A170	A130	A002	A002S	A108
PSF切削直径范围	3.0 - 13.0	0.20 - 20.00	1.00 - 12.00	13.00 - 1.1/4	3.00 - 2"	1.00 - 16.00	2.00 - 13.00	1.00 - 16.00
	18	19	23	24	26	30	32	33
P	P1	■	■	■	■	■	■	■	◪
	P2	■	■	■	■	■	■	■	◪
	P3	■	■	■	◪	■	■	■	◪
	P4	◪	◪	◪	◪	◪	◪	◪	◪
M	M1	■	◪	◪	◪	◪	◪	◪	◪
	M2	◪	◪	◪	◪	◪	◪	◪	◪
	M3	◪	◪	◪	◪	◪	◪	◪	■
	M4	◪	◪	◪	◪	◪	◪	◪	■
K	K1	■	■	■	◪	■	■	■	◪
	K2	◪	◪	◪	◪	◪	◪	◪	◪
	K3	◪	◪	◪	◪	◪	◪	◪	◪
	K4	◪	◪	◪	◪	◪	◪	◪	◪
	K5	◪	◪	◪	◪	◪	◪	◪	◪
N	N1	◪	◪	◪	◪	◪	■	■	◪
	N2	◪	◪	◪	◪	◪	◪	◪	◪
	N3	◪	◪	◪	◪	◪	◪	◪	◪
	N4	◪	◪	◪	◪	◪	■	■	◪
	N5								
S	S1	◪	◪	◪	◪	◪	◪	◪	■
	S2	◪	◪	◪	◪	◪	◪	◪	◪
	S3	◪	◪	◪	◪	◪	◪	◪	◪
	S4	◪	◪	◪	◪	◪	◪	◪	◪
H	H1								
	H2								
	H3								
	H4								

■推荐使用 ◪可以使用

A321

DORMER

HSS中长钻头，经过蒸汽和青铜回火表面处理
设计用于重载加工的钻头，带三等分削平刀柄，用于加工中等深度孔。主要适用于手持操作和立式钻机。三等分削平刀柄，可以防止打滑。自定心135°钻尖可减少阻力，表面经过蒸汽和青铜回火处理，从而改善了润滑性。



HSS	DORMER	3.5×D
135°	ST Bronze	
R	DC h8	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■33 H	■37 H	■38 H	■28 H	■25 F	◪22 E	■19 F	■15 F	◪13 E	■11 F	◪10 E	◪8 D	■21 E	■17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪18 E	◪15 E	◪9 G	◪8 G	◪7 G	◪9 C	■30 H	■22 F	■17 F	◪25 E	◪20 E	◪16 E	◪22 E	◪17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 E	◪20 E	◪15 E	◪11 E	◪10 E	◪8 E	◪23 E	◪17 E	◪13 E	◪33 J	◪25 J	◪17 I	◪42 H	◪37 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪27 H	◪59 H	◪35 I	◪18 G	◪30 J	◪28 H	◪14 F	◪23 E	◪12 D	◪6 B	◪8 E	◪4 A	◪6 E	◪3 A
S4.1	S4.2												
◪5 E	◪2 A												

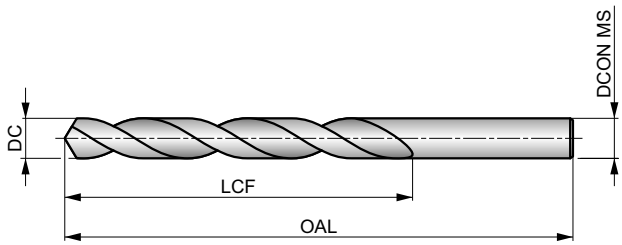
Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A3213.0	3.00	0.1180	37.0	64.0	3.00
A3213.3	3.30	0.1300	40.0	67.0	3.30
A3213.4	3.40	0.1340	40.0	67.0	3.40
A3213.5	3.50	0.1380	40.0	67.0	3.50
A3214.0	4.00	0.1580	47.0	74.0	4.00
A3214.1	4.10	0.1610	47.0	74.0	4.10
A3214.2	4.20	0.1650	47.0	74.0	4.20
A3214.3	4.30	0.1690	47.0	74.0	4.30
A3214.5	4.50	0.1770	49.0	77.0	4.50
A3214.9	4.90	0.1930	50.0	80.0	4.90
A3215.0	5.00	0.1970	50.0	80.0	5.00
A3215.1	5.10	0.2010	50.0	80.0	5.10
A3215.3	5.30	0.2090	52.0	84.0	5.30
A3215.5	5.50	0.2170	52.0	84.0	5.50
A3216.0	6.00	0.2360	52.0	90.0	6.00
A3216.3	6.30	0.2480	52.0	90.0	6.30
A3216.5	6.50	0.2560	55.0	93.0	6.50

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A3216.8	6.80	0.2680	59.0	97.0	6.80
A3217.0	7.00	0.2760	59.0	97.0	7.00
A3217.3	7.30	0.2870	62.0	100.0	7.30
A3217.5	7.50	0.2950	62.0	100.0	7.50
A3218.0	8.00	0.3150	67.0	105.0	8.00
A3218.5	8.50	0.3350	68.0	107.0	8.50
A3219.0	9.00	0.3540	70.0	108.0	9.00
A3219.5	9.50	0.3740	70.0	110.0	9.50
A32110.0	10.00	0.3940	74.0	113.0	10.00
A32110.3	10.30	0.4060	74.0	113.0	10.30
A32110.5	10.50	0.4130	75.0	115.0	10.50
A32111.0	11.00	0.4330	77.0	117.0	11.00
A32111.5	11.50	0.4530	79.0	120.0	11.50
A32112.0	12.00	0.4720	85.0	126.0	12.00
A32112.5	12.50	0.4920	88.0	130.0	12.50
A32113.0	13.00	0.5120	88.0	130.0	13.00

A100

DORMER

普通长度高速钢钻头，蒸汽回火处理。
一款优秀的多功能全方位钻头，118°的钻尖角，强壮且便于重磨，从而经济型更好，可用于手持式工具或机床，蒸汽回火处理表面能够留存切削液并避免刀具粘屑，适用于多种材料的切削。



HSS	DIN 338	4×D
118°	ST	
λ20-35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■33 H	■37 H	■38 H	■28 H	■25 F	◪22 E	■19 F	■15 F	◪13 E	■11 F	◪10 E	◪8 D	◪21 E	◪17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪18 E	◪15 E	◪9 G	◪8 G	◪7 G	◪9 C	■30 H	■22 F	■17 F	◪25 E	◪20 E	◪16 E	◪22 E	◪17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 E	◪20 E	◪15 E	◪11 E	◪10 E	◪8 E	◪23 E	◪17 E	◪13 E	◪33 J	◪25 J	◪17 I	◪42 H	◪37 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪27 H	◪59 H	◪35 I	◪18 G	◪30 J	◪28 H	◪14 F	◪23 E	◪12 D	◪6 B	◪8 E	◪4 A	◪6 E	◪3 A
S4.1	S4.2												
◪5 E	◪2 A												

DC <= 1mm; 3/64”; N60. 光亮表面
该系列产品有配套提供，请参见A190或A191

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A100.2	–	0.20	0.0079	2.5	19.0	0.20
A100.25	–	0.25	0.0098	3.0	19.0	0.25
A100.3	–	0.30	0.0118	3.0	19.0	0.30
A100.32	–	0.32	0.0126	4.0	19.0	0.32
A100N80	N80	0.34	0.0135	4.0	19.0	0.34
A100.35	–	0.35	0.0138	4.0	19.0	0.35
A100N79	N79	0.37	0.0145	4.0	19.0	0.37
A100.38	–	0.38	0.0150	4.0	19.0	0.38
A1001/64	1/64	0.40	0.0156	5.0	20.0	0.40
A100.4	–	0.40	0.0157	5.0	20.0	0.40
A100N78	N78	0.41	0.0160	5.0	20.0	0.41
A100.42	–	0.42	0.0165	5.0	20.0	0.42
A100.45	–	0.45	0.0177	5.0	20.0	0.45
A100N77	N77	0.46	0.0180	5.0	20.0	0.46
A100.48	–	0.48	0.0189	5.0	20.0	0.48
A100.5	–	0.50	0.0197	6.0	22.0	0.50
A100N76	N76	0.51	0.0200	6.0	22.0	0.51
A100.52	–	0.52	0.0205	6.0	22.0	0.52
A100N75	N75	0.53	0.0210	6.0	22.0	0.53
A100.55	–	0.55	0.0217	7.0	24.0	0.55
A100N74	N74	0.57	0.0225	7.0	24.0	0.57
A100.58	–	0.58	0.0228	7.0	24.0	0.58

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A100.6	–	0.60	0.0236	7.0	24.0	0.60
A100N73	N73	0.61	0.0240	8.0	26.0	0.61
A100.62	–	0.62	0.0244	8.0	26.0	0.62
A100N72	N72	0.64	0.0250	8.0	26.0	0.64
A100.65	–	0.65	0.0256	8.0	26.0	0.65
A100N71	N71	0.66	0.0260	8.0	26.0	0.66
A100.68	–	0.68	0.0268	9.0	28.0	0.68
A100.7	–	0.70	0.0276	9.0	28.0	0.70
A100N70	N70	0.71	0.0280	9.0	28.0	0.71
A100.72	–	0.72	0.0283	9.0	28.0	0.72
A100N69	N69	0.74	0.0292	9.0	28.0	0.74
A100.75	–	0.75	0.0295	9.0	28.0	0.75
A100.78	–	0.78	0.0307	10.0	30.0	0.78
A1001/32	1/32	0.79	0.0313	10.0	30.0	0.79
A100N68	N68	0.79	0.0310	10.0	30.0	0.79
A100.8	–	0.80	0.0315	10.0	30.0	0.80
A100N67	N67	0.81	0.0320	10.0	30.0	0.81
A100.82	–	0.82	0.0323	10.0	30.0	0.82
A100N66	N66	0.84	0.0330	10.0	30.0	0.84
A100.85	–	0.85	0.0335	10.0	30.0	0.85
A100.88	–	0.88	0.0346	11.0	32.0	0.88
A100N65	N65	0.89	0.0350	11.0	32.0	0.89

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A100.9	–	0.90	0.0354	11.0	32.0	0.90
A100N64	N64	0.91	0.0360	11.0	32.0	0.91
A100.92	–	0.92	0.0362	11.0	32.0	0.92
A100N63	N63	0.94	0.0370	11.0	32.0	0.94
A100.95	–	0.95	0.0374	11.0	32.0	0.95
A100N62	N62	0.97	0.0380	12.0	34.0	0.97
A100.98	–	0.98	0.0386	12.0	34.0	0.98
A100N61	N61	0.99	0.0390	12.0	34.0	0.99
A1001.0	–	1.00	0.0394	12.0	34.0	1.00
A100N60	N60	1.02	0.0400	12.0	34.0	1.02
A100N59	N59	1.04	0.0410	12.0	34.0	1.04
A1001.05	–	1.05	0.0413	12.0	34.0	1.05
A100N58	N58	1.07	0.0420	14.0	36.0	1.07
A100N57	N57	1.09	0.0430	14.0	36.0	1.09
A1001.1	–	1.10	0.0433	14.0	36.0	1.10
A1001.15	–	1.15	0.0453	14.0	36.0	1.15
A100N56	N56	1.18	0.0465	14.0	36.0	1.18
A1003/64	3/64	1.19	0.0469	16.0	38.0	1.19
A1001.2	–	1.20	0.0472	16.0	38.0	1.20
A1001.25	–	1.25	0.0492	16.0	38.0	1.25
A1001.3	–	1.30	0.0512	16.0	38.0	1.30
A100N55	N55	1.32	0.0520	16.0	38.0	1.32
A1001.35	–	1.35	0.0531	18.0	40.0	1.35
A1001.4	–	1.40	0.0551	18.0	40.0	1.40
A100N54	N54	1.40	0.0550	18.0	40.0	1.40
A1001.45	–	1.45	0.0571	18.0	40.0	1.45
A1001.5	–	1.50	0.0591	18.0	40.0	1.50
A100N53	N53	1.51	0.0595	20.0	43.0	1.51
A1001.55	–	1.55	0.0610	20.0	43.0	1.55
A1001/16	1/16	1.59	0.0625	20.0	43.0	1.59
A1001.6	–	1.60	0.0630	20.0	43.0	1.60
A100N52	N52	1.61	0.0635	20.0	43.0	1.61
A1001.65	–	1.65	0.0650	20.0	43.0	1.65
A1001.7	–	1.70	0.0669	20.0	43.0	1.70
A100N51	N51	1.70	0.0670	22.0	46.0	1.70
A1001.75	–	1.75	0.0689	22.0	46.0	1.75
A100N50	N50	1.78	0.0700	22.0	46.0	1.78
A1001.8	–	1.80	0.0709	22.0	46.0	1.80
A1001.85	–	1.85	0.0728	22.0	46.0	1.85
A100N49	N49	1.85	0.0730	22.0	46.0	1.85
A1001.9	–	1.90	0.0748	22.0	46.0	1.90
A100N48	N48	1.93	0.0760	24.0	49.0	1.93
A1001.95	–	1.95	0.0768	24.0	49.0	1.95
A1005/64	5/64	1.98	0.0781	24.0	49.0	1.98
A100N47	N47	1.99	0.0785	24.0	49.0	1.99
A1002.0	–	2.00	0.0787	24.0	49.0	2.00
A1002.05	–	2.05	0.0807	24.0	49.0	2.05
A100N46	N46	2.06	0.0810	24.0	49.0	2.06
A100N45	N45	2.08	0.0820	24.0	49.0	2.08
A1002.1	–	2.10	0.0827	24.0	49.0	2.10
A1002.15	–	2.15	0.0846	27.0	53.0	2.15
A100N44	N44	2.18	0.0860	27.0	53.0	2.18
A1002.2	–	2.20	0.0866	27.0	53.0	2.20
A1002.25	–	2.25	0.0886	27.0	53.0	2.25
A100N43	N43	2.26	0.0890	27.0	53.0	2.26
A1002.3	–	2.30	0.0906	27.0	53.0	2.30
A1002.35	–	2.35	0.0925	27.0	53.0	2.35
A1003/32	3/32	2.38	0.0938	30.0	57.0	2.38
A100N42	N42	2.38	0.0935	30.0	57.0	2.38
A1002.4	–	2.40	0.0945	30.0	57.0	2.40
A100N41	N41	2.44	0.0960	30.0	57.0	2.44
A1002.45	–	2.45	0.0965	30.0	57.0	2.45

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A100N40	N40	2.49	0.0980	30.0	57.0	2.49
A1002.5	–	2.50	0.0984	30.0	57.0	2.50
A100N39	N39	2.53	0.0995	30.0	57.0	2.53
A1002.55	–	2.55	0.1004	30.0	57.0	2.55
A100N38	N38	2.58	0.1015	30.0	57.0	2.58
A1002.6	–	2.60	0.1024	30.0	57.0	2.60
A100N37	N37	2.64	0.1040	30.0	57.0	2.64
A1002.65	–	2.65	0.1043	30.0	57.0	2.65
A1002.7	–	2.70	0.1063	33.0	61.0	2.70
A100N36	N36	2.71	0.1065	33.0	61.0	2.71
A1002.75	–	2.75	0.1083	33.0	61.0	2.75
A1007/64	7/64	2.78	0.1094	33.0	61.0	2.78
A100N35	N35	2.79	0.1100	33.0	61.0	2.79
A1002.8	–	2.80	0.1102	33.0	61.0	2.80
A100N34	N34	2.82	0.1110	33.0	61.0	2.82
A1002.85	–	2.85	0.1122	33.0	61.0	2.85
A100N33	N33	2.87	0.1130	33.0	61.0	2.87
A1002.9	–	2.90	0.1142	33.0	61.0	2.90
A1002.95	–	2.95	0.1161	33.0	61.0	2.95
A100N32	N32	2.95	0.1160	33.0	61.0	2.95
A1003.0	–	3.00	0.1181	33.0	61.0	3.00
A100N31	N31	3.05	0.1200	36.0	65.0	3.05
A1003.1	–	3.10	0.1220	36.0	65.0	3.10
A1003.15	–	3.15	0.1240	36.0	65.0	3.15
A1001/8	1/8	3.18	0.1250	36.0	65.0	3.18
A1003.2	–	3.20	0.1260	36.0	65.0	3.20
A1003.25	–	3.25	0.1280	36.0	65.0	3.25
A100N30	N30	3.26	0.1285	36.0	65.0	3.26
A1003.3	–	3.30	0.1299	36.0	65.0	3.30
A1003.4	–	3.40	0.1339	39.0	70.0	3.40
A100N29	N29	3.45	0.1360	39.0	70.0	3.45
A1003.5	–	3.50	0.1378	39.0	70.0	3.50
A1009/64	9/64	3.57	0.1406	39.0	70.0	3.57
A100N28	N28	3.57	0.1405	39.0	70.0	3.57
A1003.6	–	3.60	0.1417	39.0	70.0	3.60
A100N27	N27	3.66	0.1440	39.0	70.0	3.66
A1003.7	–	3.70	0.1457	39.0	70.0	3.70
A100N26	N26	3.73	0.1470	39.0	70.0	3.73
A1003.75	–	3.75	0.1476	39.0	70.0	3.75
A1003.8	–	3.80	0.1496	43.0	75.0	3.80
A100N25	N25	3.80	0.1495	43.0	75.0	3.80
A100N24	N24	3.86	0.1520	43.0	75.0	3.86
A1003.9	–	3.90	0.1535	43.0	75.0	3.90
A100N23	N23	3.91	0.1540	43.0	75.0	3.91
A1005/32	5/32	3.97	0.1563	43.0	75.0	3.97
A100N22	N22	3.99	0.1570	43.0	75.0	3.99
A1004.0	–	4.00	0.1575	43.0	75.0	4.00
A100N21	N21	4.04	0.1590	43.0	75.0	4.04
A100N20	N20	4.09	0.1610	43.0	75.0	4.09
A1004.1	–	4.10	0.1614	43.0	75.0	4.10
A1004.2	–	4.20	0.1654	43.0	75.0	4.20
A100N19	N19	4.22	0.1660	43.0	75.0	4.22
A1004.25	–	4.25	0.1673	43.0	75.0	4.25
A1004.3	–	4.30	0.1693	47.0	80.0	4.30
A100N18	N18	4.31	0.1695	47.0	80.0	4.31
A10011/64	11/64	4.37	0.1719	47.0	80.0	4.37
A100N17	N17	4.39	0.1730	47.0	80.0	4.39
A1004.4	–	4.40	0.1732	47.0	80.0	4.40
A1004.5	–	4.50	0.1772	47.0	80.0	4.50
A100N16	N16	4.50	0.1770	47.0	80.0	4.50
A100N15	N15	4.57	0.1800	47.0	80.0	4.57
A1004.6	–	4.60	0.1811	47.0	80.0	4.60

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A100N14	N14	4.62	0.1820	47.0	80.0	4.62
A1004.7	–	4.70	0.1850	47.0	80.0	4.70
A100N13	N13	4.70	0.1850	47.0	80.0	4.70
A1004.75	–	4.75	0.1870	47.0	80.0	4.75
A1003/16	3/16	4.76	0.1875	52.0	86.0	4.76
A1004.8	–	4.80	0.1890	52.0	86.0	4.80
A100N12	N12	4.80	0.1890	52.0	86.0	4.80
A100N11	N11	4.85	0.1910	52.0	86.0	4.85
A1004.9	–	4.90	0.1929	52.0	86.0	4.90
A100N10	N10	4.92	0.1935	52.0	86.0	4.92
A100N9	N9	4.98	0.1960	52.0	86.0	4.98
A1005.0	–	5.00	0.1969	52.0	86.0	5.00
A100N8	N8	5.06	0.1990	52.0	86.0	5.06
A1005.1	–	5.10	0.2008	52.0	86.0	5.10
A100N7	N7	5.11	0.2010	52.0	86.0	5.11
A10013/64	13/64	5.16	0.2031	52.0	86.0	5.16
A100N6	N6	5.18	0.2040	52.0	86.0	5.18
A1005.2	–	5.20	0.2047	52.0	86.0	5.20
A100N5	N5	5.22	0.2055	52.0	86.0	5.22
A1005.25	–	5.25	0.2067	52.0	86.0	5.25
A1005.3	–	5.30	0.2087	52.0	86.0	5.30
A100N4	N4	5.31	0.2090	57.0	93.0	5.31
A1005.4	–	5.40	0.2126	57.0	93.0	5.40
A100N3	N3	5.41	0.2130	57.0	93.0	5.41
A1005.5	–	5.50	0.2165	57.0	93.0	5.50
A1007/32	7/32	5.56	0.2188	57.0	93.0	5.56
A1005.6	–	5.60	0.2205	57.0	93.0	5.60
A100N2	N2	5.61	0.2210	57.0	93.0	5.61
A1005.7	–	5.70	0.2244	57.0	93.0	5.70
A1005.75	–	5.75	0.2264	57.0	93.0	5.75
A100N1	1	5.79	0.2280	57.0	93.0	5.79
A1005.8	–	5.80	0.2283	57.0	93.0	5.80
A1005.9	–	5.90	0.2323	57.0	93.0	5.90
A100A	A	5.94	0.2340	57.0	93.0	5.94
A10015/64	15/64	5.95	0.2344	57.0	93.0	5.95
A1006.0	–	6.00	0.2362	57.0	93.0	6.00
A100B	B	6.03	0.2380	63.0	101.0	6.03
A1006.1	–	6.10	0.2402	63.0	101.0	6.10
A100C	C	6.15	0.2420	63.0	101.0	6.15
A1006.2	–	6.20	0.2441	63.0	101.0	6.20
A1006.25	–	6.25	0.2461	63.0	101.0	6.25
A100D	D	6.25	0.2460	63.0	101.0	6.25
A1006.3	–	6.30	0.2480	63.0	101.0	6.30
A1001/4	1/4	6.35	0.2500	63.0	101.0	6.35
A100E	E	6.35	0.2500	63.0	101.0	6.35
A1006.4	–	6.40	0.2520	63.0	101.0	6.40
A1006.5	–	6.50	0.2559	63.0	101.0	6.50
A100F	F	6.53	0.2570	63.0	101.0	6.53
A1006.6	–	6.60	0.2598	63.0	101.0	6.60
A100G	G	6.63	0.2610	63.0	101.0	6.63
A1006.7	–	6.70	0.2638	63.0	101.0	6.70
A10017/64	17/64	6.75	0.2656	69.0	109.0	6.75
A1006.75	–	6.75	0.2657	69.0	109.0	6.75
A100H	H	6.76	0.2660	69.0	109.0	6.76
A1006.8	–	6.80	0.2677	69.0	109.0	6.80
A1006.9	–	6.90	0.2717	69.0	109.0	6.90
A100I	I	6.91	0.2720	69.0	109.0	6.91
A1007.0	–	7.00	0.2756	69.0	109.0	7.00
A100J	J	7.04	0.2770	69.0	109.0	7.04
A1007.1	–	7.10	0.2795	69.0	109.0	7.10
A1009/32	9/32	7.14	0.2813	69.0	109.0	7.14
A1007.2	–	7.20	0.2835	69.0	109.0	7.20

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1007.25	–	7.25	0.2854	69.0	109.0	7.25
A1007.3	–	7.30	0.2874	69.0	109.0	7.30
A100L	L	7.37	0.2900	69.0	109.0	7.37
A1007.4	–	7.40	0.2913	69.0	109.0	7.40
A1007.5	–	7.50	0.2953	69.0	109.0	7.50
A10019/64	19/64	7.54	0.2969	75.0	117.0	7.54
A1007.6	–	7.60	0.2992	75.0	117.0	7.60
A100N	N	7.67	0.3020	75.0	117.0	7.67
A1007.7	–	7.70	0.3031	75.0	117.0	7.70
A1007.75	–	7.75	0.3051	75.0	117.0	7.75
A1007.8	–	7.80	0.3071	75.0	117.0	7.80
A1007.9	–	7.90	0.3110	75.0	117.0	7.90
A1005/16	5/16	7.94	0.3125	75.0	117.0	7.94
A1008.0	–	8.00	0.3150	75.0	117.0	8.00
A100O	O	8.03	0.3160	75.0	117.0	8.03
A1008.1	–	8.10	0.3189	75.0	117.0	8.10
A1008.2	–	8.20	0.3228	75.0	117.0	8.20
A1008.25	–	8.25	0.3248	75.0	117.0	8.25
A1008.3	–	8.30	0.3268	75.0	117.0	8.30
A10021/64	21/64	8.33	0.3281	75.0	117.0	8.33
A1008.4	–	8.40	0.3307	75.0	117.0	8.40
A100Q	Q	8.43	0.3320	75.0	117.0	8.43
A1008.5	–	8.50	0.3346	75.0	117.0	8.50
A1008.6	–	8.60	0.3386	81.0	125.0	8.60
A1008.7	–	8.70	0.3425	81.0	125.0	8.70
A10011/32	11/32	8.73	0.3438	81.0	125.0	8.73
A1008.75	–	8.75	0.3445	81.0	125.0	8.75
A1008.8	–	8.80	0.3465	81.0	125.0	8.80
A1008.9	–	8.90	0.3504	81.0	125.0	8.90
A1009.0	–	9.00	0.3543	81.0	125.0	9.00
A1009.1	–	9.10	0.3583	81.0	125.0	9.10
A10023/64	23/64	9.13	0.3594	81.0	125.0	9.13
A1009.2	–	9.20	0.3622	81.0	125.0	9.20
A1009.25	–	9.25	0.3642	81.0	125.0	9.25
A1009.3	–	9.30	0.3661	81.0	125.0	9.30
A100U	U	9.35	0.3680	81.0	125.0	9.35
A1009.4	–	9.40	0.3701	81.0	125.0	9.40
A1009.5	–	9.50	0.3740	81.0	125.0	9.50
A1003/8	3/8	9.52	0.3750	87.0	133.0	9.52
A1009.6	–	9.60	0.3780	87.0	133.0	9.60
A1009.7	–	9.70	0.3819	87.0	133.0	9.70
A1009.75	–	9.75	0.3839	87.0	133.0	9.75
A1009.8	–	9.80	0.3858	87.0	133.0	9.80
A1009.9	–	9.90	0.3898	87.0	133.0	9.90
A10025/64	25/64	9.92	0.3906	87.0	133.0	9.92
A10010.0	–	10.00	0.3937	87.0	133.0	10.00
A10010.1	–	10.10	0.3976	87.0	133.0	10.10
A10010.2	–	10.20	0.4016	87.0	133.0	10.20
A10010.25	–	10.25	0.4035	87.0	133.0	10.25
A10010.3	–	10.30	0.4055	87.0	133.0	10.30
A10013/32	13/32	10.32	0.4063	87.0	133.0	10.32
A10010.4	–	10.40	0.4094	87.0	133.0	10.40
A10010.5	–	10.50	0.4134	87.0	133.0	10.50
A10010.6	–	10.60	0.4173	87.0	133.0	10.60
A10010.7	–	10.70	0.4213	94.0	142.0	10.70
A10027/64	27/64	10.72	0.4219	94.0	142.0	10.72
A10010.75	–	10.75	0.4232	94.0	142.0	10.75
A10010.8	–	10.80	0.4252	94.0	142.0	10.80
A10010.9	–	10.90	0.4291	94.0	142.0	10.90
A10011.0	–	11.00	0.4331	94.0	142.0	11.00
A10011.1	–	11.10	0.4370	94.0	142.0	11.10
A1007/16	7/16	11.11	0.4375	94.0	142.0	11.11

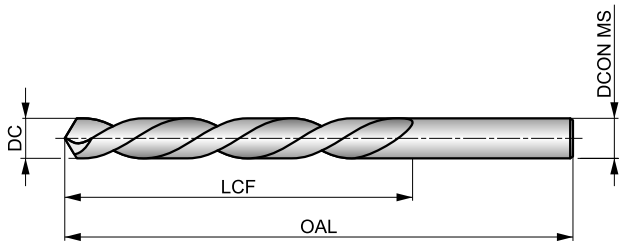
Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A10011.2	–	11.20	0.4409	94.0	142.0	11.20
A10011.25	–	11.25	0.4429	94.0	142.0	11.25
A10011.3	–	11.30	0.4449	94.0	142.0	11.30
A10011.4	–	11.40	0.4488	94.0	142.0	11.40
A10011.5	–	11.50	0.4528	94.0	142.0	11.50
A10029/64	29/64	11.51	0.4531	94.0	142.0	11.51
A10011.6	–	11.60	0.4567	94.0	142.0	11.60
A10011.7	–	11.70	0.4606	94.0	142.0	11.70
A10011.75	–	11.75	0.4626	94.0	142.0	11.75
A10011.8	–	11.80	0.4646	94.0	142.0	11.80
A10011.9	–	11.90	0.4685	101.0	151.0	11.90
A10015/32	15/32	11.91	0.4688	101.0	151.0	11.91
A10012.0	–	12.00	0.4724	101.0	151.0	12.00
A10012.1	–	12.10	0.4764	101.0	151.0	12.10
A10012.2	–	12.20	0.4803	101.0	151.0	12.20
A10012.25	–	12.25	0.4823	101.0	151.0	12.25
A10012.3	–	12.30	0.4843	101.0	151.0	12.30
A10031/64	31/64	12.30	0.4844	101.0	151.0	12.30
A10012.4	–	12.40	0.4882	101.0	151.0	12.40
A10012.5	–	12.50	0.4921	101.0	151.0	12.50
A10012.6	–	12.60	0.4961	101.0	151.0	12.60
A10012.7	–	12.70	0.5000	101.0	151.0	12.70
A1001/2	1/2	12.70	0.5000	101.0	151.0	12.70
A10012.75	–	12.75	0.5020	101.0	151.0	12.75
A10012.8	–	12.80	0.5039	101.0	151.0	12.80
A10012.9	–	12.90	0.5079	101.0	151.0	12.90
A10013.0	–	13.00	0.5118	101.0	151.0	13.00
A10033/64	33/64	13.10	0.5156	101.0	151.0	13.10
A10013.1	–	13.10	0.5157	101.0	151.0	13.10
A10013.2	–	13.20	0.5197	101.0	151.0	13.20
A10013.25	–	13.25	0.5217	108.0	160.0	13.25
A10013.3	–	13.30	0.5236	108.0	160.0	13.30
A10013.4	–	13.40	0.5276	108.0	160.0	13.40

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A10017/32	17/32	13.49	0.5313	108.0	160.0	13.49
A10013.5	–	13.50	0.5315	108.0	160.0	13.50
A10013.6	–	13.60	0.5354	108.0	160.0	13.60
A10013.7	–	13.70	0.5394	108.0	160.0	13.70
A10013.75	–	13.75	0.5413	108.0	160.0	13.75
A10013.8	–	13.80	0.5433	108.0	160.0	13.80
A10035/64	35/64	13.89	0.5469	108.0	160.0	13.89
A10013.9	–	13.90	0.5472	108.0	160.0	13.90
A10014.0	–	14.00	0.5512	108.0	160.0	14.00
A10014.25	–	14.25	0.5610	114.0	169.0	14.25
A1009/16	9/16	14.29	0.5625	114.0	169.0	14.29
A10014.5	–	14.50	0.5709	114.0	169.0	14.50
A10037/64	37/64	14.68	0.5781	114.0	169.0	14.68
A10014.75	–	14.75	0.5807	114.0	169.0	14.75
A10015.0	–	15.00	0.5906	114.0	169.0	15.00
A10019/32	19/32	15.08	0.5938	120.0	178.0	15.08
A10015.25	–	15.25	0.6004	120.0	178.0	15.25
A10015.5	–	15.50	0.6102	120.0	178.0	15.50
A10015.75	–	15.75	0.6201	120.0	178.0	15.75
A1005/8	5/8	15.88	0.6250	120.0	178.0	15.88
A10016.0	–	16.00	0.6299	120.0	178.0	16.00
A10041/64	41/64	16.27	0.6406	125.0	184.0	16.27
A10016.5	–	16.50	0.6496	125.0	184.0	16.50
A10021/32	21/32	16.67	0.6563	125.0	184.0	16.67
A10017.0	–	17.00	0.6693	125.0	184.0	17.00
A10011/16	11/16	17.46	0.6875	130.0	191.0	17.46
A10017.5	–	17.50	0.6890	130.0	191.0	17.50
A10018.0	–	18.00	0.7087	130.0	191.0	18.00
A10018.5	–	18.50	0.7283	135.0	198.0	18.50
A10019.0	–	19.00	0.7480	135.0	198.0	19.00
A10019.5	–	19.50	0.7677	140.0	205.0	19.50
A10020.0	–	20.00	0.7874	140.0	205.0	20.00

A101

DORMER

普通长度左旋高速钢钻头，蒸汽回火处理。
多功能的左旋钻头，传统的118°钻尖角，强壮且便于重磨，从而经济型更好，蒸汽回火处理能够留存切削液，防止刀具粘屑，可用于手持式工具或机床，适用于多种材料的切削。



HSS	DIN 338	4×D
118°	ST	
λ20-35°	L	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■33 H	■37 H	■38 H	■28 H	■25 F	◪22 E	■19 F	■15 F	◪13 E	■11 F	◪10 E	◪8 D	◪21 E	◪17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪18 E	◪15 E	◪9 G	◪8 G	◪7 G	◪9 C	■30 H	■22 F	■17 F	◪25 E	◪20 E	◪16 E	◪22 E	◪17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 E	◪20 E	◪15 E	◪11 E	◪10 E	◪8 E	◪23 E	◪17 E	◪13 E	◪33 J	◪25 J	◪17 I	◪42 H	◪37 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪27 H	◪59 H	◪35 I	◪18 G	◪30 J	◪28 H	◪14 F	◪23 E	◪12 D	◪6 B	◪8 E	◪4 A	◪6 E	◪3 A
S4.1	S4.2												
◪5 E	◪2 A												

DC <= 3mm 光亮表面

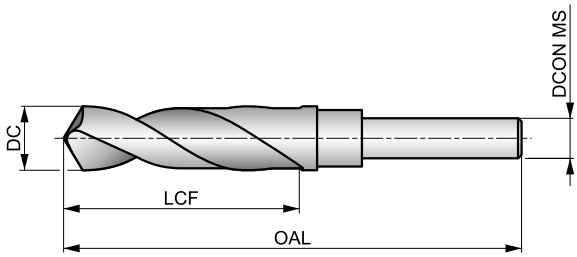
Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1011.0	1.00	0.0394	12.0	34.0	1.00
A1011.1	1.10	0.0433	14.0	36.0	1.10
A1011.2	1.20	0.0472	16.0	38.0	1.20
A1011.25	1.25	0.0492	16.0	38.0	1.25
A1011.3	1.30	0.0512	16.0	38.0	1.30
A1011.4	1.40	0.0551	18.0	40.0	1.40
A1011.5	1.50	0.0591	18.0	40.0	1.50
A1011.6	1.60	0.0630	20.0	43.0	1.60
A1011.7	1.70	0.0669	20.0	43.0	1.70
A1011.8	1.80	0.0709	22.0	46.0	1.80
A1011.9	1.90	0.0748	22.0	46.0	1.90
A1012.0	2.00	0.0787	24.0	49.0	2.00
A1012.1	2.10	0.0827	24.0	49.0	2.10
A1012.2	2.20	0.0866	27.0	53.0	2.20
A1012.4	2.40	0.0945	30.0	57.0	2.40
A1012.5	2.50	0.0984	30.0	57.0	2.50
A1012.6	2.60	0.1024	30.0	57.0	2.60
A1012.7	2.70	0.1063	33.0	61.0	2.70
A1012.8	2.80	0.1102	33.0	61.0	2.80
A1012.9	2.90	0.1142	33.0	61.0	2.90
A1013.0	3.00	0.1181	33.0	61.0	3.00
A1013.2	3.20	0.1260	36.0	65.0	3.20

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1013.3	3.30	0.1299	36.0	65.0	3.30
A1013.5	3.50	0.1378	39.0	70.0	3.50
A1013.8	3.80	0.1496	43.0	75.0	3.80
A1014.0	4.00	0.1575	43.0	75.0	4.00
A1014.2	4.20	0.1654	43.0	75.0	4.20
A1014.5	4.50	0.1772	47.0	80.0	4.50
A1014.8	4.80	0.1890	52.0	86.0	4.80
A1015.0	5.00	0.1969	52.0	86.0	5.00
A1015.1	5.10	0.2008	52.0	86.0	5.10
A1015.2	5.20	0.2047	52.0	86.0	5.20
A1015.5	5.50	0.2165	57.0	93.0	5.50
A1016.0	6.00	0.2362	57.0	93.0	6.00
A1016.5	6.50	0.2559	63.0	101.0	6.50
A1017.0	7.00	0.2756	69.0	109.0	7.00
A1017.5	7.50	0.2953	69.0	109.0	7.50
A1018.0	8.00	0.3150	75.0	117.0	8.00
A1018.5	8.50	0.3346	75.0	117.0	8.50
A1019.0	9.00	0.3543	81.0	125.0	9.00
A10110.0	10.00	0.3937	87.0	133.0	10.00
A10111.0	11.00	0.4331	94.0	142.0	11.00
A10112.0	12.00	0.4724	101.0	151.0	12.00

A170

DORMER

高速钢缩柄钻，蒸汽回火处理。
即使切削直径较大，?英寸的直柄也使该钻头能被夹持在传统的手持式电动工具中。118°钻尖角便于重磨。蒸汽回火的表面处理能够留存切削液，防止刀具粘屑。适用于多种材料的切削。



HSS	DORMER	4×D
118°	ST	
λ20-35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■33 H	■37 H	■38 H	■28 H	■25 F	◪22 D	◪19 E	◪15 E	◪13 D	◪11 E	◪10 D	◪8 C	◪21 D	◪17 D
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪18 D	◪15 D	◪8 F	◪7 F	◪6 F	◪7 B	◪27 H	◪20 E	◪15 E	◪23 D	◪19 D	◪15 D	◪21 D	◪16 D
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 D	◪19 D	◪14 D	◪11 D	◪9 D	◪8 D	◪22 D	◪16 D	◪13 D	◪33 I	◪25 I	◪17 H	◪42 G	◪37 G
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪27 G	◪56 G	◪33 H	◪17 F	◪30 I	◪28 G	◪14 E	◪17 E	◪9 C	◪5 A	◪5 D	◪4 A	◪4 D	◪3 A
S4.1	S4.2												
◪3 D	◪2 A												

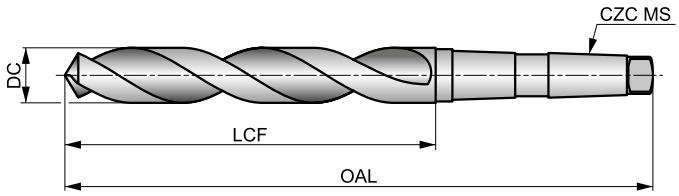
Product	DC (inch)	DC (mm)	DC (inch)	LCF (inch)	OAL (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A17013.0	–	13.00	0.5118	–	–	83.0	156.0	12.70
A17033/64	33/64	13.10	0.5156	3.1/8	6″	79.4	152.4	12.70
A17017/32	17/32	13.49	0.5313	3.1/8	6″	79.4	152.4	12.70
A17013.5	–	13.50	0.5315	–	–	83.0	156.0	12.70
A17035/64	35/64	13.89	0.5469	3.1/8	6″	79.4	152.4	12.70
A17014.0	–	14.00	0.5512	–	–	83.0	156.0	12.70
A1709/16	9/16	14.29	0.5625	3.1/8	6″	79.4	152.4	12.70
A17014.5	–	14.50	0.5709	–	–	83.0	156.0	12.70
A17037/64	37/64	14.68	0.5781	3.1/8	6″	79.4	152.4	12.70
A17015.0	–	15.00	0.5906	–	–	83.0	156.0	12.70
A17019/32	19/32	15.08	0.5938	3.1/8	6″	79.4	152.4	12.70
A17039/64	39/64	15.48	0.6094	3.1/8	6″	79.4	152.4	12.70
A17015.5	–	15.50	0.6102	–	–	83.0	156.0	12.70
A1705/8	5/8	15.88	0.6250	3.1/8	6″	79.4	152.4	12.70
A17016.0	–	16.00	0.6299	–	–	84.0	157.0	12.70
A17041/64	41/64	16.27	0.6406	3.1/8	6″	79.4	152.4	12.70
A17016.5	–	16.50	0.6496	–	–	84.0	157.0	12.70
A17021/32	21/32	16.67	0.6563	3.1/8	6″	79.4	152.4	12.70
A17017.0	–	17.00	0.6693	–	–	84.0	157.0	12.70
A17043/64	43/64	17.07	0.6719	3.1/8	6″	79.4	152.4	12.70
A17011/16	11/16	17.46	0.6875	3.1/8	6″	79.4	152.4	12.70
A17017.5	–	17.50	0.6890	–	–	84.0	157.0	12.70
A17045/64	45/64	17.86	0.7031	3.1/8	6″	79.4	152.4	12.70
A17018.0	–	18.00	0.7087	–	–	84.0	157.0	12.70

Product	DC (inch)	DC (mm)	DC (inch)	LCF (inch)	OAL (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A17023/32	23/32	18.26	0.7188	3.1/8	6″	79.4	152.4	12.70
A17018.5	–	18.50	0.7283	–	–	84.0	157.0	12.70
A17047/64	47/64	18.65	0.7344	3.1/8	6″	79.4	152.4	12.70
A17019.0	–	19.00	0.7480	–	–	84.0	157.0	12.70
A1703/4	3/4	19.05	0.7500	3.1/8	6″	79.4	152.4	12.70
A17049/64	49/64	19.45	0.7656	3″	6″	76.2	152.4	12.70
A17019.5	–	19.50	0.7677	–	–	81.0	158.0	12.70
A17025/32	25/32	19.84	0.7813	3″	6″	76.2	152.4	12.70
A17020.0	–	20.00	0.7874	–	–	81.0	158.0	12.70
A17051/64	51/64	20.24	0.7969	3″	6″	76.2	152.4	12.70
A17013/16	13/16	20.64	0.8125	3″	6″	76.2	152.4	12.70
A17021.0	–	21.00	0.8268	–	–	82.0	158.0	12.70
A17053/64	53/64	21.03	0.8281	3″	6″	76.2	152.4	12.70
A17027/32	27/32	21.43	0.8437	3″	6″	76.2	152.4	12.70
A17055/64	55/64	21.83	0.8594	3″	6″	76.2	152.4	12.70
A17022.0	–	22.00	0.8661	–	–	82.0	158.0	12.70
A1707/8	7/8	22.22	0.8750	3″	6″	76.2	152.4	12.70
A17023.0	–	23.00	0.9055	–	–	82.0	158.0	12.70
A17029/32	29/32	23.02	0.9063	3″	6″	76.2	152.4	12.70
A17059/64	59/64	23.42	0.9219	3″	6″	76.2	152.4	12.70
A17015/16	15/16	23.81	0.9375	3″	6″	76.2	152.4	12.70
A17024.0	–	24.00	0.9449	–	–	83.0	159.0	12.70
A17031/32	31/32	24.61	0.9688	3″	6″	76.2	152.4	12.70
A17025.0	–	25.00	0.9843	–	–	83.0	159.0	12.70
A1701	1″	25.40	1.0000	3″	6″	76.2	152.4	12.70
A1701.1/32	1.1/32	26.19	1.0313	3″	6″	76.2	152.4	12.70
A1701.1/16	1.1/16	26.99	1.0625	3″	6″	76.2	152.4	12.70
A1701.1/8	1.1/8	28.58	1.1250	3″	6″	76.2	152.4	12.70
A1701.3/16	1.3/16	30.16	1.1875	3″	6″	76.2	152.4	12.70
A1701.1/4	1.1/4	31.75	1.2500	3″	6″	76.2	152.4	12.70

A130

DORMER

高速钢锥柄钻头，蒸汽氧化处理。
大直径的多功能钻头，切削直径可达50.8(2英寸)，锥柄结构能够在机床中提供更好的夹紧力，传统的118°钻尖角，强壮且便于重磨，蒸汽回火处理能够留存切削液，防止刀具粘屑，适用于多种材料的切削。



HSS	DIN 345	4×D
118°	ST	
λ20-35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■33 I	■37 I	■38 I	■28 I	■25 F	◪22 E	■18 F	■14 F	◪12 E	■11 F	◪9 E	◪7 D	◪21 E	◪17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪18 E	◪15 E	◪10 G	◪9 G	◪8 G	◪10 C	■30 I	■22 E	■17 E	◪25 E	◪20 E	◪16 E	◪22 E	◪17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 E	◪20 E	◪15 E	◪11 E	◪10 E	◪8 E	◪23 E	◪17 E	◪13 E	◪26 J	◪20 J	◪13 I	◪43 H	◪39 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪28 H	◪59 H	◪35 I	◪18 F	◪30 K	◪28 J	◪14 H	◪23 F	◪13 D	◪7 B	◪9 E	◪6 A	◪7 E	◪4 A
S4.1	S4.2												
◪5 E	◪3 A												

DC > 14mm 芯厚减薄

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	CZC MS
A1303.0	–	3.00	0.1181	33.0	114.0	MK 1
A1301/8	1/8	3.18	0.1250	36.0	117.0	MK 1
A1303.3	–	3.30	0.1299	36.0	117.0	MK 1
A1303.5	–	3.50	0.1378	39.0	120.0	MK 1
A1304.0	–	4.00	0.1575	43.0	124.0	MK 1
A1304.2	–	4.20	0.1654	43.0	124.0	MK 1
A1304.25	–	4.25	0.1673	43.0	124.0	MK 1
A1304.5	–	4.50	0.1772	47.0	128.0	MK 1
A1303/16	3/16	4.76	0.1875	52.0	133.0	MK 1
A1305.0	–	5.00	0.1969	52.0	133.0	MK 1
A1305.1	–	5.10	0.2008	52.0	133.0	MK 1
A13013/64	13/64	5.16	0.2031	52.0	133.0	MK 1
A1305.2	–	5.20	0.2047	52.0	133.0	MK 1
A1305.5	–	5.50	0.2165	57.0	138.0	MK 1
A1306.0	–	6.00	0.2362	57.0	138.0	MK 1
A1301/4	1/4	6.35	0.2500	63.0	144.0	MK 1
A1306.5	–	6.50	0.2559	63.0	144.0	MK 1
A1306.7	–	6.70	0.2638	63.0	144.0	MK 1
A13017/64	17/64	6.75	0.2656	69.0	150.0	MK 1
A1306.75	–	6.75	0.2657	69.0	150.0	MK 1
A1306.8	–	6.80	0.2677	69.0	150.0	MK 1
A1307.0	–	7.00	0.2756	69.0	150.0	MK 1
A1309/32	9/32	7.14	0.2813	69.0	150.0	MK 1

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	CZC MS
A1307.5	–	7.50	0.2953	69.0	150.0	MK 1
A1305/16	5/16	7.94	0.3125	75.0	156.0	MK 1
A1308.0	–	8.00	0.3150	75.0	156.0	MK 1
A1308.2	–	8.20	0.3228	75.0	156.0	MK 1
A1308.5	–	8.50	0.3346	75.0	156.0	MK 1
A1308.6	–	8.60	0.3386	81.0	162.0	MK 1
A1308.7	–	8.70	0.3425	81.0	162.0	MK 1
A13011/32	11/32	8.73	0.3438	81.0	162.0	MK 1
A1308.75	–	8.75	0.3445	81.0	162.0	MK 1
A1309.0	–	9.00	0.3543	81.0	162.0	MK 1
A1309.5	–	9.50	0.3740	81.0	162.0	MK 1
A1303/8	3/8	9.52	0.3750	87.0	168.0	MK 1
A13010.0	–	10.00	0.3937	87.0	168.0	MK 1
A13010.2	–	10.20	0.4016	87.0	168.0	MK 1
A13010.25	–	10.25	0.4035	87.0	168.0	MK 1
A13010.3	–	10.30	0.4055	87.0	168.0	MK 1
A13013/32	13/32	10.32	0.4063	87.0	168.0	MK 1
A13010.5	–	10.50	0.4134	87.0	168.0	MK 1
A13027/64	27/64	10.72	0.4219	94.0	175.0	MK 1
A13010.75	–	10.75	0.4232	94.0	175.0	MK 1
A13010.8	–	10.80	0.4252	94.0	175.0	MK 1
A13011.0	–	11.00	0.4331	94.0	175.0	MK 1
A1307/16	7/16	11.11	0.4375	94.0	175.0	MK 1
A13011.2	–	11.20	0.4409	94.0	175.0	MK 1
A13011.5	–	11.50	0.4528	94.0	175.0	MK 1
A13011.75	–	11.75	0.4626	94.0	175.0	MK 1
A13011.8	–	11.80	0.4646	94.0	175.0	MK 1
A13012.0	–	12.00	0.4724	101.0	182.0	MK 1
A13012.2	–	12.20	0.4803	101.0	182.0	MK 1
A13012.25	–	12.25	0.4823	101.0	182.0	MK 1
A13031/64	31/64	12.30	0.4844	101.0	182.0	MK 1
A13012.5	–	12.50	0.4921	101.0	182.0	MK 1
A13012.7	–	12.70	0.5000	101.0	182.0	MK 1
A1301/2	1/2	12.70	0.5000	101.0	182.0	MK 1
A13012.75	–	12.75	0.5020	101.0	182.0	MK 1
A13012.8	–	12.80	0.5039	101.0	182.0	MK 1
A13013.0	–	13.00	0.5118	101.0	182.0	MK 1
A13033/64	33/64	13.10	0.5156	101.0	182.0	MK 1
A13013.2	–	13.20	0.5197	101.0	182.0	MK 1
A13013.25	–	13.25	0.5217	108.0	189.0	MK 1
A13017/32	17/32	13.49	0.5313	108.0	189.0	MK 1
A13013.5	–	13.50	0.5315	108.0	189.0	MK 1
A13013.75	–	13.75	0.5413	108.0	189.0	MK 1
A13013.8	–	13.80	0.5433	108.0	189.0	MK 1
A13013.9	–	13.90	0.5472	108.0	189.0	MK 1
A13014.0	–	14.00	0.5512	108.0	189.0	MK 1
A13014.1	–	14.10	0.5551	114.0	212.0	MK 2
A13014.2	–	14.20	0.5591	114.0	212.0	MK 2
A13014.25	–	14.25	0.5610	114.0	212.0	MK 2
A1309/16	9/16	14.29	0.5625	114.0	212.0	MK 2
A13014.3	–	14.30	0.5630	114.0	212.0	MK 2
A13014.5	–	14.50	0.5709	114.0	212.0	MK 2
A13037/64	37/64	14.68	0.5781	114.0	212.0	MK 2
A13014.75	–	14.75	0.5807	114.0	212.0	MK 2
A13014.8	–	14.80	0.5827	114.0	212.0	MK 2
A13014.9	–	14.90	0.5866	114.0	212.0	MK 2
A13015.0	–	15.00	0.5906	114.0	212.0	MK 2
A13015.1	–	15.10	0.5945	120.0	218.0	MK 2
A13015.2	–	15.20	0.5984	120.0	218.0	MK 2
A13015.25	–	15.25	0.6004	120.0	218.0	MK 2
A13039/64	39/64	15.48	0.6094	120.0	218.0	MK 2
A13015.5	–	15.50	0.6102	120.0	218.0	MK 2

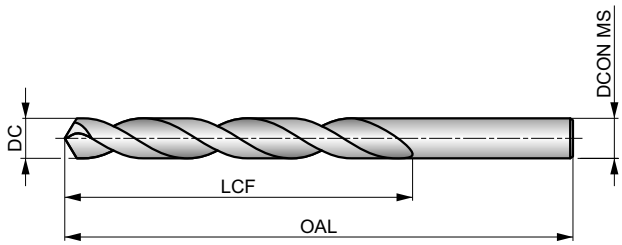
Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	CZC MS
A13015.7	–	15.70	0.6181	120.0	218.0	MK 2
A13015.75	–	15.75	0.6201	120.0	218.0	MK 2
A13015.8	–	15.80	0.6220	120.0	218.0	MK 2
A1305/8	5/8	15.88	0.6250	120.0	218.0	MK 2
A13015.9	–	15.90	0.6260	120.0	218.0	MK 2
A13016.0	–	16.00	0.6299	120.0	218.0	MK 2
A13016.1	–	16.10	0.6339	125.0	223.0	MK 2
A13016.2	–	16.20	0.6378	125.0	223.0	MK 2
A13016.25	–	16.25	0.6398	125.0	223.0	MK 2
A13041/64	41/64	16.27	0.6406	125.0	223.0	MK 2
A13016.5	–	16.50	0.6496	125.0	223.0	MK 2
A13021/32	21/32	16.67	0.6563	125.0	223.0	MK 2
A13016.75	–	16.75	0.6594	125.0	223.0	MK 2
A13017.0	–	17.00	0.6693	125.0	223.0	MK 2
A13043/64	43/64	17.07	0.6719	130.0	228.0	MK 2
A13017.25	–	17.25	0.6791	130.0	228.0	MK 2
A13011/16	11/16	17.46	0.6875	130.0	228.0	MK 2
A13017.5	–	17.50	0.6890	130.0	228.0	MK 2
A13017.75	–	17.75	0.6988	130.0	228.0	MK 2
A13045/64	45/64	17.86	0.7031	130.0	228.0	MK 2
A13018.0	–	18.00	0.7087	130.0	228.0	MK 2
A13018.25	–	18.25	0.7185	135.0	233.0	MK 2
A13023/32	23/32	18.26	0.7188	135.0	233.0	MK 2
A13018.5	–	18.50	0.7283	135.0	233.0	MK 2
A13047/64	47/64	18.65	0.7344	135.0	233.0	MK 2
A13018.75	–	18.75	0.7382	135.0	233.0	MK 2
A13019.0	–	19.00	0.7480	135.0	233.0	MK 2
A1303/4	3/4	19.05	0.7500	140.0	238.0	MK 2
A13019.25	–	19.25	0.7579	140.0	238.0	MK 2
A13019.5	–	19.50	0.7677	140.0	238.0	MK 2
A13019.75	–	19.75	0.7776	140.0	238.0	MK 2
A13025/32	25/32	19.84	0.7813	140.0	238.0	MK 2
A13020.0	–	20.00	0.7874	140.0	238.0	MK 2
A13020.25	–	20.25	0.7972	145.0	243.0	MK 2
A13020.5	–	20.50	0.8071	145.0	243.0	MK 2
A13013/16	13/16	20.64	0.8125	145.0	243.0	MK 2
A13020.75	–	20.75	0.8169	145.0	243.0	MK 2
A13021.0	–	21.00	0.8268	145.0	243.0	MK 2
A13021.25	–	21.25	0.8366	150.0	248.0	MK 2
A13021.5	–	21.50	0.8465	150.0	248.0	MK 2
A13021.75	–	21.75	0.8563	150.0	248.0	MK 2
A13022.0	–	22.00	0.8661	150.0	248.0	MK 2
A1307/8	7/8	22.22	0.8750	150.0	248.0	MK 2
A13022.25	–	22.25	0.8760	150.0	248.0	MK 2
A13022.5	–	22.50	0.8858	155.0	253.0	MK 2
A13057/64	57/64	22.62	0.8906	155.0	253.0	MK 2
A13022.75	–	22.75	0.8957	155.0	253.0	MK 2
A13023.0	–	23.00	0.9055	155.0	253.0	MK 2
A13029/32	29/32	23.02	0.9063	155.0	253.0	MK 2
A13023.25	–	23.25	0.9154	155.0	276.0	MK 3
A13023.5	–	23.50	0.9252	155.0	276.0	MK 3
A13023.75	–	23.75	0.9350	160.0	281.0	MK 3
A13015/16	15/16	23.81	0.9375	160.0	281.0	MK 3
A13024.0	–	24.00	0.9449	160.0	281.0	MK 3
A13061/64	61/64	24.21	0.9531	160.0	281.0	MK 3
A13024.5	–	24.50	0.9646	160.0	281.0	MK 3
A13024.75	–	24.75	0.9744	160.0	281.0	MK 3
A13025.0	–	25.00	0.9843	160.0	281.0	MK 3
A13025.25	–	25.25	0.9941	165.0	286.0	MK 3
A1301	1″	25.40	1.0000	165.0	286.0	MK 3
A13025.5	–	25.50	1.0039	165.0	286.0	MK 3
A13025.75	–	25.75	1.0138	165.0	286.0	MK 3

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	CZC MS
A13026.0	–	26.00	1.0236	165.0	286.0	MK 3
A13026.25	–	26.25	1.0335	165.0	286.0	MK 3
A13026.5	–	26.50	1.0433	165.0	286.0	MK 3
A1301.1/16	1.1/16	26.99	1.0625	170.0	291.0	MK 3
A13027.0	–	27.00	1.0630	170.0	291.0	MK 3
A13027.5	–	27.50	1.0827	170.0	291.0	MK 3
A13028.0	–	28.00	1.1024	170.0	291.0	MK 3
A13028.5	–	28.50	1.1220	175.0	296.0	MK 3
A1301.1/8	1.1/8	28.58	1.1250	175.0	296.0	MK 3
A13029.0	–	29.00	1.1417	175.0	296.0	MK 3
A13029.5	–	29.50	1.1614	175.0	296.0	MK 3
A13030.0	–	30.00	1.1811	175.0	296.0	MK 3
A1301.3/16	1.3/16	30.16	1.1875	180.0	301.0	MK 3
A13030.5	–	30.50	1.2008	180.0	301.0	MK 3
A13031.0	–	31.00	1.2205	180.0	301.0	MK 3
A13031.5	–	31.50	1.2402	180.0	301.0	MK 3
A1301.1/4	1.1/4	31.75	1.2500	185.0	306.0	MK 3
A13032.0	–	32.00	1.2598	185.0	334.0	MK 4
A13032.5	–	32.50	1.2795	185.0	334.0	MK 4
A13033.0	–	33.00	1.2992	185.0	334.0	MK 4
A13033.5	–	33.50	1.3189	185.0	334.0	MK 4
A13034.0	–	34.00	1.3386	190.0	339.0	MK 4
A13034.5	–	34.50	1.3583	190.0	339.0	MK 4
A1301.3/8	1.3/8	34.93	1.3750	190.0	339.0	MK 4
A13035.0	–	35.00	1.3780	190.0	339.0	MK 4
A13035.5	–	35.50	1.3976	190.0	339.0	MK 4
A13036.0	–	36.00	1.4173	195.0	344.0	MK 4
A13037.0	–	37.00	1.4567	195.0	344.0	MK 4
A13037.5	–	37.50	1.4764	195.0	344.0	MK 4
A13038.0	–	38.00	1.4961	200.0	349.0	MK 4
A1301.1/2	1.1/2	38.10	1.5000	200.0	349.0	MK 4
A13038.5	–	38.50	1.5157	200.0	349.0	MK 4
A13039.0	–	39.00	1.5354	200.0	349.0	MK 4
A13039.5	–	39.50	1.5551	200.0	349.0	MK 4
A13040.0	–	40.00	1.5748	200.0	349.0	MK 4
A13041.0	–	41.00	1.6142	205.0	354.0	MK 4
A13042.0	–	42.00	1.6535	205.0	354.0	MK 4
A13043.0	–	43.00	1.6929	210.0	359.0	MK 4
A13044.0	–	44.00	1.7323	210.0	359.0	MK 4
A1301.3/4	1.3/4	44.45	1.7500	210.0	359.0	MK 4
A13045.0	–	45.00	1.7717	210.0	359.0	MK 4
A13046.0	–	46.00	1.8110	215.0	364.0	MK 4
A13048.0	–	48.00	1.8898	220.0	369.0	MK 4
A13049.0	–	49.00	1.9291	220.0	369.0	MK 4
A13050.0	–	50.00	1.9685	220.0	369.0	MK 4
A1302	2″	50.80	2.0000	225.0	374.0	MK 4

A002

DORMER

普通长度高速钢钻头，头部氮化钛涂层。
多功能的钻头，特殊设计的118°钻尖角有助于在使用手持式工具时自定心并确保孔径精度，头部氮化钛涂层提高了切削性能并延长了刀具寿命，可用于手持式工具或机床，适用于多种材料的切削。



HSS	DIN 338	4×D
118°	TiN-Tip	
λ20-35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■46 J	■52 J	■54 J	■40 J	■35 F	◪31 F	■27 F	■21 F	◪18 F	■16 F	◪13 F	◪11 E	◪27 F	◪23 F
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪24 F	◪20 F	◪14 G	◪12 G	◪11 G	◪16 C	■40 J	■30 E	■22 E	◪34 E	◪28 E	◪22 E	◪30 E	◪23 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪19 E	◪28 E	◪21 E	◪16 E	◪13 E	◪11 E	◪32 E	◪24 E	◪19 E	■41 K	■31 K	■21 J	◪51 I	◪46 I
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪33 I	◪56 H	◪33 I	◪17 G	■30 I	■50 H	◪35 F	◪23 F	◪13 D	◪7 B	◪9 E	◪4 A	◪7 E	◪3 A
S4.1	S4.2												
◪5 E	◪2 A												

DC < 2mm 光亮表面; DC >= 2mm 端部涂 TiN 的分离式钻尖
该系列产品有配套提供，请参见A087、A089、A094、A095、A099

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A0021.0	–	1.00	0.0394	12.0	34.0	1.00
A0021.1	–	1.10	0.0433	14.0	36.0	1.10
A0023/64	3/64	1.19	0.0469	16.0	38.0	1.19
A0021.2	–	1.20	0.0472	16.0	38.0	1.20
A0021.3	–	1.30	0.0512	16.0	38.0	1.30
A0021.4	–	1.40	0.0551	18.0	40.0	1.40
A0021.5	–	1.50	0.0591	18.0	40.0	1.50
A0021/16	1/16	1.59	0.0625	20.0	43.0	1.59
A0021.6	–	1.60	0.0630	20.0	43.0	1.60
A0021.7	–	1.70	0.0669	20.0	43.0	1.70
A0021.8	–	1.80	0.0709	22.0	46.0	1.80
A0021.9	–	1.90	0.0748	22.0	46.0	1.90
A0025/64	5/64	1.98	0.0781	24.0	49.0	1.98
A0022.0	–	2.00	0.0787	24.0	49.0	2.00
A0022.1	–	2.10	0.0827	24.0	49.0	2.10
A0022.2	–	2.20	0.0866	27.0	53.0	2.20
A0022.3	–	2.30	0.0906	27.0	53.0	2.30
A0023/32	3/32	2.38	0.0938	30.0	57.0	2.38
A0022.4	–	2.40	0.0945	30.0	57.0	2.40
A0022.5	–	2.50	0.0984	30.0	57.0	2.50
A0022.6	–	2.60	0.1024	30.0	57.0	2.60
A0022.7	–	2.70	0.1063	33.0	61.0	2.70

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A0027/64	7/64	2.78	0.1094	33.0	61.0	2.78
A0022.8	–	2.80	0.1102	33.0	61.0	2.80
A0022.9	–	2.90	0.1142	33.0	61.0	2.90
A0023.0	–	3.00	0.1181	33.0	61.0	3.00
A0023.1	–	3.10	0.1220	36.0	65.0	3.10
A0021/8	1/8	3.18	0.1250	36.0	65.0	3.18
A0023.2	–	3.20	0.1260	36.0	65.0	3.20
A0023.25	–	3.25	0.1280	36.0	65.0	3.25
A0023.3	–	3.30	0.1299	36.0	65.0	3.30
A0023.4	–	3.40	0.1339	39.0	70.0	3.40
A0023.5	–	3.50	0.1378	39.0	70.0	3.50
A0029/64	9/64	3.57	0.1406	39.0	70.0	3.57
A0023.6	–	3.60	0.1417	39.0	70.0	3.60
A0023.7	–	3.70	0.1457	39.0	70.0	3.70
A0023.8	–	3.80	0.1496	43.0	75.0	3.80
A0023.9	–	3.90	0.1535	43.0	75.0	3.90
A0025/32	5/32	3.97	0.1563	43.0	75.0	3.97
A0024.0	–	4.00	0.1575	43.0	75.0	4.00
A0024.1	–	4.10	0.1614	43.0	75.0	4.10
A0024.2	–	4.20	0.1654	43.0	75.0	4.20
A0024.3	–	4.30	0.1693	47.0	80.0	4.30
A00211/64	11/64	4.37	0.1719	47.0	80.0	4.37

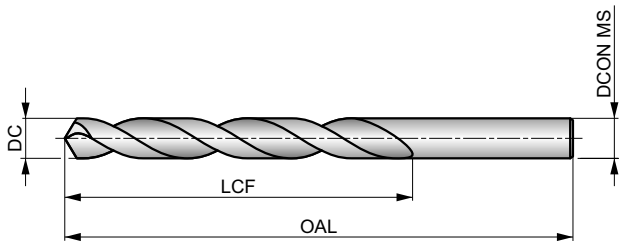
Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A0024.4	–	4.40	0.1732	47.0	80.0	4.40
A0024.5	–	4.50	0.1772	47.0	80.0	4.50
A0024.6	–	4.60	0.1811	47.0	80.0	4.60
A0024.7	–	4.70	0.1850	47.0	80.0	4.70
A0023/16	3/16	4.76	0.1875	52.0	86.0	4.76
A0024.8	–	4.80	0.1890	52.0	86.0	4.80
A0024.9	–	4.90	0.1929	52.0	86.0	4.90
A0025.0	–	5.00	0.1969	52.0	86.0	5.00
A0025.1	–	5.10	0.2008	52.0	86.0	5.10
A00213/64	13/64	5.16	0.2031	52.0	86.0	5.16
A0025.2	–	5.20	0.2047	52.0	86.0	5.20
A0025.3	–	5.30	0.2087	52.0	86.0	5.30
A0025.4	–	5.40	0.2126	57.0	93.0	5.40
A0025.5	–	5.50	0.2165	57.0	93.0	5.50
A0027/32	7/32	5.56	0.2188	57.0	93.0	5.56
A0025.6	–	5.60	0.2205	57.0	93.0	5.60
A0025.7	–	5.70	0.2244	57.0	93.0	5.70
A0025.8	–	5.80	0.2283	57.0	93.0	5.80
A0025.9	–	5.90	0.2323	57.0	93.0	5.90
A00215/64	15/64	5.95	0.2344	57.0	93.0	5.95
A0026.0	–	6.00	0.2362	57.0	93.0	6.00
A0026.1	–	6.10	0.2402	63.0	101.0	6.10
A0026.2	–	6.20	0.2441	63.0	101.0	6.20
A0026.3	–	6.30	0.2480	63.0	101.0	6.30
A0021/4	1/4	6.35	0.2500	63.0	101.0	6.35
A0026.4	–	6.40	0.2520	63.0	101.0	6.40
A0026.5	–	6.50	0.2559	63.0	101.0	6.50
A0026.6	–	6.60	0.2598	63.0	101.0	6.60
A0026.7	–	6.70	0.2638	63.0	101.0	6.70
A00217/64	17/64	6.75	0.2656	69.0	109.0	6.75
A0026.8	–	6.80	0.2677	69.0	109.0	6.80
A0026.9	–	6.90	0.2717	69.0	109.0	6.90
A0027.0	–	7.00	0.2756	69.0	109.0	7.00
A0027.1	–	7.10	0.2795	69.0	109.0	7.10
A0029/32	9/32	7.14	0.2813	69.0	109.0	7.14
A0027.2	–	7.20	0.2835	69.0	109.0	7.20
A0027.3	–	7.30	0.2874	69.0	109.0	7.30
A0027.4	–	7.40	0.2913	69.0	109.0	7.40
A0027.5	–	7.50	0.2953	69.0	109.0	7.50
A00219/64	19/64	7.54	0.2969	75.0	117.0	7.54
A0027.6	–	7.60	0.2992	75.0	117.0	7.60
A0027.7	–	7.70	0.3031	75.0	117.0	7.70
A0027.8	–	7.80	0.3071	75.0	117.0	7.80
A0027.9	–	7.90	0.3110	75.0	117.0	7.90
A0025/16	5/16	7.94	0.3125	75.0	117.0	7.94
A0028.0	–	8.00	0.3150	75.0	117.0	8.00
A0028.1	–	8.10	0.3189	75.0	117.0	8.10
A0028.2	–	8.20	0.3228	75.0	117.0	8.20
A0028.3	–	8.30	0.3268	75.0	117.0	8.30
A00221/64	21/64	8.33	0.3281	75.0	117.0	8.33
A0028.4	–	8.40	0.3307	75.0	117.0	8.40
A0028.5	–	8.50	0.3346	75.0	117.0	8.50
A0028.6	–	8.60	0.3386	81.0	125.0	8.60
A0028.7	–	8.70	0.3425	81.0	125.0	8.70
A00211/32	11/32	8.73	0.3438	81.0	125.0	8.73
A0028.8	–	8.80	0.3465	81.0	125.0	8.80
A0028.9	–	8.90	0.3504	81.0	125.0	8.90
A0029.0	–	9.00	0.3543	81.0	125.0	9.00
A0029.1	–	9.10	0.3583	81.0	125.0	9.10
A00223/64	23/64	9.13	0.3594	81.0	125.0	9.13
A0029.2	–	9.20	0.3622	81.0	125.0	9.20
A0029.3	–	9.30	0.3661	81.0	125.0	9.30
A0029.4	–	9.40	0.3701	81.0	125.0	9.40
A0029.5	–	9.50	0.3740	81.0	125.0	9.50
A0023/8	3/8	9.52	0.3750	87.0	133.0	9.52
A0029.6	–	9.60	0.3780	87.0	133.0	9.60
A0029.7	–	9.70	0.3819	87.0	133.0	9.70

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A0029.8	–	9.80	0.3858	87.0	133.0	9.80
A0029.9	–	9.90	0.3898	87.0	133.0	9.90
A00225/64	25/64	9.92	0.3906	87.0	133.0	9.92
A00210.0	–	10.00	0.3937	87.0	133.0	10.00
A00210.1	–	10.10	0.3976	87.0	133.0	10.10
A00210.2	–	10.20	0.4016	87.0	133.0	10.20
A00210.3	–	10.30	0.4055	87.0	133.0	10.30
A00213/32	13/32	10.32	0.4063	87.0	133.0	10.32
A00210.4	–	10.40	0.4094	87.0	133.0	10.40
A00210.5	–	10.50	0.4134	87.0	133.0	10.50
A00210.6	–	10.60	0.4173	87.0	133.0	10.60
A00210.7	–	10.70	0.4213	94.0	142.0	10.70
A00227/64	27/64	10.72	0.4219	94.0	142.0	10.72
A00210.8	–	10.80	0.4252	94.0	142.0	10.80
A00210.9	–	10.90	0.4291	94.0	142.0	10.90
A00211.0	–	11.00	0.4331	94.0	142.0	11.00
A00211.1	–	11.10	0.4370	94.0	142.0	11.10
A0027/16	7/16	11.11	0.4375	94.0	142.0	11.11
A00211.2	–	11.20	0.4409	94.0	142.0	11.20
A00211.3	–	11.30	0.4449	94.0	142.0	11.30
A00211.4	–	11.40	0.4488	94.0	142.0	11.40
A00211.5	–	11.50	0.4528	94.0	142.0	11.50
A00229/64	29/64	11.51	0.4531	94.0	142.0	11.51
A00211.6	–	11.60	0.4567	94.0	142.0	11.60
A00211.7	–	11.70	0.4606	94.0	142.0	11.70
A00211.8	–	11.80	0.4646	94.0	142.0	11.80
A00211.9	–	11.90	0.4685	101.0	151.0	11.90
A00215/32	15/32	11.91	0.4688	101.0	151.0	11.91
A00212.0	–	12.00	0.4724	101.0	151.0	12.00
A00212.1	–	12.10	0.4764	101.0	151.0	12.10
A00212.2	–	12.20	0.4803	101.0	151.0	12.20
A00212.3	–	12.30	0.4843	101.0	151.0	12.30
A00231/64	31/64	12.30	0.4844	101.0	151.0	12.30
A00212.4	–	12.40	0.4882	101.0	151.0	12.40
A00212.5	–	12.50	0.4921	101.0	151.0	12.50
A00212.6	–	12.60	0.4961	101.0	151.0	12.60
A00212.7	–	12.70	0.5000	101.0	151.0	12.70
A0021/2	1/2	12.70	0.5000	101.0	151.0	12.70
A00212.8	–	12.80	0.5039	101.0	151.0	12.80
A00212.9	–	12.90	0.5079	101.0	151.0	12.90
A00213.0	–	13.00	0.5118	101.0	151.0	13.00
A00233/64	33/64	13.10	0.5156	101.0	151.0	13.10
A00213.1	–	13.10	0.5157	101.0	151.0	13.10
A00213.2	–	13.20	0.5197	101.0	151.0	13.20
A00213.25	–	13.25	0.5217	108.0	160.0	13.25
A00213.3	–	13.30	0.5236	108.0	160.0	13.30
A00213.4	–	13.40	0.5276	108.0	160.0	13.40
A00217/32	17/32	13.49	0.5313	108.0	160.0	13.49
A00213.5	–	13.50	0.5315	108.0	160.0	13.50
A00213.6	–	13.60	0.5354	108.0	160.0	13.60
A00213.7	–	13.70	0.5394	108.0	160.0	13.70
A00213.75	–	13.75	0.5413	108.0	160.0	13.75
A00213.8	–	13.80	0.5433	108.0	160.0	13.80
A00213.9	–	13.90	0.5472	108.0	160.0	13.90
A00214.0	–	14.00	0.5512	108.0	160.0	14.00
A00214.25	–	14.25	0.5610	114.0	169.0	14.25
A0029/16	9/16	14.29	0.5625	114.0	169.0	14.29
A00214.5	–	14.50	0.5709	114.0	169.0	14.50
A00214.75	–	14.75	0.5807	114.0	169.0	14.75
A00215.0	–	15.00	0.5906	114.0	169.0	15.00
A00219/32	19/32	15.08	0.5938	120.0	178.0	15.08
A00215.25	–	15.25	0.6004	120.0	178.0	15.25
A00215.5	–	15.50	0.6102	120.0	178.0	15.50
A00215.75	–	15.75	0.6201	120.0	178.0	15.75
A0025/8	5/8	15.88	0.6250	120.0	178.0	15.88
A00216.0	–	16.00	0.6299	120.0	178.0	16.00

A002S

DORMER

普通长度高速钢钻头，头部氮化钛涂层。
多功能的钻头，特殊设计的118°钻尖角有助于在使用手持式工具时自定心并确保孔径精度，头部氮化钛涂层提高了切削性能并延长了刀具寿命，可用于手持式工具或机床，适用于多种材料的切削。



HSS	DIN 338	4×D
118°	TiN-Tip	
λ20-35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■46 J	■52 J	■54 J	■40 J	■35 F	◪31 F	■27 F	■21 F	◪18 F	■16 F	◪13 F	◪11 E	◪27 F	◪23 F
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪24 F	◪20 F	◪14 G	◪12 G	◪11 G	◪16 C	■40 J	■30 E	■22 E	◪34 E	◪28 E	◪22 E	◪30 E	◪23 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪19 E	◪28 E	◪21 E	◪16 E	◪13 E	◪11 E	◪32 E	◪24 E	◪19 E	■41 K	■31 K	■21 J	◪51 I	◪46 I
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪33 I	◪56 H	◪33 I	◪17 G	■30 I	■50 H	◪35 F	◪23 F	◪13 D	◪7 B	◪9 E	◪4 A	◪7 E	◪3 A
S4.1	S4.2												
◪5 E	◪2 A												

自定心分离式钻尖

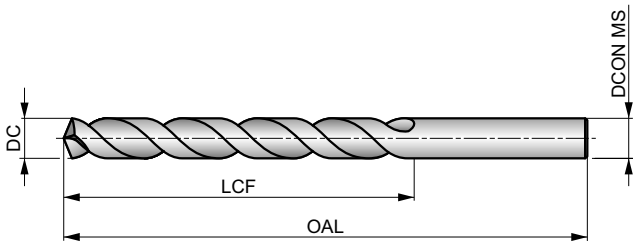
Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A002S2.0	–	2.00	0.0787	24.0	49.0	2.00
A002S2.5	–	2.50	0.0984	30.0	57.0	2.50
A002S3.0	–	3.00	0.1181	33.0	61.0	3.00
A002S1/8	1/8	3.18	0.1250	36.0	65.0	3.18
A002S3.2	–	3.20	0.1260	36.0	65.0	3.20
A002S3.3	–	3.30	0.1299	36.0	65.0	3.30
A002S3.5	–	3.50	0.1378	39.0	70.0	3.50
A002S5/32	5/32	3.97	0.1563	43.0	75.0	3.97
A002S4.0	–	4.00	0.1575	43.0	75.0	4.00
A002S4.1	–	4.10	0.1614	43.0	75.0	4.10
A002S4.2	–	4.20	0.1654	43.0	75.0	4.20
A002S4.5	–	4.50	0.1772	47.0	80.0	4.50
A002S3/16	3/16	4.76	0.1875	52.0	86.0	4.76
A002S5.0	–	5.00	0.1969	52.0	86.0	5.00
A002S13/64	13/64	5.16	0.2031	52.0	86.0	5.16
A002S5.5	–	5.50	0.2165	57.0	93.0	5.50
A002S7/32	7/32	5.56	0.2188	57.0	93.0	5.56
A002S6.0	–	6.00	0.2362	57.0	93.0	6.00
A002S1/4	1/4	6.35	0.2500	63.0	101.0	6.35
A002S6.5	–	6.50	0.2559	63.0	101.0	6.50

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A002S6.8	–	6.80	0.2677	69.0	109.0	6.80
A002S7.0	–	7.00	0.2756	69.0	109.0	7.00
A002S7.5	–	7.50	0.2953	69.0	109.0	7.50
A002S5/16	5/16	7.94	0.3125	75.0	117.0	7.94
A002S8.0	–	8.00	0.3150	75.0	117.0	8.00
A002S8.2	–	8.20	0.3228	75.0	117.0	8.20
A002S8.5	–	8.50	0.3346	75.0	117.0	8.50
A002S9.0	–	9.00	0.3543	81.0	125.0	9.00
A002S9.5	–	9.50	0.3740	81.0	125.0	9.50
A002S3/8	3/8	9.52	0.3750	87.0	133.0	9.52
A002S10.0	–	10.00	0.3937	87.0	133.0	10.00
A002S10.2	–	10.20	0.4016	87.0	133.0	10.20
A002S10.5	–	10.50	0.4134	87.0	133.0	10.50
A002S11.0	–	11.00	0.4331	94.0	142.0	11.00
A002S11.5	–	11.50	0.4528	94.0	142.0	11.50
A002S12.0	–	12.00	0.4724	101.0	151.0	12.00
A002S12.5	–	12.50	0.4921	101.0	151.0	12.50
A002S1/2	1/2	12.70	0.5000	101.0	151.0	12.70
A002S13.0	–	13.00	0.5118	101.0	151.0	13.00

A108

DORMER

不锈钢专用普通长度高速钢钻头，蒸汽回火处理。
手持式工具不锈钢钻孔时的首选，但也可以有效地用于机床，135°钻尖角有助于自定心和减少切削力，蒸汽回火处理表面能够避免刀具粘屑。



HSS	DIN 338	4×D
135°	ST	
λ>35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪33 I	◪37 I	◪38 I	◪28 I	◪25 G	◪22 E	◪19 F	◪15 F	◪13 E	◪11 F	◪10 E	◪8 D	◪21 E	◪17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪18 E	◪15 E	■10 G	■9 G	■8 G	■10 D	◪30 H	◪22 F	◪17 F	◪25 E	◪20 E	◪16 E	◪22 E	◪17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 E	◪20 E	◪15 E	◪11 E	◪10 E	◪8 E	◪23 E	◪17 E	◪13 E	◪33 J	◪25 J	◪17 I	◪42 H	◪37 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪27 H	◪59 H	◪35 I	◪18 G	◪30 J	◪28 H	◪14 F	■25 G	■16 E	◪7 B	◪9 G	◪8 E	◪7 G	◪6 E
S4.1	S4.2												
◪5 G	◪5 E												

DC > 1.5mm (1/16") 分离式钻尖
该系列产品有套装提供。请参见A188

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1081.0	–	1.00	0.0394	12.0	34.0	1.00
A1081.1	–	1.10	0.0433	14.0	36.0	1.10
A1081.2	–	1.20	0.0472	16.0	38.0	1.20
A1081.3	–	1.30	0.0512	16.0	38.0	1.30
A1081.4	–	1.40	0.0551	18.0	40.0	1.40
A1081.5	–	1.50	0.0591	18.0	40.0	1.50
A1081/16	1/16	1.59	0.0625	20.0	43.0	1.59
A1081.6	–	1.60	0.0630	20.0	43.0	1.60
A1081.7	–	1.70	0.0669	20.0	43.0	1.70
A1081.8	–	1.80	0.0709	22.0	46.0	1.80
A1081.9	–	1.90	0.0748	22.0	46.0	1.90
A1085/64	5/64	1.98	0.0781	24.0	49.0	1.98
A1082.0	–	2.00	0.0787	24.0	49.0	2.00
A1082.1	–	2.10	0.0827	24.0	49.0	2.10
A1082.2	–	2.20	0.0866	27.0	53.0	2.20
A1082.3	–	2.30	0.0906	27.0	53.0	2.30
A1083/32	3/32	2.38	0.0938	30.0	57.0	2.38
A1082.4	–	2.40	0.0945	30.0	57.0	2.40
A1082.5	–	2.50	0.0984	30.0	57.0	2.50
A1082.6	–	2.60	0.1024	30.0	57.0	2.60
A1082.7	–	2.70	0.1063	33.0	61.0	2.70
A1087/64	7/64	2.78	0.1094	33.0	61.0	2.78

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1082.8	–	2.80	0.1102	33.0	61.0	2.80
A1082.9	–	2.90	0.1142	33.0	61.0	2.90
A1083.0	–	3.00	0.1181	33.0	61.0	3.00
A1083.1	–	3.10	0.1220	36.0	65.0	3.10
A1081/8	1/8	3.18	0.1250	36.0	65.0	3.18
A1083.2	–	3.20	0.1260	36.0	65.0	3.20
A1083.3	–	3.30	0.1299	36.0	65.0	3.30
A1083.4	–	3.40	0.1339	39.0	70.0	3.40
A1083.5	–	3.50	0.1378	39.0	70.0	3.50
A1089/64	9/64	3.57	0.1406	39.0	70.0	3.57
A1083.6	–	3.60	0.1417	39.0	70.0	3.60
A1083.7	–	3.70	0.1457	39.0	70.0	3.70
A1083.8	–	3.80	0.1496	43.0	75.0	3.80
A1083.9	–	3.90	0.1535	43.0	75.0	3.90
A1085/32	5/32	3.97	0.1563	43.0	75.0	3.97
A1084.0	–	4.00	0.1575	43.0	75.0	4.00
A1084.1	–	4.10	0.1614	43.0	75.0	4.10
A1084.2	–	4.20	0.1654	43.0	75.0	4.20
A1084.3	–	4.30	0.1693	47.0	80.0	4.30
A10811/64	11/64	4.37	0.1719	47.0	80.0	4.37
A1084.4	–	4.40	0.1732	47.0	80.0	4.40
A1084.5	–	4.50	0.1772	47.0	80.0	4.50

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1084.6	–	4.60	0.1811	47.0	80.0	4.60
A1084.7	–	4.70	0.1850	47.0	80.0	4.70
A1083/16	3/16	4.76	0.1875	52.0	86.0	4.76
A1084.8	–	4.80	0.1890	52.0	86.0	4.80
A1084.9	–	4.90	0.1929	52.0	86.0	4.90
A108N10	N10	4.92	0.1935	52.0	86.0	4.92
A1085.0	–	5.00	0.1969	52.0	86.0	5.00
A1085.1	–	5.10	0.2008	52.0	86.0	5.10
A10813/64	13/64	5.16	0.2031	52.0	86.0	5.16
A1085.2	–	5.20	0.2047	52.0	86.0	5.20
A1085.3	–	5.30	0.2087	52.0	86.0	5.30
A1085.4	–	5.40	0.2126	57.0	93.0	5.40
A1085.5	–	5.50	0.2165	57.0	93.0	5.50
A1087/32	7/32	5.56	0.2188	57.0	93.0	5.56
A1085.6	–	5.60	0.2205	57.0	93.0	5.60
A1085.7	–	5.70	0.2244	57.0	93.0	5.70
A1085.8	–	5.80	0.2283	57.0	93.0	5.80
A1085.9	–	5.90	0.2323	57.0	93.0	5.90
A10815/64	15/64	5.95	0.2344	57.0	93.0	5.95
A1086.0	–	6.00	0.2362	57.0	93.0	6.00
A1086.1	–	6.10	0.2402	63.0	101.0	6.10
A1086.2	–	6.20	0.2441	63.0	101.0	6.20
A1086.3	–	6.30	0.2480	63.0	101.0	6.30
A1081/4	1/4	6.35	0.2500	63.0	101.0	6.35
A1086.4	–	6.40	0.2520	63.0	101.0	6.40
A1086.5	–	6.50	0.2559	63.0	101.0	6.50
A1086.6	–	6.60	0.2598	63.0	101.0	6.60
A1086.7	–	6.70	0.2638	63.0	101.0	6.70
A10817/64	17/64	6.75	0.2656	69.0	109.0	6.75
A1086.8	–	6.80	0.2677	69.0	109.0	6.80
A1086.9	–	6.90	0.2717	69.0	109.0	6.90
A1087.0	–	7.00	0.2756	69.0	109.0	7.00
A1087.1	–	7.10	0.2795	69.0	109.0	7.10
A1089/32	9/32	7.14	0.2813	69.0	109.0	7.14
A1087.2	–	7.20	0.2835	69.0	109.0	7.20
A1087.3	–	7.30	0.2874	69.0	109.0	7.30
A1087.4	–	7.40	0.2913	69.0	109.0	7.40
A1087.5	–	7.50	0.2953	69.0	109.0	7.50
A10819/64	19/64	7.54	0.2969	75.0	117.0	7.54
A1087.6	–	7.60	0.2992	75.0	117.0	7.60
A1087.7	–	7.70	0.3031	75.0	117.0	7.70
A1087.8	–	7.80	0.3071	75.0	117.0	7.80
A1087.9	–	7.90	0.3110	75.0	117.0	7.90
A1085/16	5/16	7.94	0.3125	75.0	117.0	7.94
A1088.0	–	8.00	0.3150	75.0	117.0	8.00
A1088.1	–	8.10	0.3189	75.0	117.0	8.10
A1088.2	–	8.20	0.3228	75.0	117.0	8.20

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1088.3	–	8.30	0.3268	75.0	117.0	8.30
A10821/64	21/64	8.33	0.3281	75.0	117.0	8.33
A1088.4	–	8.40	0.3307	75.0	117.0	8.40
A1088.5	–	8.50	0.3346	75.0	117.0	8.50
A1088.6	–	8.60	0.3386	81.0	125.0	8.60
A1088.7	–	8.70	0.3425	81.0	125.0	8.70
A10811/32	11/32	8.73	0.3438	81.0	125.0	8.73
A1088.8	–	8.80	0.3465	81.0	125.0	8.80
A1088.9	–	8.90	0.3504	81.0	125.0	8.90
A1089.0	–	9.00	0.3543	81.0	125.0	9.00
A1089.1	–	9.10	0.3583	81.0	125.0	9.10
A10823/64	23/64	9.13	0.3594	81.0	125.0	9.13
A1089.2	–	9.20	0.3622	81.0	125.0	9.20
A1089.3	–	9.30	0.3661	81.0	125.0	9.30
A1089.4	–	9.40	0.3701	81.0	125.0	9.40
A1089.5	–	9.50	0.3740	81.0	125.0	9.50
A1083/8	3/8	9.52	0.3750	87.0	133.0	9.52
A1089.6	–	9.60	0.3780	87.0	133.0	9.60
A1089.7	–	9.70	0.3819	87.0	133.0	9.70
A1089.8	–	9.80	0.3858	87.0	133.0	9.80
A1089.9	–	9.90	0.3898	87.0	133.0	9.90
A10825/64	25/64	9.92	0.3906	87.0	133.0	9.92
A10810.0	–	10.00	0.3937	87.0	133.0	10.00
A10810.2	–	10.20	0.4016	87.0	133.0	10.20
A10813/32	13/32	10.32	0.4063	87.0	133.0	10.32
A10810.5	–	10.50	0.4134	87.0	133.0	10.50
A10827/64	27/64	10.72	0.4219	94.0	142.0	10.72
A10810.8	–	10.80	0.4252	94.0	142.0	10.80
A10811.0	–	11.00	0.4331	94.0	142.0	11.00
A1087/16	7/16	11.11	0.4375	94.0	142.0	11.11
A10811.5	–	11.50	0.4528	94.0	142.0	11.50
A10829/64	29/64	11.51	0.4531	94.0	142.0	11.51
A10811.8	–	11.80	0.4646	94.0	142.0	11.80
A10815/32	15/32	11.91	0.4688	101.0	151.0	11.91
A10812.0	–	12.00	0.4724	101.0	151.0	12.00
A10812.2	–	12.20	0.4803	101.0	151.0	12.20
A10831/64	31/64	12.30	0.4844	101.0	151.0	12.30
A10812.5	–	12.50	0.4921	101.0	151.0	12.50
A1081/2	1/2	12.70	0.5000	101.0	151.0	12.70
A10812.8	–	12.80	0.5039	101.0	151.0	12.80
A10813.0	–	13.00	0.5118	101.0	151.0	13.00
A10813.5	–	13.50	0.5315	108.0	160.0	13.50
A10814.0	–	14.00	0.5512	108.0	160.0	14.00
A10814.5	–	14.50	0.5709	114.0	169.0	14.50
A10815.0	–	15.00	0.5906	114.0	169.0	15.00
A10815.25	–	15.25	0.6004	120.0	178.0	15.25
A10816.0	–	16.00	0.6299	120.0	178.0	16.00

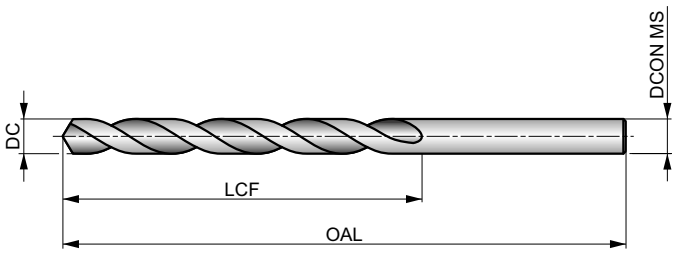
材料代码(BMC)		HSS	HSS
基本标准组(BSG)		DIN 340	BS 328
有用长度直径比 (ULDR)		6×D	10×D
应用角度		118°	118°
涂层		ST	ST
柄部			
螺旋形式		λ 20-35°	λ 20-35°
旋向(切削方向)		R	R
产品系列代码		A110	A125
PSF切削直径范围		0.50 - 1"	1.40 - 3/4
		36	38
P	P1	■	■
	P2	■	◩
	P3	◩	◩
	P4	◩	◩
M	M1	◩	◩
	M2	◩	◩
	M3	◩	◩
	M4	◩	◩
K	K1	◩	◩
	K2	◩	◩
	K3	◩	◩
	K4	◩	◩
	K5	◩	◩
N	N1	◩	◩
	N2	◩	◩
	N3	◩	◩
	N4	◩	◩
	N5		
S	S1	◩	◩
	S2	◩	◩
	S3	◩	◩
	S4	◩	◩
H	H1		
	H2		
	H3		
	H4		

■推荐使用 ◩可以使用

A110

DORMER

长系列高速钢钻头，蒸汽回火处理。
一种深孔钻，118°的钻尖角，强壮且便于重磨，从而经济型更好，蒸汽回火处理表面能够留存切削液并避免刀具粘屑，可用于手持式工具或机床，适用于多种材料的切削。



HSS	DIN 340	6×D
118°	ST	
λ20-35°	R	DC h8

DC <= 1mm; 1/16” 光亮表面

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A110.5	–	0.50	0.0197	12.0	32.0	0.50
A110.6	–	0.60	0.0236	15.0	35.0	0.60
A110.7	–	0.70	0.0276	21.0	42.0	0.70
A1101/32	1/32	0.79	0.0313	25.0	46.0	0.79
A110.8	–	0.80	0.0315	25.0	46.0	0.80
A110.9	–	0.90	0.0354	29.0	51.0	0.90
A1101.0	–	1.00	0.0394	33.0	56.0	1.00
A1101.1	–	1.10	0.0433	37.0	60.0	1.10
A1101.2	–	1.20	0.0472	41.0	65.0	1.20
A1101.3	–	1.30	0.0512	41.0	65.0	1.30
A1101.4	–	1.40	0.0551	45.0	70.0	1.40
A1101.5	–	1.50	0.0591	45.0	70.0	1.50
A1101/16	1/16	1.59	0.0625	50.0	76.0	1.59
A1101.6	–	1.60	0.0630	50.0	76.0	1.60
A1101.7	–	1.70	0.0669	50.0	76.0	1.70
A1101.75	–	1.75	0.0689	53.0	80.0	1.75
A1101.8	–	1.80	0.0709	53.0	80.0	1.80
A1101.9	–	1.90	0.0748	53.0	80.0	1.90
A1105/64	5/64	1.98	0.0781	56.0	85.0	1.98
A1102.0	–	2.00	0.0787	56.0	85.0	2.00
A1102.05	–	2.05	0.0807	56.0	85.0	2.05
A1102.1	–	2.10	0.0827	56.0	85.0	2.10
A1102.2	–	2.20	0.0866	59.0	90.0	2.20
A1102.25	–	2.25	0.0886	59.0	90.0	2.25
A1102.3	–	2.30	0.0906	59.0	90.0	2.30
A1103/32	3/32	2.38	0.0938	62.0	95.0	2.38
A1102.4	–	2.40	0.0945	62.0	95.0	2.40
A1102.5	–	2.50	0.0984	62.0	95.0	2.50
A1102.6	–	2.60	0.1024	62.0	95.0	2.60
A1102.7	–	2.70	0.1063	66.0	100.0	2.70
A1107/64	7/64	2.78	0.1094	66.0	100.0	2.78
A1102.8	–	2.80	0.1102	66.0	100.0	2.80
A1102.9	–	2.90	0.1142	66.0	100.0	2.90

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1103.0	–	3.00	0.1181	66.0	100.0	3.00
A1103.1	–	3.10	0.1220	69.0	106.0	3.10
A1101/8	1/8	3.18	0.1250	69.0	106.0	3.18
A1103.2	–	3.20	0.1260	69.0	106.0	3.20
A1103.25	–	3.25	0.1280	69.0	106.0	3.25
A1103.3	–	3.30	0.1299	69.0	106.0	3.30
A1103.4	–	3.40	0.1339	73.0	112.0	3.40
A1103.5	–	3.50	0.1378	73.0	112.0	3.50
A1109/64	9/64	3.57	0.1406	73.0	112.0	3.57
A1103.6	–	3.60	0.1417	73.0	112.0	3.60
A1103.7	–	3.70	0.1457	73.0	112.0	3.70
A1103.75	–	3.75	0.1476	73.0	112.0	3.75
A1103.8	–	3.80	0.1496	78.0	119.0	3.80
A1103.9	–	3.90	0.1535	78.0	119.0	3.90
A1105/32	5/32	3.97	0.1563	78.0	119.0	3.97
A1104.0	–	4.00	0.1575	78.0	119.0	4.00
A1104.1	–	4.10	0.1614	78.0	119.0	4.10
A1104.2	–	4.20	0.1654	78.0	119.0	4.20
A1104.25	–	4.25	0.1673	78.0	119.0	4.25
A1104.3	–	4.30	0.1693	82.0	126.0	4.30
A11011/64	11/64	4.37	0.1719	82.0	126.0	4.37
A1104.4	–	4.40	0.1732	82.0	126.0	4.40
A1104.5	–	4.50	0.1772	82.0	126.0	4.50
A1104.6	–	4.60	0.1811	82.0	126.0	4.60
A1104.7	–	4.70	0.1850	82.0	126.0	4.70
A1104.75	–	4.75	0.1870	82.0	126.0	4.75
A1103/16	3/16	4.76	0.1875	87.0	132.0	4.76
A1104.8	–	4.80	0.1890	87.0	132.0	4.80
A1104.9	–	4.90	0.1929	87.0	132.0	4.90
A1105.0	–	5.00	0.1969	87.0	132.0	5.00
A1105.1	–	5.10	0.2008	87.0	132.0	5.10
A11013/64	13/64	5.16	0.2031	87.0	132.0	5.16
A1105.2	–	5.20	0.2047	87.0	132.0	5.20

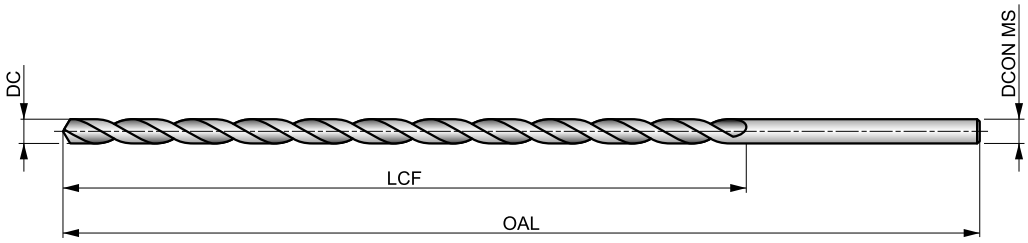
Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1105.25	–	5.25	0.2067	87.0	132.0	5.25
A1105.3	–	5.30	0.2087	87.0	132.0	5.30
A1105.4	–	5.40	0.2126	91.0	139.0	5.40
A1105.5	–	5.50	0.2165	91.0	139.0	5.50
A1107/32	7/32	5.56	0.2188	91.0	139.0	5.56
A1105.6	–	5.60	0.2205	91.0	139.0	5.60
A1105.7	–	5.70	0.2244	91.0	139.0	5.70
A1105.75	–	5.75	0.2264	91.0	139.0	5.75
A1105.8	–	5.80	0.2283	91.0	139.0	5.80
A1105.9	–	5.90	0.2323	91.0	139.0	5.90
A11015/64	15/64	5.95	0.2344	91.0	139.0	5.95
A1106.0	–	6.00	0.2362	91.0	139.0	6.00
A1106.1	–	6.10	0.2402	97.0	148.0	6.10
A1106.2	–	6.20	0.2441	97.0	148.0	6.20
A1106.25	–	6.25	0.2461	97.0	148.0	6.25
A1106.3	–	6.30	0.2480	97.0	148.0	6.30
A1101/4	1/4	6.35	0.2500	97.0	148.0	6.35
A1106.4	–	6.40	0.2520	97.0	148.0	6.40
A1106.5	–	6.50	0.2559	97.0	148.0	6.50
A1106.6	–	6.60	0.2598	97.0	148.0	6.60
A1106.7	–	6.70	0.2638	97.0	148.0	6.70
A11017/64	17/64	6.75	0.2656	102.0	156.0	6.75
A1106.75	–	6.75	0.2657	102.0	156.0	6.75
A1106.8	–	6.80	0.2677	102.0	156.0	6.80
A1106.9	–	6.90	0.2717	102.0	156.0	6.90
A1107.0	–	7.00	0.2756	102.0	156.0	7.00
A1107.1	–	7.10	0.2795	102.0	156.0	7.10
A1109/32	9/32	7.14	0.2813	102.0	156.0	7.14
A1107.2	–	7.20	0.2835	102.0	156.0	7.20
A1107.25	–	7.25	0.2854	102.0	156.0	7.25
A1107.3	–	7.30	0.2874	102.0	156.0	7.30
A1107.4	–	7.40	0.2913	102.0	156.0	7.40
A1107.5	–	7.50	0.2953	102.0	156.0	7.50
A1107.6	–	7.60	0.2992	109.0	165.0	7.60
A1107.7	–	7.70	0.3031	109.0	165.0	7.70
A1107.75	–	7.75	0.3051	109.0	165.0	7.75
A1107.8	–	7.80	0.3071	109.0	165.0	7.80
A1107.9	–	7.90	0.3110	109.0	165.0	7.90
A1105/16	5/16	7.94	0.3125	109.0	165.0	7.94
A1108.0	–	8.00	0.3150	109.0	165.0	8.00
A1108.1	–	8.10	0.3189	109.0	165.0	8.10
A1108.2	–	8.20	0.3228	109.0	165.0	8.20
A1108.25	–	8.25	0.3248	109.0	165.0	8.25
A1108.3	–	8.30	0.3268	109.0	165.0	8.30
A1108.4	–	8.40	0.3307	109.0	165.0	8.40
A1108.5	–	8.50	0.3346	109.0	165.0	8.50
A1108.6	–	8.60	0.3386	115.0	175.0	8.60
A1108.7	–	8.70	0.3425	115.0	175.0	8.70
A11011/32	11/32	8.73	0.3438	115.0	175.0	8.73
A1108.75	–	8.75	0.3445	115.0	175.0	8.75
A1108.8	–	8.80	0.3465	115.0	175.0	8.80

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1109.0	–	9.00	0.3543	115.0	175.0	9.00
A1109.1	–	9.10	0.3583	115.0	175.0	9.10
A1109.2	–	9.20	0.3622	115.0	175.0	9.20
A1109.3	–	9.30	0.3661	115.0	175.0	9.30
A1109.5	–	9.50	0.3740	115.0	175.0	9.50
A1103/8	3/8	9.52	0.3750	121.0	184.0	9.52
A1109.6	–	9.60	0.3780	121.0	184.0	9.60
A1109.7	–	9.70	0.3819	121.0	184.0	9.70
A1109.8	–	9.80	0.3858	121.0	184.0	9.80
A1109.9	–	9.90	0.3898	121.0	184.0	9.90
A11010.0	–	10.00	0.3937	121.0	184.0	10.00
A11010.1	–	10.10	0.3976	121.0	184.0	10.10
A11010.2	–	10.20	0.4016	121.0	184.0	10.20
A11010.25	–	10.25	0.4035	121.0	184.0	10.25
A11010.3	–	10.30	0.4055	121.0	184.0	10.30
A11013/32	13/32	10.32	0.4063	121.0	184.0	10.32
A11010.5	–	10.50	0.4134	121.0	184.0	10.50
A11010.75	–	10.75	0.4232	128.0	195.0	10.75
A11010.8	–	10.80	0.4252	128.0	195.0	10.80
A11011.0	–	11.00	0.4331	128.0	195.0	11.00
A1107/16	7/16	11.11	0.4375	128.0	195.0	11.11
A11011.5	–	11.50	0.4528	128.0	195.0	11.50
A11011.75	–	11.75	0.4626	128.0	195.0	11.75
A11012.0	–	12.00	0.4724	134.0	205.0	12.00
A11012.1	–	12.10	0.4764	134.0	205.0	12.10
A11012.25	–	12.25	0.4823	134.0	205.0	12.25
A11012.5	–	12.50	0.4921	134.0	205.0	12.50
A1101/2	1/2	12.70	0.5000	134.0	205.0	12.70
A11013.0	–	13.00	0.5118	134.0	205.0	13.00
A11017/32	17/32	13.49	0.5313	140.0	214.0	13.49
A11013.5	–	13.50	0.5315	140.0	214.0	13.50
A11014.0	–	14.00	0.5512	140.0	214.0	14.00
A1109/16	9/16	14.29	0.5625	144.0	220.0	14.29
A11014.5	–	14.50	0.5709	144.0	220.0	14.50
A11015.0	–	15.00	0.5906	144.0	220.0	15.00
A11015.5	–	15.50	0.6102	149.0	227.0	15.50
A1105/8	5/8	15.88	0.6250	149.0	227.0	15.88
A11016.0	–	16.00	0.6299	149.0	227.0	16.00
A11016.5	–	16.50	0.6496	154.0	235.0	16.50
A11017.0	–	17.00	0.6693	154.0	235.0	17.00
A11017.5	–	17.50	0.6890	158.0	241.0	17.50
A11018.0	–	18.00	0.7087	158.0	241.0	18.00
A11018.5	–	18.50	0.7283	162.0	247.0	18.50
A11019.0	–	19.00	0.7480	162.0	247.0	19.00
A1103/4	3/4	19.05	0.7500	166.0	254.0	19.05
A11019.5	–	19.50	0.7677	166.0	254.0	19.50
A11020.0	–	20.00	0.7874	166.0	254.0	20.00
A11021.0	–	21.00	0.8268	171.0	261.0	21.00
A11022.0	–	22.00	0.8661	176.0	268.0	22.00
A1107/8	7/8	22.22	0.8750	176.0	268.0	22.22
A1101	1″	25.40	1.0000	190.0	290.0	25.40

A125

DORMER

超长系列高速钢钻头，表面蒸汽回火处理。
推荐应用于超深孔加工或存在严重干涉的场合，传统的118°钻尖角，强壮且便于重磨，蒸汽回火处理能够留存切削液，防止刀具粘屑，不可用于手持式工具，适用于多种材料的切削。



HSS	BS 328	10×D
118°	ST	
λ20-35°	R	DC h8

DC <= 2.2mm; 5/64" 光亮表面

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1251.4X160	–	1.40	0.0551	100.0	160.0	1.40
A1251.5X125	–	1.50	0.0591	80.0	125.0	1.50
A1251.5X160	–	1.50	0.0591	100.0	160.0	1.50
A1251/16X125	1/16	1.59	0.0625	80.0	125.0	1.59
A1251/16X160	1/16	1.59	0.0625	100.0	160.0	1.59
A1251.8X160	–	1.80	0.0709	100.0	160.0	1.80
A1255/64X125	5/64	1.98	0.0781	80.0	125.0	1.98
A1255/64X160	5/64	1.98	0.0781	100.0	160.0	1.98
A1252.0X125	–	2.00	0.0787	80.0	125.0	2.00
A1252.0X160	–	2.00	0.0787	100.0	160.0	2.00
A1252.2X160	–	2.20	0.0866	100.0	160.0	2.20
A1253/32X125	3/32	2.38	0.0938	80.0	125.0	2.38
A1253/32X160	3/32	2.38	0.0938	100.0	160.0	2.38
A1252.5X125	–	2.50	0.0984	80.0	125.0	2.50
A1252.5X160	–	2.50	0.0984	100.0	160.0	2.50
A1257/64X125	7/64	2.78	0.1094	80.0	125.0	2.78
A1257/64X160	7/64	2.78	0.1094	100.0	160.0	2.78
A1253.0X160	–	3.00	0.1181	100.0	160.0	3.00
A1253.0X200	–	3.00	0.1181	150.0	200.0	3.00
A1253.0X250	–	3.00	0.1181	200.0	250.0	3.00
A1251/8X160	1/8	3.18	0.1250	100.0	160.0	3.18
A1251/8X200	1/8	3.18	0.1250	150.0	200.0	3.18
A1251/8X250	1/8	3.18	0.1250	200.0	250.0	3.18
A1251/8X315	1/8	3.18	0.1250	250.0	310.0	3.18
A1253.3X160	–	3.30	0.1299	100.0	160.0	3.30
A1253.5X160	–	3.50	0.1378	100.0	160.0	3.50
A1253.5X200	–	3.50	0.1378	150.0	200.0	3.50
A1253.5X250	–	3.50	0.1378	200.0	250.0	3.50
A1259/64X160	9/64	3.57	0.1406	100.0	160.0	3.57
A1259/64X200	9/64	3.57	0.1406	150.0	200.0	3.57
A1259/64X315	9/64	3.57	0.1406	250.0	310.0	3.57
A1255/32X160	5/32	3.97	0.1563	100.0	160.0	3.97
A1255/32X200	5/32	3.97	0.1563	150.0	200.0	3.97

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1255/32X250	5/32	3.97	0.1563	200.0	250.0	3.97
A1255/32X315	5/32	3.97	0.1563	250.0	310.0	3.97
A1254.0X160	–	4.00	0.1575	100.0	160.0	4.00
A1254.0X200	–	4.00	0.1575	150.0	200.0	4.00
A1254.0X250	–	4.00	0.1575	200.0	250.0	4.00
A1254.0X315	–	4.00	0.1575	250.0	310.0	4.00
A12511/64X160	11/64	4.37	0.1719	100.0	160.0	4.37
A12511/64X200	11/64	4.37	0.1719	150.0	200.0	4.37
A12511/64X315	11/64	4.37	0.1719	250.0	310.0	4.37
A1254.5X160	–	4.50	0.1772	100.0	160.0	4.50
A1254.5X200	–	4.50	0.1772	150.0	200.0	4.50
A1254.5X250	–	4.50	0.1772	200.0	250.0	4.50
A1254.5X315	–	4.50	0.1772	250.0	310.0	4.50
A1253/16X160	3/16	4.76	0.1875	100.0	160.0	4.76
A1253/16X200	3/16	4.76	0.1875	150.0	200.0	4.76
A1253/16X250	3/16	4.76	0.1875	200.0	250.0	4.76
A1253/16X315	3/16	4.76	0.1875	250.0	310.0	4.76
A1253/16X400	3/16	4.76	0.1875	300.0	400.0	4.76
A1255.0X160	–	5.00	0.1969	100.0	160.0	5.00
A1255.0X200	–	5.00	0.1969	150.0	200.0	5.00
A1255.0X250	–	5.00	0.1969	200.0	250.0	5.00
A1255.0X315	–	5.00	0.1969	250.0	310.0	5.00
A1255.0X400	–	5.00	0.1969	300.0	400.0	5.00
A12513/64X200	13/64	5.16	0.2031	150.0	200.0	5.16
A12513/64X250	13/64	5.16	0.2031	200.0	250.0	5.16
A12513/64X315	13/64	5.16	0.2031	250.0	310.0	5.16
A1255.5X200	–	5.50	0.2165	150.0	200.0	5.50
A1255.5X250	–	5.50	0.2165	200.0	250.0	5.50
A1255.5X315	–	5.50	0.2165	250.0	310.0	5.50
A1257/32X200	7/32	5.56	0.2188	150.0	200.0	5.56
A1257/32X250	7/32	5.56	0.2188	200.0	250.0	5.56
A12515/64X200	15/64	5.95	0.2344	150.0	200.0	5.95
A12515/64X315	15/64	5.95	0.2344	250.0	310.0	5.95

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1256.0X200	–	6.00	0.2362	150.0	200.0	6.00
A1256.0X250	–	6.00	0.2362	200.0	250.0	6.00
A1256.0X315	–	6.00	0.2362	250.0	310.0	6.00
A1256.0X400	–	6.00	0.2362	300.0	400.0	6.00
A1251/4X200	1/4	6.35	0.2500	150.0	200.0	6.35
A1251/4X250	1/4	6.35	0.2500	200.0	250.0	6.35
A1251/4X315	1/4	6.35	0.2500	250.0	310.0	6.35
A1251/4X400	1/4	6.35	0.2500	300.0	400.0	6.35
A1251/4X500	1/4	6.35	0.2500	400.0	460.0	6.35
A1256.5X200	–	6.50	0.2559	150.0	200.0	6.50
A1256.5X250	–	6.50	0.2559	200.0	250.0	6.50
A1256.5X315	–	6.50	0.2559	250.0	310.0	6.50
A12517/64X200	17/64	6.75	0.2656	150.0	200.0	6.75
A12517/64X250	17/64	6.75	0.2656	200.0	250.0	6.75
A12517/64X500	17/64	6.75	0.2656	400.0	460.0	6.75
A1257.0X200	–	7.00	0.2756	150.0	200.0	7.00
A1257.0X250	–	7.00	0.2756	200.0	250.0	7.00
A1257.0X315	–	7.00	0.2756	250.0	310.0	7.00
A1257.5X200	–	7.50	0.2953	150.0	200.0	7.50
A1257.5X250	–	7.50	0.2953	200.0	250.0	7.50
A1257.5X315	–	7.50	0.2953	250.0	310.0	7.50
A1255/16X200	5/16	7.94	0.3125	150.0	200.0	7.94
A1255/16X250	5/16	7.94	0.3125	200.0	250.0	7.94
A1255/16X315	5/16	7.94	0.3125	250.0	310.0	7.94
A1255/16X500	5/16	7.94	0.3125	400.0	460.0	7.94
A1258.0X250	–	8.00	0.3150	200.0	250.0	8.00
A1258.0X315	–	8.00	0.3150	250.0	310.0	8.00
A1258.0X400	–	8.00	0.3150	300.0	400.0	8.00
A12521/64X315	21/64	8.33	0.3281	250.0	310.0	8.33
A1258.5X250	–	8.50	0.3346	200.0	250.0	8.50
A1258.5X315	–	8.50	0.3346	250.0	310.0	8.50
A12511/32X250	11/32	8.73	0.3438	200.0	250.0	8.73
A12511/32X315	11/32	8.73	0.3438	250.0	310.0	8.73
A12511/32X400	11/32	8.73	0.3438	300.0	400.0	8.73
A12511/32X500	11/32	8.73	0.3438	400.0	460.0	8.73
A1259.0X250	–	9.00	0.3543	200.0	250.0	9.00
A1259.0X315	–	9.00	0.3543	250.0	310.0	9.00
A1259.0X400	–	9.00	0.3543	300.0	400.0	9.00
A1259.5X250	–	9.50	0.3740	200.0	250.0	9.50
A1259.5X315	–	9.50	0.3740	250.0	310.0	9.50

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1253/8X250	3/8	9.52	0.3750	200.0	250.0	9.52
A1253/8X315	3/8	9.52	0.3750	250.0	310.0	9.52
A1253/8X400	3/8	9.52	0.3750	300.0	400.0	9.52
A1253/8X500	3/8	9.52	0.3750	400.0	460.0	9.52
A12510.0X250	–	10.00	0.3937	200.0	250.0	10.00
A12510.0X315	–	10.00	0.3937	250.0	310.0	10.00
A12510.0X400	–	10.00	0.3937	300.0	400.0	10.00
A12513/32X250	13/32	10.32	0.4063	200.0	250.0	10.32
A12513/32X315	13/32	10.32	0.4063	250.0	310.0	10.32
A12510.5X250	–	10.50	0.4134	200.0	250.0	10.50
A12510.5X315	–	10.50	0.4134	250.0	310.0	10.50
A12510.5X400	–	10.50	0.4134	300.0	400.0	10.50
A12511.0X250	–	11.00	0.4331	200.0	250.0	11.00
A12511.0X315	–	11.00	0.4331	250.0	310.0	11.00
A12511.0X400	–	11.00	0.4331	300.0	400.0	11.00
A1257/16X250	7/16	11.11	0.4375	200.0	250.0	11.11
A1257/16X315	7/16	11.11	0.4375	250.0	310.0	11.11
A1257/16X400	7/16	11.11	0.4375	300.0	400.0	11.11
A12529/64X315	29/64	11.51	0.4531	250.0	310.0	11.51
A12512.0X250	–	12.00	0.4724	200.0	250.0	12.00
A12512.0X315	–	12.00	0.4724	250.0	310.0	12.00
A12512.0X400	–	12.00	0.4724	300.0	400.0	12.00
A12531/64X315	31/64	12.30	0.4844	250.0	310.0	12.30
A1251/2X250	1/2	12.70	0.5000	200.0	250.0	12.70
A1251/2X315	1/2	12.70	0.5000	250.0	310.0	12.70
A1251/2X400	1/2	12.70	0.5000	300.0	400.0	12.70
A12513.0X315	–	13.00	0.5118	250.0	310.0	13.00
A12513.0X400	–	13.00	0.5118	300.0	400.0	13.00
A12517/32X315	17/32	13.49	0.5313	250.0	310.0	13.49
A12514.0X315	–	14.00	0.5512	250.0	310.0	14.00
A12514.0X400	–	14.00	0.5512	300.0	400.0	14.00
A1259/16X315	9/16	14.29	0.5625	250.0	310.0	14.29
A12537/64X315	37/64	14.68	0.5781	250.0	310.0	14.68
A12519/32X315	19/32	15.08	0.5938	250.0	310.0	15.08
A12519/32X500	19/32	15.08	0.5938	400.0	460.0	15.08
A1255/8X315	5/8	15.88	0.6250	250.0	310.0	15.88
A1255/8X500	5/8	15.88	0.6250	400.0	460.0	15.88
A12511/16X315	11/16	17.46	0.6875	250.0	310.0	17.46
A1253/4X315	3/4	19.05	0.7500	250.0	310.0	19.05
A1253/4X500	3/4	19.05	0.7500	400.0	460.0	19.05

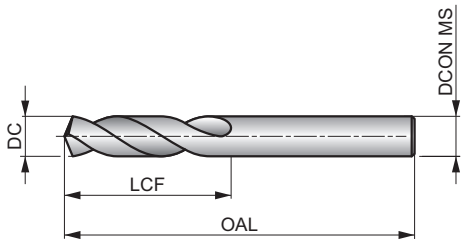
材料代码(BMC)		HSS	HSS	HSS	HSS	HSS	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E		
基本标准组(BSG)		NAS 907	NAS 907	NAS 907	NAS 907	NAS 907	NAS 907	NAS 907	NAS 907	NAS 907	DIN 338		
有用长度直径比 (ULDR)		2.5×D	4×D	4×D	4×D	4×D	3×D	4×D	4×D	4×D	4×D		
应用角度		135°	118°	135°	135°	135°	135°	135°	135°	135°	135°		
涂层		ST	ST	ST	ST	ST	Bronze	Bronze	Bronze	Bronze	Bronze		
柄部													
螺旋形式		λ.20-35°	λ.20-35°	λ.20-35°	λ.20-35°	λ.20-35°	λ.20-35°	λ.20-35°	λ.20-35°	λ.20-35°	λ.20-35°		
旋向(切削方向)		R	R	R	R	R	R	R	R	R	R		
		R40C R41C R42C	R10A R15A R18A	R10B R15B R18B	500-6 501-6 502-6	500-12 501-12 502-12	R88CO R89CO	R10CO R15CO R18CO	CO500-6 CO501-6	CO500-12 CO501-12	2ACO		
		N60 - 1/2	1/16 - 1/2	1/16 - 1/2	N60 - 1/2	3/64 - 1/2	1/16 - 1/2	N80 - 11/16	1/16 - 1/4	1/16 - 1/4	1.00 - 13.00		
		42	44	46	48	50	52	53	55	56	57		
P	P1	■	■	◪			◪	◪	◪	◪	◪		
	P2	■	■	■	◪	◪	◪	◪	◪	◪	◪		
	P3	■	■	■	◪	◪	■	■	■	■	■		
	P4	◪	◪	◪	◪	◪	■	■	■	■	■		
M	M1	■	◪	◪	◪	◪	◪	◪	◪	◪	◪		
	M2	■	◪	◪	◪	◪	■	■	■	■	■		
	M3	◪	◪	◪	■	■	■	■	■	■	■		
	M4	◪	◪	◪	■	■	■	■	■	■	■		
K	K1	■	■	■	◪	◪	◪	◪	◪	◪	◪		
	K2	■	■	■	◪	◪	■	■	■	■	■		
	K3	■	◪	■	◪	◪	■	■	■	■	■		
	K4	◪	◪	■	■	■	■	■	■	■	■		
	K5	■	◪	◪	◪	◪	◪	◪	◪	◪	◪		
N	N1	◪	◪	◪			◪	◪	◪	◪	◪		
	N2	◪	◪	◪	■	■	◪	◪	◪	◪	◪		
	N3	◪	◪	◪	■	■	◪	◪	◪	◪	◪		
	N4	◪							◪	◪			
	N5												
S	S1	◪	◪	◪	■	■	■	■			■		
	S2	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪		
	S3	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪		
	S4	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪		
H	H1												
	H2												
	H3												
	H4												

■推荐使用 ◪可以使用

R40C/R41C/R42C

PRECISION

NAS 907 C 型高速钢短钻，蒸汽回火
重型多功能电钻，表面经过蒸汽回火处理。135°自定心钻尖可降低切削力，防止钻头在接触工件时偏斜。较厚的横刃和较短的长度使这种钻头非常坚固，适合手持和机器钻孔加工多种材料。



HSS	NAS 907	2.5×D
135°	ST	
λ20-35°	R	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■36 J	■40 J	■41 J	■31 J	■27 G	■24 F	■21 G	■17 G	■14 F	■12 G	◪10 F	◪9 E	■22 F	■19 F
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■20 F	■16 F	◪10 H	◪9 H	◪8 D	◪10 D	■32 J	■24 G	■18 G	■25 F	■20 F	■16 F	■22 F	■17 F
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
■13 F	■20 F	■15 F	◪11 F	◪10 F	◪8 F	■23 F	■17 F	◪13 F	◪33 K	◪25 K	◪17 J	◪46 I	◪42 I
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪30 I	◪64 I	◪38 J	◪19 H	◪30 K	◪35 I	◪17 G	■27 G	◪16 E	◪8 C	◪11 F	◪6 B	◪8 F	◪4 B
S4.1	S4.2												
◪6 F	◪3 B												

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R41CN60 1)	–	N60	–	0.0400	0.500	1.375	0.040
R41CN59 1)	–	N59	–	0.0410	0.500	1.375	0.041
R41CN58 1)	–	N58	–	0.0420	0.500	1.375	0.042
R41CN57 1)	–	N57	–	0.0430	0.500	1.375	0.043
R41CN56 1)	–	N56	–	0.0465	0.500	1.375	0.046
R41CN55 1)	–	N55	–	0.0520	0.625	1.625	0.052
R41CN54 1)	–	N54	–	0.0550	0.625	1.625	0.055
R41CN53 1)	–	N53	–	0.0595	0.625	1.625	0.059
R40C1/16	1/16	–	–	0.0625	0.625	1.625	0.063
R41CN52	–	N52	–	0.0635	0.688	1.688	0.064
R41CN51	–	N51	–	0.0670	0.688	1.688	0.067
R41CN50	–	N50	–	0.0700	0.688	1.688	0.070
R41CN49	–	N49	–	0.0730	0.688	1.688	0.073
R41CN48	–	N48	–	0.0760	0.688	1.688	0.076
R40C5/64	5/64	–	–	0.0781	0.688	1.688	0.078
R41CN47	–	N47	–	0.0785	0.688	1.688	0.079
R41CN46	–	N46	–	0.0810	0.750	1.750	0.081
R41CN45	–	N45	–	0.0820	0.750	1.750	0.082
R41CN44	–	N44	–	0.0860	0.750	1.750	0.086
R41CN43	–	N43	–	0.0890	0.750	1.750	0.089
R41CN42	–	N42	–	0.0935	0.750	1.750	0.093
R40C3/32	3/32	–	–	0.0938	0.750	1.750	0.094
R41CN41	–	N41	–	0.0960	0.813	1.813	0.096
R41CN40	–	N40	–	0.0980	0.813	1.813	0.098

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R41CN39	–	N39	–	0.0995	0.813	1.813	0.100
R41CN38	–	N38	–	0.1015	0.813	1.813	0.102
R41CN37	–	N37	–	0.1040	0.813	1.813	0.104
R41CN36	–	N36	–	0.1065	0.813	1.813	0.106
R40C7/64	7/64	–	–	0.1094	0.813	1.813	0.109
R41CN35	–	N35	–	0.1100	0.875	1.875	0.110
R41CN34	–	N34	–	0.1110	0.875	1.875	0.111
R41CN33	–	N33	–	0.1130	0.875	1.875	0.113
R41CN32	–	N32	–	0.1160	0.875	1.875	0.116
R41CN31	–	N31	–	0.1200	0.875	1.875	0.120
R40C1/8	1/8	–	–	0.1250	0.875	1.875	0.125
R41CN30	–	N30	–	0.1285	0.938	1.938	0.129
R41CN29	–	N29	–	0.1360	0.938	1.938	0.136
R41CN28	–	N28	–	0.1405	0.938	1.938	0.141
R40C9/64	9/64	–	–	0.1406	0.938	1.938	0.141
R41CN27	–	N27	–	0.1440	1.000	2.063	0.144
R41CN26	–	N26	–	0.1470	1.000	2.063	0.147
R41CN25	–	N25	–	0.1495	1.000	2.063	0.149
R41CN24	–	N24	–	0.1520	1.000	2.063	0.152
R41CN23	–	N23	–	0.1540	1.000	2.063	0.154
R40C5/32	5/32	–	–	0.1563	1.000	2.063	0.156
R41CN22	–	N22	–	0.1570	1.063	2.125	0.157
R41CN21	–	N21	–	0.1590	1.063	2.125	0.159
R41CN20	–	N20	–	0.1610	1.063	2.125	0.161

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R41CN19	–	N19	–	0.1660	1.063	2.125	0.166
R41CN18	–	N18	–	0.1695	1.063	2.125	0.170
R40C11/64	11/64	–	–	0.1719	1.063	2.125	0.172
R41CN17	–	N17	–	0.1730	1.125	2.188	0.173
R41CN16	–	N16	–	0.1770	1.125	2.188	0.177
R41CN15	–	N15	–	0.1800	1.125	2.188	0.180
R41CN14	–	N14	–	0.1820	1.125	2.188	0.182
R41CN13	–	N13	–	0.1850	1.125	2.188	0.185
R40C3/16	3/16	–	–	0.1875	1.125	2.188	0.188
R41CN12	–	N12	–	0.1890	1.188	2.250	0.189
R41CN11	–	N11	–	0.1910	1.188	2.250	0.191
R41CN10	–	N10	–	0.1935	1.188	2.250	0.194
R41CN9	–	N9	–	0.1960	1.188	2.250	0.196
R41CN8	–	N8	–	0.1990	1.188	2.250	0.199
R41CN7	–	N7	–	0.2010	1.188	2.250	0.201
R40C13/64	13/64	–	–	0.2031	1.188	2.250	0.203
R41CN6	–	N6	–	0.2040	1.250	2.375	0.204
R41CN5	–	N5	–	0.2055	1.250	2.375	0.205
R41CN4	–	N4	–	0.2090	1.250	2.375	0.209
R41CN3	–	N3	–	0.2130	1.250	2.375	0.213
R40C7/32	7/32	–	–	0.2188	1.250	2.375	0.219
R41CN2	–	N2	–	0.2210	1.313	2.438	0.221
R41CN1	–	N1	–	0.2280	1.313	2.438	0.228
R42CA	–	–	A	0.2340	1.313	2.438	0.234
R40C15/64	15/64	–	–	0.2344	1.313	2.438	0.234
R42CB	–	–	B	0.2380	1.375	2.500	0.238
R42CC	–	–	C	0.2420	1.375	2.500	0.242
R42CD	–	–	D	0.2460	1.375	2.500	0.246
R40C1/4	1/4	–	–	0.2500	1.375	2.500	0.250
R42CF	–	–	F	0.2570	1.438	2.625	0.257
R42CG	–	–	G	0.2610	1.438	2.625	0.261
R40C17/64	17/64	–	–	0.2656	1.438	2.625	0.266
R42CH	–	–	H	0.2660	1.500	2.688	0.266

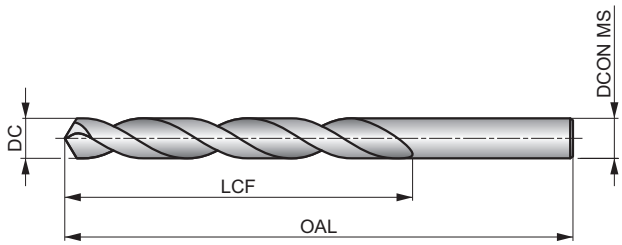
[1] 无分离式钻尖

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R42CI	–	–	I	0.2720	1.500	2.688	0.272
R42CJ	–	–	J	0.2770	1.500	2.688	0.277
R42CK	–	–	K	0.2810	1.500	2.688	0.281
R40C9/32	9/32	–	–	0.2813	1.500	2.688	0.281
R42CM	–	–	M	0.2950	1.563	2.750	0.295
R40C19/64	19/64	–	–	0.2969	1.563	2.750	0.297
R42CL	–	–	L	0.2990	1.563	2.750	0.299
R42CN	–	–	N	0.3020	1.625	2.813	0.302
R40C5/16	5/16	–	–	0.3125	1.625	2.813	0.313
R42CO	–	–	O	0.3160	1.688	2.938	0.316
R42CP	–	–	P	0.3230	1.688	2.938	0.323
R40C21/64	21/64	–	–	0.3281	1.688	2.938	0.328
R42CQ	–	–	Q	0.3320	1.688	3.000	0.332
R42CR	–	–	R	0.3390	1.688	3.000	0.339
R40C11/32	11/32	–	–	0.3438	1.688	3.000	0.344
R42CS	–	–	S	0.3480	1.750	3.063	0.348
R42CT	–	–	T	0.3580	1.750	3.063	0.358
R40C23/64	23/64	–	–	0.3594	1.750	3.063	0.359
R42CU	–	–	U	0.3680	1.813	3.125	0.368
R40C3/8	3/8	–	–	0.3750	1.813	3.125	0.375
R42CV	–	–	V	0.3770	1.875	3.250	0.377
R42CW	–	–	W	0.3860	1.875	3.250	0.386
R40C25/64	25/64	–	–	0.3906	1.875	3.250	0.391
R42CX	–	–	X	0.3970	1.938	3.313	0.397
R42CY	–	–	Y	0.4040	1.938	3.313	0.404
R40C13/32	13/32	–	–	0.4063	1.938	3.313	0.406
R42CZ	–	–	Z	0.4130	2.000	3.375	0.413
R40C27/64	27/64	–	–	0.4219	2.000	3.375	0.422
R40C7/16	7/16	–	–	0.4375	2.063	3.438	0.438
R40C29/64	29/64	–	–	0.4531	2.125	3.563	0.453
R40C15/32	15/32	–	–	0.4688	2.125	3.625	0.469
R40C31/64	31/64	–	–	0.4844	2.188	3.688	0.484
R40C1/2	1/2	–	–	0.5000	2.250	3.750	0.500

R10A/R15A/R18A

PRECISION

NAS 907 A 型高速钢手工作业钻，表面蒸汽回火处理
性能优异的钻头，具有 118° 自定心钻尖，穿透更容易，推力更小。表面经过蒸汽回火处理，提高了耐磨性和润滑性。按照 NAS 907 A 型航空航天标准制造。



HSS	NAS 907	4×D
118°	ST	
λ20-35°	R	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■36 H	■40 H	■41 H	■31 H	■27 G	■24 E	■25 F	■20 F	◪17 E	◪15 F	◪13 E	◪10 D	◪30 E	◪26 E
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
◪27 E	◪22 E	◪18 C	◪13 G	◪11 G	◪10 C	◪15 C	◪13 C	■35 H	■26 D	■19 D	■27 E	■22 E	◪18 E
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■24 E	■18 E	◪15 E	■22 E	■17 E	◪12 E	◪11 E	◪9 E	■25 E	◪19 E	◪15 E	◪33 J	◪25 J	◪17 I
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
◪46 H	◪42 H	◪30 H	◪68 H	◪40 F	◪20 H	◪28 F	◪20 D	◪11 C	◪9 E	◪8 B	◪7 E	◪6 B	◪5 E
S4.2													
◪5 B													

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R10A1/16	1/16	–	–	0.0625	7/8	1.7/8	0.063
R18AN52	–	N52	–	0.0635	7/8	1.7/8	0.064
R18AN51	–	N51	–	0.0670	1″	2″	0.067
R18AN50	–	N50	–	0.0700	1″	2″	0.070
R18AN49	–	N49	–	0.0730	1″	2″	0.073
R18AN48	–	N48	–	0.0760	1″	2″	0.076
R10A5/64	5/64	–	–	0.0781	1″	2″	0.078
R18AN47	–	N47	–	0.0785	1″	2″	0.079
R18AN46	–	N46	–	0.0810	1.1/8	2.1/8	0.081
R18AN45	–	N45	–	0.0820	1.1/8	2.1/8	0.082
R18AN44	–	N44	–	0.0860	1.1/8	2.1/8	0.086
R18AN43	–	N43	–	0.0890	1.1/4	2.1/4	0.089
R18AN42	–	N42	–	0.0935	1.1/4	2.1/4	0.093
R10A3/32	3/32	–	–	0.0938	1.1/4	2.1/4	0.094
R18AN41	–	N41	–	0.0960	1.3/8	2.3/8	0.096
R18AN40	–	N40	–	0.0980	1.3/8	2.3/8	0.098
R18AN39	–	N39	–	0.0995	1.3/8	2.3/8	0.100
R18AN38	–	N38	–	0.1015	1.7/16	2.1/2	0.102
R18AN37	–	N37	–	0.1040	1.7/16	2.1/2	0.104
R18AN36	–	N36	–	0.1065	1.7/16	2.1/2	0.106
R10A7/64	7/64	–	–	0.1094	1.1/2	2.5/8	0.109
R18AN35	–	N35	–	0.1100	1.1/2	2.5/8	0.110
R18AN34	–	N34	–	0.1110	1.1/2	2.5/8	0.111
R18AN33	–	N33	–	0.1130	1.1/2	2.5/8	0.113

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R18AN32	–	N32	–	0.1160	1.5/8	2.3/4	0.116
R18AN31	–	N31	–	0.1200	1.5/8	2.3/4	0.120
R10A1/8	1/8	–	–	0.1250	1.5/8	2.3/4	0.125
R18AN30	–	N30	–	0.1285	1.5/8	2.3/4	0.129
R18AN29	–	N29	–	0.1360	1.3/4	2.7/8	0.136
R18AN28	–	N28	–	0.1405	1.3/4	2.7/8	0.141
R10A9/64	9/64	–	–	0.1406	1.3/4	2.7/8	0.141
R18AN27	–	N27	–	0.1440	1.7/8	3″	0.144
R18AN26	–	N26	–	0.1470	1.7/8	3″	0.147
R18AN25	–	N25	–	0.1495	1.7/8	3″	0.149
R18AN24	–	N24	–	0.1520	2″	3.1/8	0.152
R18AN23	–	N23	–	0.1540	2″	3.1/8	0.154
R10A5/32	5/32	–	–	0.1563	2″	3.1/8	0.156
R18AN22	–	N22	–	0.1570	2″	3.1/8	0.157
R18AN21	–	N21	–	0.1590	2.1/8	3.1/4	0.159
R18AN20	–	N20	–	0.1610	2.1/8	3.1/4	0.161
R18AN19	–	N19	–	0.1660	2.1/8	3.1/4	0.166
R18AN18	–	N18	–	0.1695	2.1/8	3.1/4	0.170
R10A11/64	11/64	–	–	0.1719	2.1/8	3.1/4	0.172
R18AN17	–	N17	–	0.1730	2.3/16	3.3/8	0.173
R18AN16	–	N16	–	0.1770	2.3/16	3.3/8	0.177
R18AN15	–	N15	–	0.1800	2.3/16	3.3/8	0.180
R18AN14	–	N14	–	0.1820	2.3/16	3.3/8	0.182
R18AN13	–	N13	–	0.1850	2.5/16	3.1/2	0.185

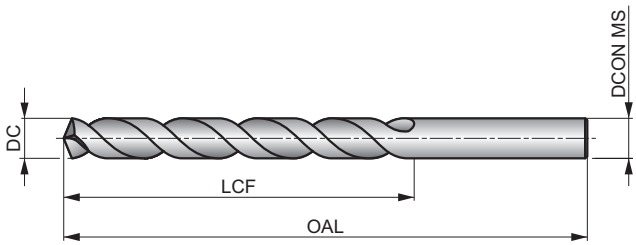
Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R10A3/16	3/16	–	–	0.1875	2.5/16	3.1/2	0.188
R18AN12	–	N12	–	0.1890	2.5/16	3.1/2	0.189
R18AN11	–	N11	–	0.1910	2.5/16	3.1/2	0.191
R18AN10	–	N10	–	0.1935	2.7/16	3.5/8	0.194
R18AN9	–	N9	–	0.1960	2.7/16	3.5/8	0.196
R18AN8	–	N8	–	0.1990	2.7/16	3.5/8	0.199
R18AN7	–	N7	–	0.2010	2.7/16	3.5/8	0.201
R10A13/64	13/64	–	–	0.2031	2.7/16	3.5/8	0.203
R18AN6	–	N6	–	0.2040	2.1/2	3.3/4	0.204
R18AN5	–	N5	–	0.2055	2.1/2	3.3/4	0.205
R18AN4	–	N4	–	0.2090	2.1/2	3.3/4	0.209
R18AN3	–	N3	–	0.2130	2.1/2	3.3/4	0.213
R10A7/32	7/32	–	–	0.2188	2.1/2	3.3/4	0.219
R18AN2	–	N2	–	0.2210	2.5/8	3.7/8	0.221
R18AN1	–	N1	–	0.2280	2.5/8	3.7/8	0.228
R15AA	–	–	A	0.2340	2.5/8	3.7/8	0.234
R10A15/64	15/64	–	–	0.2344	2.5/8	3.7/8	0.234
R15AB	–	–	B	0.2380	2.3/4	4″	0.238
R15AC	–	–	C	0.2420	2.3/4	4″	0.242
R15AD	–	–	D	0.2460	2.3/4	4″	0.246
R10A1/4	1/4	–	–	0.2500	2.3/4	4″	0.250
R15AF	–	–	F	0.2570	2.7/8	4.1/8	0.257
R15AG	–	–	G	0.2610	2.7/8	4.1/8	0.261
R10A17/64	17/64	–	–	0.2656	2.7/8	4.1/8	0.266
R15AH	–	–	H	0.2660	2.7/8	4.1/8	0.266
R15AI	–	–	I	0.2720	2.7/8	4.1/8	0.272
R15AJ	–	–	J	0.2770	2.7/8	4.1/8	0.277
R15AK	–	–	K	0.2810	2.15/16	4.1/4	0.281
R10A9/32	9/32	–	–	0.2813	2.15/16	4.1/4	0.281

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R15AL	–	–	L	0.2900	2.15/16	4.1/4	0.290
R15AM	–	–	M	0.2950	3.1/16	4.3/8	0.295
R10A19/64	19/64	–	–	0.2969	3.1/16	4.3/8	0.297
R15AN	–	–	N	0.3020	3.1/16	4.3/8	0.302
R10A5/16	5/16	–	–	0.3125	3.3/16	4.1/2	0.313
R15AO	–	–	O	0.3160	3.3/16	4.1/2	0.316
R15AP	–	–	P	0.3230	3.5/16	4.5/8	0.323
R10A21/64	21/64	–	–	0.3281	3.5/16	4.5/8	0.328
R15AQ	–	–	Q	0.3320	3.7/16	4.3/4	0.332
R15AR	–	–	R	0.3390	3.7/16	4.3/4	0.339
R10A11/32	11/32	–	–	0.3438	3.7/16	4.3/4	0.344
R15AS	–	–	S	0.3480	3.1/2	4.7/8	0.348
R15AT	–	–	T	0.3580	3.1/2	4.7/8	0.358
R10A23/64	23/64	–	–	0.3594	3.1/2	4.7/8	0.359
R15AU	–	–	U	0.3680	3.5/8	5″	0.368
R10A3/8	3/8	–	–	0.3750	3.5/8	5″	0.375
R15AV	–	–	V	0.3770	3.5/8	5″	0.377
R15AW	–	–	W	0.3860	3.3/4	5.1/8	0.386
R10A25/64	25/64	–	–	0.3906	3.3/4	5.1/8	0.391
R15AX	–	–	X	0.3970	3.3/4	5.1/8	0.397
R15AY	–	–	Y	0.4040	3.7/8	5.1/4	0.404
R10A13/32	13/32	–	–	0.4063	3.7/8	5.1/4	0.406
R15AZ	–	–	Z	0.4130	3.7/8	5.1/4	0.413
R10A27/64	27/64	–	–	0.4219	3.15/16	5.3/8	0.422
R10A7/16	7/16	–	–	0.4375	4.1/16	5.1/2	0.438
R10A29/64	29/64	–	–	0.4531	4.3/16	5.5/8	0.453
R10A15/32	15/32	–	–	0.4688	4.5/16	5.3/4	0.469
R10A31/64	31/64	–	–	0.4844	4.3/8	5.7/8	0.484
R10A1/2	1/2	–	–	0.5000	4.1/2	6″	0.500

R10B/R15B/R18B

PRECISION

NAS 907 B 型高速钢标准长度钻头，蒸汽回火
重型标准长度钻头，配备 135° 低推力自定心钻尖，更易穿透。表面蒸汽回火处理，提高了耐磨性和润滑性。按照 NAS 907 B 型航空航天标准制造。



HSS	NAS 907	4×D
135°	ST	
λ20-35°	R	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪36 H	◪40 H	◪41 H	■31 H	■27 G	■24 E	■25 F	■20 F	■17 E	◪15 F	◪13 E	◪10 D	◪30 E	◪26 E
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
◪27 E	◪22 E	◪18 C	◪13 G	■11 G	■10 C	◪15 C	◪13 C	■35 H	■26 D	■19 D	■27 E	■22 E	■18 E
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■24 E	■18 E	■15 E	■22 E	■17 E	■12 E	■11 E	■9 E	◪25 E	◪19 E	■15 E	◪33 J	◪25 J	◪17 I
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
◪46 H	◪42 H	◪30 H	◪68 H	◪40 F	◪20 H	◪28 F	◪20 D	◪11 C	◪9 E	◪8 B	◪7 E	◪6 B	◪5 E
S4.2													
◪5 B													

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R10B1/16	1/16	–	–	0.0625	7/8	1.7/8	0.063
R18BN52	–	N52	–	0.0635	7/8	1.7/8	0.064
R18BN51	–	N51	–	0.0670	1″	2″	0.067
R18BN50	–	N50	–	0.0700	1″	2″	0.070
R18BN49	–	N49	–	0.0730	1″	2″	0.073
R18BN48	–	N48	–	0.0760	1″	2″	0.076
R10B5/64	5/64	–	–	0.0781	1″	2″	0.078
R18BN47	–	N47	–	0.0785	1″	2″	0.079
R18BN46	–	N46	–	0.0810	1.1/8	2.1/8	0.081
R18BN45	–	N45	–	0.0820	1.1/8	2.1/8	0.082
R18BN44	–	N44	–	0.0860	1.1/8	2.1/8	0.086
R18BN43	–	N43	–	0.0890	1.1/4	2.1/4	0.089
R18BN42	–	N42	–	0.0935	1.1/4	2.1/4	0.093
R10B3/32	3/32	–	–	0.0938	1.1/4	2.1/4	0.094
R18BN41	–	N41	–	0.0960	1.3/8	2.3/8	0.096
R18BN40	–	N40	–	0.0980	1.3/8	2.3/8	0.098
R18BN39	–	N39	–	0.0995	1.3/8	2.3/8	0.100
R18BN38	–	N38	–	0.1015	1.7/16	2.1/2	0.102
R18BN37	–	N37	–	0.1040	1.7/16	2.1/2	0.104
R18BN36	–	N36	–	0.1065	1.7/16	2.1/2	0.106
R10B7/64	7/64	–	–	0.1094	1.1/2	2.5/8	0.109
R18BN35	–	N35	–	0.1100	1.1/2	2.5/8	0.110
R18BN34	–	N34	–	0.1110	1.1/2	2.5/8	0.111
R18BN33	–	N33	–	0.1130	1.1/2	2.5/8	0.113

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R18BN32	–	N32	–	0.1160	1.5/8	2.3/4	0.116
R18BN31	–	N31	–	0.1200	1.5/8	2.3/4	0.120
R10B1/8	1/8	–	–	0.1250	1.5/8	2.3/4	0.125
R18BN30	–	N30	–	0.1285	1.5/8	2.3/4	0.129
R18BN29	–	N29	–	0.1360	1.3/4	2.7/8	0.136
R18BN28	–	N28	–	0.1405	1.3/4	2.7/8	0.141
R10B9/64	9/64	–	–	0.1406	1.3/4	2.7/8	0.141
R18BN27	–	N27	–	0.1440	1.7/8	3″	0.144
R18BN26	–	N26	–	0.1470	1.7/8	3″	0.147
R18BN25	–	N25	–	0.1495	1.7/8	3″	0.149
R18BN24	–	N24	–	0.1520	2″	3.1/8	0.152
R18BN23	–	N23	–	0.1540	2″	3.1/8	0.154
R10B5/32	5/32	–	–	0.1563	2″	3.1/8	0.156
R18BN22	–	N22	–	0.1570	2″	3.1/8	0.157
R18BN21	–	N21	–	0.1590	2.1/8	3.1/4	0.159
R18BN20	–	N20	–	0.1610	2.1/8	3.1/4	0.161
R18BN19	–	N19	–	0.1660	2.1/8	3.1/4	0.166
R18BN18	–	N18	–	0.1695	2.1/8	3.1/4	0.170
R10B11/64	11/64	–	–	0.1719	2.1/8	3.1/4	0.172
R18BN17	–	N17	–	0.1730	2.3/16	3.3/8	0.173
R18BN16	–	N16	–	0.1770	2.3/16	3.3/8	0.177
R18BN15	–	N15	–	0.1800	2.3/16	3.3/8	0.180
R18BN14	–	N14	–	0.1820	2.3/16	3.3/8	0.182
R18BN13	–	N13	–	0.1850	2.5/16	3.1/2	0.185

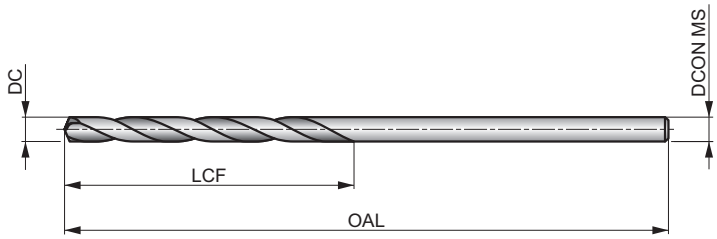
Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R10B3/16	3/16	–	–	0.1875	2.5/16	3.1/2	0.188
R18BN12	–	N12	–	0.1890	2.5/16	3.1/2	0.189
R18BN11	–	N11	–	0.1910	2.5/16	3.1/2	0.191
R18BN10	–	N10	–	0.1935	2.7/16	3.5/8	0.194
R18BN9	–	N9	–	0.1960	2.7/16	3.5/8	0.196
R18BN8	–	N8	–	0.1990	2.7/16	3.5/8	0.199
R18BN7	–	N7	–	0.2010	2.7/16	3.5/8	0.201
R10B13/64	13/64	–	–	0.2031	2.7/16	3.5/8	0.203
R18BN6	–	N6	–	0.2040	2.1/2	3.3/4	0.204
R18BN5	–	N5	–	0.2055	2.1/2	3.3/4	0.205
R18BN4	–	N4	–	0.2090	2.1/2	3.3/4	0.209
R18BN3	–	N3	–	0.2130	2.1/2	3.3/4	0.213
R10B7/32	7/32	–	–	0.2188	2.1/2	3.3/4	0.219
R18BN2	–	N2	–	0.2210	2.5/8	3.7/8	0.221
R18BN1	–	N1	–	0.2280	2.5/8	3.7/8	0.228
R15BA	–	–	A	0.2340	2.5/8	3.7/8	0.234
R10B15/64	15/64	–	–	0.2344	2.5/8	3.7/8	0.234
R15BB	–	–	B	0.2380	2.3/4	4″	0.238
R15BC	–	–	C	0.2420	2.3/4	4″	0.242
R15BD	–	–	D	0.2460	2.3/4	4″	0.246
R10B1/4	1/4	–	–	0.2500	2.3/4	4″	0.250
R15BF	–	–	F	0.2570	2.7/8	4.1/8	0.257
R15BG	–	–	G	0.2610	2.7/8	4.1/8	0.261
R10B17/64	17/64	–	–	0.2656	2.7/8	4.1/8	0.266
R15BH	–	–	H	0.2660	2.7/8	4.1/8	0.266
R15BI	–	–	I	0.2720	2.7/8	4.1/8	0.272
R15BJ	–	–	J	0.2770	2.7/8	4.1/8	0.277
R15BK	–	–	K	0.2810	2.15/16	4.1/4	0.281
R10B9/32	9/32	–	–	0.2813	2.15/16	4.1/4	0.281

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R15BL	–	–	L	0.2900	2.15/16	4.1/4	0.290
R15BM	–	–	M	0.2950	3.1/16	4.3/8	0.295
R10B19/64	19/64	–	–	0.2969	3.1/16	4.3/8	0.297
R15BN	–	–	N	0.3020	3.1/16	4.3/8	0.302
R10B5/16	5/16	–	–	0.3125	3.3/16	4.1/2	0.313
R15BO	–	–	O	0.3160	3.3/16	4.1/2	0.316
R15BP	–	–	P	0.3230	3.5/16	4.5/8	0.323
R10B21/64	21/64	–	–	0.3281	3.5/16	4.5/8	0.328
R15BQ	–	–	Q	0.3320	3.7/16	4.3/4	0.332
R15BR	–	–	R	0.3390	3.7/16	4.3/4	0.339
R10B11/32	11/32	–	–	0.3438	3.7/16	4.3/4	0.344
R15BS	–	–	S	0.3480	3.1/2	4.7/8	0.348
R15BT	–	–	T	0.3580	3.1/2	4.7/8	0.358
R10B23/64	23/64	–	–	0.3594	3.1/2	4.7/8	0.359
R15BU	–	–	U	0.3680	3.5/8	5″	0.368
R10B3/8	3/8	–	–	0.3750	3.5/8	5″	0.375
R15BV	–	–	V	0.3770	3.5/8	5″	0.377
R15BW	–	–	W	0.3860	3.3/4	5.1/8	0.386
R10B25/64	25/64	–	–	0.3906	3.3/4	5.1/8	0.391
R15BX	–	–	X	0.3970	3.3/4	5.1/8	0.397
R15BY	–	–	Y	0.4040	3.7/8	5.1/4	0.404
R10B13/32	13/32	–	–	0.4063	3.7/8	5.1/4	0.406
R15BZ	–	–	Z	0.4130	3.7/8	5.1/4	0.413
R10B27/64	27/64	–	–	0.4219	3.15/16	5.3/8	0.422
R10B7/16	7/16	–	–	0.4375	4.1/16	5.1/2	0.438
R10B29/64	29/64	–	–	0.4531	4.3/16	5.5/8	0.453
R10B15/32	15/32	–	–	0.4688	4.5/16	5.3/4	0.469
R10B31/64	31/64	–	–	0.4844	4.3/8	5.7/8	0.484
R10B1/2	1/2	–	–	0.5000	4.1/2	6″	0.500

500-6/501-6/502-6

PRECISION

NAS 907 B 型高速钢航空航天专用加长钻，6 英寸 OAL
长系列钻头按照国家航空航天标准制造，全长较长，刃长较短，非常适合在难以触及的区域钻孔。135°自定心钻尖和蒸汽回火表面处理使其适用于大多数材料的钻孔。



HSS	NAS 907	4×D
135°	ST	
λ20-35°	R	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2
◪25 F	■22 E	◪19 F	◪15 F	■13 E	■11 F	◪10 E	◪8 D	◪21 E	◪17 E	◪18 E	◪15 E	■9 G	■8 G
M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3
■7 C	■9 C	◪30 I	◪22 F	◪17 F	◪25 E	◪20 E	■16 E	◪22 E	◪17 E	■13 E	◪20 E	◪15 E	■11 E
K4.4	K4.5	K5.1	K5.2	K5.3	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1
■10 E	■8 E	◪23 E	◪17 E	■13 E	■27 G	■24 F	◪27 H	■21 H	◪16 G	■23 F	■12 D	■6 B	◪8 E
S2.2	S3.1	S3.2	S4.1	S4.2									
◪4 A	◪6 E	◪3 A	◪5 E	◪2 A									

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
501-6N60 [1]	–	N60	–	0.0400	11/16	6″	0.040
501-6N59 [1]	–	N59	–	0.0410	11/16	6″	0.041
501-6N58 [1]	–	N58	–	0.0420	11/16	6″	0.042
501-6N57 [1]	–	N57	–	0.0430	3/4	6″	0.043
501-6N56 [1]	–	N56	–	0.0465	3/4	6″	0.046
500-63/64 [1]	3/64	–	–	0.0469	3/4	6″	0.047
501-6N55 [1]	–	N55	–	0.0520	7/8	6″	0.052
501-6N54 [1]	–	N54	–	0.0550	7/8	6″	0.055
501-6N53 [1]	–	N53	–	0.0595	7/8	6″	0.059
500-61/16	1/16	–	–	0.0625	7/8	6″	0.063
501-6N52	–	N52	–	0.0635	7/8	6″	0.064
501-6N51	–	N51	–	0.0670	1″	6″	0.067
501-6N50	–	N50	–	0.0700	1″	6″	0.070
501-6N49	–	N49	–	0.0730	1″	6″	0.073
501-6N48	–	N48	–	0.0760	1″	6″	0.076
500-65/64	5/64	–	–	0.0781	1″	6″	0.078
501-6N47	–	N47	–	0.0785	1″	6″	0.079
501-6N46	–	N46	–	0.0810	1.1/8	6″	0.081
501-6N45	–	N45	–	0.0820	1.1/8	6″	0.082
501-6N44	–	N44	–	0.0860	1.1/8	6″	0.086
501-6N43	–	N43	–	0.0890	1.1/4	6″	0.089
501-6N42	–	N42	–	0.0935	1.1/4	6″	0.093
500-63/32	3/32	–	–	0.0938	1.1/4	6″	0.094
501-6N41	–	N41	–	0.0960	1.3/8	6″	0.096
501-6N40	–	N40	–	0.0980	1.3/8	6″	0.098
501-6N39	–	N39	–	0.0995	1.3/8	6″	0.100

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
501-6N38	–	N38	–	0.1015	1.7/16	6″	0.102
501-6N37	–	N37	–	0.1040	1.7/16	6″	0.104
501-6N36	–	N36	–	0.1065	1.7/16	6″	0.106
500-67/64	7/64	–	–	0.1094	1.1/2	6″	0.109
501-6N35	–	N35	–	0.1100	1.1/2	6″	0.110
501-6N34	–	N34	–	0.1110	1.1/2	6″	0.111
501-6N33	–	N33	–	0.1130	1.1/2	6″	0.113
501-6N32	–	N32	–	0.1160	1.5/8	6″	0.116
501-6N31	–	N31	–	0.1200	1.5/8	6″	0.120
500-61/8	1/8	–	–	0.1250	1.5/8	6″	0.125
501-6N30	–	N30	–	0.1285	1.5/8	6″	0.129
501-6N29	–	N29	–	0.1360	1.3/4	6″	0.136
501-6N28	–	N28	–	0.1405	1.3/4	6″	0.141
500-69/64	9/64	–	–	0.1406	1.3/4	6″	0.141
501-6N27	–	N27	–	0.1440	1.7/8	6″	0.144
501-6N26	–	N26	–	0.1470	1.7/8	6″	0.147
501-6N25	–	N25	–	0.1495	1.7/8	6″	0.149
501-6N24	–	N24	–	0.1520	2″	6″	0.152
501-6N23	–	N23	–	0.1540	2″	6″	0.154
500-65/32	5/32	–	–	0.1563	2″	6″	0.156
501-6N22	–	N22	–	0.1570	2″	6″	0.157
501-6N21	–	N21	–	0.1590	2.1/8	6″	0.159
501-6N20	–	N20	–	0.1610	2.1/8	6″	0.161
501-6N19	–	N19	–	0.1660	2.1/8	6″	0.166
501-6N18	–	N18	–	0.1695	2.1/8	6″	0.170
500-611/64	11/64	–	–	0.1719	2.1/8	6″	0.172

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
501-6N17	–	N17	–	0.1730	2.3/16	6″	0.173
501-6N16	–	N16	–	0.1770	2.3/16	6″	0.177
501-6N15	–	N15	–	0.1800	2.3/16	6″	0.180
501-6N14	–	N14	–	0.1820	2.3/16	6″	0.182
501-6N13	–	N13	–	0.1850	2.5/16	6″	0.185
500-63/16	3/16	–	–	0.1875	2.5/16	6″	0.188
501-6N12	–	N12	–	0.1890	2.5/16	6″	0.189
501-6N11	–	N11	–	0.1910	2.5/16	6″	0.191
501-6N10	–	N10	–	0.1935	2.7/16	6″	0.194
501-6N9	–	N9	–	0.1960	2.7/16	6″	0.196
501-6N8	–	N8	–	0.1990	2.7/16	6″	0.199
501-6N7	–	N7	–	0.2010	2.7/16	6″	0.201
500-613/64	13/64	–	–	0.2031	2.7/16	6″	0.203
501-6N6	–	N6	–	0.2040	2.1/2	6″	0.204
501-6N5	–	N5	–	0.2055	2.1/2	6″	0.205
501-6N4	–	N4	–	0.2090	2.1/2	6″	0.209
501-6N3	–	N3	–	0.2130	2.1/2	6″	0.213
500-67/32	7/32	–	–	0.2188	2.1/2	6″	0.219
501-6N2	–	N2	–	0.2210	2.5/8	6″	0.221
501-6N1	–	N1	–	0.2280	2.5/8	6″	0.228
502-6A	–	–	A	0.2340	2.5/8	6″	0.234
500-615/64	15/64	–	–	0.2344	2.5/8	6″	0.234
502-6B	–	–	B	0.2380	2.3/4	6″	0.238
502-6C	–	–	C	0.2420	2.3/4	6″	0.242
502-6D	–	–	D	0.2460	2.3/4	6″	0.246
500-61/4	1/4	–	–	0.2500	2.3/4	6″	0.250
502-6F	–	–	F	0.2570	2.7/8	6″	0.257
502-6G	–	–	G	0.2610	2.7/8	6″	0.261
500-617/64	17/64	–	–	0.2656	2.7/8	6″	0.266
502-6H	–	–	H	0.2660	2.7/8	6″	0.266
502-6I	–	–	I	0.2720	2.7/8	6″	0.272
502-6J	–	–	J	0.2770	2.7/8	6″	0.277

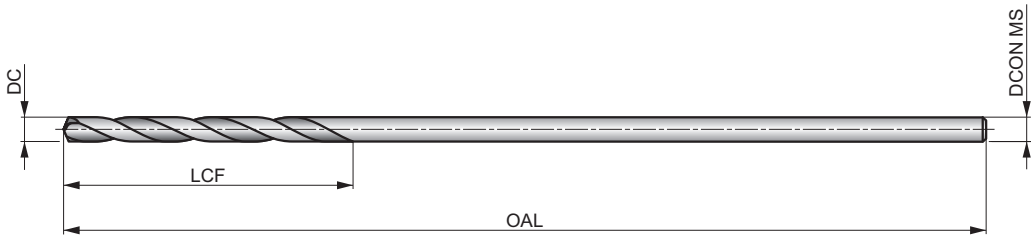
[1] 无分离式钻尖

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
502-6K	–	–	K	0.2810	2.15/16	6″	0.281
500-69/32	9/32	–	–	0.2813	2.15/16	6″	0.281
502-6L	–	–	L	0.2900	2.15/16	6″	0.290
502-6M	–	–	M	0.2950	3.1/16	6″	0.295
500-619/64	19/64	–	–	0.2969	3.1/16	6″	0.297
502-6N	–	–	N	0.3020	3.1/16	6″	0.302
500-65/16	5/16	–	–	0.3125	3.3/16	6″	0.313
502-6O	–	–	O	0.3160	3.3/16	6″	0.316
502-6P	–	–	P	0.3230	3.5/16	6″	0.323
500-621/64	21/64	–	–	0.3281	3.5/16	6″	0.328
502-6Q	–	–	Q	0.3320	3.7/16	6″	0.332
502-6R	–	–	R	0.3390	3.7/16	6″	0.339
500-611/32	11/32	–	–	0.3438	3.7/16	6″	0.344
502-6S	–	–	S	0.3480	3.1/2	6″	0.348
502-6T	–	–	T	0.3580	3.1/2	6″	0.358
500-623/64	23/64	–	–	0.3594	3.1/2	6″	0.359
502-6U	–	–	U	0.3680	3.5/8	6″	0.368
500-63/8	3/8	–	–	0.3750	3.5/8	6″	0.375
502-6V	–	–	V	0.3772	3.5/8	6″	0.377
502-6W	–	–	W	0.3860	3.3/4	6″	0.386
500-625/64	25/64	–	–	0.3906	3.3/4	6″	0.391
502-6X	–	–	X	0.3970	3.3/4	6″	0.397
502-6Y	–	–	Y	0.4040	3.7/8	6″	0.404
500-613/32	13/32	–	–	0.4063	3.7/8	6″	0.406
502-6Z	–	–	Z	0.4130	3.7/8	6″	0.413
500-627/64	27/64	–	–	0.4219	3.15/16	6″	0.422
500-67/16	7/16	–	–	0.4375	4.1/16	6″	0.438
500-629/64	29/64	–	–	0.4531	4.3/16	6″	0.453
500-615/32	15/32	–	–	0.4688	4.5/16	6″	0.469
500-631/64	31/64	–	–	0.4844	4.3/8	6″	0.484
500-61/2	1/2	–	–	0.5000	4.1/2	6″	0.500

500-12/501-12/502-12

PRECISION

NAS 907 B 型高速钢航空航天专用加长钻，12 英寸 OAL
超长系列钻头按照国家航空航天标准制造，全长超长，刃长较短，非常适合在难以触及的区域钻孔。135° 自定心钻尖和蒸汽回火表面处理使其适用于钻孔大多数材料。



HSS	NAS 907	4×D
135°	ST	
λ20-35°	R	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2	M2.1	M2.2	M3.1	M3.2
◪25 F	■22 E	◪19 F	◪15 F	■13 E	■11 F	◪10 E	◪8 D	◪21 E	◪17 E	◪18 E	◪15 E	■9 G	■8 G
M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3
■7 C	■9 C	◪30 I	◪22 F	◪17 F	◪25 E	◪20 E	■16 E	◪22 E	◪17 E	■13 E	◪20 E	◪15 E	■11 E
K4.4	K4.5	K5.1	K5.2	K5.3	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1
■10 E	■8 E	◪23 E	◪17 E	■13 E	■27 G	■24 F	◪27 H	■21 H	◪16 G	■23 F	■12 D	■6 B	◪8 E
S2.2	S3.1	S3.2	S4.1	S4.2									
◪4 A	◪6 E	◪3 A	◪5 E	◪2 A									

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
500-123/64	3/64	–	–	0.0469	3/4	12″	0.047
500-121/16	1/16	–	–	0.0625	7/8	12″	0.063
501-12N50	–	N50	–	0.0700	1″	12″	0.070
501-12N49	–	N49	–	0.0730	1″	12″	0.073
500-125/64	5/64	–	–	0.0781	1″	12″	0.078
501-12N47	–	N47	–	0.0785	1″	12″	0.079
501-12N46	–	N46	–	0.0810	1.1/8	12″	0.081
501-12N45	–	N45	–	0.0820	1.1/8	12″	0.082
501-12N44	–	N44	–	0.0860	1.1/8	12″	0.086
501-12N43	–	N43	–	0.0890	1.1/4	12″	0.089
501-12N42	–	N42	–	0.0935	1.1/4	12″	0.093
500-123/32	3/32	–	–	0.0938	1.1/4	12″	0.094
501-12N41	–	N41	–	0.0960	1.3/8	12″	0.096
501-12N40	–	N40	–	0.0980	1.3/8	12″	0.098
501-12N37	–	N37	–	0.1040	1.7/16	12″	0.104
501-12N36	–	N36	–	0.1065	1.7/16	12″	0.106
500-127/64	7/64	–	–	0.1094	1.1/2	12″	0.109
501-12N31	–	N31	–	0.1200	1.5/8	12″	0.120
500-121/8	1/8	–	–	0.1250	1.5/8	12″	0.125
501-12N30	–	N30	–	0.1285	1.5/8	12″	0.129
501-12N29	–	N29	–	0.1360	1.3/4	12″	0.136
500-129/64	9/64	–	–	0.1406	1.3/4	12″	0.141
501-12N27	–	N27	–	0.1440	1.7/8	12″	0.144
501-12N26	–	N26	–	0.1470	1.7/8	12″	0.147
501-12N25	–	N25	–	0.1495	1.7/8	12″	0.149
501-12N23	–	N23	–	0.1540	2″	12″	0.154

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
500-125/32	5/32	–	–	0.1563	2″	12″	0.156
501-12N22	–	N22	–	0.1570	2″	12″	0.157
501-12N21	–	N21	–	0.1590	2.1/8	12″	0.159
501-12N20	–	N20	–	0.1610	2.1/8	12″	0.161
501-12N19	–	N19	–	0.1660	2.1/8	12″	0.166
501-12N18	–	N18	–	0.1695	2.1/8	12″	0.170
500-1211/64	11/64	–	–	0.1719	2.1/8	12″	0.172
501-12N17	–	N17	–	0.1730	2.3/16	12″	0.173
501-12N16	–	N16	–	0.1770	2.3/16	12″	0.177
501-12N13	–	N13	–	0.1850	2.5/16	12″	0.185
500-123/16	3/16	–	–	0.1875	2.5/16	12″	0.188
501-12N12	–	N12	–	0.1890	2.5/16	12″	0.189
501-12N11	–	N11	–	0.1910	2.5/16	12″	0.191
501-12N10	–	N10	–	0.1935	2.7/16	12″	0.194
501-12N9	–	N9	–	0.1960	2.7/16	12″	0.196
501-12N7	–	N7	–	0.2010	2.7/16	12″	0.201
500-1213/64	13/64	–	–	0.2031	2.7/16	12″	0.203
501-12N5	–	N5	–	0.2055	2.1/2	12″	0.205
501-12N4	–	N4	–	0.2090	2.1/2	12″	0.209
501-12N3	–	N3	–	0.2130	2.1/2	12″	0.213
500-127/32	7/32	–	–	0.2188	2.1/2	12″	0.219
501-12N1	–	N1	–	0.2280	2.5/8	12″	0.228
502-12A	–	–	A	0.2340	2.5/8	12″	0.234
500-1215/64	15/64	–	–	0.2344	2.5/8	12″	0.234
502-12B	–	–	B	0.2380	2.3/4	12″	0.238
502-12C	–	–	C	0.2420	2.3/4	12″	0.242

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
502-12D	–	–	D	0.2460	2.3/4	12″	0.246
500-121/4	1/4	–	–	0.2500	2.3/4	12″	0.250
502-12F	–	–	F	0.2570	2.7/8	12″	0.257
502-12G	–	–	G	0.2610	2.7/8	12″	0.261
500-1217/64	17/64	–	–	0.2656	2.7/8	12″	0.266
502-12H	–	–	H	0.2660	2.7/8	12″	0.266
502-12I	–	–	I	0.2720	2.7/8	12″	0.272
502-12J	–	–	J	0.2770	2.7/8	12″	0.277
502-12K	–	–	K	0.2810	2.15/16	12″	0.281
500-129/32	9/32	–	–	0.2813	2.15/16	12″	0.281
502-12L	–	–	L	0.2900	2.15/16	12″	0.290
502-12M	–	–	M	0.2950	3.1/16	12″	0.295
500-1219/64	19/64	–	–	0.2969	3.1/16	12″	0.297
502-12N	–	–	N	0.3020	3.1/16	12″	0.302
500-125/16	5/16	–	–	0.3125	3.3/16	12″	0.313
502-12O	–	–	O	0.3160	3.3/16	12″	0.316
502-12P	–	–	P	0.3230	3.5/16	12″	0.323
500-1221/64	21/64	–	–	0.3281	3.5/16	12″	0.328
502-12Q	–	–	Q	0.3320	3.7/16	12″	0.332
502-12R	–	–	R	0.3390	3.7/16	12″	0.339

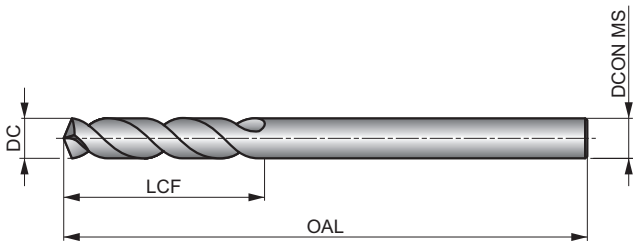
Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
500-1211/32	11/32	–	–	0.3438	3.7/16	12″	0.344
502-12S	–	–	S	0.3480	3.1/2	12″	0.348
502-12T	–	–	T	0.3580	3.1/2	12″	0.358
500-1223/64	23/64	–	–	0.3594	3.1/2	12″	0.359
502-12U	–	–	U	0.3680	3.5/8	12″	0.368
500-123/8	3/8	–	–	0.3750	3.5/8	12″	0.375
502-12V	–	–	V	0.3770	3.5/8	12″	0.377
502-12W	–	–	W	0.3860	3.3/4	12″	0.386
500-1225/64	25/64	–	–	0.3906	3.3/4	12″	0.391
502-12X	–	–	X	0.3970	3.3/4	12″	0.397
502-12Y	–	–	Y	0.4040	3.7/8	12″	0.404
500-1213/32	13/32	–	–	0.4063	3.7/8	12″	0.406
502-12Z	–	–	Z	0.4130	3.7/8	12″	0.413
500-1227/64	27/64	–	–	0.4219	3.15/16	12″	0.422
500-127/16	7/16	–	–	0.4375	4.1/16	12″	0.438
500-1229/64	29/64	–	–	0.4531	4.3/16	12″	0.453
500-1215/32	15/32	–	–	0.4688	4.5/16	12″	0.469
500-1231/64	31/64	–	–	0.4844	4.3/8	12″	0.484
500-121/2	1/2	–	–	0.5000	4.1/2	12″	0.500

R88CO/R89CO

PRECISION

NAS 907 D 型高速钢-E (8%) 钻重载标准长度钻头
刃长较短，柄较长，刚性更强的作业钻头。在钻浅孔或较薄的材料时，该钻头可发挥更大的作用。青铜回火表面处理，低切削力 135° 自定心刃尖，更易穿透。 按照 NAS 907 D 型航空航天标准制造。

HSS-E	NAS 907	3×D
135°	Bronze	
λ 20-35°	R	



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪36 H	◪40 H	◪41 H	◪31 H	◪27 G	■24 E	■25 F	■20 F	■17 E	■15 F	■13 E	■10 D	◪30 E	◪26 E
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1
■27 E	■22 E	■18 C	■13 G	■11 G	■10 C	■15 C	◪35 H	■26 D	■19 D	◪27 E	◪22 E	■18 E	◪24 E
K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1
◪18 E	■15 E	◪22 E	◪17 E	■12 E	■11 E	■9 E	◪25 E	◪19 E	■15 E	◪33 J	◪25 J	◪17 I	◪46 H
N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2
◪42 H	◪30 H	◪68 H	◪40 F	◪20 H	■28 F	■20 D	■11 C	■9 E	◪8 B	■7 E	◪6 B	■5 E	◪5 B

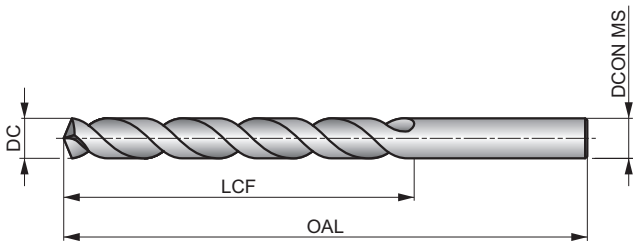
Product	DC (inch)	DC (Wire gauge size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R88C01/16	1/16	–	0.0625	7/16	1.7/8	0.063
R89C0N52	–	N52	0.0635	7/16	1.7/8	0.064
R89C0N51	–	N51	0.0670	1/2	2″	0.067
R89C0N50	–	N50	0.0700	1/2	2″	0.070
R89C0N49	–	N49	0.0730	1/2	2″	0.073
R88C05/64	5/64	–	0.0781	1/2	2″	0.078
R89C0N46	–	N46	0.0810	9/16	2.1/8	0.081
R89C0N45	–	N45	0.0820	9/16	2.1/8	0.082
R89C0N44	–	N44	0.0860	9/16	2.1/8	0.086
R89C0N43	–	N43	0.0890	5/8	2.1/4	0.089
R89C0N42	–	N42	0.0935	5/8	2.1/4	0.093
R88C03/32	3/32	–	0.0938	5/8	2.1/4	0.094
R89C0N41	–	N41	0.0960	5/8	2.3/8	0.096
R89C0N40	–	N40	0.0980	13/16	2.3/8	0.098
R89C0N39	–	N39	0.0995	13/16	2.3/8	0.100
R89C0N36	–	N36	0.1065	13/16	2.1/2	0.106
R88C07/64	7/64	–	0.1094	13/16	2.5/8	0.109
R89C0N31	–	N31	0.1200	7/8	2.3/4	0.120
R88C01/8	1/8	–	0.1250	7/8	2.3/4	0.125
R89C0N30	–	N30	0.1285	15/16	2.3/4	0.129
R89C0N29	–	N29	0.1360	15/16	2.7/8	0.136
R88C09/64	9/64	–	0.1406	15/16	2.7/8	0.141
R89C0N27	–	N27	0.1440	1″	3″	0.144
R89C0N26	–	N26	0.1470	1″	3″	0.147
R89C0N25	–	N25	0.1495	1″	3″	0.149
R89C0N24	–	N24	0.1520	1″	3.1/8	0.152
R88C05/32	5/32	–	0.1563	1″	3.1/8	0.156
R89C0N22	–	N22	0.1570	1.1/16	3.1/8	0.157
R89C0N21	–	N21	0.1590	1.1/16	3.1/4	0.159
R89C0N20	–	N20	0.1610	1.1/16	3.1/4	0.161
R88C011/64	11/64	–	0.1719	1.1/16	3.1/4	0.172
R89C0N16	–	N16	0.1770	1.1/8	3.3/8	0.177

Product	DC (inch)	DC (Wire gauge size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R89C0N13	–	N13	0.1850	1.1/8	3.1/2	0.185
R88C03/16	3/16	–	0.1875	1.1/8	3.1/2	0.188
R89C0N12	–	N12	0.1890	1.1/8	3.1/2	0.189
R89C0N11	–	N11	0.1910	1.3/16	3.1/2	0.191
R89C0N10	–	N10	0.1935	1.3/16	3.5/8	0.194
R89C0N9	–	N9	0.1960	1.3/16	3.5/8	0.196
R89C0N8	–	N8	0.1990	1.3/16	3.5/8	0.199
R89C0N7	–	N7	0.2010	1.3/16	3.5/8	0.201
R88C013/64	13/64	–	0.2031	1.3/16	3.5/8	0.203
R89C0N6	–	N6	0.2040	1.1/4	3.3/4	0.204
R89C0N5	–	N5	0.2055	1.1/4	3.3/4	0.205
R89C0N3	–	N3	0.2130	1.1/4	3.3/4	0.213
R88C07/32	7/32	–	0.2188	1.1/4	3.3/4	0.219
R88C015/64	15/64	–	0.2344	1.5/16	3.7/8	0.234
R88C01/4	1/4	–	0.2500	1.3/8	4″	0.250
R88C017/64	17/64	–	0.2656	1.7/16	4.1/8	0.266
R88C09/32	9/32	–	0.2813	1.1/2	4.1/4	0.281
R88C019/64	19/64	–	0.2969	1.9/16	4.3/8	0.297
R88C05/16	5/16	–	0.3125	1.5/8	4.1/2	0.313
R88C021/64	21/64	–	0.3281	1.11/16	4.5/8	0.328
R88C011/32	11/32	–	0.3438	1.11/16	4.3/4	0.344
R88C023/64	23/64	–	0.3594	1.3/4	4.7/8	0.359
R88C03/8	3/8	–	0.3750	1.13/16	5″	0.375
R88C025/64	25/64	–	0.3906	1.7/8	5.1/8	0.391
R88C013/32	13/32	–	0.4063	1.15/16	5.1/4	0.406
R88C027/64	27/64	–	0.4219	2″	5.3/8	0.422
R88C07/16	7/16	–	0.4375	2.1/16	5.1/2	0.438
R88C029/64	29/64	–	0.4531	2.1/8	5.5/8	0.453
R88C015/32	15/32	–	0.4688	2.1/8	5.3/4	0.469
R88C031/64	31/64	–	0.4844	2.3/16	5.7/8	0.484
R88C01/2	1/2	–	0.5000	2.1/4	6″	0.500

R10CO/R15CO/R18CO

PRECISION

NAS 907 J 型 HSS-E (8%) 钴重型标准长度钻头
高质量钻头，可钻出尺寸精确、光洁度更好的孔。低推力 135° 自定心分瓣钻尖，穿孔更容易。青铜回火表面处理有助于防止工件材料粘在钻头切削刃上。按照 NAS 907 J 型航空航天标准制造。



HSS-E	NAS 907	4×D
135°	Bronze	
λ20-35°	R	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪36 H	◪40 H	◪41 H	◪31 H	◪27 G	■24 E	■25 F	■20 F	■17 E	■15 F	■13 E	■10 D	◪30 E	◪26 E
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1
■27 E	■22 E	■18 C	■13 G	■11 G	■10 C	■15 C	◪35 H	■26 D	■19 D	◪27 E	◪22 E	■18 E	◪24 E
K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1
◪18 E	■15 E	◪22 E	◪17 E	■12 E	■11 E	■9 E	◪25 E	◪19 E	■15 E	◪33 J	◪25 J	◪17 I	◪46 H
N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2
◪42 H	◪30 H	◪68 H	◪40 F	◪20 H	■28 F	■20 D	■11 C	■9 E	◪8 B	■7 E	◪6 B	■5 E	◪5 B

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R18CON80 1)	–	N80	–	0.0135	1/8	3/4	0.013
R18CON79 1)	–	N79	–	0.0145	1/8	3/4	0.015
R10CO1/64 1)	1/64	–	–	0.0156	3/16	3/4	0.016
R18CON78 1)	–	N78	–	0.0160	3/16	7/8	0.016
R18CON77 1)	–	N77	–	0.0180	3/16	7/8	0.018
R18CON76 1)	–	N76	–	0.0200	3/16	7/8	0.020
R18CON75 1)	–	N75	–	0.0210	1/4	1″	0.021
R18CON74 1)	–	N74	–	0.0225	1/4	1″	0.022
R18CON73 1)	–	N73	–	0.0240	5/16	1.1/8	0.024
R18CON72 1)	–	N72	–	0.0250	5/16	1.1/8	0.025
R18CON71 1)	–	N71	–	0.0260	3/8	1.1/4	0.026
R18CON70 1)	–	N70	–	0.0280	3/8	1.1/4	0.028
R18CON69 1)	–	N69	–	0.0292	1/2	1.3/8	0.029
R18CON68 1)	–	N68	–	0.0310	1/2	1.3/8	0.031
R10CO1/32 1)	1/32	–	–	0.0313	1/2	1.3/8	0.031
R18CON67 1)	–	N67	–	0.0320	1/2	1.3/8	0.032
R18CON66 1)	–	N66	–	0.0330	1/2	1.3/8	0.033
R18CON65 1)	–	N65	–	0.0350	5/8	1.1/2	0.035
R18CON64 1)	–	N64	–	0.0360	5/8	1.1/2	0.036
R18CON63 1)	–	N63	–	0.0370	5/8	1.1/2	0.037
R18CON62 1)	–	N62	–	0.0380	5/8	1.1/2	0.038
R18CON61 1)	–	N61	–	0.0390	11/16	1.5/8	0.039
R18CON60	–	N60	–	0.0400	11/16	1.5/8	0.040
R18CON59	–	N59	–	0.0410	11/16	1.5/8	0.041
R18CON58	–	N58	–	0.0420	11/16	1.5/8	0.042
R18CON57	–	N57	–	0.0430	3/4	1.3/4	0.043

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R18CON56	–	N56	–	0.0465	3/4	1.3/4	0.046
R10CO3/64	3/64	–	–	0.0469	3/4	1.3/4	0.047
R18CON55	–	N55	–	0.0520	7/8	1.7/8	0.052
R18CON54	–	N54	–	0.0550	7/8	1.7/8	0.055
R18CON53	–	N53	–	0.0595	7/8	1.7/8	0.059
R10CO1/16	1/16	–	–	0.0625	7/8	1.7/8	0.063
R18CON52	–	N52	–	0.0635	7/8	1.7/8	0.064
R18CON51	–	N51	–	0.0670	1″	2″	0.067
R18CON50	–	N50	–	0.0700	1″	2″	0.070
R18CON49	–	N49	–	0.0730	1″	2″	0.073
R18CON48	–	N48	–	0.0760	1″	2″	0.076
R10CO5/64	5/64	–	–	0.0781	1″	2″	0.078
R18CON47	–	N47	–	0.0785	1″	2″	0.079
R18CON46	–	N46	–	0.0810	1.1/8	2.1/8	0.081
R18CON45	–	N45	–	0.0820	1.1/8	2.1/8	0.082
R18CON44	–	N44	–	0.0860	1.1/8	2.1/8	0.086
R18CON43	–	N43	–	0.0890	1.1/4	2.1/4	0.089
R18CON42	–	N42	–	0.0935	1.1/4	2.1/4	0.093
R10CO3/32	3/32	–	–	0.0938	1.1/4	2.1/4	0.094
R18CON41	–	N41	–	0.0960	1.3/8	2.3/8	0.096
R18CON40	–	N40	–	0.0980	1.3/8	2.3/8	0.098
R18CON39	–	N39	–	0.0995	1.3/8	2.3/8	0.100
R18CON38	–	N38	–	0.1015	1.7/16	2.1/2	0.102
R18CON37	–	N37	–	0.1040	1.7/16	2.1/2	0.104
R18CON36	–	N36	–	0.1065	1.7/16	2.1/2	0.106
R10CO7/64	7/64	–	–	0.1094	1.1/2	2.5/8	0.109

Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R18C0N35	–	N35	–	0.1100	1.1/2	2.5/8	0.110
R18C0N34	–	N34	–	0.1110	1.1/2	2.5/8	0.111
R18C0N33	–	N33	–	0.1130	1.1/2	2.5/8	0.113
R18C0N32	–	N32	–	0.1160	1.5/8	2.3/4	0.116
R18C0N31	–	N31	–	0.1200	1.5/8	2.3/4	0.120
R10C01/8	1/8	–	–	0.1250	1.5/8	2.3/4	0.125
R18C0N30	–	N30	–	0.1285	1.5/8	2.3/4	0.129
R18C0N29	–	N29	–	0.1360	1.3/4	2.7/8	0.136
R18C0N28	–	N28	–	0.1405	1.3/4	2.7/8	0.141
R10C09/64	9/64	–	–	0.1406	1.3/4	2.7/8	0.141
R18C0N27	–	N27	–	0.1440	1.7/8	3″	0.144
R18C0N26	–	N26	–	0.1470	1.7/8	3″	0.147
R18C0N25	–	N25	–	0.1495	1.7/8	3″	0.149
R18C0N24	–	N24	–	0.1520	2″	3.1/8	0.152
R18C0N23	–	N23	–	0.1540	2″	3.1/8	0.154
R10C05/32	5/32	–	–	0.1563	2″	3.1/8	0.156
R18C0N22	–	N22	–	0.1570	2″	3.1/8	0.157
R18C0N21	–	N21	–	0.1590	2.1/8	3.1/4	0.159
R18C0N20	–	N20	–	0.1610	2.1/8	3.1/4	0.161
R18C0N19	–	N19	–	0.1660	2.1/8	3.1/4	0.166
R18C0N18	–	N18	–	0.1695	2.1/8	3.1/4	0.170
R10C011/64	11/64	–	–	0.1719	2.1/8	3.1/4	0.172
R18C0N17	–	N17	–	0.1730	2.3/16	3.3/8	0.173
R18C0N16	–	N16	–	0.1770	2.3/16	3.3/8	0.177
R18C0N15	–	N15	–	0.1800	2.3/16	3.3/8	0.180
R18C0N14	–	N14	–	0.1820	2.3/16	3.3/8	0.182
R18C0N13	–	N13	–	0.1850	2.5/16	3.1/2	0.185
R10C03/16	3/16	–	–	0.1875	2.5/16	3.1/2	0.188
R18C0N12	–	N12	–	0.1890	2.5/16	3.1/2	0.189
R18C0N11	–	N11	–	0.1910	2.5/16	3.1/2	0.191
R18C0N10	–	N10	–	0.1935	2.7/16	3.5/8	0.194
R18C0N9	–	N9	–	0.1960	2.7/16	3.5/8	0.196
R18C0N8	–	N8	–	0.1990	2.7/16	3.5/8	0.199
R18C0N7	–	N7	–	0.2010	2.7/16	3.5/8	0.201
R10C013/64	13/64	–	–	0.2031	2.7/16	3.5/8	0.203
R18C0N6	–	N6	–	0.2040	2.1/2	3.3/4	0.204
R18C0N5	–	N5	–	0.2055	2.1/2	3.3/4	0.205
R18C0N4	–	N4	–	0.2090	2.1/2	3.3/4	0.209
R18C0N3	–	N3	–	0.2130	2.1/2	3.3/4	0.213
R10C07/32	7/32	–	–	0.2188	2.1/2	3.3/4	0.219
R18C0N2	–	N2	–	0.2210	2.5/8	3.7/8	0.221
R18C0N1	–	N1	–	0.2280	2.5/8	3.7/8	0.228
R15C0A	–	–	A	0.2340	2.5/8	3.7/8	0.234
R10C015/64	15/64	–	–	0.2344	2.5/8	3.7/8	0.234
R15C0B	–	–	B	0.2380	2.3/4	4″	0.238
R15C0C	–	–	C	0.2420	2.3/4	4″	0.242
R15C0D	–	–	D	0.2460	2.3/4	4″	0.246
R10C01/4	1/4	–	–	0.2500	2.3/4	4″	0.250
R15C0F	–	–	F	0.2570	2.7/8	4.1/8	0.257

[1] 无分离式钻尖

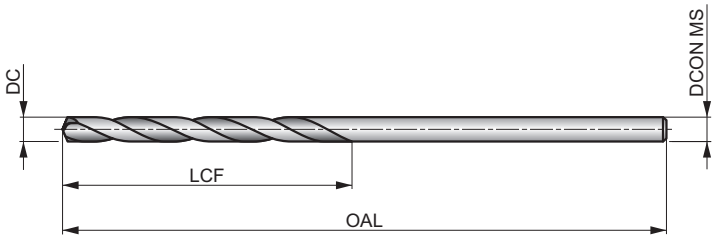
Product	DC (inch)	DC (Wire gauge size)	DC (Letter size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
R15C0G	–	–	G	0.2610	2.7/8	4.1/8	0.261
R10C017/64	17/64	–	–	0.2656	2.7/8	4.1/8	0.266
R15C0H	–	–	H	0.2660	2.7/8	4.1/8	0.266
R15C0I	–	–	I	0.2720	2.7/8	4.1/8	0.272
R15C0J	–	–	J	0.2770	2.7/8	4.1/8	0.277
R15C0K	–	–	K	0.2810	2.15/16	4.1/4	0.281
R10C09/32	9/32	–	–	0.2813	2.15/16	4.1/4	0.281
R15C0L	–	–	L	0.2900	2.15/16	4.1/4	0.290
R15C0M	–	–	M	0.2950	3.1/16	4.3/8	0.295
R10C019/64	19/64	–	–	0.2969	3.1/16	4.3/8	0.297
R15C0N	–	–	N	0.3020	3.1/16	4.3/8	0.302
R10C05/16	5/16	–	–	0.3125	3.3/16	4.1/2	0.313
R15C0O	–	–	O	0.3160	3.3/16	4.1/2	0.316
R15C0P	–	–	P	0.3230	3.5/16	4.5/8	0.323
R10C021/64	21/64	–	–	0.3281	3.5/16	4.5/8	0.328
R15C0Q	–	–	Q	0.3320	3.7/16	4.3/4	0.332
R15C0R	–	–	R	0.3390	3.7/16	4.3/4	0.339
R10C011/32	11/32	–	–	0.3438	3.7/16	4.3/4	0.344
R15C0S	–	–	S	0.3480	3.1/2	4.7/8	0.348
R15C0T	–	–	T	0.3580	3.1/2	4.7/8	0.358
R10C023/64	23/64	–	–	0.3594	3.1/2	4.7/8	0.359
R15C0U	–	–	U	0.3680	3.5/8	5″	0.368
R10C03/8	3/8	–	–	0.3750	3.5/8	5″	0.375
R15C0V	–	–	V	0.3770	3.5/8	5″	0.377
R15C0W	–	–	W	0.3860	3.3/4	5.1/8	0.386
R10C025/64	25/64	–	–	0.3906	3.3/4	5.1/8	0.391
R15C0X	–	–	X	0.3970	3.3/4	5.1/8	0.397
R15C0Y	–	–	Y	0.4040	3.7/8	5.1/4	0.404
R10C013/32	13/32	–	–	0.4063	3.7/8	5.1/4	0.406
R15C0Z	–	–	Z	0.4130	3.7/8	5.1/4	0.413
R10C027/64	27/64	–	–	0.4219	3.15/16	5.3/8	0.422
R10C07/16	7/16	–	–	0.4375	4.1/16	5.1/2	0.438
R10C029/64	29/64	–	–	0.4531	4.3/16	5.5/8	0.453
R10C015/32	15/32	–	–	0.4688	4.5/16	5.3/4	0.469
R10C031/64	31/64	–	–	0.4844	4.3/8	5.7/8	0.484
R10C01/2	1/2	–	–	0.5000	4.1/2	6″	0.500
R10C033/64	33/64	–	–	0.5156	4.13/16	6.5/8	0.516
R10C017/32	17/32	–	–	0.5313	4.13/16	6.5/8	0.531
R10C035/64	35/64	–	–	0.5469	4.13/16	6.5/8	0.547
R10C09/16	9/16	–	–	0.5625	4.13/16	6.5/8	0.563
R10C037/64	37/64	–	–	0.5781	4.13/16	6.5/8	0.578
R10C019/32	19/32	–	–	0.5938	5.3/16	7.1/8	0.594
R10C039/64	39/64	–	–	0.6094	5.3/16	7.1/8	0.609
R10C05/8	5/8	–	–	0.6250	5.3/16	7.1/8	0.625
R10C041/64	41/64	–	–	0.6406	5.3/16	7.1/8	0.641
R10C021/32	21/32	–	–	0.6563	5.3/16	7.1/8	0.656
R10C043/64	43/64	–	–	0.6719	5.5/8	7.5/8	0.672
R10C011/16	11/16	–	–	0.6875	5.5/8	7.5/8	0.688

CO500-6/CO501-6

PRECISION

NAS 907 B 型 HSS-E 航空航天专用加长钻，6 英寸 OAL
长系列钻头按照国家航空航天标准制造，全长较长，刃长较短，非常适合在难以触及的区域钻孔。钻材料、135° 刀尖和青铜回火表面处理提高了钻削大多数材料时的刀具寿命。

HSS-E	NAS 907	4×D
135°	Bronze	
λ20-35°	R	



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪36 G	◪40 G	◪41 G	◪31 G	◪27 E	■24 D	■25 E	■20 E	■17 D	■15 E	■13 D	■10 B	◪30 H	◪26 H
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
■27 H	■22 H	◪18 D	■13 F	■11 F	■10 D	■15 D	◪13 D	◪35 H	■26 H	■19 H	◪27 F	◪22 F	■18 D
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
◪24 F	◪18 F	■15 D	◪22 F	◪17 F	■12 D	■11 D	■9 D	◪25 F	◪19 F	■15 D	◪32 I	◪24 I	◪16 H
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.3	S2.1	S2.2	S3.1	S3.2
◪42 G	◪37 G	◪27 G	◪54 G	◪32 H	◪16 E	◪35 I	◪26 G	◪12 E	■6 D	■8 B	◪7 B	■6 B	◪5 B
S4.1	S4.2												
■5 B	◪4 B												

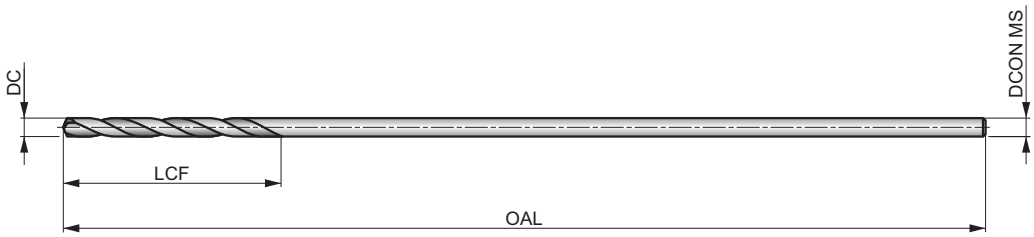
Product	DC (inch)	DC (Wire gauge size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
CO500-61/16	1/16	–	0.0625	7/8	6″	0.063
CO501-6N52	–	N52	0.0635	7/8	6″	0.064
CO501-6N51	–	N51	0.0670	1″	6″	0.067
CO501-6N50	–	N50	0.0700	1″	6″	0.070
CO501-6N49	–	N49	0.0730	1″	6″	0.073
CO501-6N48	–	N48	0.0760	1″	6″	0.076
CO500-65/64	5/64	–	0.0781	1″	6″	0.078
CO501-6N47	–	N47	0.0785	1″	6″	0.079
CO501-6N46	–	N46	0.0810	1.1/8	6″	0.081
CO501-6N45	–	N45	0.0820	1.1/8	6″	0.082
CO501-6N44	–	N44	0.0860	1.1/8	6″	0.086
CO501-6N43	–	N43	0.0890	1.1/4	6″	0.089
CO501-6N42	–	N42	0.0935	1.1/4	6″	0.093
CO500-63/32	3/32	–	0.0938	1.1/4	6″	0.094
CO501-6N41	–	N41	0.0960	1.3/8	6″	0.096
CO501-6N40	–	N40	0.0980	1.3/8	6″	0.098
CO501-6N39	–	N39	0.0995	1.3/8	6″	0.100
CO501-6N38	–	N38	0.1015	1.7/16	6″	0.102
CO501-6N37	–	N37	0.1040	1.7/16	6″	0.104
CO501-6N36	–	N36	0.1065	1.7/16	6″	0.106
CO500-67/64	7/64	–	0.1094	1.1/2	6″	0.109
CO501-6N35	–	N35	0.1100	1.1/2	6″	0.110
CO501-6N34	–	N34	0.1110	1.1/2	6″	0.111
CO501-6N33	–	N33	0.1130	1.1/2	6″	0.113
CO501-6N32	–	N32	0.1160	1.5/8	6″	0.116
CO501-6N31	–	N31	0.1200	1.5/8	6″	0.120
CO500-61/8	1/8	–	0.1250	1.5/8	6″	0.125
CO501-6N30	–	N30	0.1285	1.5/8	6″	0.129
CO501-6N29	–	N29	0.1360	1.3/4	6″	0.136
CO501-6N28	–	N28	0.1405	1.3/4	6″	0.141
CO500-69/64	9/64	–	0.1406	1.3/4	6″	0.141
CO501-6N27	–	N27	0.1440	1.7/8	6″	0.144
CO501-6N26	–	N26	0.1470	1.7/8	6″	0.147

Product	DC (inch)	DC (Wire gauge size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
CO501-6N25	–	N25	0.1495	1.7/8	6″	0.149
CO501-6N24	–	N24	0.1520	2″	6″	0.152
CO501-6N23	–	N23	0.1540	2″	6″	0.154
CO500-65/32	5/32	–	0.1563	2″	6″	0.156
CO501-6N22	–	N22	0.1570	2″	6″	0.157
CO501-6N21	–	N21	0.1590	2.1/8	6″	0.159
CO501-6N20	–	N20	0.1610	2.1/8	6″	0.161
CO501-6N19	–	N19	0.1660	2.1/8	6″	0.166
CO501-6N18	–	N18	0.1695	2.1/8	6″	0.170
CO500-611/64	11/64	–	0.1719	2.1/8	6″	0.172
CO501-6N17	–	N17	0.1730	2.3/16	6″	0.173
CO501-6N16	–	N16	0.1770	2.3/16	6″	0.177
CO501-6N15	–	N15	0.1800	2.3/16	6″	0.180
CO501-6N14	–	N14	0.1820	2.3/16	6″	0.182
CO501-6N13	–	N13	0.1850	2.5/16	6″	0.185
CO500-63/16	3/16	–	0.1875	2.5/16	6″	0.188
CO501-6N12	–	N12	0.1890	2.5/16	6″	0.189
CO501-6N11	–	N11	0.1910	2.5/16	6″	0.191
CO501-6N10	–	N10	0.1935	2.7/16	6″	0.194
CO501-6N9	–	N9	0.1960	2.7/16	6″	0.196
CO501-6N8	–	N8	0.1990	2.7/16	6″	0.199
CO501-6N7	–	N7	0.2010	2.7/16	6″	0.201
CO500-613/64	13/64	–	0.2031	2.7/16	6″	0.203
CO501-6N6	–	N6	0.2040	2.1/2	6″	0.204
CO501-6N5	–	N5	0.2055	2.1/2	6″	0.205
CO501-6N4	–	N4	0.2090	2.1/2	6″	0.209
CO501-6N3	–	N3	0.2130	2.1/2	6″	0.213
CO500-67/32	7/32	–	0.2188	2.1/2	6″	0.219
CO501-6N2	–	N2	0.2210	2.5/8	6″	0.221
CO501-6N1	–	N1	0.2280	2.5/8	6″	0.228
CO500-615/64	15/64	–	0.2344	2.5/8	6″	0.234
CO500-61/4	1/4	–	0.2500	2.3/4	6″	0.250

CO500-12/CO501-12

PRECISION

NAS 907 B 型 HSS-E 航空航天专用加长钻，12 英寸 OAL
超长系列钻头按照国家航空航天标准制造，全长超长，刃长较短，非常适合在难以触及的区域钻孔。钻材料、135° 刀尖和青铜回火表面处理提高了钻削大多数材料时的刀具寿命。



HSS-E	NAS 907	4×D
135°	Bronze	
λ20-35°	R	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪36 G	◪40 G	◪41 G	◪31 G	◪27 E	■24 D	■25 E	■20 E	■17 D	■15 E	■13 D	■10 B	◪30 H	◪26 H
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
■27 H	■22 H	◪18 D	■13 F	■11 F	■10 D	■15 D	◪13 D	◪35 H	■26 H	■19 H	◪27 F	◪22 F	■18 D
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
◪24 F	◪18 F	■15 D	◪22 F	◪17 F	■12 D	■11 D	■9 D	◪25 F	◪19 F	■15 D	◪32 I	◪24 I	◪16 H
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.3	S2.1	S2.2	S3.1	S3.2
◪42 G	◪37 G	◪27 G	◪54 G	◪32 H	◪16 E	◪35 I	◪26 G	◪12 E	■6 D	■8 B	◪7 B	■6 B	◪5 B
S4.1	S4.2												
■5 B	◪4 B												

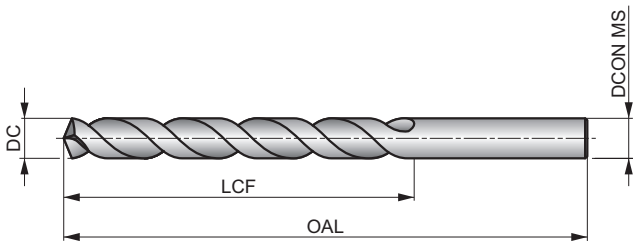
Product	DC (inch)	DC (Wire gauge size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
CO500-121/16	1/16	–	0.0625	7/8	12″	0.063
CO500-125/64	5/64	–	0.0781	1″	12″	0.078
CO500-123/32	3/32	–	0.0938	1.1/4	12″	0.094
CO501-12N40	–	N40	0.0980	1.3/8	12″	0.098
CO500-127/64	7/64	–	0.1094	1.1/2	12″	0.109
CO500-121/8	1/8	–	0.1250	1.5/8	12″	0.125
CO501-12N30	–	N30	0.1285	1.5/8	12″	0.129
CO501-12N29	–	N29	0.1360	1.3/4	12″	0.136
CO500-129/64	9/64	–	0.1406	1.3/4	12″	0.141
CO500-125/32	5/32	–	0.1563	2″	12″	0.156
CO501-12N21	–	N21	0.1590	2.1/8	12″	0.159

Product	DC (inch)	DC (Wire gauge size)	DC (inch)	LCF (inch)	OAL (inch)	DCON MS (inch)
CO501-12N20	–	N20	0.1610	2.1/8	12″	0.161
CO500-1211/64	11/64	–	0.1719	2.1/8	12″	0.172
CO501-12N16	–	N16	0.1770	2.3/16	12″	0.177
CO500-123/16	3/16	–	0.1875	2.5/16	12″	0.188
CO501-12N11	–	N11	0.1910	2.5/16	12″	0.191
CO501-12N10	–	N10	0.1935	2.7/16	12″	0.194
CO500-1213/64	13/64	–	0.2031	2.7/16	12″	0.203
CO500-127/32	7/32	–	0.2188	2.1/2	12″	0.219
CO501-12N2	–	N2	0.2210	2.5/8	12″	0.221
CO500-1215/64	15/64	–	0.2344	2.5/8	12″	0.234
CO500-121/4	1/4	–	0.2500	2.3/4	12″	0.250

2ACO

PRECISION

NAS 907 J 型 HSS-E 重载标准长度钻头，青铜回火表面处理，公制尺寸
性能卓越，打出的孔尺寸精确，光洁度更高。低切削力 135° 自定心钻尖，穿孔更容易。青铜回火表面处理有助于防止工件材料粘在钻头切削刃上。按照 NAS 907 J 型航空航天标准制造。



HSS-E	DIN 338	4×D
135°	Bronze	
λ20-35°	R	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪36 H	◪40 H	◪41 H	◪31 H	◪27 G	■24 E	■25 F	■20 F	■17 E	■15 F	■13 E	■10 D	◪30 E	◪26 E
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1
■27 E	■22 E	■18 C	■13 G	■11 G	■10 C	■15 C	◪35 H	■26 D	■19 D	◪27 E	◪22 E	■18 E	◪24 E
K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1
◪18 E	■15 E	◪22 E	◪17 E	■12 E	■11 E	■9 E	◪25 E	◪19 E	■15 E	◪33 J	◪25 J	◪17 I	◪46 H
N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2
◪42 H	◪30 H	◪68 H	◪40 F	◪20 H	■28 F	■20 D	■11 C	■9 E	◪8 B	■7 E	◪6 B	■5 E	◪5 B

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
2ACO1.0	1.00	0.0394	12.0	34.0	1.00
2ACO1.05	1.05	0.0413	12.0	34.0	1.05
2ACO1.1	1.10	0.0433	14.0	36.0	1.10
2ACO1.15	1.15	0.0453	14.0	36.0	1.15
2ACO1.2	1.20	0.0472	16.0	38.0	1.20
2ACO1.25	1.25	0.0492	16.0	38.0	1.25
2ACO1.3	1.30	0.0512	16.0	38.0	1.30
2ACO1.35	1.35	0.0531	18.0	40.0	1.35
2ACO1.4	1.40	0.0551	18.0	40.0	1.40
2ACO1.45	1.45	0.0571	18.0	40.0	1.45
2ACO1.5	1.50	0.0591	18.0	40.0	1.50
2ACO1.55	1.55	0.0610	20.0	43.0	1.55
2ACO1.6	1.60	0.0630	20.0	43.0	1.60
2ACO1.65	1.65	0.0650	20.0	43.0	1.65
2ACO1.7	1.70	0.0669	20.0	43.0	1.70
2ACO1.75	1.75	0.0689	22.0	46.0	1.75
2ACO1.8	1.80	0.0709	22.0	46.0	1.80
2ACO1.85	1.85	0.0728	22.0	46.0	1.85
2ACO1.9	1.90	0.0748	22.0	46.0	1.90
2ACO1.95	1.95	0.0768	24.0	49.0	1.95
2ACO2.0	2.00	0.0787	24.0	49.0	2.00
2ACO2.05	2.05	0.0807	24.0	49.0	2.05
2ACO2.1	2.10	0.0827	24.0	49.0	2.10
2ACO2.2	2.20	0.0866	27.0	53.0	2.20
2ACO2.3	2.30	0.0906	27.0	53.0	2.30
2ACO2.35	2.35	0.0925	27.0	53.0	2.35

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
2ACO2.4	2.40	0.0945	30.0	57.0	2.40
2ACO2.5	2.50	0.0984	30.0	57.0	2.50
2ACO2.6	2.60	0.1024	30.0	57.0	2.60
2ACO2.7	2.70	0.1063	33.0	61.0	2.70
2ACO2.8	2.80	0.1102	33.0	61.0	2.80
2ACO2.9	2.90	0.1142	33.0	61.0	2.90
2ACO3.0	3.00	0.1181	33.0	61.0	3.00
2ACO3.1	3.10	0.1220	36.0	65.0	3.10
2ACO3.2	3.20	0.1260	36.0	65.0	3.20
2ACO3.25	3.25	0.1280	36.0	65.0	3.25
2ACO3.3	3.30	0.1299	36.0	65.0	3.30
2ACO3.4	3.40	0.1339	39.0	70.0	3.40
2ACO3.5	3.50	0.1378	39.0	70.0	3.50
2ACO3.6	3.60	0.1417	39.0	70.0	3.60
2ACO3.7	3.70	0.1457	39.0	70.0	3.70
2ACO3.75	3.75	0.1476	39.0	70.0	3.75
2ACO3.8	3.80	0.1496	43.0	75.0	3.80
2ACO4.0	4.00	0.1575	43.0	75.0	4.00
2ACO4.1	4.10	0.1614	43.0	75.0	4.10
2ACO4.2	4.20	0.1654	43.0	75.0	4.20
2ACO4.25	4.25	0.1673	43.0	75.0	4.25
2ACO4.3	4.30	0.1693	47.0	80.0	4.30
2ACO4.4	4.40	0.1732	47.0	80.0	4.40
2ACO4.5	4.50	0.1772	47.0	80.0	4.50
2ACO4.7	4.70	0.1850	47.0	80.0	4.70
2ACO4.8	4.80	0.1890	52.0	86.0	4.80

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
2AC05.0	5.00	0.1969	52.0	86.0	5.00
2AC05.1	5.10	0.2008	52.0	86.0	5.10
2AC05.2	5.20	0.2047	52.0	86.0	5.20
2AC05.25	5.25	0.2067	52.0	86.0	5.25
2AC05.3	5.30	0.2087	52.0	86.0	5.30
2AC05.5	5.50	0.2165	57.0	93.0	5.50
2AC05.6	5.60	0.2205	57.0	93.0	5.60
2AC05.7	5.70	0.2244	57.0	93.0	5.70
2AC05.9	5.90	0.2323	57.0	93.0	5.90
2AC06.0	6.00	0.2362	57.0	93.0	6.00
2AC06.1	6.10	0.2402	63.0	101.0	6.10
2AC06.2	6.20	0.2441	63.0	101.0	6.20
2AC06.3	6.30	0.2480	63.0	101.0	6.30
2AC06.4	6.40	0.2520	63.0	101.0	6.40
2AC06.5	6.50	0.2559	63.0	101.0	6.50
2AC06.6	6.60	0.2598	63.0	101.0	6.60
2AC06.7	6.70	0.2638	63.0	101.0	6.70
2AC06.8	6.80	0.2677	69.0	109.0	6.80
2AC06.9	6.90	0.2717	69.0	109.0	6.90
2AC07.0	7.00	0.2756	69.0	109.0	7.00
2AC07.1	7.10	0.2795	69.0	109.0	7.10
2AC07.2	7.20	0.2835	69.0	109.0	7.20
2AC07.25	7.25	0.2854	69.0	109.0	7.25
2AC07.3	7.30	0.2874	69.0	109.0	7.30
2AC07.5	7.50	0.2953	69.0	109.0	7.50
2AC07.8	7.80	0.3071	75.0	117.0	7.80
2AC07.9	7.90	0.3110	75.0	117.0	7.90

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
2AC08.0	8.00	0.3150	75.0	117.0	8.00
2AC08.2	8.20	0.3228	75.0	117.0	8.20
2AC08.4	8.40	0.3307	75.0	117.0	8.40
2AC08.5	8.50	0.3346	75.0	117.0	8.50
2AC08.8	8.80	0.3465	81.0	125.0	8.80
2AC08.9	8.90	0.3504	81.0	125.0	8.90
2AC09.0	9.00	0.3543	81.0	125.0	9.00
2AC09.1	9.10	0.3583	81.0	125.0	9.10
2AC09.2	9.20	0.3622	81.0	125.0	9.20
2AC09.3	9.30	0.3661	81.0	125.0	9.30
2AC09.4	9.40	0.3701	81.0	125.0	9.40
2AC09.5	9.50	0.3740	81.0	125.0	9.50
2AC09.6	9.60	0.3780	87.0	133.0	9.60
2AC09.7	9.70	0.3819	87.0	133.0	9.70
2AC09.8	9.80	0.3858	87.0	133.0	9.80
2AC010.0	10.00	0.3937	87.0	133.0	10.00
2AC010.2	10.20	0.4016	87.0	133.0	10.20
2AC010.5	10.50	0.4134	87.0	133.0	10.50
2AC010.8	10.80	0.4252	94.0	142.0	10.80
2AC011.0	11.00	0.4331	94.0	142.0	11.00
2AC011.2	11.20	0.4409	94.0	142.0	11.20
2AC011.5	11.50	0.4528	94.0	142.0	11.50
2AC011.8	11.80	0.4646	94.0	142.0	11.80
2AC012.0	12.00	0.4724	101.0	151.0	12.00
2AC012.2	12.20	0.4803	101.0	151.0	12.20
2AC012.5	12.50	0.4921	101.0	151.0	12.50
2AC013.0	13.00	0.5118	101.0	151.0	13.00

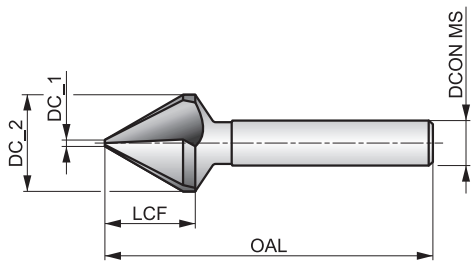
材料代码(BMC)		HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS-E	HSS	
涂层		Bright	Bright	Bright	Bright	Bright	Bright	Bright	Bright	TiAlN	Bright	Bright	
基本标准组(BSG)		DIN 334C	DIN 335C	DORMER	DIN 335A	ANSI	DIN 335C	DIN 335C	DIN 335C	DIN 335C	DORMER	DORMER	
旋向(切削方向)		R	R	R	R	R	R	R	R	R	R	R	
柄部													
应用角度		60°	82°	90°	90°		90°	90°	90°	90°	90°	90°	90°
产品系列代码		G135	G154	G129	G132	B690	G142	G136	G106	G506	G107	G600	G236
PSF切削直径范围		6.30 - 25.00	6.30 - 25.00	6.00 - 31.50	8.00 - 20.00	1/4 - 1"	5.00 - 31.00	4.30 - 31.00	6.30 - 50.00	6.30 - 50.00	6.30 - 20.50	6.30 - 25.00	Set
		60	61	62	63	64	65	66	67	68	69	70	71
P	P1	■	■	■		■	■	■	■	■	■	■	
	P2	■	■	■	◪	■	■	■	■	■	■	■	
	P3	◪	■	◪	◪	■	■	■	■	■	■	■	
	P4	◪	◪		■		◪	◪	◪	■	■	◪	
M	M1	◪	◪	◪		◪	■	◪	◪	◪	◪	◪	
	M2	◪	◪	◪		◪	◪	◪	◪	◪	◪	◪	
	M3				◪		◪						
	M4				◪		◪						
K	K1	◪	◪	◪	■	◪		◪	■	■	◪	◪	
	K2	◪	◪	◪	◪	◪		◪	◪	■	◪	◪	
	K3	◪	◪	◪	◪	◪		◪	◪	■	◪	◪	
	K4				◪					◪	◪		
	K5	◪	◪		◪			◪	◪	■	◪	◪	
N	N1	◪	◪	■	◪	■	■	◪	◪	◪	◪	◪	
	N2	■	◪	◪	■	◪	◪	◪	◪	■	◪	◪	
	N3	■	■	■	◪	■	■	■	■	■	■	◪	
	N4	◪	◪	◪	◪	◪	■	◪	◪	◪	◪		
	N5												
S	S1												
	S2												
	S3												
	S4												
H	H1												
	H2												
	H3												
	H4												

■推荐使用　◪可以使用

G135

DORMER

60°高速钢直柄锪钻，表面光亮处理。
用于特殊紧固件孔口倒角和去除毛刺的60°锪钻，最大直径25，可用于手持式工具或机床，适用于多种材料的切削。



HSS | Bright | DIN 334C
R | 60°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280Y开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■ 23 E	■ 26 E	■ 27 E	■ 20 E	■ 18 D	◪ 16 B	■ 16 D	◪ 13 D	◪ 11 B	■ 10 D	◪ 8 B	◪ 8 C	◪ 6 C	◪ 7 C
M2.2	**K1.1**	**K1.2**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K5.1**	**K5.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪ 6 C	◪ 20 F	◪ 15 D	◪ 21 C	◪ 17 C	◪ 18 C	◪ 14 C	◪ 19 C	◪ 15 C	◪ 40 G	■ 30 G	◪ 20 F	■ 20 F	◪ 18 F
N3.1	**N3.2**	**N3.3**	**N4.1**	**N4.2**									
■ 21 F	■ 12 F	◪ 6 D	◪ 40 G	◪ 35 G									

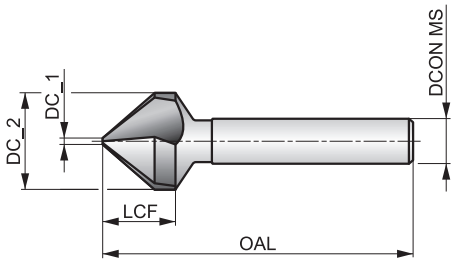
DCON MS公差h9

Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	DCON MS (mm)	NOF
G1356.3	6.30	1.60	6.8	45.0	5.00	3
G1358.0	8.00	2.00	8.5	50.0	6.00	3
G13510.0	10.00	2.50	7.6	50.0	6.00	3
G13512.5	12.50	3.20	11.7	56.0	8.00	3
G13516.0	16.00	4.00	14.5	63.0	10.00	3
G13520.0	20.00	5.00	17.5	67.0	10.00	3
G13525.0	25.00	6.30	20.5	71.0	10.00	3

G154

DORMER

82°高速钢直柄锪钻，表面光亮处理。
一种平头螺钉和孔口倒角的多功能工具82°锪钻，可用于手持式工具或机床，适用于多种材料的切削。



HSS	Bright	DIN 335C
R		82°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■ 23 E	■ 26 E	■ 27 E	■ 20 E	■ 18 D	◪ 16 B	■ 16 D	■ 13 D	◪ 11 B	■ 10 D	◪ 8 B	◪ 8 C	◪ 6 C	◪ 7 C
M2.2	**K1.1**	**K1.2**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K5.1**	**K5.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪ 6 C	◪ 20 F	◪ 15 D	◪ 21 C	◪ 17 C	◪ 18 C	◪ 14 C	◪ 14 C	◪ 10 C	◪ 40 G	■ 30 G	◪ 20 F	■ 20 F	◪ 18 F
N3.1	**N3.2**	**N3.3**	**N4.1**	**N4.2**									
■ 21 F	■ 12 F	◪ 6 D	◪ 40 G	◪ 35 G									

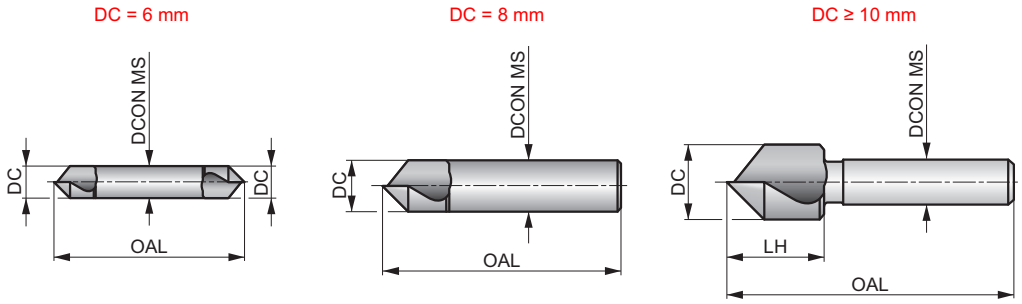
DCON MS公差h9

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G1546.3	6.30	1.50	5.5	45.0	5.00	3
G1548.3	8.30	2.00	6.5	50.0	6.00	3
G15410.4	10.40	2.50	7.6	50.0	6.00	3
G15412.4	12.40	2.80	8.5	56.0	8.00	3
G15416.5	16.50	3.20	10.5	60.0	10.00	3
G15420.5	20.50	3.50	13.0	63.0	10.00	3
G15425.0	25.00	3.80	15.5	67.0	10.00	3

G129

DORMER

90°高速钢单刃直柄锪钻，表面光亮处理。
孔口倒角和去除毛刺的90°锪钻，表面光亮处理，单刃的设计能够提供平稳的倒角加工并减少啸叫和振动，适用于低碳钢和中等强度有色金属材料（如铝合金）。



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	M1.1	M1.2	M2.1	K1.1	K1.2	K2.1
■21 D	■24 D	■25 D	■18 D	■16 C	◪14 A	■13 B	◪11 B	◪8 B	◪6 B	◪7 B	◪18 D	◪13 C	◪19 A

K2.2	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2	N3.1	N3.2	N3.3	N4.1	N4.2
◪15 A	◪16 A	◪12 A	■34 D	■25 D	◪16 C	◪16 C	◪14 C	■17 C	■9 C	◪5 B	◪35 D	◪30 D

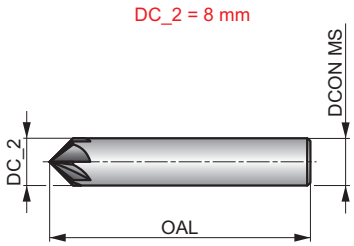
DCON MS公差h9

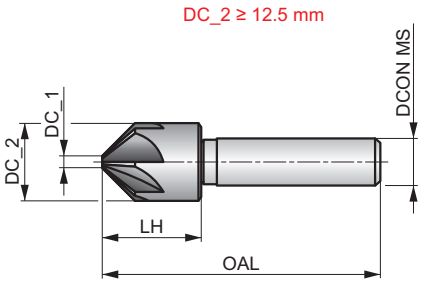
Product	DC (mm)	LH (mm)	OAL (mm)	DCON MS (mm)	NOF
G1296.0	6.00	–	45.0	6.00	1
G1298.0	8.00	–	50.0	8.00	1
G12910.0	10.00	17.0	49.0	8.00	1
G12912.5	12.50	17.0	49.0	8.00	1
G12916.0	16.00	20.0	56.0	10.00	1
G12920.0	20.00	24.0	60.0	10.00	1
G12925.0	25.00	25.0	75.0	12.00	1
G12931.5	31.50	29.0	80.0	12.00	1

G132

DORMER

90°高速钢多刃直柄锪钻，表面光亮处理。
标准紧固件孔口倒角和去除毛刺的90°锪钻，多刃的设计能够提供平稳的倒角加工并减少啸叫和振动，可用于手持式工具或机床，适用于多种材料的切削。





HSS	Bright	DIN 335A
R		90°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P2.2	P2.3	P3.2	P3.3	P4.1	P4.2	P4.3	M3.3	M4.1	K1.1	K1.2	K1.3	K2.2	K2.3
◪ 18 E	■ 16 D	◪ 13 D	■ 11 B	◪ 10 D	■ 8 C	■ 7 B	◪ 3 A	◪ 4 A	◪ 20 F	■ 15 D	■ 11 D	◪ 17 C	■ 14 D

K3.1	K3.2	K3.3	K4.1	K4.2	K5.1	K5.2	K5.3	N1.3	N2.3	N3.2	N4.3
■ 18 E	◪ 14 E	◪ 11 D	◪ 17 C	◪ 13 C	◪ 19	◪ 15	■ 11 D	◪ 20 F	■ 13 F	◪ 12 F	◪ 5 G

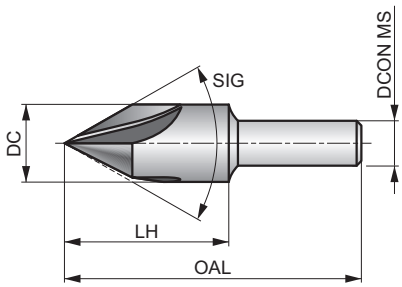
DCON MS公差h9

Product	DC_2 (mm)	DC_1 (mm)	LH (mm)	OAL (mm)	DCON MS (mm)	NOF
G1328.0	8.00	–	–	48.0	8.00	5
G13212.5	12.50	2.00	15.5	48.0	8.00	5
G13216.0	16.00	3.20	19.5	56.0	10.00	7
G13220.0	20.00	5.00	23.0	60.0	10.00	7

B690

DORMER

高速钢直柄中心孔铰刀，60°、82°、90° 或 100° 沉孔角度
主要用于铰中心钻孔、轴的车床中心以及螺钉头和铆钉的沉孔角。可提供 60°、82°、90° 或 100° 沉孔角。凹槽数量不均匀，在提高精度的同时，还能消除颤动，从而促进精确加工。



HSS | Bright | ANSI
R | | 60-100°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	M1.1	M1.2	M2.1	K1.1	K1.2	K2.1
■21 D	■24 D	■25 D	■18 D	■16 C	◪14 A	■13 B	◪11 B	◪8 B	◪6 B	◪7 B	◪18 D	◪13 C	◪19 A

K2.2	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2	N3.1	N3.2	N3.3	N4.1	N4.2
◪15 A	◪16 A	◪12 A	■34 D	■25 D	■16 C	◪16 C	◪14 C	■17 C	■9 C	◪5 B	◪35 D	◪30 D

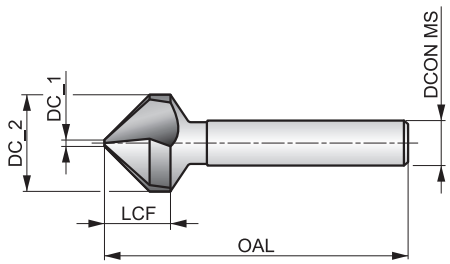
Product	DC (inch)	DC (inch)	SIG (°)	DCON MS (inch)	OAL (inch)	NOF
B6901/4X60	1/4	0.2500	60	3/16	1.1/2	3
B6901/4X82	1/4	0.2500	82	3/16	1.1/2	3
B6901/4X90	1/4	0.2500	90	3/16	1.1/2	3
B6901/4X100	1/4	0.2500	100	3/16	1.1/2	3
B6903/8X60	3/8	0.3750	60	1/4	1.3/4	3
B6903/8X82	3/8	0.3750	82	1/4	1.3/4	3
B6903/8X90	3/8	0.3750	90	1/4	1.3/4	3
B6903/8X100	3/8	0.3750	100	1/4	1.3/4	3
B6901/2X60	1/2	0.5000	60	3/8	2″	3
B6901/2X82	1/2	0.5000	82	3/8	2″	3
B6901/2X90	1/2	0.5000	90	3/8	2″	3
B6901/2X100	1/2	0.5000	100	3/8	2″	3

Product	DC (inch)	DC (inch)	SIG (°)	DCON MS (inch)	OAL (inch)	NOF
B6905/8X60	5/8	0.6250	60	3/8	2.1/4	3
B6905/8X82	5/8	0.6250	82	3/8	2.1/4	3
B6905/8X90	5/8	0.6250	90	3/8	2.1/4	3
B6905/8X100	5/8	0.6250	100	3/8	2.1/4	3
B6903/4X60	3/4	0.7500	60	1/2	2.5/8	3
B6903/4X82	3/4	0.7500	82	1/2	2.5/8	3
B6903/4X90	3/4	0.7500	90	1/2	2.5/8	3
B6903/4X100	3/4	0.7500	100	1/2	2.5/8	3
B6901X60	1″	1.0000	60	1/2	3″	3
B6901X82	1″	1.0000	82	1/2	3″	3
B6901X90	1″	1.0000	90	1/2	3″	3
B6901X100	1″	1.0000	100	1/2	3″	3

G142

DORMER

不锈钢专用90°高速钢直柄锪钻，表面光亮处理。
标准紧固件孔口倒角和去除毛刺的90°锪钻，增加后角使得刃口更锋利，从而提高加工粘性材料（如不锈钢和有色金属）的性能，可用于手持式工具或机床。



HSS	Bright	DIN 335C
R		90°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■23 E	■26 E	■27 E	■20 E	■18 D	◪16 B	■16 D	■13 D	◪11 B	■10 D	◪8 B	■11 C	■9 C	■10 C
M2.2	**M3.1**	**M3.2**	**M4.1**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**
◪8 C	■7 B	◪6 B	◪4 A	■40 G	■30 G	◪20 F	◪20 F	◪18 F	◪20 F	■34 F	■20 F	■10 D	■40 G
N4.2													
■35 G													

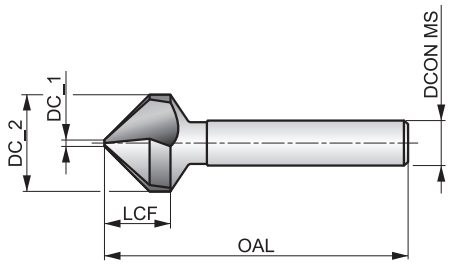
DCON MS公差h9

Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	DCON MS (mm)	NOF
G1425.0	5.00	1.50	4.5	40.0	4.00	3
G1426.3	6.30	1.50	5.5	45.0	5.00	3
G1428.0	8.00	2.00	6.1	50.0	6.00	3
G1428.3	8.30	2.00	6.5	50.0	6.00	3
G14210.0	10.00	2.50	7.6	50.0	6.00	3
G14210.4	10.40	2.50	7.6	50.0	6.00	3
G14212.4	12.40	2.80	8.5	56.0	8.00	3
G14215.0	15.00	3.20	9.5	60.0	10.00	3
G14216.5	16.50	3.20	10.5	60.0	10.00	3
G14220.5	20.50	3.50	13.0	63.0	10.00	3
G14223.0	23.00	3.80	13.7	67.0	10.00	3
G14225.0	25.00	3.80	15.5	67.0	10.00	3
G14231.0	31.00	4.20	18.5	71.0	12.00	3

G136

DORMER

90°高速钢直柄锪钻，表面光亮处理。
孔口倒角和去除毛刺的90°锪钻，缩柄的设计使得大直径的锪钻也能够安装在标准卡盘或刀柄中，可用于手持式工具或机床，AlTiN涂层能够提高性能并延长刀具寿命，适用于多种材料的切削。



HSS | Bright | DIN 335C

R | | 90°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■23 E	■26 E	■27 E	■20 E	■18 D	◪16 B	■16 D	■13 D	◪11 B	■10 D	◪8 B	◪8 C	◪6 C	◪7 C
M2.2	**K1.1**	**K1.2**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K5.1**	**K5.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪6 C	◪20 F	◪15 D	◪21 C	◪17 C	◪18 C	◪14 C	◪19 C	◪15 C	◪40 G	■30 G	◪20 F	■20 F	◪18 F
N3.1	**N3.2**	**N3.3**	**N4.1**	**N4.2**									
■21 F	■12 F	◪6 D	◪40 G	◪35 G									

DCON MS公差h9
该系列产品有套装提供。请参见G236。

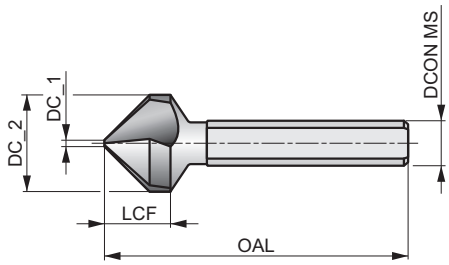
Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	DCON MS (mm)	NOF
G1364.3	4.30	1.30	4.0	40.0	4.00	3
G1365.0	5.00	1.50	4.5	40.0	4.00	3
G1365.3	5.30	1.50	4.5	40.0	4.00	3
G1365.8	5.80	1.50	5.0	45.0	5.00	3
G1366.0	6.00	1.50	5.0	45.0	5.00	3
G1366.3	6.30	1.50	5.5	45.0	5.00	3
G1367.0	7.00	1.80	5.5	50.0	6.00	3
G1367.3	7.30	1.80	6.1	50.0	6.00	3
G1368.0	8.00	2.00	6.1	50.0	6.00	3
G1368.3	8.30	2.00	6.5	50.0	6.00	3
G1369.4	9.40	2.20	7.2	50.0	6.00	3
G13610.0	10.00	2.50	7.6	50.0	6.00	3
G13610.4	10.40	2.50	7.6	50.0	6.00	3

Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	DCON MS (mm)	NOF
G13611.5	11.50	2.80	8.0	56.0	8.00	3
G13612.4	12.40	2.80	8.5	56.0	8.00	3
G13613.4	13.40	2.90	9.0	56.0	8.00	3
G13615.0	15.00	3.20	9.5	60.0	10.00	3
G13616.5	16.50	3.20	10.5	60.0	10.00	3
G13619.0	19.00	3.50	11.7	63.0	10.00	3
G13620.5	20.50	3.50	13.0	63.0	10.00	3
G13623.0	23.00	3.80	13.7	67.0	10.00	3
G13625.0	25.00	3.80	15.5	67.0	10.00	3
G13626.0	26.00	3.80	15.5	67.0	10.00	3
G13628.0	28.00	4.00	16.5	71.0	12.00	3
G13630.0	30.00	4.20	18.5	71.0	12.00	3
G13631.0	31.00	4.20	18.5	71.0	12.00	3

G106

DORMER

90°高速钢削平直柄锪钻，表面光亮处理。
标准紧固件孔口倒角和去除毛刺的90°锪钻，柄部的三个磨平面改善了三爪卡盘的夹持，适用于多种材料的切削。



HSS	Bright	DIN 335C
R		90°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

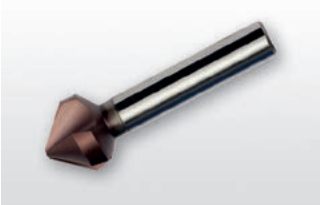
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■ 23 E	■ 26 E	■ 27 E	■ 20 E	■ 18 D	◪ 16 B	■ 16 D	■ 13 D	◪ 11 B	■ 10 D	◪ 8 B	◪ 8 C	◪ 6 C	◪ 7 C
M2.2	**K1.1**	**K1.2**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K5.1**	**K5.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪ 6 C	■ 20 F	■ 15 D	◪ 21 C	◪ 17 C	◪ 18 C	◪ 14 C	◪ 19 C	◪ 15 C	◪ 40 G	■ 30 G	◪ 20 F	◪ 20 F	◪ 18 F
N3.1	**N3.2**	**N3.3**	**N4.1**	**N4.2**									
■ 21 F	◪ 12 F	◪ 6 D	◪ 40 G	◪ 35 G									

DCON MS公差h9
该系列产品有套装提供。请参见G236。

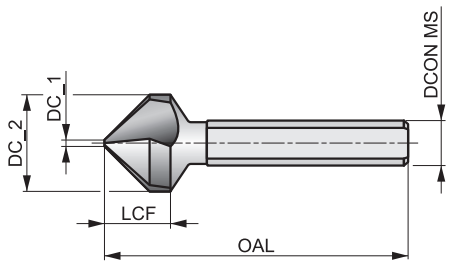
Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	DCON MS (mm)	NOF
G1066.3	6.30	1.50	5.6	45.0	5.00	3
G1068.3	8.30	2.00	6.9	50.0	6.00	3
G10610.4	10.40	2.50	7.8	50.0	6.00	3
G10612.4	12.40	2.80	8.6	56.0	8.00	3
G10616.5	16.50	3.20	11.1	60.0	10.00	3
G10620.5	20.50	3.50	12.9	63.0	10.00	3
G10625.0	25.00	3.80	15.7	67.0	10.00	3
G10631.0	31.00	4.20	18.5	71.0	12.00	3
G10634.0	34.00	4.50	19.0	103.0	16.00	3
G10637.0	37.00	4.50	21.2	118.0	16.00	3
G10640.0	40.00	4.50	20.0	118.0	16.00	3
G10650.0	50.00	5.00	23.6	126.0	16.00	3

G506

DORMER



90°高速钢削平直柄锪钻，氮铝化钛涂层。
标准紧固件孔口倒角和去除毛刺的90°锪钻，柄部的三个磨平面改善了三爪卡盘的夹持，尤其是使用手持式工具时，AlTiN涂层能够延长刀具寿命，适用于多种材料的切削。



HSS | TiAIN | DIN 335C
R | | 90°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■40 E	■45 E	■46 E	■34 E	■30 D	■27 B	■28 D	■22 D	■19 B	■16 D	■14 B	◪11 B	◪11 C	◪9 C
M2.1	**M2.2**	**M2.3**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K4.1**	**K4.2**
◪10 C	◪9 C	◪8 B	■41 F	■30 D	◪23 D	■42 C	■34 C	◪27 C	■37 C	■28 C	◪23 C	◪34 C	◪26 C
K4.3	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**
◪19 C	■39 C	■29 C	◪23 C	◪60 G	◪45 G	■30 F	■30 F	■27 F	■19 F	■32 F	■18 F	◪9 D	◪62 G
N4.2													
◪55 G													

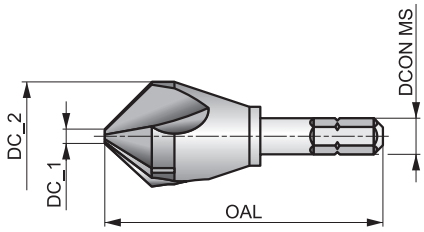
DCON MS公差h9
该系列产品有套装提供。请参见G236。

Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	DCON MS (mm)	NOF
G5066.3	6.30	1.50	5.6	45.0	5.00	3
G5068.3	8.30	2.00	6.9	50.0	6.00	3
G50610.4	10.40	2.50	7.8	50.0	6.00	3
G50612.4	12.40	2.80	8.6	56.0	8.00	3
G50616.5	16.50	3.20	11.1	60.0	10.00	3
G50620.5	20.50	3.50	12.9	63.0	10.00	3
G50625.0	25.00	3.80	15.7	67.0	10.00	3
G50631.0	31.00	4.20	18.5	71.0	12.00	3
G50637.0	37.00	4.50	21.2	118.0	16.00	3
G50640.0	40.00	4.50	20.0	118.0	16.00	3
G50650.0	50.00	5.00	23.6	126.0	16.00	3

G107

DORMER

90°六角驱动锪钻，表面光亮处理。
一个多功能的90°锪钻，六角柄结构能够更方便地安装在电动夹头中，为标准紧固件提供倒角并清除钻孔产生的毛刺，适用于多种材料的切削。



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■ 23 E	■ 26 E	■ 27 E	■ 20 E	■ 18 D	◪ 16 B	■ 16 D	■ 13 D	◪ 11 B	■ 10 D	◪ 8 B	◪ 11 C	◪ 9 C	◪ 10 C
M2.2	**M2.3**	**K1.1**	**K1.2**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K4.1**	**K5.1**	**K5.2**	**N1.1**	**N1.2**	**N1.3**
◪ 9 C	◪ 8 B	■ 20 F	◪ 15 D	■ 21 C	◪ 17 C	■ 18 C	◪ 14 C	◪ 15 C	■ 19 C	◪ 15 C	◪ 40 G	■ 30 G	◪ 20 F
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**						
◪ 20 F	◪ 18 F	◪ 20 F	■ 21 F	◪ 12 F	◪ 6 D	◪ 40 G	◪ 35 G						

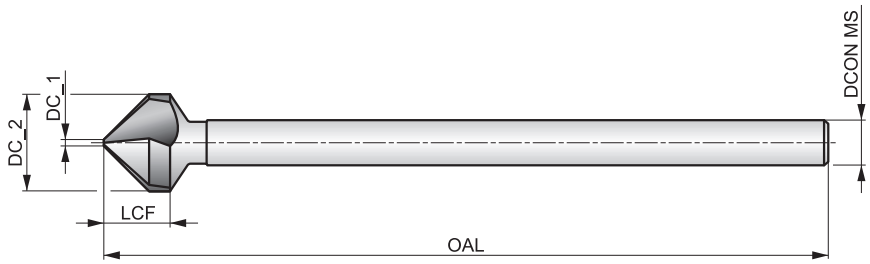
6.35; 1/4’’ 六角柄; DIN 74.

Product	DC_2	DC_1	OAL	DCON MS	CZC MS	NOF
	(mm)	(mm)	(mm)	(inch)		
G1076.3	6.30	1.50	50.0	1/4″	M2-M3	3
G10710.4	10.40	2.50	50.0	1/4″	M5	3
G10712.4	12.40	2.80	50.0	1/4″	M6	3
G10716.5	16.50	3.20	50.0	1/4″	M8	3
G10720.5	20.50	3.50	50.0	1/4″	M10	3

G600

DORMER

90°高速钢长悬伸直柄锪钻，表面光亮处理。
标准紧固件孔口倒角和去除毛刺的90°锪钻，延长的柄部使得锪钻能够在难以到达的区域倒角，适用于多种材料的切削。



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■ 20 E	■ 22 E	■ 23 E	■ 17 E	■ 15 D	◪ 13 B	■ 12 D	■ 9 D	◪ 8 B	■ 7 D	◪ 6 B	◪ 8 C	◪ 6 C	◪ 7 C
M2.2	**K1.1**	**K1.2**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K5.1**	**K5.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪ 6 C	■ 17 E	◪ 12 C	◪ 18 B	◪ 14 B	◪ 15 B	◪ 11 B	◪ 16 B	◪ 12 B	◪ 35 G	◪ 25 G	◪ 15 F	◪ 15 F	◪ 13 F
N3.1	**N3.2**	**N3.3**											
■ 16 E	◪ 10 E	◪ 5 C											

DCON MS公差h9

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G6006.3	6.30	1.30	5.6	154.0	5.00	3
G6008.3	8.30	1.80	6.9	155.0	6.00	3
G60010.4	10.40	2.20	7.8	157.0	6.00	3
G60012.4	12.40	2.50	8.6	158.0	8.00	3
G60015.0	15.00	2.80	10.3	159.0	10.00	3
G60016.5	16.50	2.80	11.1	161.0	10.00	3
G60020.5	20.50	3.00	12.9	164.0	10.00	3
G60025.0	25.00	3.20	15.7	168.0	10.00	3

G236

DORMER

塑料圆筒锪钻套装
包含了不同尺寸的90°锪钻的套装，一共有5种规格的套装可选，G106或GG136或G560，适用于多种材料的切削。

A=套件中的型号, B=套件中的数量, C=套件中的直径

Product	Nr.	A	B	C
G2361	1	G136	6	6.30 mm, 8.30 mm, 10.40 mm, 12.40 mm, 16.50 mm, 20.50 mm
G2362	2	G136	4	6.30 mm, 10.40 mm, 16.50 mm, 20.50 mm
G2363	3	G560	6	6.30 mm, 8.30 mm, 10.40 mm, 12.40 mm, 16.50 mm, 20.50 mm
G2364	4	G106	6	6.30 mm, 8.30 mm, 10.40 mm, 12.40 mm, 16.50 mm, 20.50 mm
G2365	5	G506	6	6.30 mm, 8.30 mm, 10.40 mm, 12.40 mm, 16.50 mm, 20.50 mm

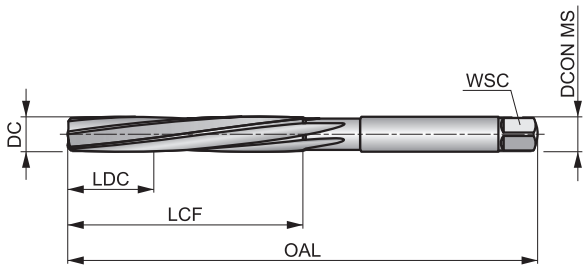
材料代码(BMC)	HSS	HSS	HSS	HSS	HSS	HSS-E	HSS	HSS	HSS	HSS	HSS	HSS	HSS
涂层	Bright ST	Bright	Bright	Bright	Bright ST	Bright	Bright ST	Bright	Bright	Bright	Bright	Bright	ST Bronze
基本标准组(BSG)	DIN 206	ANSI	ANSI	ANSI	BS 328	DIN 2179	DIN 9	DIN 9	ANSI	ANSI	ANSI	ANSI	ANSI
旋向(切削方向)	R	R	R	R	R	R	R	R	R	R	R	R	R
柄部													
铰刀形式	B				A		A	B					
可达到的孔公差 (TCHA)	H7												
锥度-毫米(锥度比率) - 公制					1:48	1:50	1:50	1:50	1:48	1:48	1:48		
产品系列代码	B100	B610	B620	B650	B301	B953	B903	B952	B630	B660	B670	B680	B122
PSF切削直径范围	1.50 - 40.00	N60 - 1.1/2	1/16 - 1"	1/8 - 1"	3/32 - 1/2	2.00 - 12.00	1.50 - 20.00	1.20 - 40.00	7/0 - N10	N0 - N10	N0 - N10	1/8 - 1"	3/8 - 1"
	74	76	78	79	80	81	82	83	84	85	86	87	88
P P1	■	■	■	■	■	■	■	■	■	■	■	■	■
P2	■	■	■	■	■	■	■	■	■	■	■	■	■
P3	◪	■	■	■	■	◪	■	■	■	■	■	■	◪
P4	◪	■	■	◪	◪	◪	◪	◪	■	◪	◪	◪	
M M1	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪
M2	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪	◪
M3													
M4													
K K1	■	■	■	■	■	■	◪	◪	■	■	■	■	
K2	◪	■	■	■	■	■	■	■	■	■	■	■	
K3	■	◪	◪	■	◪	◪	◪	◪	■	■	■	■	
K4													
K5													
N N1	■	◪	■	■	■	◪	■	■	■	■	■	■	◪
N2	■	◪	■	■	■	■	■	■	■	■	■	■	◪
N3	■	■	■	■	■	◪	■	■	■	■	■	■	■
N4	◪	◪		◪	◪	◪	◪	◪	◪	◪	◪	◪	◪
N5													
S S1													
S2													
S3													
S4													
H H1													
H2													
H3													
H4													

■推荐使用 ◪可以使用

B100

DORMER

手用高速钢直柄铰刀，孔径精度H7，表面光亮并蒸汽回火处理。
精密的磨制刀具，主要用于手工铰孔，左手螺旋并右手切削，能够平稳地铰孔，并改善孔径尺寸和表面光洁度，适用于多种材料的切削。



HSS	Bright ST	DIN 206
R		B
H7		

工件材料组的适用性。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	◪	■	◪	◪	◪	◪	◪	◪	◪
M2.1	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪	■	■	◪	■	■	◪	■	◪	◪	■	■	■	■
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**								
◪	■	■	◪	◪	◪								

DCON MS公差e9

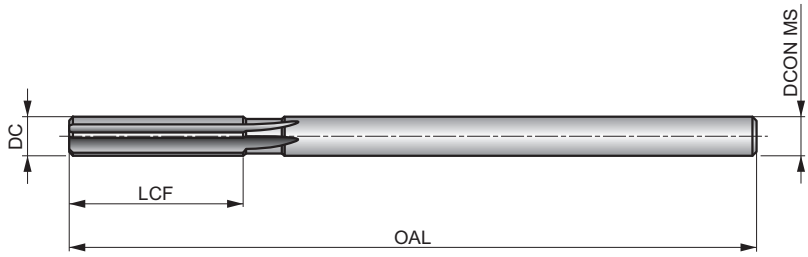
Product	DC (inch)	DC (mm)	OAL (mm)	LCF (mm)	LDC (mm)	NOF	WSC (mm)	DCON MS (mm)
B1001.5	–	1.50	41.0	20.0	5.00	3	1.12	1.50
B1002.0	–	2.00	50.0	25.0	6.00	4	1.60	2.00
B1003/32	3/32	2.38	54.0	27.0	7.00	4	1.80	2.38
B1002.5	–	2.50	58.0	29.0	7.00	4	2.10	2.50
B1003.0	–	3.00	62.0	31.0	8.00	6	2.40	3.00
B1001/8	1/8	3.18	66.0	33.0	8.00	6	2.40	3.18
B1003.2	–	3.20	66.0	33.0	8.00	6	2.40	3.20
B1003.5	–	3.50	71.0	35.0	9.00	6	2.70	3.50
B1005/32	5/32	3.97	76.0	38.0	10.00	6	3.00	3.97
B1004.0	–	4.00	76.0	38.0	10.00	6	3.00	4.00
B1004.5	–	4.50	81.0	41.0	10.00	6	3.40	4.50
B1003/16	3/16	4.76	87.0	44.0	11.00	6	3.80	4.76
B1005.0	–	5.00	87.0	44.0	11.00	6	3.80	5.00
B1005.5	–	5.50	93.0	47.0	12.00	6	4.30	5.50
B1007/32	7/32	5.56	93.0	47.0	12.00	6	4.30	5.56
B1006.0	–	6.00	93.0	47.0	12.00	6	4.90	6.00
B1001/4	1/4	6.35	100.0	50.0	13.00	6	4.90	6.35
B1006.5	–	6.50	100.0	50.0	13.00	6	4.90	6.50
B10017/64	17/64	6.75	107.0	54.0	14.00	6	5.50	6.75
B1007.0	–	7.00	107.0	54.0	14.00	6	5.50	7.00
B1009/32	9/32	7.14	107.0	54.0	14.00	6	6.20	7.14
B1007.5	–	7.50	107.0	54.0	14.00	6	6.20	7.50
B1005/16	5/16	7.94	115.0	58.0	15.00	6	6.20	7.94
B1008.0	–	8.00	115.0	58.0	15.00	6	6.20	8.00
B10021/64	21/64	8.33	115.0	58.0	15.00	6	7.00	8.33
B1008.5	–	8.50	115.0	58.0	15.00	6	7.00	8.50
B10011/32	11/32	8.73	124.0	62.0	16.00	6	7.00	8.73

Product	DC	DC	OAL	LCF	LDC	NOF	WSC	DCON MS
	(inch)	(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
B1009.0	–	9.00	124.0	62.0	16.00	6	7.00	9.00
B1009.5	–	9.50	124.0	62.0	16.00	6	8.00	9.50
B1003/8	3/8	9.52	124.0	62.0	17.00	6	8.00	9.52
B10010.0	–	10.00	133.0	66.0	17.00	6	8.00	10.00
B10013/32	13/32	10.32	133.0	66.0	17.00	6	8.00	10.32
B10010.5	–	10.50	133.0	66.0	17.00	6	8.00	10.50
B10011.0	–	11.00	142.0	71.0	18.00	6	9.00	11.00
B1007/16	7/16	11.11	142.0	71.0	18.00	6	9.00	11.11
B10011.5	–	11.50	142.0	71.0	18.00	6	9.00	11.50
B10012.0	–	12.00	152.0	76.0	19.00	6	9.00	12.00
B10012.5	–	12.50	152.0	76.0	19.00	6	10.00	12.50
B1001/2	1/2	12.70	152.0	76.0	19.00	6	10.00	12.70
B10013.0	–	13.00	152.0	76.0	19.00	6	10.00	13.00
B10013.5	–	13.50	163.0	81.0	20.00	8	11.00	13.50
B10014.0	–	14.00	163.0	81.0	20.00	8	11.00	14.00
B1009/16	9/16	14.29	163.0	81.0	20.00	8	11.00	14.29
B10014.5	–	14.50	163.0	81.0	20.00	8	11.00	14.50
B10015.0	–	15.00	163.0	81.0	20.00	8	12.00	15.00
B1005/8	5/8	15.88	175.0	87.0	22.00	8	12.00	15.88
B10016.0	–	16.00	175.0	87.0	22.00	8	12.00	16.00
B10017.0	–	17.00	175.0	87.0	22.00	8	13.00	17.00
B10018.0	–	18.00	188.0	93.0	23.00	8	14.50	18.00
B10019.0	–	19.00	188.0	93.0	23.00	8	14.50	19.00
B1003/4	3/4	19.05	188.0	93.0	25.00	8	14.50	19.05
B10020.0	–	20.00	201.0	100.0	25.00	8	16.00	20.00
B10021.0	–	21.00	201.0	100.0	25.00	8	16.00	21.00
B10022.0	–	22.00	215.0	107.0	27.00	8	18.00	22.00
B1007/8	7/8	22.22	215.0	107.0	27.00	8	18.00	22.22
B10023.0	–	23.00	215.0	107.0	27.00	8	18.00	23.00
B10024.0	–	24.00	231.0	115.0	29.00	8	18.00	24.00
B10025.0	–	25.00	231.0	115.0	29.00	8	20.00	25.00
B1001	1″	25.40	231.0	115.0	29.00	8	20.00	25.40
B10026.0	–	26.00	231.0	115.0	29.00	8	20.00	26.00
B10028.0	–	28.00	247.0	124.0	31.00	10	22.00	28.00
B10030.0	–	30.00	247.0	124.0	31.00	10	24.00	30.00
B10032.0	–	32.00	265.0	133.0	33.00	10	24.00	32.00
B10035.0	–	35.00	284.0	142.0	36.00	10	29.00	35.00
B10040.0	–	40.00	305.0	152.0	38.00	10	32.00	40.00

B610

DORMER

高速钢直柄直槽铰刀，光亮处理
多功能通用机用铰刀比手动铰刀的槽更短、更深，设计用于对大多数材料进行高效的机器铰削。可提供的尺寸范围很广，包括英制、线规、字母以及根据 ANSI B94.2-1983 (R1988) 生产的增量十进制尺寸。



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工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
19 C	22 C	23 C	16 C	14 C	12 B	11 B	9 B	7 A	5 B	4 A		9 C	8 B
M2.1	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
7 B	14 E	10 D	7 D	14 C	11 C	9 C	12 C	9 C	22 F	16 F	9 F	25 E	22 E
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**									
14 E	45 D	26 E	12 D	28 B									

Product	DC (inch)	DC (Wire gauge size)	DC (inch)	DCON MS (inch)	LCF (inch)	OAL (inch)	NOF
B610N60	–	N60	0.0400	0.039	1/2	2.1/2	4
B610N59	–	N59	0.0410	0.039	1/2	2.1/2	4
B610N58	–	N58	0.0420	0.039	1/2	2.1/2	4
B610N57	–	N57	0.0430	0.039	1/2	2.1/2	4
B610N56	–	N56	0.0465	0.045	1/2	2.1/2	4
B6103/64	3/64	–	0.0469	0.045	1/2	2.1/2	4
B610N55	–	N55	0.0520	0.051	1/2	2.1/2	4
B610N54	–	N54	0.0550	0.051	1/2	2.1/2	4
B610N53	–	N53	0.0595	0.059	1/2	2.1/2	4
B6101/16	1/16	–	0.0625	0.059	1/2	2.1/2	4
B610N52	–	N52	0.0635	0.059	1/2	2.1/2	4
B610N51	–	N51	0.0670	0.066	3/4	3″	4
B610N50	–	N50	0.0700	0.066	3/4	3″	4
B610N49	–	N49	0.0730	0.066	3/4	3″	4
B610N48	–	N48	0.0760	0.072	3/4	3″	4
B6105/64	5/64	–	0.0781	0.072	3/4	3″	4
B610N47	–	N47	0.0785	0.072	3/4	3″	4
B610N46	–	N46	0.0810	0.077	3/4	3″	4
B610N45	–	N45	0.0820	0.077	3/4	3″	4
B610N44	–	N44	0.0860	0.081	3/4	3″	4
B610N43	–	N43	0.0890	0.081	3/4	3″	4
B610N42	–	N42	0.0935	0.088	3/4	3″	4
B6103/32	3/32	–	0.0938	0.088	3/4	3″	4
B610N41	–	N41	0.0960	0.093	7/8	3.1/2	4
B610N40	–	N40	0.0980	0.093	7/8	3.1/2	4
B610N39	–	N39	0.0995	0.093	7/8	3.1/2	4
B610N38	–	N38	0.1015	0.095	7/8	3.1/2	4
B610N37	–	N37	0.1040	0.095	7/8	3.1/2	4

Product	DC (inch)	DC (Wire gauge size)	DC (inch)	DCON MS (inch)	LCF (inch)	OAL (inch)	NOF
B610N36	–	N36	0.1065	0.103	7/8	3.1/2	4
B6107/64	7/64	–	0.1094	0.103	7/8	3.1/2	4
B610N35	–	N35	0.1100	0.103	7/8	3.1/2	4
B610N34	–	N34	0.1110	0.105	7/8	3.1/2	4
B610N33	–	N33	0.1130	0.105	7/8	3.1/2	4
B610N32	–	N32	0.1160	0.112	7/8	3.1/2	4
B610N31	–	N31	0.1200	0.112	7/8	3.1/2	4
B610.1230	–	–	0.1230	0.112	7/8	3.1/2	4
B610.1240	–	–	0.1240	0.119	7/8	3.1/2	4
B610.1247	–	–	0.1247	0.119	7/8	3.1/2	4
B6101/8	1/8	–	0.1250	0.119	7/8	3.1/2	4
B610.1260	–	–	0.1260	0.119	7/8	3.1/2	4
B610N30	–	N30	0.1285	0.119	7/8	3.1/2	4
B610N29	–	N29	0.1360	0.128	1″	4″	4
B610N28	–	N28	0.1400	0.135	1″	4″	4
B6109/64	9/64	–	0.1410	0.135	1″	4″	4
B610N27	–	N27	0.1440	0.135	1″	4″	4
B610N26	–	N26	0.1470	0.143	1″	4″	4
B610N25	–	N25	0.1495	0.143	1″	4″	4
B610N24	–	N24	0.1520	0.146	1″	4″	4
B610N23	–	N23	0.1540	0.146	1″	4″	4
B6105/32	5/32	–	0.1562	0.151	1″	4″	6
B610N22	–	N22	0.1570	0.151	1″	4″	6
B610N21	–	N21	0.1590	0.153	1.1/8	4.1/2	6
B610N20	–	N20	0.1610	0.153	1.1/8	4.1/2	6
B610N19	–	N19	0.1660	0.160	1.1/8	4.1/2	6
B610N18	–	N18	0.1695	0.160	1.1/8	4.1/2	6
B61011/64	11/64	–	0.1719	0.165	1.1/8	4.1/2	6

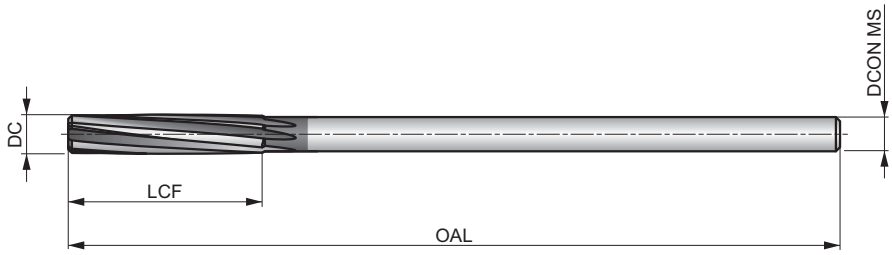
Product	DC (inch)	DC (Wire gauge size)	DC (inch)	DCON MS (inch)	LCF (inch)	OAL (inch)	NOF
B610N17	–	N17	0.1730	0.165	1.1/8	4.1/2	6
B610N16	–	N16	0.1770	0.170	1.1/8	4.1/2	6
B610N15	–	N15	0.1800	0.175	1.1/8	4.1/2	6
B610N14	–	N14	0.1820	0.175	1.1/8	4.1/2	6
B610N13	–	N13	0.1850	0.180	1.1/8	4.1/2	6
B610.1855	–	–	0.1855	0.180	1.1/8	4.1/2	6
B610.1865	–	–	0.1865	0.180	1.1/8	4.1/2	6
B610.1870	–	–	0.1870	0.180	1.1/8	4.1/2	6
B6103/16	3/16	–	0.1875	0.180	1.1/8	4.1/2	6
B610.1885	–	–	0.1885	0.180	1.1/8	4.1/2	6
B610N12	–	N12	0.1890	0.180	1.1/8	4.1/2	6
B610N11	–	N11	0.1910	0.186	1.1/4	5″	6
B610N10	–	N10	0.1935	0.186	1.1/4	5″	6
B610N9	–	N9	0.1960	0.190	1.1/4	5″	6
B610N8	–	N8	0.1990	0.190	1.1/4	5″	6
B610N7	–	N7	0.2010	0.195	1.1/4	5″	6
B61013/64	13/64	–	0.2031	0.195	1.1/4	5″	6
B610N6	–	N6	0.2040	0.195	1.1/4	5″	6
B610N5	–	N5	0.2055	0.202	1.1/4	5″	6
B610N4	–	N4	0.2090	0.202	1.1/4	5″	6
B610N3	–	N3	0.2130	0.207	1.1/4	5″	6
B6107/32	7/32	–	0.2188	0.207	1.1/4	5″	6
B610N2	–	N2	0.2210	0.217	1.1/2	6″	6
B610N1	–	N1	0.2280	0.217	1.1/2	6″	6
B610A	–	–	0.2340	0.227	1.1/2	6″	6
B61015/64	15/64	–	0.2344	0.227	1.1/2	6″	6
B610B	–	–	0.2380	0.233	1.1/2	6″	6
B610C	–	–	0.2420	0.233	1.1/2	6″	6
B610D	–	–	0.2460	0.233	1.1/2	6″	6
B610.2480	–	–	0.2480	0.233	1.1/2	6″	6
B610.2490	–	–	0.2490	0.240	1.1/2	6″	6
B610.2495	–	–	0.2495	0.240	1.1/2	6″	6
B6101/4	1/4	–	0.2500	0.240	1.1/2	6″	6
B610.2510	–	–	0.2510	0.240	1.1/2	6″	6
B610F	–	–	0.2570	0.248	1.1/2	6″	6
B610G	–	–	0.2610	0.248	1.1/2	6″	6
B61017/64	17/64	–	0.2656	0.248	1.1/2	6″	6
B610H	–	–	0.2660	0.248	1.1/2	6″	6
B610LETTERI	–	–	0.2720	0.248	1.1/2	6″	6
B610J	–	–	0.2770	0.248	1.1/2	6″	6
B610K	–	–	0.2810	0.248	1.1/2	6″	6
B6109/32	9/32	–	0.2812	0.248	1.1/2	6″	6
B610L	–	–	0.2900	0.279	1.1/2	6″	6
B610M	–	–	0.2950	0.279	1.1/2	6″	6
B61019/64	19/64	–	0.2969	0.279	1.1/2	6″	6
B610N	–	–	0.3020	0.279	1.1/2	6″	6
B610.3105	–	–	0.3105	0.279	1.1/2	6″	6
B610.3115	–	–	0.3115	0.279	1.1/2	6″	6
B610.3120	–	–	0.3120	0.279	1.1/2	6″	6
B6105/16	5/16	–	0.3125	0.279	1.1/2	6″	6
B610.3135	–	–	0.3135	0.279	1.1/2	6″	6
B610O	–	–	0.3160	0.279	1.1/2	6″	6
B610P	–	–	0.3230	0.279	1.1/2	6″	6
B61021/64	21/64	–	0.3281	0.279	1.1/2	6″	6
B610Q	–	–	0.3320	0.279	1.1/2	6″	6
B610R	–	–	0.3390	0.279	1.1/2	6″	6
B61011/32	11/32	–	0.3438	0.279	1.1/2	6″	6
B610S	–	–	0.3480	0.310	1.3/4	7″	6
B610T	–	–	0.3580	0.310	1.3/4	7″	6
B61023/64	23/64	–	0.3594	0.310	1.3/4	7″	6
B610U	–	–	0.3680	0.310	1.3/4	7″	6
B610.3730	–	–	0.3730	0.310	1.3/4	7″	6

Product	DC (inch)	DC (Wire gauge size)	DC (inch)	DCON MS (inch)	LCF (inch)	OAL (inch)	NOF
B610.3740	–	–	0.3740	0.310	1.3/4	7″	6
B610.3745	–	–	0.3745	0.310	1.3/4	7″	6
B6103/8	3/8	–	0.3750	0.310	1.3/4	7″	6
B610.3760	–	–	0.3760	0.310	1.3/4	7″	6
B610V	–	–	0.3770	0.310	1.3/4	7″	6
B610W	–	–	0.3860	0.310	1.3/4	7″	6
B61025/64	25/64	–	0.3910	0.310	1.3/4	7″	6
B610X	–	–	0.3970	0.310	1.3/4	7″	6
B610Y	–	–	0.4040	0.310	1.3/4	7″	6
B61013/32	13/32	–	0.4062	0.310	1.3/4	7″	6
B610Z	–	–	0.4130	0.373	1.3/4	7″	6
B61027/64	27/64	–	0.4219	0.373	1.3/4	7″	6
B610.4355	–	–	0.4355	0.373	1.3/4	7″	6
B610.4365	–	–	0.4365	0.373	1.3/4	7″	6
B610.4370	–	–	0.4370	0.373	1.3/4	7″	6
B6107/16	7/16	–	0.4375	0.373	1.3/4	7″	6
B610.4385	–	–	0.4385	0.373	1.3/4	7″	6
B61029/64	29/64	–	0.4531	0.373	1.3/4	7″	6
B61015/32	15/32	–	0.4688	0.373	1.3/4	7″	6
B61031/64	31/64	–	0.4844	0.435	2″	8″	6
B610.4980	–	–	0.4980	0.435	2″	8″	6
B610.4990	–	–	0.4990	0.435	2″	8″	6
B610.4995	–	–	0.4995	0.435	2″	8″	6
B6101/2	1/2	–	0.5000	0.435	2″	8″	6
B610.5010	–	–	0.5010	0.435	2″	8″	6
B61033/64	33/64	–	0.5156	0.435	2″	8″	6
B61017/32	17/32	–	0.5312	0.435	2″	8″	6
B61035/64	35/64	–	0.5469	0.435	2″	8″	8
B6109/16	9/16	–	0.5625	0.435	2″	8″	8
B61037/64	37/64	–	0.5781	0.435	2″	8″	8
B61019/32	19/32	–	0.5938	0.435	2″	8″	8
B61039/64	39/64	–	0.6094	0.562	2.1/4	9″	8
B6105/8	5/8	–	0.6250	0.562	2.1/4	9″	8
B61041/64	41/64	–	0.6410	0.562	2.1/4	9″	8
B61021/32	21/32	–	0.6562	0.562	2.1/4	9″	8
B61043/64	43/64	–	0.6719	0.562	2.1/4	9″	8
B61011/16	11/16	–	0.6875	0.562	2.1/4	9″	8
B61045/64	45/64	–	0.7031	0.562	2.1/4	9″	8
B61023/32	23/32	–	0.7188	0.562	2.1/4	9″	8
B61047/64	47/64	–	0.7344	0.625	2.1/2	9.1/2	8
B6103/4	3/4	–	0.7500	0.625	2.1/2	9.1/2	8
B61049/64	49/64	–	0.7656	0.625	2.1/2	9.1/2	8
B61025/32	25/32	–	0.7812	0.625	2.1/2	9.1/2	8
B61051/64	51/64	–	0.7969	0.625	2.1/2	9.1/2	8
B61013/16	13/16	–	0.8125	0.625	2.1/2	9.1/2	8
B61053/64	53/64	–	0.8281	0.625	2.1/2	9.1/2	8
B61027/32	27/32	–	0.8438	0.625	2.1/2	9.1/2	8
B61055/64	55/64	–	0.8594	0.750	2.5/8	10″	8
B6107/8	7/8	–	0.8750	0.750	2.5/8	10″	8
B61057/64	57/64	–	0.8910	0.750	2.5/8	10″	8
B61029/32	29/32	–	0.9062	0.750	2.5/8	10″	8
B61059/64	59/64	–	0.9219	0.750	2.5/8	10″	8
B61015/16	15/16	–	0.9375	0.750	2.5/8	10″	8
B61061/64	61/64	–	0.9531	0.750	2.5/8	10″	8
B61031/32	31/32	–	0.9688	0.750	2.5/8	10″	8
B61063/64	63/64	–	0.9844	0.875	2.3/4	10.1/2	8
B6101	1″	–	1.0000	0.875	2.3/4	10.1/2	8
B6101.1/16	1.1/16	–	1.0625	0.875	2.3/4	10.1/2	8
B6101.1/8	1.1/8	–	1.1250	0.875	2.7/8	11″	8
B6101.3/16	1.3/16	–	1.1875	1.000	2.7/8	11″	8
B6101.1/4	1.1/4	–	1.2500	1.000	3″	11.1/2	8
B6101.3/8	1.3/8	–	1.3750	1.000	3.1/4	12″	8
B6101.1/2	1.1/2	–	1.5000	1.250	3.1/2	12.1/2	8

B620

DORMER

高速钢直柄大螺旋机用铰刀，光亮处理
通用机用铰刀比手动铰刀的直槽更短、更深，设计用于对大多数材料进行高效机铰。可提供的尺寸范围很广的不同增量尺寸。按照 ANSI B94.2-1983 (R1988) 标准生产。



HSS | Bright | ANSI

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■21 C	■24 C	■25 C	■18 C	■16 C	◪14 B	■13 B	◪11 B	◪9 B	■8 B	◪7 B	◪5 A	◪11 C	◪10 B
M2.1	**M2.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**
◪9 B	◪8 B	■16 E	◪12 D	◪9 D	■16 C	◪13 C	◪10 C	◪14 C	◪11 C	◪24 F	■18 F	◪11 F	■27 E
N2.2	**N2.3**	**N3.1**	**N3.2**	**N3.3**									
◪24 E	◪16 E	■47 D	■28 E	◪14 D									

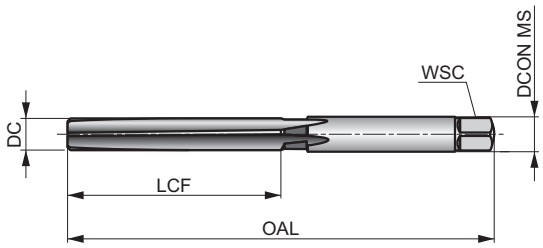
Product	DC (inch)	DC (Wire gauge size)	DC (inch)	DCON MS (inch)	LCF (inch)	OAL (inch)	NOF
B6201/16	1/16	–	0.0625	0.059	1/2	2.1/2	4
B6205/64	5/64	–	0.0781	0.072	3/4	3″	4
B6203/32	3/32	–	0.0938	0.088	3/4	3″	4
B6207/64	7/64	–	0.1094	0.103	7/8	3.1/2	4
B6201/8	1/8	–	0.1250	0.119	7/8	3.1/2	4
B6205/32	5/32	–	0.1562	0.151	1″	4″	6
B62011/64	11/64	–	0.1719	0.165	1.1/8	4.1/2	6
B6203/16	3/16	–	0.1875	0.180	1.1/8	4.1/2	6
B62013/64	13/64	–	0.2031	0.195	1.1/4	5″	6
B6207/32	7/32	–	0.2188	0.207	1.1/4	5″	6
B6201/4	1/4	–	0.2500	0.240	1.1/2	6″	6
B62017/64	17/64	–	0.2656	0.248	1.1/2	6″	6
B6209/32	9/32	–	0.2812	0.248	1.1/2	6″	6
B6205/16	5/16	–	0.3125	0.279	1.1/2	6″	6

Product	DC (inch)	DC (Wire gauge size)	DC (inch)	DCON MS (inch)	LCF (inch)	OAL (inch)	NOF
B62011/32	11/32	–	0.3438	0.279	1.1/2	6″	6
B6203/8	3/8	–	0.3750	0.310	1.3/4	7″	6
B62025/64	25/64	–	0.3910	0.310	1.3/4	7″	6
B62013/32	13/32	–	0.4062	0.310	1.3/4	7″	6
B6207/16	7/16	–	0.4375	0.373	1.3/4	7″	6
B62031/64	31/64	–	0.4844	0.435	2″	8″	6
B6201/2	1/2	–	0.5000	0.435	2″	8″	6
B62017/32	17/32	–	0.5312	0.435	2″	8″	6
B6209/16	9/16	–	0.5625	0.435	2″	8″	8
B6205/8	5/8	–	0.6250	0.562	2.1/4	9″	8
B62011/16	11/16	–	0.6875	0.562	2.1/4	9″	8
B6203/4	3/4	–	0.7500	0.625	2.1/2	9.1/2	8
B6207/8	7/8	–	0.8750	0.750	2.5/8	10″	8
B6201	1″	–	1.0000	0.875	2.3/4	10.1/2	8

B650

DORMER

高速钢直槽手动铰刀，光亮处理
重型手动铰刀，带有直槽，用于手工加工钻孔。方形驱动允许使用扳手旋转刀具，或将刀具固定安装在旋转部件上。适用于铰削包括钢材在内的大多数材料。按照 ANSI B94.2-1983 (R1988) 标准生产。



HSS | Bright | ANSI

工件材料组的适用性。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	◪	■	◪	◪	◪	◪	◪	◪	◪

M2.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2
◪	■	■	◪	■	■	◪	■	◪	◪	■	■	■	■

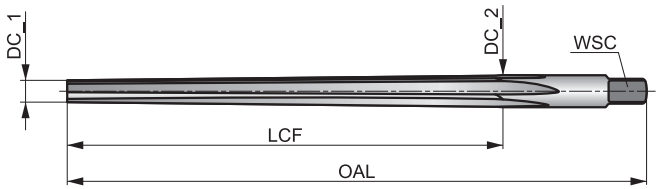
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2
◪	■	■	◪	◪	◪

Product	DC (inch)	DC (inch)	LCF (inch)	OAL (inch)	NOF
B6501/8	1/8	0.1250	1.1/2	3″	6
B6503/16	3/16	0.1875	1.3/4	3.1/2	6
B6501/4	1/4	0.2500	2″	4″	6
B6505/16	5/16	0.3125	2.1/4	4.1/2	6
B6503/8	3/8	0.3750	2.1/2	5″	6
B6507/16	7/16	0.4375	2.3/4	5.1/2	6
B6501/2	1/2	0.5000	3″	6″	6
B6509/16	9/16	0.5625	3.1/4	6.1/2	8
B6505/8	5/8	0.6250	3.1/2	7″	8
B6503/4	3/4	0.7500	4.3/16	8.3/8	8
B6507/8	7/8	0.8750	4.7/8	9.3/4	8
B6501	1″	1.0000	5.7/16	10.7/8	8

B301

DORMER

手用高速钢锥度直柄铰刀，锥度1:48，表面光亮并蒸汽回火处理。
一种用于英制1:48锥形销孔精加工的缩柄铰刀，能够轻易地在预孔中定位和定心以提高精度和性能，适用于多种材料的切削。



HSS	Bright ST	BS 328
R		A
1:48		

工件材料组的适用性。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	◪	■	◪	◪	◪	◪	◪	◪	◪
M2.1	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪	■	■	◪	■	■	◪	■	◪	◪	■	■	■	■
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**								
◪	■	■	◪	◪	◪								

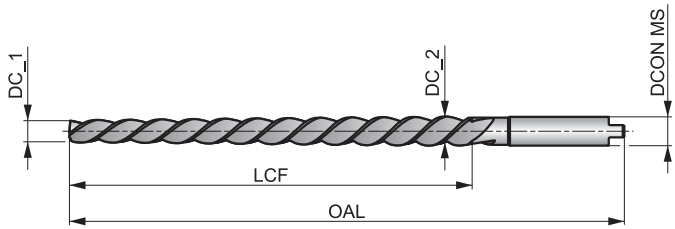
DC <= 1/4 公差极限+0.0030; DC >=9/32 公差极限+0.0050

Product	nom d	DC_1	DC_2	OAL	LCF	NOF	WSC	DCON MS
		(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
B3013/32	3/32	1.75	2.41	57.0	32.0	4	2.00	2.41
B3011/8	1/8	2.30	3.23	70.0	44.0	4	2.50	3.23
B3015/32	5/32	2.95	4.01	76.0	51.0	4	3.10	4.01
B3013/16	3/16	3.50	4.95	102.0	70.0	4	4.00	4.95
B3011/4	1/4	4.64	6.43	117.0	86.0	6	5.00	6.43
B3015/16	5/16	5.84	8.03	143.0	105.0	6	6.30	8.03
B3013/8	3/8	7.03	9.68	165.0	127.0	6	8.00	9.68
B3011/2	1/2	9.41	12.85	210.0	165.0	6	10.00	12.85

B953

DORMER

手用高速钢直柄锥度铰刀，锥度1:50，表面光亮处理。
较大的左手螺旋并右手切削，用于精加工锥孔以满足1:50公制锥形销标准，锥点缩径以提高切削性能，适用于多种材料的切削。



HSS-E | Bright | DIN 2179
R | 1:50

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■10 B	■12 B	■13 B	■9 B	■8 B	◪6 A	■7 A	◪6 A	◪3 A	■4 A	◪3 A	◪2 A	◪11 C	◪10 B
M2.1	**M2.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**
◪9 B	◪8 B	■10 C	■6 B	◪4 B	■8 A	■6 A	◪4 A	■7 A	◪4 A	◪14 D	■12 D	■9 D	■16 C
N2.2	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**								
■14 C	◪10 C	■22 B	■14 C	◪6 B	◪22 B								

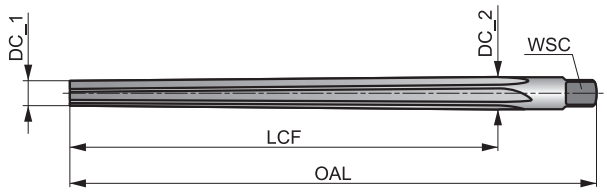
DCON MS公差h9

Product	nom d	DC_1	DC_2	OAL	LCF	NOF	DCON MS
		(mm)	(mm)	(mm)	(mm)		(mm)
B9532.0	2.0	1.90	2.86	86.0	48.0	3	3.15
B9532.5	2.5	2.40	3.36	86.0	48.0	3	3.15
B9533.0	3.0	2.90	4.06	100.0	58.0	3	4.00
B9534.0	4.0	3.90	5.26	112.0	68.0	3	5.00
B9535.0	5.0	4.90	6.36	122.0	73.0	3	6.30
B9536.0	6.0	5.90	8.00	160.0	105.0	3	8.00
B9536.5	6.5	6.40	8.78	188.0	119.0	3	8.50
B9538.0	8.0	7.90	10.80	207.0	145.0	3	10.00
B95310.0	10.0	9.90	13.40	245.0	175.0	3	12.50
B95312.0	12.0	11.80	16.00	290.0	210.0	3	16.00

B903

DORMER

手用高速钢锥度直柄铰刀，锥度1:50，表面光亮并蒸汽回火处理。
一种用于英制1:50锥形销孔精加工的铰刀，小端直径的减小能够轻易地在预孔中定位和定心，适用于多种材料的切削。



HSS	Bright ST	DIN 9
R		A
1:50		

工件材料组的适用性。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	◪	■	◪	◪	◪	◪	◪	◪	◪
M2.1	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪	■	■	◪	■	■	◪	■	◪	◪	■	■	■	■
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**								
◪	■	■	◪	◪	◪								

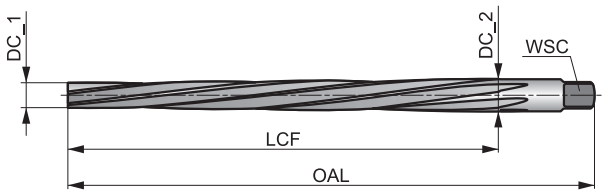
DCON MS公差h11; DC <= 5mm 上公差+0.0750; DC < 5mm 上公差+0.1250

Product	nom d	DC_1	DC_2	OAL	LCF	NOF	WSC	DCON MS
		(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
B9031.5	1.5	1.40	2.14	57.0	37.0	4	1.80	2.14
B9032.0	2.0	1.90	2.86	68.0	48.0	4	2.24	2.86
B9032.5	2.5	2.40	3.36	68.0	48.0	4	2.80	3.36
B9033.0	3.0	2.90	4.06	80.0	58.0	4	3.15	4.00
B9034.0	4.0	3.90	5.26	93.0	68.0	4	4.00	5.00
B9035.0	5.0	4.90	6.36	100.0	73.0	4	5.00	6.30
B9036.0	6.0	5.90	8.00	135.0	105.0	6	6.30	7.90
B9038.0	8.0	7.90	10.80	180.0	145.0	6	8.00	10.50
B90310.0	10.0	9.90	13.40	215.0	175.0	6	10.00	13.30
B90312.0	12.0	11.80	16.00	255.0	210.0	8	11.20	16.00
B90313.0	13.0	12.86	16.74	255.0	210.0	8	12.50	16.74
B90314.0	14.0	13.86	17.74	255.0	210.0	8	12.50	17.74
B90316.0	16.0	15.80	20.40	280.0	230.0	8	14.00	20.40
B90320.0	20.0	19.80	24.80	310.0	250.0	8	18.00	24.80

B952

DORMER

手用高速钢锥度直柄铰刀，锥度1:50，表面光亮处理。
左手螺旋并右手切削，能够平稳地铰孔以实现更好孔径尺寸和表面光洁度，小端直径的减小能够轻易地在预孔中定位和定心，适用于多种材料的切削。



HSS	Bright	DIN 9
R		B
1:50		

工件材料组的适用性。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	◪	■	◪	◪	◪	◪	◪	◪	◪
M2.1	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪	■	■	◪	■	■	◪	■	◪	◪	■	■	■	■
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**								
◪	■	■	◪	◪	◪								

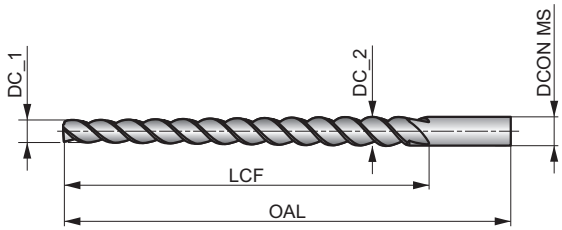
DCON MS公差h11; DC <= 2.5mm 直槽, A型

Product	nom d	DC_1	DC_2	OAL	LCF	NOF	WSC	DCON MS
		(mm)	(mm)	(mm)	(mm)		(mm)	(mm)
B9521.2	1.2	1.10	1.74	50.0	32.0	3	2.40	3.15
B9521.5	1.5	1.40	2.14	57.0	37.0	3	2.40	3.15
B9522.0	2.0	1.90	2.86	68.0	48.0	3	2.40	3.15
B9522.5	2.5	2.40	3.36	68.0	48.0	4	2.40	3.15
B9523.0	3.0	2.90	4.06	80.0	58.0	5	3.00	4.00
B9523.5	3.5	3.40	4.66	87.0	63.0	5	3.40	4.50
B9524.0	4.0	3.90	5.26	93.0	68.0	5	3.80	5.00
B9525.0	5.0	4.90	6.36	100.0	73.0	5	4.90	6.30
B9526.0	6.0	5.90	8.00	135.0	105.0	6	6.20	8.00
B9527.0	7.0	6.90	9.40	160.0	125.0	6	7.00	9.00
B9528.0	8.0	7.90	10.80	180.0	145.0	6	8.00	10.00
B9529.0	9.0	8.90	12.10	195.0	160.0	6	9.00	11.20
B95210.0	10.0	9.90	13.40	215.0	175.0	6	10.00	12.50
B95212.0	12.0	11.80	16.00	255.0	210.0	8	11.00	14.00
B95213.0	13.0	12.80	17.00	255.0	210.0	8	12.00	16.00
B95214.0	14.0	13.80	18.00	255.0	210.0	8	12.00	16.00
B95216.0	16.0	15.80	20.40	280.0	230.0	8	14.50	18.00
B95220.0	20.0	19.80	24.80	310.0	250.0	8	18.00	22.40
B95225.0	25.0	24.70	30.70	370.0	300.0	10	22.00	28.00
B95230.0	30.0	29.70	36.10	400.0	320.0	10	24.00	31.50
B95240.0	40.0	39.70	46.50	430.0	340.0	12	32.00	40.00

B630

DORMER

高速钢直柄机用铰刀，锥度，光亮处理
与直刃铰刀相比，大螺旋角右旋使这些铰刀的操作更顺畅，无颤动。推荐用于较难铰削的材料，可获得更好的表面光洁度，非常适合间断加工，并有助于从盲孔中排出切屑。按照 ANSI B94.2-1983 (R1988) 标准生产。



HSS | Bright | ANSI
R | 1:48

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 10 B	■ 12 B	■ 13 B	■ 9 B	■ 8 B	◪ 6 A	■ 7 A	◪ 6 A	◪ 3 A	■ 4 A	◪ 3 A	◪ 2 A	◪ 11 C	◪ 10 B
M2.1	**M2.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**
◪ 9 B	◪ 8 B	■ 10 C	■ 6 B	◪ 4 B	■ 8 A	■ 6 A	◪ 4 A	■ 7 A	◪ 4 A	◪ 14 D	■ 12 D	■ 9 D	■ 16 C
N2.2	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**								
■ 14 C	◪ 10 C	■ 22 B	■ 14 C	◪ 6 B	◪ 22 B								

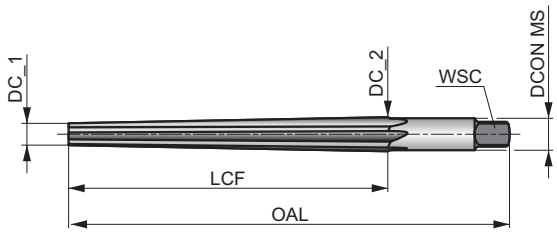
Product	nom d	DC_1 (inch)	DC_2 (inch)	DCON MS (inch)	LCF (inch)	OAL (inch)	NOF
B6307/0	7/0	0.0497	0.0666	5/64	13/16	1.13/16	2
B6306/0	6/0	0.0611	0.0810	3/32	15/16	1.15/16	2
B6305/0	5/0	0.0719	0.0966	7/64	1.3/16	2.3/16	2
B6304/0	4/0	0.0869	0.1142	1/8	1.5/16	2.5/16	2
B6303/0	3/0	0.1029	0.1300	9/64	1.5/16	5.5/16	2
B6302/0	2/0	0.1137	0.1462	5/32	1.9/16	2.9/16	3
B630N1	1	0.1447	0.1798	3/16	1.11/16	2.15/16	3
B630N2	2	0.1600	0.2010	13/64	1.15/16	3.3/16	3

Product	nom d	DC_1 (inch)	DC_2 (inch)	DCON MS (inch)	LCF (inch)	OAL (inch)	NOF
B630N3	3	0.1813	0.2294	15/64	2.5/16	3.11/16	3
B630N4	4	0.2071	0.2600	17/64	2.9/16	4.1/16	3
B630N5	5	0.2410	0.2994	5/16	2.13/16	4.5/16	3
B630N6	6	0.2773	0.3540	23/64	3.11/16	5.7/16	3
B630N7	7	0.3297	0.4220	13/32	4.7/16	6.5/16	3
B630N8	8	0.3971	0.5050	7/16	5.3/16	7.3/16	3
B630N9	9	0.4800	0.6066	9/16	6.1/16	8.5/16	4
B630N10	10	0.5799	0.7216	5/8	6.13/16	9.5/16	4

B660

DORMER

高速钢直槽手动铰刀，锥度，光亮处理
设计用于将直钻孔转换为锥形孔（每英尺 1/4 英寸），适用于标准锥销（ASA B5.20-1958）。方形驱动允许使用扳手旋转刀具，或将刀具固定安装在旋转部件上。适用于大多数材料的铰孔，包括钢材。按照 ANSI B94.2-1983 (R1988) 标准生产。



HSS | Bright | ANSI
R | 1:48

工件材料组的适用性。

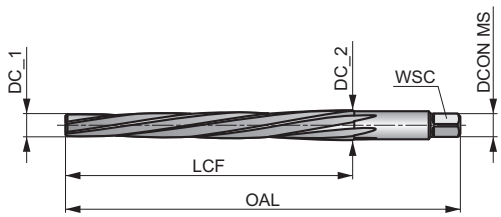
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	◪	■	◪	◪	◪	◪	◪	◪	◪
M2.1	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪	■	■	◪	■	■	◪	■	◪	◪	■	■	■	■
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**								
◪	■	■	◪	◪	◪								

Product	nom d	DC_1 (inch)	DC_2 (inch)	DCON MS (inch)	LCF (inch)	OAL (inch)	WSC (inch)	NOF
B660N0	0	0.1287	0.1638	11/64	1.11/16	2.15/16	0.130	6
B660N1	1	0.1447	0.1798	3/16	1.11/16	2.15/16	0.140	6
B660N2	2	0.1600	0.2010	13/64	1.15/16	3.3/16	0.150	6
B660N3	3	0.1813	0.2294	15/64	2.5/16	3.11/16	0.175	6
B660N4	4	0.2071	0.2600	17/64	2.9/16	4.1/16	0.200	6
B660N5	5	0.2410	0.2994	5/16	2.13/16	4.5/16	0.235	6
B660N6	6	0.2773	0.3540	23/64	3.11/16	5.7/16	0.270	6
B660N7	7	0.3297	0.4220	13/32	4.7/16	6.5/16	0.305	6
B660N8	8	0.3971	0.5050	7/16	5.3/16	7.3/16	0.330	6
B660N9	9	0.4800	0.6066	9/16	6.1/16	8.5/16	0.420	8
B660N10	10	0.5799	0.7216	5/8	6.13/16	9.5/16	0.470	8

B670

DORMER

高速钢螺旋槽手动铰刀，锥型，光亮处理
右手刀，左螺旋大螺旋角，可铰出锥形孔（每英尺 1/4\“），用于标准锥销（ASA B5.20-1958）。方形驱动允许旋转刀具或静态安装刀具以加工旋转零件。螺旋刃有助于排屑，从而提高表面光洁度。按照 ANSI B94.2-1983 (R1988) 标准生产。



HSS	Bright	ANSI
R		1:48

工件材料组的适用性。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	◪	■	◪	◪	◪	◪	◪	◪	◪
M2.1	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪	■	■	◪	■	■	◪	■	◪	◪	■	■	■	■
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**								
◪	■	■	◪	◪	◪								

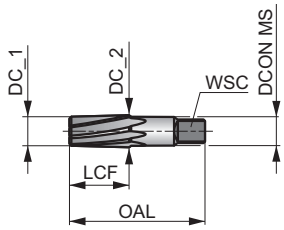
Nom d 是根据美国标准圆锥销规格 (ASA B5.20-1958) 确定的圆锥销编号。

Product	nom d	DC_1 (inch)	DC_2 (inch)	DCON MS (inch)	LCF (inch)	OAL (inch)	WSC (inch)	NOF
B670N0	0	0.1287	0.1638	11/64	1.11/16	2.15/16	0.130	6
B670N1	1	0.1447	0.1798	3/16	1.11/16	2.15/16	0.140	6
B670N2	2	0.1600	0.2010	13/64	1.15/16	3.3/16	0.150	6
B670N3	3	0.1813	0.2294	15/64	2.5/16	3.11/16	0.175	6
B670N4	4	0.2071	0.2600	17/64	2.9/16	4.1/16	0.200	6
B670N5	5	0.2410	0.2994	5/16	2.13/16	4.5/16	0.235	6
B670N6	6	0.2773	0.3540	23/64	3.11/16	5.7/16	0.270	6
B670N7	7	0.3297	0.4220	13/32	4.7/16	6.5/16	0.305	6
B670N8	8	0.3971	0.5050	7/16	5.3/16	7.3/16	0.330	6
B670N9	9	0.4800	0.6066	9/16	6.1/16	8.5/16	0.420	8
B670N10	10	0.5799	0.7216	5/8	6.13/16	9.5/16	0.470	8

B680

DORMER

高速钢螺旋槽手动铰刀，NPT 锥管型，光亮处理
右手刀，左螺旋，在 NPT 攻丝前铰出锥形孔（每英尺 3/4”）。方形驱动允许旋转刀具或将刀具静止安装在旋转部件上。螺旋刃有助于排屑，从而提高表面光洁度。按照 ANSI B94.2-1983 (R1988) 标准生产。



HSS | Bright | ANSI

工件材料组的适用性。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■	■	■	■	■	◪	■	◪	◪	◪	◪	◪	◪	◪

M2.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	N1.1	N1.2	N1.3	N2.1	N2.2
◪	■	■	◪	■	■	◪	■	◪	◪	■	■	■	■

N2.3	N3.1	N3.2	N3.3	N4.1	N4.2
◪	■	■	◪	◪	◪

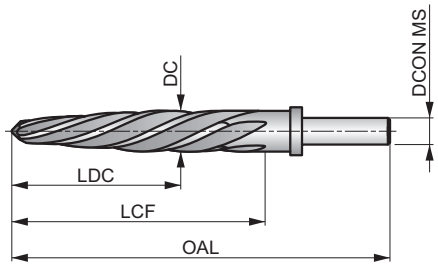
Nom d 是 NPT 管螺纹尺寸。

Product	nom d	DC_1	DC_2	DCON MS	LCF	OAL	WSC	NOF
		(inch)	(inch)	(inch)	(inch)	(inch)	(inch)	
B6801/8	1/8	0.3160	0.3620	0.438	3/4	2.1/8	0.328	6
B6801/4	1/4	0.4060	0.4720	0.563	1.1/16	2.7/16	0.421	6
B6803/8	3/8	0.5400	0.6060	0.700	1.1/16	2.9/16	0.531	8
B6801/2	1/2	0.6650	0.7510	0.688	1.3/8	3.1/8	0.575	8
B6803/4	3/4	0.8760	0.9620	0.906	1.3/8	3.1/4	0.679	10
B6801	1”	1.1030	1.2120	1.125	1.3/4	3.3/4	0.843	10

B122

DORMER

手用高速钢缩柄铰刀，青铜色蒸汽回火处理。
一种用于在薄壁钢板的螺栓连接或铆钉链接之前，重新校准孔的手用铰刀，小的引导直径能够轻易地在预孔中实现定位和校准，适用于多种材料的切削。



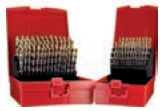
HSS | ST Bronze | ANSI

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P3.1	M1.1	M1.2	M2.1	N1.1	N1.2	N2.1	N2.2	N3.1
■ 15 C	■ 16 C	■ 17 C	■ 13 C	◪ 11 C	◪ 7 B	◪ 11 C	◪ 10 B	◪ 9 B	◪ 23 F	◪ 17 F	◪ 23 E	◪ 21 E	■ 34 D

N3.2	N4.1	N4.2
■ 20 E	◪ 22 B	◪ 21 B

Product	DC	DC	OAL	LCF	NOF	DCON MS
	(inch)	(inch)	(inch)	(inch)		(inch)
B1223/8	3/8	0.3750	4.5/8	2.1/2	4	3/8
B1221/2	1/2	0.5000	5.7/8	3.3/4	5	1/2
B1229/16	9/16	0.5625	5.7/8	3.3/4	5	1/2
B1225/8	5/8	0.6250	6.3/8	4.1/4	5	1/2
B12211/16	11/16	0.6875	6.3/8	4.1/4	5	1/2
B1223/4	3/4	0.7500	6.7/8	4.1/2	5	1/2
B12213/16	13/16	0.8125	6.7/8	4.1/2	5	1/2
B1227/8	7/8	0.8750	6.7/8	4.1/2	5	1/2
B12215/16	15/16	0.9375	6.7/8	4.1/2	5	1/2
B1221	1″	1.0000	6.7/8	4.1/2	5	1/2

材料代码(BMC)	HSS	HSS	HSS	HSS	HSS	HSS	HSS
基本标准组(BSG)	DIN ANSI	DIN 338	DIN 338	DIN 338	DIN 338	DIN 338	DIN 338
有用长度直径比 (ULDR)	2.5×D	4×D	4×D	4×D	4×D	4×D	4×D
应用角度	135°	118°	118°	118°	118°	118°	135°
涂层	TiN-Tip	TiN-Tip	TiN-Tip	TiN-Tip	TiN-Tip	TiN-Tip	ST
柄部							
螺旋形式	λ.20-35°	λ.20-35°	λ.20-35°	λ.20-35°	λ.20-35°	λ.20-35°	λ.>35°
旋向(切削方向)	R	R	R	R	R	R	R
							
产品系列代码	A088	A089	A087	A094	A095	A099 Drillboy	A188
PSF切削直径范围	Set	Set	Set	Set	Set	Set	Set
	92	92	93	93	94	94	95
P P1							
P2							
P3							
P4							
M M1							
M2							
M3							
M4							
K K1							
K2							
K3							
K4							
K5							
N N1							
N2							
N3							
N4							
N5							
S S1							
S2							
S3							
S4							
H H1							
H2							
H3							
H4							

■推荐使用 ◪可以使用

	A295	A190	A191	A191_2	M900	M901	M902	A080
	HSS-E	HSS	HSS	HSS	Cr steel			
	DIN 338	DIN 338	DIN 338	DIN 338				
	4×D	4×D	4×D	4×D				
	135°	118°	118°	118°				
	Bronze	ST	Bright	ST				
	λ 20-35°	λ 20-35°	λ 20-35°	λ 20-35°				
	R	R	R	R	L			
	Set	Set	Set	Set	Size 1 - 9	Set	Set	Set
	95	96	97	97	98	99	99	99
P1					■			
P2					■			
P3					■			
P4					■			
M1					■			
M2					■			
M3					◪			
M4								
K1					■			
K2					■			
K3					■			
K4					■			
K5					■			
N1					■			
N2					■			
N3					■			
N4					■			
N5								
S1								
S2								
S3								
S4								
H1								
H2								
H3								
H4								

■推荐使用 ◪可以使用

A088

DORMER

A022短型高速钢钻头套装，头部氮化钛涂层。
一个坚固的A022钻头套装盒，包含了24种不同直径的短型钻头，一次性采购即可涵盖各种尺寸，可用于手持式工具或机床的多种应用场合，头部TiN涂层能够提高性能并延长刀具寿命。

HSS	DIN ANSI	2.5×D
135°	TiN-Tip	
λ20-35°	R	DC h8

A=套件中的型号, B=套件中的数量, C=套件中的直径

Product	Nr.	A	B	C
A088200S	200S	A022	24	1.0 mm - 10.5 mm x 0.5 mm + 3.3 mm, 4.2 mm, 6.8 mm, 10.2 mm

A089

DORMER

普通长度A002高速钢钻头套装，头部氮化钛涂层。
一个方便的A002钻头套装盒，包含了广受欢迎的5种不同直径的钻头，一次性采购即可涵盖多种尺寸，可用于手持式工具或机床的多种应用场合，头部TiN涂层能够提高性能并延长刀具寿命。

HSS	DIN 338	4×D
118°	TiN-Tip	
λ20-35°	R	DC h8

A=套件中的型号, B=套件中的数量, C=套件中的直径

Product	Nr.	A	B	C
A08910	10	A002	5	A0024.0, A0025.0, A0026.0, A0028.0, A00210.0

A087

DORMER

普通长度A002高速钢钻头套装，头部氮化钛涂层。
一个便于携带的A002钻头套装盒，包含了广受欢迎的19种不同直径的钻头，尺寸清晰且选择方便，可用于手持式工具或机床的多种应用场合，头部TiN涂层能够提高性能并延长刀具寿命。

HSS	DIN 338	4×D
118°	TiN-Tip	
λ20-35°	R	DC h8

A=套件中的型号, B=套件中的数量, C=套件中的直径. 1.0mm =< DC >= 2.9mm 118° 4后面钻尖

Product	Nr.	A	B	C
A087201	201	A002	19	1.0 mm - 10.0 mm x 0.5 mm

A094

DORMER

普通长度A002高速钢钻头套装，头部氮化钛涂层。
一个巧妙的A002钻头圆桶套装，包含了不同公制直径的钻头，能够非常简单地选择各种尺寸，旋转透明的塑料顶部直到所需尺寸的钻头凸显在外罩的孔中，然后倒置即可取出钻头。

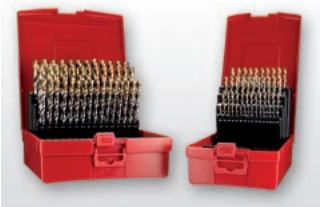
HSS	DIN 338	4×D
118°	TiN-Tip	
λ20-35°	R	DC h8

A=套件中的型号, B=套件中的数量, C=套件中的直径. 1.0mm =< DC >= 2.9mm 118° 4后面钻尖

Product	Nr.	A	B	C
A094413	413	A002	13	1.5 mm - 6.5 mm x 0.5 mm + 3.3 mm, 4.2 mm
A094419	419	A002	19	1.0 mm - 10.0 mm x 0.5 mm

A095

DORMER



普通长度A002高速钢钻头套装，头部氮化钛涂层。
一个实用的塑料套装盒，集中包含了公制或分制尺寸的A002钻头，所有钻头尺寸清晰且选择方便，可用于手持式工具或机床的多种应用场合，头部TiN涂层能够提高性能并延长刀具寿命。

HSS	DIN 338	4×D
118°	TiN-Tip	
λ20-35°	R	DC h8

1.0mm =< DC >= 2.9mm 118° 4后面钻尖.A=套件中的型号, B=套件中的数量, C=套件中的直径

Product	Nr.	A	B	C
A09518	18	A002	29	1/16 inch - 1/2 inch x 1/64 inch
A095200	200	A002	24	1.0 mm - 10.5 mm x 0.5 mm + 3.3 mm, 4.2 mm, 6.8 mm, 10.2 mm
A095201	201	A002	19	1.0 mm - 10.0 mm x 0.5 mm
A095202	202	A002	51	1.0 mm - 6.0 mm x 0.1 mm
A095203	203	A002	41	6.0 mm - 10.0 mm x 0.1 mm
A095204	204	A002	25	1.0 mm - 13.0 mm x 0.5 mm
A095206	206	A002	29	1.0 mm - 13.0 mm x 0.5 mm + 3.3 mm, 4.2 mm, 6.8 mm, 10.2 mm
A095209	209	A002	91	1.0 mm - 10.0 mm x 0.1 mm

A099 Drillboy

DORMER

普通长度的A002高速钢钻头工具盒套装，头部氮化钛涂层。
一个独立的台架，包含各种尺寸的A002钻头，放置在台面或其他合适的平面上以便突出显示，在需要时可以很容易地移除或进一步补充A002系列钻头，该台架能够提供多年的服务。

HSS	DIN 338	4×D
118°	TiN-Tip	
λ20-35°	R	DC h8

1.0mm =< DC >= 2.9mm 118° 4后面钻尖.A=套件中的型号, B=套件中的数量, C=套件中的直径

Product	Nr.	A	B	C
A099DRILLBOYXL	DRILLBOY	A002	55	3 x (1.0, 1.5, 2.0, 2.5, 3.0, 3.3, 3.5, 4.0) + 2 x (4.2, 4.5, 5.0, 5.5, 6.0, 6.5, 6.8, 7.0, 7.5, 8.0) + 8.5, 9.0, 9.5, 10.0, 10.2, 10.5, 11.0, 11.5, 12.0, 12.5, 13.0 mm

A188

DORMER

普通长度A108高速钢钻头套装，蒸汽回火处理。
一个实用的塑料套装盒，包含了不同尺寸的公制A108钻头，可应用于手持式工具或机床等多种设备。

HSS	DIN 338	4×D
135°	ST	
λ>35°	R	DC h8

A=套件中的型号, B=套件中的数量, C=套件中的直径. DC > 1.5mm; 1/16“分离式钻尖

Product	Nr.	A	B	C
A188201	201	A108	19	1.0 mm - 10.0 mm x 0.5 mm
A188204	204	A108	25	1.0 mm - 13.0 mm x 0.5 mm

A295

DORMER

普通长度A777含钴高速钢钻头套装，青铜色表面处理。
一个实用的塑料套装盒，包含了不同尺寸的分制A777钻头，所有钻头排列有序，尺寸清晰且选择方便，A777钻头具有135°钻尖角，有助于自定心并减少切削力。

HSS-E	DIN 338	4×D
135°	Bronze	
λ20-35°	R	DC h8

A=套件中的型号, B=套件中的数量, C=套件中的直径.DC <= 1.4mm 4后面钻尖

Product	Nr.	A	B	C
A295219	219	A777	19	1.0 mm - 10.0 mm x 0.5 mm
A295225	225	A777	25	1.0 mm - 13.0 mm x 0.5 mm

A190

DORMER

普通长度A100高速钢钻头套装，蒸汽回火处理。
一个便携的A100钻头塑料盒套装，包含了不同公制或分制尺寸的普通长度钻头（118°的常规钻尖），选择所需尺寸的钻头非常简单。

HSS	DIN 338	4×D
118°	ST	
λ20-35°	R	DC h8

A=套件中的型号, B=套件中的数量, C=套件中的直径.DC <= 1mm; 3/64"; N60光亮表面.

Product	Nr.	A	B	C
A1903	3	A100	21	1/16 inch - 3/8 inch x 1/64 inch
A19012	12	A100	60	No.1 - No.60
A19018	18	A100	29	1/16 inch - 1/2 inch x 1/64 inch
A19020	20	A100	15	1/16 inch - 1/2 inch x 1/32 inch
A190201	201	A100	19	1.0 mm - 10.0 mm x 0.5 mm
A190202	202	A100	51	1.0 mm - 6.0 mm x 0.1 mm
A190203	203	A100	41	6.0 mm - 10.0 mm x 0.1 mm
A190204	204	A100	25	1.0 mm - 13.0 mm x 0.5 mm
A190206	206	A100	29	1.0 mm - 13.0 mm x 0.5 mm + 3.3 mm, 4.2 mm, 6.8 mm, 10.2 mm
A190209 [1]	209	A100	91	1.0 mm - 10.0 mm x 0.1 mm

[1] 2盒装出售：第1盒（1.0-5.9 x 0.1 mm）+ 第2盒（6.0-10.0 x 0.1 mm）

A191

DORMER

普通长度A100高速钢钻头套装，蒸汽回火处理。
一个便携的A100钻头套装盒，包含了不同公制直径的普通长度钻头（118°的常规钻尖），尺寸清晰且选择方便，在一个便携式的塑料盒中提供公制或线径尺寸的套装，能够简单地选择所需尺寸的钻头。

HSS	DIN 338	4×D
118°	Bright	
λ20-35°	R	DC h8

A=套件中的型号, B=套件中的数量, C=套件中的直径.DC <= 1mm; 3/64"; N60光亮表面.

Product	Nr.	A	B	C
A19131M	31M	A100	20	0.3 mm - 1.0 mm x 0.05 mm + 0.38 mm, 0.52 mm, 0.58 mm, 0.78 mm, 0.82 mm

A191_2

DORMER

普通长度A100高速钢钻头套装，蒸汽回火处理。
一个巧妙的A100钻头圆桶套装，包含了不同公制直径的钻头，能够非常简单地选择各种尺寸，旋转透明的塑料顶部直到所需尺寸的钻头凸显在外罩的孔中，然后倒置即可取出钻头。

HSS	DIN 338	4×D
118°	ST	
λ20-35°	R	DC h8

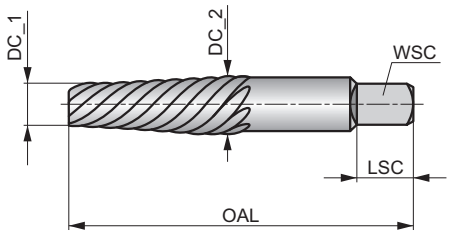
A=套件中的型号, B=套件中的数量, C=套件中的直径.DC <= 1mm; 3/64"; N60光亮表面.

Product	Nr.	A	B	C
A191413	413	A100	13	1.5 mm - 6.5 mm x 0.5 mm + 3.3 mm, 4.2 mm
A191419	419	A100	19	1.0 mm - 10.0 mm x 0.5 mm

M900

DORMER

螺钉拔取器
使用螺钉拔取器逆时针转动，以便在不损坏螺纹的情况下从螺纹孔中拆除损坏的右旋螺栓。在使用拔取器前，必须钻出正确尺寸的导孔。



钻孔尺寸 A：用于低或中等拉伸强度的螺钉。B：用于高强度螺钉

Product		A (mm)	B (mm)	(inch)	A (inch)	B (inch)	DC_1 (mm)	DC_2 (mm)	WSC (mm)	LSC (mm)	OAL (mm)
M9001	M5 - M6	2	2	3/16″-1/4″	5/64	5/64	1.37	3.20	2.60	5.1	51.1
M9002	M6 - M8	2.8	3	1/4″ - 5/16″	7/64	1/8	2.18	4.80	3.90	6.7	61.1
M9003	M8 - M12	4	4.2	5/16″ - 7/16″	5/32	11/64	3.18	6.40	4.80	7.5	68.7
M9004	M12 - M14	5.5	6	7/16″ - 9/16″	7/32	15/64	4.37	8.00	6.00	8	76.7
M9005	M14 - M20	7.2	8	9/16″ - 3/4″	9/32	5/16	6.35	11.10	8.30	11.5	86.1
M9006	M20 - M30	10.5	11	3/4″ - 1″	13/32	7/16	9.53	15.90	11.90	13.1	94.4
M9007	M30 - M42	13.5	14.5	1″ - 1.3/8″	17/32	9/16	12.30	19.10	14.30	17.9	107.4
M9008	M42 - M45	20.5	21.5	1.3/8″ - 1.3/4″	13/16	27/32	18.65	25.10	19.80	19.4	114.3
M9009	M45 - M50	27	28	1.3/4 - 2.1/8	1.1/16	1.3/32	24.61	32.30	24.60	22.6	121.3

M901

DORMER

螺钉拔取器组件
螺钉拔取器组件，尺寸M9001 - M9005或M9001 - M9006。

A=套件中的型号, B=套件中的数量, C=套件中的直径

Product	Nr.	A	B	C
M901A	A	M900	5	M9001-M9005
M901B	B	M900	6	M9001-M9006

M902

螺栓去除组件
用于拆除损坏的右旋螺栓的工具，一套四件。首先使用P100旋转锉磨平螺栓。然后使用P101旋转锉加工一个起始锥形。第三步使用HSS-E短柱钻头A117钻一个用于拔取器的孔。最后逆时针转动螺钉拔取器，以便在不损坏螺纹的情况下去除损坏的螺栓。

A=套件中的型号, B=套件中的数量, C=套件中的直径

Product	Nr.	A	B	C
M902M6-M8	M6-M8	M900, P100, P101, A117	4	P1004.9, P1014.9, A1173.0, M9002
M902M8-M10	M8-M10	M900, P100, P101, A117	4	P1006.4, P1016.4, A1174.0, M9003
M902M10-M12	M10-M12	M900, P100, P101, A117	4	P1007.8, P1017.8, A1174.2, M9003
M902M12-M14	M12-M14	M900, P100, P101, A117	4	P1009.3, P1019.3, A1176.0, M9004
M902M14-M16	M14-M16	M900, P100, P101, A117	4	P10010.7, P10110.7, A1178.0, M9005

A080

DORMER

空的成套展示盒
空置的展示架，因而能够选择合适的数量的钻头进行单独采购，红色的展示架标有多马的标志并配有各种多马钻头的图片，公制的或分制的钻头直径标记在三个架子上。

空展示柜

Product	Nr.	C
A080M1EMPTY	M1EMPTY	(1.00, 1.50, 2.00, 2.50, 3.00, 3.50, 4.00, 4.50, 5.00, 5.50, 6.00, 6.50, 7.00, 7.50, 8.00, 8.50, 9.00, 9.50, 10.00, 10.50, 11.00, 11.50, 12.00) mm
A080F1EMPTY	F1EMPTY	(1/16, 5/64, 3/32, 7/64, 1/8, 9/64, 5/32, 11/64, 3/16, 13/64, 7/32, 15/64, 1/4, 17/64, 9/32, 19/64, 5/16, 21/64, 11/32, 3/8, 13/32, 7/16, 1/2) inch

用于混合制造的工具。通常与带机床进给和数控系统的传统机床配合使用。适合中等切削参数。

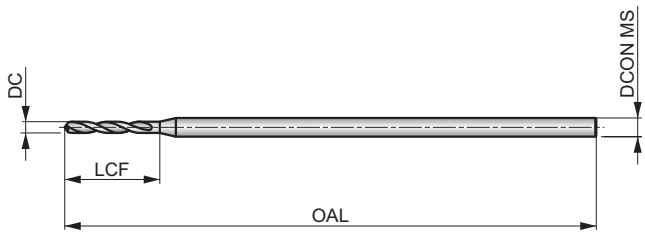
材料代码(BMC)	HSS-E	HSS	HSS-E	HSS-E	HSS-E	HM
基本标准组(BSG)	DIN 1899	DIN 1897	DIN 1897	DIN 1897	DIN ANSI	DIN 6539
有用长度直径比 (ULDR)	2.5×D	2.5×D	2.5×D	2.5×D	3×D	2.5×D
应用角度	118°	130°	130°	135°	130°	120°
涂层	Bright	TiN	Bronze	Bronze	Bright	TiN-Tip
柄部						
螺旋形式	λ.20-35°	λ.32-40°	λ.20-35°	λ.20-35°	λ.>35°	λ.20-35°
旋向(切削方向)	R	R	R	R	R	R
		ADX			PFX	
产品系列代码	A720	A520	A620	A117	A920	R023
PSF切削直径范围	0.15 - 1.40	3.00 - 13.00	2.50 - 13.00	1.00 - 13.00	1.00 - 20.00	1.00 - 12.00
	104	105	107	108	110	112
P	P1	■	■	◪	◪	■	■
	P2	■	■	◪	◪	■	■
	P3	■	■	◪	◪	■	■
	P4	◪	■	◪	■	■	■
M	M1	◪	■	■	■	■	
	M2	◪	■	■	■	■	
	M3	◪	■	■	■	■	
	M4	◪	■	■	■	■	
K	K1	■	■	◪	◪	◪	■
	K2	◪	■	◪	◪	◪	■
	K3	◪	■	◪	◪	◪	■
	K4	◪	■	◪	■	◪	◪
	K5	◪	■	◪	◪	◪	■
N	N1	◪	◪	◪	◪	◪	■
	N2	◪	■	◪	◪	◪	◪
	N3	◪	■	◪	◪	◪	◪
	N4	◪	■	◪	◪	◪	■
	N5						
S	S1	◪	■	◪	■	■	
	S2	◪	◪	◪	■	■	
	S3	◪	◪	◪	■	■	
	S4	◪	◪	◪	■	■	
H	H1						◪
	H2						◪
	H3						◪
	H4						

■推荐使用 ◪可以使用

A720

DORMER

含钴高速钢微钻，表面光亮处理。
直径从0.15至1.4的微钻，为了便于夹持，所有钻头的柄径为1.00或1.50，钻尖角118°，四后面型结构有助于自定心并减少切削力。



HSS-E	DIN 1899	2.5×D
118°	Bright	
λ20-35°	R	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■36 A	■40 A	■41 A	■31 A	■27 A	◪24 A	■25 A	■20 A	◪17 A	■15 A	◪13 A	◪10 A	◪30 A	◪26 A
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪27 A	◪22 A	◪12 A	◪10 A	◪9 A	◪15 A	■30 A	■22 A	■17 A	◪25 A	◪20 A	◪16 A	◪22 A	◪17 A
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 A	◪20 A	◪15 A	◪11 A	◪10 A	◪8 A	◪23 A	◪17 A	◪13 A	◪35 A	◪26 A	◪18 A	◪42 A	◪37 A
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
◪27 A	◪68 A	◪40 A	◪20 A	◪48 A	◪25 A	◪23 A	◪17 A	◪8 A	◪9 A	◪6 A	◪7 A	◪4 A	◪5 A
S4.2													
◪3 A													

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A720.15	0.15	0.0059	1.0	25.0	1.00
A720.18	0.18	0.0070	1.4	25.0	1.00
A720.2	0.20	0.0079	1.8	25.0	1.00
A720.22	0.22	0.0087	1.8	25.0	1.00
A720.25	0.25	0.0098	2.2	25.0	1.00
A720.27	0.27	0.0106	2.2	25.0	1.00
A720.28	0.28	0.0110	2.2	25.0	1.00
A720.3	0.30	0.0118	2.2	25.0	1.00
A720.35	0.35	0.0138	2.8	25.0	1.00
A720.4	0.40	0.0157	3.6	25.0	1.00
A720.45	0.45	0.0177	3.6	25.0	1.00
A720.5	0.50	0.0197	4.0	25.0	1.00
A720.55	0.55	0.0217	4.5	25.0	1.00

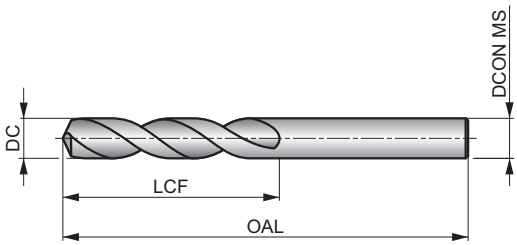
Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A720.6	0.60	0.0236	4.5	25.0	1.00
A720.62	0.62	0.0244	5.0	25.0	1.00
A720.65	0.65	0.0256	5.0	25.0	1.00
A720.7	0.70	0.0276	5.6	25.0	1.00
A720.75	0.75	0.0295	5.6	25.0	1.00
A720.8	0.80	0.0315	6.3	25.0	1.50
A720.85	0.85	0.0335	6.3	25.0	1.50
A720.9	0.90	0.0354	7.1	25.0	1.50
A720.95	0.95	0.0374	7.1	25.0	1.50
A7201.0	1.00	0.0394	8.0	25.0	1.50
A7201.05	1.05	0.0413	8.0	25.0	1.50
A7201.3	1.30	0.0512	10.0	25.0	1.50
A7201.4	1.40	0.0551	11.2	25.0	1.50

A520

DORMER

ADX 短型高速钢钻头，氮化钛涂层。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(H9公差)，130°钻尖角有助于自定心并减小切削力，只能用于持续输出进给的机床，氮化钛涂层延长了刀具寿命。

ADX



HSS	DIN 1897	2.5×D
130°	TiN	
λ32-40°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 53 M	■ 59 M	■ 61 M	■ 45 M	■ 40 K	■ 35 G	■ 31 I	■ 25 I	■ 21 G	■ 19 I	■ 16 G	◪ 13 E	■ 41 I	■ 35 I
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■ 37 I	■ 30 I	■ 19 I	■ 16 I	■ 14 I	■ 20 G	■ 48 M	■ 36 K	■ 27 K	■ 37 J	■ 30 J	■ 24 F	■ 33 J	■ 25 J
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
■ 20 F	■ 30 J	■ 23 J	■ 17 F	■ 14 F	■ 12 F	■ 34 J	■ 26 J	■ 20 F	◪ 55 I	◪ 41 I	■ 28 M	■ 57 K	■ 51 K
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
■ 37 K	■ 85 K	■ 50 I	◪ 25 E	◪ 65 G	■ 50 G	■ 35 F	■ 34 I	■ 20 G	◪ 4 B	◪ 15 G	◪ 10 E	◪ 11 G	◪ 7 E
S4.1	S4.2												
◪ 9 G	◪ 6 E												

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A5203.0	–	3.00	0.1181	16.0	46.0	3.00
A5203.1	–	3.10	0.1220	18.0	49.0	3.10
A5201/8	1/8	3.18	0.1250	18.0	49.0	3.18
A5203.2	–	3.20	0.1260	18.0	49.0	3.20
A5203.3	–	3.30	0.1299	18.0	49.0	3.30
A5203.4	–	3.40	0.1339	20.0	52.0	3.40
A5203.5	–	3.50	0.1378	20.0	52.0	3.50
A5203.6	–	3.60	0.1417	20.0	52.0	3.60
A5203.7	–	3.70	0.1457	20.0	52.0	3.70
A5203.8	–	3.80	0.1496	22.0	55.0	3.80
A5203.9	–	3.90	0.1535	22.0	55.0	3.90
A5204.0	–	4.00	0.1575	22.0	55.0	4.00
A5204.1	–	4.10	0.1614	22.0	55.0	4.10
A5204.2	–	4.20	0.1654	22.0	55.0	4.20
A5204.3	–	4.30	0.1693	24.0	58.0	4.30
A52011/64	11/64	4.37	0.1719	24.0	58.0	4.37
A5204.4	–	4.40	0.1732	24.0	58.0	4.40
A5204.5	–	4.50	0.1772	24.0	58.0	4.50
A5204.6	–	4.60	0.1811	24.0	58.0	4.60
A5204.7	–	4.70	0.1850	24.0	58.0	4.70
A5203/16	3/16	4.76	0.1875	26.0	62.0	4.76
A5204.8	–	4.80	0.1890	26.0	62.0	4.80
A5204.9	–	4.90	0.1929	26.0	62.0	4.90
A5205.0	–	5.00	0.1969	26.0	62.0	5.00

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A5205.1	–	5.10	0.2008	26.0	62.0	5.10
A5205.2	–	5.20	0.2047	26.0	62.0	5.20
A5205.3	–	5.30	0.2087	26.0	62.0	5.30
A5205.4	–	5.40	0.2126	28.0	66.0	5.40
A5205.5	–	5.50	0.2165	28.0	66.0	5.50
A5207/32	7/32	5.56	0.2188	28.0	66.0	5.56
A5205.6	–	5.60	0.2205	28.0	66.0	5.60
A5205.7	–	5.70	0.2244	28.0	66.0	5.70
A5205.8	–	5.80	0.2283	28.0	66.0	5.80
A5205.9	–	5.90	0.2323	28.0	66.0	5.90
A5206.0	–	6.00	0.2362	28.0	66.0	6.00
A5206.1	–	6.10	0.2402	31.0	70.0	6.10
A5206.2	–	6.20	0.2441	31.0	70.0	6.20
A5206.3	–	6.30	0.2480	31.0	70.0	6.30
A5201/4	1/4	6.35	0.2500	31.0	70.0	6.35
A5206.4	–	6.40	0.2520	31.0	70.0	6.40
A5206.5	–	6.50	0.2559	31.0	70.0	6.50
A5206.6	–	6.60	0.2598	31.0	70.0	6.60
A5206.7	–	6.70	0.2638	31.0	70.0	6.70
A52017/64	17/64	6.75	0.2656	34.0	74.0	6.75
A5206.8	–	6.80	0.2677	34.0	74.0	6.80
A5206.9	–	6.90	0.2717	34.0	74.0	6.90
A5207.0	–	7.00	0.2756	34.0	74.0	7.00
A5207.1	–	7.10	0.2795	34.0	74.0	7.10

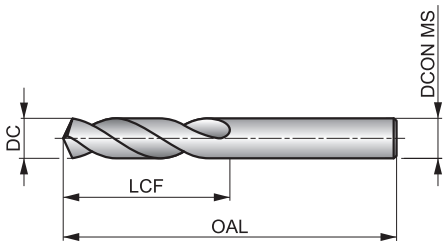
Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A5209/32	9/32	7.14	0.2813	34.0	74.0	7.14
A5207.2	–	7.20	0.2835	34.0	74.0	7.20
A5207.4	–	7.40	0.2913	34.0	74.0	7.40
A5207.5	–	7.50	0.2953	34.0	74.0	7.50
A5207.8	–	7.80	0.3071	37.0	79.0	7.80
A5207.9	–	7.90	0.3110	37.0	79.0	7.90
A5205/16	5/16	7.94	0.3125	37.0	79.0	7.94
A5208.0	–	8.00	0.3150	37.0	79.0	8.00
A5208.1	–	8.10	0.3189	37.0	79.0	8.10
A5208.2	–	8.20	0.3228	37.0	79.0	8.20
A5208.3	–	8.30	0.3268	37.0	79.0	8.30
A5208.4	–	8.40	0.3307	37.0	79.0	8.40
A5208.5	–	8.50	0.3346	37.0	79.0	8.50
A5208.6	–	8.60	0.3386	40.0	84.0	8.60
A5208.7	–	8.70	0.3425	40.0	84.0	8.70
A52011/32	11/32	8.73	0.3438	40.0	84.0	8.73
A5208.8	–	8.80	0.3465	40.0	84.0	8.80
A5209.0	–	9.00	0.3543	40.0	84.0	9.00
A5209.1	–	9.10	0.3583	40.0	84.0	9.10
A5209.5	–	9.50	0.3740	40.0	84.0	9.50
A5203/8	3/8	9.52	0.3750	43.0	89.0	9.52
A5209.6	–	9.60	0.3780	43.0	89.0	9.60
A5209.7	–	9.70	0.3819	43.0	89.0	9.70
A52025/64	25/64	9.92	0.3906	43.0	89.0	9.92

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A52010.0	–	10.00	0.3937	43.0	89.0	10.00
A52010.1	–	10.10	0.3976	43.0	89.0	10.10
A52010.2	–	10.20	0.4016	43.0	89.0	10.20
A52010.3	–	10.30	0.4055	43.0	89.0	10.30
A52013/32	13/32	10.32	0.4063	43.0	89.0	10.32
A52010.5	–	10.50	0.4134	43.0	89.0	10.50
A52027/64	27/64	10.72	0.4219	47.0	95.0	10.72
A52010.8	–	10.80	0.4252	47.0	95.0	10.80
A52011.0	–	11.00	0.4331	47.0	95.0	11.00
A52011.1	–	11.10	0.4370	47.0	95.0	11.10
A5207/16	7/16	11.11	0.4375	47.0	95.0	11.11
A52011.3	–	11.30	0.4449	47.0	95.0	11.30
A52011.5	–	11.50	0.4528	47.0	95.0	11.50
A52011.7	–	11.70	0.4606	47.0	95.0	11.70
A52011.8	–	11.80	0.4646	47.0	95.0	11.80
A52012.0	–	12.00	0.4724	51.0	102.0	12.00
A52012.1	–	12.10	0.4764	51.0	102.0	12.10
A52012.2	–	12.20	0.4803	51.0	102.0	12.20
A52031/64	31/64	12.30	0.4844	51.0	102.0	12.30
A52012.5	–	12.50	0.4921	51.0	102.0	12.50
A5201/2	1/2	12.70	0.5000	51.0	102.0	12.70
A52012.8	–	12.80	0.5039	51.0	102.0	12.80
A52013.0	–	13.00	0.5118	51.0	102.0	13.00

A620

DORMER

短刃型含钴高速钢(5%Co)钻头，青铜色，表面回火处理。
钻头具有130°的钻尖角，有助于自定心并降低切削力。青铜色涂层是一层薄薄的氧化层，也是含钴材料的标志，适用于多种材料的切削，不得用于手持式工具。



HSS-E	DIN 1897	2.5×D
130°	Bronze	
λ20-35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪40 H	◪45 H	◪46 H	◪34 H	◪30 G	◪27 F	◪27 G	◪21 G	◪18 F	◪16 G	◪13 F	◪11 E	■30 F	■26 F
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■27 F	■22 F	■13 H	■11 H	■10 H	■15 D	◪34 K	◪25 F	◪19 F	◪27 F	◪22 F	◪18 F	◪24 F	◪18 F
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪15 F	◪22 F	◪17 F	◪12 F	◪11 F	◪9 F	◪25 F	◪19 F	◪15 F	◪40 K	◪30 K	◪20 J	◪49 I	◪44 I
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪32 I	◪68 J	◪40 K	◪20 I	◪40 L	◪32 K	◪18 I	◪30 G	◪18 F	◪10 C	◪12 F	◪8 C	◪9 F	◪6 C
S4.1	S4.2												
◪7 F	◪5 C												

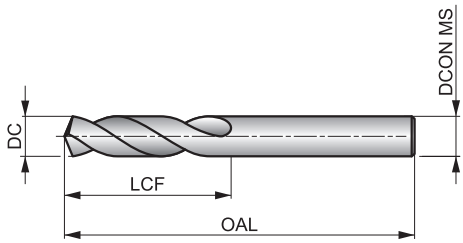
Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A6202.5	2.50	0.0984	14.0	43.0	2.50
A6202.6	2.60	0.1024	14.0	43.0	2.60
A6202.7	2.70	0.1063	16.0	46.0	2.70
A6202.8	2.80	0.1102	16.0	46.0	2.80
A6202.9	2.90	0.1142	16.0	46.0	2.90
A6203.0	3.00	0.1181	16.0	46.0	3.00
A6203.1	3.10	0.1220	18.0	49.0	3.10
A6203.2	3.20	0.1260	18.0	49.0	3.20
A6203.3	3.30	0.1299	18.0	49.0	3.30
A6203.4	3.40	0.1339	20.0	52.0	3.40
A6203.5	3.50	0.1378	20.0	52.0	3.50
A6204.0	4.00	0.1575	22.0	55.0	4.00
A6204.1	4.10	0.1614	22.0	55.0	4.10
A6204.2	4.20	0.1654	22.0	55.0	4.20
A6204.3	4.30	0.1693	24.0	58.0	4.30
A6204.5	4.50	0.1772	24.0	58.0	4.50
A6204.7	4.70	0.1850	24.0	58.0	4.70
A6204.9	4.90	0.1929	26.0	62.0	4.90
A6205.0	5.00	0.1969	26.0	62.0	5.00
A6205.1	5.10	0.2008	26.0	62.0	5.10
A6205.2	5.20	0.2047	26.0	62.0	5.20
A6205.3	5.30	0.2087	26.0	62.0	5.30
A6205.5	5.50	0.2165	28.0	66.0	5.50
A6205.6	5.60	0.2205	28.0	66.0	5.60
A6206.0	6.00	0.2362	28.0	66.0	6.00

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A6206.2	6.20	0.2441	31.0	70.0	6.20
A6206.3	6.30	0.2480	31.0	70.0	6.30
A6206.5	6.50	0.2559	31.0	70.0	6.50
A6206.8	6.80	0.2677	34.0	74.0	6.80
A6206.9	6.90	0.2717	34.0	74.0	6.90
A6207.0	7.00	0.2756	34.0	74.0	7.00
A6207.5	7.50	0.2953	34.0	74.0	7.50
A6207.8	7.80	0.3071	37.0	79.0	7.80
A6208.0	8.00	0.3150	37.0	79.0	8.00
A6208.2	8.20	0.3228	37.0	79.0	8.20
A6208.5	8.50	0.3346	37.0	79.0	8.50
A6208.7	8.70	0.3425	40.0	84.0	8.70
A6209.0	9.00	0.3543	40.0	84.0	9.00
A6209.5	9.50	0.3740	40.0	84.0	9.50
A62010.0	10.00	0.3937	43.0	89.0	10.00
A62010.2	10.20	0.4016	43.0	89.0	10.20
A62010.3	10.30	0.4055	43.0	89.0	10.30
A62010.5	10.50	0.4134	43.0	89.0	10.50
A62010.8	10.80	0.4252	47.0	95.0	10.80
A62011.0	11.00	0.4331	47.0	95.0	11.00
A62011.5	11.50	0.4528	47.0	95.0	11.50
A62012.0	12.00	0.4724	51.0	102.0	12.00
A62012.5	12.50	0.4921	51.0	102.0	12.50
A62013.0	13.00	0.5118	51.0	102.0	13.00

A117

DORMER

短刃型含钴高速钢(8%Co)钻头，青铜色，表面回火处理。
推荐应用于难加工材料的钻头，135°钻尖角有助于自定心，也降低了切削力，能够可靠地完成一个高精度和高质量的孔，青铜色涂层是一层薄薄的氧化层，也是含钴材料的标志。



HSS-E	DIN 1897	2.5×D
135°	Bronze	
λ20-35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪40 H	◪45 H	◪46 H	◪34 H	◪30 G	■27 F	◪27 G	◪21 G	■18 F	◪16 G	■13 F	■11 E	■30 F	■26 F
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■27 F	■22 F	■13 H	■11 H	■10 H	■15 D	◪34 K	◪25 F	◪19 F	◪27 F	◪22 F	■18 F	◪24 F	◪18 F
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
■15 F	◪22 F	◪17 F	■12 F	■11 F	■9 F	◪25 F	◪19 F	■15 F	◪35 K	◪26 K	◪18 J	◪48 I	◪43 I
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪31 I	◪68 J	◪40 K	◪20 I	◪35 M	◪28 K	◪17 I	■30 G	■18 F	■10 C	■12 F	■8 C	■9 F	■6 C
S4.1	S4.2												
■7 F	■5 C												

DC <= 1.5mm 118° 钻尖; DC < 3.00 mm 5% 钻

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1171.0	–	1.00	0.0394	6.0	26.0	1.00
A1171.1	–	1.10	0.0433	7.0	28.0	1.10
A1171.2	–	1.20	0.0472	8.0	30.0	1.20
A1171.3	–	1.30	0.0512	8.0	30.0	1.30
A1171.4	–	1.40	0.0551	9.0	32.0	1.40
A1171.5	–	1.50	0.0591	9.0	32.0	1.50
A1171.6	–	1.60	0.0630	10.0	34.0	1.60
A1171.7	–	1.70	0.0669	10.0	34.0	1.70
A1171.8	–	1.80	0.0709	11.0	36.0	1.80
A1171.9	–	1.90	0.0748	11.0	36.0	1.90
A1172.0	–	2.00	0.0787	12.0	38.0	2.00
A1172.1	–	2.10	0.0827	12.0	38.0	2.10
A1172.2	–	2.20	0.0866	13.0	40.0	2.20
A1172.3	–	2.30	0.0906	13.0	40.0	2.30
A1172.4	–	2.40	0.0945	14.0	43.0	2.40
A1172.5	–	2.50	0.0984	14.0	43.0	2.50
A1172.6	–	2.60	0.1024	14.0	43.0	2.60
A1172.7	–	2.70	0.1063	16.0	46.0	2.70
A1172.8	–	2.80	0.1102	16.0	46.0	2.80
A1172.9	–	2.90	0.1142	16.0	46.0	2.90
A1173.0	–	3.00	0.1181	16.0	46.0	3.00
A1173.1	–	3.10	0.1220	18.0	49.0	3.10
A1171/8	1/8	3.18	0.1250	18.0	49.0	3.18

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1173.2	–	3.20	0.1260	18.0	49.0	3.20
A1173.3	–	3.30	0.1299	18.0	49.0	3.30
A1173.4	–	3.40	0.1339	20.0	52.0	3.40
A1173.5	–	3.50	0.1378	20.0	52.0	3.50
A1173.6	–	3.60	0.1417	20.0	52.0	3.60
A1173.7	–	3.70	0.1457	20.0	52.0	3.70
A1173.8	–	3.80	0.1496	22.0	55.0	3.80
A1173.9	–	3.90	0.1535	22.0	55.0	3.90
A1175/32	5/32	3.97	0.1563	22.0	55.0	3.97
A1174.0	–	4.00	0.1575	22.0	55.0	4.00
A1174.1	–	4.10	0.1614	22.0	55.0	4.10
A1174.2	–	4.20	0.1654	22.0	55.0	4.20
A1174.3	–	4.30	0.1693	24.0	58.0	4.30
A1174.4	–	4.40	0.1732	24.0	58.0	4.40
A1174.5	–	4.50	0.1772	24.0	58.0	4.50
A1174.6	–	4.60	0.1811	24.0	58.0	4.60
A1174.7	–	4.70	0.1850	24.0	58.0	4.70
A1173/16	3/16	4.76	0.1875	26.0	62.0	4.76
A1174.8	–	4.80	0.1890	26.0	62.0	4.80
A1174.9	–	4.90	0.1929	26.0	62.0	4.90
A1175.0	–	5.00	0.1969	26.0	62.0	5.00
A1175.1	–	5.10	0.2008	26.0	62.0	5.10
A1175.2	–	5.20	0.2047	26.0	62.0	5.20

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1175.3	–	5.30	0.2087	26.0	62.0	5.30
A1175.4	–	5.40	0.2126	28.0	66.0	5.40
A1175.5	–	5.50	0.2165	28.0	66.0	5.50
A1175.6	–	5.60	0.2205	28.0	66.0	5.60
A1175.7	–	5.70	0.2244	28.0	66.0	5.70
A1175.8	–	5.80	0.2283	28.0	66.0	5.80
A1175.9	–	5.90	0.2323	28.0	66.0	5.90
A1176.0	–	6.00	0.2362	28.0	66.0	6.00
A1176.1	–	6.10	0.2402	31.0	70.0	6.10
A1176.2	–	6.20	0.2441	31.0	70.0	6.20
A1176.3	–	6.30	0.2480	31.0	70.0	6.30
A1171/4	1/4	6.35	0.2500	31.0	70.0	6.35
A1176.4	–	6.40	0.2520	31.0	70.0	6.40
A1176.5	–	6.50	0.2559	31.0	70.0	6.50
A1176.6	–	6.60	0.2598	31.0	70.0	6.60
A1176.7	–	6.70	0.2638	31.0	70.0	6.70
A1176.8	–	6.80	0.2677	34.0	74.0	6.80
A1176.9	–	6.90	0.2717	34.0	74.0	6.90
A1177.0	–	7.00	0.2756	34.0	74.0	7.00
A1177.1	–	7.10	0.2795	34.0	74.0	7.10
A1177.2	–	7.20	0.2835	34.0	74.0	7.20
A1177.3	–	7.30	0.2874	34.0	74.0	7.30
A1177.4	–	7.40	0.2913	34.0	74.0	7.40
A1177.5	–	7.50	0.2953	34.0	74.0	7.50
A1177.6	–	7.60	0.2992	37.0	79.0	7.60
A1177.7	–	7.70	0.3031	37.0	79.0	7.70
A1177.8	–	7.80	0.3071	37.0	79.0	7.80

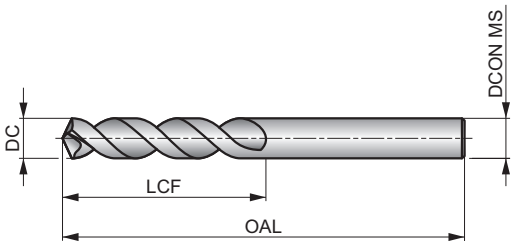
Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A1177.9	–	7.90	0.3110	37.0	79.0	7.90
A1175/16	5/16	7.94	0.3125	37.0	79.0	7.94
A1178.0	–	8.00	0.3150	37.0	79.0	8.00
A1178.1	–	8.10	0.3189	37.0	79.0	8.10
A1178.2	–	8.20	0.3228	37.0	79.0	8.20
A1178.3	–	8.30	0.3268	37.0	79.0	8.30
A1178.4	–	8.40	0.3307	37.0	79.0	8.40
A1178.5	–	8.50	0.3346	37.0	79.0	8.50
A1178.6	–	8.60	0.3386	40.0	84.0	8.60
A1178.7	–	8.70	0.3425	40.0	84.0	8.70
A1178.8	–	8.80	0.3465	40.0	84.0	8.80
A1178.9	–	8.90	0.3504	40.0	84.0	8.90
A1179.0	–	9.00	0.3543	40.0	84.0	9.00
A1179.1	–	9.10	0.3583	40.0	84.0	9.10
A1179.2	–	9.20	0.3622	40.0	84.0	9.20
A1179.3	–	9.30	0.3661	40.0	84.0	9.30
A1179.5	–	9.50	0.3740	40.0	84.0	9.50
A1179.9	–	9.90	0.3898	43.0	89.0	9.90
A11710.0	–	10.00	0.3937	43.0	89.0	10.00
A11710.2	–	10.20	0.4016	43.0	89.0	10.20
A11710.5	–	10.50	0.4134	43.0	89.0	10.50
A11711.0	–	11.00	0.4331	47.0	95.0	11.00
A11711.5	–	11.50	0.4528	47.0	95.0	11.50
A11712.0	–	12.00	0.4724	51.0	102.0	12.00
A1171/2	1/2	12.70	0.5000	51.0	102.0	12.70
A11713.0	–	13.00	0.5118	51.0	102.0	13.00

A920

DORMER

短型PFX含钴高速钢钻头，表面光亮处理。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(H10公差)，自定心的130°钻尖角和特殊抛物线槽设计，有助于一次进刀完成深孔加工，适用于多种材料的切削。

PFX



HSS-E	DIN ANSI	3×D
130°	Bright	
λ>35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■42 J	■47 J	■49 J	■36 J	■32 I	■28 E	■34 I	■27 I	■23 E	■20 I	■17 E	■14 E	■21 F	■17 F
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■18 F	■15 F	■8 F	■7 F	■6 F	■9 D	◪34 L	◪25 L	◪19 L	◪32 L	◪26 L	◪21 J	◪28 L	◪22 L
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪17 J	◪26 L	◪20 L	◪14 J	◪12 J	◪10 J	◪30 L	◪22 L	◪17 J	◪75 L	◪56 L	■38 N	◪62 N	◪55 N
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
◪40 N	◪112 J	◪66 J	◪33 H	◪55 J	◪40 H	■30 G	■18 G	■10 C	■12 G	■8 E	■9 G	■6 E	■7 G
S4.2													
■5 E													

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9201.0	–	1.00	0.0394	6.0	26.0	1.00
A9203/64	3/64	1.19	0.0469	13.0	35.0	1.19
A9201.2	–	1.20	0.0472	8.0	30.0	1.20
A9201.25	–	1.25	0.0492	8.0	30.0	1.25
A9201.3	–	1.30	0.0512	8.0	30.0	1.30
A9201.35	–	1.35	0.0531	9.0	32.0	1.35
A9201.4	–	1.40	0.0551	9.0	32.0	1.40
A9201.5	–	1.50	0.0591	9.0	32.0	1.50
A9201.55	–	1.55	0.0610	10.0	34.0	1.55
A9201/16	1/16	1.59	0.0625	16.0	41.0	1.59
A9201.6	–	1.60	0.0630	10.0	34.0	1.60
A9201.7	–	1.70	0.0669	10.0	34.0	1.70
A9201.8	–	1.80	0.0709	11.0	36.0	1.80
A9201.9	–	1.90	0.0748	11.0	36.0	1.90
A9205/64	5/64	1.98	0.0781	17.0	43.0	1.98
A9202.0	–	2.00	0.0787	12.0	38.0	2.00
A9202.1	–	2.10	0.0827	12.0	38.0	2.10
A9202.15	–	2.15	0.0846	13.0	40.0	2.15
A9202.2	–	2.20	0.0866	13.0	40.0	2.20
A9202.3	–	2.30	0.0906	13.0	40.0	2.30
A9202.35	–	2.35	0.0925	14.0	43.0	2.35
A9203/32	3/32	2.38	0.0938	19.0	41.0	2.38
A9202.4	–	2.40	0.0945	14.0	43.0	2.40
A9202.5	–	2.50	0.0984	14.0	43.0	2.50

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9202.6	–	2.60	0.1024	14.0	43.0	2.60
A9202.7	–	2.70	0.1063	16.0	46.0	2.70
A9207/64	7/64	2.78	0.1094	21.0	46.0	2.78
A9202.8	–	2.80	0.1102	16.0	46.0	2.80
A9202.9	–	2.90	0.1142	16.0	46.0	2.90
A9203.0	–	3.00	0.1181	16.0	46.0	3.00
A9203.1	–	3.10	0.1220	18.0	49.0	3.10
A9201/8	1/8	3.18	0.1250	22.0	48.0	3.18
A9203.2	–	3.20	0.1260	18.0	49.0	3.20
A9203.3	–	3.30	0.1299	18.0	49.0	3.30
A9203.4	–	3.40	0.1339	20.0	52.0	3.40
A9203.5	–	3.50	0.1378	20.0	52.0	3.50
A9209/64	9/64	3.57	0.1406	24.0	49.0	3.57
A9203.6	–	3.60	0.1417	20.0	52.0	3.60
A9203.7	–	3.70	0.1457	20.0	52.0	3.70
A9203.8	–	3.80	0.1496	22.0	55.0	3.80
A9205/32	5/32	3.97	0.1563	25.0	52.0	3.97
A9204.0	–	4.00	0.1575	22.0	55.0	4.00
A9204.1	–	4.10	0.1614	22.0	55.0	4.10
A9204.2	–	4.20	0.1654	22.0	55.0	4.20
A9204.3	–	4.30	0.1693	24.0	58.0	4.30
A92011/64	11/64	4.37	0.1719	27.0	54.0	4.37
A9204.4	–	4.40	0.1732	24.0	58.0	4.40
A9204.5	–	4.50	0.1772	24.0	58.0	4.50

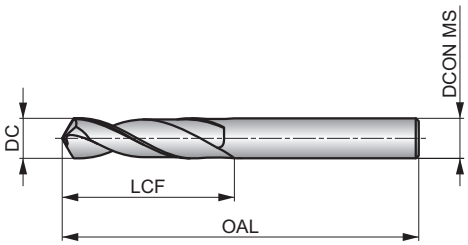
Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9204.6	–	4.60	0.1811	24.0	58.0	4.60
A9203/16	3/16	4.76	0.1875	29.0	56.0	4.76
A9204.8	–	4.80	0.1890	26.0	62.0	4.80
A9204.9	–	4.90	0.1929	26.0	62.0	4.90
A9205.0	–	5.00	0.1969	26.0	62.0	5.00
A9205.1	–	5.10	0.2008	26.0	62.0	5.10
A92013/64	13/64	5.16	0.2031	30.0	57.0	5.16
A9205.2	–	5.20	0.2047	26.0	62.0	5.20
A9205.3	–	5.30	0.2087	26.0	62.0	5.30
A9205.4	–	5.40	0.2126	28.0	66.0	5.40
A9205.5	–	5.50	0.2165	28.0	66.0	5.50
A9207/32	7/32	5.56	0.2188	32.0	60.0	5.56
A9205.6	–	5.60	0.2205	28.0	66.0	5.60
A9205.7	–	5.70	0.2244	28.0	66.0	5.70
A9205.9	–	5.90	0.2323	28.0	66.0	5.90
A9206.0	–	6.00	0.2362	28.0	66.0	6.00
A9206.2	–	6.20	0.2441	31.0	70.0	6.20
A9201/4	1/4	6.35	0.2500	35.0	64.0	6.35
A9206.4	–	6.40	0.2520	31.0	70.0	6.40
A9206.5	–	6.50	0.2559	31.0	70.0	6.50
A9206.6	–	6.60	0.2598	31.0	70.0	6.60
A9206.7	–	6.70	0.2638	31.0	70.0	6.70
A92017/64	17/64	6.75	0.2656	37.0	67.0	6.75
A9206.8	–	6.80	0.2677	34.0	74.0	6.80
A9206.9	–	6.90	0.2717	34.0	74.0	6.90
A9207.0	–	7.00	0.2756	34.0	74.0	7.00
A9207.1	–	7.10	0.2795	34.0	74.0	7.10
A9209/32	9/32	7.14	0.2813	38.0	68.0	7.14
A9207.5	–	7.50	0.2953	34.0	74.0	7.50
A92019/64	19/64	7.54	0.2969	40.0	70.0	7.54
A9207.8	–	7.80	0.3071	37.0	79.0	7.80
A9205/16	5/16	7.94	0.3125	41.0	71.0	7.94
A9208.0	–	8.00	0.3150	37.0	79.0	8.00
A9208.3	–	8.30	0.3268	37.0	79.0	8.30

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9208.4	–	8.40	0.3307	37.0	79.0	8.40
A9208.5	–	8.50	0.3346	37.0	79.0	8.50
A9208.6	–	8.60	0.3386	40.0	84.0	8.60
A9208.7	–	8.70	0.3425	40.0	84.0	8.70
A9209.0	–	9.00	0.3543	40.0	84.0	9.00
A9209.5	–	9.50	0.3740	40.0	84.0	9.50
A9203/8	3/8	9.52	0.3750	46.0	79.0	9.52
A92025/64	25/64	9.92	0.3906	48.0	83.0	9.92
A92010.0	–	10.00	0.3937	43.0	89.0	10.00
A92010.2	–	10.20	0.4016	43.0	89.0	10.20
A92010.3	–	10.30	0.4055	43.0	89.0	10.30
A92010.5	–	10.50	0.4134	43.0	89.0	10.50
A92027/64	27/64	10.72	0.4219	51.0	86.0	10.72
A92010.8	–	10.80	0.4252	47.0	95.0	10.80
A92011.0	–	11.00	0.4331	47.0	95.0	11.00
A9207/16	7/16	11.11	0.4375	52.0	87.0	11.11
A92011.5	–	11.50	0.4528	47.0	95.0	11.50
A92011.8	–	11.80	0.4646	47.0	95.0	11.80
A92012.0	–	12.00	0.4724	51.0	102.0	12.00
A92012.5	–	12.50	0.4921	51.0	102.0	12.50
A9201/2	1/2	12.70	0.5000	57.0	95.0	12.70
A92013.0	–	13.00	0.5118	51.0	102.0	13.00
A92014.0	–	14.00	0.5512	54.0	107.0	14.00
A92014.5	–	14.50	0.5709	56.0	111.0	14.50
A92016.0	–	16.00	0.6299	58.0	115.0	16.00
A92016.5	–	16.50	0.6496	60.0	119.0	16.50
A92021/32	21/32	16.67	0.6563	73.0	114.0	16.67
A92017.0	–	17.00	0.6693	60.0	119.0	17.00
A92017.5	–	17.50	0.6890	62.0	123.0	17.50
A92018.0	–	18.00	0.7087	62.0	123.0	18.00
A92023/32	23/32	18.26	0.7188	76.0	121.0	18.26
A92019.0	–	19.00	0.7480	64.0	127.0	19.00
A92025/32	25/32	19.84	0.7813	83.0	130.0	19.84
A92020.0	–	20.00	0.7874	66.0	131.0	20.00

R023

DORMER

整硬合金钻头，TiN 尖端涂层
多功能入门级钻头，钻尖角度为 120°，采用4后面分离式钻尖，可降低阻力，CTW 刀槽结构可提高穿透率。TiN刀尖涂层可提高性能并延长刀具寿命。适用于各种工件材料，包括数控机床和普通机床。



HM	DIN 6539	2.5×D
120°	TiN-Tip	
λ20-35°	R	DC h7

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	K1.1	K1.2
■99 T	■111 T	■115 T	■85 T	■75 T	■66 T	■66 T	■53 T	■45 T	■40 S	■34 S	■27 S	■75 U	■56 U
K1.3	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**
■42 U	■68 U	■55 U	■44 U	■60 U	■46 U	■37 U	◪55 T	◪42 T	◪31 T	◪26 T	◪22 T	■63 U	■47 U
K5.3	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N4.1**	**N4.2**	**H1.1**	**H2.1**	**H3.1**
■37 U	■150 W	■113 W	■75 W	◪129 W	◪116 W	◪84 W	◪317 W	◪190 W	■60 V	■100 V	◪34 S	◪20 S	◪22 S

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R0231.0	1.00	0.0394	6.0	26.0	1.00
R0231.1	1.10	0.0433	7.0	28.0	1.10
R0231.2	1.20	0.0472	8.0	30.0	1.20
R0231.3	1.30	0.0512	8.0	30.0	1.30
R0231.4	1.40	0.0551	9.0	32.0	1.40
R0231.5	1.50	0.0591	9.0	32.0	1.50
R0231.6	1.60	0.0630	10.0	34.0	1.60
R0231.7	1.70	0.0669	10.0	34.0	1.70
R0231.8	1.80	0.0709	11.0	36.0	1.80
R0231.9	1.90	0.0748	11.0	36.0	1.90
R0232.0	2.00	0.0787	12.0	38.0	2.00
R0232.1	2.10	0.0827	12.0	38.0	2.10
R0232.2	2.20	0.0866	13.0	40.0	2.20
R0232.3	2.30	0.0906	13.0	40.0	2.30
R0232.4	2.40	0.0945	14.0	43.0	2.40
R0232.5	2.50	0.0984	14.0	43.0	2.50
R0232.6	2.60	0.1024	14.0	43.0	2.60
R0232.7	2.70	0.1063	16.0	46.0	2.70
R0232.8	2.80	0.1102	16.0	46.0	2.80
R0232.9	2.90	0.1142	16.0	46.0	2.90
R0233.0	3.00	0.1181	16.0	46.0	3.00
R0233.1	3.10	0.1220	18.0	49.0	3.10
R0233.2	3.20	0.1260	18.0	49.0	3.20
R0233.3	3.30	0.1299	18.0	49.0	3.30
R0233.4	3.40	0.1339	20.0	52.0	3.40
R0233.5	3.50	0.1378	20.0	52.0	3.50
R0233.6	3.60	0.1417	20.0	52.0	3.60
R0233.7	3.70	0.1457	20.0	52.0	3.70

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R0233.8	3.80	0.1496	22.0	55.0	3.80
R0233.9	3.90	0.1535	22.0	55.0	3.90
R0234.0	4.00	0.1575	22.0	55.0	4.00
R0234.1	4.10	0.1614	22.0	55.0	4.10
R0234.2	4.20	0.1654	22.0	55.0	4.20
R0234.3	4.30	0.1693	24.0	58.0	4.30
R0234.4	4.40	0.1732	24.0	58.0	4.40
R0234.5	4.50	0.1772	24.0	58.0	4.50
R0234.6	4.60	0.1811	24.0	58.0	4.60
R0234.7	4.70	0.1850	24.0	58.0	4.70
R0234.8	4.80	0.1890	26.0	62.0	4.80
R0234.9	4.90	0.1929	26.0	62.0	4.90
R0235.0	5.00	0.1969	26.0	62.0	5.00
R0235.1	5.10	0.2008	26.0	62.0	5.10
R0235.2	5.20	0.2047	26.0	62.0	5.20
R0235.3	5.30	0.2087	26.0	62.0	5.30
R0235.4	5.40	0.2126	28.0	66.0	5.40
R0235.5	5.50	0.2165	28.0	66.0	5.50
R0235.6	5.60	0.2205	28.0	66.0	5.60
R0235.7	5.70	0.2244	28.0	66.0	5.70
R0235.8	5.80	0.2283	28.0	66.0	5.80
R0235.9	5.90	0.2323	28.0	66.0	5.90
R0236.0	6.00	0.2362	28.0	66.0	6.00
R0236.1	6.10	0.2402	31.0	70.0	6.10
R0236.2	6.20	0.2441	31.0	70.0	6.20
R0236.3	6.30	0.2480	31.0	70.0	6.30
R0236.4	6.40	0.2520	31.0	70.0	6.40
R0236.5	6.50	0.2559	31.0	70.0	6.50

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
R0236.6	6.60	0.2598	31.0	70.0	6.60
R0236.7	6.70	0.2638	31.0	70.0	6.70
R0236.8	6.80	0.2677	34.0	74.0	6.80
R0236.9	6.90	0.2717	34.0	74.0	6.90
R0237.0	7.00	0.2756	34.0	74.0	7.00
R0237.1	7.10	0.2795	34.0	74.0	7.10
R0237.2	7.20	0.2835	34.0	74.0	7.20
R0237.3	7.30	0.2874	34.0	74.0	7.30
R0237.4	7.40	0.2913	34.0	74.0	7.40
R0237.5	7.50	0.2953	34.0	74.0	7.50
R0237.6	7.60	0.2992	37.0	79.0	7.60
R0237.7	7.70	0.3031	37.0	79.0	7.70
R0237.8	7.80	0.3071	37.0	79.0	7.80
R0237.9	7.90	0.3110	37.0	79.0	7.90
R0238.0	8.00	0.3150	37.0	79.0	8.00
R0238.1	8.10	0.3189	37.0	79.0	8.10
R0238.2	8.20	0.3228	37.0	79.0	8.20
R0238.3	8.30	0.3268	37.0	79.0	8.30
R0238.4	8.40	0.3307	37.0	79.0	8.40
R0238.5	8.50	0.3346	37.0	79.0	8.50

Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
R0238.6	8.60	0.3386	40.0	84.0	8.60
R0238.7	8.70	0.3425	40.0	84.0	8.70
R0238.8	8.80	0.3465	40.0	84.0	8.80
R0238.9	8.90	0.3504	40.0	84.0	8.90
R0239.0	9.00	0.3543	40.0	84.0	9.00
R0239.1	9.10	0.3583	40.0	84.0	9.10
R0239.2	9.20	0.3622	40.0	84.0	9.20
R0239.3	9.30	0.3661	40.0	84.0	9.30
R0239.4	9.40	0.3701	40.0	84.0	9.40
R0239.5	9.50	0.3740	40.0	84.0	9.50
R0239.6	9.60	0.3780	43.0	89.0	9.60
R0239.7	9.70	0.3819	43.0	89.0	9.70
R0239.8	9.80	0.3858	43.0	89.0	9.80
R0239.9	9.90	0.3898	43.0	89.0	9.90
R02310.0	10.00	0.3937	43.0	89.0	10.00
R02310.2	10.20	0.4016	43.0	89.0	10.20
R02310.5	10.50	0.4134	43.0	89.0	10.50
R02311.0	11.00	0.4331	47.0	95.0	11.00
R02311.5	11.50	0.4528	47.0	95.0	11.50
R02312.0	12.00	0.4724	51.0	102.0	12.00

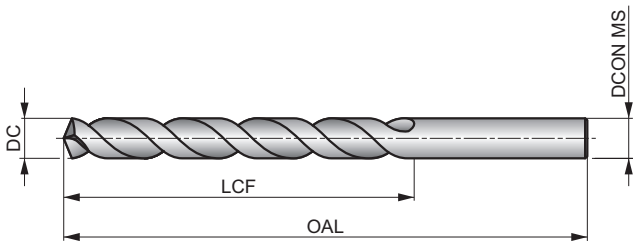
材料代码(BMC)	HSS-E	HSS-E	HSS	HSS-E	HM	
基本标准组(BSG)	DIN 338	DIN 338	DIN 338	DORMER	DIN 338	
有用长度直径比 (ULDR)	4×D	4×D	4×D	5×D	4×D	
应用角度	135°	130°	130°	130°	120°	
涂层	Bronze	Bright	TiN	TiAlN Top	TiN-Tip	
柄部				DIN 6535HA		
螺旋形式	λ 20-35°	VA	λ 32-40°	λ >35°	λ 20-35°	
旋向(切削方向)	R	R	R	R	R	
冷却液 (CSP)						
			ADX	ADX		
产品系列代码	A777	A147	A510	A553	R003	
PSF切削直径范围	0.30 - 16.00	0.30 - 15.0	3.00 - 14.00	5.00 - 18.00	1.00 - 14.00	
	116	118	120	122	123	
P	P1	◪	◪	■	■	■
	P2	◪	◪	■	■	■
	P3	◪	◪	■	■	■
	P4	■	◪	■	■	■
M	M1	◪	■	■	■	
	M2	◪	■	■	■	
	M3	◪	■	■	■	
	M4	◪	◪	◪	◪	
K	K1	◪	◪	■	■	■
	K2	◪	◪	■	■	■
	K3	◪	◪	■	■	■
	K4	■	◪	■	■	◪
	K5	◪	◪	■	■	■
N	N1	◪	◪	◪	◪	■
	N2	◪	◪	■	■	◪
	N3	◪	◪	■	■	■
	N4		◪	■	■	■
	N5					
S	S1	■	■	◪	◪	
	S2	◪	◪	◪	◪	
	S3	◪	◪	◪	◪	
	S4	◪	◪	◪	◪	
H	H1					◪
	H2					◪
	H3					◪
	H4					

■推荐使用 ◪可以使用

A777

DORMER

普通长度含钴高速钢(8%Co)钻头，青铜色，表面回火处理。
在加工高强度材料时性能优异，同时确保了孔径精度和孔壁光洁度，135°钻尖角有助于自定心。青铜色涂层是在刀具表面形成的一层薄薄的氧化层，是8%含钴高速钢钻头的标志。



HSS-E	DIN 338	4×D
135°	Bronze	
λ20-35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪36 H	◪40 H	◪41 H	◪31 H	◪27 G	■24 E	◪25 F	◪20 F	■17 E	◪15 F	■13 E	■10 D	◪30 E	◪26 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪27 E	◪22 E	◪13 G	◪11 G	◪10 G	◪15 C	◪35 H	◪26 D	◪19 D	◪27 E	◪22 E	■18 E	◪24 E	◪18 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
■15 E	◪22 E	◪17 E	■12 E	■11 E	■9 E	◪25 E	◪19 E	■15 E	◪33 J	◪25 J	◪17 I	◪46 H	◪42 H
N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2	
◪30 H	◪68 H	◪40 F	◪20 H	■28 F	■20 D	■11 C	■9 E	◪8 B	■7 E	◪6 B	■5 E	◪5 B	

NAS907J. DC <= 1.4mm 4后面钻尖
该系列产品有套装提供。请参见A295

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A777.3	–	0.30	0.0118	3.0	19.0	0.30
A777.35	–	0.35	0.0138	4.0	19.0	0.35
A777.4	–	0.40	0.0157	5.0	20.0	0.40
A777.45	–	0.45	0.0177	5.0	20.0	0.45
A777.5	–	0.50	0.0197	6.0	22.0	0.50
A777.55	–	0.55	0.0217	7.0	24.0	0.55
A777.6	–	0.60	0.0236	7.0	24.0	0.60
A777.65	–	0.65	0.0256	8.0	26.0	0.65
A777.7	–	0.70	0.0276	9.0	28.0	0.70
A777.8	–	0.80	0.0315	10.0	30.0	0.80
A777.9	–	0.90	0.0354	11.0	32.0	0.90
A777.95	–	0.95	0.0374	11.0	32.0	0.95
A7771.0	–	1.00	0.0394	12.0	34.0	1.00
A7771.1	–	1.10	0.0433	14.0	36.0	1.10
A7771.2	–	1.20	0.0472	16.0	38.0	1.20
A7771.3	–	1.30	0.0512	16.0	38.0	1.30
A7771.4	–	1.40	0.0551	18.0	40.0	1.40
A7771.5	–	1.50	0.0591	18.0	40.0	1.50
A7771/16	1/16	1.59	0.0625	20.0	43.0	1.59
A7771.6	–	1.60	0.0630	20.0	43.0	1.60
A7771.7	–	1.70	0.0669	20.0	43.0	1.70
A7771.8	–	1.80	0.0709	22.0	46.0	1.80
A7771.9	–	1.90	0.0748	22.0	46.0	1.90
A7775/64	5/64	1.98	0.0781	24.0	49.0	1.98

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A7772.0	–	2.00	0.0787	24.0	49.0	2.00
A7772.1	–	2.10	0.0827	24.0	49.0	2.10
A7772.2	–	2.20	0.0866	27.0	53.0	2.20
A7772.3	–	2.30	0.0906	27.0	53.0	2.30
A7773/32	3/32	2.38	0.0938	30.0	57.0	2.38
A7772.4	–	2.40	0.0945	30.0	57.0	2.40
A7772.5	–	2.50	0.0984	30.0	57.0	2.50
A7772.6	–	2.60	0.1024	30.0	57.0	2.60
A7772.7	–	2.70	0.1063	33.0	61.0	2.70
A7777/64	7/64	2.78	0.1094	33.0	61.0	2.78
A7772.8	–	2.80	0.1102	33.0	61.0	2.80
A7772.9	–	2.90	0.1142	33.0	61.0	2.90
A7773.0	–	3.00	0.1181	33.0	61.0	3.00
A7773.1	–	3.10	0.1220	36.0	65.0	3.10
A7771/8	1/8	3.18	0.1250	36.0	65.0	3.18
A7773.2	–	3.20	0.1260	36.0	65.0	3.20
A7773.3	–	3.30	0.1299	36.0	65.0	3.30
A7773.4	–	3.40	0.1339	39.0	70.0	3.40
A7773.5	–	3.50	0.1378	39.0	70.0	3.50
A7779/64	9/64	3.57	0.1406	39.0	70.0	3.57
A7773.6	–	3.60	0.1417	39.0	70.0	3.60
A7773.7	–	3.70	0.1457	39.0	70.0	3.70
A7773.8	–	3.80	0.1496	43.0	75.0	3.80
A7773.9	–	3.90	0.1535	43.0	75.0	3.90

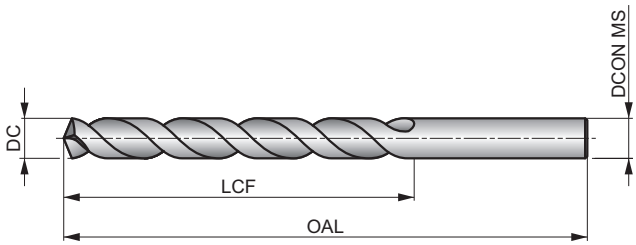
Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A7775/32	5/32	3.97	0.1563	43.0	75.0	3.97
A7774.0	–	4.00	0.1575	43.0	75.0	4.00
A7774.1	–	4.10	0.1614	43.0	75.0	4.10
A7774.2	–	4.20	0.1654	43.0	75.0	4.20
A7774.3	–	4.30	0.1693	47.0	80.0	4.30
A77711/64	11/64	4.37	0.1719	47.0	80.0	4.37
A7774.4	–	4.40	0.1732	47.0	80.0	4.40
A7774.5	–	4.50	0.1772	47.0	80.0	4.50
A7774.6	–	4.60	0.1811	47.0	80.0	4.60
A7774.7	–	4.70	0.1850	47.0	80.0	4.70
A7773/16	3/16	4.76	0.1875	52.0	86.0	4.76
A7774.8	–	4.80	0.1890	52.0	86.0	4.80
A7774.9	–	4.90	0.1929	52.0	86.0	4.90
A7775.0	–	5.00	0.1969	52.0	86.0	5.00
A7775.1	–	5.10	0.2008	52.0	86.0	5.10
A77713/64	13/64	5.16	0.2031	52.0	86.0	5.16
A7775.2	–	5.20	0.2047	52.0	86.0	5.20
A7775.3	–	5.30	0.2087	52.0	86.0	5.30
A7775.4	–	5.40	0.2126	57.0	93.0	5.40
A7775.5	–	5.50	0.2165	57.0	93.0	5.50
A7777/32	7/32	5.56	0.2188	57.0	93.0	5.56
A7775.6	–	5.60	0.2205	57.0	93.0	5.60
A7775.7	–	5.70	0.2244	57.0	93.0	5.70
A7775.8	–	5.80	0.2283	57.0	93.0	5.80
A7775.9	–	5.90	0.2323	57.0	93.0	5.90
A77715/64	15/64	5.95	0.2344	57.0	93.0	5.95
A7776.0	–	6.00	0.2362	57.0	93.0	6.00
A7776.1	–	6.10	0.2402	63.0	101.0	6.10
A7776.2	–	6.20	0.2441	63.0	101.0	6.20
A7776.3	–	6.30	0.2480	63.0	101.0	6.30
A7771/4	1/4	6.35	0.2500	63.0	101.0	6.35
A7776.4	–	6.40	0.2520	63.0	101.0	6.40
A7776.5	–	6.50	0.2559	63.0	101.0	6.50
A7776.6	–	6.60	0.2598	63.0	101.0	6.60
A7776.7	–	6.70	0.2638	63.0	101.0	6.70
A77717/64	17/64	6.75	0.2656	69.0	109.0	6.75
A7776.8	–	6.80	0.2677	69.0	109.0	6.80
A7776.9	–	6.90	0.2717	69.0	109.0	6.90
A7777.0	–	7.00	0.2756	69.0	109.0	7.00
A7777.1	–	7.10	0.2795	69.0	109.0	7.10
A7779/32	9/32	7.14	0.2813	69.0	109.0	7.14
A7777.2	–	7.20	0.2835	69.0	109.0	7.20
A7777.3	–	7.30	0.2874	69.0	109.0	7.30
A7777.4	–	7.40	0.2913	69.0	109.0	7.40
A7777.5	–	7.50	0.2953	69.0	109.0	7.50
A77719/64	19/64	7.54	0.2969	75.0	117.0	7.54
A7777.6	–	7.60	0.2992	75.0	117.0	7.60
A7777.7	–	7.70	0.3031	75.0	117.0	7.70
A7777.8	–	7.80	0.3071	75.0	117.0	7.80
A7777.9	–	7.90	0.3110	75.0	117.0	7.90
A7775/16	5/16	7.94	0.3125	75.0	117.0	7.94
A7778.0	–	8.00	0.3150	75.0	117.0	8.00

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A7778.1	–	8.10	0.3189	75.0	117.0	8.10
A7778.2	–	8.20	0.3228	75.0	117.0	8.20
A7778.3	–	8.30	0.3268	75.0	117.0	8.30
A77721/64	21/64	8.33	0.3281	75.0	117.0	8.33
A7778.4	–	8.40	0.3307	75.0	117.0	8.40
A7778.5	–	8.50	0.3346	75.0	117.0	8.50
A7778.6	–	8.60	0.3386	81.0	125.0	8.60
A7778.7	–	8.70	0.3425	81.0	125.0	8.70
A77711/32	11/32	8.73	0.3438	81.0	125.0	8.73
A7778.8	–	8.80	0.3465	81.0	125.0	8.80
A7778.9	–	8.90	0.3504	81.0	125.0	8.90
A7779.0	–	9.00	0.3543	81.0	125.0	9.00
A7779.1	–	9.10	0.3583	81.0	125.0	9.10
A77723/64	23/64	9.13	0.3594	81.0	125.0	9.13
A7779.2	–	9.20	0.3622	81.0	125.0	9.20
A7779.3	–	9.30	0.3661	81.0	125.0	9.30
A7779.4	–	9.40	0.3701	81.0	125.0	9.40
A7779.5	–	9.50	0.3740	81.0	125.0	9.50
A7773/8	3/8	9.52	0.3750	87.0	133.0	9.52
A7779.6	–	9.60	0.3780	87.0	133.0	9.60
A7779.7	–	9.70	0.3819	87.0	133.0	9.70
A7779.8	–	9.80	0.3858	87.0	133.0	9.80
A7779.9	–	9.90	0.3898	87.0	133.0	9.90
A77725/64	25/64	9.92	0.3906	87.0	133.0	9.92
A77710.0	–	10.00	0.3937	87.0	133.0	10.00
A77710.1	–	10.10	0.3976	87.0	133.0	10.10
A77710.2	–	10.20	0.4016	87.0	133.0	10.20
A77713/32	13/32	10.32	0.4063	87.0	133.0	10.32
A77710.5	–	10.50	0.4134	87.0	133.0	10.50
A77727/64	27/64	10.72	0.4219	94.0	142.0	10.72
A77710.8	–	10.80	0.4252	94.0	142.0	10.80
A77711.0	–	11.00	0.4331	94.0	142.0	11.00
A7777/16	7/16	11.11	0.4375	94.0	142.0	11.11
A77711.2	–	11.20	0.4409	94.0	142.0	11.20
A77711.5	–	11.50	0.4528	94.0	142.0	11.50
A77729/64	29/64	11.51	0.4531	94.0	142.0	11.51
A77711.8	–	11.80	0.4646	94.0	142.0	11.80
A77715/32	15/32	11.91	0.4688	101.0	151.0	11.91
A77712.0	–	12.00	0.4724	101.0	151.0	12.00
A77712.2	–	12.20	0.4803	101.0	151.0	12.20
A77731/64	31/64	12.30	0.4844	101.0	151.0	12.30
A77712.5	–	12.50	0.4921	101.0	151.0	12.50
A7771/2	1/2	12.70	0.5000	101.0	151.0	12.70
A77712.8	–	12.80	0.5039	101.0	151.0	12.80
A77713.0	–	13.00	0.5118	101.0	151.0	13.00
A77713.5	–	13.50	0.5315	108.0	160.0	13.50
A77714.0	–	14.00	0.5512	108.0	160.0	14.00
A77714.5	–	14.50	0.5709	114.0	169.0	14.50
A77715.0	–	15.00	0.5906	114.0	169.0	15.00
A77715.5	–	15.50	0.6102	120.0	178.0	15.50
A77716.0	–	16.00	0.6299	120.0	178.0	16.00

A147

DORMER

不锈钢专用普通长度含钻高速钢钻头，表面光亮处理。
多功能的实用钻头，130°钻尖角有助于头自定心并减少切削力，满足所有机床加工不锈钢的要求，同样也可用于手持式工具，表面光亮处理。



HSS-E	DIN 338	4×D
130°	Bright	
VA	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪33 I	◪37 I	◪38 I	◪28 I	◪25 G	◪22 E	◪19 F	◪15 F	◪13 E	◪11 F	◪10 E	◪8 D	■21 E	■17 E
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
■18 E	■15 E	◪13 B	■10 G	■9 G	■8 G	■10 D	◪9 B	◪30 H	◪22 F	◪17 F	◪25 E	◪20 E	◪16 E
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
◪22 E	◪17 E	◪13 E	◪20 E	◪15 E	◪11 E	◪10 E	◪8 E	◪23 E	◪17 E	◪13 E	◪33 J	◪25 J	◪17 I
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2
◪42 H	◪37 H	◪27 H	◪59 H	◪35 I	◪18 G	◪30 J	◪28 H	◪14 F	■25 G	■16 E	◪7 B	◪9 G	◪8 E
S3.1	S3.2	S4.1	S4.2										
◪7 G	◪6 E	◪5 G	◪5 E										

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A147.3	–	0.30	0.0118	3.0	19.0	0.30
A147.4	–	0.40	0.0157	5.0	20.0	0.40
A147.5	–	0.50	0.0197	6.0	22.0	0.50
A147.6	–	0.60	0.0236	7.0	24.0	0.60
A147.7	–	0.70	0.0276	9.0	28.0	0.70
A147.8	–	0.80	0.0315	10.0	30.0	0.80
A147.9	–	0.90	0.0354	11.0	32.0	0.90
A1471.0	–	1.00	0.0394	12.0	34.0	1.00
A1471.1	–	1.10	0.0433	14.0	36.0	1.10
A1471.2	–	1.20	0.0472	16.0	38.0	1.20
A1471.3	–	1.30	0.0512	16.0	38.0	1.30
A1471.4	–	1.40	0.0551	18.0	40.0	1.40
A1471.5	–	1.50	0.0591	18.0	40.0	1.50
A1471/16	1/16	1.59	0.0625	20.0	43.0	1.59
A1471.6	–	1.60	0.0630	20.0	43.0	1.60
A1471.7	–	1.70	0.0669	20.0	43.0	1.70
A1471.8	–	1.80	0.0709	22.0	46.0	1.80
A1471.9	–	1.90	0.0748	22.0	46.0	1.90
A1472.0	–	2.00	0.0787	24.0	49.0	2.00
A1472.1	–	2.10	0.0827	24.0	49.0	2.10
A1472.2	–	2.20	0.0866	27.0	53.0	2.20
A1472.3	–	2.30	0.0906	27.0	53.0	2.30
A1473/32	3/32	2.38	0.0938	30.0	57.0	2.38
A1472.4	–	2.40	0.0945	30.0	57.0	2.40

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1472.5	–	2.50	0.0984	30.0	57.0	2.50
A1472.6	–	2.60	0.1024	30.0	57.0	2.60
A1472.7	–	2.70	0.1063	33.0	61.0	2.70
A1472.8	–	2.80	0.1102	33.0	61.0	2.80
A1472.9	–	2.90	0.1142	33.0	61.0	2.90
A1473.0	–	3.00	0.1181	33.0	61.0	3.00
A1473.1	–	3.10	0.1220	36.0	65.0	3.10
A1471/8	1/8	3.18	0.1250	36.0	65.0	3.18
A1473.2	–	3.20	0.1260	36.0	65.0	3.20
A1473.3	–	3.30	0.1299	36.0	65.0	3.30
A1473.4	–	3.40	0.1339	39.0	70.0	3.40
A1473.5	–	3.50	0.1378	39.0	70.0	3.50
A1473.6	–	3.60	0.1417	39.0	70.0	3.60
A1473.7	–	3.70	0.1457	39.0	70.0	3.70
A1473.8	–	3.80	0.1496	43.0	75.0	3.80
A1473.9	–	3.90	0.1535	43.0	75.0	3.90
A1475/32	5/32	3.97	0.1563	43.0	75.0	3.97
A1474.0	–	4.00	0.1575	43.0	75.0	4.00
A1474.1	–	4.10	0.1614	43.0	75.0	4.10
A1474.2	–	4.20	0.1654	43.0	75.0	4.20
A1474.3	–	4.30	0.1693	47.0	80.0	4.30
A1474.4	–	4.40	0.1732	47.0	80.0	4.40
A1474.5	–	4.50	0.1772	47.0	80.0	4.50
A1474.6	–	4.60	0.1811	47.0	80.0	4.60

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1474.7	–	4.70	0.1850	47.0	80.0	4.70
A1473/16	3/16	4.76	0.1875	52.0	86.0	4.76
A1474.8	–	4.80	0.1890	52.0	86.0	4.80
A1474.9	–	4.90	0.1929	52.0	86.0	4.90
A1475.0	–	5.00	0.1969	52.0	86.0	5.00
A1475.1	–	5.10	0.2008	52.0	86.0	5.10
A1475.2	–	5.20	0.2047	52.0	86.0	5.20
A1475.3	–	5.30	0.2087	52.0	86.0	5.30
A1475.4	–	5.40	0.2126	57.0	93.0	5.40
A1475.5	–	5.50	0.2165	57.0	93.0	5.50
A1475.6	–	5.60	0.2205	57.0	93.0	5.60
A1475.7	–	5.70	0.2244	57.0	93.0	5.70
A1475.8	–	5.80	0.2283	57.0	93.0	5.80
A1475.9	–	5.90	0.2323	57.0	93.0	5.90
A1476.0	–	6.00	0.2362	57.0	93.0	6.00
A1476.1	–	6.10	0.2402	63.0	101.0	6.10
A1476.2	–	6.20	0.2441	63.0	101.0	6.20
A1476.3	–	6.30	0.2480	63.0	101.0	6.30
A1471/4	1/4	6.35	0.2500	63.0	101.0	6.35
A1476.4	–	6.40	0.2520	63.0	101.0	6.40
A1476.5	–	6.50	0.2559	63.0	101.0	6.50
A1476.6	–	6.60	0.2598	63.0	101.0	6.60
A1476.7	–	6.70	0.2638	63.0	101.0	6.70
A1476.8	–	6.80	0.2677	69.0	109.0	6.80
A1476.9	–	6.90	0.2717	69.0	109.0	6.90
A1477.0	–	7.00	0.2756	69.0	109.0	7.00
A1477.1	–	7.10	0.2795	69.0	109.0	7.10
A1477.2	–	7.20	0.2835	69.0	109.0	7.20
A1477.3	–	7.30	0.2874	69.0	109.0	7.30
A1477.4	–	7.40	0.2913	69.0	109.0	7.40
A1477.5	–	7.50	0.2953	69.0	109.0	7.50

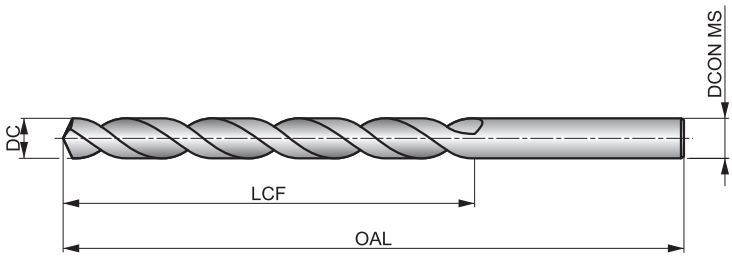
Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1477.7	–	7.70	0.3031	75.0	117.0	7.70
A1477.8	–	7.80	0.3071	75.0	117.0	7.80
A1477.9	–	7.90	0.3110	75.0	117.0	7.90
A1478.0	–	8.00	0.3150	75.0	117.0	8.00
A1478.1	–	8.10	0.3189	75.0	117.0	8.10
A1478.2	–	8.20	0.3228	75.0	117.0	8.20
A1478.3	–	8.30	0.3268	75.0	117.0	8.30
A1478.4	–	8.40	0.3307	75.0	117.0	8.40
A1478.5	–	8.50	0.3346	75.0	117.0	8.50
A1478.6	–	8.60	0.3386	81.0	125.0	8.60
A1478.7	–	8.70	0.3425	81.0	125.0	8.70
A1478.8	–	8.80	0.3465	81.0	125.0	8.80
A1478.9	–	8.90	0.3504	81.0	125.0	8.90
A1479.0	–	9.00	0.3543	81.0	125.0	9.00
A1479.1	–	9.10	0.3583	81.0	125.0	9.10
A1479.2	–	9.20	0.3622	81.0	125.0	9.20
A1479.5	–	9.50	0.3740	81.0	125.0	9.50
A1479.7	–	9.70	0.3819	87.0	133.0	9.70
A1479.8	–	9.80	0.3858	87.0	133.0	9.80
A14710.0	–	10.00	0.3937	87.0	133.0	10.00
A14710.2	–	10.20	0.4016	87.0	133.0	10.20
A14710.5	–	10.50	0.4134	87.0	133.0	10.50
A14711.0	–	11.00	0.4331	94.0	142.0	11.00
A14711.5	–	11.50	0.4528	94.0	142.0	11.50
A14712.0	–	12.00	0.4724	101.0	151.0	12.00
A14712.5	–	12.50	0.4921	101.0	151.0	12.50
A14713.0	–	13.00	0.5118	101.0	151.0	13.00
A14713.5	–	13.50	0.5315	108.0	160.0	13.50
A14714.0	–	14.00	0.5512	108.0	160.0	14.00
A14715.0	–	15.00	0.5906	114.0	169.0	15.00

A510

DORMER

ADX 普通长度高速钢钻头，氮化钛涂层。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(H9公差)，130°钻尖角有助于自定心，只能用于持续输出进给的机床，氮化钛涂层提高了切削性能并延长了刀具寿命，适用于多种材料的切削。

ADX



HSS	DIN 338	4×D
130°	TiN	
λ32-40°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■53 M	■59 M	■61 M	■45 M	■40 K	■35 F	■31 H	■25 H	■21 F	■19 H	■16 F	◪13 D	■38 G	■32 G
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■34 G	■28 G	■16 I	■14 I	◪13 I	◪19 G	■42 K	■31 J	■23 J	■34 J	■28 J	■22 F	■30 J	■23 J
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
■19 F	■28 J	■21 J	■16 F	■13 F	■11 F	■32 J	■24 J	■19 F	◪50 G	◪38 G	■25 M	■48 I	■43 I
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
■31 I	■85 I	■50 I	◪25 D	■65 G	■50 G	■35 F	◪32 G	◪20 H	◪4 B	◪12 E	◪8 E	◪9 E	◪6 E
S4.1	S4.2												
◪7 E	◪5 E												

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A5103.0	–	3.00	0.1181	33.0	61.0	3.00
A5103.1	–	3.10	0.1220	36.0	65.0	3.10
A5101/8	1/8	3.18	0.1250	36.0	65.0	3.18
A5103.2	–	3.20	0.1260	36.0	65.0	3.20
A5103.3	–	3.30	0.1299	36.0	65.0	3.30
A5103.4	–	3.40	0.1339	39.0	70.0	3.40
A5103.5	–	3.50	0.1378	39.0	70.0	3.50
A5109/64	9/64	3.57	0.1406	39.0	70.0	3.57
A5103.6	–	3.60	0.1417	39.0	70.0	3.60
A5103.7	–	3.70	0.1457	39.0	70.0	3.70
A5103.8	–	3.80	0.1496	43.0	75.0	3.80
A5103.9	–	3.90	0.1535	43.0	75.0	3.90
A5105/32	5/32	3.97	0.1563	43.0	75.0	3.97
A5104.0	–	4.00	0.1575	43.0	75.0	4.00
A5104.1	–	4.10	0.1614	43.0	75.0	4.10
A5104.2	–	4.20	0.1654	43.0	75.0	4.20
A5104.3	–	4.30	0.1693	47.0	80.0	4.30
A5104.4	–	4.40	0.1732	47.0	80.0	4.40
A5104.5	–	4.50	0.1772	47.0	80.0	4.50
A5104.6	–	4.60	0.1811	47.0	80.0	4.60
A5104.7	–	4.70	0.1850	47.0	80.0	4.70
A5103/16	3/16	4.76	0.1875	52.0	86.0	4.76
A5104.8	–	4.80	0.1890	52.0	86.0	4.80
A5104.9	–	4.90	0.1929	52.0	86.0	4.90

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A5105.0	–	5.00	0.1969	52.0	86.0	5.00
A5105.1	–	5.10	0.2008	52.0	86.0	5.10
A51013/64	13/64	5.16	0.2031	52.0	86.0	5.16
A5105.2	–	5.20	0.2047	52.0	86.0	5.20
A5105.3	–	5.30	0.2087	52.0	86.0	5.30
A5105.4	–	5.40	0.2126	57.0	93.0	5.40
A5105.5	–	5.50	0.2165	57.0	93.0	5.50
A5107/32	7/32	5.56	0.2188	57.0	93.0	5.56
A5105.6	–	5.60	0.2205	57.0	93.0	5.60
A5105.7	–	5.70	0.2244	57.0	93.0	5.70
A5105.8	–	5.80	0.2283	57.0	93.0	5.80
A5105.9	–	5.90	0.2323	57.0	93.0	5.90
A51015/64	15/64	5.95	0.2344	57.0	93.0	5.95
A5106.0	–	6.00	0.2362	57.0	93.0	6.00
A5106.1	–	6.10	0.2402	63.0	101.0	6.10
A5106.2	–	6.20	0.2441	63.0	101.0	6.20
A5106.3	–	6.30	0.2480	63.0	101.0	6.30
A5101/4	1/4	6.35	0.2500	63.0	101.0	6.35
A5106.4	–	6.40	0.2520	63.0	101.0	6.40
A5106.5	–	6.50	0.2559	63.0	101.0	6.50
A5106.6	–	6.60	0.2598	63.0	101.0	6.60
A5106.7	–	6.70	0.2638	63.0	101.0	6.70
A51017/64	17/64	6.75	0.2656	69.0	109.0	6.75
A5106.8	–	6.80	0.2677	69.0	109.0	6.80

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A5106.9	–	6.90	0.2717	69.0	109.0	6.90
A5107.0	–	7.00	0.2756	69.0	109.0	7.00
A5107.1	–	7.10	0.2795	69.0	109.0	7.10
A5109/32	9/32	7.14	0.2813	69.0	109.0	7.14
A5107.2	–	7.20	0.2835	69.0	109.0	7.20
A5107.3	–	7.30	0.2874	69.0	109.0	7.30
A5107.4	–	7.40	0.2913	69.0	109.0	7.40
A5107.5	–	7.50	0.2953	69.0	109.0	7.50
A51019/64	19/64	7.54	0.2969	75.0	117.0	7.54
A5107.6	–	7.60	0.2992	75.0	117.0	7.60
A5107.8	–	7.80	0.3071	75.0	117.0	7.80
A5105/16	5/16	7.94	0.3125	75.0	117.0	7.94
A5108.0	–	8.00	0.3150	75.0	117.0	8.00
A5108.1	–	8.10	0.3189	75.0	117.0	8.10
A5108.2	–	8.20	0.3228	75.0	117.0	8.20
A5108.3	–	8.30	0.3268	75.0	117.0	8.30
A5108.5	–	8.50	0.3346	75.0	117.0	8.50
A5108.6	–	8.60	0.3386	81.0	125.0	8.60
A5108.7	–	8.70	0.3425	81.0	125.0	8.70
A51011/32	11/32	8.73	0.3438	81.0	125.0	8.73
A5108.8	–	8.80	0.3465	81.0	125.0	8.80
A5108.9	–	8.90	0.3504	81.0	125.0	8.90
A5109.0	–	9.00	0.3543	81.0	125.0	9.00
A5109.1	–	9.10	0.3583	81.0	125.0	9.10
A5109.2	–	9.20	0.3622	81.0	125.0	9.20
A5109.3	–	9.30	0.3661	81.0	125.0	9.30
A5109.4	–	9.40	0.3701	81.0	125.0	9.40
A5109.5	–	9.50	0.3740	81.0	125.0	9.50
A5103/8	3/8	9.52	0.3750	87.0	133.0	9.52

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A5109.6	–	9.60	0.3780	87.0	133.0	9.60
A5109.7	–	9.70	0.3819	87.0	133.0	9.70
A5109.8	–	9.80	0.3858	87.0	133.0	9.80
A5109.9	–	9.90	0.3898	87.0	133.0	9.90
A51025/64	25/64	9.92	0.3906	87.0	133.0	9.92
A51010.0	–	10.00	0.3937	87.0	133.0	10.00
A51010.1	–	10.10	0.3976	87.0	133.0	10.10
A51010.2	–	10.20	0.4016	87.0	133.0	10.20
A51010.3	–	10.30	0.4055	87.0	133.0	10.30
A51013/32	13/32	10.32	0.4063	87.0	133.0	10.32
A51010.4	–	10.40	0.4094	87.0	133.0	10.40
A51010.5	–	10.50	0.4134	87.0	133.0	10.50
A51027/64	27/64	10.72	0.4219	94.0	142.0	10.72
A51010.8	–	10.80	0.4252	94.0	142.0	10.80
A51011.0	–	11.00	0.4331	94.0	142.0	11.00
A51011.1	–	11.10	0.4370	94.0	142.0	11.10
A5107/16	7/16	11.11	0.4375	94.0	142.0	11.11
A51011.5	–	11.50	0.4528	94.0	142.0	11.50
A51011.7	–	11.70	0.4606	94.0	142.0	11.70
A51011.8	–	11.80	0.4646	94.0	142.0	11.80
A51015/32	15/32	11.91	0.4688	101.0	151.0	11.91
A51012.0	–	12.00	0.4724	101.0	151.0	12.00
A51012.3	–	12.30	0.4843	101.0	151.0	12.30
A51031/64	31/64	12.30	0.4844	101.0	151.0	12.30
A51012.5	–	12.50	0.4921	101.0	151.0	12.50
A5101/2	1/2	12.70	0.5000	101.0	151.0	12.70
A51013.0	–	13.00	0.5118	101.0	151.0	13.00
A51014.0	–	14.00	0.5512	108.0	160.0	14.00

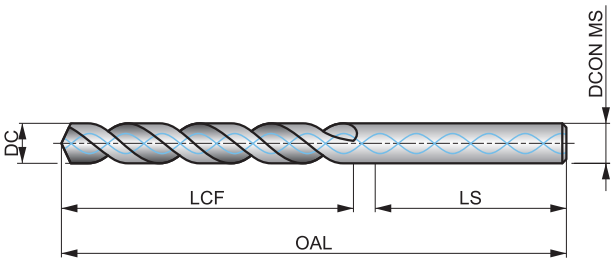
A553

DORMER

ADX 普通长度含钴高速钢内冷钻头，氮铝化钛涂层。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(H9公差)，130°钻尖角，头部氮铝化钛涂层提高了性能并延长了刀具寿命，只能用于数控机床，适用于多种材料的切削。

ADX

HSS-E	DORMER	5×D
130°	TiAlN Top	DIN 6535HA
λ>35°	R	
DC h8		



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 80 L	■ 89 L	■ 92 L	■ 68 L	■ 60 L	■ 53 F	■ 41 H	■ 33 H	■ 28 F	■ 25 H	■ 21 F	■ 17 D	■ 55 G	■ 46 G
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■ 49 G	■ 40 G	■ 22 I	■ 19 I	◪ 17 I	◪ 27 G	■ 70 K	■ 52 J	■ 39 J	■ 55 J	■ 45 J	■ 36 F	■ 49 J	■ 37 J
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
■ 30 F	■ 45 J	■ 34 J	■ 25 F	■ 22 F	■ 18 F	■ 51 J	■ 39 J	■ 30 F	◪ 70 H	◪ 53 H	■ 35 M	■ 85 I	■ 76 I
N2.3	N3.1	N3.2	N3.3	N4.1	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2
■ 55 I	■ 144 I	■ 85 I	◪ 43 G	■ 90 G	■ 45 G	◪ 30 E	◪ 8 C	◪ 20 E	◪ 14 G	◪ 15 E	◪ 10 G	◪ 12 E	◪ 8 G

DCON MS公差h6

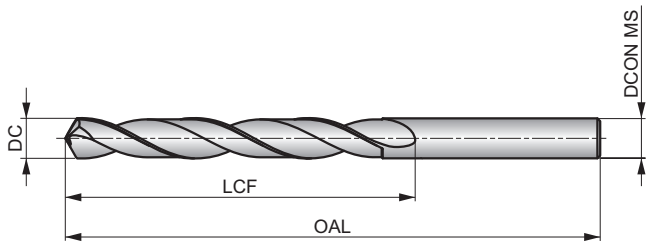
Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
A5535.0	5.00	0.1969	36.0	79.0	36.0	6.00
A5535.5	5.50	0.2165	40.0	79.0	36.0	6.00
A5536.0	6.00	0.2362	43.0	79.0	36.0	6.00
A5538.0	8.00	0.3150	58.0	94.0	36.0	8.00
A5538.5	8.50	0.3346	75.0	130.0	40.0	10.00
A5539.0	9.00	0.3543	75.0	130.0	40.0	10.00
A5539.5	9.50	0.3740	75.0	130.0	40.0	10.00
A55310.3	10.30	0.4055	87.0	150.0	45.0	12.00
A55311.0	11.00	0.4331	94.0	150.0	45.0	12.00

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
A55311.3	11.30	0.4449	94.0	150.0	45.0	12.00
A55311.5	11.50	0.4528	94.0	150.0	45.0	12.00
A55312.0	12.00	0.4724	94.0	150.0	45.0	12.00
A55312.5	12.50	0.4921	101.0	160.0	45.0	14.00
A55313.0	13.00	0.5118	101.0	160.0	45.0	14.00
A55313.5	13.50	0.5315	101.0	160.0	45.0	14.00
A55314.0	14.00	0.5512	101.0	160.0	45.0	14.00
A55315.0	15.00	0.5906	108.0	170.0	48.0	16.00
A55318.0	18.00	0.7087	130.0	190.0	48.0	18.00

R003

DORMER

整硬合金钻头，TiN 尖端涂层
多功能入门级钻头，钻尖角度为 120°，采用4后面分离式钻尖，可降低阻力，CTW 刀槽结构可提高穿透率。TiN刀尖涂层可提高性能并延长刀具寿命。适用于各种工件材料，包括数控机床和普通机床。



HM	DIN 338	4×D
120°	TiN-Tip	
λ20-35°	R	DC h7

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	K1.1	K1.2
■99 S	■111 S	■115 S	■85 S	■75 S	■66 S	■66 S	■53 S	■45 S	■40 S	■34 S	■27 S	■75 T	■56 T
K1.3	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**
■42 T	■68 T	■55 T	■44 T	■60 T	■46 T	■37 T	◪55 T	◪42 T	◪31 T	◪26 T	◪22 T	■63 T	■47 T
K5.3	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N4.1**	**N4.2**	**H1.1**	**H2.1**	**H3.1**
■37 T	■150 V	■113 V	■75 V	◪129 V	◪116 V	◪84 V	■317 V	■190 V	■60 U	■100 U	◪34 S	◪20 S	◪22 S

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R0031.0	–	1.00	0.0394	12.0	34.0	1.00
R003N60	N60	1.02	0.0400	12.0	34.0	1.02
R0031.1	–	1.10	0.0433	14.0	36.0	1.10
R003N56	N56	1.18	0.0465	16.0	38.0	1.18
R0033/64	3/64	1.19	0.0469	16.0	38.0	1.19
R0031.2	–	1.20	0.0472	16.0	38.0	1.20
R0031.3	–	1.30	0.0512	16.0	38.0	1.30
R003N54	N54	1.40	0.0550	18.0	40.0	1.40
R0031.4	–	1.40	0.0551	18.0	40.0	1.40
R0031.5	–	1.50	0.0591	18.0	40.0	1.50
R003N53	N53	1.51	0.0595	20.0	43.0	1.51
R0031/16	1/16	1.59	0.0625	20.0	43.0	1.59
R0031.6	–	1.60	0.0630	20.0	43.0	1.60
R003N52	N52	1.61	0.0635	20.0	43.0	1.61
R0031.7	–	1.70	0.0669	20.0	43.0	1.70
R003N51	N51	1.70	0.0670	22.0	46.0	1.70
R003N50	N50	1.78	0.0700	22.0	46.0	1.78
R0031.8	–	1.80	0.0709	22.0	46.0	1.80
R0031.9	–	1.90	0.0748	22.0	46.0	1.90
R003N48	N48	1.93	0.0760	24.0	49.0	1.93
R0035/64	5/64	1.98	0.0781	24.0	49.0	1.98
R003N47	N47	1.99	0.0785	24.0	49.0	1.99
R0032.0	–	2.00	0.0787	24.0	49.0	2.00
R003N46	N46	2.06	0.0810	24.0	49.0	2.06
R0032.1	–	2.10	0.0827	24.0	49.0	2.10
R003N44	N44	2.18	0.0860	27.0	53.0	2.18
R0032.2	–	2.20	0.0866	27.0	53.0	2.20
R003N43	N43	2.26	0.0890	27.0	53.0	2.26

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R0032.3	–	2.30	0.0906	27.0	53.0	2.30
R0033/32	3/32	2.38	0.0937	30.0	57.0	2.38
R0032.4	–	2.40	0.0945	30.0	57.0	2.40
R003N41	N41	2.44	0.0960	30.0	57.0	2.44
R0032.5	–	2.50	0.0984	30.0	57.0	2.50
R003N39	N39	2.53	0.0995	30.0	57.0	2.53
R003N38	N38	2.58	0.1015	30.0	57.0	2.58
R0032.6	–	2.60	0.1024	30.0	57.0	2.60
R003N37	N37	2.64	0.1040	30.0	57.0	2.64
R0032.7	–	2.70	0.1063	33.0	61.0	2.70
R003N36	N36	2.71	0.1065	33.0	61.0	2.71
R0037/64	7/64	2.78	0.1094	33.0	61.0	2.78
R0032.8	–	2.80	0.1102	33.0	61.0	2.80
R003N33	N33	2.87	0.1130	33.0	61.0	2.87
R0032.9	–	2.90	0.1142	33.0	61.0	2.90
R003N32	N32	2.95	0.1160	33.0	61.0	2.95
R0033.0	–	3.00	0.1181	33.0	61.0	3.00
R003N31	N31	3.05	0.1200	36.0	65.0	3.05
R0033.1	–	3.10	0.1220	36.0	65.0	3.10
R0031/8	1/8	3.17	0.1250	36.0	65.0	3.17
R0033.2	–	3.20	0.1260	36.0	65.0	3.20
R0033.3	–	3.30	0.1299	36.0	65.0	3.30
R0033.4	–	3.40	0.1339	39.0	70.0	3.40
R003N29	N29	3.45	0.1360	39.0	70.0	3.45
R0033.5	–	3.50	0.1378	39.0	70.0	3.50
R003N28	N28	3.57	0.1405	39.0	70.0	3.57
R0039/64	9/64	3.57	0.1406	39.0	70.0	3.57
R0033.6	–	3.60	0.1417	39.0	70.0	3.60

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R0033.7	–	3.70	0.1457	39.0	70.0	3.70
R003N26	N26	3.73	0.1470	39.0	70.0	3.73
R003N25	N25	3.80	0.1495	43.0	75.0	3.80
R0033.8	–	3.80	0.1496	43.0	75.0	3.80
R0033.9	–	3.90	0.1535	43.0	75.0	3.90
R0035/32	5/32	3.97	0.1563	43.0	75.0	3.97
R0034.0	–	4.00	0.1575	43.0	75.0	4.00
R003N21	N21	4.04	0.1590	43.0	75.0	4.04
R003N20	N20	4.09	0.1610	43.0	75.0	4.09
R0034.1	–	4.10	0.1614	43.0	75.0	4.10
R0034.2	–	4.20	0.1654	43.0	75.0	4.20
R003N19	N19	4.22	0.1660	43.0	75.0	4.22
R0034.3	–	4.30	0.1693	47.0	80.0	4.30
R00311/64	11/64	4.37	0.1719	47.0	80.0	4.37
R003N17	N17	4.39	0.1730	47.0	80.0	4.39
R0034.4	–	4.40	0.1732	47.0	80.0	4.40
R0034.5	–	4.50	0.1772	47.0	80.0	4.50
R003N15	N15	4.57	0.1800	47.0	80.0	4.57
R0034.6	–	4.60	0.1811	47.0	80.0	4.60
R0034.7	–	4.70	0.1850	47.0	80.0	4.70
R0033/16	3/16	4.76	0.1875	52.0	86.0	4.76
R003N12	N12	4.80	0.1890	52.0	86.0	4.80
R0034.8	–	4.80	0.1890	52.0	86.0	4.80
R003N11	N11	4.85	0.1910	52.0	86.0	4.85
R0034.9	–	4.90	0.1929	52.0	86.0	4.90
R003N10	N10	4.92	0.1935	52.0	86.0	4.92
R0035.0	–	5.00	0.1969	52.0	86.0	5.00
R0035.1	–	5.10	0.2008	52.0	86.0	5.10
R003N7	N7	5.11	0.2010	52.0	86.0	5.11
R00313/64	13/64	5.16	0.2031	52.0	86.0	5.16
R0035.2	–	5.20	0.2047	52.0	86.0	5.20
R0035.3	–	5.30	0.2087	52.0	86.0	5.30
R0035.4	–	5.40	0.2126	57.0	93.0	5.40
R003N3	N3	5.41	0.2130	57.0	93.0	5.41
R0035.5	–	5.50	0.2165	57.0	93.0	5.50
R0037/32	7/32	5.56	0.2187	57.0	93.0	5.56
R0035.6	–	5.60	0.2205	57.0	93.0	5.60
R003N2	N2	5.61	0.2210	57.0	93.0	5.61
R0035.7	–	5.70	0.2244	57.0	93.0	5.70
R0035.8	–	5.80	0.2283	57.0	93.0	5.80
R0035.9	–	5.90	0.2323	57.0	93.0	5.90
R00315/64	15/64	5.95	0.2344	57.0	93.0	5.95
R0036.0	–	6.00	0.2362	57.0	93.0	6.00
R0036.1	–	6.10	0.2402	63.0	101.0	6.10
R003C	C	6.15	0.2420	63.0	101.0	6.15
R0036.2	–	6.20	0.2441	63.0	101.0	6.20
R0036.3	–	6.30	0.2480	63.0	101.0	6.30
R0031/4	1/4	6.35	0.2500	63.0	101.0	6.35
R0036.4	–	6.40	0.2520	63.0	101.0	6.40
R0036.5	–	6.50	0.2559	63.0	101.0	6.50
R003F	F	6.53	0.2570	63.0	101.0	6.53
R0036.6	–	6.60	0.2598	63.0	101.0	6.60
R0036.7	–	6.70	0.2638	63.0	101.0	6.70
R00317/64	17/64	6.75	0.2656	69.0	109.0	6.75
R0036.8	–	6.80	0.2677	69.0	109.0	6.80
R0036.9	–	6.90	0.2717	69.0	109.0	6.90

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R003I	I	6.91	0.2720	69.0	109.0	6.91
R0037.0	–	7.00	0.2756	69.0	109.0	7.00
R0037.1	–	7.10	0.2795	69.0	109.0	7.10
R0039/32	9/32	7.14	0.2813	69.0	109.0	7.14
R0037.2	–	7.20	0.2835	69.0	109.0	7.20
R0037.3	–	7.30	0.2874	69.0	109.0	7.30
R0037.4	–	7.40	0.2913	69.0	109.0	7.40
R0037.5	–	7.50	0.2953	69.0	109.0	7.50
R00319/64	19/64	7.54	0.2969	75.0	117.0	7.54
R0037.6	–	7.60	0.2992	75.0	117.0	7.60
R0037.7	–	7.70	0.3031	75.0	117.0	7.70
R0037.8	–	7.80	0.3071	75.0	117.0	7.80
R0037.9	–	7.90	0.3110	75.0	117.0	7.90
R0035/16	5/16	7.94	0.3125	75.0	117.0	7.94
R0038.0	–	8.00	0.3150	75.0	117.0	8.00
R0038.1	–	8.10	0.3189	75.0	117.0	8.10
R0038.2	–	8.20	0.3228	75.0	117.0	8.20
R0038.3	–	8.30	0.3268	75.0	117.0	8.30
R00321/64	21/64	8.33	0.3281	75.0	117.0	8.33
R0038.4	–	8.40	0.3307	75.0	117.0	8.40
R003Q	Q	8.43	0.3320	75.0	117.0	8.43
R0038.5	–	8.50	0.3346	75.0	117.0	8.50
R0038.6	–	8.60	0.3386	81.0	125.0	8.60
R003R	R	8.61	0.3390	81.0	125.0	8.61
R0038.7	–	8.70	0.3425	81.0	125.0	8.70
R00311/32	11/32	8.73	0.3437	81.0	125.0	8.73
R0038.8	–	8.80	0.3465	81.0	125.0	8.80
R0038.9	–	8.90	0.3504	81.0	125.0	8.90
R0039.0	–	9.00	0.3543	81.0	125.0	9.00
R0039.1	–	9.10	0.3583	81.0	125.0	9.10
R00323/64	23/64	9.13	0.3594	81.0	125.0	9.13
R0039.2	–	9.20	0.3622	81.0	125.0	9.20
R0039.3	–	9.30	0.3661	81.0	125.0	9.30
R003U	U	9.35	0.3680	81.0	125.0	9.35
R0039.4	–	9.40	0.3701	81.0	125.0	9.40
R0039.5	–	9.50	0.3740	81.0	125.0	9.50
R0033/8	3/8	9.53	0.3750	87.0	133.0	9.53
R0039.6	–	9.60	0.3780	87.0	133.0	9.60
R0039.7	–	9.70	0.3819	87.0	133.0	9.70
R0039.8	–	9.80	0.3858	87.0	133.0	9.80
R003W	W	9.80	0.3860	87.0	133.0	9.80
R0039.9	–	9.90	0.3898	87.0	133.0	9.90
R00310.0	–	10.00	0.3937	87.0	133.0	10.00
R00310.2	–	10.20	0.4016	87.0	133.0	10.20
R00313/32	13/32	10.32	0.4063	87.0	133.0	10.32
R00310.5	–	10.50	0.4134	87.0	133.0	10.50
R00327/64	27/64	10.72	0.4219	94.0	142.0	10.72
R00311.0	–	11.00	0.4331	94.0	142.0	11.00
R0037/16	7/16	11.11	0.4375	94.0	142.0	11.11
R00311.5	–	11.50	0.4528	94.0	142.0	11.50
R00329/64	29/64	11.51	0.4531	94.0	142.0	11.51
R00315/32	15/32	11.91	0.4687	101.0	151.0	11.91
R00312.0	–	12.00	0.4724	101.0	151.0	12.00
R0031/2	1/2	12.70	0.5000	101.0	151.0	12.70
R00313.0	–	13.00	0.5118	101.0	151.0	13.00
R00314.0	–	14.00	0.5512	108.0	160.0	14.00

材料代码(BMC)	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS
基本标准组(BSG)	DIN ANSI	DIN ANSI	DIN 1869-1	DIN 1869-2	DIN 1869-3	DIN 1870(2)
有用长度直径比 (ULDR)	6×D	10×D	15×D	20×D	25×D	20×D
应用角度	130°	130°	130°	130°	130°	130°
涂层	Bright	Bright	Bright	Bright	Bright	Bright ST
柄部						
螺旋形式	λ>35°	λ>35°	λ>35°	λ>35°	λ>35°	λ>35°
旋向(切削方向)	R	R	R	R	R	R
	PFX	PFX	PFX	PFX	PFX	
产品系列代码	A900	A940	A976	A977	A978	A952
PSF切削直径范围	1.00 - 20.00	1.00 - 19.00	1.50 - 14.00	1.50 - 14.00	3.00 - 10.00	8.00 - 30.00
	126	128	130	131	132	133
P	P1	■	■	◪	◪	◪	■
	P2	■	■	■	■	■	■
	P3	■	■	■	■	■	◪
	P4	■	■	■	■	■	◪
M	M1	■	■	◪	◪	◪	◪
	M2	■	■	◪	◪	◪	◪
	M3	■	■	◪	◪	◪	◪
	M4	■	■	◪	◪	◪	◪
K	K1	◪					◪
	K2	◪	◪	◪	◪	◪	◪
	K3	◪	◪	◪	◪	◪	◪
	K4	◪	◪	◪	◪	◪	◪
	K5	◪	◪	◪	◪	◪	◪
N	N1	◪	◪				◪
	N2	◪	◪				◪
	N3	◪	◪	◪	◪	◪	◪
	N4	◪	◪				◪
	N5						
S	S1	■	■	◪	◪	◪	◪
	S2	■					◪
	S3	■					◪
	S4	■					◪
H	H1						
	H2						
	H3						
	H4						

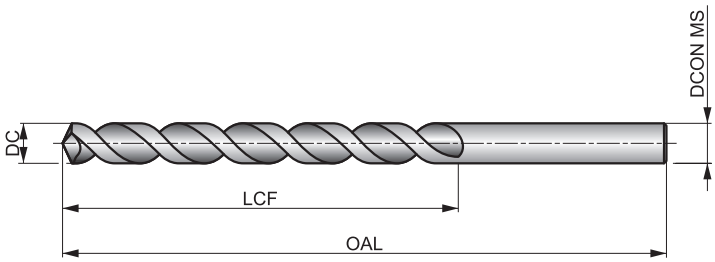
■推荐使用 ◪可以使用

A900

DORMER

普通长度PFX含钴高速钢钻头，表面光亮处理。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(H10公差)，自定心的130°钻尖角和特殊抛物线槽设计，有助于一次进刀完成深孔加工，适用于多种材料的切削。

PFX



HSS-E	DIN ANSI	6×D
130°	Bright	
λ>35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■34 H	■39 H	■40 H	■30 H	■26 H	■23 E	■31 H	■25 H	■21 E	■19 H	■16 E	■13 E	■21 E	■17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
■18 E	■15 E	■8 E	■7 E	■6 E	■9 C	◪24 J	◪18 J	◪13 J	◪23 J	◪19 J	◪15 I	◪21 J	◪16 J
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 I	◪19 J	◪14 J	◪11 I	◪9 I	◪8 I	◪22 J	◪16 J	◪13 I	◪60 J	◪45 J	■30 N	◪62 N	◪55 N
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1
◪40 N	◪90 H	◪53 I	◪27 G	◪55 I	◪40 G	■22 E	■15 E	■6 C	■9 G	■8 C	■7 G	■6 C	■5 G
S4.2													
■5 C													

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9001.0	–	1.00	0.0394	12.0	34.0	1.00
A9001.1	–	1.10	0.0433	14.0	36.0	1.10
A9001.2	–	1.20	0.0472	16.0	38.0	1.20
A9001.25	–	1.25	0.0492	16.0	36.0	1.25
A9001.3	–	1.30	0.0512	16.0	38.0	1.30
A9001.4	–	1.40	0.0551	18.0	40.0	1.40
A9001.5	–	1.50	0.0591	18.0	40.0	1.50
A9001.55	–	1.55	0.0610	20.0	43.0	1.55
A9001/16	1/16	1.59	0.0625	22.0	48.0	1.59
A9001.6	–	1.60	0.0630	20.0	43.0	1.60
A9001.7	–	1.70	0.0669	20.0	43.0	1.70
A9001.75	–	1.75	0.0689	22.0	46.0	1.75
A9001.8	–	1.80	0.0709	22.0	46.0	1.80
A9001.9	–	1.90	0.0748	22.0	46.0	1.90
A9005/64	5/64	1.98	0.0781	25.0	51.0	1.98
A9002.0	–	2.00	0.0787	24.0	49.0	2.00
A9002.1	–	2.10	0.0827	24.0	49.0	2.10
A9002.2	–	2.20	0.0866	27.0	53.0	2.20
A9002.3	–	2.30	0.0906	27.0	53.0	2.30
A9003/32	3/32	2.38	0.0937	32.0	57.0	2.38
A9002.4	–	2.40	0.0945	30.0	57.0	2.40
A9002.5	–	2.50	0.0984	30.0	57.0	2.50
A9002.6	–	2.60	0.1024	30.0	57.0	2.60
A9002.7	–	2.70	0.1063	33.0	61.0	2.70

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9007/64	7/64	2.78	0.1094	38.0	67.0	2.78
A9002.8	–	2.80	0.1102	33.0	61.0	2.80
A9002.9	–	2.90	0.1142	33.0	61.0	2.90
A9003.0	–	3.00	0.1181	33.0	61.0	3.00
A9003.1	–	3.10	0.1220	36.0	65.0	3.10
A9001/8	1/8	3.18	0.1250	41.0	70.0	3.18
A9003.2	–	3.20	0.1260	36.0	65.0	3.20
A9003.3	–	3.30	0.1299	36.0	65.0	3.30
A9003.4	–	3.40	0.1339	39.0	70.0	3.40
A9003.5	–	3.50	0.1378	39.0	70.0	3.50
A9009/64	9/64	3.57	0.1406	44.0	73.0	3.57
A9003.6	–	3.60	0.1417	39.0	70.0	3.60
A9003.7	–	3.70	0.1457	39.0	70.0	3.70
A9003.8	–	3.80	0.1496	43.0	75.0	3.80
A9003.9	–	3.90	0.1535	43.0	75.0	3.90
A9005/32	5/32	3.97	0.1563	51.0	79.0	3.97
A9004.0	–	4.00	0.1575	43.0	75.0	4.00
A9004.1	–	4.10	0.1614	43.0	75.0	4.10
A9004.2	–	4.20	0.1654	43.0	75.0	4.20
A9004.3	–	4.30	0.1693	47.0	80.0	4.30
A90011/64	11/64	4.37	0.1719	54.0	83.0	4.37
A9004.5	–	4.50	0.1772	47.0	80.0	4.50
A9004.6	–	4.60	0.1811	47.0	80.0	4.60
A9004.7	–	4.70	0.1850	47.0	80.0	4.70

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9003/16	3/16	4.76	0.1875	59.0	89.0	4.76
A9004.9	–	4.90	0.1929	52.0	86.0	4.90
A9005.0	–	5.00	0.1969	52.0	86.0	5.00
A9005.1	–	5.10	0.2008	52.0	86.0	5.10
A90013/64	13/64	5.16	0.2031	62.0	92.0	5.16
A9005.2	–	5.20	0.2047	52.0	86.0	5.20
A9005.3	–	5.30	0.2087	52.0	86.0	5.30
A9005.4	–	5.40	0.2126	57.0	93.0	5.40
A9005.5	–	5.50	0.2165	57.0	93.0	5.50
A9007/32	7/32	5.56	0.2188	64.0	95.0	5.56
A9005.6	–	5.60	0.2205	57.0	93.0	5.60
A9005.7	–	5.70	0.2244	57.0	93.0	5.70
A9005.8	–	5.80	0.2283	57.0	93.0	5.80
A9005.9	–	5.90	0.2323	57.0	93.0	5.90
A9006.0	–	6.00	0.2362	57.0	93.0	6.00
A9006.1	–	6.10	0.2402	63.0	101.0	6.10
A9006.2	–	6.20	0.2441	63.0	101.0	6.20
A9006.3	–	6.30	0.2480	63.0	101.0	6.30
A9001/4	1/4	6.35	0.2500	70.0	102.0	6.35
A9006.4	–	6.40	0.2520	63.0	101.0	6.40
A9006.5	–	6.50	0.2559	63.0	101.0	6.50
A9006.6	–	6.60	0.2598	63.0	101.0	6.60
A9006.7	–	6.70	0.2638	63.0	101.0	6.70
A90017/64	17/64	6.75	0.2656	73.0	105.0	6.75
A9006.8	–	6.80	0.2677	69.0	109.0	6.80
A9006.9	–	6.90	0.2717	69.0	109.0	6.90
A9007.0	–	7.00	0.2756	69.0	109.0	7.00
A9007.1	–	7.10	0.2795	69.0	109.0	7.10
A9007.2	–	7.20	0.2835	69.0	109.0	7.20
A9007.4	–	7.40	0.2913	69.0	109.0	7.40
A9007.5	–	7.50	0.2953	69.0	109.0	7.50
A9005/16	5/16	7.94	0.3125	81.0	114.0	7.94
A9008.0	–	8.00	0.3150	75.0	117.0	8.00
A9008.1	–	8.10	0.3189	75.0	117.0	8.10
A9008.5	–	8.50	0.3346	75.0	117.0	8.50

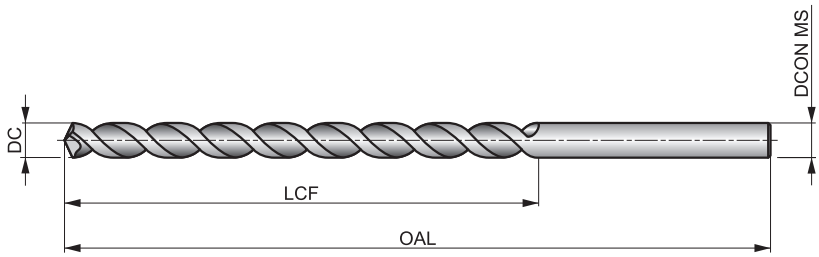
Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9008.7	–	8.70	0.3425	81.0	125.0	8.70
A90011/32	11/32	8.73	0.3438	87.0	121.0	8.73
A9008.8	–	8.80	0.3465	81.0	125.0	8.80
A9009.0	–	9.00	0.3543	81.0	125.0	9.00
A9009.5	–	9.50	0.3740	81.0	125.0	9.50
A9003/8	3/8	9.52	0.3750	92.0	127.0	9.52
A90010.0	–	10.00	0.3937	87.0	133.0	10.00
A90010.2	–	10.20	0.4016	87.0	133.0	10.20
A90010.3	–	10.30	0.4055	87.0	133.0	10.30
A90010.5	–	10.50	0.4134	87.0	133.0	10.50
A90011.0	–	11.00	0.4331	94.0	142.0	11.00
A90011.5	–	11.50	0.4528	94.0	142.0	11.50
A90011.8	–	11.80	0.4646	94.0	142.0	11.80
A90015/32	15/32	11.91	0.4688	110.0	146.0	11.91
A90012.0	–	12.00	0.4724	101.0	151.0	12.00
A90031/64	31/64	12.30	0.4844	111.0	149.0	12.30
A90012.5	–	12.50	0.4921	101.0	151.0	12.50
A9001/2	1/2	12.70	0.5000	101.0	151.0	12.70
A90013.0	–	13.00	0.5118	101.0	151.0	13.00
A90013.5	–	13.50	0.5315	108.0	160.0	13.50
A90014.0	–	14.00	0.5512	108.0	160.0	14.00
A9009/16	9/16	14.29	0.5625	122.0	168.0	14.29
A90015.0	–	15.00	0.5906	114.0	169.0	15.00
A90016.0	–	16.00	0.6299	120.0	178.0	16.00
A90017.0	–	17.00	0.6693	125.0	184.0	17.00
A90011/16	11/16	17.46	0.6875	143.0	194.0	17.46
A90018.0	–	18.00	0.7087	130.0	191.0	18.00
A90023/32	23/32	18.26	0.7188	130.0	191.0	18.26
A90018.5	–	18.50	0.7283	135.0	198.0	18.50
A90047/64	47/64	18.65	0.7344	135.0	198.0	18.65
A9003/4	3/4	19.05	0.7500	135.0	198.0	19.05
A90049/64	49/64	19.45	0.7656	135.0	198.0	19.45
A90019.5	–	19.50	0.7677	140.0	205.0	19.50
A90025/32	25/32	19.84	0.7813	140.0	205.0	19.84
A90020.0	–	20.00	0.7874	140.0	205.0	20.00

A940

DORMER

长系列PFX含钴高速钢钻头，表面光亮处理。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(H10公差)，自定心的130°钻尖角和特殊抛物线槽设计，有助于一次进刀完成额外的深孔加工，适用于多种材料的切削。

PFX



HSS-E	DIN ANSI	10×D
130°	Bright	
λ>35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
29 F	33 F	34 F	25 F	22 G	19 C	25 G	20 G	17 C	15 G	13 C	10 C	21 C	17 C
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2
18 C	15 C	8 E	7 E	6 E	9 B	20 I	16 I	13 H	17 I	13 I	11 H	16 I	12 I
K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2
9 H	8 H	6 H	18 I	14 I	11 H	53 H	40 H	27 N	62 N	55 N	40 N	119 G	70 F
N3.3	N4.1	N4.2	S1.1	S1.2	S1.3								
35 F	55 H	40 F	18 E	13 C	6 C								

DC >= 9.6mm 小于 10xD

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9401.0	–	1.00	0.0394	33.0	56.0	1.00
A9401.1	–	1.10	0.0433	37.0	60.0	1.10
A9403/64	3/64	1.19	0.0469	29.0	57.0	1.19
A9401.2	–	1.20	0.0472	41.0	65.0	1.20
A9401.3	–	1.30	0.0512	41.0	65.0	1.30
A9401.4	–	1.40	0.0551	45.0	70.0	1.40
A9401.5	–	1.50	0.0591	45.0	70.0	1.50
A9401/16	1/16	1.59	0.0625	44.0	76.0	1.59
A9401.6	–	1.60	0.0630	50.0	76.0	1.60
A9401.7	–	1.70	0.0669	50.0	76.0	1.70
A9401.8	–	1.80	0.0709	53.0	80.0	1.80
A9401.9	–	1.90	0.0748	53.0	80.0	1.90
A9405/64	5/64	1.98	0.0781	51.0	95.0	1.98
A9402.0	–	2.00	0.0787	56.0	85.0	2.00
A9402.1	–	2.10	0.0827	56.0	85.0	2.10
A9402.2	–	2.20	0.0866	59.0	90.0	2.20
A9402.3	–	2.30	0.0906	59.0	90.0	2.30
A9403/32	3/32	2.38	0.0938	57.0	108.0	2.38
A9402.4	–	2.40	0.0945	62.0	95.0	2.40
A9402.5	–	2.50	0.0984	62.0	95.0	2.50
A9402.6	–	2.60	0.1024	62.0	95.0	2.60
A9402.7	–	2.70	0.1063	66.0	100.0	2.70
A9407/64	7/64	2.78	0.1094	64.0	117.0	2.78
A9402.8	–	2.80	0.1102	66.0	100.0	2.80
A9402.9	–	2.90	0.1142	66.0	100.0	2.90

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9403.0	–	3.00	0.1181	66.0	100.0	3.00
A9403.1	–	3.10	0.1220	69.0	106.0	3.10
A9401/8	1/8	3.18	0.1250	70.0	130.0	3.18
A9403.2	–	3.20	0.1260	69.0	106.0	3.20
A9403.3	–	3.30	0.1299	69.0	106.0	3.30
A9403.4	–	3.40	0.1339	73.0	112.0	3.40
A9403.5	–	3.50	0.1378	73.0	112.0	3.50
A9409/64	9/64	3.57	0.1406	76.0	137.0	3.57
A9403.6	–	3.60	0.1417	73.0	112.0	3.60
A9403.7	–	3.70	0.1457	73.0	112.0	3.70
A9403.8	–	3.80	0.1496	78.0	119.0	3.80
A9403.9	–	3.90	0.1535	78.0	119.0	3.90
A9405/32	5/32	3.97	0.1563	76.0	137.0	3.97
A9404.0	–	4.00	0.1575	78.0	119.0	4.00
A9404.1	–	4.10	0.1614	78.0	119.0	4.10
A9404.2	–	4.20	0.1654	78.0	119.0	4.20
A9404.3	–	4.30	0.1693	82.0	126.0	4.30
A9404.4	–	4.40	0.1732	82.0	126.0	4.40
A9404.5	–	4.50	0.1772	82.0	126.0	4.50
A9404.6	–	4.60	0.1811	82.0	126.0	4.60
A9403/16	3/16	4.76	0.1875	86.0	146.0	4.76
A9404.8	–	4.80	0.1890	87.0	132.0	4.80
A9404.9	–	4.90	0.1929	87.0	132.0	4.90
A9405.0	–	5.00	0.1969	87.0	132.0	5.00
A9405.1	–	5.10	0.2008	87.0	132.0	5.10

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9405.2	–	5.20	0.2047	87.0	132.0	5.20
A9405.3	–	5.30	0.2087	87.0	132.0	5.30
A9405.4	–	5.40	0.2126	91.0	139.0	5.40
A9405.5	–	5.50	0.2165	91.0	139.0	5.50
A9405.8	–	5.80	0.2283	91.0	139.0	5.80
A9405.9	–	5.90	0.2323	91.0	139.0	5.90
A9406.0	–	6.00	0.2362	91.0	139.0	6.00
A9406.1	–	6.10	0.2402	97.0	148.0	6.10
A9406.2	–	6.20	0.2441	97.0	148.0	6.20
A9401/4	1/4	6.35	0.2500	95.0	156.0	6.35
A9406.4	–	6.40	0.2520	97.0	148.0	6.40
A9406.5	–	6.50	0.2559	97.0	148.0	6.50
A9406.6	–	6.60	0.2598	97.0	148.0	6.60
A9406.7	–	6.70	0.2638	97.0	148.0	6.70
A94017/64	17/64	6.75	0.2656	98.0	159.0	6.75
A9406.8	–	6.80	0.2677	102.0	156.0	6.80
A9406.9	–	6.90	0.2717	102.0	156.0	6.90
A9407.0	–	7.00	0.2756	102.0	156.0	7.00
A9407.2	–	7.20	0.2835	102.0	156.0	7.20
A9407.3	–	7.30	0.2874	102.0	156.0	7.30
A9407.5	–	7.50	0.2953	102.0	156.0	7.50
A9407.8	–	7.80	0.3071	109.0	165.0	7.80
A9405/16	5/16	7.94	0.3125	102.0	162.0	7.94
A9408.0	–	8.00	0.3150	109.0	165.0	8.00
A9408.2	–	8.20	0.3228	109.0	165.0	8.20
A9408.3	–	8.30	0.3268	109.0	165.0	8.30
A9408.5	–	8.50	0.3346	109.0	165.0	8.50
A9408.6	–	8.60	0.3386	115.0	175.0	8.60
A9408.7	–	8.70	0.3425	115.0	175.0	8.70
A94011/32	11/32	8.73	0.3438	105.0	165.0	8.73

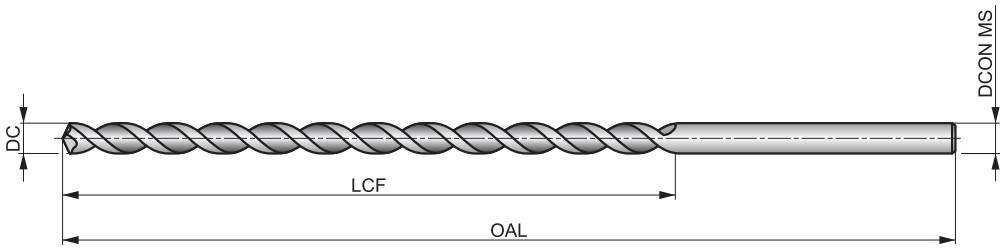
Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A9409.0	–	9.00	0.3543	115.0	175.0	9.00
A9409.5	–	9.50	0.3740	115.0	175.0	9.50
A9409.8	–	9.80	0.3858	121.0	184.0	9.80
A94010.0	–	10.00	0.3937	121.0	184.0	10.00
A94010.2	–	10.20	0.4016	121.0	184.0	10.20
A94010.3	–	10.30	0.4055	121.0	184.0	10.30
A94013/32	13/32	10.32	0.4063	111.0	178.0	10.32
A94010.5	–	10.50	0.4134	121.0	184.0	10.50
A94027/64	27/64	10.72	0.4219	117.0	184.0	10.72
A94011.0	–	11.00	0.4331	128.0	195.0	11.00
A9407/16	7/16	11.11	0.4375	117.0	184.0	11.11
A94011.5	–	11.50	0.4528	128.0	195.0	11.50
A94029/64	29/64	11.51	0.4531	121.0	190.0	11.51
A94011.8	–	11.80	0.4646	128.0	195.0	11.80
A94012.0	–	12.00	0.4724	134.0	205.0	12.00
A94012.2	–	12.20	0.4803	134.0	205.0	12.20
A94031/64	31/64	12.30	0.4844	121.0	197.0	12.30
A94012.5	–	12.50	0.4921	134.0	205.0	12.50
A94013.0	–	13.00	0.5118	134.0	205.0	13.00
A94017/32	17/32	13.49	0.5313	121.0	203.0	13.49
A94014.0	–	14.00	0.5512	140.0	214.0	14.00
A9409/16	9/16	14.29	0.5625	124.0	210.0	14.29
A94014.5	–	14.50	0.5709	144.0	220.0	14.50
A94015.0	–	15.00	0.5906	144.0	220.0	15.00
A94015.5	–	15.50	0.6102	149.0	227.0	15.50
A94016.0	–	16.00	0.6299	149.0	227.0	16.00
A94021/32	21/32	16.67	0.6563	130.0	229.0	16.67
A94017.0	–	17.00	0.6693	154.0	235.0	17.00
A94011/16	11/16	17.46	0.6875	137.0	235.0	17.46
A94019.0	–	19.00	0.7480	162.0	247.0	19.00

A976

DORMER

超长系列PFX含钴高速钢钻头(DIN1869系列1)，表面光亮处理。
推荐应用于超深孔加工或存在额外干涉的场合，特别设计的抛物线槽型避免了啄钻的要求，130°钻尖角，建议配合3倍径的PFX引导钻使用（确保相同的切削直径公差），适用于多种材料的切削。

PFX



HSS-E	DIN 1869-1	15×D
130°	Bright	
λ>35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪29 C	◪33 C	◪34 C	◪25 C	■22 C	■19 A	■18 C	■14 C	■12 A	■11 C	■9 A	■7 A	◪16 B	◪14 B
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2
◪15 B	◪12 B	◪8 C	◪7 C	◪6 C	◪8 A	◪20 C	◪16 C	◪13 A	◪17 C	◪13 C	◪11 A	◪16 C	◪12 C
K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N3.1	S1.1	S1.2	S1.3				
◪9 A	◪8 A	◪6 A	◪18 C	◪14 C	◪11 A	◪30 D	◪15 C	◪11 A	◪5 A				

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9761.5	–	1.50	0.0591	75.0	115.0	1.50
A9762.0X125	–	2.00	0.0787	85.0	125.0	2.00
A9762.1X125	–	2.10	0.0827	85.0	125.0	2.10
A9762.2X135	–	2.20	0.0866	90.0	135.0	2.20
A9762.3X135	–	2.30	0.0906	90.0	135.0	2.30
A9762.4X140	–	2.40	0.0945	95.0	140.0	2.40
A9762.5X140	–	2.50	0.0984	95.0	140.0	2.50
A9762.6X140	–	2.60	0.1024	95.0	140.0	2.60
A9762.7X150	–	2.70	0.1063	100.0	150.0	2.70
A9762.8X150	–	2.80	0.1102	100.0	150.0	2.80
A9762.9X150	–	2.90	0.1142	100.0	150.0	2.90
A9763.0X150	–	3.00	0.1181	100.0	150.0	3.00
A9763.1X155	–	3.10	0.1220	105.0	155.0	3.10
A9761/8	1/8	3.18	0.1250	105.0	155.0	3.18
A9763.2X155	–	3.20	0.1260	105.0	155.0	3.20
A9763.3X155	–	3.30	0.1299	105.0	155.0	3.30
A9763.4X165	–	3.40	0.1339	115.0	165.0	3.40
A9763.5X165	–	3.50	0.1378	115.0	165.0	3.50
A9763.6X165	–	3.60	0.1417	115.0	165.0	3.60
A9763.7X165	–	3.70	0.1457	115.0	165.0	3.70
A9763.8X175	–	3.80	0.1496	120.0	175.0	3.80
A9763.9X175	–	3.90	0.1535	120.0	175.0	3.90
A9765/32	5/32	3.97	0.1563	120.0	175.0	3.97
A9764.0X175	–	4.00	0.1575	120.0	175.0	4.00
A9764.1X175	–	4.10	0.1614	120.0	175.0	4.10
A9764.2X175	–	4.20	0.1654	120.0	175.0	4.20
A9764.3X185	–	4.30	0.1693	125.0	185.0	4.30
A9764.5X185	–	4.50	0.1772	125.0	185.0	4.50
A9764.6X185	–	4.60	0.1811	125.0	185.0	4.60
A9764.7X185	–	4.70	0.1850	125.0	185.0	4.70
A9763/16	3/16	4.76	0.1875	135.0	195.0	4.76
A9764.8X195	–	4.80	0.1890	135.0	195.0	4.80
A9765.0X195	–	5.00	0.1969	135.0	195.0	5.00

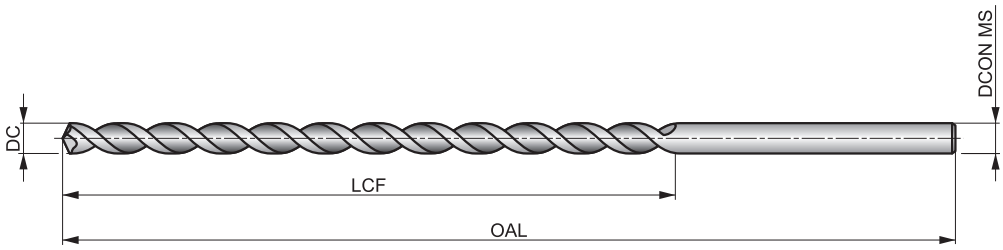
Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9765.1X195	–	5.10	0.2008	135.0	195.0	5.10
A9765.2X195	–	5.20	0.2047	135.0	195.0	5.20
A9765.3X195	–	5.30	0.2087	135.0	195.0	5.30
A9765.5X205	–	5.50	0.2165	140.0	205.0	5.50
A9765.7X205	–	5.70	0.2244	140.0	205.0	5.70
A9765.8X205	–	5.80	0.2283	140.0	205.0	5.80
A9765.9X205	–	5.90	0.2323	140.0	205.0	5.90
A9766.0X205	–	6.00	0.2362	140.0	205.0	6.00
A9766.1X215	–	6.10	0.2402	150.0	215.0	6.10
A9766.2X215	–	6.20	0.2441	150.0	215.0	6.20
A9761/4	1/4	6.35	0.2500	150.0	215.0	6.35
A9766.4X215	–	6.40	0.2520	150.0	215.0	6.40
A9766.5X215	–	6.50	0.2559	150.0	215.0	6.50
A9766.7X215	–	6.70	0.2638	150.0	215.0	6.70
A9766.8X225	–	6.80	0.2677	155.0	225.0	6.80
A9767.0X225	–	7.00	0.2756	155.0	225.0	7.00
A9767.5X225	–	7.50	0.2953	155.0	225.0	7.50
A9765/16	5/16	7.94	0.3125	165.0	240.0	7.94
A9768.0X240	–	8.00	0.3150	165.0	240.0	8.00
A9768.5X240	–	8.50	0.3346	165.0	240.0	8.50
A97611/32	11/32	8.73	0.3438	175.0	250.0	8.73
A9769.0X250	–	9.00	0.3543	175.0	250.0	9.00
A9769.5X250	–	9.50	0.3740	175.0	250.0	9.50
A9763/8	3/8	9.52	0.3750	185.0	265.0	9.52
A97610.0X265	–	10.00	0.3937	185.0	265.0	10.00
A97610.5	–	10.50	0.4134	185.0	265.0	10.50
A97611.0	–	11.00	0.4331	195.0	280.0	11.00
A9767/16	7/16	11.11	0.4375	195.0	280.0	11.11
A97611.5	–	11.50	0.4528	195.0	280.0	11.50
A97612.0	–	12.00	0.4724	205.0	295.0	12.00
A97612.5	–	12.50	0.4921	205.0	295.0	12.50
A97613.0	–	13.00	0.5118	205.0	295.0	13.00
A97614.0 [1]	–	14.00	0.5512	215.0	310.0	14.00

A977

DORMER

超长系列PFX含钴高速钢钻头(DIN1869系列2)，表面光亮处理。
推荐应用于超深孔加工或存在额外干涉的场合，特别设计的抛物线槽型避免了啄钻的要求，130°钻尖角，建议配合3倍径的PFX引导钻使用（确保相同的切削直径公差），适用于多种材料的切削。

PFX



HSS-E	DIN 1869-2	20×D
130°	Bright	
λ>35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪29 B	◪33 B	◪34 B	◪25 B	■22 B	■19 A	■18 B	■14 B	■12 A	■11 B	■9 A	■7 A	◪16 B	◪14 B
M2.1	**M2.2**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K4.1**	**K4.2**
◪15 B	◪12 B	◪8 B	◪7 B	◪6 B	◪8 A	◪20 B	◪16 B	◪13 A	◪17 B	◪13 B	◪11 A	◪16 B	◪12 B
K4.3	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N3.1**	**S1.1**	**S1.2**	**S1.3**				
◪9 A	◪8 A	◪6 A	◪18 B	◪14 B	◪11 A	◪30 C	◪15 B	◪11 A	◪5 A				

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9771.5 [1]	–	1.50	0.0591	100.0	150.0	1.50
A9771/16 [1]	1/16	1.59	0.0625	100.0	150.0	1.59
A9772.0 [1]	–	2.00	0.0787	110.0	160.0	2.00
A9773/32 [1]	3/32	2.38	0.0938	115.0	170.0	2.38
A9773.0X190	–	3.00	0.1181	130.0	190.0	3.00
A9771/8	1/8	3.18	0.1250	135.0	200.0	3.18
A9773.5X210	–	3.50	0.1378	145.0	210.0	3.50
A9774.0X220	–	4.00	0.1575	150.0	220.0	4.00
A9774.5X235	–	4.50	0.1772	160.0	235.0	4.50
A9773/16	3/16	4.76	0.1875	170.0	245.0	4.76
A9775.0X245	–	5.00	0.1969	170.0	245.0	5.00
A9775.5X260	–	5.50	0.2165	180.0	260.0	5.50
A9776.0X260	–	6.00	0.2362	180.0	260.0	6.00
A9771/4	1/4	6.35	0.2500	190.0	275.0	6.35

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9776.5X275	–	6.50	0.2559	190.0	275.0	6.50
A9777.0X290	–	7.00	0.2756	200.0	290.0	7.00
A9778.0X305	–	8.00	0.3150	210.0	305.0	8.00
A9778.5X305	–	8.50	0.3346	210.0	305.0	8.50
A9779.0X320	–	9.00	0.3543	220.0	320.0	9.00
A9779.5X320	–	9.50	0.3740	220.0	320.0	9.50
A97710.0X340	–	10.00	0.3937	235.0	340.0	10.00
A97710.5	–	10.50	0.4134	235.0	340.0	10.50
A97711.0	–	11.00	0.4331	250.0	365.0	11.00
A97711.5	–	11.50	0.4528	250.0	365.0	11.50
A97712.0	–	12.00	0.4724	260.0	375.0	12.00
A97712.5	–	12.50	0.4921	260.0	375.0	12.50
A97713.0	–	13.00	0.5118	260.0	375.0	13.00
A97714.0 [1]	–	14.00	0.5512	270.0	390.0	14.00

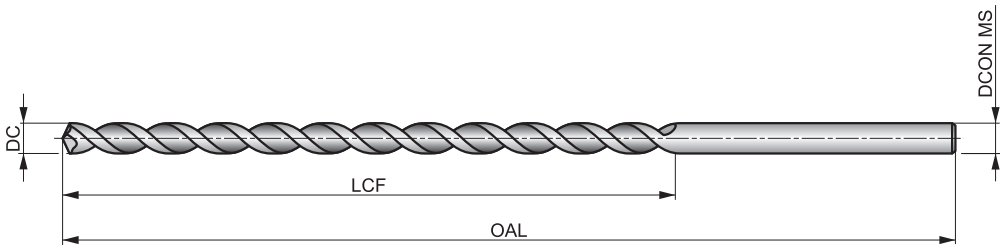
[1] Dormer标准

A978

DORMER

超长系列PFX含钻高速钢钻头(DIN1869系列3)，表面光亮处理。
推荐应用于超深孔加工或存在额外干涉的场合，特别设计的抛物线槽型避免了啄钻的要求，130°钻尖角，建议配合3倍径的PFX引导钻使用（确保相同的切削直径公差），适用于多种材料的切削。

PFX



HSS-E	DIN 1869-3	25×D
130°	Bright	
λ>35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪29 A	◪33 A	◪34 A	◪25 A	■22 A	■19 A	■18 A	■14 A	■12 A	■11 A	■9 A	■7 A	◪16 A	◪14 A
M2.1	**M2.2**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K4.1**	**K4.2**
◪15 A	◪12 A	◪8 A	◪7 A	◪6 A	◪8 A	◪20 A	◪16 A	◪13 A	◪17 A	◪13 A	◪11 A	◪16 A	◪12 A
K4.3	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N3.1**	**S1.1**	**S1.2**	**S1.3**				
◪9 A	◪8 A	◪6 A	◪18 A	◪14 A	◪11 A	◪30 B	◪15 A	◪11 A	◪5 A				

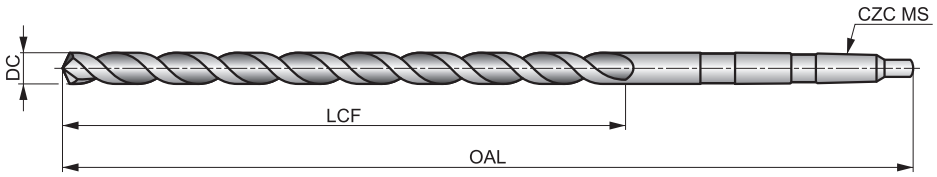
Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A9783.0 [1]	–	3.00	0.1181	160.0	240.0	3.00
A9783.5X265	–	3.50	0.1378	180.0	265.0	3.50
A9784.0X280	–	4.00	0.1575	190.0	280.0	4.00
A9784.5X295	–	4.50	0.1772	200.0	295.0	4.50
A9785.0X315	–	5.00	0.1969	210.0	315.0	5.00
A9786.0X330	–	6.00	0.2362	225.0	330.0	6.00
A9781/4	1/4	6.35	0.2500	235.0	350.0	6.35
A9786.5X350	–	6.50	0.2559	235.0	350.0	6.50
A9787.0X370	–	7.00	0.2756	250.0	370.0	7.00
A9788.0X390	–	8.00	0.3150	265.0	390.0	8.00
A9788.5X390	–	8.50	0.3346	265.0	390.0	8.50
A9789.0X410	–	9.00	0.3543	280.0	410.0	9.00
A9789.5X410	–	9.50	0.3740	280.0	410.0	9.50
A97810.0X430	–	10.00	0.3937	295.0	430.0	10.00

[1] Dormer标准

A952

DORMER

PFX超长系列高速钢锥柄钻(DIN1870系列2)，表面光亮处理。
一种具有特殊抛物线槽设计的多功能钻头，能够一次进刀完成深孔加工，130°的钻尖角有助于自定心(建议使用短型PFX钻头定心)，因此减小了钻孔过程中的切削力，适用于多种材料的切削。



HSS	DIN 1870(2)	20×D
130°	Bright ST	
λ>35°	R	DC h8

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■25 G	■28 G	■29 G	■22 G	■19 E	◪17 C	◪12 D	◪9 D	◪8 C	◪7 D	◪6 C	◪5 B	◪16 C	◪14 C
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪15 C	◪12 C	◪7 E	◪6 E	◪5 E	◪12 A	◪22 G	◪16 D	◪12 D	◪16 C	◪13 C	◪10 C	◪14 C	◪11 C
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪9 C	◪13 C	◪10 C	◪7 C	◪6 C	◪5 C	◪15 C	◪11 C	◪9 C	◪30 H	◪23 H	◪15 G	◪37 F	◪33 F
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪24 F	◪56 F	◪33 G	◪17 D	◪30 J	◪30 H	◪10 F	◪18 D	◪10 B	◪6 A	◪7 C	◪4 A	◪5 C	◪3 A
S4.1	S4.2												
◪4 C	◪2 A												

DC >= 14.5mm 小于 20xD; DC > 23mm 光亮表面

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	CZC MS
A9528.0	8.00	0.3150	210.0	330.0	MK 1
A9529.0	9.00	0.3543	220.0	345.0	MK 1
A95210.0	10.00	0.3937	235.0	360.0	MK 1
A95211.0	11.00	0.4331	250.0	375.0	MK 1
A95213.0	13.00	0.5118	260.0	395.0	MK 1
A95214.0	14.00	0.5512	275.0	410.0	MK 1
A95215.0	15.00	0.5906	275.0	425.0	MK 2
A95216.0	16.00	0.6299	295.0	445.0	MK 2
A95217.0	17.00	0.6693	295.0	445.0	MK 2
A95219.0	19.00	0.7480	310.0	465.0	MK 2

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	CZC MS
A95220.0	20.00	0.7874	325.0	490.0	MK 2
A95221.0	21.00	0.8268	325.0	490.0	MK 2
A95223.0	23.00	0.9055	345.0	515.0	MK 2
A95224.0	24.00	0.9449	365.0	555.0	MK 3
A95225.0	25.00	0.9843	365.0	555.0	MK 3
A95226.0	26.00	1.0236	365.0	555.0	MK 3
A95227.0	27.00	1.0630	385.0	580.0	MK 3
A95228.0	28.00	1.1024	385.0	580.0	MK 3
A95229.0	29.00	1.1417	385.0	580.0	MK 3
A95230.0	30.00	1.1811	385.0	580.0	MK 3

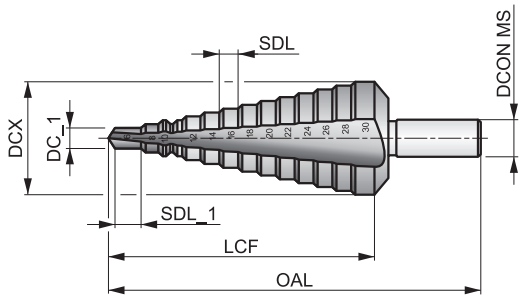
材料代码(BMC)	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	HSS	
基本标准组(BSG)	DORMER	DIN 373	ANSI	ANSI	ANSI	ANSI	ANSI	DIN 8374	DIN 8376	DORMER	DORMER	
有用长度直径比(ULDR)								4×D	4×D	2.5×D	2.5×D	
应用角度	20°	180°						90°	180°	180°	90°	
涂层	Bright	Bright	Bright	Bright	Bright	Bright	Bright	ST	ST	ST	ST	
柄部												
螺旋形式								λ 20-35°	λ 20-35°			
旋向(切削方向)	R	R	R	R		R	R	R	R	R	R	
产品系列代码	G314	G125	G702	G703	G704	G705	G706	A400	A402	A413	A412	
PSF切削直径范围	4.00 - 9.00	6.50 - 20.00	1/4 - 2"	1/2 - 2.1/8	1/8 - 1.1/2	1/4 - 15/16	1/4 - 1"	M3 - M8	M3 - M10	M3 - M10	M3 - M10	
	136	137	138	139	140	141	142	143	144	145	146	
P	P1	■	■	■	■		■	■	■	■	■	■	
	P2	◪	■	■	■		■	■	■	■	■	■	
	P3	◪	◪	■	■		■	■	■	■	■	■	
	P4		◪	◪	◪		◪	◪	◪	◪	◪	◪	
M	M1	◪	◪	◪	◪		◪	◪	◪	◪	■	■	
	M2	◪	◪	◪	◪		◪	◪	◪	◪	■	■	
	M3								◪	◪	◪	◪	
	M4								◪	◪	◪	◪	
K	K1	◪	◪	■	■		■	■	■	■	■	■	
	K2		◪	■	■		■	■	◪	◪	◪	◪	
	K3		◪	◪	◪		◪	◪	◪	◪	◪	◪	
	K4		◪	◪	◪		◪	◪	◪	◪	◪	◪	
	K5		◪	■	■		■	■	◪	◪	◪	◪	
N	N1	■	■	■	■		■	■	◪	◪	◪	◪	
	N2	◪	◪	◪	◪		◪	◪	◪	◪	◪	◪	
	N3	■	■	■	■		■	■	◪	◪	◪	◪	
	N4	■	◪	■	■		■	■	◪	◪	◪	◪	
	N5											
S	S1								◪	◪	◪	◪	
	S2								◪	◪	◪	◪	
	S3								◪	◪	◪	◪	
	S4								◪	◪	◪	◪	
H	H1												
	H2												
	H3												
	H4												

■推荐使用 ◪可以使用

G314

DORMER

加工薄板材的锥形高速钢阶梯钻，表面光亮处理。
锥形阶梯钻具有多级设计，从而孔径能够逐渐扩大直至所需的直径。削平的缩柄结构意味着所有直径的钻头可以安装同一个标准卡盘或刀柄中，适用于多种材料的切削。



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	M1.1	M1.2	M2.1	K1.1	N1.1	N1.2
■ 20	■ 22	■ 23	■ 17	◪ 15	◪ 13	■ 12	◪ 9	◪ 8	◪ 6	◪ 7	◪ 17	■ 30	■ 23

N1.3	N2.1	N2.2	N3.1	N3.2	N3.3	N4.1	N4.2
◪ 15	◪ 31	◪ 28	■ 34	■ 20	◪ 10	■ 30	■ 20

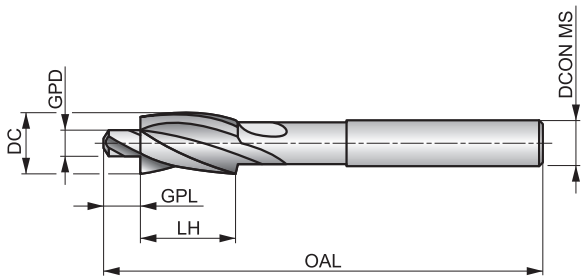
SDI = 阶梯直径增量

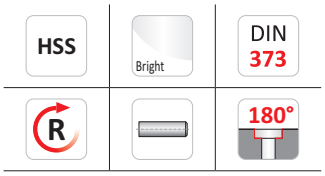
Product	Nr.	DC_1 (mm)	DCX (mm)	SDL (mm)	SDI (mm)	SDL_1 (mm)	LCF (mm)	OAL (mm)	DCON MS (mm)
G314412	412	4.00	12.00	5.00	4 - 5 - 6 - 7 - 8 - 9 - 10 - 11 - 12	5.00	61.0	80.0	6.00
G3141220	1220	12.00	20.00	4.00	12 - 13 - 14 - 15 - 16 - 17 - 18 - 19 - 20	4.00	55.0	76.0	9.00
G3142030	2030	20.00	30.00	4.00	20 - 21 - 22 - 23 - 24 - 25 - 26 - 27 - 28 - 29 - 30	4.00	67.0	88.0	12.00
G3143040	3040	30.00	40.00	4.00	30 - 31 - 32 - 33 - 34 - 35 - 36 - 37 - 38 - 39 - 40	4.00	74.0	98.0	13.00
G314420	420	4.00	20.00	4.00	4 - 6 - 8 - 10 - 12 - 14 - 16 - 18 - 20	4.00	48.0	76.0	8.00
G314630	630	6.00	30.00	4.00	6 - 8 - 10 - 12 - 14 - 16 - 18 - 20 - 22 - 24 - 26 - 28 - 30	4.00	73.0	98.0	10.00
G314M	M	9.00	36.00	3.00	9 - 12 - 15 - 18 - 21 - 24 - 27 - 30 - 33 - 36	3.00	57.0	86.0	12.00

G125

DORMER

180°高速钢直柄沉孔钻，表面光亮处理。
一种用于标准内六角头螺钉和螺栓的180°沉孔钻，它有一个实心的导向柱（可用于不同尺寸公差的预加工孔），有助于在标准公制尺寸的预孔中精确引导沉孔钻，适用于多种材料的切削。





工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■20 E	■22 E	■23 E	■17 E	■15 D	◪13 C	■12 D	◪9 D	◪8 C	◪7 D	◪6 C	◪8 D	◪6 D	◪7 D
M2.2	**M2.3**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**
◪6 D	◪5 C	■17 E	◪12 E	◪11 E	■15 D	◪12 D	◪10 C	◪13 D	◪10 D	◪12 D	◪9 D	■14 D	◪10 D
N1.1	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**			
◪30 G	■23 G	■15 G	◪31 G	◪28 G	◪20 G	■34 C	■20 C	◪10 C	■30 C	◪20 C			

DCON MS公差h9

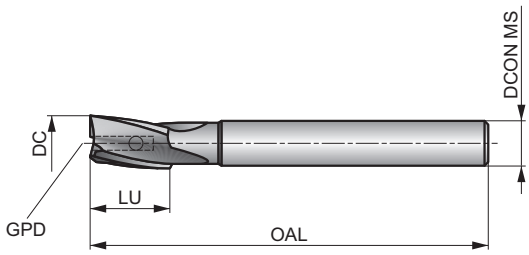
Product	DC	GPD	CZC MS	GPL	OAL	LH	DCON MS	NOF
	(mm)	(mm)		(mm)	(mm)	(mm)	(mm)	
G1256.5X3.2 [1]	6.50	3.20	M 3 f	4.50	71.0	14.0	5.00	3
G1256.5X3.4 [2]	6.50	3.40	M 3 m	4.50	71.0	14.0	5.00	3
G1258.0X3.3 [3]	8.00	3.30	M 4 t	5.00	71.0	14.0	5.00	3
G1258.0X4.3 [1]	8.00	4.30	M 4 f	5.00	71.0	14.0	5.00	3
G1258.0X4.5 [2]	8.00	4.50	M 4 m	5.00	71.0	14.0	5.00	3
G12510.0X4.2 [3]	10.00	4.20	M 5 t	5.50	80.0	18.0	8.00	3
G12510.0X5.3 [1]	10.00	5.30	M 5 f	5.50	80.0	18.0	8.00	3
G12510.0X5.5 [2]	10.00	5.50	M 5 m	5.50	80.0	18.0	8.00	3
G12511.0X5.0 [3]	11.00	5.00	M 6 t	6.00	80.0	18.0	8.00	3
G12511.0X6.4 [1]	11.00	6.40	M 6 f	6.00	80.0	18.0	8.00	3
G12511.0X6.6 [2]	11.00	6.60	M 6 m	6.00	80.0	18.0	8.00	3
G12515.0X6.8 [3]	15.00	6.80	M 8 t	8.00	100.0	22.0	12.50	3
G12515.0X8.4 [1]	15.00	8.40	M 8 f	8.00	100.0	22.0	12.50	3
G12515.0X9.0 [2]	15.00	9.00	M 8 m	8.00	100.0	22.0	12.50	3
G12518.0X8.5 [3]	18.00	8.50	M 10 t	10.00	100.0	22.0	12.50	3
G12518.0X10.5 [1]	18.00	10.50	M 10 f	10.00	100.0	22.0	12.50	3
G12518.0X11.0 [2]	18.00	11.00	M 10 m	10.00	100.0	22.0	12.50	3
G12520.0X10.2 [3]	20.00	10.20	M 12 t	10.00	100.0	22.0	12.50	3
G12520.0X13.0 [1]	20.00	13.00	M 12 f	10.00	100.0	22.0	12.50	3
G12520.0X13.5 [2]	20.00	13.50	M 12 m	10.00	100.0	22.0	12.50	3

[1] f = 用于通孔的精加工
[2] m = 用于通孔的半精加工
[3] t = 用于攻丝底孔

G702

DORMER

带缩柄的高速钢锪孔主体，带引导式钻尖
圆柱柄沉孔主体与可拆卸式引导装置配合使用，通过切削平底沉孔来扩大预制孔的顶部。本体中安装了一个可拆卸引导装置 G704，该引导装置可沿着现有孔导向和对中沉孔切割操作。



HSS | Bright | ANSI

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

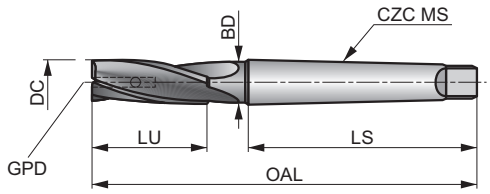
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 20 E	■ 22 E	■ 23 E	■ 17 E	■ 15 D	◪ 13 C	■ 12 D	◪ 9 D	◪ 8 C	◪ 7 D	◪ 6 C	◪	◪ 8 D	◪ 6 D
M2.1	**M2.2**	**M2.3**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**
◪ 7 D	◪ 6 D	◪ 5 C	■ 17 E	◪ 12 E	◪ 11 E	■ 15 D	◪ 12 D	◪ 10 C	◪ 13 D	◪ 10 D	◪ 12 D	◪ 9 D	■ 14 D
K5.2	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**		
◪ 10 D	◪ 30 G	■ 23 G	■ 15 G	◪ 31 G	◪ 28 G	◪ 20 G	■ 34 C	■ 20 C	◪ 10 C	■ 30 C	◪ 20 C		

Product	DC (inch)	DC (inch)	LU (inch)	OAL (inch)	DCON MS (inch)	NOF	GPD (inch)	GPDN (inch)	GPDX (inch)
G7021/4	1/4	0.2500	3/4	3.13/16	15/64	3	3/32	1/8	3/16
G7029/32	9/32	0.2813	3/4	3.13/16	17/64	3	3/32	1/8	7/32
G7025/16	5/16	0.3125	3/4	3.13/16	19/64	3	3/32	1/8	1/4
G70211/32	11/32	0.3438	3/4	3.13/16	5/16	3	3/32	1/8	9/32
G7023/8	3/8	0.3750	1″	4.1/16	5/16	3	5/32	3/16	5/16
G70213/32	13/32	0.4063	1″	4.1/16	3/8	3	5/32	3/16	11/32
G7027/16	7/16	0.4375	1″	4.1/16	3/8	3	5/32	3/16	3/8
G70215/32	15/32	0.4688	1.1/4	4.5/16	7/16	3	3/16	3/16	13/32
G7021/2	1/2	0.5000	1.1/4	4.5/16	7/16	3	3/16	3/16	7/16
G7029/16	9/16	0.5625	1.1/4	4.5/16	1/2	3	3/16	3/16	1/2
G70219/32	19/32	0.5938	1.1/4	5.1/8	1/2	3	3/16	3/16	17/32
G7025/8	5/8	0.6250	1.1/4	5.1/8	1/2	3	3/16	3/16	9/16
G70211/16	11/16	0.6875	1.1/4	5.1/8	1/2	3	3/16	3/16	5/8
G7023/4	3/4	0.7500	1.1/2	5.3/8	1/2	3	1/4	5/16	11/16
G70225/32	25/32	0.7813	1.1/2	5.3/8	5/8	3	1/4	5/16	23/32
G70213/16	13/16	0.8125	1.1/2	5.3/8	5/8	3	1/4	5/16	3/4
G70227/32	27/32	0.8438	1.1/2	5.3/8	3/4	3	1/4	5/16	25/32
G7027/8	7/8	0.8750	1.1/2	5.3/8	3/4	3	1/4	5/16	13/16
G7021	1″	1.0000	1.3/4	6.3/8	3/4	3	5/16	3/8	15/16
G7022	2″	2.0000	2.1/2	8.3/8	1.1/2	5	1/2	9/16	1.15/16

G703

DORMER

带锥柄的 HSS 沉孔主体，带引导式钻尖
带莫氏锥柄的沉孔主体与可拆卸引导装置配合使用，通过切削平底沉孔来扩大预成型孔的顶部。本体中安装了一个可拆卸引导装置 G704，该引导装置可沿着现有孔引导沉孔切削操作并使其居中。



HSS | Bright | ANSI

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 20 E	■ 22 E	■ 23 E	■ 17 E	■ 15 D	◪ 13 C	■ 12 D	◪ 9 D	◪ 8 C	◪ 7 D	◪ 6 C	◪	◪ 8 D	◪ 6 D
M2.1	**M2.2**	**M2.3**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**
◪ 7 D	◪ 6 D	◪ 5 C	■ 17 E	◪ 12 E	◪ 11 E	■ 15 D	◪ 12 D	◪ 10 C	◪ 13 D	◪ 10 D	◪ 12 D	◪ 9 D	■ 14 D
K5.2	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**		
◪ 10 D	◪ 30 G	■ 23 G	■ 15 G	◪ 31 G	◪ 28 G	◪ 20 G	■ 34 C	■ 20 C	◪ 10 C	■ 30 C	◪ 20 C		

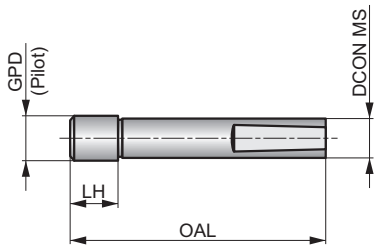
Product	DC (inch)	DC (inch)	LU (inch)	OAL (inch)	CZC MS	BD (inch)	LS (inch)	NOF	GPD (inch)	GPDN (inch)	GPDX (inch)
G7031/2	1/2	0.5000	1.1/4	4.5/16	1	29/64	2.9/16	3	3/16	1/4	7/16
G70311/16	11/16	0.6875	1.1/4	5.1/8	2	5/8	3.1/8	3	3/16	1/4	5/8
G7033/4	3/4	0.7500	1.1/2	5.3/8	2	21/32	3.1/8	3	1/4	5/16	11/16
G70313/16	13/16	0.8125	1.1/2	5.3/8	2	21/32	3.1/8	3	1/4	5/16	3/4
G7037/8	7/8	0.8750	1.1/2	5.3/8	2	21/32	3.1/8	3	1/4	5/16	13/16
G70315/16	15/16	0.9375	1.1/2	6.1/8	3	7/8	3.7/8	3	1/4	5/16	7/8
G7031	1″	1.0000	1.3/4	6.3/8	3	7/8	3.7/8	3	5/16	3/8	15/16
G7031.1/16	1.1/16	1.0625	1.3/4	6.3/8	3	7/8	3.7/8	3	5/16	3/8	1″
G7031.1/8	1.1/8	1.1250	1.3/4	6.3/8	3	7/8	3.7/8	3	5/16	3/8	1.1/16
G7031.3/16	1.3/16	1.1875	1.3/4	6.3/8	3	7/8	3.7/8	3	5/16	3/8	1.1/8
G7031.1/4	1.1/4	1.2500	2″	6.5/8	3	7/8	3.7/8	5	3/8	7/16	1.3/16
G7031.3/8	1.3/8	1.3750	2″	6.5/8	3	7/8	3.7/8	5	3/8	7/16	1.5/16
G7031.1/2	1.1/2	1.5000	2″	7.7/8	4	1.3/16	4.7/8	5	3/8	7/16	1.7/16
G7031.5/8	1.5/8	1.6250	2.1/4	8.1/8	4	1.3/8	4.7/8	5	7/16	1/2	1.9/16
G7032	2″	2.0000	2.1/2	8.3/8	4	1.1/2	4.7/8	5	1/2	9/16	1.5/16
G7032.1/8	2.1/8	2.1250	2.1/2	9.7/8	5	1.3/4	6.1/8	5	1/2	9/16	2.1/16

G704

DORMER

HSS 导孔器，可拆卸式
无切削的可拆卸式引导装置，与沉孔钻体配合使用，可沿着工件上的现有孔进行钻孔。多个具有相同安装（柄）直径的引导装置将与沉孔主体的安装直径相匹配。请确保安装直径与本体的安装直径正确匹配。

HSS	Bright	ANSI



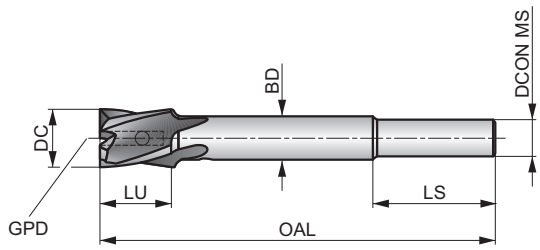
Product	GPD (inch)	DCON MS (inch)	LH (inch)	OAL (inch)
G7041/8X3/32	1/8	3/32	0.125	1.1/4
G7045/32X3/32	5/32	3/32	0.188	1.5/16
G7043/16X3/32	3/16	3/32	0.188	1.5/16
G7047/32X3/32	7/32	3/32	0.250	1.3/8
G7041/4X3/32	1/4	3/32	0.250	1.3/8
G7041/8X1/8	1/8	1/8	0.125	1.7/16
G7045/32X1/8	5/32	1/8	0.188	1.1/2
G7043/16X1/8	3/16	1/8	0.188	1.1/2
G7047/32X1/8	7/32	1/8	0.250	1.9/16
G7041/4X1/8	1/4	1/8	0.250	1.9/16
G7049/32X1/8	9/32	1/8	0.313	1.5/8
G7045/16X1/8	5/16	1/8	0.313	1.5/8
G7043/8X1/8	3/8	1/8	0.375	1.11/16
G7047/16X1/8	7/16	1/8	0.438	1.3/4
G7041/2X1/8	1/2	1/8	0.500	1.13/16
G7043/16X5/32	3/16	5/32	0.188	1.9/16
G7047/32X5/32	7/32	5/32	0.250	1.5/8
G7041/4X5/32	1/4	5/32	0.250	1.5/8
G7049/32X5/32	9/32	5/32	0.313	1.11/16
G7045/16X5/32	5/16	5/32	0.313	1.11/16
G7043/8X5/32	3/8	5/32	0.375	1.3/4
G7043/16X3/16	3/16	3/16	0.250	1.7/8
G7047/32X3/16	7/32	3/16	0.250	1.7/8
G7041/4X3/16	1/4	3/16	0.250	1.7/8
G7049/32X3/16	9/32	3/16	0.313	1.15/16
G7045/16X3/16	5/16	3/16	0.313	1.15/16
G70411/32X3/16	11/32	3/16	0.375	2″
G7043/8X3/16	3/8	3/16	0.375	2″
G70413/32X3/16	13/32	3/16	0.438	2.1/16
G7047/16X3/16	7/16	3/16	0.438	2.1/16
G70415/32X3/16	15/32	3/16	0.500	2.1/8
G7041/2X3/16	1/2	3/16	0.500	2.1/8
G7049/16X3/16	9/16	3/16	0.563	2.3/16
G7045/8X3/16	5/8	3/16	0.563	2.3/16
G70413/16X3/16	13/16	3/16	0.813	2.7/16
G7047/8X3/16	7/8	3/16	0.875	2.1/2
G7041/4X1/4	1/4	1/4	0.250	1.11/16
G7049/32X1/4	9/32	1/4	0.313	1.3/4
G7045/16X1/4	5/16	1/4	0.313	1.3/4

Product	GPD (inch)	DCON MS (inch)	LH (inch)	OAL (inch)
G7043/8X1/4	3/8	1/4	0.375	1.13/16
G7047/16X1/4	7/16	1/4	0.438	1.7/8
G7041/2X1/4	1/2	1/4	0.500	1.15/16
G70417/32X1/4	17/32	1/4	0.563	2″
G7049/16X1/4	9/16	1/4	0.563	2″
G7045/8X1/4	5/8	1/4	0.625	2.1/16
G70411/16X1/4	11/16	1/4	0.688	2.1/8
G7043/4X1/4	3/4	1/4	0.750	2.3/16
G70413/16X1/4	13/16	1/4	0.875	2.5/16
G7041X1/4	1″	1/4	1.000	2.7/16
G7043/8X5/16	3/8	5/16	0.375	2″
G7047/16X5/16	7/16	5/16	0.438	2.1/16
G7041/2X5/16	1/2	5/16	0.500	2.1/8
G7049/16X5/16	9/16	5/16	0.563	2.3/16
G7045/8X5/16	5/8	5/16	0.625	2.1/4
G70411/16X5/16	11/16	5/16	0.688	2.5/16
G7043/4X5/16	3/4	5/16	0.750	2.3/8
G70413/16X5/16	13/16	5/16	0.875	2.1/2
G70415/16X5/16	15/16	5/16	1.000	2.5/8
G7041X5/16	1″	5/16	1.000	2.5/8
G7047/16X3/8	7/16	3/8	0.438	2.5/16
G7041/2X3/8	1/2	3/8	0.500	2.3/8
G7049/16X3/8	9/16	3/8	0.563	2.7/16
G7045/8X3/8	5/8	3/8	0.625	2.1/2
G70411/16X3/8	11/16	3/8	0.688	2.9/16
G7043/4X3/8	3/4	3/8	0.750	2.5/8
G70413/16X3/8	13/16	3/8	0.875	2.3/4
G7047/8X3/8	7/8	3/8	0.875	2.3/4
G70415/16X3/8	15/16	3/8	1.000	2.5/8
G7049/16X7/16	9/16	7/16	0.625	2.7/8
G70411/16X7/16	11/16	7/16	0.750	3″
G7043/4X7/16	3/4	7/16	0.750	3″
G70413/16X7/16	13/16	7/16	0.875	3.1/8
G7047/8X7/16	7/8	7/16	0.875	3.1/8
G70415/16X7/16	15/16	7/16	1.000	3.1/4
G7041X7/16	1″	7/16	1.000	3.1/4
G7049/16X1/2	9/16	1/2	0.625	3.1/8
G7041X1/2	1″	1/2	1.000	3.1/2
G7041.1/2X1/2	1.1/2	1/2	1.500	4″

G705

DORMER

HSS 沉孔主体，航空航天专用长系列，带引导式钻尖
圆柱柄航空航天专用长系列沉孔主体与可拆卸引导装置配合使用，通过切削平底沉孔来扩大预制孔的顶部。本体中安装有一个可拆卸引导装置 G704，该引导装置可沿着现有孔导向和对中沉孔切削操作。



HSS | Bright | ANSI

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

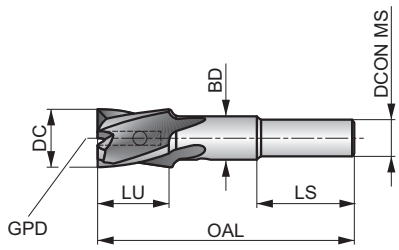
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■20 E	■22 E	■23 E	■17 E	■15 D	◪13 C	■12 D	◪9 D	◪8 C	◪7 D	◪6 C	◪8 D	◪6 D	◪7 D
M2.2	**M2.3**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**
◪6 D	◪5 C	■17 E	◪12 E	◪11 E	■15 D	◪12 D	◪10 C	◪13 D	◪10 D	◪12 D	◪9 D	■14 D	◪10 D
N1.1	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**			
◪30 G	■23 G	■15 G	◪31 G	◪28 G	◪20 G	■34 C	■20 C	◪10 C	■30 C	◪20 C			

Product	DC (inch)	DC (inch)	LU (inch)	OAL (inch)	DCON MS (inch)	LS (inch)	BD (inch)	NOF	GPD (inch)	GPDN (inch)	GPDX (inch)
G7051/4	1/4	0.2500	1/2	4	15/64	15/64	15/64	4	3/32	1/8	3/16
G7055/16	5/16	0.3125	1/2	4	19/64	19/64	19/64	4	3/32	1/8	1/4
G7053/8	3/8	0.3750	5/8	4	5/16	5/16	5/16	4	3/32	1/8	5/16
G7057/16	7/16	0.4375	5/8	4	3/8	3/8	3/8	4	1/8	3/16	3/8
G7051/2	1/2	0.5000	5/8	4.1/4	7/16	7/16	7/16	4	1/8	1/8	7/16
G70517/32	17/32	0.5313	5/8	4.1/4	1/2	1/2	1/2	4	1/8	1/8	1/2
G7059/16	9/16	0.5625	5/8	4.1/4	1/2	1/2	1/2	4	1/8	1/8	1/2
G70519/32	19/32	0.5938	5/8	4.1/4	1/2	9/16	9/16	4	1/8	1/8	1/2
G7055/8	5/8	0.6250	5/8	4.1/4	1/2	9/16	9/16	4	1/8	1/8	1/2
G70521/32	21/32	0.6563	5/8	5.3/8	1/2	9/16	9/16	4	3/16	3/16	5/8
G70511/16	11/16	0.6875	5/8	5.3/8	1/2	5/8	5/8	4	3/16	3/16	5/8
G7053/4	3/4	0.7500	3/4	5.3/8	1/2	11/16	11/16	4	3/16	3/16	5/8
G70525/32	25/32	0.7813	3/4	5.3/8	1/2	11/16	11/16	4	3/16	3/16	5/8
G70513/16	13/16	0.8125	3/4	5.3/8	1/2	3/4	3/4	4	3/16	3/16	5/8
G7057/8	7/8	0.8750	15/16	5.3/8	1/2	3/4	3/4	4	3/16	3/16	13/16
G70515/16	15/16	0.9375	15/16	5.3/8	1/2	3/4	3/4	4	3/16	3/16	7/8

G706

DORMER

HSS 沉孔主体，航空航天专用短系列，带引导式钻尖
圆柱柄航空航天专用短系列沉孔主体与可拆卸引导装置配合使用，通过切削平底沉孔来扩大预制孔的顶部。本体中安装了一个可拆卸引导装置 G704，该引导装置可沿着现有孔导向和对中沉孔切削操作。



HSS | Bright | ANSI

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

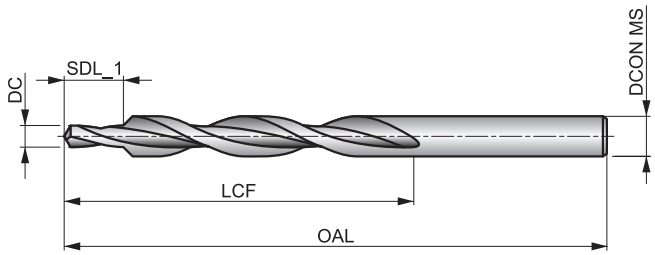
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■20 E	■22 E	■23 E	■17 E	■15 D	◪13 C	■12 D	◪9 D	◪8 C	◪7 D	◪6 C	◪8 D	◪6 D	◪7 D
M2.2	**M2.3**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K4.1**	**K4.2**	**K5.1**	**K5.2**
◪6 D	◪5 C	■17 E	◪12 E	◪11 E	■15 D	◪12 D	◪10 C	◪13 D	◪10 D	◪12 D	◪9 D	■14 D	◪10 D
N1.1	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**			
◪30 G	■23 G	■15 G	◪31 G	◪28 G	◪20 G	■34 C	■20 C	◪10 C	■30 C	◪20 C			

Product	DC (inch)	DC (inch)	LU (inch)	OAL (inch)	DCON MS (inch)	LS (inch)	BD (inch)	NOF	GPD (inch)	GPDN (inch)	GPDX (inch)
G7061/4	1/4	0.2500	1/2	2.3/8	1/4	1.1/8	15/64	4	3/32	1/8	3/16
G7065/16	5/16	0.3125	1/2	2.3/8	1/4	7/8	17/64	4	3/32	1/8	1/4
G70611/32	11/32	0.3438	1/2	2.3/8	1/4	7/8	19/64	4	3/32	1/8	9/32
G7063/8	3/8	0.3750	1/2	2.3/8	1/4	7/8	5/16	4	3/32	3/16	5/16
G70613/32	13/32	0.4063	1/2	2.13/16	1/4	7/8	5/16	4	1/8	3/16	11/32
G7067/16	7/16	0.4375	1/2	2.13/16	1/4	7/8	5/16	4	1/8	3/16	3/8
G70615/32	15/32	0.4688	1/2	2.13/16	1/4	7/8	5/16	4	1/8	1/4	13/32
G7061/2	1/2	0.5000	1/2	2.13/16	1/4	7/8	3/8	4	1/8	1/4	7/16
G70617/32	17/32	0.5313	1/2	2.13/16	1/4	7/8	3/8	4	1/8	1/4	15/32
G7069/16	9/16	0.5625	1/2	2.13/16	1/4	7/8	3/8	4	1/8	1/4	1/2
G70611/16	11/16	0.6875	1/2	2.13/16	1/4	7/8	1/2	4	1/8	1/4	5/8
G7063/4	3/4	0.7500	1/2	2.13/16	1/4	7/8	1/2	4	3/16	5/16	11/16
G70613/16	13/16	0.8125	1/2	2.13/16	1/4	7/8	1/2	4	3/16	5/16	3/4
G7067/8	7/8	0.8750	1/2	2.13/16	1/4	7/8	1/2	4	3/16	5/16	13/16
G7061	1″	1.0000	1/2	2.13/16	1/4	7/8	1/2	4	3/16	3/8	15/16

A400

DORMER

高速钢多刃阶梯钻，蒸汽回火处理。
一种用于标准公制螺钉孔和倒角沉孔的多功能钻头，118°引导钻尖和90°沉孔，蒸汽回火处理能够留存切削液，防止刀具粘屑，适用于数控机床和传统机床，适用于多种材料的切削。



HSS	DIN 8374	4×D
90°	ST	
λ20-35°	R	118°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

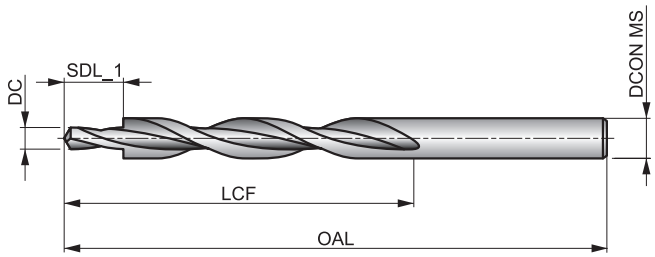
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
29 G	33 G	34 G	25 G	22 E	19 C	15 E	12 E	10 C	9 E	7 C	6 C	22 E	19 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
20 E	16 E	10 G	9 G	8 G	12 C	30 G	22 E	17 E	23 E	19 E	15 C	21 E	16 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
13 C	19 E	14 E	11 C	9 C	8 C	22 E	16 E	13 C	45 E	34 E	23 E	49 E	44 E
N2.3	N3.1	N3.2	N3.3	N4.1	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2
32 E	68 E	40 E	20 E	30 I	23 E	14 C	8 A	8 C	6 A	6 C	4 A	5 C	3 A

Product	TDZ	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	SDL_1 (mm)	DCON MS (mm)
A400M3	M3	3.20	0.1260	57.0	93.0	9.00	6.00
A400M4	M4	4.30	0.1693	75.0	117.0	11.00	8.00
A400M5	M5	5.30	0.2087	87.0	133.0	13.00	10.00
A400M6	M6	6.40	0.2520	94.0	142.0	15.00	11.50
A400M8	M8	8.40	0.3307	114.0	169.0	19.00	15.00

A402

DORMER

高速钢阶梯钻，蒸汽回火处理。
推荐用于标准公制螺钉孔及其沉孔的钻头，118°引导钻尖和90°沉孔，特殊的引导孔直径和长度，蒸汽回火处理能够留存切削液，防止刀具粘屑，适用于多种材料的切削。



HSS	DIN 8376	4×D
180°	ST	
λ20-35°	R	118°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

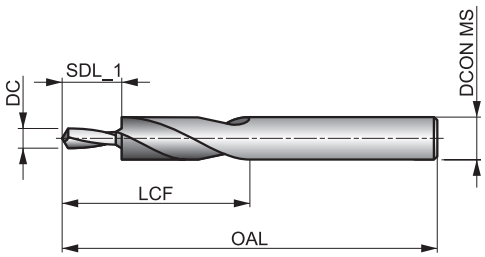
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
29 G	33 G	34 G	25 G	22 E	19 C	15 E	12 E	10 C	9 E	7 C	6 C	22 E	19 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
20 E	16 E	10 G	9 G	8 G	12 C	30 G	22 E	17 E	23 E	19 E	15 C	21 E	16 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
13 C	19 E	14 E	11 C	9 C	8 C	22 E	16 E	13 C	45 E	34 E	23 E	49 E	44 E
N2.3	N3.1	N3.2	N3.3	N4.1	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2
32 E	68 E	40 E	20 E	30 I	23 E	14 C	8 A	8 C	6 A	6 C	4 A	5 C	3 A

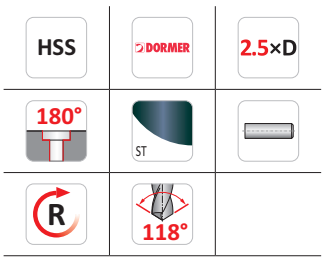
Product	TDZ	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	SDL_1 (mm)	DCON MS (mm)
A402M3	M3	3.40	0.1339	57.0	93.0	9.00	6.00
A402M4	M4	4.50	0.1772	75.0	117.0	11.00	8.00
A402M5	M5	5.50	0.2165	87.0	133.0	13.00	10.00
A402M6	M6	6.60	0.2598	94.0	142.0	15.00	11.00
A402M8	M8	9.00	0.3543	114.0	169.0	19.00	15.00
A402M10	M10	11.00	0.4331	130.0	191.0	23.00	18.00

A413

DORMER

高速钢阶梯钻，蒸汽回火处理。
一种推荐作为标准公制螺钉孔及其沉孔的通用钻头，118°引导钻尖和180°沉孔，蒸汽回火处理能够留存切削液，防止刀具粘屑，适用于数控机床和传统机床，适用于多种材料的切削。





工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

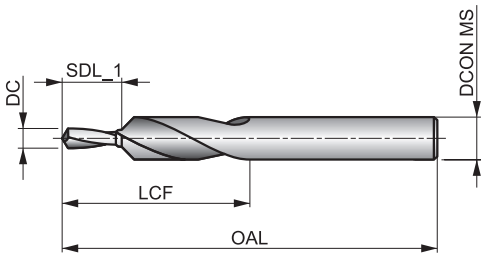
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 29 I	■ 33 I	■ 34 I	■ 25 I	■ 22 G	◪ 19 E	■ 15 G	■ 12 G	◪ 10 E	■ 9 G	◪ 7 E	◪ 6 C	■ 22 G	■ 19 G
M2.1	**M2.2**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**
■ 20 G	■ 16 G	◪ 10 I	◪ 9 I	◪ 8 I	◪ 12 E	■ 30 G	■ 22 E	■ 17 E	◪ 23 E	◪ 19 E	◪ 15 E	◪ 21 E	◪ 16 E
K3.3	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪ 13 E	◪ 19 E	◪ 14 E	◪ 11 E	◪ 9 E	◪ 8 E	◪ 22 E	◪ 16 E	◪ 13 E	◪ 45 G	◪ 34 G	◪ 23 G	◪ 42 G	◪ 37 G
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**	**S3.1**	**S3.2**	**S4.1**	**S4.2**
◪ 27 G	◪ 68 G	◪ 40 G	◪ 20 G	◪ 30 I	◪ 27 G	◪ 16 E	◪ 8 C	◪ 11 G	◪ 6 C	◪ 8 G	◪ 4 C	◪ 6 G	◪ 3 C

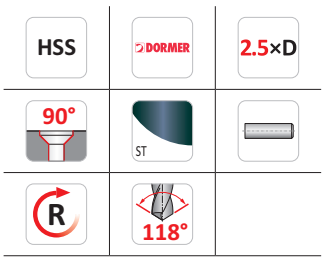
Product	TDZ	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	SDL_1 (mm)	DCON MS (mm)
A413M3	M3	3.40	0.1339	28.0	66.0	9.00	6.00
A413M4	M4	4.50	0.1772	37.0	79.0	11.00	8.00
A413M5	M5	5.50	0.2165	43.0	89.0	13.00	10.00
A413M6	M6	6.60	0.2598	47.0	95.0	15.00	11.00
A413M8	M8	9.00	0.3543	56.0	111.0	19.00	15.00
A413M10	M10	11.00	0.4331	62.0	123.0	23.00	18.00

A412

DORMER

高速钢阶梯钻，蒸汽回火处理。
一种用于标准公制螺钉孔及其沉孔的钻头，118°的引导钻尖和90°倒角，蒸汽回火处理能够留存切削液，防止刀具粘屑，适用于数控机床和传统机床，适用于多种材料的切削。





工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 29 I	■ 33 I	■ 34 I	■ 25 I	■ 22 G	◪ 19 E	■ 15 G	■ 12 G	◪ 10 E	■ 9 G	◪ 7 E	◪ 6 C	■ 22 G	■ 19 G
M2.1	**M2.2**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**
■ 20 G	■ 16 G	◪ 10 I	◪ 9 I	◪ 8 I	◪ 12 E	■ 30 G	■ 22 E	■ 17 E	◪ 23 E	◪ 19 E	◪ 15 E	◪ 21 E	◪ 16 E
K3.3	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪ 13 E	◪ 19 E	◪ 14 E	◪ 11 E	◪ 9 E	◪ 8 E	◪ 22 E	◪ 16 E	◪ 13 E	◪ 45 G	◪ 34 G	◪ 23 G	◪ 42 G	◪ 37 G
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**	**S3.1**	**S3.2**	**S4.1**	**S4.2**
◪ 27 G	◪ 68 G	◪ 40 G	◪ 20 G	◪ 30 I	◪ 27 G	◪ 16 E	◪ 8 C	◪ 11 G	◪ 6 C	◪ 8 G	◪ 4 C	◪ 6 G	◪ 3 C

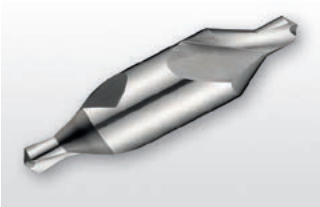
Product	TDZ	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	SDL_1 (mm)	DCON MS (mm)
A412M3	M3	3.40	0.1339	31.0	70.0	9.00	6.60
A412M4	M4	4.50	0.1772	40.0	84.0	11.00	9.00
A412M5	M5	5.50	0.2165	47.0	95.0	13.00	11.00
A412M6	M6	6.60	0.2598	51.0	102.0	15.00	13.00
A412M8	M8	9.00	0.3543	62.0	123.0	19.00	17.20
A412M10	M10	11.00	0.4331	70.0	141.0	23.00	21.50

材料代码(BMC)	HSS	HSS	HSS-E	HSS-E	HSS	HSS	HSS	HSS-E	HM	HSS		
基本标准组(BSG)	DIN 333A	DIN 333A	DIN 333A	DIN 333A	DIN 333R	DORMER	BS 328	DORMER	DIN 333A			
有用长度直径比 (ULDR)	1×D	1×D	1×D	1×D	1×D	1×D	1×D	1×D	1×D	1×D		
应用角度	60°	60°	60°	60°	R	60°	60°	60°	60°	60°		
涂层	Bright	TiN	Bright	TiAlN	Bright	Bright	Bright	Bright	Bright	Bright		
柄部												
旋向(切削方向)	R	R	R	R	R	R	R	R	R	R		
产品系列代码	A200	A205	A206	A266	A210	A201	A225	A242	R200	A296		
PSF切削直径范围	0.50 - 12.50	1.00 - 5.00	1.00 - 5.00	1.00 - 5.00	0.50 - 8.00	0.63 - 6.00	3/64 - 5/16	1.00 - 5.00	1.00 - 5.00	Set		
	148	149	150	151	152	153	154	155	156	156		
P P1	■	■	■	■	■	■	■	■	■			
P2	■	■	■	■	■	■	■	■	■			
P3	■	■	■	■	■	■	■	■	■			
P4	◪	◪	◪	◪	◪	◪	◪	◪	■			
M M1	◪	◪	◪	◪	◪	◪	◪	◪				
M2	◪	◪	◪	◪	◪	◪	◪	◪				
M3	◪	◪	◪	◪	◪	◪	◪	◪				
M4	◪	◪	◪	◪	◪	◪	◪	◪				
K K1	■	■	■	■	■	■	■	■	■			
K2	◪	◪	◪	◪	◪	◪	◪	◪	■			
K3	◪	◪	◪	◪	◪	◪	◪	◪	■			
K4	◪	◪	◪	◪	◪	◪	◪	◪	■			
K5	◪	◪	◪	◪	◪	◪	◪	◪	■			
N N1	◪	◪	◪	◪	◪	◪	◪	◪	■			
N2	◪	◪	◪	◪	◪	◪	◪	◪	■			
N3	◪	◪	◪	◪	◪	◪	◪	◪	■			
N4	◪	◪	◪	◪	◪	◪	◪	◪				
N5												
S S1	◪	◪	◪	◪	◪	◪	◪	◪				
S2	◪	◪	◪	◪	◪	◪	◪	◪				
S3	◪	◪	◪	◪	◪	◪	◪	◪				
S4	◪	◪	◪	◪	◪	◪	◪	◪				
H H1												
H2												
H3												
H4												

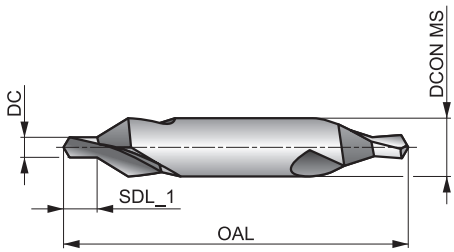
■推荐使用 ◪可以使用

A200

DORMER



118°高速钢中心钻带60°倒角，表面光亮处理。
推荐用于在工件轴的端部钻一个高精度孔，以便工件轴在正式加工前安全地固定。两端均可使用的双头钻提高了刀具的加工效率，适用于多种材料的切削。



HSS	DIN 333A	1×D
60°	Bright	
R	118°	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■33 I	■37 I	■38 I	■28 I	■25 G	◪22 E	■19 F	■15 F	◪13 E	■11 F	◪10 E	◪8 D	◪21 E	◪17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪18 E	◪15 E	◪9 G	◪8 G	◪7 G	◪10 C	■30 I	■22 F	■17 F	◪25 E	◪20 E	◪16 E	◪22 E	◪17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 E	◪20 E	◪15 E	◪11 E	◪10 E	◪8 E	◪23 E	◪17 E	◪13 E	◪33 J	◪25 J	◪17 I	◪42 H	◪37 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪27 H	◪56 H	◪33 I	◪17 G	◪30 J	◪28 H	◪14 F	◪24 F	◪13 D	◪7 B	◪7 E	◪6 A	◪5 E	◪4 A
S4.1	S4.2												
◪4 E	◪3 A												

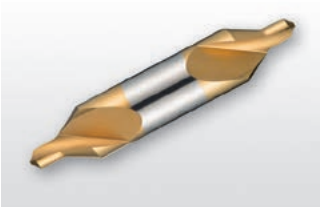
该系列产品有套装提供。请参见A296。

Product	DC (mm)	DC (inch)	SDL_1 (mm)	OAL (mm)	DCON MS (mm)
A200.5X3.15 [1]	0.50	0.0197	0.9 - 0.6	25.0	3.15
A200.8X3.15 [1]	0.80	0.0315	1.3 - 1.0	25.0	3.15
A2001.0X3.15	1.00	0.0394	1.7 - 1.3	31.0	3.15
A2001.25X3.15	1.25	0.0492	2.0 - 1.6	31.0	3.15
A2001.6X4.0	1.60	0.0630	2.6 - 2.0	35.0	4.00
A2002.0X5.0	2.00	0.0787	3.1 - 2.5	40.0	5.00
A2002.5X6.3	2.50	0.0984	3.8 - 3.1	45.0	6.30
A2003.15X8.0	3.15	0.1240	4.6 - 3.9	50.0	8.00
A2004.0X10.0	4.00	0.1575	5.9 - 5.0	55.0	10.00
A2005.0X12.5	5.00	0.1969	7.2 - 6.3	63.0	12.50
A2006.3X16.0	6.30	0.2480	8.9 - 8.0	71.0	16.00
A2008.0X20.0	8.00	0.3150	11.1 - 10.1	80.0	20.00
A20010.0X25.0	10.00	0.3937	13.8 - 12.8	100.0	25.00
A20012.5X31.5	12.50	0.4921	17.5 - 16.5	125.0	31.50

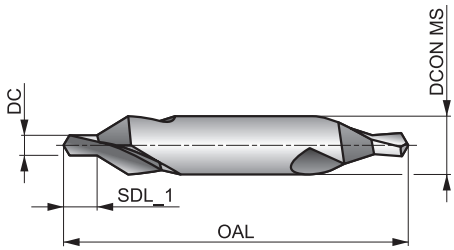
[1] 只有单头的

A205

DORMER



118°高速钢中心钻带60°倒角，氮化钛涂层。
推荐用于在工件轴的端部钻一个高精度孔，以便工件轴在正式加工前安全地固定。两端均可使用的双头钻提高了刀具的加工效率，氮化钛涂层提高了切削性能并延长了刀具寿命，适用于多种材料的切削。



HSS	DIN 333A	1×D
60°	TiN	
R	118°	

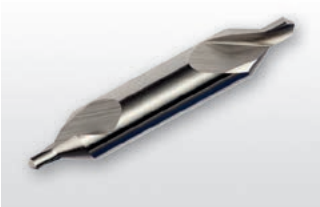
工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■40 I	■45 I	■46 I	■34 I	■30 G	◪27 E	■24 F	■19 F	◪16 E	■14 F	◪12 E	◪10 D	◪25 E	◪21 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪22 E	◪18 E	◪12 G	◪10 G	◪9 G	◪12 C	■36 I	■27 F	■20 F	◪30 E	◪24 E	◪19 E	◪26 E	◪20 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪16 E	◪24 E	◪18 E	◪13 E	◪11 E	◪10 E	◪27 E	◪21 E	◪16 E	◪40 J	◪30 J	◪20 I	◪49 H	◪44 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪32 H	◪68 H	◪40 I	◪20 G	◪36 J	◪34 H	◪17 F	◪29 F	◪16 D	◪8 B	◪8 E	◪7 A	◪6 E	◪5 A
S4.1	S4.2												
◪5 E	◪4 A												

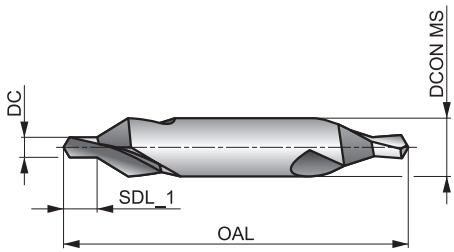
Product	DC	DC	SDL_1	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
A2051.0X3.15	1.00	0.0394	1.7 - 1.3	31.0	3.15
A2051.25X3.15	1.25	0.0492	2.0 - 1.6	31.0	3.15
A2051.6X4.0	1.60	0.0630	2.6 - 2.0	35.0	4.00
A2052.0X5.0	2.00	0.0787	3.1 - 2.5	40.0	5.00
A2052.5X6.3	2.50	0.0984	3.8 - 3.1	45.0	6.30
A2053.15X8.0	3.15	0.1240	4.6 - 3.9	50.0	8.00
A2054.0X10.0	4.00	0.1575	5.9 - 5.0	55.0	10.00
A2055.0X12.5	5.00	0.1969	7.2 - 6.3	63.0	12.50

A206

DORMER



118°高速钢中心钻带60°倒角，表面光亮处理。
推荐用于在工件轴的端部钻一个高精度孔，以便工件轴在正式加工前安全地固定。两端均可使用的双头钻提高了刀具的加工效率，适用于多种材料的切削。



HSS-E	DIN 333A	1×D
60°	Bright	
R	118°	

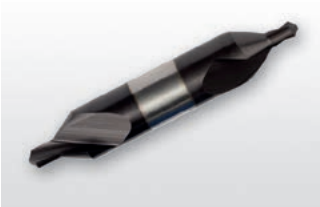
工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■40 I	■45 I	■46 I	■34 I	■30 G	◪27 E	■24 F	■19 F	◪16 E	■14 F	◪12 E	◪10 D	◪25 E	◪21 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪22 E	◪18 E	◪12 G	◪10 G	◪9 G	◪12 C	■36 I	■27 F	■20 F	◪30 E	◪24 E	◪19 E	◪26 E	◪20 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪16 E	◪24 E	◪18 E	◪13 E	◪11 E	◪10 E	◪27 E	◪21 E	◪16 E	◪40 J	◪30 J	◪20 I	◪49 H	◪44 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪32 H	◪68 H	◪40 I	◪20 G	◪36 J	◪34 H	◪17 F	◪29 F	◪16 D	◪8 B	◪8 E	◪7 A	◪6 E	◪5 A
S4.1	S4.2												
◪5 E	◪4 A												

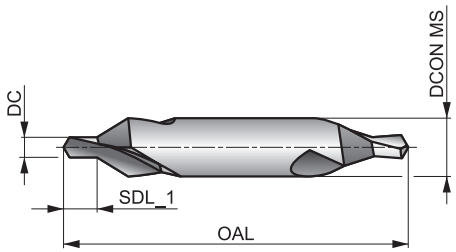
Product	DC (mm)	DC (inch)	SDL_1 (mm)	OAL (mm)	DCON MS (mm)
A2061.0X3.15	1.00	0.0394	1.7 - 1.3	31.0	3.15
A2061.25X3.15	1.25	0.0492	2.0 - 1.6	31.0	3.15
A2061.6X4.0	1.60	0.0630	2.6 - 2.0	35.0	4.00
A2062.0X5.0	2.00	0.0787	3.1 - 2.5	40.0	5.00
A2062.5X6.3	2.50	0.0984	3.8 - 3.1	45.0	6.30
A2063.15X8.0	3.15	0.1240	4.6 - 3.9	50.0	8.00
A2064.0X10.0	4.00	0.1575	5.9 - 5.0	55.0	10.00
A2065.0X12.5	5.00	0.1969	7.2 - 6.3	63.0	12.50

A266

DORMER



118°高速钢中心钻带60°倒角，氮铝化钛涂层。
推荐用于在工件轴的端部钻一个高精度孔，以便工件轴在正式加工前安全地固定。两端均可使用的双头钻提高了刀具的加工效率，氮化钛涂层提高了切削性能并延长了刀具寿命，适用于多种材料的切削。



HSS-E	DIN 333A	1×D
60°	TiAlN	
R	118°	

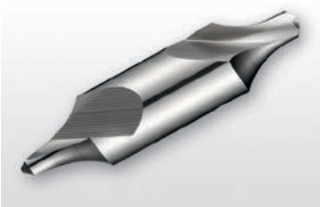
工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■40 I	■45 I	■46 I	■34 I	■30 G	◪27 E	■24 F	■19 F	◪16 E	■14 F	◪12 E	◪10 D	◪25 E	◪21 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪22 E	◪18 E	◪12 G	◪10 G	◪9 G	◪12 C	■36 I	■27 F	■20 F	◪30 E	◪24 E	◪19 E	◪26 E	◪20 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪16 E	◪24 E	◪18 E	◪13 E	◪11 E	◪10 E	◪27 E	◪21 E	◪16 E	◪40 J	◪30 J	◪20 I	◪49 H	◪44 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪32 H	◪68 H	◪40 I	◪20 G	◪36 J	◪34 H	◪17 F	◪29 F	◪16 D	◪8 B	◪8 E	◪7 A	◪6 E	◪5 A
S4.1	S4.2												
◪5 E	◪4 A												

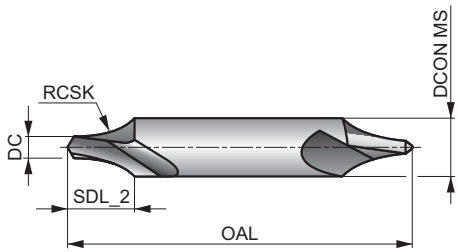
Product	DC (mm)	DC (inch)	SDL_1 (mm)	OAL (mm)	DCON MS (mm)
A2661.0X3.15	1.00	0.0394	1.7 - 1.3	31.0	3.15
A2661.25X3.15	1.25	0.0492	2.0 - 1.6	31.0	3.15
A2661.6X4.0	1.60	0.0630	2.6 - 2.0	35.0	4.00
A2662.0X5.0	2.00	0.0787	3.1 - 2.5	40.0	5.00
A2662.5X6.3	2.50	0.0984	3.8 - 3.1	45.0	6.30
A2663.15X8.0	3.15	0.1240	4.6 - 3.9	50.0	8.00
A2664.0X10.0	4.00	0.1575	5.9 - 5.0	55.0	10.00
A2665.0X12.5	5.00	0.1969	7.2 - 6.3	63.0	12.50

A210

DORMER



118°高速钢中心钻带圆弧倒角，表面光亮处理。
推荐用于在工件轴的端部钻一个高精度孔，以便工件轴在正式加工前安全地固定。两端均可使用的双头钻提高了刀具的加工效率，适用于多种材料的切削。



HSS	DIN 333R	1×D
R	Bright	
R	118°	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■33 I	■37 I	■38 I	■28 I	■25 G	◪22 E	■19 F	■15 F	◪13 E	■11 F	◪10 E	◪8 D	◪21 E	◪17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪18 E	◪15 E	◪9 G	◪8 G	◪7 G	◪10 C	■30 I	■22 F	■17 F	◪25 E	◪20 E	◪16 E	◪22 E	◪17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 E	◪20 E	◪15 E	◪11 E	◪10 E	◪8 E	◪23 E	◪17 E	◪13 E	◪33 J	◪25 J	◪17 I	◪42 H	◪37 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪27 H	◪56 H	◪33 I	◪17 G	◪30 J	◪28 H	◪14 F	◪24 F	◪13 D	◪7 B	◪7 E	◪6 A	◪5 E	◪4 A
S4.1	S4.2												
◪4 E	◪3 A												

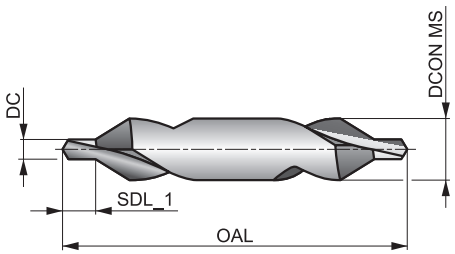
Product	DC (mm)	DC (inch)	SDL_2 (mm)	OAL (mm)	RCSK (mm)	DCON MS (mm)
A210.5X3.15 [1]	0.50	0.0197	2.6 - 2.3	25.0	2.50 - 2.00	3.15
A210.8X3.15 [1]	0.80	0.0315	2.9 - 2.6	25.0	3.15 - 2.50	3.15
A2101.0X3.15	1.00	0.0394	3.3 - 3.0	31.0	3.65 - 2.90	3.15
A2101.25X3.15	1.25	0.0492	3.6 - 3.3	31.0	3.95 - 3.15	3.15
A2101.6X4.0	1.60	0.0630	4.7 - 4.2	35.0	5.00 - 4.00	4.00
A2102.0X5.0	2.00	0.0787	5.4 - 5.0	40.0	6.25 - 5.00	5.00
A2102.5X6.3	2.50	0.0984	6.8 - 6.3	45.0	7.88 - 6.30	6.30
A2103.15X8.0	3.15	0.1240	8.5 - 8.0	50.0	10.00 - 8.00	8.00
A2104.0X10.0	4.00	0.1575	10.6 - 10.0	55.0	12.50 - 10.00	10.00
A2105.0X12.5	5.00	0.1969	13.1 - 12.5	63.0	15.63 - 12.50	12.50
A2106.3X16.0	6.30	0.2480	16.6 - 16.0	71.0	20.00 - 16.00	16.00
A2108.0X20.0	8.00	0.3150	20.7 - 20.0	80.0	25.00 - 20.00	20.00

[1] 只有单头的

A201

DORMER

122°高速钢中心钻带60°倒角，表面光亮处理。
推荐用于在工件轴的端部钻一个高精度孔，以便工件轴在正式加工前安全地固定。两端均可使用的双头钻提高了刀具的加工效率，适用于多种材料的切削。



HSS	DORMER	1×D
60°	Bright	
R	122°	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

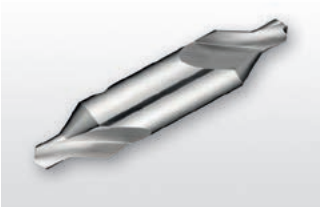
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■33 I	■37 I	■38 I	■28 I	■25 G	◪22 E	■19 F	■15 F	◪13 E	■11 F	◪10 E	◪8 D	◪21 E	◪17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪18 E	◪15 E	◪9 G	◪8 G	◪7 G	◪10 C	■30 I	■22 F	■17 F	◪25 E	◪20 E	◪16 E	◪22 E	◪17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 E	◪20 E	◪15 E	◪11 E	◪10 E	◪8 E	◪23 E	◪17 E	◪13 E	◪33 J	◪25 J	◪17 I	◪42 H	◪37 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪27 H	◪56 H	◪33 I	◪17 G	◪30 J	◪28 H	◪14 F	◪24 F	◪13 D	◪7 B	◪7 E	◪6 A	◪5 E	◪4 A
S4.1	S4.2												
◪4 E	◪3 A												

Product	DC (mm)	DC (inch)	SDL_1 (mm)	OAL (mm)	DCON MS (mm)
A201.63X3.15 [1]	0.63	0.0248	1.2 - 0.9	20.0	3.15
A201.75X3.5	0.75	0.0295	1.3 - 1.0	35.0	3.50
A2011.0X4.0	1.00	0.0394	2.1 - 1.5	35.0	4.00
A2011.5X5.0	1.50	0.0591	2.8 - 2.0	40.0	5.00
A2011.6X5.0	1.60	0.0630	2.4 - 2.0	40.0	5.00
A2012.0X6.0	2.00	0.0787	4.0 - 3.0	45.0	6.00
A2012.0X6.3	2.00	0.0787	2.9 - 2.5	45.0	6.30
A2012.5X8.0	2.50	0.0984	4.5 - 3.5	50.0	8.00
A2013.0X8.0	3.00	0.1181	4.4 - 3.9	50.0	8.00
A2013.0X10.0	3.00	0.1181	5.0 - 4.0	56.0	10.00
A2013.15X10.0	3.15	0.1240	4.4 - 3.9	56.0	10.00
A2014.0X12.0	4.00	0.1575	6.2 - 5.0	66.0	12.00
A2015.0X14.0	5.00	0.1969	7.7 - 6.5	78.0	14.00
A2016.0X18.0	6.00	0.2362	9.2 - 8.0	90.0	18.00

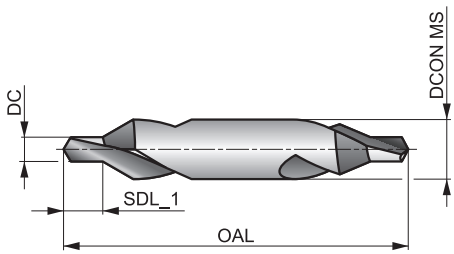
[1] 只有单头的

A225

DORMER



120°高速钢中心钻带60°倒角，表面光亮处理。
英国328标准。推荐用于在工件轴的端部钻一个高精度孔，以便工件轴在正式加工前安全地固定。两端均可使用的双头钻提高了刀具的加工效率，适用于多种材料的切削。



HSS	BS 328	1×D
60°	Bright	
R	120°	

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■33 I	■37 I	■38 I	■28 I	■25 G	◪22 E	■19 F	■15 F	◪13 E	■11 F	◪10 E	◪8 D	◪21 E	◪17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪18 E	◪15 E	◪9 G	◪8 G	◪7 G	◪10 C	■30 I	■22 F	■17 F	◪25 E	◪20 E	◪16 E	◪22 E	◪17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 E	◪20 E	◪15 E	◪11 E	◪10 E	◪8 E	◪23 E	◪17 E	◪13 E	◪33 J	◪25 J	◪17 I	◪42 H	◪37 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪27 H	◪56 H	◪33 I	◪17 G	◪30 J	◪28 H	◪14 F	◪24 F	◪13 D	◪7 B	◪7 E	◪6 A	◪5 E	◪4 A
S4.1	S4.2												
◪4 E	◪3 A												

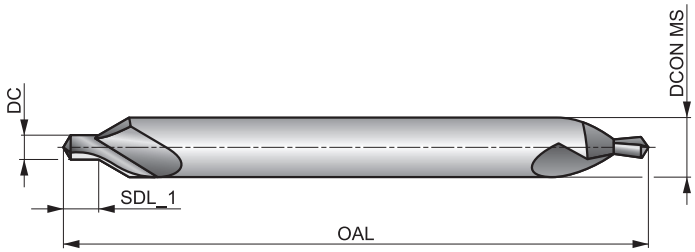
该系列产品有套装提供。请参见A296。

Product	Nr.	DC (inch)	DC (inch)	SDL_1 (inch)	OAL (inch)	DCON MS (inch)
A225BS1	BS1	3/64	0.0469	5/64 - 1/16	1.1/2	1/8
A225BS2	BS2	1/16	0.0625	3/32 - 5/64	1.3/4	3/16
A225BS3	BS3	3/32	0.0938	5/32 - 1/8	2"	1/4
A225BS4	BS4	1/8	0.1250	3/16 - 5/32	2.1/4	5/16
A225BS5	BS5	3/16	0.1875	9/32 - 1/4	2.1/2	7/16
A225BS5A	BS5A	7/32	0.2188	5/16 - 9/32	2.3/4	1/2
A225BS6	BS6	1/4	0.2500	3/8 - 5/16	3"	5/8
A225BS7	BS7	5/16	0.3125	15/32 - 13/32	3.1/2	3/4

A242

DORMER

长型118°含钻高速钢中心钻带60°倒角，表面光亮处理。
用于在工件轴的端部钻一个高精度孔，以便工件轴在正式加工前安全地固定。两端均可使用的双头钻提高了刀具的加工效率，适用于多种材料的切削。



HSS-E	DORMER	1×D
60°	Bright	
R	118°	

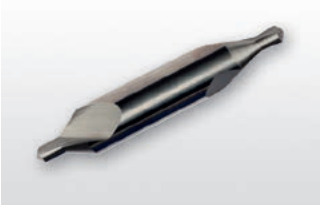
工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■33 I	■37 I	■38 I	■28 I	■25 G	◪22 E	■19 F	■15 F	◪13 E	■11 F	◪10 E	◪8 D	◪21 E	◪17 E
M2.1	M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2
◪18 E	◪15 E	◪9 G	◪8 G	◪7 G	◪10 C	■30 I	■22 F	■17 F	◪25 E	◪20 E	◪16 E	◪22 E	◪17 E
K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2
◪13 E	◪20 E	◪15 E	◪11 E	◪10 E	◪8 E	◪23 E	◪17 E	◪13 E	◪33 J	◪25 J	◪17 I	◪42 H	◪37 H
N2.3	N3.1	N3.2	N3.3	N4.1	N4.2	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
◪27 H	◪56 H	◪33 I	◪17 G	◪30 J	◪28 H	◪14 F	◪24 F	◪13 D	◪7 B	◪7 E	◪6 A	◪5 E	◪4 A
S4.1	S4.2												
◪4 E	◪3 A												

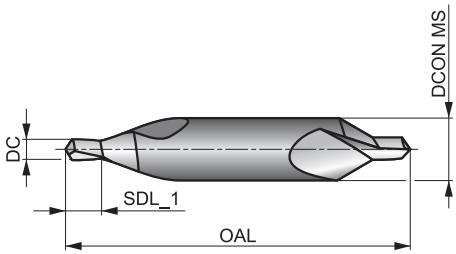
Product	DC	DC	SDL_1	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
A2421.0X4.0	1.00	0.0394	1.7 - 1.3	100.0	4.00
A2421.5X5.0	1.50	0.0591	2.6 - 2.0	100.0	5.00
A2422.0X6.0	2.00	0.0787	3.1 - 2.5	100.0	6.00
A2422.5X8.0	2.50	0.0984	3.8 - 3.1	100.0	8.00
A2423.0X8.0	3.00	0.1181	4.6 - 3.9	100.0	8.00
A2423.0X10.0	3.00	0.1181	4.6 - 3.9	100.0	10.00
A2424.0X10.0	4.00	0.1575	5.9 - 5.0	100.0	10.00
A2424.0X12.0	4.00	0.1575	5.9 - 5.0	100.0	12.00
A2425.0X12.0	5.00	0.1969	7.2 - 6.3	100.0	12.00

R200

DORMER



118°合金中心钻带60°倒角，表面光亮处理。
118°的钻尖和60°的沉孔，推荐用于在工件轴的端部钻一个高精度孔，以便工件轴在正式加工前安全地固定。两端均可使用的双头钻提高了刀具的加工效率，可用于所有数控机床，适用于多种材料的切削。



HM	DIN 333A	1×D
60°	Bright	
R		

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	K1.1	K1.2
60 H	67 H	69 H	51 H	45 F	40 D	44 E	36 E	30 D	26 E	22 D	18 C	40 H	30 E
K1.3	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**
22 E	37 D	30 D	24 D	33 D	25 D	20 D	30 D	23 D	17 D	14 D	12 D	34 D	26 D
K5.3	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**				
20 D	120 I	90 I	60 H	154 G	138 G	100 G	169 G	100 H	50 F				

Product	DC (mm)	DC (inch)	SDL_1 (mm)	OAL (mm)	DCON MS (mm)
R2001.0X3.15	1.00	0.0394	1.7 - 1.3	31.0	3.15
R2001.25X3.15	1.25	0.0492	2.0 - 1.6	31.0	3.15
R2001.6X4.0	1.60	0.0630	2.6 - 2.0	35.0	4.00
R2002.0X5.0	2.00	0.0787	3.1 - 2.5	40.0	5.00
R2002.5X6.3	2.50	0.0984	3.8 - 3.1	45.0	6.30
R2003.15X8.0	3.15	0.1240	4.6 - 3.9	50.0	8.00
R2004.0X10.0	4.00	0.1575	5.9 - 5.0	55.0	10.00
R2005.0X12.5	5.00	0.1969	7.2 - 6.3	63.0	12.50

A296

DORMER

高速钢中心钻套装
一个便携的中心钻塑料盒套装，共收纳了5支中心钻。建议加工之前在工件轴的末端钻一个精密孔以固定中心钻。双头的结构提高了每支中心钻的加工效率。

A296200 - 118° 钻尖 DIN333A, A296225 - 120° 钻尖 BS328.A=套件中的型号, B=套件中的数量, C=套件中的直径

Product	Nr.	A	B	C
A296200	200	A200	5	1.00 mm, 2.00 mm, 2.50 mm, 3.15 mm, 4.00 mm
A296225	225	A225	5	BS1, BS2, BS3, BS4, BS5

材料代码(BMC)	HSS	HSS-E	HSS	HSS-E	HM	HSS	HSS	HSS	HSS
涂层	TiN	Bright	TiAlN	AlTiCN	Bright	TiAlN	Bright	Bright	TiN
基本标准组(BSG)	DIN 334C	DORMER	DIN 335C	DIN 335C	DIN 335C	DIN 335C	DIN 334D	DIN 335D	DIN 335D
旋向(切削方向)	R	R	R	R	R	R	R	R	R
柄部									
应用角度	60°	90°	90°	90°	90°	100°	60°	90°	90°

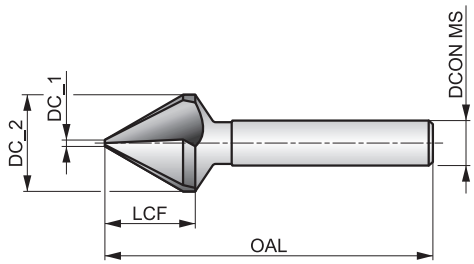
产品系列代码	G335	G149	G560	G570	G400	G171	G137	G138	G338
PSF切削直径范围	6.30 - 25.00	5.00 - 25.00	6.30 - 31.00	6.30 - 31.00	6.30 - 31.00	6.30 - 25.00	31.50 - 50.00	25.00 - 63.00	25.00 - 50.00
	158	159	160	161	162	163	164	165	166
P	P1	■	■	■	◪	■	■	■	■	■
	P2	■	■	■	◪	■	■	■	■	■
	P3	■	■	■	■	■	■	◪	◪	■
	P4	■		■	■	■	■	◪	◪	■
M	M1	◪	◪	◪	■	■	◪	◪	◪	◪
	M2	◪	◪	◪	■	◪	◪	◪	◪	◪
	M3	◪			■	◪				
	M4				◪	◪				
K	K1	■	◪	■	■	■	■	◪	◪	■
	K2	■	◪	■	■	■	■	◪	◪	■
	K3	■	◪	■	■	■	■	◪	◪	■
	K4	◪		◪	◪	■	◪			◪
	K5	■	◪	■	■	■	■	◪	◪	■
N	N1	■	■	◪	◪	■	◪	◪	◪	■
	N2	■	◪	■	◪	■	■	◪	◪	■
	N3	■	■	■	◪	■	■	■	■	■
	N4	◪	◪	◪		■	◪	◪	◪	◪
	N5									
S	S1					■				
	S2					◪				
	S3					◪				
	S4					◪				
H	H1					■				
	H2					■				
	H3					◪				
	H4					◪				

■推荐使用 ◪可以使用

G335

DORMER

60°高速钢直柄锪钻，氮化钛涂层。
一种60°的锪钻，用于特殊紧固件的倒角并去除孔内毛刺。氮化钛涂层提高了切削性能并延长了刀具寿命，可用于手持式工具或机床，适用于多种材料的切削。



HSS | TiN | DIN 334C | R | 60°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■33 E	■37 E	■38 E	■28 E	■25 D	■22 B	■23 D	■18 D	■15 B	■13 D	■11 B	◪9 B	◪10 C	◪8 C
M2.1	**M3.1**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**
◪9 C	◪8 B	■34 F	■25 D	◪19 D	■35 C	■28 C	◪23 C	■31 C	■24 C	◪19 C	◪29 C	◪22 C	◪16 C
K5.1	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**
■32 C	■24 C	◪19 C	■53 G	■40 G	■27 F	■27 F	■24 F	■17 F	■28 F	■16 F	◪8 D	◪58 G	◪50 G

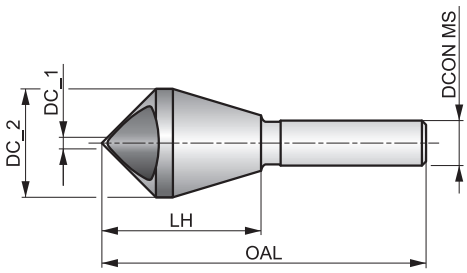
DCON MS公差h9

Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	DCON MS (mm)	NOF
G3356.3	6.30	1.60	6.8	45.0	5.00	3
G3358.0	8.00	2.00	8.5	50.0	6.00	3
G33510.0	10.00	2.50	7.6	50.0	6.00	3
G33512.5	12.50	3.20	11.7	56.0	8.00	3
G33516.0	16.00	4.00	14.5	63.0	10.00	3
G33520.0	20.00	5.00	17.5	67.0	10.00	3
G33525.0	25.00	6.30	20.5	71.0	10.00	3

G149

DORMER

90°高速钢直柄贯穿孔锪钻，表面光亮处理。
孔口倒角和去除毛刺的90°锪钻，特殊的贯穿孔设计能够引导铁屑离开切削刃口，从而使倒角加工更平稳，适用于多种材料的切削。



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	M1.1	M1.2	M2.1	K1.1	K2.1	K3.1
◪21 D	■24 D	■25 D	■18 D	■16 C	◪14 A	■16 B	◪13 B	◪8 B	◪6 B	◪7 B	◪18 D	◪19 A	◪16 A

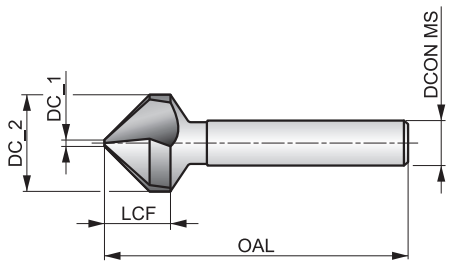
K5.1	N1.1	N1.2	N1.3	N2.1	N2.2	N3.1	N3.2	N3.3	N4.1	N4.2
◪14 A	■34 D	■25 D	■16 C	◪16 C	◪14 C	■17 C	■9 C	■5 B	◪17 D	◪5 D

Product	DC_2	DC_1	LH	OAL	DCON MS	DC	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	
G1495	5.00	2.00	19.0	45.0	6.00	10.00	1
G14910	10.00	5.00	23.0	48.0	8.00	14.00	1
G14915	15.00	10.00	34.0	65.0	10.00	21.00	1
G14920	20.00	15.00	43.0	84.0	12.00	28.00	1
G14925	25.00	20.00	48.0	102.0	15.00	35.00	1

G560

DORMER

90°高速钢直柄锪钻，氮铝化钛涂层。
标准紧固件孔口倒角和去除毛刺的90°锪钻，缩柄的设计使得大直径的锪钻也能够安装在标准卡盘或刀柄中，可用于手持式工具或机床，AlTiN涂层能够提高性能并延长刀具寿命。



HSS | TiAIN | DIN 335C | R | 90°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■40 E	■45 E	■46 E	■34 E	■30 D	■27 B	■28 D	■22 D	■19 B	■16 D	■14 B	◪11 B	◪11 C	◪9 C
M2.1	**M2.2**	**M2.3**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K4.1**	**K4.2**
◪10 C	◪9 C	◪8 B	■41 F	■30 D	◪23 D	■42 C	■34 C	◪27 C	■37 C	■28 C	◪23 C	◪34 C	◪26 C
K4.3	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**
◪19 C	■39 C	■29 C	◪23 C	◪60 G	◪45 G	■30 F	■30 F	■27 F	■19 F	■32 F	■18 F	◪9 D	◪62 G
N4.2													
◪55 G													

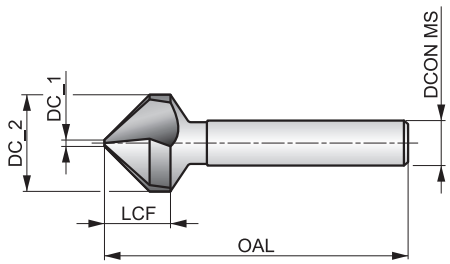
DCON MS公差h9
该系列产品有套装提供。请参见G236。

Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	DCON MS (mm)	NOF
G5606.3	6.30	1.50	5.5	45.0	5.00	3
G5608.0	8.00	2.00	6.1	50.0	6.00	3
G5608.3	8.30	2.00	6.5	50.0	6.00	3
G56010.0	10.00	2.50	7.6	50.0	6.00	3
G56010.4	10.40	2.50	7.6	50.0	6.00	3
G56012.4	12.40	2.80	8.5	56.0	8.00	3
G56016.5	16.50	3.20	10.5	60.0	10.00	3
G56020.5	20.50	3.50	13.0	63.0	10.00	3
G56025.0	25.00	3.80	15.5	67.0	10.00	3
G56031.0	31.00	4.20	18.5	71.0	12.00	3

G570

DORMER

90°高速钢直柄锪钻，碳氮化铝钛涂层。
标准紧固件孔口倒角和去除毛刺的90°锪钻，可用于手持式工具或机床，特别适用于硬材料和研磨材料的倒角，AlTiCN涂层能够提高性能并延长刀具寿命。



HSS-E | AlTiCN | DIN 335C | R | 90°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
◪40 E	◪45 E	◪46 E	◪34 E	◪30 D	■27 B	■28 D	■22 D	■19 B	■16 D	■14 B	◪11 B	■23 C	■20 C
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
■21 C	■17 C	◪14 A	■14 B	■12 B	◪11 B	■15 A	◪13 A	■41 C	■30 C	◪23 C	■42 C	■34 C	◪27 C
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
■37 C	■28 C	◪23 C	◪34 C	◪26 C	◪19 C	■39 C	■29 C	◪23 C	◪60 G	◪45 G	◪30 F	◪30 F	◪27 F
N2.3	**N3.1**	**N3.2**	**N3.3**										
◪19 F	◪32 F	◪18 F	◪9 D										

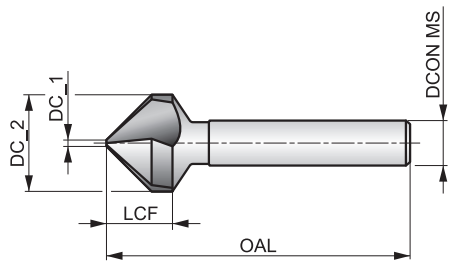
DCON MS公差h9

Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	DCON MS (mm)	NOF
G5706.3	6.30	1.50	6.5	45.0	5.00	3
G5708.3	8.30	2.00	8.2	50.0	6.00	3
G57010.4	10.40	2.50	9.7	50.0	6.00	3
G57012.4	12.40	2.80	10.6	56.0	8.00	3
G57016.5	16.50	3.20	13.9	60.0	10.00	3
G57020.5	20.50	3.50	17.1	63.0	10.00	3
G57025.0	25.00	3.80	21.4	67.0	10.00	3
G57031.0	31.00	4.20	24.4	71.0	12.00	3

G400

DORMER

合金90°直柄锪钻，表面光亮处理。
高性能90°锪钻，表面光亮处理，适用于高效率和高质量的数控机床，可用于硬材料和和研磨材料的倒角，用于标准紧固件的90°孔口倒角。



HM | Bright | DIN 335C
R | | 90°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■64 E	■72 E	■74 E	■55 E	■48 D	■43 B	■45 D	■36 D	■30 B	■26 D	■23 B	■18 A	■24 C	■21 C
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
■22 C	◪18 C	◪15 B	■20 B	◪17 B	◪15 B	◪15 A	◪13 A	■45 F	■33 D	■25 D	■46 C	■37 C	◪30 C
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
■41 C	■31 C	◪25 C	■38 C	■28 C	■21 C	◪18 C	◪15 C	■43 C	■32 C	■25 C	◪75 G	■55 G	■40 F
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	N4.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
■40 F	■36 F	■26 F	■42 F	■25 F	◪13 D	■17 E	■12 C	■10 A	◪9 A	■8 B	◪7 A	■6 B	◪5 A
S4.1	S4.2	H1.1	H2.1	H2.2	H3.1	H3.2	H4.1	H4.2					
■5 B	◪4 A	■12 A	■7 A	◪6 B	■8 A	◪7 B	■5 A	◪4 B					

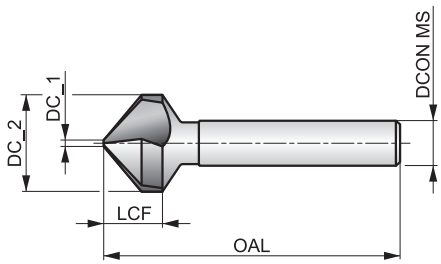
DCON MS公差h6

Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	DCON MS (mm)	NOF
G4006.3	6.30	1.50	5.0	45.0	5.00	3
G4008.3	8.30	2.00	6.0	50.0	6.00	3
G40010.4	10.40	2.50	7.1	50.0	6.00	3
G40012.4	12.40	2.80	8.0	56.0	8.00	3
G40016.5	16.50	3.20	10.0	60.0	10.00	3
G40020.5	20.50	3.50	12.5	63.0	10.00	3
G40025.0	25.00	3.80	15.0	67.0	10.00	3
G40031.0	31.00	4.20	18.0	71.0	12.00	3

G171

DORMER

100°高速钢直柄锪钻，氮铝化钛涂层。
标准紧固件孔口倒角和去除毛刺的多功能100°锪钻，TiAlN涂层可提高性能并延长刀具寿命，可用于手持式工具或机床，适用于多种材料的切削。



HSS	TiAlN	DIN 335C
R		100°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■40 E	■45 E	■46 E	■34 E	■30 D	■27 B	■28 D	■22 D	■19 B	■16 D	■14 B	◪11 B	◪11 C	◪9 C
M2.1	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K5.1**
◪10 C	■41 F	■30 D	◪23 D	■42 C	■34 C	◪27 C	■37 C	■28 C	◪23 C	◪34 C	◪26 C	◪19 C	■39 C
K5.2	**K5.3**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**	
■29 C	◪23 C	◪60 G	◪45 G	■30 F	■30 F	■27 F	■19 F	■32 F	■18 F	◪9 D	◪62 G	◪55 G	

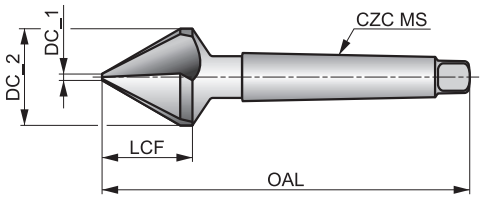
DCON MS公差h9

Product	DC_2	DC_1	LCF	OAL	DCON MS	NOF
	(mm)	(mm)	(mm)	(mm)	(mm)	
G1716.3	6.30	1.50	4.5	44.0	5.00	3
G1718.3	8.30	2.00	5.5	49.0	6.00	3
G17110.4	10.40	2.50	6.6	49.0	6.00	3
G17112.4	12.40	2.80	7.0	53.0	8.00	3
G17116.5	16.50	3.20	9.0	56.0	10.00	3
G17120.5	20.50	3.50	11.0	61.0	10.00	3
G17125.0	25.00	3.80	13.5	65.0	10.00	3

G137

DORMER

60°锥柄锪钻，表面光亮处理。
一种表面光亮处理的60°锪钻，，用于特殊紧固件的倒角并去除孔内毛刺。锥柄的设计允许刀具直接安装于机床主轴从而进行加工，适用于多种材料的切削。



HSS | Bright | DIN 334D

R | 60°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

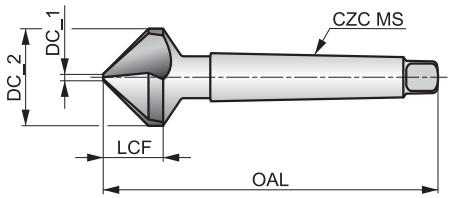
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■ 23 E	■ 26 E	■ 27 E	■ 20 E	■ 18 D	◪ 16 B	■ 16 D	◪ 13 D	◪ 11 B	■ 10 D	◪ 8 B	◪ 8 C	◪ 6 C	◪ 7 C
M2.2	**K1.1**	**K1.2**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K5.1**	**K5.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪ 6 C	◪ 20 F	◪ 15 D	◪ 21 C	◪ 17 C	◪ 18 C	◪ 14 C	◪ 19 C	◪ 15 C	◪ 40 G	■ 30 G	◪ 20 F	■ 20 F	◪ 18 F
N3.1	**N3.2**	**N3.3**	**N4.1**	**N4.2**									
■ 21 F	■ 12 F	◪ 6 D	◪ 40 G	◪ 35 G									

Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	CZC MS	NOF
G13731.5	31.50	10.00	23.0	118.0	MK 2	3
G13740.0	40.00	12.50	28.5	150.0	MK 3	3
G13750.0	50.00	16.00	36.0	160.0	MK 3	3

G138

DORMER

90°锥柄锪钻，表面光亮处理。
标准紧固件孔口倒角和去除毛刺的90°锪钻，锥柄的设计允许刀具直接安装在机床主轴中，适用于多种材料的切削。



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

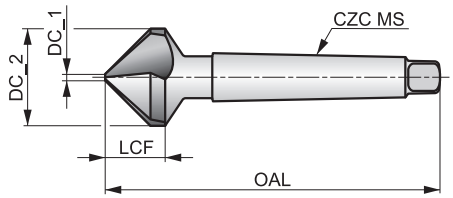
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
■ 23 E	■ 26 E	■ 27 E	■ 20 E	■ 18 D	◪ 16 B	■ 16 D	◪ 13 D	◪ 11 B	■ 10 D	◪ 8 B	◪ 8	◪ 6	◪ 7
M2.2	**K1.1**	**K1.2**	**K2.1**	**K2.2**	**K3.1**	**K3.2**	**K5.1**	**K5.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪ 6	◪ 20 F	◪ 15 D	◪ 21 C	◪ 17 C	◪ 18 C	◪ 14 C	◪ 19 C	◪ 15 C	◪ 40 G	■ 30 G	◪ 20 F	■ 20 F	◪ 18 F
N3.1	**N3.2**	**N3.3**	**N4.1**	**N4.2**									
■ 21 F	■ 12 F	◪ 6 D	◪ 40 G	◪ 35 G									

Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	CZC MS	NOF
G13825.0	25.00	3.80	15.5	106.0	MK 2	3
G13830.0	30.00	4.20	18.5	112.0	MK 2	3
G13831.0	31.00	4.20	20.0	112.0	MK 2	3
G13834.0	34.00	4.50	19.5	118.0	MK 2	3
G13837.0	37.00	4.80	21.7	118.0	MK 2	3
G13840.0	40.00	10.00	20.5	140.0	MK 3	3
G13850.0	50.00	14.00	24.1	150.0	MK 3	3
G13863.0	63.00	16.00	28.5	180.0	MK 4	3

G338

DORMER

90°锥柄锪钻，氮化钛涂层。
标准紧固件孔口倒角和去除毛刺的90°锪钻，提高了长时间高速加工的性能，锥柄的设计允许刀具直接安装在机床主轴中，TiN涂层能够提高性能并延长刀具寿命，适用于多种材料的切削。



HSS | TiN | DIN 335D | R | 90°

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页280开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■33 E	■37 E	■38 E	■28 E	■25 D	■22 B	■23 D	■18 D	■15 B	■13 D	■11 B	◪9 B	◪11 C	◪9 C
M2.1	**M2.2**	**M2.3**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K4.1**	**K4.2**
◪10 C	◪9 C	◪8 B	■34 F	■25 D	◪19 D	■35 C	■28 C	◪23 C	■31 C	■24 C	◪19 C	◪29 C	◪22 C
K4.3	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**
◪16 C	■32 C	■24 C	◪19 C	■53 G	■40 G	■27 F	■27 F	■24 F	■17 F	■28 F	■16 F	◪8 D	◪58 G
N4.2													
◪50 G													

Product	DC_2 (mm)	DC_1 (mm)	LCF (mm)	OAL (mm)	CZC MS	NOF
G33825.0	25.00	3.80	15.5	106.0	MK 2	3
G33831.0	31.00	4.20	20.0	112.0	MK 2	3
G33837.0	37.00	4.80	21.7	118.0	MK 2	3
G33840.0	40.00	10.00	20.5	140.0	MK 3	3
G33850.0	50.00	14.00	24.1	150.0	MK 3	3

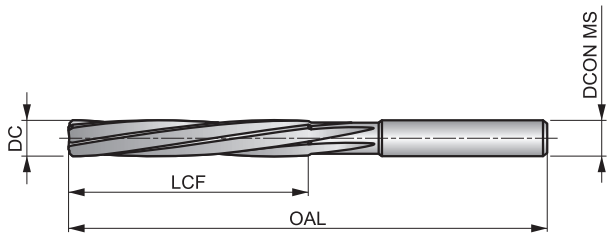
材料代码(BMC)	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS-E	HSS	HSS
涂层	Bright ST	Bright	Bright	Bright	Bright ST	Bright	Bright ST	ST
基本标准组(BSG)	BS 328	DIN 212	DIN 212	DIN 208	BS 328	DIN 2180	DIN 311	ANSI
旋向(切削方向)	R	R	R	R	R	R	R	R
柄部		DIN 6535HA						
铰刀形式	B	B	B	B	B			
可达到的孔公差 (TCHA)	H7	H7	ø.95-5.5 +0.004 ø5.51-12 +0.005	H7	H7		k11	
锥度-毫米(锥度比率) - 公制						1:50		
产品系列代码	B901	B180	B170	B161	B101	B954	B121	B640
PSF切削直径范围	1.50 - 1/2	1.50 - 20.00	1.00 - 12.00	3.00 - 50.00	3.00 - 50.00	8.00 - 30.00	12.00 - 25.00	7/16 - 1.1/16
	168	169	171	173	174	175	176	177
P	P1	■	■	■	■	■	■	■	■
	P2	■	■	■	■	■	■	■	■
	P3	■	■	■	■	■	◪	■	■
	P4	◪	◪	◪	◪	◪	◪	◪	■
M	M1	◪	◪	◪	◪	◪	◪		
	M2	◪	◪	◪	◪		◪		
	M3								
	M4								
K	K1	■	■	■	■	■	■	■	■
	K2	■	■	■	■	■	■	■	■
	K3	◪	◪	◪	◪	◪	◪	◪	◪
	K4								
	K5								
N	N1	■	■	■	■	■	■	■	■
	N2	■	■	■	■	■	■	■	■
	N3	■	■	■	■	■	■	■	■
	N4	◪	◪	◪	◪	◪	◪	◪	◪
	N5								
S	S1								
	S2								
	S3								
	S4								
H	H1								
	H2								
	H3								
	H4								

■推荐使用 ◪可以使用

B901

DORMER

机用高速钢直柄铰刀，孔径精度H7，表面光亮并蒸汽回火处理。
机用高性能直柄铰刀，精磨的槽型，左手螺旋并右手切削，能够改善孔径尺寸和表面光洁度，适用于多种材料的切削。



HSS-E	Bright ST	BS 328
R		B
H7		

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■15 C	■16 C	■17 C	■13 C	■11 C	◪10 B	■7 B	■6 B	◪5 B	■4 B	◪4 B	◪3 A	◪10 C	◪8 C
M2.1	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪9 C	■14 E	■10 D	◪8 D	■12 C	■10 C	◪8 C	◪11 C	◪8 C	◪23 F	■17 F	■12 F	■25 E	■22 E
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**								
◪14 E	■34 D	■20 E	■10 D	◪22 B	◪21 B								

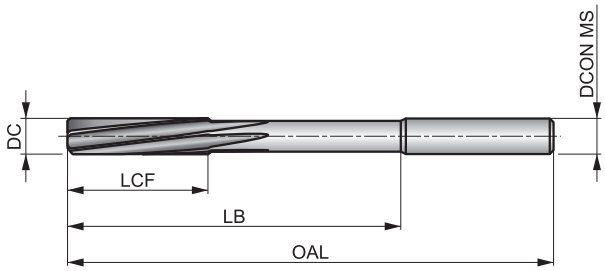
Product	DC (inch)	DC (mm)	OAL (mm)	LCF (mm)	NOF	DCON MS (mm)
B9011.5	–	1.50	44.0	21.0	4	1.50
B9012.0	–	2.00	50.0	25.0	4	2.00
B9013/32	3/32	2.38	58.0	29.0	4	2.38
B9012.5	–	2.50	58.0	29.0	4	2.50
B9013.0	–	3.00	62.0	31.0	4	3.00
B9011/8	1/8	3.18	66.0	33.0	4	3.18
B9015/32	5/32	3.97	76.0	38.0	6	3.97
B9014.0	–	4.00	76.0	38.0	6	4.00
B9013/16	3/16	4.76	87.0	44.0	6	4.76
B9015.0	–	5.00	87.0	44.0	6	5.00
B90115/64	15/64	5.95	93.0	47.0	6	5.95
B9016.0	–	6.00	93.0	47.0	6	6.00

Product	DC (inch)	DC (mm)	OAL (mm)	LCF (mm)	NOF	DCON MS (mm)
B9011/4	1/4	6.35	100.0	50.0	6	6.35
B9017.0	–	7.00	107.0	54.0	6	7.00
B9019/32	9/32	7.14	107.0	54.0	6	7.14
B9015/16	5/16	7.94	115.0	58.0	6	7.94
B9018.0	–	8.00	115.0	58.0	6	8.00
B9019.0	–	9.00	124.0	62.0	6	9.00
B9013/8	3/8	9.52	133.0	66.0	6	9.52
B90110.0	–	10.00	133.0	66.0	6	10.00
B90111.0	–	11.00	142.0	71.0	6	11.00
B9017/16	7/16	11.11	142.0	71.0	6	11.11
B90112.0	–	12.00	152.0	76.0	6	12.00
B9011/2	1/2	12.70	152.0	76.0	6	12.70

B180

DORMER

机用高速钢直柄铰刀，孔径精度H7，表面光亮处理。
用于高精度刀柄的机用高性能铰刀，左手螺旋并右手切削，精磨的槽型能够平稳地铰孔，并改善孔径尺寸和表面光洁度，适用于多种材料的切削。



HSS-E	Bright	DIN 212
R	DIN 6535HA	B
H7		

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■21 C	■24 C	■25 C	■18 C	■16 C	◪14 B	■13 B	■11 B	◪9 B	■8 B	◪7 B	◪5 A	◪11 C	◪10 B
M2.1	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪9 B	■16 E	■12 D	◪9 D	■16 C	■13 C	◪10 C	■14 C	◪11 C	◪24 F	■18 F	■11 F	◪27 E	■24 E
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**									
■16 E	■47 D	■28 E	◪14 D	◪30 B									

DCON MS公差h6

Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	DCON MS (mm)
B1801.5	1.50	40.0	8.0	18.00	3	2.00
B1801.6	1.60	43.0	9.0	20.00	3	2.00
B1801.7	1.70	43.0	9.0	20.00	3	2.00
B1801.8	1.80	46.0	10.0	22.00	4	2.00
B1801.9	1.90	46.0	10.0	22.00	4	2.00
B1802.0	2.00	49.0	11.0	24.00	4	2.00
B1802.1	2.10	49.0	11.0	24.00	4	2.00
B1802.2	2.20	53.0	12.0	26.00	4	3.00
B1802.3	2.30	53.0	12.0	26.00	4	3.00
B1802.4	2.40	57.0	14.0	28.00	4	3.00
B1802.5	2.50	57.0	14.0	28.00	4	3.00
B1802.6	2.60	57.0	14.0	28.00	4	3.00
B1802.7	2.70	61.0	15.0	32.00	6	3.00
B1802.8	2.80	61.0	15.0	32.00	6	3.00
B1802.9	2.90	61.0	15.0	32.00	6	3.00
B1803.0	3.00	61.0	15.0	32.00	6	3.00
B1803.1	3.10	65.0	16.0	35.00	6	4.00
B1803.2	3.20	65.0	16.0	35.00	6	4.00
B1803.3	3.30	65.0	16.0	35.00	6	4.00
B1803.4	3.40	70.0	18.0	40.00	6	4.00
B1803.5	3.50	70.0	18.0	40.00	6	4.00
B1803.6	3.60	70.0	18.0	40.00	6	4.00
B1803.9	3.90	75.0	19.0	43.00	6	4.00
B1804.0	4.00	75.0	19.0	43.00	6	4.00
B1804.1	4.10	75.0	19.0	43.00	6	4.00
B1804.2	4.20	75.0	19.0	43.00	6	4.00
B1804.3	4.30	80.0	21.0	47.00	6	5.00

Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	DCON MS (mm)
B1804.5	4.50	80.0	21.0	47.00	6	5.00
B1804.6	4.60	80.0	21.0	47.00	6	5.00
B1804.7	4.70	80.0	21.0	47.00	6	5.00
B1804.8	4.80	86.0	23.0	52.00	6	5.00
B1804.9	4.90	86.0	23.0	52.00	6	5.00
B1805.0	5.00	86.0	23.0	52.00	6	5.00
B1805.1	5.10	86.0	23.0	52.00	6	5.00
B1805.2	5.20	86.0	23.0	52.00	6	5.00
B1805.3	5.30	86.0	23.0	52.00	6	5.00
B1805.4	5.40	93.0	26.0	57.00	6	6.00
B1805.5	5.50	93.0	26.0	57.00	6	6.00
B1805.6	5.60	93.0	26.0	57.00	6	6.00
B1805.7	5.70	93.0	26.0	57.00	6	6.00
B1805.9	5.90	93.0	26.0	57.00	6	6.00
B1806.0	6.00	93.0	26.0	57.00	6	6.00
B1806.1	6.10	101.0	28.0	63.00	6	6.00
B1806.2	6.20	101.0	28.0	63.00	6	6.00
B1806.3	6.30	101.0	28.0	63.00	6	6.00
B1806.4	6.40	101.0	28.0	63.00	6	6.00
B1806.5	6.50	101.0	28.0	63.00	6	6.00
B1806.6	6.60	101.0	28.0	63.00	6	6.00
B1806.7	6.70	101.0	28.0	63.00	6	6.00
B1806.8	6.80	109.0	31.0	69.00	6	8.00
B1807.0	7.00	109.0	31.0	69.00	6	8.00
B1807.1	7.10	109.0	31.0	69.00	6	8.00
B1807.2	7.20	109.0	31.0	69.00	6	8.00
B1807.5	7.50	109.0	31.0	69.00	6	8.00

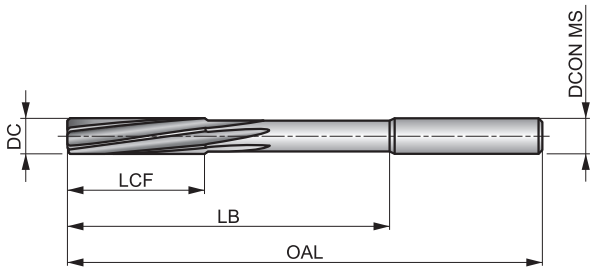
Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B1807.8	7.80	117.0	33.0	75.00	6	8.00
B1807.9	7.90	117.0	33.0	75.00	6	8.00
B1808.0	8.00	117.0	33.0	75.00	6	8.00
B1808.1	8.10	117.0	33.0	75.00	6	8.00
B1808.2	8.20	117.0	33.0	75.00	6	8.00
B1808.3	8.30	117.0	33.0	75.00	6	8.00
B1808.4	8.40	117.0	33.0	75.00	6	8.00
B1808.5	8.50	117.0	33.0	75.00	6	8.00
B1808.7	8.70	125.0	36.0	81.00	6	10.00
B1808.8	8.80	125.0	36.0	81.00	6	10.00
B1809.0	9.00	125.0	36.0	81.00	6	10.00
B1809.5	9.50	125.0	36.0	81.00	6	10.00

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B1809.6	9.60	133.0	38.0	87.00	6	10.00
B18010.0	10.00	133.0	38.0	87.00	6	10.00
B18011.0	11.00	142.0	41.0	96.00	6	10.00
B18012.0	12.00	151.0	44.0	105.00	6	10.00
B18013.0	13.00	151.0	44.0	105.00	6	10.00
B18014.0	14.00	160.0	47.0	110.00	8	14.00
B18015.0	15.00	162.0	50.0	112.00	8	14.00
B18016.0	16.00	170.0	52.0	120.00	8	14.00
B18017.0	17.00	175.0	54.0	123.00	8	14.00
B18018.0	18.00	182.0	56.0	130.00	8	14.00
B18019.0	19.00	189.0	58.0	131.00	8	16.00
B18020.0	20.00	195.0	60.0	137.00	8	16.00

B170

DORMER

机用高速钢直柄铰刀，孔径精度增量0.01，表面光亮处理。
不同的增量尺寸能够加工精确的孔径尺寸和额外的公差。左手螺旋并右手切削，精磨的槽型能够平稳地铰孔，并改善孔径尺寸和表面光洁度，适用于多种材料的切削。



HSS-E	Bright	DIN 212
R		B
ø.95-5.5 +0.004 ø5.51-12 +0.005		

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■21 C	■24 C	■25 C	■18 C	■16 C	◪14 B	■13 B	■11 B	◪9 B	■8 B	◪7 B	◪5 A	◪11 C	◪10 B
M2.1	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪9 B	■16 E	■12 D	◪9 D	■16 C	■13 C	◪10 C	■14 C	◪11 C	◪24 D	■18 F	■11 F	◪27 E	■24 E
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**									
■16 E	■47 D	■28 E	◪14 D	◪30 B									

DCON MS公差h9

Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	DCON MS (mm)
B1701.0	1.00	34.0	5.5	15.00	3	1.00
B1701.05	1.05	34.0	5.5	15.00	3	1.00
B1701.49	1.49	40.0	8.0	18.00	3	1.50
B1701.5	1.50	40.0	8.0	18.00	3	1.50
B1701.52	1.52	43.0	9.0	20.00	3	1.60
B1701.98	1.98	49.0	11.0	24.00	4	2.00
B1701.99	1.99	49.0	11.0	24.00	4	2.00
B1702.0	2.00	49.0	11.0	24.00	4	2.00
B1702.01	2.01	49.0	11.0	24.00	4	2.00
B1702.02	2.02	49.0	11.0	24.00	4	2.00
B1702.03	2.03	49.0	11.0	24.00	4	2.00
B1702.05	2.05	49.0	11.0	24.00	4	2.00
B1702.5	2.50	57.0	14.0	28.00	4	2.50
B1702.51	2.51	57.0	14.0	28.00	4	2.50
B1702.98	2.98	61.0	15.0	32.00	6	3.00
B1702.99	2.99	61.0	15.0	32.00	6	3.00
B1703.0	3.00	61.0	15.0	32.00	6	3.00
B1703.01	3.01	65.0	16.0	35.00	6	3.20
B1703.02	3.02	65.0	16.0	35.00	6	3.20
B1703.03	3.03	65.0	16.0	35.00	6	3.20
B1703.05	3.05	65.0	16.0	35.00	6	3.20
B1703.98	3.98	75.0	19.0	43.00	6	4.00
B1703.99	3.99	75.0	19.0	43.00	6	4.00
B1704.0	4.00	75.0	19.0	43.00	6	4.00
B1704.01	4.01	75.0	19.0	43.00	6	4.00
B1704.02	4.02	75.0	19.0	43.00	6	4.00
B1704.03	4.03	75.0	19.0	43.00	6	4.00

Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	DCON MS (mm)
B1704.04	4.04	75.0	19.0	43.00	6	4.00
B1704.05	4.05	75.0	19.0	43.00	6	4.00
B1704.98	4.98	86.0	23.0	52.00	6	5.00
B1704.99	4.99	86.0	23.0	52.00	6	5.00
B1705.0	5.00	86.0	23.0	52.00	6	5.00
B1705.01	5.01	86.0	23.0	52.00	6	5.00
B1705.02	5.02	86.0	23.0	52.00	6	5.00
B1705.03	5.03	86.0	23.0	52.00	6	5.00
B1705.04	5.04	86.0	23.0	52.00	6	5.00
B1705.05	5.05	86.0	23.0	52.00	6	5.00
B1705.5	5.50	93.0	26.0	57.00	6	5.60
B1705.98	5.98	93.0	26.0	57.00	6	5.60
B1705.99	5.99	93.0	26.0	57.00	6	5.60
B1706.0	6.00	93.0	26.0	57.00	6	5.60
B1706.01	6.01	101.0	28.0	63.00	6	6.30
B1706.02	6.02	101.0	28.0	63.00	6	6.30
B1706.03	6.03	101.0	28.0	63.00	6	6.30
B1706.04	6.04	101.0	28.0	63.00	6	6.30
B1706.05	6.05	101.0	28.0	63.00	6	6.30
B1706.51	6.51	101.0	28.0	63.00	6	6.30
B1706.98	6.98	109.0	31.0	69.00	6	7.10
B1706.99	6.99	109.0	31.0	69.00	6	7.10
B1707.0	7.00	109.0	31.0	69.00	6	7.10
B1707.01	7.01	109.0	31.0	69.00	6	7.10
B1707.02	7.02	109.0	31.0	69.00	6	7.10
B1707.05	7.05	109.0	31.0	69.00	6	7.10
B1707.98	7.98	117.0	33.0	75.00	6	8.00

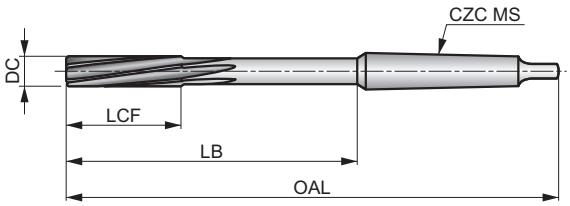
Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B1707.99	7.99	117.0	33.0	75.00	6	8.00
B1708.0	8.00	117.0	33.0	75.00	6	8.00
B1708.01	8.01	117.0	33.0	75.00	6	8.00
B1708.02	8.02	117.0	33.0	75.00	6	8.00
B1708.03	8.03	117.0	33.0	75.00	6	8.00
B1708.04	8.04	117.0	33.0	75.00	6	8.00
B1708.05	8.05	117.0	33.0	75.00	6	8.00
B1708.98	8.98	125.0	36.0	81.00	6	9.00
B1709.0	9.00	125.0	36.0	81.00	6	9.00
B1709.01	9.01	125.0	36.0	81.00	6	9.00
B1709.02	9.02	125.0	36.0	81.00	6	9.00
B1709.05	9.05	125.0	36.0	81.00	6	9.00
B1709.5	9.50	125.0	36.0	81.00	6	9.00
B1709.51	9.51	133.0	38.0	87.00	6	10.00

Product	DC	OAL	LCF	LB	NOF	DCON MS
	(mm)	(mm)	(mm)	(mm)		(mm)
B1709.52	9.52	133.0	38.0	87.00	6	10.00
B1709.98	9.98	133.0	38.0	87.00	6	10.00
B1709.99	9.99	133.0	38.0	87.00	6	10.00
B17010.0	10.00	133.0	38.0	87.00	6	10.00
B17010.01	10.01	133.0	38.0	87.00	6	10.00
B17010.02	10.02	133.0	38.0	87.00	6	10.00
B17010.03	10.03	133.0	38.0	87.00	6	10.00
B17010.04	10.04	133.0	38.0	87.00	6	10.00
B17010.05	10.05	133.0	38.0	87.00	6	10.00
B17010.98	10.98	142.0	41.0	96.00	6	10.00
B17011.98	11.98	151.0	44.0	105.00	6	10.00
B17011.99	11.99	151.0	44.0	105.00	6	10.00
B17012.0	12.00	151.0	44.0	105.00	6	10.00

B161

DORMER

机用高速钢锥柄铰刀，孔径精度H7，表面光亮处理。
精密的磨制刀具，左手螺旋并右手切削，能够平稳地铰孔并改善孔径尺寸和表面光洁度，适用于多种材料的切削。



HSS-E	Bright	DIN 208
R		B
H7		

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■21 C	■24 C	■25 C	■18 C	■16 C	◪14 B	■13 B	■11 B	◪9 B	■8 B	◪7 B	◪5 A	◪11 C	◪10 B
M2.1	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪9 B	■16 E	■12 D	◪9 D	■16 C	■13 C	◪10 C	■14 C	◪11 C	◪24 F	■18 F	■11 F	◪27 E	■24 E
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**									
■16 E	■47 D	■28 E	◪14 D	◪30 B									

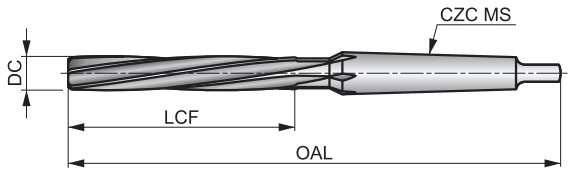
Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	CZC MS
B1613.0	3.00	113.0	15.0	47.50	6	MK 1
B1614.0	4.00	124.0	19.0	58.50	6	MK 1
B1615.0	5.00	133.0	23.0	67.50	6	MK 1
B1616.0	6.00	138.0	26.0	72.50	6	MK 1
B1617.0	7.00	150.0	31.0	84.50	6	MK 1
B1618.0	8.00	156.0	33.0	90.50	6	MK 1
B1619.0	9.00	162.0	36.0	96.50	6	MK 1
B16110.0	10.00	168.0	38.0	102.50	6	MK 1
B16111.0	11.00	175.0	41.0	109.50	6	MK 1
B16112.0	12.00	182.0	44.0	116.50	6	MK 1
B16113.0	13.00	182.0	44.0	116.50	6	MK 1
B16114.0	14.00	189.0	47.0	123.50	8	MK 1
B16115.0	15.00	204.0	50.0	124.00	8	MK 2
B16116.0	16.00	210.0	52.0	130.00	8	MK 2
B16117.0	17.00	214.0	54.0	134.00	8	MK 2
B16118.0	18.00	219.0	56.0	139.00	8	MK 2
B16119.0	19.00	223.0	58.0	143.00	8	MK 2
B16120.0	20.00	228.0	60.0	148.00	8	MK 2

Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	CZC MS
B16121.0	21.00	232.0	62.0	152.00	8	MK 2
B16122.0	22.00	237.0	64.0	157.00	8	MK 2
B16123.0	23.00	241.0	66.0	161.00	8	MK 2
B16124.0	24.00	268.0	68.0	169.00	8	MK 3
B16125.0	25.00	268.0	68.0	169.00	8	MK 3
B16126.0	26.00	273.0	70.0	174.00	8	MK 3
B16127.0	27.00	277.0	71.0	178.00	10	MK 3
B16128.0	28.00	277.0	71.0	178.00	10	MK 3
B16130.0	30.00	281.0	73.0	182.00	10	MK 3
B16132.0	32.00	317.0	77.0	193.00	10	MK 4
B16134.0	34.00	321.0	78.0	197.00	10	MK 4
B16135.0	35.00	321.0	78.0	197.00	10	MK 4
B16138.0	38.00	329.0	81.0	205.00	10	MK 4
B16140.0	40.00	329.0	81.0	205.00	10	MK 4
B16142.0	42.00	333.0	82.0	209.00	12	MK 4
B16145.0	45.00	336.0	83.0	212.00	12	MK 4
B16150.0	50.00	344.0	86.0	220.00	12	MK 4

B101

DORMER

机用高速钢锥柄铰刀，孔径精度H7。
符合BS 328标准的机用锥柄铰刀，精密的磨制刀具，左手螺旋并右手切削，能够平稳地铰孔并改善孔径尺寸和表面光洁度，适用于多种材料的切削。



HSS-E	Bright ST	BS 328
R		B
H7		

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■ 15 C	■ 16 C	■ 17 C	■ 13 C	■ 11 C	◪ 10 B	■ 7 B	■ 6 B	◪ 5 B	■ 4 B	◪ 4 B	◪ 3 A	◪ 7 B	◪ 6 A
K1.1	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**
■ 14 E	■ 10 D	◪ 8 D	■ 12 C	■ 10 C	◪ 8 C	■ 11 C	◪ 8 C	◪ 23 F	■ 17 F	■ 9 F	◪ 25 E	■ 18 E	■ 14 E
N3.1	**N3.2**	**N3.3**	**N4.1**										
■ 34 D	■ 20 E	◪ 10 D	◪ 22 B										

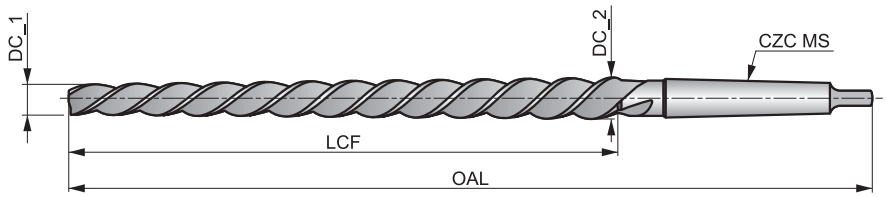
Product	DC (inch)	DC (mm)	OAL (mm)	LCF (mm)	NOF	CZC MS
B1013.0	–	3.00	112.0	33.0	4	MK 1
B1014.0	–	4.00	117.0	38.0	6	MK 1
B1013/16	3/16	4.76	124.0	44.0	6	MK 1
B1015.0	–	5.00	124.0	44.0	6	MK 1
B1016.0	–	6.00	127.0	47.0	6	MK 1
B1011/4	1/4	6.35	130.0	50.0	6	MK 1
B1015/16	5/16	7.94	138.0	58.0	6	MK 1
B1018.0	–	8.00	138.0	58.0	6	MK 1
B1013/8	3/8	9.52	146.0	66.0	6	MK 1
B10110.0	–	10.00	146.0	66.0	6	MK 1
B10111.0	–	11.00	151.0	71.0	6	MK 1
B1017/16	7/16	11.11	151.0	71.0	6	MK 1
B10112.0	–	12.00	156.0	76.0	6	MK 1
B1011/2	1/2	12.70	156.0	76.0	6	MK 1
B10113.0	–	13.00	156.0	76.0	6	MK 1
B10114.0	–	14.00	161.0	81.0	8	MK 1
B1019/16	9/16	14.29	181.0	81.0	8	MK 2
B10115.0	–	15.00	181.0	81.0	8	MK 2
B1015/8	5/8	15.88	187.0	87.0	8	MK 2
B10116.0	–	16.00	187.0	87.0	8	MK 2
B10116.5	–	16.50	187.0	87.0	8	MK 2
B10117.0	–	17.00	187.0	87.0	8	MK 2

Product	DC (inch)	DC (mm)	OAL (mm)	LCF (mm)	NOF	CZC MS
B10118.0	–	18.00	193.0	93.0	8	MK 2
B10119.0	–	19.00	193.0	93.0	8	MK 2
B1013/4	3/4	19.05	200.0	100.0	8	MK 2
B10120.0	–	20.00	200.0	100.0	8	MK 2
B10121.0	–	21.00	200.0	100.0	8	MK 2
B10122.0	–	22.00	207.0	107.0	8	MK 2
B1017/8	7/8	22.22	207.0	107.0	8	MK 2
B10123.0	–	23.00	207.0	107.0	8	MK 2
B10124.0	–	24.00	242.0	115.0	8	MK 3
B10125.0	–	25.00	242.0	115.0	10	MK 3
B1011	1″	25.40	242.0	115.0	10	MK 3
B10126.0	–	26.00	242.0	115.0	10	MK 3
B10128.0	–	28.00	251.0	124.0	10	MK 3
B10129.0	–	29.00	251.0	124.0	10	MK 3
B10130.0	–	30.00	251.0	124.0	10	MK 3
B1011.1/4	1.1/4	31.75	260.0	133.0	10	MK 3
B10135.0	–	35.00	302.0	142.0	10	MK 4
B10140.0	–	40.00	312.0	152.0	10	MK 4
B10141.0	–	41.00	312.0	152.0	10	MK 4
B10144.0	–	44.00	323.0	163.0	10	MK 4
B10150.0	–	50.00	334.0	174.0	12	MK 4

B954

DORMER

机用高速钢锥柄锥度铰刀，锥度1:50。
特殊设计的较大左手螺旋并右手切削，能够平稳地铰孔以提高精度，用于精加工锥孔以满足1:50公制锥形销标准，适用于多种材料的切削。



HSS-E	Bright	DIN 2180
R		1:50

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

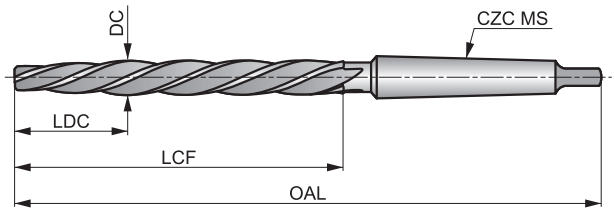
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■10 B	■12 B	■13 B	■9 B	■8 B	◪6 A	■7 A	■6 A	◪3 A	■4 A	◪3 A	◪2 A	◪11 C	◪10 B
M2.1	**M2.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**
◪9 B	◪8 B	■10 C	■6 B	◪4 B	■8 A	■6 A	◪4 A	■11 A	◪8 A	◪14 F	■12 F	■9 F	■16 E
N2.2	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**								
■14 E	◪10 E	■22 D	■14 E	◪6 D	◪22 B								

Product	nom d	DC_1 (mm)	DC_2 (mm)	OAL (mm)	LCF (mm)	NOF	CZC MS
B9548.0	8.0	7.90	10.80	227.0	145.0	3	MK 1
B95410.0	10.0	9.90	13.40	257.0	175.0	3	MK 1
B95412.0	12.0	11.80	16.00	315.0	210.0	3	MK 2
B95413.0	13.0	12.86	16.74	295.0	194.0	3	MK 2
B95414.0	14.0	13.86	17.74	295.0	194.0	3	MK 2
B95416.0	16.0	15.80	20.40	335.0	230.0	3	MK 2
B95420.0	20.0	19.80	24.80	377.0	250.0	3	MK 3
B95425.0	25.0	24.70	30.70	427.0	300.0	3	MK 3
B95430.0	30.0	29.70	36.10	475.0	320.0	4	MK 4

B121

DORMER

机用高速钢锥柄扩孔铰刀
一种用于在大型装配的螺栓连接或铆接两个或多个工件之前，重新校准孔的铰刀，1:10锥度的小引导直径，简化了刀具在预孔中的定位和校准，适用于多种材料的切削。



HSS	Bright ST	DIN 311
R		k11

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	K1.1	K1.2
■ 15 C	■ 16 C	■ 17 C	■ 13 C	■ 11 C	◪ 10 B	■ 7 B	■ 6 B	◪ 5 B	■ 4 B	◪ 4 B	◪ 3 A	■ 14 E	■ 10 D
K1.3	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**
◪ 8 D	■ 12 C	■ 10 C	◪ 8 C	◪ 11 C	◪ 8 C	◪ 23 F	■ 17 F	■ 9 F	◪ 21 E	■ 18 E	◪ 14 E	■ 34 D	■ 20 E
N3.3	**N4.1**												
◪ 10 D	◪ 21 B												

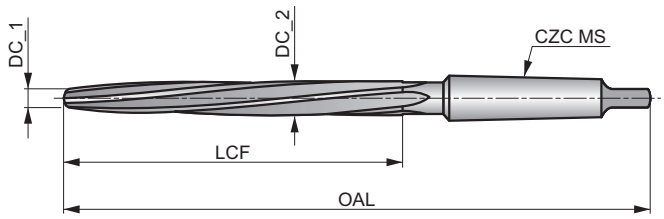
1:10开始锥度(LDC)

Product	DC (mm)	OAL (mm)	LCF (mm)	LDC (mm)	NOF	CZC MS
B12112.0	12.00	199.0	105.0	39.00	4	MK 2
B12114.0	14.00	209.0	115.0	42.00	4	MK 2
B12116.0	16.00	229.0	135.0	48.00	4	MK 2
B12117.0	17.00	251.0	135.0	51.00	4	MK 3
B12118.0	18.00	261.0	145.0	58.00	4	MK 3
B12120.0	20.00	271.0	155.0	62.00	4	MK 3
B12121.0	21.00	271.0	155.0	62.00	4	MK 3
B12122.0	22.00	281.0	165.0	66.00	4	MK 3
B12124.0	24.00	296.0	180.0	72.00	4	MK 3
B12125.0	25.00	296.0	180.0	72.00	4	MK 3

B640

DORMER

高速钢锥柄铰刀，蒸汽回火
用于重新对准大型工件（如工字钢）上的孔，在这种情况下，两个或多个工件将通过螺栓或铆钉连接起来。较小的起始端带有较长的锥形导程，操作员可以通过铰去不匹配的预钻孔来对准不匹配的预钻孔。
按照 ANSI B94.2-1983 (R1988) 标准生产。



HSS | ST | ANSI

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	K1.1	K1.2
■ 15 C	■ 16 C	■ 17 C	■ 13 C	■ 11 C	◪ 10 B	■ 7 B	■ 6 B	◪ 5 B	■ 4 B	◪ 4 B	◪ 3 A	■ 14 E	■ 10 D
K1.3	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**
◪ 8 D	■ 12 C	■ 10 C	◪ 8 C	◪ 11 C	◪ 8 C	◪ 23 F	■ 17 F	■ 9 F	◪ 21 E	■ 18 E	◪ 14 E	■ 34 D	■ 20 E
N3.3	**N4.1**												
◪ 10 D	◪ 21 B												

Product	nom d	DC_1 (inch)	DC_2 (inch)	CZC MS	LCF (inch)	OAL (inch)	NOF
B6407/16	7/16	0.2500	0.4375	2	4.3/8	8.1/4	5
B6401/2	1/2	0.2813	0.5000	2	5.1/8	9″	5
B6409/16	9/16	0.3438	0.5625	2	5.1/8	9″	5
B6405/8	5/8	0.3750	0.6250	2	6.1/8	10″	5
B64011/16	11/16	0.3906	0.6875	3	7.1/8	11.3/4	5
B6403/4	3/4	0.4375	0.7500	3	7.3/8	12″	5
B64013/16	13/16	0.5000	0.8125	3	7.3/8	12″	5
B6407/8	7/8	0.5625	0.8750	3	7.3/8	12″	5
B64015/16	15/16	0.6250	0.9375	3	7.3/8	12″	5
B6401	1″	0.6875	1.0000	3	7.3/8	12″	5
B6401.1/16	1.1/16	0.7500	1.0625	3	7.3/8	12″	5

提高工艺安全性和生产率的工具。通常用于 CNC 和自动化生产。
适用于高切削参数。

材料代码(BMC)	HM	HM	HM	HM
基本标准组(BSG)	DORMER	DORMER	DORMER	DORMER
有用长度直径比 (ULDR)	1×D	1×D	1×D	1×D
应用角度	90°	90°	120°	150°
涂层	Bright	TiAlN	Bright	TiAlN
柄部		DIN 6535HA		
螺旋形式	λ 20-35°	λ 20-35°	λ 20-35°	λ 20-35°
旋向(切削方向)	R	R	R	R

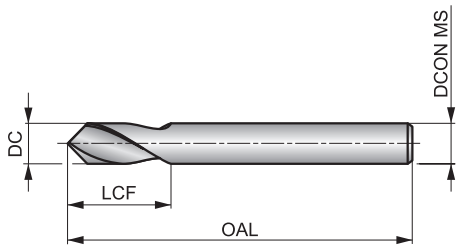
产品系列代码	R123	R6011	R122	R125
PSF切削直径范围	5.00 - 20.00	6.00 - 16.00	5.00 - 20.00	5.00 - 16.00
	182	183	184	185
P	P1 ■	■	■	■
	P2 ■	■	■	■
	P3 ■	■	■	■
	P4 ■	■	■	■
M	M1 ■	■	■	■
	M2 ■	■	■	■
	M3 ■	■	■	■
	M4			
K	K1 ■	■	■	■
	K2 ■	■	■	■
	K3 ■	■	■	■
	K4 ■	■	■	■
	K5 ■	■	■	■
N	N1 ■	■	■	■
	N2 ■	■	■	■
	N3 ■	■	■	■
	N4 ■	■	■	■
	N5			
S	S1 ■	■	■	■
	S2 ■	■	■	■
	S3 ■	■	■	■
	S4 ■	■	■	■
H	H1 ■	■	■	■
	H2 ◪	◪	◪	◪
	H3 ◪	◪	◪	◪
	H4			

■推荐使用 ◪可以使用

R123

DORMER

90°合金定心钻
精密设计的钻尖角提供了一个精确的引导，便于后续钻孔的定心，90°的钻尖角有助于自定心并减少钻入材料的切削力，适用于多种材料的切削。



HM	DORMER	1×D
90°	Bright	
λ20-35°	R	DC h6

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

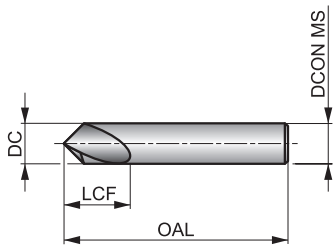
P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■99 S	■111 S	■115 S	■85 S	■75 S	■66 S	■66 S	■53 S	■45 S	■40 S	■34 S	■27 S	■73 S	■61 S
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■65 S	■53 S	■52 S	■45 S	■75 T	■56 T	■42 T	■68 T	■55 T	■44 T	■60 T	■46 T	■37 T	■55 T
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■42 T	■31 T	■26 T	■22 T	■63 T	■47 T	■37 T	■200 V	■150 V	■100 V	■172 V	■155 V	■112 V	■423 V
N3.2	N3.3	N4.1	N4.2	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2	H1.1
■250 V	■125 V	■60 X	■100 V	■45 T	■35 T	■25 S	■40 S	■28 S	■30 S	■20 S	■23 S	■16 S	■56 S
H2.1	H2.2	H3.1	H3.2										
◪33 S	◪36 S	◪37 S	◪30 S										

Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R1235.0	5.00	0.1969	16.0	62.0	5.00
R1236.0	6.00	0.2362	17.0	66.0	6.00
R1238.0	8.00	0.3150	22.0	79.0	8.00
R12310.0	10.00	0.3937	26.0	89.0	10.00
R12312.0	12.00	0.4724	30.0	102.0	12.00
R12316.0	16.00	0.6299	34.0	115.0	16.00
R12320.0	20.00	0.7874	40.0	131.0	20.00

R6011

DORMER

90°合金定心钻，氮铝化钛涂层。
精密设计的钻尖角提供了一个精确的引导，便于后续钻孔的定心，90°的钻尖角有助于自定心并减少钻入材料的切削力，氮铝化钛涂层提高了性能并延长了刀具寿命，适用于多种材料的切削。



HM	DORMER	1×D
90°	TiAlN	DIN 6535HA
λ20-35°	R	DC h6

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■119 S	■134 S	■138 S	■102 S	■90 S	■80 S	■81 S	■65 S	■55 S	■48 S	■41 S	■34 S	■82 S	■70 S
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■73 S	■60 S	■58 S	■50 S	■80 T	■59 T	■44 T	■86 T	■70 T	■56 T	■76 T	■58 T	■47 T	■71 T
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■53 T	■39 T	■33 T	■28 T	■80 T	■60 T	■46 T	■200 V	■150 V	■100 V	■172 V	■155 V	■112 V	■423 V
N3.2	N3.3	N4.1	N4.2	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2	H1.1
■250 V	■125 V	■60 X	■100 V	■55 T	■45 T	■35 S	■53 S	■42 S	■40 S	■30 S	■31 S	■24 S	■56 S
H2.1	H2.2	H3.1	H3.2										
◪33 S	◪36 S	◪37 S	◪30 S										

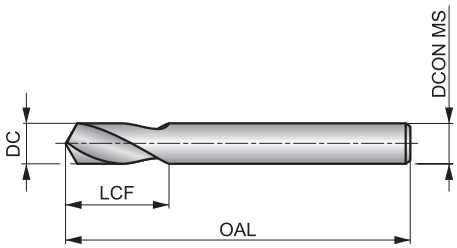
DCON MS公差h6

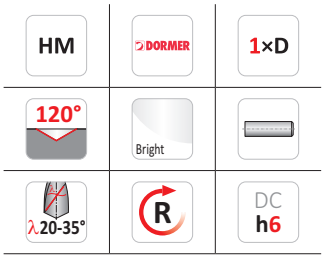
Product	DC	DC	LCF	OAL	DCON MS
	(mm)	(inch)	(mm)	(mm)	(mm)
R60116.0	6.00	0.2362	16.0	50.0	6.00
R601110.0	10.00	0.3937	25.0	70.0	10.00
R601116.0	16.00	0.6299	26.0	90.0	16.00

R122

DORMER

120°合金定心钻
精密设计的钻尖角提供了一个精确的引导，便于后续钻孔的定心，120°的钻尖角有助于自定心并减少切削力，适用于多种材料的切削。





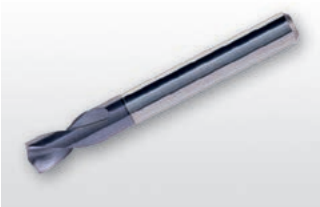
工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■99 S	■111 S	■115 S	■85 S	■75 S	■66 S	■66 S	■53 S	■45 S	■40 S	■34 S	■27 S	■73 S	■61 S
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■65 S	■53 S	■52 S	■45 S	■75 T	■56 T	■42 T	■68 T	■55 T	■44 T	■60 T	■46 T	■37 T	■55 T
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■42 T	■31 T	■26 T	■22 T	■63 T	■47 T	■37 T	■200 V	■150 V	■100 V	■172 V	■155 V	■112 V	■423 V
N3.2	N3.3	N4.1	N4.2	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2	H1.1
■250 V	■125 V	■60 X	■100 V	■45 T	■35 T	■25 S	■40 S	■28 S	■30 S	■20 S	■23 S	■16 S	■56 S
H2.1	H2.2	H3.1	H3.2										
◪33 S	◪36 S	◪37 S	◪30 S										

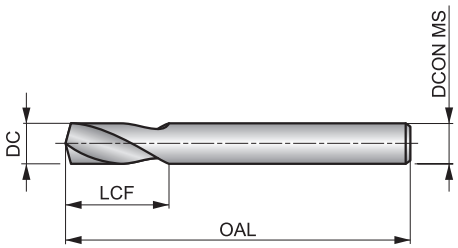
Product	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R1225.0	5.00	0.1969	16.0	62.0	5.00
R1226.0	6.00	0.2362	17.0	66.0	6.00
R1228.0	8.00	0.3150	22.0	79.0	8.00
R12210.0	10.00	0.3937	26.0	89.0	10.00
R12212.0	12.00	0.4724	30.0	102.0	12.00
R12216.0	16.00	0.6299	34.0	115.0	16.00
R12220.0	20.00	0.7874	40.0	131.0	20.00

R125

DORMER



150°合金定心钻，氮铝化钛涂层。
精密设计的钻尖角提供了一个精确的引导，便于后续钻孔的定心，150°的钻尖角有助于自定心并减少钻入材料的切削力，氮铝化钛涂层提高了性能并延长了刀具寿命，适用于多种材料的切削。



HM	DORMER	1×D
150°	TiAlN	
λ20-35°	R	DC h6

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■119 S	■134 S	■138 S	■102 S	■90 S	■80 S	■81 S	■65 S	■55 S	■48 S	■41 S	■34 S	■82 S	■70 S
M2.1	M2.2	M3.1	M3.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1
■73 S	■60 S	■58 S	■50 S	■80 T	■59 T	■44 T	■86 T	■70 T	■56 T	■76 T	■58 T	■47 T	■71 T
K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1
■53 T	■39 T	■33 T	■28 T	■80 T	■60 T	■46 T	■200 V	■150 V	■100 V	■172 V	■155 V	■112 V	■423 V
N3.2	N3.3	N4.1	N4.2	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2	S4.1	S4.2	H1.1
■250 V	■125 V	■60 X	■100 V	■55 T	■45 T	■35 S	■53 S	■42 S	■40 S	■30 S	■31 S	■24 S	■56 S
H2.1	H2.2	H3.1	H3.2										
◪33 S	◪36 S	◪37 S	◪30 S										

DCON MS公差h6

Product	DC	LCF	OAL	DCON MS
	(mm)	(mm)	(mm)	(mm)
R1255.0	5.00	16.0	62.0	5.00
R1256.0	6.00	17.0	66.0	6.00
R1258.0	8.00	22.0	79.0	8.00
R12510.0	10.00	26.0	89.0	10.00
R12512.0	12.00	30.0	102.0	12.00
R12516.0	16.00	34.0	115.0	16.00

材料代码(BMC)		HM	HM	HM	HM	HM	HM	HM	HM	HM	HM		
基本标准组(BSG)		DIN 6539	DIN 338	DIN 6537K	DIN 6537K	DIN 6537L	DIN 6537L	DORMER	DIN 6537K	DIN 6537L	DORMER		
有用长度直径比 (ULDR)		2.5×D	4×D	3×D	3×D	5×D	5×D	8×D	3×D	5×D	3×D		
应用角度		130°	130°	140°	140°	140°	140°	140°	140°	140°	90°		
涂层		TiN	TiN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN	TiAlN		
柄部				DIN 6535HA	DIN 6535HA	DIN 6535HA	DIN 6535HA	DIN 6535HA	DIN 6535HA	DIN 6535HA	DIN 6535HA		
螺旋形式		λ 20-35°	λ 20-35°	CTW	CTW	CTW	CTW	CTW	CTW	CTW	λ 20-35°		
旋向(切削方向)		R	R	R	R	R	R	R	R	R	R		
冷却液 (CSP)													
		CDX	CDX	FORCE X	FORCE X	FORCE X	FORCE X	FORCE X	FORCE M	FORCE M			
产品系列代码		R520	R510	R458	R457	R454	R453	R459	R467	R463	R7131		
PSF切削直径范围		3.00 - 16.50	3.00 - 14.00	3.00 - 20.00	3.00 - 20.00	3.00 - 20.00	3.00 - 20.00	3.00 - 16.00	3.00 - 16.00	3.00 - 16.00	3.30 - 10.40		
		188	190	191	195	199	203	207	210	213	216		
P	P1	■	■	■	■	■	■	■			■		
	P2	■	■	■	■	■	■	■			■		
	P3	■	■	■	■	■	■	■			■		
	P4	■	■	■	■	■	■	■			■		
M	M1	◪	◪	◪	◪	◪	◪	◪	■	■	■		
	M2	◪	◪	◪	◪	◪	◪	◪	■	■	■		
	M3			◪	◪	◪	◪	◪	■	■	■		
	M4			◪	◪	◪	◪	◪	■	■	■		
K	K1	■	■	■	■	■	■	■			■		
	K2	■	■	■	■	■	■	■			■		
	K3	■	■	■	■	■	■	■			■		
	K4	■	■	■	■	■	■	■			■		
	K5	■	■	■	■	■	■	■			■		
N	N1	■	■	■	■	■	■	◪			■		
	N2	■	■	■	■	■	■	■			■		
	N3			■	■	■	■	◪			■		
	N4	■	■										
	N5												
S	S1	◪	◪	◪	■	◪	■		■	■			
	S2								◪	◪			
	S3								◪	◪			
	S4								◪	◪			
H	H1	◪	◪	■	■	■	■						
	H2	◪	◪	◪	◪	◪	◪						
	H3	◪	◪	◪	◪	◪	◪						
	H4												

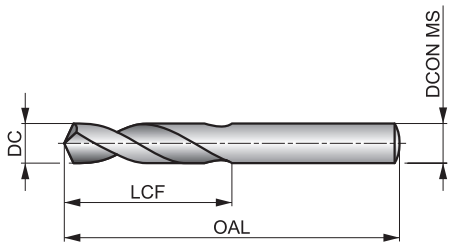
■推荐使用 ◪可以使用

R520

DORMER

CDX短型合金钻头，氮化钛涂层。
高性能短型钻头，能够高转速高进给地加工高质量和高精度的孔(H9公差)，130°钻尖角有助于自定心并减小切削力，氮化钛涂层提高了切削性能并延长了刀具寿命，适用于所有数控机床以及多种材料。

CDX



HM	DIN 6539	2.5×D
130°	TiN	
λ20-35°	R	DC h7

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■119 X	■134 X	■138 X	■102 X	■90 X	■80 X	■81 X	■65 X	■55 X	■48 X	■41 X	■34 W	◪69 W	◪58 W
M2.1	M2.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3
◪61 W	◪50 W	■90 Y	■67 Y	■50 Y	■80 X	■65 X	■52 X	■71 X	■54 X	■44 X	■66 X	■49 X	■36 X
K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N4.1	N4.2	S1.1
■31 X	■26 X	■74 X	■56 X	■43 X	■225 Z	■169 Z	■113 Z	■231 Y	■208 Y	■150 Y	■75 Z	■115 V	◪60 W
S1.2	S1.3	H1.1	H2.1	H2.2	H3.1	H3.2							
◪45 V	◪35 U	◪65 U	◪38 U	◪36 T	◪43 U	◪35 U							

DCON MS公差h7

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R5203.0	–	3.00	0.1181	16.0	46.0	3.00
R5203.1	–	3.10	0.1220	18.0	49.0	3.10
R5201/8	1/8	3.18	0.1250	18.0	49.0	3.18
R5203.2	–	3.20	0.1260	18.0	49.0	3.20
R5203.3	–	3.30	0.1299	18.0	49.0	3.30
R5203.4	–	3.40	0.1339	20.0	52.0	3.40
R5203.5	–	3.50	0.1378	20.0	52.0	3.50
R5203.6	–	3.60	0.1417	20.0	52.0	3.60
R5203.7	–	3.70	0.1457	20.0	52.0	3.70
R5203.8	–	3.80	0.1496	22.0	55.0	3.80
R5203.9	–	3.90	0.1535	22.0	55.0	3.90
R5204.0	–	4.00	0.1575	22.0	55.0	4.00
R5204.1	–	4.10	0.1614	22.0	55.0	4.10
R5204.2	–	4.20	0.1654	22.0	55.0	4.20
R5204.3	–	4.30	0.1693	24.0	58.0	4.30
R5204.4	–	4.40	0.1732	24.0	58.0	4.40
R5204.5	–	4.50	0.1772	24.0	58.0	4.50
R5204.6	–	4.60	0.1811	24.0	58.0	4.60
R5204.7	–	4.70	0.1850	24.0	58.0	4.70
R5204.8	–	4.80	0.1890	26.0	62.0	4.80
R5204.9	–	4.90	0.1929	26.0	62.0	4.90
R5205.0	–	5.00	0.1969	26.0	62.0	5.00
R5205.1	–	5.10	0.2008	26.0	62.0	5.10
R5205.2	–	5.20	0.2047	26.0	62.0	5.20
R5205.3	–	5.30	0.2087	26.0	62.0	5.30

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R5205.4	–	5.40	0.2126	28.0	66.0	5.40
R5205.5	–	5.50	0.2165	28.0	66.0	5.50
R5205.6	–	5.60	0.2205	28.0	66.0	5.60
R5205.8	–	5.80	0.2283	28.0	66.0	5.80
R5205.9	–	5.90	0.2323	28.0	66.0	5.90
R5206.0	–	6.00	0.2362	28.0	66.0	6.00
R5206.1	–	6.10	0.2402	31.0	70.0	6.10
R5206.2	–	6.20	0.2441	31.0	70.0	6.20
R5206.3	–	6.30	0.2480	31.0	70.0	6.30
R5201/4	1/4	6.35	0.2500	31.0	70.0	6.35
R5206.4	–	6.40	0.2520	31.0	70.0	6.40
R5206.5	–	6.50	0.2559	31.0	70.0	6.50
R5206.6	–	6.60	0.2598	31.0	70.0	6.60
R5206.7	–	6.70	0.2638	31.0	70.0	6.70
R5206.8	–	6.80	0.2677	34.0	74.0	6.80
R5206.9	–	6.90	0.2717	34.0	74.0	6.90
R5207.0	–	7.00	0.2756	34.0	74.0	7.00
R5207.1	–	7.10	0.2795	34.0	74.0	7.10
R5207.2	–	7.20	0.2835	34.0	74.0	7.20
R5207.3	–	7.30	0.2874	34.0	74.0	7.30
R5207.4	–	7.40	0.2913	34.0	74.0	7.40
R5207.5	–	7.50	0.2953	34.0	74.0	7.50
R5207.6	–	7.60	0.2992	37.0	79.0	7.60
R5207.7	–	7.70	0.3031	37.0	79.0	7.70
R5207.8	–	7.80	0.3071	37.0	79.0	7.80

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
R5205/16	5/16	7.94	0.3126	37.0	79.0	7.94
R5208.0	–	8.00	0.3150	37.0	79.0	8.00
R5208.1	–	8.10	0.3189	37.0	79.0	8.10
R5208.2	–	8.20	0.3228	37.0	79.0	8.20
R5208.3	–	8.30	0.3268	37.0	79.0	8.30
R5208.4	–	8.40	0.3307	37.0	79.0	8.40
R5208.5	–	8.50	0.3346	37.0	79.0	8.50
R5208.6	–	8.60	0.3386	40.0	84.0	8.60
R5208.7	–	8.70	0.3425	40.0	84.0	8.70
R5208.8	–	8.80	0.3465	40.0	84.0	8.80
R5209.0	–	9.00	0.3543	40.0	84.0	9.00
R5209.1	–	9.10	0.3583	40.0	84.0	9.10
R5209.3	–	9.30	0.3661	40.0	84.0	9.30
R5209.5	–	9.50	0.3740	40.0	84.0	9.50
R5203/8	3/8	9.52	0.3748	43.0	89.0	9.52
R5209.6	–	9.60	0.3780	43.0	89.0	9.60
R5209.7	–	9.70	0.3819	43.0	89.0	9.70
R5209.8	–	9.80	0.3858	43.0	89.0	9.80
R52010.0	–	10.00	0.3937	43.0	89.0	10.00
R52010.1	–	10.10	0.3976	43.0	89.0	10.10
R52010.2	–	10.20	0.4016	43.0	89.0	10.20

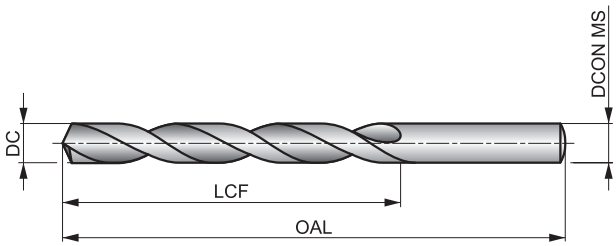
Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
R52010.3	–	10.30	0.4055	43.0	89.0	10.30
R52010.4	–	10.40	0.4094	43.0	89.0	10.40
R52010.5	–	10.50	0.4134	43.0	89.0	10.50
R52011.0	–	11.00	0.4331	47.0	95.0	11.00
R5207/16	7/16	11.11	0.4374	47.0	95.0	11.11
R52011.2	–	11.20	0.4409	47.0	95.0	11.20
R52011.5	–	11.50	0.4528	47.0	95.0	11.50
R52012.0	–	12.00	0.4724	51.0	102.0	12.00
R52012.5	–	12.50	0.4921	51.0	102.0	12.50
R5201/2	1/2	12.70	0.5000	51.0	102.0	12.70
R52013.0	–	13.00	0.5118	51.0	102.0	13.00
R52013.5	–	13.50	0.5315	54.0	107.0	13.50
R52014.0	–	14.00	0.5512	54.0	107.0	14.00
R52014.2	–	14.20	0.5591	56.0	111.0	14.20
R52014.25	–	14.25	0.5610	56.0	111.0	14.25
R52014.5	–	14.50	0.5709	56.0	111.0	14.50
R52015.0	–	15.00	0.5906	56.0	111.0	15.00
R52015.1	–	15.10	0.5945	58.0	115.0	15.10
R5205/8	5/8	15.88	0.6252	58.0	115.0	15.88
R52016.0	–	16.00	0.6299	58.0	115.0	16.00
R52016.5	–	16.50	0.6496	60.0	119.0	16.50

R510

DORMER

CDX普通长度合金钻头，氮化钛涂层。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(H8公差)，130°钻尖角有助于自定心并减小切削力，氮化钛涂层提高了切削性能并延长了刀具寿命，适用于多种材料的切削。

CDX



HM	DIN 338	4×D
130°	TiN	
λ20-35°	R	DC h7

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■119 W	■134 W	■138 W	■102 W	■90 W	■80 V	■81 W	■65 W	■55 V	■48 W	■41 V	■34 V	◪69 V	◪58 V
M2.1	M2.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3
◪61 V	◪50 V	■90 X	■67 X	■50 X	■80 W	■65 W	■52 W	■71 W	■54 W	■44 W	■66 W	■49 W	■36 W
K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N4.1	N4.2	S1.1
■31 W	■26 W	■74 W	■56 W	■43 W	■225 Y	■169 Y	■113 Y	■231 X	■208 X	■150 X	■75 X	■115 V	◪45 V
H1.1	H2.1	H2.2	H3.1	H3.2									
◪65 T	◪38 T	◪36 S	◪43 T	◪35 T									

DCON MS公差h7

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R5103.0	–	3.00	0.1181	33.0	61.0	3.00
R5101/8	1/8	3.18	0.1250	36.0	65.0	3.18
R5103.2	–	3.20	0.1260	36.0	65.0	3.20
R5103.3	–	3.30	0.1299	36.0	65.0	3.30
R5103.4	–	3.40	0.1339	39.0	70.0	3.40
R5103.5	–	3.50	0.1378	39.0	70.0	3.50
R5103.7	–	3.70	0.1457	39.0	70.0	3.70
R5103.9	–	3.90	0.1535	43.0	75.0	3.90
R5104.0	–	4.00	0.1575	43.0	75.0	4.00
R5104.1	–	4.10	0.1614	43.0	75.0	4.10
R5104.2	–	4.20	0.1654	43.0	75.0	4.20
R5104.3	–	4.30	0.1693	47.0	80.0	4.30
R5104.5	–	4.50	0.1772	47.0	80.0	4.50
R5104.7	–	4.70	0.1850	47.0	80.0	4.70
R5103/16	3/16	4.76	0.1874	52.0	86.0	4.76
R5104.9	–	4.90	0.1929	52.0	86.0	4.90
R5105.0	–	5.00	0.1969	52.0	86.0	5.00
R5105.1	–	5.10	0.2008	52.0	86.0	5.10
R5105.5	–	5.50	0.2165	57.0	93.0	5.50
R5105.6	–	5.60	0.2205	57.0	93.0	5.60
R5105.7	–	5.70	0.2244	57.0	93.0	5.70
R5106.0	–	6.00	0.2362	57.0	93.0	6.00
R5101/4	1/4	6.35	0.2500	63.0	101.0	6.35
R5106.5	–	6.50	0.2559	63.0	101.0	6.50
R5106.6	–	6.60	0.2598	63.0	101.0	6.60
R5106.8	–	6.80	0.2677	69.0	109.0	6.80
R5107.0	–	7.00	0.2756	69.0	109.0	7.00
R5107.3	–	7.30	0.2874	69.0	109.0	7.30

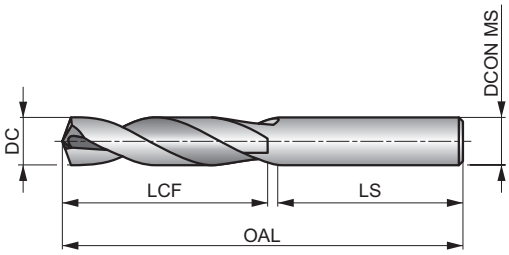
Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R5107.4	–	7.40	0.2913	69.0	109.0	7.40
R5107.5	–	7.50	0.2953	69.0	109.0	7.50
R5107.8	–	7.80	0.3071	75.0	117.0	7.80
R5105/16	5/16	7.94	0.3126	75.0	117.0	7.94
R5108.0	–	8.00	0.3150	75.0	117.0	8.00
R5108.5	–	8.50	0.3346	75.0	117.0	8.50
R5108.7	–	8.70	0.3425	81.0	125.0	8.70
R5108.8	–	8.80	0.3465	81.0	125.0	8.80
R5109.0	–	9.00	0.3543	81.0	125.0	9.00
R5109.2	–	9.20	0.3622	81.0	125.0	9.20
R5109.3	–	9.30	0.3661	81.0	125.0	9.30
R5109.5	–	9.50	0.3740	81.0	125.0	9.50
R5103/8	3/8	9.52	0.3748	87.0	133.0	9.52
R5109.9	–	9.90	0.3898	87.0	133.0	9.90
R51010.0	–	10.00	0.3937	87.0	133.0	10.00
R51010.2	–	10.20	0.4016	87.0	133.0	10.20
R51010.3	–	10.30	0.4055	87.0	133.0	10.30
R51010.4	–	10.40	0.4094	87.0	133.0	10.40
R51010.5	–	10.50	0.4134	87.0	133.0	10.50
R51010.8	–	10.80	0.4252	94.0	142.0	10.80
R51011.0	–	11.00	0.4331	94.0	142.0	11.00
R5107/16	7/16	11.11	0.4374	94.0	142.0	11.11
R51011.2	–	11.20	0.4409	94.0	142.0	11.20
R51011.5	–	11.50	0.4528	94.0	142.0	11.50
R51012.0	–	12.00	0.4724	101.0	151.0	12.00
R5101/2	1/2	12.70	0.5000	101.0	151.0	12.70
R51013.0	–	13.00	0.5118	101.0	151.0	13.00
R51014.0	–	14.00	0.5512	108.0	160.0	14.00

R458

DORMER

Force X 3倍径合金钻，氮铝化钛涂层。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(H9公差)，自定心的140°钻尖角、四后面的分离式钻尖以及CTW槽型增强了穿透力，氮铝化钛涂层提高了表面硬度并延长了刀具寿命。

FORCE X



HM	DIN 6537K	3×D
140°	TiAlN	DIN 6535HA
CTW	R	DC m7

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
143 W	160 W	166 W	122 W	108 W	95 V	106 V	86 V	72 V	63 V	54 V	44 U	60 U	51 U
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
54 U	44 U	37 T	33 T	28 T	26 T	24 T	21 T	88 W	65 W	49 W	78 V	64 V	51 V
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
70 V	54 V	43 V	65 V	49 V	36 V	30 V	26 V	73 V	55 V	42 V	200 W	150 W	100 W
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**S1.1**	**S1.2**	**S1.3**	**H1.1**	**H2.1**	**H2.2**	**H3.1**	**H3.2**
246 V	222 V	160 V	298 V	176 V	88 V	44 U	36 U	32 T	45 U	26 U	24 U	30 U	24 U

DCON MS公差h6

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
R4583.0	–	3.00	0.1181	20.0	62.0	36.0	6.00
R4583.1	–	3.10	0.1220	20.0	62.0	36.0	6.00
R4581/8	1/8	3.18	0.1250	20.0	62.0	36.0	6.00
R4583.2	–	3.20	0.1260	20.0	62.0	36.0	6.00
R458N30	N30	3.26	0.1283	20.0	62.0	36.0	6.00
R4583.3	–	3.30	0.1299	20.0	62.0	36.0	6.00
R4583.4	–	3.40	0.1339	20.0	62.0	36.0	6.00
R458N29	N29	3.45	0.1360	20.0	62.0	36.0	6.00
R4583.5	–	3.50	0.1378	20.0	62.0	36.0	6.00
R458N28	N28	3.57	0.1406	20.0	62.0	36.0	6.00
R4589/64	9/64	3.57	0.1406	20.0	62.0	36.0	6.00
R4583.6	–	3.60	0.1417	20.0	62.0	36.0	6.00
R458N27	N27	3.66	0.1441	20.0	62.0	36.0	6.00
R4583.7	–	3.70	0.1457	20.0	62.0	36.0	6.00
R4583.73	–	3.73	0.1469	24.0	66.0	36.0	6.00
R458N26	N26	3.73	0.1469	24.0	66.0	36.0	6.00
R458N25	N25	3.80	0.1496	24.0	66.0	36.0	6.00
R4583.8	–	3.80	0.1496	24.0	66.0	36.0	6.00
R458N24	N24	3.86	0.1520	24.0	66.0	36.0	6.00
R4583.9	–	3.90	0.1535	24.0	66.0	36.0	6.00
R458N23	N23	3.91	0.1539	24.0	66.0	36.0	6.00
R4585/32	5/32	3.97	0.1563	24.0	66.0	36.0	6.00
R458N22	N22	3.99	0.1571	24.0	66.0	36.0	6.00
R4584.0	–	4.00	0.1575	24.0	66.0	36.0	6.00
R458N21	N21	4.04	0.1591	24.0	66.0	36.0	6.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R458N20	N20	4.09	0.1610	24.0	66.0	36.0	6.00
R4584.1	–	4.10	0.1614	24.0	66.0	36.0	6.00
R4584.2	–	4.20	0.1654	24.0	66.0	36.0	6.00
R458N19	N19	4.22	0.1661	24.0	66.0	36.0	6.00
R4584.3	–	4.30	0.1693	24.0	66.0	36.0	6.00
R458N18	N18	4.31	0.1697	24.0	66.0	36.0	6.00
R45811/64	11/64	4.37	0.1719	24.0	66.0	36.0	6.00
R458N17	N17	4.39	0.1728	24.0	66.0	36.0	6.00
R4584.4	–	4.40	0.1732	24.0	66.0	36.0	6.00
R4584.5	–	4.50	0.1772	24.0	66.0	36.0	6.00
R458N16	N16	4.50	0.1772	24.0	66.0	36.0	6.00
R458N15	N15	4.57	0.1799	24.0	66.0	36.0	6.00
R4584.6	–	4.60	0.1811	24.0	66.0	36.0	6.00
R458N14	N14	4.62	0.1819	24.0	66.0	36.0	6.00
R458N13	N13	4.70	0.1850	24.0	66.0	36.0	6.00
R4584.7	–	4.70	0.1850	24.0	66.0	36.0	6.00
R4583/16	3/16	4.76	0.1875	28.0	66.0	36.0	6.00
R4584.8	–	4.80	0.1890	28.0	66.0	36.0	6.00
R458N12	N12	4.80	0.1890	28.0	66.0	36.0	6.00
R458N11	N11	4.85	0.1909	28.0	66.0	36.0	6.00
R4584.9	–	4.90	0.1929	28.0	66.0	36.0	6.00
R458N10	N10	4.92	0.1937	28.0	66.0	36.0	6.00
R458N9	N9	4.98	0.1961	28.0	66.0	36.0	6.00
R4585.0	–	5.00	0.1969	28.0	66.0	36.0	6.00
R458N8	N8	5.06	0.1992	28.0	66.0	36.0	6.00
R4585.1	–	5.10	0.2008	28.0	66.0	36.0	6.00
R458N7	N7	5.11	0.2010	28.0	66.0	36.0	6.00
R45813/64	13/64	5.16	0.2031	28.0	66.0	36.0	6.00
R458N6	N6	5.18	0.2039	28.0	66.0	36.0	6.00
R4585.2	–	5.20	0.2047	28.0	66.0	36.0	6.00
R458N5	N5	5.22	0.2055	28.0	66.0	36.0	6.00
R4585.3	–	5.30	0.2087	28.0	66.0	36.0	6.00
R458N4	N4	5.31	0.2091	28.0	66.0	36.0	6.00
R4585.4	–	5.40	0.2126	28.0	66.0	36.0	6.00
R458N3	N3	5.41	0.2130	28.0	66.0	36.0	6.00
R4585.5	–	5.50	0.2165	28.0	66.0	36.0	6.00
R4587/32	7/32	5.56	0.2188	28.0	66.0	36.0	6.00
R4585.6	–	5.60	0.2205	28.0	66.0	36.0	6.00
R458N2	N2	5.61	0.2209	28.0	66.0	36.0	6.00
R4585.7	–	5.70	0.2244	28.0	66.0	36.0	6.00
R458N1	N1	5.79	0.2280	28.0	66.0	36.0	6.00
R4585.8	–	5.80	0.2283	28.0	66.0	36.0	6.00
R4585.9	–	5.90	0.2323	28.0	66.0	36.0	6.00
R45815/64	15/64	5.95	0.2344	28.0	66.0	36.0	6.00
R4586.0	–	6.00	0.2362	28.0	66.0	36.0	6.00
R458B	B	6.05	0.2380	34.0	79.0	36.0	8.00
R4586.1	–	6.10	0.2402	34.0	79.0	36.0	8.00
R458C	C	6.15	0.2421	34.0	79.0	36.0	8.00
R4586.2	–	6.20	0.2441	34.0	79.0	36.0	8.00
R458D	D	6.25	0.2461	34.0	79.0	36.0	8.00
R4586.3	–	6.30	0.2480	34.0	79.0	36.0	8.00
R4581/4	1/4	6.35	0.2500	34.0	79.0	36.0	8.00
R4586.4	–	6.40	0.2520	34.0	79.0	36.0	8.00
R4586.5	–	6.50	0.2559	34.0	79.0	36.0	8.00
R458F	F	6.53	0.2571	34.0	79.0	36.0	8.00
R4586.6	–	6.60	0.2598	34.0	79.0	36.0	8.00
R458G	G	6.63	0.2610	34.0	79.0	36.0	8.00
R4586.7	–	6.70	0.2638	34.0	79.0	36.0	8.00
R45817/64	17/64	6.75	0.2656	34.0	79.0	36.0	8.00
R458H	H	6.76	0.2661	34.0	79.0	36.0	8.00
R4586.8	–	6.80	0.2677	34.0	79.0	36.0	8.00
R4586.9	–	6.90	0.2717	34.0	79.0	36.0	8.00

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
R458I	I	6.91	0.2720	34.0	79.0	36.0	8.00
R4587.0	–	7.00	0.2756	34.0	79.0	36.0	8.00
R458J	J	7.04	0.2772	34.0	79.0	36.0	8.00
R4587.1	–	7.10	0.2795	41.0	79.0	36.0	8.00
R4589/32	9/32	7.14	0.2813	41.0	79.0	36.0	8.00
R4587.2	–	7.20	0.2835	41.0	79.0	36.0	8.00
R4587.3	–	7.30	0.2874	41.0	79.0	36.0	8.00
R458L	L	7.37	0.2902	41.0	79.0	36.0	8.00
R4587.4	–	7.40	0.2913	41.0	79.0	36.0	8.00
R4587.5	–	7.50	0.2953	41.0	79.0	36.0	8.00
R45819/64	19/64	7.54	0.2969	41.0	79.0	36.0	8.00
R4587.6	–	7.60	0.2992	41.0	79.0	36.0	8.00
R458N	N	7.67	0.3020	41.0	79.0	36.0	8.00
R4587.7	–	7.70	0.3031	41.0	79.0	36.0	8.00
R4587.8	–	7.80	0.3071	41.0	79.0	36.0	8.00
R4587.9	–	7.90	0.3110	41.0	79.0	36.0	8.00
R4585/16	5/16	7.94	0.3125	41.0	79.0	36.0	8.00
R4588.0	–	8.00	0.3150	41.0	79.0	36.0	8.00
R458O	O	8.03	0.3161	47.0	89.0	40.0	10.00
R4588.1	–	8.10	0.3189	47.0	89.0	40.0	10.00
R4588.2	–	8.20	0.3228	47.0	89.0	40.0	10.00
R4588.3	–	8.30	0.3268	47.0	89.0	40.0	10.00
R45821/64	21/64	8.33	0.3281	47.0	89.0	40.0	10.00
R4588.4	–	8.40	0.3307	47.0	89.0	40.0	10.00
R458Q	Q	8.43	0.3319	47.0	89.0	40.0	10.00
R4588.5	–	8.50	0.3346	47.0	89.0	40.0	10.00
R4588.6	–	8.60	0.3386	47.0	89.0	40.0	10.00
R458R	R	8.61	0.3390	47.0	89.0	40.0	10.00
R4588.7	–	8.70	0.3425	47.0	89.0	40.0	10.00
R45811/32	11/32	8.73	0.3438	47.0	89.0	40.0	10.00
R4588.8	–	8.80	0.3465	47.0	89.0	40.0	10.00
R458S	S	8.84	0.3480	47.0	89.0	40.0	10.00
R4588.9	–	8.90	0.3504	47.0	89.0	40.0	10.00
R4589.0	–	9.00	0.3543	47.0	89.0	40.0	10.00
R458T	T	9.09	0.3579	47.0	89.0	40.0	10.00
R4589.1	–	9.10	0.3583	47.0	89.0	40.0	10.00
R45823/64	23/64	9.13	0.3594	47.0	89.0	40.0	10.00
R4589.2	–	9.20	0.3622	47.0	89.0	40.0	10.00
R4589.3	–	9.30	0.3661	47.0	89.0	40.0	10.00
R458U	U	9.35	0.3681	47.0	89.0	40.0	10.00
R4589.4	–	9.40	0.3701	47.0	89.0	40.0	10.00
R4589.5	–	9.50	0.3740	47.0	89.0	40.0	10.00
R4583/8	3/8	9.53	0.3750	47.0	89.0	40.0	10.00
R458V	V	9.58	0.3772	47.0	89.0	40.0	10.00
R4589.6	–	9.60	0.3780	47.0	89.0	40.0	10.00
R4589.7	–	9.70	0.3819	47.0	89.0	40.0	10.00
R4589.8	–	9.80	0.3858	47.0	89.0	40.0	10.00
R4589.9	–	9.90	0.3898	47.0	89.0	40.0	10.00
R45825/64	25/64	9.92	0.3906	47.0	89.0	40.0	10.00
R45810.0	–	10.00	0.3937	47.0	89.0	40.0	10.00
R458X	X	10.08	0.3969	55.0	102.0	45.0	12.00
R45810.1	–	10.10	0.3976	55.0	102.0	45.0	12.00
R45810.2	–	10.20	0.4016	55.0	102.0	45.0	12.00
R458Y	Y	10.26	0.4039	55.0	102.0	45.0	12.00
R45810.3	–	10.30	0.4055	55.0	102.0	45.0	12.00
R45813/32	13/32	10.32	0.4063	55.0	102.0	45.0	12.00
R45810.4	–	10.40	0.4094	55.0	102.0	45.0	12.00
R45810.5	–	10.50	0.4134	55.0	102.0	45.0	12.00
R45810.6	–	10.60	0.4173	55.0	102.0	45.0	12.00
R45810.7	–	10.70	0.4213	55.0	102.0	45.0	12.00
R45827/64	27/64	10.72	0.4219	55.0	102.0	45.0	12.00
R45810.8	–	10.80	0.4252	55.0	102.0	45.0	12.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R45810.9	–	10.90	0.4291	55.0	102.0	45.0	12.00
R45811.0	–	11.00	0.4331	55.0	102.0	45.0	12.00
R45811.1	–	11.10	0.4370	55.0	102.0	45.0	12.00
R4587/16	7/16	11.11	0.4375	55.0	102.0	45.0	12.00
R45811.2	–	11.20	0.4409	55.0	102.0	45.0	12.00
R45811.3	–	11.30	0.4449	55.0	102.0	45.0	12.00
R45811.4	–	11.40	0.4488	55.0	102.0	45.0	12.00
R45811.5	–	11.50	0.4528	55.0	102.0	45.0	12.00
R45829/64	29/64	11.51	0.4531	55.0	102.0	45.0	12.00
R45811.6	–	11.60	0.4567	55.0	102.0	45.0	12.00
R45811.7	–	11.70	0.4606	55.0	102.0	45.0	12.00
R45811.8	–	11.80	0.4646	55.0	102.0	45.0	12.00
R45811.9	–	11.90	0.4685	55.0	102.0	45.0	12.00
R45815/32	15/32	11.91	0.4688	55.0	102.0	45.0	12.00
R45812.0	–	12.00	0.4724	55.0	102.0	45.0	12.00
R45812.1	–	12.10	0.4764	60.0	107.0	45.0	14.00
R45812.2	–	12.20	0.4803	60.0	107.0	45.0	14.00
R45831/64	31/64	12.30	0.4844	60.0	107.0	45.0	14.00
R45812.5	–	12.50	0.4921	60.0	107.0	45.0	14.00
R45812.7	–	12.70	0.5000	60.0	107.0	45.0	14.00
R4581/2	1/2	12.70	0.5000	60.0	107.0	45.0	14.00
R45812.8	–	12.80	0.5039	60.0	107.0	45.0	14.00
R45813.0	–	13.00	0.5118	60.0	107.0	45.0	14.00
R45833/64	33/64	13.10	0.5156	60.0	107.0	45.0	14.00
R45813.3	–	13.30	0.5236	60.0	107.0	45.0	14.00
R45817/32	17/32	13.49	0.5313	60.0	107.0	45.0	14.00
R45813.5	–	13.50	0.5315	60.0	107.0	45.0	14.00
R45813.8	–	13.80	0.5433	60.0	107.0	45.0	14.00
R45835/64	35/64	13.89	0.5469	60.0	107.0	45.0	14.00
R45814.0	–	14.00	0.5512	60.0	107.0	45.0	14.00
R45814.25	–	14.25	0.5610	65.0	115.0	48.0	16.00
R4589/16	9/16	14.29	0.5625	65.0	115.0	48.0	16.00
R45814.5	–	14.50	0.5709	65.0	115.0	48.0	16.00
R45837/64	37/64	14.68	0.5781	65.0	115.0	48.0	16.00
R45814.8	–	14.80	0.5827	65.0	115.0	48.0	16.00
R45815.0	–	15.00	0.5906	65.0	115.0	48.0	16.00
R45819/32	19/32	15.08	0.5938	65.0	115.0	48.0	16.00
R45815.1	–	15.10	0.5945	65.0	115.0	48.0	16.00
R45815.3	–	15.30	0.6024	65.0	115.0	48.0	16.00
R45839/64	39/64	15.48	0.6094	65.0	115.0	48.0	16.00
R45815.5	–	15.50	0.6102	65.0	115.0	48.0	16.00
R45815.8	–	15.80	0.6220	65.0	115.0	48.0	16.00
R4585/8	5/8	15.88	0.6250	65.0	115.0	48.0	16.00
R45816.0	–	16.00	0.6299	65.0	115.0	48.0	16.00
R45841/64	41/64	16.27	0.6406	73.0	123.0	48.0	18.00
R45816.5	–	16.50	0.6496	73.0	123.0	48.0	18.00
R45821/32	21/32	16.67	0.6563	73.0	123.0	48.0	18.00
R45817.0	–	17.00	0.6693	73.0	123.0	48.0	18.00
R45843/64	43/64	17.07	0.6720	73.0	123.0	48.0	18.00
R45811/16	11/16	17.46	0.6874	73.0	123.0	48.0	18.00
R45817.5	–	17.50	0.6890	73.0	123.0	48.0	18.00
R45817.8	–	17.80	0.7008	73.0	123.0	48.0	18.00
R45845/64	45/64	17.86	0.7031	73.0	123.0	48.0	18.00
R45818.0	–	18.00	0.7087	73.0	123.0	48.0	18.00
R45823/32	23/32	18.26	0.7189	79.0	131.0	50.0	20.00
R45818.5	–	18.50	0.7283	79.0	131.0	50.0	20.00
R45847/64	47/64	18.65	0.7343	79.0	131.0	50.0	20.00
R45819.0	–	19.00	0.7480	79.0	131.0	50.0	20.00
R4583/4	–	19.05	0.7500	79.0	131.0	50.0	20.00
R45819.5	–	19.50	0.7677	79.0	131.0	50.0	20.00
R45819.8	–	19.80	0.7795	79.0	131.0	50.0	20.00
R45820.0	–	20.00	0.7874	79.0	131.0	50.0	20.00

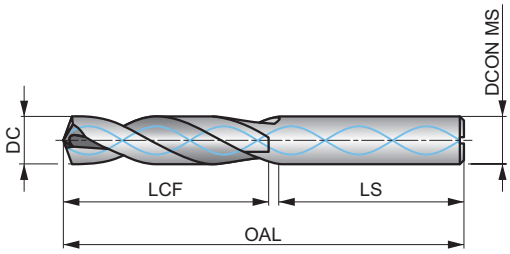
R457

DORMER

Force X 3倍径内冷合金钻，氮铝化钛涂层。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(H9公差)，自定心的140°钻尖角、四后面的分离式钻尖以及CTW槽型增强了穿透力，内冷孔提高了排屑能力，氮铝化钛涂层提高了表面硬度并延长了刀具寿命。

FORCE X

HM	DIN 6537K	3×D
140°	TiAlN	DIN 6535HA
CTW	R	
DC m7		



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
179 W	200 W	207 W	153 W	135 W	119 V	133 V	107 V	90 V	79 V	67 V	55 U	75 V	64 V
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
67 V	55 V	46 U	41 V	35 V	32 V	30 U	26 U	110 W	81 W	61 W	98 V	80 V	64 V
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
87 V	67 V	54 V	81 V	61 V	45 V	38 V	32 V	91 V	69 V	53 V	250 W	188 W	125 W
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**S1.1**	**S1.2**	**S1.3**	**H1.1**	**H2.1**	**H2.2**	**H3.1**	**H3.2**
308 V	277 V	200 V	373 W	220 W	110 W	55 V	45 V	40 U	56 U	33 U	30 U	37 U	30 U

DCON MS公差h6

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
R4573.0	–	3.00	0.1181	20.0	62.0	36.0	6.00
R4573.1	–	3.10	0.1220	20.0	62.0	36.0	6.00
R4571/8	1/8	3.18	0.1250	20.0	62.0	36.0	6.00
R4573.2	–	3.20	0.1260	20.0	62.0	36.0	6.00
R457N30	N30	3.26	0.1283	20.0	62.0	36.0	6.00
R4573.3	–	3.30	0.1299	20.0	62.0	36.0	6.00
R4573.4	–	3.40	0.1339	20.0	62.0	36.0	6.00
R457N29	N29	3.45	0.1360	20.0	62.0	36.0	6.00
R4573.5	–	3.50	0.1378	20.0	62.0	36.0	6.00
R457N28	N28	3.57	0.1406	20.0	62.0	36.0	6.00
R4579/64	9/64	3.57	0.1406	20.0	62.0	36.0	6.00
R4573.6	–	3.60	0.1417	20.0	62.0	36.0	6.00
R457N27	N27	3.66	0.1441	20.0	62.0	36.0	6.00
R4573.7	–	3.70	0.1457	20.0	62.0	36.0	6.00
R457N26	N26	3.73	0.1469	24.0	66.0	36.0	6.00
R457N25	N25	3.80	0.1496	24.0	66.0	36.0	6.00
R4573.8	–	3.80	0.1496	24.0	66.0	36.0	6.00
R457N24	N24	3.86	0.1520	24.0	66.0	36.0	6.00
R4573.9	–	3.90	0.1535	24.0	66.0	36.0	6.00
R457N23	N23	3.91	0.1539	24.0	66.0	36.0	6.00
R4575/32	5/32	3.97	0.1563	24.0	66.0	36.0	6.00
R457N22	N22	3.99	0.1571	24.0	66.0	36.0	6.00
R4574.0	–	4.00	0.1575	24.0	66.0	36.0	6.00
R457N21	N21	4.04	0.1591	24.0	66.0	36.0	6.00
R4574.05	–	4.05	0.1594	24.0	66.0	36.0	6.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R457N20	N20	4.09	0.1610	24.0	66.0	36.0	6.00
R4574.1	–	4.10	0.1614	24.0	66.0	36.0	6.00
R4574.2	–	4.20	0.1654	24.0	66.0	36.0	6.00
R4574.3	–	4.30	0.1693	24.0	66.0	36.0	6.00
R457N18	N18	4.31	0.1697	24.0	66.0	36.0	6.00
R45711/64	11/64	4.37	0.1719	24.0	66.0	36.0	6.00
R457N17	N17	4.39	0.1728	24.0	66.0	36.0	6.00
R4574.4	–	4.40	0.1732	24.0	66.0	36.0	6.00
R4574.5	–	4.50	0.1772	24.0	66.0	36.0	6.00
R457N16	N16	4.50	0.1772	24.0	66.0	36.0	6.00
R457N15	N15	4.57	0.1799	24.0	66.0	36.0	6.00
R4574.6	–	4.60	0.1811	24.0	66.0	36.0	6.00
R457N14	N14	4.62	0.1819	24.0	66.0	36.0	6.00
R4574.7	–	4.70	0.1850	24.0	66.0	36.0	6.00
R4573/16	3/16	4.76	0.1875	28.0	66.0	36.0	6.00
R4574.8	–	4.80	0.1890	28.0	66.0	36.0	6.00
R457N11	N11	4.85	0.1909	28.0	66.0	36.0	6.00
R4574.9	–	4.90	0.1929	28.0	66.0	36.0	6.00
R457N9	N9	4.98	0.1961	28.0	66.0	36.0	6.00
R4575.0	–	5.00	0.1969	28.0	66.0	36.0	6.00
R4575.05	–	5.05	0.1988	28.0	66.0	36.0	6.00
R457N8	N8	5.06	0.1992	28.0	66.0	36.0	6.00
R4575.1	–	5.10	0.2008	28.0	66.0	36.0	6.00
R457N7	N7	5.11	0.2010	28.0	66.0	36.0	6.00
R45713/64	13/64	5.16	0.2031	28.0	66.0	36.0	6.00
R457N6	N6	5.18	0.2039	28.0	66.0	36.0	6.00
R4575.2	–	5.20	0.2047	28.0	66.0	36.0	6.00
R457N5	N5	5.22	0.2055	28.0	66.0	36.0	6.00
R4575.3	–	5.30	0.2087	28.0	66.0	36.0	6.00
R457N4	N4	5.31	0.2091	28.0	66.0	36.0	6.00
R4575.4	–	5.40	0.2126	28.0	66.0	36.0	6.00
R457N3	N3	5.41	0.2130	28.0	66.0	36.0	6.00
R4575.5	–	5.50	0.2165	28.0	66.0	36.0	6.00
R4577/32	7/32	5.56	0.2188	28.0	66.0	36.0	6.00
R4575.6	–	5.60	0.2205	28.0	66.0	36.0	6.00
R457N2	N2	5.61	0.2209	28.0	66.0	36.0	6.00
R4575.7	–	5.70	0.2244	28.0	66.0	36.0	6.00
R457N1	N1	5.79	0.2280	28.0	66.0	36.0	6.00
R4575.8	–	5.80	0.2283	28.0	66.0	36.0	6.00
R4575.9	–	5.90	0.2323	28.0	66.0	36.0	6.00
R457A	A	5.94	0.2339	28.0	66.0	36.0	6.00
R45715/64	15/64	5.95	0.2344	28.0	66.0	36.0	6.00
R4576.0	–	6.00	0.2362	28.0	66.0	36.0	6.00
R457B	B	6.05	0.2380	34.0	79.0	36.0	8.00
R4576.05	–	6.05	0.2382	34.0	79.0	36.0	8.00
R4576.1	–	6.10	0.2402	34.0	79.0	36.0	8.00
R457C	C	6.15	0.2421	34.0	79.0	36.0	8.00
R4576.2	–	6.20	0.2441	34.0	79.0	36.0	8.00
R457D	D	6.25	0.2461	34.0	79.0	36.0	8.00
R4576.3	–	6.30	0.2480	34.0	79.0	36.0	8.00
R4571/4	1/4	6.35	0.2500	34.0	79.0	36.0	8.00
R4576.4	–	6.40	0.2520	34.0	79.0	36.0	8.00
R4576.5	–	6.50	0.2559	34.0	79.0	36.0	8.00
R457F	F	6.53	0.2571	34.0	79.0	36.0	8.00
R4576.6	–	6.60	0.2598	34.0	79.0	36.0	8.00
R457G	G	6.63	0.2610	34.0	79.0	36.0	8.00
R4576.7	–	6.70	0.2638	34.0	79.0	36.0	8.00
R45717/64	17/64	6.75	0.2656	34.0	79.0	36.0	8.00
R4576.8	–	6.80	0.2677	34.0	79.0	36.0	8.00
R4576.9	–	6.90	0.2717	34.0	79.0	36.0	8.00
R457I	I	6.91	0.2720	34.0	79.0	36.0	8.00
R4577.0	–	7.00	0.2756	34.0	79.0	36.0	8.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R457J	J	7.04	0.2772	41.0	79.0	36.0	8.00
R4577.1	–	7.10	0.2795	41.0	79.0	36.0	8.00
R4579/32	9/32	7.14	0.2813	41.0	79.0	36.0	8.00
R4577.2	–	7.20	0.2835	41.0	79.0	36.0	8.00
R4577.3	–	7.30	0.2874	41.0	79.0	36.0	8.00
R4577.4	–	7.40	0.2913	41.0	79.0	36.0	8.00
R4577.5	–	7.50	0.2953	41.0	79.0	36.0	8.00
R45719/64	19/64	7.54	0.2969	41.0	79.0	36.0	8.00
R4577.6	–	7.60	0.2992	41.0	79.0	36.0	8.00
R457N	N	7.67	0.3020	41.0	79.0	36.0	8.00
R4577.7	–	7.70	0.3031	41.0	79.0	36.0	8.00
R4577.8	–	7.80	0.3071	41.0	79.0	36.0	8.00
R4577.9	–	7.90	0.3110	41.0	79.0	36.0	8.00
R4575/16	5/16	7.94	0.3125	41.0	79.0	36.0	8.00
R4578.0	–	8.00	0.3150	41.0	79.0	36.0	8.00
R457O	O	8.03	0.3161	47.0	89.0	40.0	10.00
R4578.05	–	8.05	0.3169	47.0	89.0	40.0	10.00
R4578.1	–	8.10	0.3189	47.0	89.0	40.0	10.00
R4578.2	–	8.20	0.3228	47.0	89.0	40.0	10.00
R457P	P	8.20	0.3228	47.0	89.0	40.0	10.00
R4578.3	–	8.30	0.3268	47.0	89.0	40.0	10.00
R45721/64	21/64	8.33	0.3281	47.0	89.0	40.0	10.00
R4578.4	–	8.40	0.3307	47.0	89.0	40.0	10.00
R457Q	Q	8.43	0.3319	47.0	89.0	40.0	10.00
R4578.5	–	8.50	0.3346	47.0	89.0	40.0	10.00
R4578.6	–	8.60	0.3386	47.0	89.0	40.0	10.00
R457R	R	8.61	0.3390	47.0	89.0	40.0	10.00
R4578.7	–	8.70	0.3425	47.0	89.0	40.0	10.00
R45711/32	11/32	8.73	0.3438	47.0	89.0	40.0	10.00
R4578.8	–	8.80	0.3465	47.0	89.0	40.0	10.00
R457S	S	8.84	0.3480	47.0	89.0	40.0	10.00
R4578.9	–	8.90	0.3504	47.0	89.0	40.0	10.00
R4579.0	–	9.00	0.3543	47.0	89.0	40.0	10.00
R4579.1	–	9.10	0.3583	47.0	89.0	40.0	10.00
R45723/64	23/64	9.13	0.3594	47.0	89.0	40.0	10.00
R4579.2	–	9.20	0.3622	47.0	89.0	40.0	10.00
R4579.3	–	9.30	0.3661	47.0	89.0	40.0	10.00
R457U	U	9.35	0.3681	47.0	89.0	40.0	10.00
R4579.4	–	9.40	0.3701	47.0	89.0	40.0	10.00
R4579.5	–	9.50	0.3740	47.0	89.0	40.0	10.00
R4573/8	3/8	9.53	0.3750	47.0	89.0	40.0	10.00
R457V	V	9.58	0.3772	47.0	89.0	40.0	10.00
R4579.6	–	9.60	0.3780	47.0	89.0	40.0	10.00
R4579.7	–	9.70	0.3819	47.0	89.0	40.0	10.00
R4579.8	–	9.80	0.3858	47.0	89.0	40.0	10.00
R457W	W	9.80	0.3858	47.0	89.0	40.0	10.00
R4579.9	–	9.90	0.3898	47.0	89.0	40.0	10.00
R45725/64	25/64	9.92	0.3906	47.0	89.0	40.0	10.00
R45710.0	–	10.00	0.3937	47.0	89.0	40.0	10.00
R45710.05	–	10.05	0.3957	55.0	102.0	45.0	12.00
R457X	X	10.08	0.3969	55.0	102.0	45.0	12.00
R45710.1	–	10.10	0.3976	55.0	102.0	45.0	12.00
R45710.2	–	10.20	0.4016	55.0	102.0	45.0	12.00
R457Y	Y	10.26	0.4039	55.0	102.0	45.0	12.00
R45710.3	–	10.30	0.4055	55.0	102.0	45.0	12.00
R45713/32	13/32	10.32	0.4063	55.0	102.0	45.0	12.00
R45710.4	–	10.40	0.4094	55.0	102.0	45.0	12.00
R457Z	Z	10.49	0.4130	55.0	102.0	45.0	12.00
R45710.5	–	10.50	0.4134	55.0	102.0	45.0	12.00
R45710.6	–	10.60	0.4173	55.0	102.0	45.0	12.00
R45727/64	27/64	10.72	0.4219	55.0	102.0	45.0	12.00
R45710.8	–	10.80	0.4252	55.0	102.0	45.0	12.00

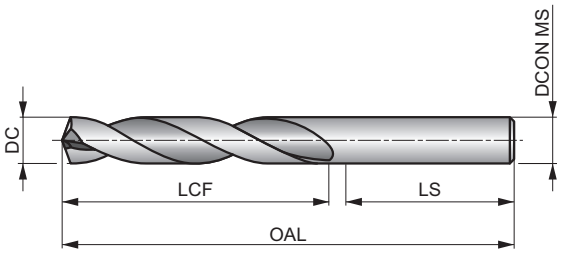
Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R45711.0	–	11.00	0.4331	55.0	102.0	45.0	12.00
R4577/16	7/16	11.11	0.4375	55.0	102.0	45.0	12.00
R45711.2	–	11.20	0.4409	55.0	102.0	45.0	12.00
R45711.3	–	11.30	0.4449	55.0	102.0	45.0	12.00
R45711.4	–	11.40	0.4488	55.0	102.0	45.0	12.00
R45711.5	–	11.50	0.4528	55.0	102.0	45.0	12.00
R45729/64	29/64	11.51	0.4531	55.0	102.0	45.0	12.00
R45711.6	–	11.60	0.4567	55.0	102.0	45.0	12.00
R45711.8	–	11.80	0.4646	55.0	102.0	45.0	12.00
R45715/32	15/32	11.91	0.4688	55.0	102.0	45.0	12.00
R45712.0	–	12.00	0.4724	55.0	102.0	45.0	12.00
R45712.05	–	12.05	0.4744	60.0	107.0	45.0	14.00
R45712.1	–	12.10	0.4764	60.0	107.0	45.0	14.00
R45712.2	–	12.20	0.4803	60.0	107.0	45.0	14.00
R45731/64	31/64	12.30	0.4844	60.0	107.0	45.0	14.00
R45712.5	–	12.50	0.4921	60.0	107.0	45.0	14.00
R45712.7	–	12.70	0.5000	60.0	107.0	45.0	14.00
R4571/2	1/2	12.70	0.5000	60.0	107.0	45.0	14.00
R45712.8	–	12.80	0.5039	60.0	107.0	45.0	14.00
R45713.0	–	13.00	0.5118	60.0	107.0	45.0	14.00
R45733/64	33/64	13.10	0.5156	60.0	107.0	45.0	14.00
R45713.3	–	13.30	0.5236	60.0	107.0	45.0	14.00
R45717/32	17/32	13.49	0.5313	60.0	107.0	45.0	14.00
R45713.5	–	13.50	0.5315	60.0	107.0	45.0	14.00
R45713.8	–	13.80	0.5433	60.0	107.0	45.0	14.00
R45735/64	35/64	13.89	0.5469	60.0	107.0	45.0	14.00
R45714.0	–	14.00	0.5512	60.0	107.0	45.0	14.00
R45714.25	–	14.25	0.5610	65.0	115.0	48.0	16.00
R4579/16	9/16	14.29	0.5625	65.0	115.0	48.0	16.00
R45714.5	–	14.50	0.5709	65.0	115.0	48.0	16.00
R45737/64	37/64	14.68	0.5781	65.0	115.0	48.0	16.00
R45714.8	–	14.80	0.5827	65.0	115.0	48.0	16.00
R45715.0	–	15.00	0.5906	65.0	115.0	48.0	16.00
R45719/32	19/32	15.08	0.5938	65.0	115.0	48.0	16.00
R45715.1	–	15.10	0.5945	65.0	115.0	48.0	16.00
R45715.3	–	15.30	0.6024	65.0	115.0	48.0	16.00
R45739/64	39/64	15.48	0.6094	65.0	115.0	48.0	16.00
R45715.5	–	15.50	0.6102	65.0	115.0	48.0	16.00
R45715.8	–	15.80	0.6220	65.0	115.0	48.0	16.00
R4575/8	5/8	15.88	0.6250	65.0	115.0	48.0	16.00
R45716.0	–	16.00	0.6299	65.0	115.0	48.0	16.00
R45741/64	41/64	16.27	0.6406	73.0	123.0	48.0	18.00
R45716.5	–	16.50	0.6496	73.0	123.0	48.0	18.00
R45721/32	21/32	16.67	0.6563	73.0	123.0	48.0	18.00
R45717.0	–	17.00	0.6693	73.0	123.0	48.0	18.00
R45743/64	43/64	17.07	0.6720	73.0	123.0	48.0	18.00
R45711/16	11/16	17.46	0.6874	73.0	123.0	48.0	18.00
R45717.5	–	17.50	0.6890	73.0	123.0	48.0	18.00
R45745/64	45/64	17.86	0.7031	73.0	123.0	48.0	18.00
R45718.0	–	18.00	0.7087	73.0	123.0	48.0	18.00
R45723/32	23/32	18.26	0.7189	79.0	131.0	50.0	20.00
R45718.5	–	18.50	0.7283	79.0	131.0	50.0	20.00
R45747/64	47/64	18.65	0.7343	79.0	131.0	50.0	20.00
R45718.8	–	18.80	0.7402	79.0	131.0	50.0	20.00
R45719.0	–	19.00	0.7480	79.0	131.0	50.0	20.00
R4573/4	3/4	19.05	0.7500	79.0	131.0	50.0	20.00
R45719.5	–	19.50	0.7677	79.0	131.0	50.0	20.00
R45719.8	–	19.80	0.7795	79.0	131.0	50.0	20.00
R45720.0	–	20.00	0.7874	79.0	131.0	50.0	20.00

R454

DORMER

Force X 5倍径合金钻，氮铝化钛涂层。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(H9公差)，自定心的140°钻尖角、四后面的分离式钻尖以及CTW槽型增强了穿透力，氮铝化钛涂层提高了表面硬度并延长了刀具寿命。

FORCE X



HM	DIN 6537L	5×D
140°	TiAlN	DIN 6535HA
CTW	R	DC m7

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
134 V	150 V	155 V	115 V	101 V	89 V	100 V	80 V	68 V	59 V	50 V	41 U	56 U	48 U
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
50 U	41 U	35 T	31 T	26 T	24 T	23 T	20 T	83 W	61 W	46 W	74 V	60 V	48 V
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
65 V	50 V	41 V	61 V	46 V	34 V	29 V	24 V	68 V	52 V	40 V	188 W	141 W	94 W
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	H1.1	H2.1	H2.2	H3.1	H3.2
231 V	208 V	150 V	280 V	165 V	83 V	41 U	34 U	30 T	42 U	25 U	23 U	28 U	23 U

DCON MS公差h6

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
R4543.0	–	3.00	0.1181	28.0	66.0	36.0	6.00
R4543.1	–	3.10	0.1220	28.0	66.0	36.0	6.00
R4541/8	1/8	3.18	0.1250	28.0	66.0	36.0	6.00
R4543.2	–	3.20	0.1260	28.0	66.0	36.0	6.00
R454N30	N30	3.26	0.1283	28.0	66.0	36.0	6.00
R4543.3	–	3.30	0.1299	28.0	66.0	36.0	6.00
R4543.4	–	3.40	0.1339	28.0	66.0	36.0	6.00
R454N29	N29	3.45	0.1360	28.0	66.0	36.0	6.00
R4543.5	–	3.50	0.1378	28.0	66.0	36.0	6.00
R454N28	N28	3.57	0.1406	28.0	66.0	36.0	6.00
R4549/64	9/64	3.57	0.1406	28.0	66.0	36.0	6.00
R4543.6	–	3.60	0.1417	28.0	66.0	36.0	6.00
R454N27	N27	3.66	0.1441	28.0	66.0	36.0	6.00
R4543.7	–	3.70	0.1457	28.0	66.0	36.0	6.00
R454N26	N26	3.73	0.1469	36.0	74.0	36.0	6.00
R4543.8	–	3.80	0.1496	36.0	74.0	36.0	6.00
R454N24	N24	3.86	0.1520	36.0	74.0	36.0	6.00
R4543.9	–	3.90	0.1535	36.0	74.0	36.0	6.00
R4545/32	5/32	3.97	0.1563	36.0	74.0	36.0	6.00
R4544.0	–	4.00	0.1575	36.0	74.0	36.0	6.00
R454N21	N21	4.04	0.1591	36.0	74.0	36.0	6.00
R454N20	N20	4.09	0.1610	36.0	74.0	36.0	6.00
R4544.1	–	4.10	0.1614	36.0	74.0	36.0	6.00
R4544.2	–	4.20	0.1654	36.0	74.0	36.0	6.00
R454N19	N19	4.22	0.1661	36.0	74.0	36.0	6.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4544.3	–	4.30	0.1693	36.0	74.0	36.0	6.00
R45411/64	11/64	4.37	0.1719	36.0	74.0	36.0	6.00
R4544.4	–	4.40	0.1732	36.0	74.0	36.0	6.00
R4544.5	–	4.50	0.1772	36.0	74.0	36.0	6.00
R454N16	N16	4.50	0.1772	36.0	74.0	36.0	6.00
R454N15	N15	4.57	0.1799	36.0	74.0	36.0	6.00
R4544.6	–	4.60	0.1811	36.0	74.0	36.0	6.00
R454N14	N14	4.62	0.1819	36.0	74.0	36.0	6.00
R4544.7	–	4.70	0.1850	36.0	74.0	36.0	6.00
R4543/16	3/16	4.76	0.1875	44.0	82.0	36.0	6.00
R4544.8	–	4.80	0.1890	44.0	82.0	36.0	6.00
R454N11	N11	4.85	0.1909	44.0	82.0	36.0	6.00
R4544.9	–	4.90	0.1929	44.0	82.0	36.0	6.00
R454N10	N10	4.92	0.1937	44.0	82.0	36.0	6.00
R454N9	N9	4.98	0.1961	44.0	82.0	36.0	6.00
R4545.0	–	5.00	0.1969	44.0	82.0	36.0	6.00
R454N8	N8	5.06	0.1992	44.0	82.0	36.0	6.00
R4545.1	–	5.10	0.2008	44.0	82.0	36.0	6.00
R454N7	N7	5.11	0.2010	44.0	82.0	36.0	6.00
R45413/64	13/64	5.16	0.2031	44.0	82.0	36.0	6.00
R454N6	N6	5.18	0.2039	44.0	82.0	36.0	6.00
R4545.2	–	5.20	0.2047	44.0	82.0	36.0	6.00
R454N5	N5	5.22	0.2055	44.0	82.0	36.0	6.00
R454N4	N4	5.31	0.2091	44.0	82.0	36.0	6.00
R454N3	N3	5.41	0.2130	44.0	82.0	36.0	6.00
R4545.5	–	5.50	0.2165	44.0	82.0	36.0	6.00
R4547/32	7/32	5.56	0.2188	44.0	82.0	36.0	6.00
R4545.6	–	5.60	0.2205	44.0	82.0	36.0	6.00
R454N2	N2	5.61	0.2209	44.0	82.0	36.0	6.00
R4545.7	–	5.70	0.2244	44.0	82.0	36.0	6.00
R454N1	N1	5.79	0.2280	44.0	82.0	36.0	6.00
R4545.8	–	5.80	0.2283	44.0	82.0	36.0	6.00
R454A	A	5.94	0.2339	44.0	82.0	36.0	6.00
R45415/64	15/64	5.95	0.2344	44.0	82.0	36.0	6.00
R4546.0	–	6.00	0.2362	44.0	82.0	36.0	6.00
R454B	B	6.05	0.2380	53.0	91.0	36.0	8.00
R4546.1	–	6.10	0.2402	53.0	91.0	36.0	8.00
R454C	C	6.15	0.2421	53.0	91.0	36.0	8.00
R4546.2	–	6.20	0.2441	53.0	91.0	36.0	8.00
R454D	D	6.25	0.2461	53.0	91.0	36.0	8.00
R4546.3	–	6.30	0.2480	53.0	91.0	36.0	8.00
R4541/4	1/4	6.35	0.2500	53.0	91.0	36.0	8.00
R454E	E	6.35	0.2500	53.0	91.0	36.0	8.00
R4546.4	–	6.40	0.2520	53.0	91.0	36.0	8.00
R4546.5	–	6.50	0.2559	53.0	91.0	36.0	8.00
R454F	F	6.53	0.2571	53.0	91.0	36.0	8.00
R4546.6	–	6.60	0.2598	53.0	91.0	36.0	8.00
R454G	G	6.63	0.2610	53.0	91.0	36.0	8.00
R4546.7	–	6.70	0.2638	53.0	91.0	36.0	8.00
R45417/64	17/64	6.75	0.2656	53.0	91.0	36.0	8.00
R454H	H	6.76	0.2661	53.0	91.0	36.0	8.00
R4546.8	–	6.80	0.2677	53.0	91.0	36.0	8.00
R4546.9	–	6.90	0.2717	53.0	91.0	36.0	8.00
R454I	I	6.91	0.2720	53.0	91.0	36.0	8.00
R4547.0	–	7.00	0.2756	53.0	91.0	36.0	8.00
R454J	J	7.04	0.2772	53.0	91.0	36.0	8.00
R4547.1	–	7.10	0.2795	53.0	91.0	36.0	8.00
R4549/32	9/32	7.14	0.2813	53.0	91.0	36.0	8.00
R4547.3	–	7.30	0.2874	53.0	91.0	36.0	8.00
R454L	L	7.37	0.2902	53.0	91.0	36.0	8.00
R4547.4	–	7.40	0.2913	53.0	91.0	36.0	8.00
R4547.5	–	7.50	0.2953	53.0	91.0	36.0	8.00

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
R45419/64	19/64	7.54	0.2969	53.0	91.0	36.0	8.00
R4547.6	–	7.60	0.2992	53.0	91.0	36.0	8.00
R454N	N	7.67	0.3020	53.0	91.0	36.0	8.00
R4547.7	–	7.70	0.3031	53.0	91.0	36.0	8.00
R4547.8	–	7.80	0.3071	53.0	91.0	36.0	8.00
R4547.9	–	7.90	0.3110	53.0	91.0	36.0	8.00
R4545/16	5/16	7.94	0.3125	53.0	91.0	36.0	8.00
R4548.0	–	8.00	0.3150	53.0	91.0	36.0	8.00
R454O	O	8.03	0.3161	61.0	103.0	40.0	10.00
R4548.1	–	8.10	0.3189	61.0	103.0	40.0	10.00
R4548.2	–	8.20	0.3228	61.0	103.0	40.0	10.00
R45421/64	21/64	8.33	0.3281	61.0	103.0	40.0	10.00
R4548.4	–	8.40	0.3307	61.0	103.0	40.0	10.00
R454Q	Q	8.43	0.3319	61.0	103.0	40.0	10.00
R4548.5	–	8.50	0.3346	61.0	103.0	40.0	10.00
R4548.6	–	8.60	0.3386	61.0	103.0	40.0	10.00
R454R	R	8.61	0.3390	61.0	103.0	40.0	10.00
R4548.7	–	8.70	0.3425	61.0	103.0	40.0	10.00
R45411/32	11/32	8.73	0.3438	61.0	103.0	40.0	10.00
R4548.8	–	8.80	0.3465	61.0	103.0	40.0	10.00
R454S	S	8.84	0.3480	61.0	103.0	40.0	10.00
R4548.9	–	8.90	0.3504	61.0	103.0	40.0	10.00
R4549.0	–	9.00	0.3543	61.0	103.0	40.0	10.00
R4549.1	–	9.10	0.3583	61.0	103.0	40.0	10.00
R45423/64	23/64	9.13	0.3594	61.0	103.0	40.0	10.00
R4549.3	–	9.30	0.3661	61.0	103.0	40.0	10.00
R454U	U	9.35	0.3681	61.0	103.0	40.0	10.00
R4549.4	–	9.40	0.3701	61.0	103.0	40.0	10.00
R4549.5	–	9.50	0.3740	61.0	103.0	40.0	10.00
R4543/8	3/8	9.53	0.3750	61.0	103.0	40.0	10.00
R4549.6	–	9.60	0.3780	61.0	103.0	40.0	10.00
R4549.7	–	9.70	0.3819	61.0	103.0	40.0	10.00
R4549.8	–	9.80	0.3858	61.0	103.0	40.0	10.00
R4549.9	–	9.90	0.3898	61.0	103.0	40.0	10.00
R454W	W	9.80	0.3858	61.0	103.0	40.0	10.00
R45425/64	25/64	9.92	0.3906	61.0	103.0	40.0	10.00
R45410.0	–	10.00	0.3937	61.0	103.0	40.0	10.00
R454X	X	10.08	0.3969	70.0	118.0	45.0	12.00
R45410.1	–	10.10	0.3976	70.0	118.0	45.0	12.00
R45410.2	–	10.20	0.4016	70.0	118.0	45.0	12.00
R454Y	Y	10.26	0.4039	70.0	118.0	45.0	12.00
R45410.3	–	10.30	0.4055	70.0	118.0	45.0	12.00
R45413/32	13/32	10.32	0.4063	70.0	118.0	45.0	12.00
R45410.4	–	10.40	0.4094	70.0	118.0	45.0	12.00
R454Z	Z	10.49	0.4130	70.0	118.0	45.0	12.00
R45410.5	–	10.50	0.4134	70.0	118.0	45.0	12.00
R45410.6	–	10.60	0.4173	70.0	118.0	45.0	12.00
R45427/64	27/64	10.72	0.4219	70.0	118.0	45.0	12.00
R45411.0	–	11.00	0.4331	70.0	118.0	45.0	12.00
R4547/16	7/16	11.11	0.4375	70.0	118.0	45.0	12.00
R45411.2	–	11.20	0.4409	70.0	118.0	45.0	12.00
R45411.4	–	11.40	0.4488	70.0	118.0	45.0	12.00
R45411.5	–	11.50	0.4528	70.0	118.0	45.0	12.00
R45429/64	29/64	11.51	0.4531	70.0	118.0	45.0	12.00
R45411.6	–	11.60	0.4567	70.0	118.0	45.0	12.00
R45411.8	–	11.80	0.4646	70.0	118.0	45.0	12.00
R45415/32	15/32	11.91	0.4688	70.0	118.0	45.0	12.00
R45412.0	–	12.00	0.4724	70.0	118.0	45.0	12.00
R45412.1	–	12.10	0.4764	76.0	124.0	45.0	14.00
R45412.2	–	12.20	0.4803	76.0	124.0	45.0	14.00
R45431/64	31/64	12.30	0.4844	76.0	124.0	45.0	14.00
R45412.5	–	12.50	0.4921	76.0	124.0	45.0	14.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R45412.7	–	12.70	0.5000	76.0	124.0	45.0	14.00
R4541/2	1/2	12.70	0.5000	76.0	124.0	45.0	14.00
R45412.8	–	12.80	0.5039	76.0	124.0	45.0	14.00
R45413.0	–	13.00	0.5118	76.0	124.0	45.0	14.00
R45433/64	33/64	13.10	0.5156	76.0	124.0	45.0	14.00
R45417/32	17/32	13.49	0.5313	76.0	124.0	45.0	14.00
R45413.5	–	13.50	0.5315	76.0	124.0	45.0	14.00
R45413.8	–	13.80	0.5433	76.0	124.0	45.0	14.00
R45435/64	35/64	13.89	0.5469	76.0	124.0	45.0	14.00
R45414.0	–	14.00	0.5512	76.0	124.0	45.0	14.00
R45414.25	–	14.25	0.5610	82.0	133.0	48.0	16.00
R4549/16	9/16	14.29	0.5625	82.0	133.0	48.0	16.00
R45414.5	–	14.50	0.5709	82.0	133.0	48.0	16.00
R45437/64	37/64	14.68	0.5781	82.0	133.0	48.0	16.00
R45414.8	–	14.80	0.5827	82.0	133.0	48.0	16.00
R45415.0	–	15.00	0.5906	82.0	133.0	48.0	16.00
R45419/32	19/32	15.08	0.5938	82.0	133.0	48.0	16.00
R45415.1	–	15.10	0.5945	82.0	133.0	48.0	16.00
R45439/64	39/64	15.48	0.6094	82.0	133.0	48.0	16.00
R45415.5	–	15.50	0.6102	82.0	133.0	48.0	16.00
R45415.8	–	15.80	0.6220	82.0	133.0	48.0	16.00
R4545/8	5/8	15.88	0.6250	82.0	133.0	48.0	16.00
R45416.0	–	16.00	0.6299	82.0	133.0	48.0	16.00
R45441/64	41/64	16.27	0.6406	91.0	143.0	48.0	18.00
R45416.5	–	16.50	0.6496	91.0	143.0	48.0	18.00
R45421/32	21/32	16.67	0.6563	91.0	143.0	48.0	18.00
R45417.0	–	17.00	0.6693	91.0	143.0	48.0	18.00
R45443/64	43/64	17.07	0.6720	91.0	143.0	48.0	18.00
R45411/16	11/16	17.46	0.6874	91.0	143.0	48.0	18.00
R45417.5	–	17.50	0.6890	91.0	143.0	48.0	18.00
R45417.8	–	17.80	0.7008	91.0	143.0	48.0	18.00
R45445/64	45/64	17.86	0.7031	91.0	143.0	48.0	18.00
R45418.0	–	18.00	0.7087	91.0	143.0	48.0	18.00
R45423/32	23/32	18.26	0.7189	99.0	153.0	50.0	20.00
R45418.5	–	18.50	0.7283	99.0	153.0	50.0	20.00
R45447/64	47/64	18.65	0.7343	99.0	153.0	50.0	20.00
R45419.0	–	19.00	0.7480	99.0	153.0	50.0	20.00
R4543/4	3/4	19.05	0.7500	99.0	153.0	50.0	20.00
R45419.5	–	19.50	0.7677	99.0	153.0	50.0	20.00
R45419.8	–	19.80	0.7795	99.0	153.0	50.0	20.00
R45420.0	–	20.00	0.7874	99.0	153.0	50.0	20.00

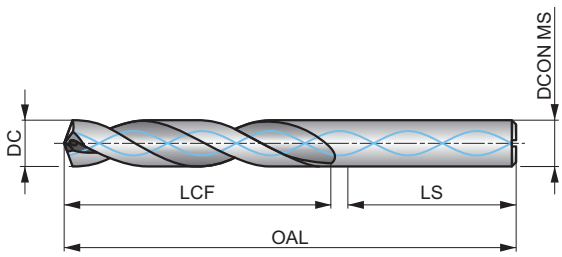
R453

DORMER

Force X 5倍径内冷合金钻，氮铝化钛涂层。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(H9公差)，自定心的140°钻尖角、四后面的分离式钻尖以及CTW槽型增强了穿透力，内冷孔提高了排屑能力，氮铝化钛涂层提高了表面硬度并延长了刀具寿命。

FORCE X

HM	DIN 6537L	5×D
140°	TiAlN	DIN 6535HA
CTW	R	
DC m7		



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
170 V	190 V	197 V	145 V	128 V	113 V	126 V	102 V	86 V	75 V	64 V	52 U	71 V	61 V
M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3
64 V	52 V	44 U	39 V	33 V	30 V	29 U	25 U	105 W	77 W	58 W	93 V	76 V	61 V
K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3
83 V	64 V	51 V	77 V	58 V	43 V	36 V	30 V	86 V	66 V	50 V	238 W	179 W	119 W
N2.1	N2.2	N2.3	N3.1	N3.2	N3.3	S1.1	S1.2	S1.3	H1.1	H2.1	H2.2	H3.1	H3.2
293 V	263 V	190 V	354 W	209 W	105 W	52 V	43 V	38 U	53 U	31 U	29 U	35 U	29 U

DCON MS公差h6

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
R4533.0	–	3.00	0.1181	28.0	66.0	36.0	6.00
R4533.1	–	3.10	0.1220	28.0	66.0	36.0	6.00
R4531/8	1/8	3.18	0.1250	28.0	66.0	36.0	6.00
R4533.2	–	3.20	0.1260	28.0	66.0	36.0	6.00
R453N30	N30	3.26	0.1283	28.0	66.0	36.0	6.00
R4533.3	–	3.30	0.1299	28.0	66.0	36.0	6.00
R4533.4	–	3.40	0.1339	28.0	66.0	36.0	6.00
R453N29	N29	3.45	0.1360	28.0	66.0	36.0	6.00
R4533.5	–	3.50	0.1378	28.0	66.0	36.0	6.00
R453N28	N28	3.57	0.1406	28.0	66.0	36.0	6.00
R4539/64	9/64	3.57	0.1406	28.0	66.0	36.0	6.00
R4533.6	–	3.60	0.1417	28.0	66.0	36.0	6.00
R453N27	N27	3.66	0.1441	28.0	66.0	36.0	6.00
R4533.7	–	3.70	0.1457	28.0	66.0	36.0	6.00
R453N26	N26	3.73	0.1469	36.0	74.0	36.0	6.00
R4533.8	–	3.80	0.1496	36.0	74.0	36.0	6.00
R453N24	N24	3.86	0.1520	36.0	74.0	36.0	6.00
R4533.9	–	3.90	0.1535	36.0	74.0	36.0	6.00
R453N23	N23	3.91	0.1539	36.0	74.0	36.0	6.00
R4535/32	5/32	3.97	0.1563	36.0	74.0	36.0	6.00
R453N22	N22	3.99	0.1571	36.0	74.0	36.0	6.00
R4534.0	–	4.00	0.1575	36.0	74.0	36.0	6.00
R453N21	N21	4.04	0.1591	36.0	74.0	36.0	6.00
R4534.05	–	4.05	0.1594	36.0	74.0	36.0	6.00
R453N20	N20	4.09	0.1610	36.0	74.0	36.0	6.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4534.1	–	4.10	0.1614	36.0	74.0	36.0	6.00
R4534.2	–	4.20	0.1654	36.0	74.0	36.0	6.00
R453N19	N19	4.22	0.1661	36.0	74.0	36.0	6.00
R4534.3	–	4.30	0.1693	36.0	74.0	36.0	6.00
R453N18	N18	4.31	0.1697	36.0	74.0	36.0	6.00
R45311/64	11/64	4.37	0.1719	36.0	74.0	36.0	6.00
R4534.4	–	4.40	0.1732	36.0	74.0	36.0	6.00
R4534.5	–	4.50	0.1772	36.0	74.0	36.0	6.00
R453N16	N16	4.50	0.1772	36.0	74.0	36.0	6.00
R453N15	N15	4.57	0.1799	36.0	74.0	36.0	6.00
R4534.6	–	4.60	0.1811	36.0	74.0	36.0	6.00
R453N14	N14	4.62	0.1819	36.0	74.0	36.0	6.00
R4534.7	–	4.70	0.1850	36.0	74.0	36.0	6.00
R4533/16	3/16	4.76	0.1875	44.0	82.0	36.0	6.00
R4534.8	–	4.80	0.1890	44.0	82.0	36.0	6.00
R453N12	N12	4.80	0.1890	44.0	82.0	36.0	6.00
R453N11	N11	4.85	0.1909	44.0	82.0	36.0	6.00
R4534.9	–	4.90	0.1929	44.0	82.0	36.0	6.00
R453N10	N10	4.92	0.1937	44.0	82.0	36.0	6.00
R453N9	N9	4.98	0.1961	44.0	82.0	36.0	6.00
R4535.0	–	5.00	0.1969	44.0	82.0	36.0	6.00
R4535.05	–	5.05	0.1988	44.0	82.0	36.0	6.00
R453N8	N8	5.06	0.1992	44.0	82.0	36.0	6.00
R4535.1	–	5.10	0.2008	44.0	82.0	36.0	6.00
R453N7	N7	5.11	0.2010	44.0	82.0	36.0	6.00
R45313/64	13/64	5.16	0.2031	44.0	82.0	36.0	6.00
R4535.2	–	5.20	0.2047	44.0	82.0	36.0	6.00
R453N5	N5	5.22	0.2055	44.0	82.0	36.0	6.00
R4535.3	–	5.30	0.2087	44.0	82.0	36.0	6.00
R453N4	N4	5.31	0.2091	44.0	82.0	36.0	6.00
R4535.4	–	5.40	0.2126	44.0	82.0	36.0	6.00
R453N3	N3	5.41	0.2130	44.0	82.0	36.0	6.00
R4535.5	–	5.50	0.2165	44.0	82.0	36.0	6.00
R4537/32	7/32	5.56	0.2188	44.0	82.0	36.0	6.00
R4535.6	–	5.60	0.2205	44.0	82.0	36.0	6.00
R453N2	N2	5.61	0.2209	44.0	82.0	36.0	6.00
R4535.7	–	5.70	0.2244	44.0	82.0	36.0	6.00
R453N1	N1	5.79	0.2280	44.0	82.0	36.0	6.00
R4535.8	–	5.80	0.2283	44.0	82.0	36.0	6.00
R4535.9	–	5.90	0.2323	44.0	82.0	36.0	6.00
R453A	A	5.94	0.2339	44.0	82.0	36.0	6.00
R45315/64	15/64	5.95	0.2344	44.0	82.0	36.0	6.00
R4536.0	–	6.00	0.2362	44.0	82.0	36.0	6.00
R453B	B	6.05	0.2380	53.0	91.0	36.0	8.00
R4536.05	–	6.05	0.2382	53.0	91.0	36.0	8.00
R4536.1	–	6.10	0.2402	53.0	91.0	36.0	8.00
R453C	C	6.15	0.2421	53.0	91.0	36.0	8.00
R4536.2	–	6.20	0.2441	53.0	91.0	36.0	8.00
R453D	D	6.25	0.2461	53.0	91.0	36.0	8.00
R4536.3	–	6.30	0.2480	53.0	91.0	36.0	8.00
R4531/4	1/4	6.35	0.2500	53.0	91.0	36.0	8.00
R4536.4	–	6.40	0.2520	53.0	91.0	36.0	8.00
R4536.5	–	6.50	0.2559	53.0	91.0	36.0	8.00
R453F	F	6.53	0.2571	53.0	91.0	36.0	8.00
R4536.6	–	6.60	0.2598	53.0	91.0	36.0	8.00
R453G	G	6.63	0.2610	53.0	91.0	36.0	8.00
R4536.7	–	6.70	0.2638	53.0	91.0	36.0	8.00
R45317/64	17/64	6.75	0.2656	53.0	91.0	36.0	8.00
R4536.8	–	6.80	0.2677	53.0	91.0	36.0	8.00
R4536.9	–	6.90	0.2717	53.0	91.0	36.0	8.00
R453I	I	6.91	0.2720	53.0	91.0	36.0	8.00
R4537.0	–	7.00	0.2756	53.0	91.0	36.0	8.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R453J	J	7.04	0.2772	53.0	91.0	36.0	8.00
R4537.1	–	7.10	0.2795	53.0	91.0	36.0	8.00
R453K	K	7.14	0.2811	53.0	91.0	36.0	8.00
R4539/32	9/32	7.14	0.2813	53.0	91.0	36.0	8.00
R4537.2	–	7.20	0.2835	53.0	91.0	36.0	8.00
R4537.3	–	7.30	0.2874	53.0	91.0	36.0	8.00
R453L	L	7.37	0.2902	53.0	91.0	36.0	8.00
R4537.4	–	7.40	0.2913	53.0	91.0	36.0	8.00
R453M	M	7.49	0.2949	53.0	91.0	36.0	8.00
R4537.5	–	7.50	0.2953	53.0	91.0	36.0	8.00
R45319/64	19/64	7.54	0.2969	53.0	91.0	36.0	8.00
R4537.6	–	7.60	0.2992	53.0	91.0	36.0	8.00
R453N	N	7.67	0.3020	53.0	91.0	36.0	8.00
R4537.7	–	7.70	0.3031	53.0	91.0	36.0	8.00
R4537.8	–	7.80	0.3071	53.0	91.0	36.0	8.00
R4537.9	–	7.90	0.3110	53.0	91.0	36.0	8.00
R4535/16	5/16	7.94	0.3125	53.0	91.0	36.0	8.00
R4538.0	–	8.00	0.3150	53.0	91.0	36.0	8.00
R453O	O	8.03	0.3161	61.0	103.0	40.0	10.00
R4538.05	–	8.05	0.3169	61.0	103.0	40.0	10.00
R4538.1	–	8.10	0.3189	61.0	103.0	40.0	10.00
R4538.2	–	8.20	0.3228	61.0	103.0	40.0	10.00
R453P	P	8.20	0.3228	61.0	103.0	40.0	10.00
R4538.3	–	8.30	0.3268	61.0	103.0	40.0	10.00
R45321/64	21/64	8.33	0.3281	61.0	103.0	40.0	10.00
R4538.4	–	8.40	0.3307	61.0	103.0	40.0	10.00
R453Q	Q	8.43	0.3319	61.0	103.0	40.0	10.00
R4538.5	–	8.50	0.3346	61.0	103.0	40.0	10.00
R4538.6	–	8.60	0.3386	61.0	103.0	40.0	10.00
R453R	R	8.61	0.3390	61.0	103.0	40.0	10.00
R4538.7	–	8.70	0.3425	61.0	103.0	40.0	10.00
R45311/32	11/32	8.73	0.3438	61.0	103.0	40.0	10.00
R4538.8	–	8.80	0.3465	61.0	103.0	40.0	10.00
R453S	S	8.84	0.3480	61.0	103.0	40.0	10.00
R4538.9	–	8.90	0.3504	61.0	103.0	40.0	10.00
R4539.0	–	9.00	0.3543	61.0	103.0	40.0	10.00
R4539.1	–	9.10	0.3583	61.0	103.0	40.0	10.00
R45323/64	23/64	9.13	0.3594	61.0	103.0	40.0	10.00
R4539.2	–	9.20	0.3622	61.0	103.0	40.0	10.00
R4539.3	–	9.30	0.3661	61.0	103.0	40.0	10.00
R453U	U	9.35	0.3681	61.0	103.0	40.0	10.00
R4539.4	–	9.40	0.3701	61.0	103.0	40.0	10.00
R4539.5	–	9.50	0.3740	61.0	103.0	40.0	10.00
R4533/8	3/8	9.53	0.3750	61.0	103.0	40.0	10.00
R4539.6	–	9.60	0.3780	61.0	103.0	40.0	10.00
R4539.7	–	9.70	0.3819	61.0	103.0	40.0	10.00
R4539.8	–	9.80	0.3858	61.0	103.0	40.0	10.00
R453W	W	9.80	0.3858	61.0	103.0	40.0	10.00
R4539.9	–	9.90	0.3898	61.0	103.0	40.0	10.00
R45325/64	25/64	9.92	0.3906	61.0	103.0	40.0	10.00
R45310.0	–	10.00	0.3937	61.0	103.0	40.0	10.00
R45310.05	–	10.05	0.3957	70.0	118.0	45.0	12.00
R453X	X	10.08	0.3969	70.0	118.0	45.0	12.00
R45310.1	–	10.10	0.3976	70.0	118.0	45.0	12.00
R45310.2	–	10.20	0.4016	70.0	118.0	45.0	12.00
R453Y	Y	10.26	0.4039	70.0	118.0	45.0	12.00
R45310.3	–	10.30	0.4055	70.0	118.0	45.0	12.00
R45313/32	13/32	10.32	0.4063	70.0	118.0	45.0	12.00
R45310.4	–	10.40	0.4094	70.0	118.0	45.0	12.00
R45310.5	–	10.50	0.4134	70.0	118.0	45.0	12.00
R45310.6	–	10.60	0.4173	70.0	118.0	45.0	12.00
R45327/64	27/64	10.72	0.4219	70.0	118.0	45.0	12.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R45310.8	–	10.80	0.4252	70.0	118.0	45.0	12.00
R45311.0	–	11.00	0.4331	70.0	118.0	45.0	12.00
R4537/16	7/16	11.11	0.4375	70.0	118.0	45.0	12.00
R45311.2	–	11.20	0.4409	70.0	118.0	45.0	12.00
R45311.3	–	11.30	0.4449	70.0	118.0	45.0	12.00
R45311.4	–	11.40	0.4488	70.0	118.0	45.0	12.00
R45311.5	–	11.50	0.4528	70.0	118.0	45.0	12.00
R45329/64	29/64	11.51	0.4531	70.0	118.0	45.0	12.00
R45311.6	–	11.60	0.4567	70.0	118.0	45.0	12.00
R45311.8	–	11.80	0.4646	70.0	118.0	45.0	12.00
R45315/32	15/32	11.91	0.4688	70.0	118.0	45.0	12.00
R45312.0	–	12.00	0.4724	70.0	118.0	45.0	12.00
R45312.05	–	12.05	0.4744	76.0	124.0	45.0	14.00
R45312.2	–	12.20	0.4803	76.0	124.0	45.0	14.00
R45331/64	31/64	12.30	0.4844	76.0	124.0	45.0	14.00
R45312.5	–	12.50	0.4921	76.0	124.0	45.0	14.00
R45312.7	–	12.70	0.5000	76.0	124.0	45.0	14.00
R4531/2	1/2	12.70	0.5000	76.0	124.0	45.0	14.00
R45312.8	–	12.80	0.5039	76.0	124.0	45.0	14.00
R45313.0	–	13.00	0.5118	76.0	124.0	45.0	14.00
R45333/64	33/64	13.10	0.5156	76.0	124.0	45.0	14.00
R45313.3	–	13.30	0.5236	76.0	124.0	45.0	14.00
R45317/32	17/32	13.49	0.5313	76.0	124.0	45.0	14.00
R45313.5	–	13.50	0.5315	76.0	124.0	45.0	14.00
R45313.8	–	13.80	0.5433	76.0	124.0	45.0	14.00
R45335/64	35/64	13.89	0.5469	76.0	124.0	45.0	14.00
R45314.0	–	14.00	0.5512	76.0	124.0	45.0	14.00
R45314.25	–	14.25	0.5610	82.0	133.0	48.0	16.00
R4539/16	9/16	14.29	0.5625	82.0	133.0	48.0	16.00
R45314.5	–	14.50	0.5709	82.0	133.0	48.0	16.00
R45337/64	37/64	14.68	0.5781	82.0	133.0	48.0	16.00
R45314.8	–	14.80	0.5827	82.0	133.0	48.0	16.00
R45315.0	–	15.00	0.5906	82.0	133.0	48.0	16.00
R45319/32	19/32	15.08	0.5938	82.0	133.0	48.0	16.00
R45315.1	–	15.10	0.5945	82.0	133.0	48.0	16.00
R45315.3	–	15.30	0.6024	82.0	133.0	48.0	16.00
R45315.5	–	15.50	0.6102	82.0	133.0	48.0	16.00
R45315.8	–	15.80	0.6220	82.0	133.0	48.0	16.00
R4535/8	5/8	15.88	0.6250	82.0	133.0	48.0	16.00
R45316.0	–	16.00	0.6299	82.0	133.0	48.0	16.00
R45341/64	41/64	16.27	0.6406	91.0	143.0	48.0	18.00
R45316.5	–	16.50	0.6496	91.0	143.0	48.0	18.00
R45321/32	21/32	16.67	0.6563	91.0	143.0	48.0	18.00
R45317.0	–	17.00	0.6693	91.0	143.0	48.0	18.00
R45343/64	43/64	17.07	0.6720	91.0	143.0	48.0	18.00
R45311/16	11/16	17.46	0.6874	91.0	143.0	48.0	18.00
R45317.5	–	17.50	0.6890	91.0	143.0	48.0	18.00
R45317.8	–	17.80	0.7008	91.0	143.0	48.0	18.00
R45345/64	45/64	17.86	0.7031	91.0	143.0	48.0	18.00
R45318.0	–	18.00	0.7087	91.0	143.0	48.0	18.00
R45323/32	23/32	18.26	0.7189	99.0	153.0	50.0	20.00
R45318.5	–	18.50	0.7283	99.0	153.0	50.0	20.00
R45347/64	47/64	18.65	0.7343	99.0	153.0	50.0	20.00
R45319.0	–	19.00	0.7480	99.0	153.0	50.0	20.00
R4533/4	3/4	19.05	0.7500	99.0	153.0	50.0	20.00
R45319.5	–	19.50	0.7677	99.0	153.0	50.0	20.00
R45319.8	–	19.80	0.7795	99.0	153.0	50.0	20.00
R45320.0	–	20.00	0.7874	99.0	153.0	50.0	20.00

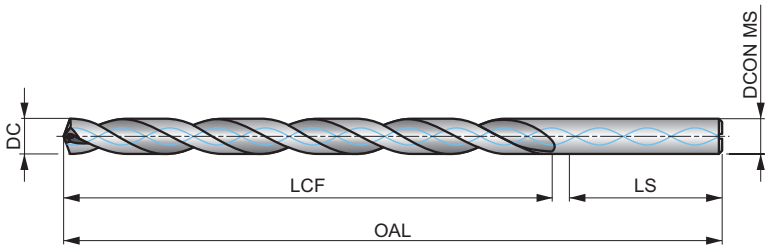
R459

DORMER

Force X 8倍径内冷合金钻，氮铝化钛涂层。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(H9公差)，自定心的140°钻尖角、四后面的分离式钻尖以及CTW槽型增强了穿透力，内冷孔提高了排屑能力，氮铝化钛涂层提高了表面硬度并延长了刀具寿命。

FORCE X

HM	DORMER	8×D
140°	TiAlN	DIN 6535HA
CTW	R	
DC m7		



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
143 V	160 V	166 V	122 V	108 U	95 U	106 U	86 U	72 U	63 U	54 U	44 T	60 V	51 V
M2.1	**M2.2**	**M2.3**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**M4.2**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**
54 V	44 V	37 U	33 V	28 V	26 V	24 U	21 U	88 W	65 W	49 W	78 V	64 V	51 V
K3.1	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**
70 V	54 V	43 V	65 V	49 V	36 V	30 V	26 V	73 V	55 V	42 V	200 W	150 W	100 W
N2.1	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**								
246 V	222 V	160 V	298 V	176 V	88 V								

DCON MS公差h6

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
R4593.0	–	3.00	0.1181	37.0	79.0	36.0	6.00
R4593.1	–	3.10	0.1220	37.0	79.0	36.0	6.00
R4591/8	1/8	3.18	0.1250	37.0	79.0	36.0	6.00
R4593.2	–	3.20	0.1260	37.0	79.0	36.0	6.00
R4593.3	–	3.30	0.1299	37.0	79.0	36.0	6.00
R4593.4	–	3.40	0.1339	37.0	79.0	36.0	6.00
R4593.5	–	3.50	0.1378	37.0	79.0	36.0	6.00
R4599/64	9/64	3.57	0.1406	37.0	79.0	36.0	6.00
R4593.6	–	3.60	0.1417	37.0	79.0	36.0	6.00
R4593.7	–	3.70	0.1457	37.0	79.0	36.0	6.00
R4593.8	–	3.80	0.1496	48.0	90.0	36.0	6.00
R4593.9	–	3.90	0.1535	48.0	90.0	36.0	6.00
R4595/32	5/32	3.97	0.1563	48.0	90.0	36.0	6.00
R4594.0	–	4.00	0.1575	48.0	90.0	36.0	6.00
R4594.1	–	4.10	0.1614	48.0	90.0	36.0	6.00
R4594.2	–	4.20	0.1654	48.0	90.0	36.0	6.00
R4594.3	–	4.30	0.1693	48.0	90.0	36.0	6.00
R45911/64	11/64	4.37	0.1719	48.0	90.0	36.0	6.00
R4594.4	–	4.40	0.1732	48.0	90.0	36.0	6.00
R4594.5	–	4.50	0.1772	48.0	90.0	36.0	6.00
R4594.6	–	4.60	0.1811	48.0	90.0	36.0	6.00
R4594.7	–	4.70	0.1850	62.0	104.0	36.0	6.00
R4593/16	3/16	4.76	0.1875	62.0	104.0	36.0	6.00
R4594.8	–	4.80	0.1890	62.0	104.0	36.0	6.00
R4594.9	–	4.90	0.1929	62.0	104.0	36.0	6.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4595.0	–	5.00	0.1969	62.0	104.0	36.0	6.00
R4595.1	–	5.10	0.2008	62.0	104.0	36.0	6.00
R45913/64	13/64	5.16	0.2031	62.0	104.0	36.0	6.00
R4595.2	–	5.20	0.2047	62.0	104.0	36.0	6.00
R4595.3	–	5.30	0.2087	62.0	104.0	36.0	6.00
R4595.4	–	5.40	0.2126	62.0	104.0	36.0	6.00
R4595.5	–	5.50	0.2165	62.0	104.0	36.0	6.00
R4597/32	7/32	5.56	0.2188	62.0	104.0	36.0	6.00
R4595.6	–	5.60	0.2205	62.0	104.0	36.0	6.00
R4595.7	–	5.70	0.2244	62.0	104.0	36.0	6.00
R4595.8	–	5.80	0.2283	62.0	104.0	36.0	6.00
R4595.9	–	5.90	0.2323	62.0	104.0	36.0	6.00
R45915/64	15/64	5.95	0.2344	62.0	104.0	36.0	6.00
R4596.0	–	6.00	0.2362	62.0	104.0	36.0	6.00
R4596.1	–	6.10	0.2402	84.0	126.0	36.0	8.00
R4596.2	–	6.20	0.2441	84.0	126.0	36.0	8.00
R4596.3	–	6.30	0.2480	84.0	126.0	36.0	8.00
R4591/4	1/4	6.35	0.2500	84.0	126.0	36.0	8.00
R4596.4	–	6.40	0.2520	84.0	126.0	36.0	8.00
R4596.5	–	6.50	0.2559	84.0	126.0	36.0	8.00
R4596.6	–	6.60	0.2598	84.0	126.0	36.0	8.00
R4596.7	–	6.70	0.2638	84.0	126.0	36.0	8.00
R45917/64	17/64	6.75	0.2656	84.0	126.0	36.0	8.00
R4596.8	–	6.80	0.2677	84.0	126.0	36.0	8.00
R4596.9	–	6.90	0.2717	84.0	126.0	36.0	8.00
R4597.0	–	7.00	0.2756	84.0	126.0	36.0	8.00
R4597.1	–	7.10	0.2795	84.0	126.0	36.0	8.00
R4599/32	9/32	7.14	0.2813	84.0	126.0	36.0	8.00
R4597.2	–	7.20	0.2835	84.0	126.0	36.0	8.00
R4597.3	–	7.30	0.2874	84.0	126.0	36.0	8.00
R4597.4	–	7.40	0.2913	84.0	126.0	36.0	8.00
R4597.5	–	7.50	0.2953	84.0	126.0	36.0	8.00
R45919/64	19/64	7.54	0.2969	84.0	126.0	36.0	8.00
R4597.6	–	7.60	0.2992	84.0	126.0	36.0	8.00
R4597.7	–	7.70	0.3031	84.0	126.0	36.0	8.00
R4597.8	–	7.80	0.3071	84.0	126.0	36.0	8.00
R4597.9	–	7.90	0.3110	84.0	126.0	36.0	8.00
R4595/16	5/16	7.94	0.3125	84.0	126.0	36.0	8.00
R4598.0	–	8.00	0.3150	84.0	126.0	36.0	8.00
R4598.1	–	8.10	0.3189	106.0	152.0	40.0	10.00
R4598.2	–	8.20	0.3228	106.0	152.0	40.0	10.00
R4598.3	–	8.30	0.3268	106.0	152.0	40.0	10.00
R45921/64	21/64	8.33	0.3281	106.0	152.0	40.0	10.00
R4598.4	–	8.40	0.3307	106.0	152.0	40.0	10.00
R4598.5	–	8.50	0.3346	106.0	152.0	40.0	10.00
R4598.6	–	8.60	0.3386	106.0	152.0	40.0	10.00
R4598.7	–	8.70	0.3425	106.0	152.0	40.0	10.00
R45911/32	11/32	8.73	0.3438	106.0	152.0	40.0	10.00
R4598.8	–	8.80	0.3465	106.0	152.0	40.0	10.00
R4598.9	–	8.90	0.3504	106.0	152.0	40.0	10.00
R4599.0	–	9.00	0.3543	106.0	152.0	40.0	10.00
R4599.1	–	9.10	0.3583	106.0	152.0	40.0	10.00
R45923/64	23/64	9.13	0.3594	106.0	152.0	40.0	10.00
R4599.2	–	9.20	0.3622	106.0	152.0	40.0	10.00
R4599.3	–	9.30	0.3661	106.0	152.0	40.0	10.00
R4599.4	–	9.40	0.3701	106.0	152.0	40.0	10.00
R4599.5	–	9.50	0.3740	106.0	152.0	40.0	10.00
R4593/8	3/8	9.53	0.3750	106.0	152.0	40.0	10.00
R4599.6	–	9.60	0.3780	106.0	152.0	40.0	10.00
R4599.7	–	9.70	0.3819	106.0	152.0	40.0	10.00
R4599.8	–	9.80	0.3858	106.0	152.0	40.0	10.00
R4599.9	–	9.90	0.3898	106.0	152.0	40.0	10.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R45925/64	25/64	9.92	0.3906	106.0	152.0	40.0	10.00
R45910.0	–	10.00	0.3937	106.0	152.0	40.0	10.00
R45910.2	–	10.20	0.4016	128.0	180.0	45.0	12.00
R45910.3	–	10.30	0.4055	128.0	180.0	45.0	12.00
R45913/32	13/32	10.32	0.4063	128.0	180.0	45.0	12.00
R45910.4	–	10.40	0.4094	128.0	180.0	45.0	12.00
R45910.5	–	10.50	0.4134	128.0	180.0	45.0	12.00
R45927/64	27/64	10.72	0.4219	128.0	180.0	45.0	12.00
R45910.8	–	10.80	0.4252	128.0	180.0	45.0	12.00
R45911.0	–	11.00	0.4331	128.0	180.0	45.0	12.00
R4597/16	7/16	11.11	0.4375	128.0	180.0	45.0	12.00
R45911.2	–	11.20	0.4409	128.0	180.0	45.0	12.00
R45911.3	–	11.30	0.4449	128.0	180.0	45.0	12.00
R45911.5	–	11.50	0.4528	128.0	180.0	45.0	12.00
R45929/64	29/64	11.51	0.4531	128.0	180.0	45.0	12.00
R45911.8	–	11.80	0.4646	128.0	180.0	45.0	12.00
R45915/32	15/32	11.91	0.4688	128.0	180.0	45.0	12.00
R45912.0	–	12.00	0.4724	128.0	180.0	45.0	12.00
R45912.2	–	12.20	0.4803	151.0	202.0	48.0	14.00
R45931/64	31/64	12.30	0.4844	151.0	202.0	48.0	14.00
R45912.5	–	12.50	0.4921	151.0	202.0	48.0	14.00
R4591/2	1/2	12.70	0.5000	151.0	202.0	48.0	14.00
R45912.8	–	12.80	0.5039	151.0	202.0	48.0	14.00
R45913.0	–	13.00	0.5118	151.0	202.0	48.0	14.00
R45933/64	33/64	13.10	0.5156	151.0	202.0	48.0	14.00
R45917/32	17/32	13.49	0.5313	151.0	202.0	48.0	14.00
R45913.5	–	13.50	0.5315	151.0	202.0	48.0	14.00
R45935/64	35/64	13.89	0.5469	151.0	202.0	48.0	14.00
R45914.0	–	14.00	0.5512	151.0	202.0	48.0	14.00
R45914.25	–	14.25	0.5610	172.0	227.0	48.0	16.00
R4599/16	9/16	14.29	0.5625	172.0	227.0	48.0	16.00
R45914.5	–	14.50	0.5709	172.0	227.0	48.0	16.00
R45937/64	37/64	14.68	0.5781	172.0	227.0	48.0	16.00
R45915.0	–	15.00	0.5906	172.0	227.0	48.0	16.00
R45919/32	19/32	15.08	0.5938	172.0	227.0	48.0	16.00
R45915.1	–	15.10	0.5945	172.0	227.0	48.0	16.00
R45915.5	–	15.50	0.6102	172.0	227.0	48.0	16.00
R4595/8	5/8	15.88	0.6250	172.0	227.0	48.0	16.00
R45916.0	–	16.00	0.6299	172.0	227.0	48.0	16.00

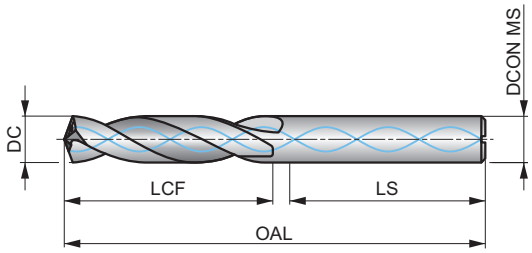
R467

DORMER

Force M 3倍径内冷合金钻，氮铝化钛涂层。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(不锈钢和耐热材料实现H9公差)，140°钻尖角、四后面的分离式钻尖以及CTW槽型，内冷孔提高了排屑能力，氮铝化钛涂层提高了表面硬度并延长了刀具寿命，适用于多种材料的切削。

FORCE M

HM	DIN 6537K	3×D
140°	TiAlN	DIN 6535HA
CTW	R	
DC m7		



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

M1.1	M1.2	M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	S1.1	S1.2	S1.3	S2.1
117 G	99 G	104 G	85 G	71 E	87 G	75 G	68 F	60 F	52 E	55 V	45 V	40 U	60 U

S2.2	S3.1	S3.2	S4.1	S4.2
56 U	45 U	40 U	35 U	32 U

DCON MS公差h6

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
R4673.0	–	3.00	0.1181	20.0	62.0	36.0	6.00
R4673.1	–	3.10	0.1220	20.0	62.0	36.0	6.00
R4671/8	1/8	3.18	0.1250	20.0	62.0	36.0	6.00
R4673.2	–	3.20	0.1260	20.0	62.0	36.0	6.00
R4673.3	–	3.30	0.1299	20.0	62.0	36.0	6.00
R4673.4	–	3.40	0.1339	20.0	62.0	36.0	6.00
R467N29	N29	3.45	0.1360	20.0	62.0	36.0	6.00
R4673.5	–	3.50	0.1378	20.0	62.0	36.0	6.00
R4679/64	9/64	3.57	0.1406	20.0	62.0	36.0	6.00
R4673.6	–	3.60	0.1417	20.0	62.0	36.0	6.00
R4673.7	–	3.70	0.1457	20.0	62.0	36.0	6.00
R4673.8	–	3.80	0.1496	24.0	66.0	36.0	6.00
R4673.9	–	3.90	0.1535	24.0	66.0	36.0	6.00
R4675/32	5/32	3.97	0.1563	24.0	66.0	36.0	6.00
R4674.0	–	4.00	0.1575	24.0	66.0	36.0	6.00
R4674.05	–	4.05	0.1594	24.0	66.0	36.0	6.00
R4674.1	–	4.10	0.1614	24.0	66.0	36.0	6.00
R4674.2	–	4.20	0.1654	24.0	66.0	36.0	6.00
R4674.3	–	4.30	0.1693	24.0	66.0	36.0	6.00
R46711/64	11/64	4.37	0.1719	24.0	66.0	36.0	6.00
R4674.4	–	4.40	0.1732	24.0	66.0	36.0	6.00
R4674.5	–	4.50	0.1772	24.0	66.0	36.0	6.00
R4674.6	–	4.60	0.1811	24.0	66.0	36.0	6.00
R4674.7	–	4.70	0.1850	24.0	66.0	36.0	6.00
R4673/16	3/16	4.76	0.1875	28.0	66.0	36.0	6.00
R4674.8	–	4.80	0.1890	28.0	66.0	36.0	6.00
R4674.9	–	4.90	0.1929	28.0	66.0	36.0	6.00
R4675.0	–	5.00	0.1969	28.0	66.0	36.0	6.00
R4675.05	–	5.05	0.1988	28.0	66.0	36.0	6.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4675.1	–	5.10	0.2008	28.0	66.0	36.0	6.00
R467N7	N7	5.11	0.2010	28.0	66.0	36.0	6.00
R46713/64	13/64	5.16	0.2031	28.0	66.0	36.0	6.00
R4675.2	–	5.20	0.2047	28.0	66.0	36.0	6.00
R467N5	N5	5.22	0.2055	28.0	66.0	36.0	6.00
R4675.3	–	5.30	0.2087	28.0	66.0	36.0	6.00
R4675.4	–	5.40	0.2126	28.0	66.0	36.0	6.00
R4675.5	–	5.50	0.2165	28.0	66.0	36.0	6.00
R4677/32	7/32	5.56	0.2188	28.0	66.0	36.0	6.00
R4675.6	–	5.60	0.2205	28.0	66.0	36.0	6.00
R4675.7	–	5.70	0.2244	28.0	66.0	36.0	6.00
R4675.8	–	5.80	0.2283	28.0	66.0	36.0	6.00
R4675.9	–	5.90	0.2323	28.0	66.0	36.0	6.00
R46715/64	15/64	5.95	0.2344	28.0	66.0	36.0	6.00
R4676.0	–	6.00	0.2362	28.0	66.0	36.0	6.00
R4676.05	–	6.05	0.2382	34.0	79.0	36.0	8.00
R4676.1	–	6.10	0.2402	34.0	79.0	36.0	8.00
R4676.2	–	6.20	0.2441	34.0	79.0	36.0	8.00
R4676.3	–	6.30	0.2480	34.0	79.0	36.0	8.00
R4671/4	1/4	6.35	0.2500	34.0	79.0	36.0	8.00
R4676.4	–	6.40	0.2520	34.0	79.0	36.0	8.00
R4676.5	–	6.50	0.2559	34.0	79.0	36.0	8.00
R4676.6	–	6.60	0.2598	34.0	79.0	36.0	8.00
R4676.7	–	6.70	0.2638	34.0	79.0	36.0	8.00
R46717/64	17/64	6.75	0.2656	34.0	79.0	36.0	8.00
R4676.8	–	6.80	0.2677	34.0	79.0	36.0	8.00
R4676.9	–	6.90	0.2717	34.0	79.0	36.0	8.00
R4677.0	–	7.00	0.2756	34.0	79.0	36.0	8.00
R4677.1	–	7.10	0.2795	41.0	79.0	36.0	8.00
R4679/32	9/32	7.14	0.2813	41.0	79.0	36.0	8.00
R4677.2	–	7.20	0.2835	41.0	79.0	36.0	8.00
R4677.3	–	7.30	0.2874	41.0	79.0	36.0	8.00
R4677.4	–	7.40	0.2913	41.0	79.0	36.0	8.00
R4677.5	–	7.50	0.2953	41.0	79.0	36.0	8.00
R46719/64	19/64	7.54	0.2969	41.0	79.0	36.0	8.00
R4677.6	–	7.60	0.2992	41.0	79.0	36.0	8.00
R4677.7	–	7.70	0.3031	41.0	79.0	36.0	8.00
R4677.8	–	7.80	0.3071	41.0	79.0	36.0	8.00
R4675/16	5/16	7.94	0.3125	41.0	79.0	36.0	8.00
R4678.0	–	8.00	0.3150	41.0	79.0	36.0	8.00
R4678.05	–	8.05	0.3169	47.0	89.0	40.0	10.00
R4678.1	–	8.10	0.3189	47.0	89.0	40.0	10.00
R4678.2	–	8.20	0.3228	47.0	89.0	40.0	10.00
R4678.3	–	8.30	0.3268	47.0	89.0	40.0	10.00
R4678.4	–	8.40	0.3307	47.0	89.0	40.0	10.00
R4678.5	–	8.50	0.3346	47.0	89.0	40.0	10.00
R4678.6	–	8.60	0.3386	47.0	89.0	40.0	10.00
R4678.7	–	8.70	0.3425	47.0	89.0	40.0	10.00
R46711/32	11/32	8.73	0.3438	47.0	89.0	40.0	10.00
R4678.8	–	8.80	0.3465	47.0	89.0	40.0	10.00
R4678.9	–	8.90	0.3504	47.0	89.0	40.0	10.00
R4679.0	–	9.00	0.3543	47.0	89.0	40.0	10.00
R4679.1	–	9.10	0.3583	47.0	89.0	40.0	10.00
R46723/64	23/64	9.13	0.3594	47.0	89.0	40.0	10.00
R4679.3	–	9.30	0.3661	47.0	89.0	40.0	10.00
R4679.4	–	9.40	0.3701	47.0	89.0	40.0	10.00
R4679.5	–	9.50	0.3740	47.0	89.0	40.0	10.00
R4673/8	3/8	9.53	0.3750	47.0	89.0	40.0	10.00
R4679.6	–	9.60	0.3780	47.0	89.0	40.0	10.00
R4679.7	–	9.70	0.3819	47.0	89.0	40.0	10.00
R4679.8	–	9.80	0.3858	47.0	89.0	40.0	10.00
R4679.9	–	9.90	0.3898	47.0	89.0	40.0	10.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R46725/64	25/64	9.92	0.3906	47.0	89.0	40.0	10.00
R46710.0	–	10.00	0.3937	47.0	89.0	40.0	10.00
R46710.05	–	10.05	0.3957	55.0	102.0	45.0	12.00
R46710.1	–	10.10	0.3976	55.0	102.0	45.0	12.00
R46710.2	–	10.20	0.4016	55.0	102.0	45.0	12.00
R46710.3	–	10.30	0.4055	55.0	102.0	45.0	12.00
R46713/32	13/32	10.32	0.4063	55.0	102.0	45.0	12.00
R46710.4	–	10.40	0.4094	55.0	102.0	45.0	12.00
R46710.5	–	10.50	0.4134	55.0	102.0	45.0	12.00
R46710.6	–	10.60	0.4173	55.0	102.0	45.0	12.00
R46727/64	27/64	10.72	0.4219	55.0	102.0	45.0	12.00
R46710.9	–	10.90	0.4291	55.0	102.0	45.0	12.00
R46711.0	–	11.00	0.4331	55.0	102.0	45.0	12.00
R4677/16	7/16	11.11	0.4375	55.0	102.0	45.0	12.00
R46711.2	–	11.20	0.4409	55.0	102.0	45.0	12.00
R46711.4	–	11.40	0.4488	55.0	102.0	45.0	12.00
R46711.5	–	11.50	0.4528	55.0	102.0	45.0	12.00
R46729/64	29/64	11.51	0.4531	55.0	102.0	45.0	12.00
R46711.8	–	11.80	0.4646	55.0	102.0	45.0	12.00
R46715/32	15/32	11.91	0.4688	55.0	102.0	45.0	12.00
R46712.0	–	12.00	0.4724	55.0	102.0	45.0	12.00
R46712.05	–	12.05	0.4744	60.0	107.0	45.0	14.00
R46712.1	–	12.10	0.4764	60.0	107.0	45.0	14.00
R46712.2	–	12.20	0.4803	60.0	107.0	45.0	14.00
R46731/64	31/64	12.30	0.4844	60.0	107.0	45.0	14.00
R46712.5	–	12.50	0.4921	60.0	107.0	45.0	14.00
R46712.7	–	12.70	0.5000	60.0	107.0	45.0	14.00
R4671/2	1/2	12.70	0.5000	60.0	107.0	45.0	14.00
R46713.0	–	13.00	0.5118	60.0	107.0	45.0	14.00
R46733/64	33/64	13.10	0.5156	60.0	107.0	45.0	14.00
R46717/32	17/32	13.49	0.5313	60.0	107.0	45.0	14.00
R46713.5	–	13.50	0.5315	60.0	107.0	45.0	14.00
R46735/64	35/64	13.89	0.5469	60.0	107.0	45.0	14.00
R46714.0	–	14.00	0.5512	60.0	107.0	45.0	14.00
R46714.25	–	14.25	0.5610	65.0	115.0	48.0	16.00
R4679/16	9/16	14.29	0.5625	65.0	115.0	48.0	16.00
R46714.5	–	14.50	0.5709	65.0	115.0	48.0	16.00
R46737/64	37/64	14.68	0.5781	65.0	115.0	48.0	16.00
R46715.0	–	15.00	0.5906	65.0	115.0	48.0	16.00
R46719/32	19/32	15.08	0.5938	65.0	115.0	48.0	16.00
R46715.1	–	15.10	0.5945	65.0	115.0	48.0	16.00
R46715.3	–	15.30	0.6024	65.0	115.0	48.0	16.00
R46715.5	–	15.50	0.6102	65.0	115.0	48.0	16.00
R4675/8	5/8	15.88	0.6250	65.0	115.0	48.0	16.00
R46716.0	–	16.00	0.6299	65.0	115.0	48.0	16.00

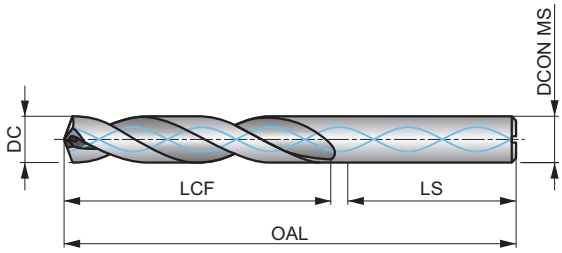
R463

DORMER

Force M 5倍径内冷合金钻，氮铝化钛涂层。
高性能钻头，能够高转速高进给地加工高质量和高精度的孔(不锈钢和耐热材料实现H9公差)，140°钻尖角、四后面的分离式钻尖以及CTW槽型，内冷孔提高了排屑能力，氮铝化钛涂层提高了表面硬度并延长了刀具寿命，适用于多种材料的切削。

FORCE M

HM	DIN 6537L	5×D
140°	TiAlN	DIN 6535HA
CTW	R	
DC m7		



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

M1.1	M1.2	M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	S1.1	S1.2	S1.3	S2.1
111 G	94 G	99 G	81 G	67 E	83 G	71 G	65 F	57 F	49 E	52 V	43 V	38 U	57 U

S2.2	S3.1	S3.2	S4.1	S4.2
53 U	43 U	38 U	33 U	30 U

DCON MS公差h6

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	LS (mm)	DCON MS (mm)
R4633.0	–	3.00	0.1181	28.0	66.0	36.0	6.00
R4633.1	–	3.10	0.1220	28.0	66.0	36.0	6.00
R4631/8	1/8	3.18	0.1250	28.0	66.0	36.0	6.00
R4633.2	–	3.20	0.1260	28.0	66.0	36.0	6.00
R4633.3	–	3.30	0.1299	28.0	66.0	36.0	6.00
R4633.4	–	3.40	0.1339	28.0	66.0	36.0	6.00
R463N29	N29	3.45	0.1360	28.0	66.0	36.0	6.00
R4633.5	–	3.50	0.1378	28.0	66.0	36.0	6.00
R4639/64	9/64	3.57	0.1406	28.0	66.0	36.0	6.00
R4633.6	–	3.60	0.1417	28.0	66.0	36.0	6.00
R4633.7	–	3.70	0.1457	28.0	66.0	36.0	6.00
R4633.8	–	3.80	0.1496	36.0	74.0	36.0	6.00
R4633.9	–	3.90	0.1535	36.0	74.0	36.0	6.00
R4635/32	5/32	3.97	0.1563	36.0	74.0	36.0	6.00
R4634.0	–	4.00	0.1575	36.0	74.0	36.0	6.00
R4634.05	–	4.05	0.1594	36.0	74.0	36.0	6.00
R4634.1	–	4.10	0.1614	36.0	74.0	36.0	6.00
R4634.2	–	4.20	0.1654	36.0	74.0	36.0	6.00
R4634.3	–	4.30	0.1693	36.0	74.0	36.0	6.00
R46311/64	11/64	4.37	0.1719	36.0	74.0	36.0	6.00
R4634.4	–	4.40	0.1732	36.0	74.0	36.0	6.00
R4634.5	–	4.50	0.1772	36.0	74.0	36.0	6.00
R4634.6	–	4.60	0.1811	36.0	74.0	36.0	6.00
R4634.7	–	4.70	0.1850	36.0	74.0	36.0	6.00
R4633/16	3/16	4.76	0.1875	44.0	82.0	36.0	6.00
R4634.8	–	4.80	0.1890	44.0	82.0	36.0	6.00
R4634.9	–	4.90	0.1929	44.0	82.0	36.0	6.00
R4635.0	–	5.00	0.1969	44.0	82.0	36.0	6.00
R4635.05	–	5.05	0.1988	44.0	82.0	36.0	6.00

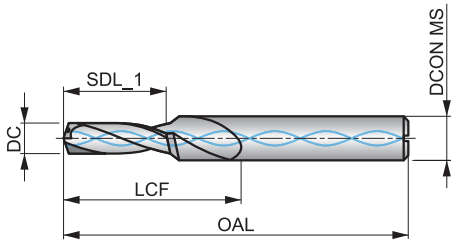
Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R4635.1	–	5.10	0.2008	44.0	82.0	36.0	6.00
R463N7	N7	5.11	0.2010	44.0	82.0	36.0	6.00
R46313/64	13/64	5.16	0.2031	44.0	82.0	36.0	6.00
R4635.2	–	5.20	0.2047	44.0	82.0	36.0	6.00
R463N5	N5	5.22	0.2055	44.0	82.0	36.0	6.00
R4635.3	–	5.30	0.2087	44.0	82.0	36.0	6.00
R4635.5	–	5.50	0.2165	44.0	82.0	36.0	6.00
R4637/32	7/32	5.56	0.2188	44.0	82.0	36.0	6.00
R4635.6	–	5.60	0.2205	44.0	82.0	36.0	6.00
R4635.7	–	5.70	0.2244	44.0	82.0	36.0	6.00
R4635.8	–	5.80	0.2283	44.0	82.0	36.0	6.00
R4635.9	–	5.90	0.2323	44.0	82.0	36.0	6.00
R46315/64	15/64	5.95	0.2344	44.0	82.0	36.0	6.00
R4636.0	–	6.00	0.2362	44.0	82.0	36.0	6.00
R4636.05	–	6.05	0.2382	53.0	91.0	36.0	8.00
R4636.1	–	6.10	0.2402	53.0	91.0	36.0	8.00
R4636.2	–	6.20	0.2441	53.0	91.0	36.0	8.00
R4636.3	–	6.30	0.2480	53.0	91.0	36.0	8.00
R4631/4	1/4	6.35	0.2500	53.0	91.0	36.0	8.00
R4636.4	–	6.40	0.2520	53.0	91.0	36.0	8.00
R4636.5	–	6.50	0.2559	53.0	91.0	36.0	8.00
R4636.6	–	6.60	0.2598	53.0	91.0	36.0	8.00
R4636.7	–	6.70	0.2638	53.0	91.0	36.0	8.00
R46317/64	17/64	6.75	0.2656	53.0	91.0	36.0	8.00
R4636.8	–	6.80	0.2677	53.0	91.0	36.0	8.00
R4636.9	–	6.90	0.2717	53.0	91.0	36.0	8.00
R4637.0	–	7.00	0.2756	53.0	91.0	36.0	8.00
R4637.1	–	7.10	0.2795	53.0	91.0	36.0	8.00
R4637.2	–	7.20	0.2835	53.0	91.0	36.0	8.00
R4637.3	–	7.30	0.2874	53.0	91.0	36.0	8.00
R4637.4	–	7.40	0.2913	53.0	91.0	36.0	8.00
R4637.5	–	7.50	0.2953	53.0	91.0	36.0	8.00
R4637.6	–	7.60	0.2992	53.0	91.0	36.0	8.00
R4637.7	–	7.70	0.3031	53.0	91.0	36.0	8.00
R4637.8	–	7.80	0.3071	53.0	91.0	36.0	8.00
R4637.9	–	7.90	0.3110	53.0	91.0	36.0	8.00
R4635/16	5/16	7.94	0.3125	53.0	91.0	36.0	8.00
R4638.0	–	8.00	0.3150	53.0	91.0	36.0	8.00
R4638.05	–	8.05	0.3169	61.0	103.0	40.0	10.00
R4638.1	–	8.10	0.3189	61.0	103.0	40.0	10.00
R4638.2	–	8.20	0.3228	61.0	103.0	40.0	10.00
R4638.3	–	8.30	0.3268	61.0	103.0	40.0	10.00
R46321/64	21/64	8.33	0.3281	61.0	103.0	40.0	10.00
R4638.4	–	8.40	0.3307	61.0	103.0	40.0	10.00
R4638.5	–	8.50	0.3346	61.0	103.0	40.0	10.00
R4638.6	–	8.60	0.3386	61.0	103.0	40.0	10.00
R4638.7	–	8.70	0.3425	61.0	103.0	40.0	10.00
R46311/32	11/32	8.73	0.3438	61.0	103.0	40.0	10.00
R4638.8	–	8.80	0.3465	61.0	103.0	40.0	10.00
R4638.9	–	8.90	0.3504	61.0	103.0	40.0	10.00
R4639.0	–	9.00	0.3543	61.0	103.0	40.0	10.00
R4639.1	–	9.10	0.3583	61.0	103.0	40.0	10.00
R46323/64	23/64	9.13	0.3594	61.0	103.0	40.0	10.00
R4639.2	–	9.20	0.3622	61.0	103.0	40.0	10.00
R4639.3	–	9.30	0.3661	61.0	103.0	40.0	10.00
R4639.4	–	9.40	0.3701	61.0	103.0	40.0	10.00
R4639.5	–	9.50	0.3740	61.0	103.0	40.0	10.00
R4633/8	3/8	9.53	0.3750	61.0	103.0	40.0	10.00
R4639.6	–	9.60	0.3780	61.0	103.0	40.0	10.00
R4639.7	–	9.70	0.3819	61.0	103.0	40.0	10.00
R4639.8	–	9.80	0.3858	61.0	103.0	40.0	10.00
R4639.9	–	9.90	0.3898	61.0	103.0	40.0	10.00

Product	DC	DC	DC	LCF	OAL	LS	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)	(mm)
R46310.0	–	10.00	0.3937	61.0	103.0	40.0	10.00
R46310.05	–	10.05	0.3957	70.0	118.0	45.0	12.00
R46310.1	–	10.10	0.3976	70.0	118.0	45.0	12.00
R46310.2	–	10.20	0.4016	70.0	118.0	45.0	12.00
R46310.3	–	10.30	0.4055	70.0	118.0	45.0	12.00
R46313/32	13/32	10.32	0.4063	70.0	118.0	45.0	12.00
R46310.4	–	10.40	0.4094	70.0	118.0	45.0	12.00
R46310.5	–	10.50	0.4134	70.0	118.0	45.0	12.00
R46327/64	27/64	10.72	0.4219	70.0	118.0	45.0	12.00
R46310.8	–	10.80	0.4252	70.0	118.0	45.0	12.00
R46311.0	–	11.00	0.4331	70.0	118.0	45.0	12.00
R4637/16	7/16	11.11	0.4375	70.0	118.0	45.0	12.00
R46311.2	–	11.20	0.4409	70.0	118.0	45.0	12.00
R46311.3	–	11.30	0.4449	70.0	118.0	45.0	12.00
R46311.4	–	11.40	0.4488	70.0	118.0	45.0	12.00
R46311.5	–	11.50	0.4528	70.0	118.0	45.0	12.00
R46329/64	29/64	11.51	0.4531	70.0	118.0	45.0	12.00
R46311.6	–	11.60	0.4567	70.0	118.0	45.0	12.00
R46311.8	–	11.80	0.4646	70.0	118.0	45.0	12.00
R46315/32	15/32	11.91	0.4688	70.0	118.0	45.0	12.00
R46312.0	–	12.00	0.4724	70.0	118.0	45.0	12.00
R46312.05	–	12.05	0.4744	76.0	124.0	45.0	14.00
R46312.2	–	12.20	0.4803	76.0	124.0	45.0	14.00
R46331/64	31/64	12.30	0.4844	76.0	124.0	45.0	14.00
R46312.5	–	12.50	0.4921	76.0	124.0	45.0	14.00
R46312.7	–	12.70	0.5000	76.0	124.0	45.0	14.00
R4631/2	1/2	12.70	0.5000	76.0	124.0	45.0	14.00
R46312.8	–	12.80	0.5039	76.0	124.0	45.0	14.00
R46313.0	–	13.00	0.5118	76.0	124.0	45.0	14.00
R46333/64	33/64	13.10	0.5156	76.0	124.0	45.0	14.00
R46313.5	–	13.50	0.5315	76.0	124.0	45.0	14.00
R46313.8	–	13.80	0.5433	76.0	124.0	45.0	14.00
R46314.0	–	14.00	0.5512	76.0	124.0	45.0	14.00
R46314.25	–	14.25	0.5610	82.0	133.0	48.0	16.00
R46314.5	–	14.50	0.5709	82.0	133.0	48.0	16.00
R46315.0	–	15.00	0.5906	82.0	133.0	48.0	16.00
R46315.3	–	15.30	0.6024	82.0	133.0	48.0	16.00
R46315.5	–	15.50	0.6102	82.0	133.0	48.0	16.00
R46315.8	–	15.80	0.6220	82.0	133.0	48.0	16.00
R46316.0	–	16.00	0.6299	82.0	133.0	48.0	16.00

R7131

DORMER

合金内冷阶梯钻，氮铝化钛涂层。
多功能钻头，具有特殊的导向直径和导向长度，以满足公制螺纹的孔径尺寸和深度，一道工序完成钻孔和倒角能够减少节拍时间和刀具库存，140°的钻尖角和90°的倒角，氮铝化钛涂层提高了切削性能并延长了刀具寿命，适用于多种材料的切削。



HM	DORMER	3×D
90°	TiAlN	DIN 6535HA
λ20-35°	R	
DC m7		

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	M1.1	M1.2	M2.1
139 W	156 W	161 W	119 W	105 W	93 V	96 V	77 V	65 V	57 V	48 V	62 V	52 V	55 V
M2.2	M3.1	M3.2	M3.3	M4.1	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3
45 V	47 V	40 V	36 U	35 U	90 W	67 W	50 W	92 V	75 V	60 V	82 V	62 V	50 V
K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3
76 V	57 V	42 V	36 V	30 V	86 V	64 V	50 V	250 W	188 W	125 W	308 V	277 V	200 V
N3.1	N3.2	N3.3											
373 W	220 W	110 W											

DCON MS公差h6

Product	DC (mm)	DC (inch)	SDL_1 (mm)	LCF (mm)	OAL (mm)	DCON MS (mm)	TDZ
R71313.3	3.30	0.1299	11.40	20.0	66.0	6.00	M4
R71314.2	4.20	0.1654	13.60	24.0	66.0	6.00	M5
R71315.0	5.00	0.1969	16.50	28.0	79.0	8.00	M6
R71316.8	6.80	0.2677	21.00	34.0	89.0	10.00	M8
R71318.5	8.50	0.3346	25.50	47.0	102.0	12.00	M10
R713110.2	10.20	0.4016	30.00	55.0	107.0	14.00	M12
R713110.4	10.40	0.4094	30.00	55.0	107.0	14.00	M12

材料代码(BMC)	HSS	HSS	HSS	HSS	HSS	HM	HM						
基本标准组(BSG)	DORMER	DORMER	DORMER	DORMER	DORMER	DORMER	DORMER						
有用长度直径比 (ULDR)	1.5×D	3×D	5×D	8×D	12×D								
应用角度						140°	140°						
涂层	Bright Ni	Bright Ni	Bright Ni	Bright Ni	Bright Ni	Ti-phon	Ti-phon						
柄部	ISO 9766	DIN 6535HB DIN 6535HE	DIN 6535HB DIN 6535HE	DIN 6535HB DIN 6535HE									
旋向(切削方向)	R	R	R	R	R	R	R						
冷却液 (CSP)													
	HYDRA	HYDRA	HYDRA	HYDRA	HYDRA	HYDRA	HYDRA	HYDRA	HYDRA				
产品系列代码	H851	H853	H855	H858	H8512	R950	R960	H860	H861				
PSF切削直径范围	31/64 - 30.00	12.00 - 42.50	12.00 - 42.50	14.00 - 42.50	14.00 - 25.00	15/32 - 42.00	15/32 - 30.50	N1 - N7	N1 - N5				
	218	219	221	223	224	225	227	229	229				
P	P1						◪	■					
	P2						■	◪					
	P3						■						
	P4						■						
M	M1							■					
	M2							■					
	M3							■					
	M4							■					
K	K1							■					
	K2						■	◪					
	K3						■	◪					
	K4						■	◪					
	K5						■	◪					
N	N1												
	N2												
	N3												
	N4												
	N5												
S	S1							◪					
	S2							◪					
	S3							◪					
	S4							◪					
H	H1												
	H2												
	H3												
	H4												

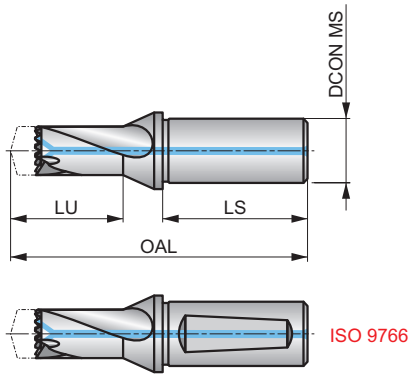
■推荐使用 ◪可以使用

H851

DORMER

1.5倍径天龙钻内冷刀体，光亮处理并镀镍。
天龙钻刀体，安装R950/R960刀头，一系列的刀头直径适用于同一个刀体，对准刀头的内冷孔能够提供高效的冷却，侧固柄能够防止钻头在刀柄中转动，光亮的镀镍表面能够防止腐蚀或生锈，并提高排屑性能。

HYDRA



HSS | DORMER | 1.5×D
Bright Ni | ISO 9766 | R

钻头附送4个螺丝和1个螺丝扳手，DCON MS公差h6

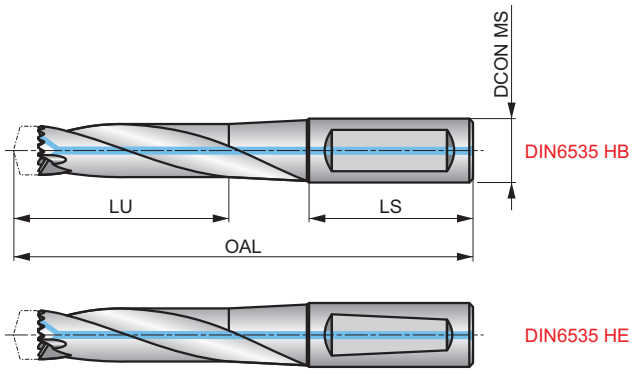
Product	DCON MS (inch)	DCON MS (mm)	LU (mm)	OAL (mm)	LS (mm)	ADINTMS
H85131/64	5/8	15.88	25.50	88.5	47.6	Cylindrical
H85117/32	5/8	15.88	30.90	93.9	47.6	Cylindrical
H85112.0	–	16.00	25.50	88.5	48.0	ISO 9766
H85112.5	–	16.00	25.80	88.8	48.0	ISO 9766
H85113.0	–	16.00	27.00	90.0	48.0	ISO 9766
H85114.0	–	16.00	30.90	93.9	48.0	ISO 9766
H85139/64	3/4	19.05	32.30	97.3	50.8	Cylindrical
H85141/64	3/4	19.05	34.90	99.9	50.8	Cylindrical
H85111/16	3/4	19.05	36.40	101.4	50.8	Cylindrical
H85123/32	3/4	19.05	39.00	104.0	50.8	Cylindrical
H85115.0	–	20.00	32.30	97.3	50.0	ISO 9766
H85116.0	–	20.00	34.90	99.9	50.0	ISO 9766
H85117.0	–	20.00	36.40	101.4	50.0	ISO 9766
H85118.0	–	20.00	39.00	104.0	50.0	ISO 9766
H85119.0	–	25.00	40.40	111.4	56.0	ISO 9766
H85120.0	–	25.00	43.00	114.0	56.0	ISO 9766
H85121.0	–	25.00	44.50	115.5	56.0	ISO 9766
H85122.0	–	25.00	46.10	117.1	56.0	ISO 9766
H85123.0	–	25.00	47.00	118.0	56.0	ISO 9766
H85149/64	1″	25.40	40.40	111.4	57.1	Cylindrical
H85151/64	1″	25.40	43.00	114.0	57.1	Cylindrical
H85127/32	1″	25.40	44.50	115.5	57.1	Cylindrical
H85157/64	1″	25.40	46.10	117.1	57.1	Cylindrical
H85159/64	1″	25.40	47.00	118.0	57.1	Cylindrical
H85131/32	1″	25.40	49.30	124.3	57.1	Cylindrical
H8511.1/64	1.1/4	31.75	49.70	124.7	60.3	Cylindrical
H8511.3/64	1.1/4	31.75	52.30	127.3	60.3	Cylindrical
H8511.3/32	1.1/4	31.75	52.80	127.8	60.3	Cylindrical
H8511.3/16	1.1/4	31.75	58.40	133.4	60.3	Cylindrical
H85124.0	–	32.00	49.30	124.3	60.0	ISO 9766
H85125.0	–	32.00	49.70	124.7	60.0	ISO 9766
H85126.0	–	32.00	52.30	127.3	60.0	ISO 9766
H85127.0	–	32.00	52.80	127.8	60.0	ISO 9766
H85128.0	–	32.00	54.40	129.4	60.0	ISO 9766
H85129.0	–	32.00	55.80	130.8	60.0	ISO 9766
H85130.0	–	32.00	58.40	133.4	60.0	ISO 9766

H853

DORMER

3倍径天龙钻内冷刀体，光亮处理并镀镍。
天龙钻刀体，安装R950/R960刀头，一系列的刀头直径适用于同一个刀体，对准刀头的内冷孔能够提供高效的冷却，光亮的镀镍表面能够防止腐蚀或生锈，并提高排屑性能。

HYDRA



HSS	DORMER	3×D
Bright Ni	DIN 6535HB DIN 6535HE	R

钻头附送4个螺丝和1个螺丝扳手，DCON MS公差h6

Product	DCON MS (inch)	DCON MS (mm)	LU (mm)	OAL (mm)	LS (mm)	ADINTMS
H85312.0	–	16.00	44.00	105.0	48.0	DIN6535HE
H85331/64	5/8	15.88	44.00	105.0	48.0	DIN6535HB
H85312.5	–	16.00	44.00	105.0	48.0	DIN6535HE
H8531/2	5/8	15.88	44.00	105.0	48.0	DIN6535HB
H85313.0	–	16.00	47.00	110.0	48.0	DIN6535HE
H85317/32	5/8	15.88	47.00	110.0	48.0	DIN6535HB
H85314.0	–	16.00	52.50	116.5	48.0	DIN6535HE
H8539/16	3/4	19.05	52.50	116.5	48.0	DIN6535HB
H85315.0	–	20.00	55.50	126.5	50.0	DIN6535HE
H85339/64	3/4	19.05	55.50	126.5	50.0	DIN6535HB
H85316.0	–	20.00	59.50	131.5	50.0	DIN6535HE
H85341/64	3/4	19.05	59.50	131.5	50.0	DIN6535HB
H85317.0	–	20.00	62.50	136.5	50.0	DIN6535HE
H85311/16	3/4	19.05	62.50	136.5	50.0	DIN6535HB
H85318.0	–	20.00	66.50	141.5	50.0	DIN6535HE
H85323/32	3/4	19.05	66.50	141.5	50.0	DIN6535HB
H85319.0	–	25.00	69.50	156.5	56.0	DIN6535HE
H85349/64	1″	25.40	69.50	156.5	56.0	DIN6535HB
H85320.0	–	25.00	73.50	156.5	56.0	DIN6535HE
H85351/64	1″	25.40	73.50	156.5	56.0	DIN6535HB
H85321.0	–	25.00	76.50	156.5	56.0	DIN6535HE
H85327/32	1″	25.40	76.50	156.5	56.0	DIN6535HB
H85322.0	–	25.00	80.10	161.5	56.0	DIN6535HE
H85357/64	1″	25.40	80.10	161.5	56.0	DIN6535HB
H85323.0	–	25.00	82.50	160.5	56.0	DIN6535HE
H85359/64	1″	25.40	82.50	160.5	56.0	DIN6535HB
H85324.0	–	32.00	86.20	170.2	60.0	DIN6535HE
H85331/32	1″	25.40	86.20	170.2	60.0	DIN6535HB
H85325.0	–	32.00	88.00	170.0	60.0	DIN6535HE
H8531.1/64	1.1/4	31.75	88.00	170.0	60.0	DIN6535HB
H85326.0	–	32.00	92.00	175.0	60.0	DIN6535HE
H8531.3/64	1.1/4	31.75	92.00	175.0	60.0	DIN6535HB
H85327.0	–	32.00	94.00	175.0	60.0	DIN6535HE
H8531.3/32	1.1/4	31.75	94.00	175.0	60.0	DIN6535HB

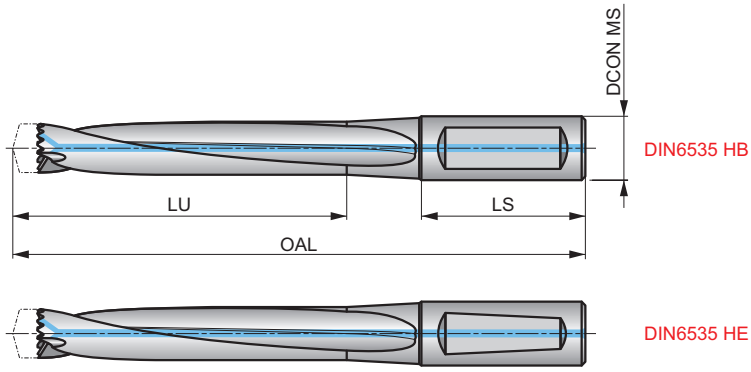
Product	DCON MS	DCON MS	LU	OAL	LS	ADINTMS
	(inch)	(mm)	(mm)	(mm)	(mm)	
H85328.0	–	32.00	97.00	180.0	60.0	DIN6535HE
H8531.1/8	1.1/4	31.75	97.00	180.0	60.0	DIN6535HB
H85329.0	–	32.00	100.00	185.0	60.0	DIN6535HE
H8531.11/64	1.1/4	31.75	100.00	185.0	60.0	DIN6535HB
H85330.0	–	32.00	104.00	185.0	60.0	DIN6535HE
H8531.3/16	1.1/4	31.75	104.00	185.0	60.0	DIN6535HB
H85332.0	–	32.00	111.50	196.5	60.0	DIN6535HE
H85333.5	–	32.00	116.50	201.5	60.0	DIN6535HE
H85335.0	–	40.00	121.50	216.5	70.0	DIN6535HB
H85336.5	–	40.00	125.50	221.5	70.0	DIN6535HB
H85338.0	–	40.00	131.50	226.5	70.0	DIN6535HB
H85339.5	–	40.00	136.50	231.5	70.0	DIN6535HB
H85341.0	–	40.00	146.50	246.5	70.0	DIN6535HB
H85342.5	–	40.00	151.60	251.6	70.0	DIN6535HB

H855

DORMER

5倍径天龙钻内冷刀体，光亮处理并镀镍。
天龙钻刀体，安装R950/R960刀头，一系列的刀头直径适用于同一个刀体，对准刀头的内冷孔能够提供高效的冷却，光亮的镀镍表面能够防止腐蚀或生锈，并提高排屑性能。

HYDRA



HSS	DORMER	5×D
Bright Ni	DIN 6535HB DIN 6535HE	R

钻头附送4个螺丝和1个螺丝扳手，DCON MS公差h6

Product	DCON MS (inch)	DCON MS (mm)	LU (mm)	OAL (mm)	LS (mm)	ADINTMS
H85512.0	–	16.00	69.00	130.0	48.0	DIN6535HE
H85531/64	5/8	15.88	69.00	130.0	48.0	DIN6535HB
H85512.5	–	16.00	69.00	130.0	48.0	DIN6535HE
H8551/2	5/8	15.88	69.00	130.0	48.0	DIN6535HB
H85513.0	–	16.00	74.00	140.0	48.0	DIN6535HE
H85517/32	5/8	15.88	74.00	140.0	48.0	DIN6535HB
H85514.0	–	16.00	81.50	146.5	48.0	DIN6535HE
H8559/16	3/4	19.05	81.50	146.5	48.0	DIN6535HB
H85515.0	–	20.00	86.50	156.5	50.0	DIN6535HE
H85539/64	3/4	19.05	86.50	156.5	50.0	DIN6535HB
H85516.0	–	20.00	92.50	166.5	50.0	DIN6535HE
H85541/64	3/4	19.05	92.50	166.5	50.0	DIN6535HB
H85517.0	–	20.00	97.50	171.5	50.0	DIN6535HE
H85511/16	3/4	19.05	97.50	171.5	50.0	DIN6535HB
H85518.0	–	20.00	103.50	176.5	50.0	DIN6535HE
H85523/32	3/4	19.05	103.50	176.5	50.0	DIN6535HB
H85519.0	–	25.00	108.50	191.5	56.0	DIN6535HE
H85549/64	1″	25.40	108.50	191.5	56.0	DIN6535HB
H85520.0	–	25.00	114.50	196.5	56.0	DIN6535HE
H85551/64	1″	25.40	114.50	196.5	56.0	DIN6535HB
H85521.0	–	25.00	119.50	196.5	56.0	DIN6535HE
H85527/32	1″	25.40	119.50	196.5	56.0	DIN6535HB
H85522.0	–	25.00	125.10	201.1	56.0	DIN6535HE
H85557/64	1″	25.40	125.10	201.1	56.0	DIN6535HB
H85523.0	–	25.00	129.50	210.5	56.0	DIN6535HE
H85559/64	1″	25.40	129.50	210.5	56.0	DIN6535HB
H85524.0	–	32.00	135.20	220.2	60.0	DIN6535HE
H85531/32	1″	25.40	135.20	220.2	60.0	DIN6535HB
H85525.0	–	32.00	140.00	225.0	60.0	DIN6535HE
H8551.1/64	1.1/4	31.75	140.00	225.0	60.0	DIN6535HB
H85526.0	–	32.00	146.00	230.0	60.0	DIN6535HE
H8551.3/64	1.1/4	31.75	146.00	230.0	60.0	DIN6535HB
H85527.0	–	32.00	151.00	235.0	60.0	DIN6535HE
H8551.3/32	1.1/4	31.75	151.00	235.0	60.0	DIN6535HB

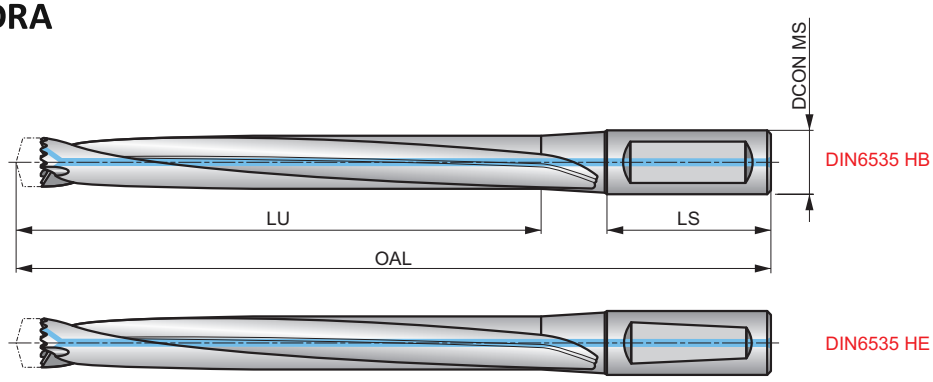
Product	DCON MS	DCON MS	LU	OAL	LS	ADINTMS
	(inch)	(mm)	(mm)	(mm)	(mm)	
H85528.0	–	32.00	157.00	240.0	60.0	DIN6535HE
H8551.1/8	1.1/4	31.75	157.00	240.0	60.0	DIN6535HB
H85529.0	–	32.00	162.00	245.0	60.0	DIN6535HE
H8551.11/64	1.1/4	31.75	162.00	245.0	60.0	DIN6535HB
H85530.0	–	32.00	167.00	255.0	60.0	DIN6535HE
H8551.3/16	1.1/4	31.75	167.00	255.0	60.0	DIN6535HB
H85532.0	–	32.00	176.50	261.5	60.0	DIN6535HE
H85533.5	–	32.00	186.50	271.5	60.0	DIN6535HE
H85535.0	–	40.00	196.50	291.5	70.0	DIN6535HB
H85536.5	–	40.00	201.50	296.5	70.0	DIN6535HB
H85538.0	–	40.00	211.50	306.5	70.0	DIN6535HB
H85539.5	–	40.00	221.50	316.5	70.0	DIN6535HB
H85541.0	–	40.00	226.50	325.6	70.0	DIN6535HB
H85542.5	–	40.00	236.50	336.5	70.0	DIN6535HB

H858

DORMER

8倍径天龙钻内冷刀体，光亮处理并镀镍。
天龙钻刀体，安装R950/R960刀头，一系列的刀头直径适用于同一个刀体，对准刀头的内冷孔能够提供高效的冷却，光亮的镀镍表面能够防止腐蚀或生锈，并提高排屑性能。

HYDRA



HSS	DORMER	8×D
Bright Ni	DIN 6535HB DIN 6535HE	R

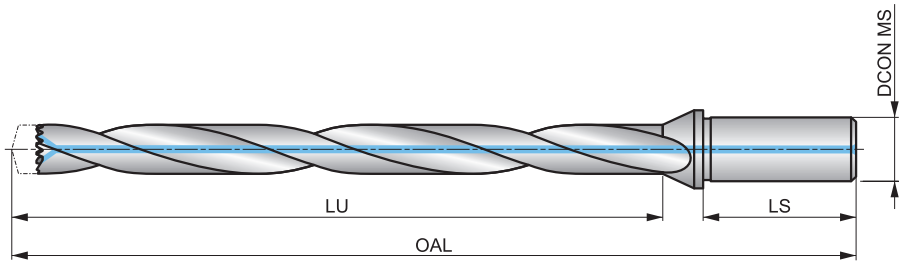
钻头附送4个螺丝和1个螺丝扳手，DCON MS公差h6

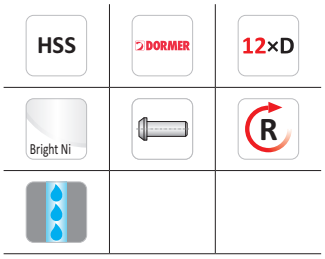
Product	DCON MS (mm)	LU (mm)	OAL (mm)	LS (mm)	ADINTMS
H85814.0	16.00	124.50	191.5	48.0	DIN6535HE
H85815.0	20.00	133.50	201.5	50.0	DIN6535HE
H85816.0	20.00	141.50	211.5	50.0	DIN6535HE
H85817.0	20.00	150.50	221.5	50.0	DIN6535HE
H85818.0	20.00	158.50	226.5	50.0	DIN6535HE
H85819.0	25.00	167.50	251.5	56.0	DIN6535HE
H85820.0	25.00	175.50	264.5	56.0	DIN6535HE
H85821.0	25.00	184.50	266.5	56.0	DIN6535HE
H85822.0	25.00	192.10	271.1	56.0	DIN6535HE
H85823.0	25.00	200.50	280.5	56.0	DIN6535HE
H85824.0	32.00	208.20	295.2	60.0	DIN6535HE
H85825.0	32.00	217.00	300.0	60.0	DIN6535HE
H85826.0	32.00	225.00	310.0	60.0	DIN6535HE
H85827.0	32.00	234.00	320.0	60.0	DIN6535HE
H85828.0	32.00	242.00	325.0	60.0	DIN6535HE
H85829.0	32.00	251.00	335.0	60.0	DIN6535HE
H85830.0	32.00	259.00	345.0	60.0	DIN6535HE
H85832.0	32.00	271.50	356.5	60.0	DIN6535HE
H85833.5	32.00	286.50	371.5	60.0	DIN6535HE
H85835.0	40.00	301.50	396.5	70.0	DIN6535HB
H85836.5	40.00	311.50	406.5	70.0	DIN6535HB
H85838.0	40.00	326.50	421.5	70.0	DIN6535HB
H85839.5	40.00	336.50	431.5	70.0	DIN6535HB
H85841.0	40.00	351.50	451.5	70.0	DIN6535HB
H85842.5	40.00	361.50	461.5	70.0	DIN6535HB

H8512

12倍径天龙钻内冷刀体，光亮处理并镀镍。
天龙钻刀体，安装R950/R960刀头，一系列的刀头直径适用于同一个刀体，对准刀头的内冷孔能够提供高效的冷却，侧固柄能够防止钻头在刀柄中转动，光亮的镀镍表面能够防止腐蚀或生锈，并提高排屑性能。

HYDRA



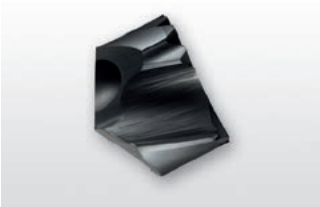


钻头附送4个螺丝和1个螺丝扳手，DCON MS公差h6

Product	DCON MS (mm)	LU (mm)	OAL (mm)	LS (mm)
H851214.0	16.00	168.00	236.0	48.0
H851215.0	20.00	180.00	250.3	50.0
H851216.0	20.00	192.00	262.6	50.0
H851217.0	20.00	204.00	275.0	50.0
H851218.0	20.00	216.00	287.2	50.0
H851219.0	25.00	228.00	305.6	56.0
H851220.0	25.00	240.00	317.8	56.0
H851221.0	25.00	252.00	330.1	56.0
H851222.0	25.00	264.00	343.0	56.0
H851223.0	25.00	276.00	354.8	56.0
H851224.0	32.00	288.00	371.7	60.0
H851225.0	32.00	300.00	383.8	60.0

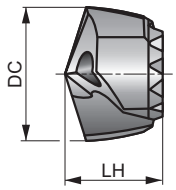
R950

DORMER



钢件专用天龙钻刀片，Ti-phon涂层。
经济型的高精度可换头硬质合金涂层刀头，用于高效加工钢件和硬材料，140°钻尖角有助于自定心并减少切削力，Ti-phon涂层可防止积屑瘤并极大地改善排屑，具有优异的耐磨性和刃口强度。

HYDRA



HM | DORMER | 140°
Ti-phon | R
DC h7

H851	校正系数为1.10的速度和进给的应用起始值
H853	校正系数为1.00的速度和进给的应用起始值
H855	校正系数为0.80的速度和进给的应用起始值
H858	校正系数为0.60的速度和进给的应用起始值
H8512	校正系数为0.50的速度和进给的应用起始值

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M2.3	M4.2
133 W	148 W	154 W	114 W	100 W	88 W	125 W	101 W	85 W	75 W	63 W	52 T	41 T	35 T
K2.1	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**
108 V	88 V	70 V	96 V	73 V	59 V	89 V	67 V	49 V	42 V	35 V	100 V	76 V	58 V

Product	DC (inch)	DC (mm)	DC (inch)	LH (mm)
R95015/32	15/32	11.91	0.4688	9.1
R95012.0	–	12.00	0.4724	9.1
R95012.1	–	12.10	0.4764	9.1
R95012.2	–	12.20	0.4803	9.1
R95031/64	31/64	12.30	0.4844	9.1
R95012.5	–	12.50	0.4921	9.4
R95012.6	–	12.60	0.4961	9.4
R9501/2	1/2	12.70	0.5000	9.4
R95012.8	–	12.80	0.5039	9.4
R95012.9	–	12.90	0.5079	9.4
R95013.0	–	13.00	0.5118	9.7
R95033/64	33/64	13.10	0.5156	9.7
R95013.2	–	13.20	0.5197	9.7
R95017/32	17/32	13.49	0.5313	9.7
R95013.5	–	13.50	0.5315	10.3
R95013.6	–	13.60	0.5354	10.3
R95013.7	–	13.70	0.5394	10.3
R95013.8	–	13.80	0.5433	10.3
R95035/64	35/64	13.89	0.5469	10.3
R95014.0	–	14.00	0.5512	10.3
R95014.1	–	14.10	0.5551	10.3
R95014.2	–	14.20	0.5591	10.3
R9509/16	9/16	14.29	0.5625	10.3
R95014.5	–	14.50	0.5709	10.3
R95014.6	–	14.60	0.5748	11.0
R95037/64	37/64	14.68	0.5781	11.0
R95014.7	–	14.70	0.5787	11.0
R95014.8	–	14.80	0.5827	11.0
R95015.0	–	15.00	0.5906	11.0
R95019/32	19/32	15.08	0.5938	11.0

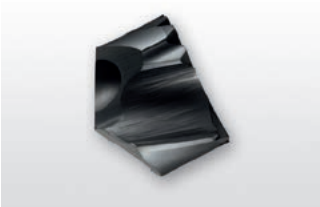
Product	DC (inch)	DC (mm)	DC (inch)	LH (mm)
R95015.1	–	15.10	0.5945	11.0
R95015.2	–	15.20	0.5984	11.0
R95015.24	–	15.24	0.6000	11.0
R95039/64	39/64	15.48	0.6094	11.0
R95015.5	–	15.50	0.6102	11.0
R95015.6	–	15.60	0.6142	11.6
R95015.7	–	15.70	0.6181	11.6
R9505/8	5/8	15.88	0.6250	11.6
R95016.0	–	16.00	0.6299	11.6
R95016.08	–	16.08	0.6331	11.6
R95016.1	–	16.10	0.6339	11.6
R95016.2	–	16.20	0.6378	11.6
R95041/64	41/64	16.27	0.6406	11.6
R95016.3	–	16.30	0.6417	11.6
R95016.5	–	16.50	0.6496	11.6
R95016.6	–	16.60	0.6535	12.2
R95021/32	21/32	16.67	0.6563	12.2
R95016.7	–	16.70	0.6575	12.2
R95017.0	–	17.00	0.6693	12.2
R95043/64	43/64	17.07	0.6719	12.2
R95017.1	–	17.10	0.6732	12.2
R95017.2	–	17.20	0.6772	12.2
R95011/16	11/16	17.46	0.6875	12.2
R95017.5	–	17.50	0.6890	12.2
R95017.6	–	17.60	0.6929	12.9
R95017.7	–	17.70	0.6969	12.9
R95045/64	45/64	17.86	0.7031	12.9
R95018.0	–	18.00	0.7087	12.9
R95018.1	–	18.10	0.7126	12.9
R95018.2	–	18.20	0.7165	12.9

Product	DC (inch)	DC (mm)	DC (inch)	LH (mm)
R95023/32	23/32	18.26	0.7188	12.9
R95018.5	–	18.50	0.7283	12.9
R95018.6	–	18.60	0.7323	13.5
R95047/64	47/64	18.65	0.7344	13.5
R95018.7	–	18.70	0.7362	13.5
R95018.9	–	18.90	0.7441	13.5
R95019.0	–	19.00	0.7480	13.5
R9503/4	3/4	19.05	0.7500	13.5
R95019.1	–	19.10	0.7520	13.5
R95019.2	–	19.20	0.7559	13.5
R95019.25	–	19.25	0.7579	13.5
R95019.3	–	19.30	0.7598	13.5
R95019.35	–	19.35	0.7618	13.5
R95049/64	49/64	19.45	0.7656	13.5
R95019.5	–	19.50	0.7677	13.5
R95019.6	–	19.60	0.7717	14.1
R95019.7	–	19.70	0.7756	14.1
R95025/32	25/32	19.84	0.7813	14.1
R95020.0	–	20.00	0.7874	14.1
R95051/64	51/64	20.24	0.7969	14.1
R95020.5	–	20.50	0.8071	14.1
R95013/16	13/16	20.64	0.8125	14.8
R95021.0	–	21.00	0.8268	14.8
R95053/64	53/64	21.03	0.8281	14.8
R95027/32	27/32	21.43	0.8438	14.8
R95021.5	–	21.50	0.8465	14.8
R95055/64	55/64	21.83	0.8594	15.0
R95022.0	–	22.00	0.8661	15.0
R9507/8	7/8	22.22	0.8750	15.0
R95022.5	–	22.50	0.8858	15.0
R95057/64	57/64	22.62	0.8906	15.0
R95022.7	–	22.70	0.8937	15.0
R95023.0	–	23.00	0.9055	15.1
R95029/32	29/32	23.02	0.9063	15.1
R95059/64	59/64	23.42	0.9219	15.1
R95023.5	–	23.50	0.9252	15.1
R95015/16	15/16	23.81	0.9375	15.4
R95024.0	–	24.00	0.9449	15.4
R95061/64	61/64	24.21	0.9531	15.4
R95024.5	–	24.50	0.9646	15.4
R95031/32	31/32	24.61	0.9688	15.4
R95025.0	–	25.00	0.9844	15.8
R95063/64	63/64	25.00	0.9844	15.8
R9501	1″	25.40	1.0000	15.8
R95025.5	–	25.50	1.0039	15.8
R95025.6	–	25.60	1.0079	15.8
R95025.65	–	25.65	1.0098	15.8
R9501.1/64	1.1/64	25.80	1.0156	15.8
R95026.0	–	26.00	1.0236	16.4
R9501.1/32	1.1/32	26.19	1.0313	16.4

Product	DC (inch)	DC (mm)	DC (inch)	LH (mm)
R95026.5	–	26.50	1.0433	16.4
R9501.3/64	1.3/64	26.59	1.0469	16.4
R9501.1/16	1.1/16	26.99	1.0625	17.1
R95027.0	–	27.00	1.0630	17.1
R9501.5/64	1.5/64	27.38	1.0781	17.1
R95027.5	–	27.50	1.0827	17.1
R9501.3/32	1.3/32	27.78	1.0938	17.1
R95028.0	–	28.00	1.1024	17.7
R9501.7/64	1.7/64	28.18	1.1094	17.7
R95028.5	–	28.50	1.1220	17.7
R9501.1/8	1.1/8	28.58	1.1250	17.7
R9501.9/64	1.9/64	28.97	1.1406	18.3
R95029.0	–	29.00	1.1417	18.3
R9501.5/32	1.5/32	29.37	1.1563	18.3
R95029.5	–	29.50	1.1614	18.3
R9501.11/64	1.11/64	29.77	1.1719	18.3
R95030.0	–	30.00	1.1811	19.0
R9501.3/16	1.3/16	30.16	1.1875	19.0
R95030.5	–	30.50	1.2008	19.0
R9501.7/32	1.7/32	30.96	1.2188	21.0
R95031.0	–	31.00	1.2205	21.0
R9501.1/4	1.1/4	31.75	1.2500	21.0
R95032.0	–	32.00	1.2598	21.0
R95032.5	–	32.50	1.2795	21.0
R9501.19/64	1.19/64	32.94	1.2969	21.0
R95033.0	–	33.00	1.2992	21.0
R95033.5	–	33.50	1.3189	21.0
R95034.0	–	34.00	1.3386	23.0
R9501.11/32	1.11/32	34.13	1.3438	23.0
R95034.5	–	34.50	1.3583	23.0
R9501.3/8	1.3/8	34.93	1.3750	23.0
R95035.0	–	35.00	1.3780	23.0
R95036.0	–	36.00	1.4173	23.0
R9501.27/64	1.27/64	36.12	1.4219	23.0
R95036.5	–	36.50	1.4370	23.0
R95037.0	–	37.00	1.4567	25.0
R9501.15/32	1.15/32	37.31	1.4688	25.0
R95037.5	–	37.50	1.4764	25.0
R95038.0	–	38.00	1.4961	25.0
R9501.1/2	1.1/2	38.10	1.5000	25.0
R95038.5	–	38.50	1.5157	25.0
R9501.17/32	1.17/32	38.89	1.5313	25.0
R95039.0	–	39.00	1.5354	25.0
R95039.5	–	39.50	1.5551	25.0
R9501.9/16	1.9/16	39.69	1.5625	27.0
R95040.0	–	40.00	1.5748	27.0
R95041.0	–	41.00	1.6142	27.0
R9501.5/8	1.5/8	41.28	1.6250	27.0
R95042.0	–	42.00	1.6535	27.0

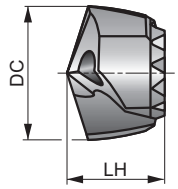
R960

DORMER



不锈钢专用天龙钻刀片，Ti-phon涂层。
经济型的高精度可换头硬质合金涂层刀头，用于高效加工不锈钢，140°钻尖角有助于自定心并减少切削力，Ti-phon涂层可防止积屑瘤并极大地改善排屑，具有优异的耐磨性和刃口强度。

HYDRA



HM | DORMER | 140°
Ti-phon | R
DC h7

H851	校正系数为1.10的速度和进给的应用起始值
H853	校正系数为1.00的速度和进给的应用起始值
H855	校正系数为0.80的速度和进给的应用起始值
H858	校正系数为0.60的速度和进给的应用起始值
H8512	校正系数为0.50的速度和进给的应用起始值

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页274开始。

P1.1	P1.2	P1.3	P2.1	M1.1	M1.2	M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2
133 W	148 W	154 W	114 W	82 V	70 V	73 V	60 V	50 T	58 T	50 T	45 T	40 T	34 T
K1.1	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**
120 V	89 V	67 V	108 V	88 V	70 V	96 V	73 V	59 V	89 V	67 V	49 V	42 V	35 V
K5.1	**K5.2**	**K5.3**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**	**S3.1**	**S3.2**	**S4.1**	**S4.2**		
100 V	76 V	58 V	45 T	35 T	30 S	40 S	35 S	30 S	25 S	23 S	20 S		

Product	DC (inch)	DC (mm)	DC (inch)	LH (mm)
R96015/32	15/32	11.91	0.4688	9.1
R96012.0	–	12.00	0.4724	9.1
R96012.1	–	12.10	0.4764	9.1
R96012.2	–	12.20	0.4803	9.1
R96031/64	31/64	12.30	0.4844	9.1
R96012.5	–	12.50	0.4921	9.4
R96012.6	–	12.60	0.4961	9.4
R9601/2	1/2	12.70	0.5000	9.4
R96012.8	–	12.80	0.5039	9.4
R96012.9	–	12.90	0.5079	9.4
R96013.0	–	13.00	0.5118	9.7
R96033/64	33/64	13.10	0.5156	9.7
R96013.2	–	13.20	0.5197	9.7
R96017/32	17/32	13.49	0.5313	9.7
R96013.5	–	13.50	0.5315	10.3
R96013.6	–	13.60	0.5354	10.3
R96013.7	–	13.70	0.5394	10.3
R96013.8	–	13.80	0.5433	10.3
R96035/64	35/64	13.89	0.5469	10.3
R96014.0	–	14.00	0.5512	10.3
R96014.1	–	14.10	0.5551	10.3
R96014.2	–	14.20	0.5591	10.3
R9609/16	9/16	14.29	0.5625	10.3
R96014.5	–	14.50	0.5709	10.3
R96014.6	–	14.60	0.5748	11.0
R96037/64	37/64	14.68	0.5781	11.0
R96014.7	–	14.70	0.5787	11.0
R96014.8	–	14.80	0.5827	11.0

Product	DC (inch)	DC (mm)	DC (inch)	LH (mm)
R96015.0	–	15.00	0.5906	11.0
R96019/32	19/32	15.08	0.5938	11.0
R96015.1	–	15.10	0.5945	11.0
R96015.2	–	15.20	0.5984	11.0
R96015.24	–	15.24	0.6000	11.0
R96039/64	39/64	15.48	0.6094	11.0
R96015.5	–	15.50	0.6102	11.0
R96015.6	–	15.60	0.6142	11.6
R96015.7	–	15.70	0.6181	11.6
R9605/8	5/8	15.88	0.6250	11.6
R96016.0	–	16.00	0.6299	11.6
R96016.08	–	16.08	0.6331	11.6
R96016.1	–	16.10	0.6339	11.6
R96016.2	–	16.20	0.6378	11.6
R96041/64	41/64	16.27	0.6406	11.6
R96016.3	–	16.30	0.6417	11.6
R96016.5	–	16.50	0.6496	11.6
R96016.6	–	16.60	0.6535	12.2
R96021/32	21/32	16.67	0.6563	12.2
R96016.7	–	16.70	0.6575	12.2
R96017.0	–	17.00	0.6693	12.2
R96043/64	43/64	17.07	0.6719	12.2
R96017.1	–	17.10	0.6732	12.2
R96017.2	–	17.20	0.6772	12.2
R96011/16	11/16	17.46	0.6875	12.2
R96017.5	–	17.50	0.6890	12.2
R96017.6	–	17.60	0.6929	12.9
R96017.7	–	17.70	0.6969	12.9

Product	DC (inch)	DC (mm)	DC (inch)	LH (mm)
R96045/64	45/64	17.86	0.7031	12.9
R96018.0	–	18.00	0.7087	12.9
R96018.1	–	18.10	0.7126	12.9
R96018.2	–	18.20	0.7165	12.9
R96023/32	23/32	18.26	0.7188	12.9
R96018.5	–	18.50	0.7283	12.9
R96018.6	–	18.60	0.7323	13.5
R96047/64	47/64	18.65	0.7344	13.5
R96018.7	–	18.70	0.7362	13.5
R96018.9	–	18.90	0.7441	13.5
R96019.0	–	19.00	0.7480	13.5
R9603/4	3/4	19.05	0.7500	13.5
R96019.1	–	19.10	0.7520	13.5
R96019.2	–	19.20	0.7559	13.5
R96019.25	–	19.25	0.7579	13.5
R96019.3	–	19.30	0.7598	13.5
R96019.35	–	19.35	0.7618	13.5
R96049/64	49/64	19.45	0.7656	13.5
R96019.5	–	19.50	0.7677	13.5
R96019.6	–	19.60	0.7717	14.1
R96019.7	–	19.70	0.7756	14.1
R96025/32	25/32	19.84	0.7813	14.1
R96020.0	–	20.00	0.7874	14.1
R96051/64	51/64	20.24	0.7969	14.1
R96020.5	–	20.50	0.8071	14.1
R96013/16	13/16	20.64	0.8125	14.8
R96021.0	–	21.00	0.8268	14.8
R96053/64	53/64	21.03	0.8281	14.8
R96027/32	27/32	21.43	0.8438	14.8
R96021.5	–	21.50	0.8465	14.8
R96055/64	55/64	21.83	0.8594	15.0
R96022.0	–	22.00	0.8661	15.0
R9607/8	7/8	22.22	0.8750	15.0
R96022.5	–	22.50	0.8858	15.0
R96057/64	57/64	22.62	0.8906	15.0
R96022.7	–	22.70	0.8937	15.0

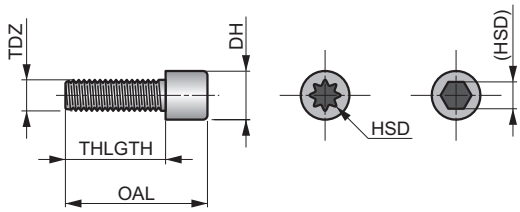
Product	DC (inch)	DC (mm)	DC (inch)	LH (mm)
R96023.0	–	23.00	0.9055	15.1
R96029/32	29/32	23.02	0.9063	15.1
R96059/64	59/64	23.42	0.9219	15.1
R96023.5	–	23.50	0.9252	15.1
R96015/16	15/16	23.81	0.9375	15.4
R96024.0	–	24.00	0.9449	15.4
R96061/64	61/64	24.21	0.9531	15.4
R96024.5	–	24.50	0.9646	15.4
R96031/32	31/32	24.61	0.9688	15.4
R96025.0	–	25.00	0.9844	15.8
R96063/64	63/64	25.00	0.9844	15.8
R9601	1″	25.40	1.0000	15.8
R96025.5	–	25.50	1.0039	15.8
R96025.65	–	25.65	1.0098	15.8
R9601.1/64	1.1/64	25.80	1.0156	15.8
R96026.0	–	26.00	1.0236	16.4
R9601.1/32	1.1/32	26.19	1.0313	16.4
R96026.5	–	26.50	1.0433	16.4
R9601.3/64	1.3/64	26.59	1.0469	16.4
R9601.1/16	1.1/16	26.99	1.0625	17.1
R96027.0	–	27.00	1.0630	17.1
R9601.5/64	1.5/64	27.38	1.0781	17.1
R96027.5	–	27.50	1.0827	17.1
R9601.3/32	1.3/32	27.78	1.0938	17.1
R96028.0	–	28.00	1.1024	17.7
R9601.7/64	1.7/64	28.18	1.1094	17.7
R96028.5	–	28.50	1.1220	17.7
R9601.1/8	1.1/8	28.58	1.1250	17.7
R9601.9/64	1.9/64	28.97	1.1406	18.3
R96029.0	–	29.00	1.1417	18.3
R9601.5/32	1.5/32	29.37	1.1563	18.3
R96029.5	–	29.50	1.1614	18.3
R9601.11/64	1.11/64	29.77	1.1719	18.3
R96030.0	–	30.00	1.1811	19.0
R9601.3/16	1.3/16	30.16	1.1875	19.0
R96030.5	–	30.50	1.2008	19.0

H860

DORMER

天龙钻螺钉
可更换的锁紧螺钉，用于天龙钻刀片。

HYDRA



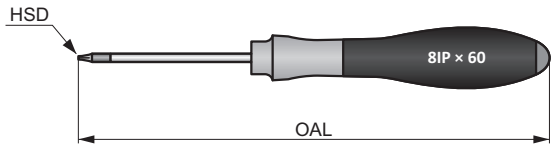
Product	Nr.	TDZ	OAL (mm)	THLGTH (mm)	DH (mm)	HSD
H860N1	1	M2.2	7.5	5.70	3.5	8IP
H860N2	2	M2.5	9.0	7.00	4.1	10IP
H860N3	3	M3.0	10.5	8.00	4.9	15IP
H860N4	4	M3.5	11.5	8.80	5.5	15IP
H860N5	5	M4.0	12.5	9.50	6.0	20IP
H860N6	6	M4.5	14.3	10.80	6.8	25IP
H860N7	7	M5.0	20.0	15.00	8.5	4

H861

DORMER

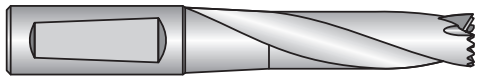
天龙钻螺钉专用螺丝刀
螺丝刀，用于锁紧天龙钻刀片的螺钉。

HYDRA



Product	Nr.	HSD	OAL (mm)
H861N1	N1	8IP	164.0
H861N2	N2	10IP	191.0
H861N3	N3	15IP	191.0
H861N4	N4	20IP	218.0
H861N5	N5	25IP	218.0

高性能可更换钻头

装配									
DC	**H851** 1.5×D	**H853** 3×D	**H855** 5×D	**H858** 8×D	**H8512** 12×D	**R950**	**R960**	**H860**	**H861**
范围	12.00 – 30.50 15/32″ – 1.3/16″	12.00 – 42.50 15/32″ – 1.5/8″	12.00 – 42.50 15/32″ – 1.5/8″	13.50 – 42.50 35/64″ – 1.5/8″	13.50 – 25.65 35/64″ – 1.1/64″	12.00 – 42.00 15/32″ – 1.5/8″	12.00 – 30.50 15/32″ – 1.3/16″	N1 – N7	N1 – N6
页面	218	219	221	223	224	225	227	229	229

DC	H851 1.5×D	H853 3×D	H855 5×D	H858 8×D	H8512 12×D	R950	R960	H860	H861
15/32″	H85112.0 H85131/64	H85312.0 H85331/64	H85512.0 H85531/64	–	–	R95015/32	R96015/32	H860N1	H861N1
12.0						R95012.0	R96012.0		
12.1						R95012.1	R96012.1		
12.2						R95012.2	R96012.2		
31/64″						R95031/64	R96031/64		
12.5	H85112.5	H85312.5 H8531/2	H85512.5 H8551/2	–	–	R95012.5	R96012.5		
12.6						R95012.6	R96012.6		
1/2″						R9501/2	R9601/2		
12.8						R95012.8	R96012.8		
12.9						R95012.9	R96012.9		
13.0	H85113.0 H85117/32	H85313.0 H85317/32	H85513.0 H85517/32	–	–	R95013.0	R96013.0		
33/64″						R95033/64	R96033/64		
13.2						R95013.2	R96013.2		
17/32″						R95017/32	R96017/32		
13.5	H85114.0	H85314.0 H8539/16	H85514.0 H8559/16	H85814.0	H851214.0	R95013.5	R96013.5		
13.6						R95013.6	R96013.6		
13.7						R95013.7	R96013.7		
13.8						R95013.8	R96013.8		
35/64″						R95035/64	R96035/64		
14.0						R95014.0	R96014.0		
14.1						R95014.1	R96014.1		
14.2						R95014.2	R96014.2		
9/16″						R9509/16	R9609/16		
14.5						R95014.5	R96014.5		
14.6	H85115.0 H85139/64	H85315.0 H85339/64	H85515.0 H85539/64	H85815.0	H851215.0	R95014.6	R96014.6		
37/64″						R95037/64	R96037/64		
14.7						R95014.7	R96014.7		
14.8						R95014.8	R96014.8		
15.0						R95015.0	R96015.0		
19/32″						R95019/32	R96019/32		
15.1						R95015.1	R96015.1		
15.2						R95015.2	R96015.2		
15.24						R95015.24	R96015.24		
39/64″						R95039/64	R96039/64		
15.5						R95015.5	R96015.5		

高性能可更换钻头

DC	H851 1.5×D	H853 3×D	H855 5×D	H858 8×D	H8512 12×D	R950	R960	H860	H861
15.6	H85116.0 H85141/64	H85316.0 H85341/64	H85516.0 H85541/64	H85816.0	H851216.0	R95015.6	R96015.6	H860N2	H861N2
15.7						R95015.7	R96015.7		
5/8″						R9505/8	R9605/8		
16.0						R95016.0	R96016.0		
16.08						R95016.08	R96016.08		
16.1						R95016.1	R96016.1		
16.2						R95016.2	R96016.2		
16.3						R95016.3	R96016.3		
41/64″						R95041/64	R96041/64		
16.5						R95016.5	R96016.5		
16.6	H85117.0 H85111/16	H85317.0 H85311/16	H85517.0 H85511/16	H85817.0	H851217.0	R95016.6	R96016.6		
21/32″						R95021/32	R96021/32		
16.7						R95016.7	R96016.7		
17.0						R95017.0	R96017.0		
43/64″						R95043/64	R96043/64		
17.1						R95017.1	R96017.1		
17.2						R95017.2	R96017.2		
11/16″						R95011/16	R96011/16		
17.5						R95017.5	R96017.5		
17.6	H85118.0 H85123/32	H85318.0 H85323/32	H85518.0 H85523/32	H85818.0	H851218.0	R95017.6	R96017.6		
17.7						R95017.7	R96017.7		
45/64″						R95045/64	R96045/64		
18.0						R95018.0	R96018.0		
18.1						R95018.1	R96018.1		
18.2						R95018.2	R96018.2		
23/32″						R95023/32	R96023/32		
18.5						R95018.5	R96018.5		
18.6	H85119.0 H85149/64	H85319.0 H85349/64	H85519.0 H85549/64	H85819.0	H851219.0	R95018.6	R96018.6	H860N3	H861N3
47/64″						R95047/64	R96047/64		
18.7						R95018.7	R96018.7		
18.9						R95018.9	R96018.9		
19.0						R95019.0	R96019.0		
3/4″						R9503/4	R9603/4		
19.1						R95019.1	R96019.1		
19.2						R95019.2	R96019.2		
19.25						R95019.25	R96019.25		
19.3						R95019.3	R96019.3		
19.35						R95019.35	R96019.35		
49/64″						R95049/64	R96049/64		
19.5						R95019.5	R96019.5		
19.6	H85120.0 H85151/64	H85320.0 H85351/64	H85520.0 H85551/64	H85820.0	H851220.0	R95019.6	R96019.6		
19.7						R95019.7	R96019.7		
25/32″						R95025/32	R96025/32		
20.0						R95020.0	R96020.0		
51/64″						R95051/64	R96051/64		
20.5						R95020.5	R96020.5		
13/16″	H85121.0 H85127/32	H85321.0 H85327/32	H85521.0 H85527/32	H85821.0	H851221.0	R95013/16	R96013/16		
21.0						R95021.0	R96021.0		
53/64″						R95053/64	R96053/64		
27/32″						R95027/32	R96027/32		
21.5						R95021.5	R96021.5		
55/64″	H85122.0 H85157/64	H85322.0 H85357/64	H85522.0 H85557/64	H85822.0	H851222.0	R95055/64	R96055/64	H860N4	
22.0						R95022.0	R96022.0		
7/8″						R9507/8	R9607/8		
22.5						R95022.5	R96022.5		
57/64″						R95057/64	R96057/64		
22.7						R95022.7	R96022.7		
23.0	H85123.0 H85159/64	H85323.0 H85359/64	H85523.0 H85559/64	H85823.0	H851223.0	R95023.0	R96023.0		
29/32″						R95029/32	R96029/32		
59/64″						R95059/64	R96059/64		
23.5						R95023.5	R96023.5		

高性能可更换钻头

DC	H851 1.5×D	H853 3×D	H855 5×D	H858 8×D	H8512 12×D	R950	R960	H860	H861
15/16	H85124.0 H85131/32	H85324.0 H85331/32	H85524.0 H85531/32	H85824.0	H851224.0	R95015/16	R96015/16	H860N4	H861N3
24.0						R95024.0	R96024.0		
61/64						R95061/64	R96061/64		
24.5						R95024.5	R96024.5		
31/32″						R95031/32	R96031/32		
25.0	H85125.0 H8511.1/64	H85325.0 H8531.1/64	H85525.0 H8551.1/64	H85825.0	H851225.0	R95025.0	R96025.0	H860N5	H861N4
63/64″						R95063/64	R96063/64		
1″						R9501	R9601		
25.5						R95025.5	R96025.5		
25.6						R95025.6	–		
25.65						R95025.65	R96025.65		
1.1/64″						R9501.1/64	R9601.1/64		
26.0	H85126.0 H8511.3/64	H85326.0 H8531.3/64	H85526.0 H8551.3/64	H85826.0	–	R95026.0	R96026.0		
1.1/32″						R9501.1/32	R9601.1/32		
26.5						R95026.5	R96026.5		
1.3/64						R9501.3/64	R9601.3/64		
1.1/16″	H85127.0 H8511.3/32	H85327.0 H8531.3/32	H85527.0 H8551.3/32	H85827.0	–	R9501.1/16	R9601.1/16		
27.0						R95027.0	R96027.0		
1.5/64″						R9501.5/64	R9601.5/64		
27.5						R95027.5	R96027.5		
1.3/32″						R9501.3/32	R9601.3/32		
28.0	H85128.0	H85328.0 H8531.1/8	H85528.0 H8551.1/8	H85828.0	–	R95028.0	R96028.0	H860N6	H861N5
1.7/64″						R9501.7/64	R9601.7/64		
28.5						R95028.5	R96028.5		
1.1/8″						R9501.1/8	R9601.1/8		
1.9/64″	H85129.0	H85329.0 H8531.11/64	H85529.0 H8551.11/64	H85829.0	–	R9501.9/64	R9601.9/64		
29.0						R95029.0	R96029.0		
1.5/32″						R9501.5/32	R9601.5/32		
29.5						R95029.5	R96029.5		
1.11/64″						R9501.11/64	R9601.11/64		
30.0	H85130.0 H8511.3/16	H85330.0 H8531.3/16	H85530.0 H8551.3/16	H85830.0	–	R95030.0	R96030.0		
1.3/16″						R9501.3/16	R9601.3/16		
30.5						R95030.5	R96030.5		
1.7/32″	–	H85332.0	H85532.0	H85832.0	–	R9501.7/32	–		
31.0						R95031.0	–		
1.1/4″						R9501.1/4	–		
32.0						R95032.0	–		
32.5	–	H85333.5	H85533.5	H85833.5	–	R95032.5	–		
1.19/64″						R9501.19/64	–		
33.0						R95033.0	–		
33.5						R95033.5	–		
34.0	–	H85335.0	H85535.0	H85835.0	–	R95034.0	–	H860N7	H861N6
1.11/32″						R9501.11/32	–		
34.5						R95034.5	–		
1.3/8″						R9501.3/8	–		
35.0						R95035.0	–		
36.0	–	H85336.5	H85536.5	H85836.5	–	R95036.0	–		
1.27/64″						R9501.27/64	–		
36.5						R95036.5	–		
37.0	–	H85338.0	H85538.0	H85838.0	–	R95037.0	–		
1.15/32″						R9501.15/32	–		
37.5						R95037.5	–		
38.0						R95038.0	–		
1.1/2″	–	H85339.5	H85539.5	H85839.5	–	R9501.1/2	–		
38.5						R95038.5	–		
1.17/32″						R9501.17/32	–		
39.0						R95039.0	–		
39.5						R95039.5	–		
1.9/16″	–	H85341.0	H85541.0	H85841.0	–	R9501.9/16	–		
40.0						R95040.0	–		
41.0						R95041.0	–		

高性能可更换钻头

DC	H851 1.5×D	H853 3×D	H855 5×D	H858 8×D	H8512 12×D	R950	R960	H860	H861
1.5/8"	–	H85342.5	H85542.5	H85842.5	–	R9501.5/8	–	H860N7	–
42.0						R95042.0	–		

附件

H860	H861	天龙钻刀头DC范围			扳手规格 / 扳手头
		公制（最小 – 最大）	分数形式（最小 – 最大）	小数形式（最小 – 最大）	
H860N1	H861N1	12.0 mm – 15.5 mm	15/32" – 39/64"	0.4688" – 0.6102"	8IP
H860N2	H861N2	15.6 mm – 18.5 mm	5/8" – 23/32"	0.6142" – 0.7283"	10IP
H860N3	H861N3	18.6 mm – 21.5 mm	47/64" – 27/32"	0.7323" – 0.8465"	15IP
H860N4	H861N3	22.0 mm – 24.5 mm	55/64" – 31/32"	0.8594" – 0.9688"	15IP
H860N5	H861N4	25.0 mm – 27.5 mm	63/64" – 1-3/32"	0.9843" – 1.0938"	20IP
H860N6	H861N5	28.0 mm – 33.5 mm	1-7/64" – 1-19/64"	1.1024" – 1.3189"	25IP
H860N7	–	34.0 mm – 42.0 mm	1-11/32" – 1-5/8"	1.3386" – 1.6535"	4 mm Hex

材料代码(BMC)	HSS	HSS	HSS	HSS								
应用角度	2×D	3×D	4×D	5×D								
涂层	Bright Ni	Bright Ni	Bright Ni	Bright Ni								
柄部	ISO 9766	ISO 9766	ISO 9766	ISO 9766								
切削方向	R	R	R	R								
冷却液 (CSP)												
钻头公差	± 0.05	± 0.05	± 0.05	± 0.05								
孔的公差 *	0 / +0.2	0 / +0.3	0 / +0.4	0 / +0.5								
表面粗糙度 *	2 – 6 µm	2 – 6 µm	2 – 6 µm	2 – 6 µm								
产品系列代码	802D	803D	804D	805D	XPET..AP	SCET..-UD	XPET..AP-SD	SCET..-SD	EP			
	15.0 – 40.0	15.0 – 58.0	17.0 – 58.0	19.0 – 31.0								
	236	238	241	243	246	245	246	245	247			
P	P1				■	■	■	■				
	P2				■	■	■	■				
	P3				■	■	■	■				
	P4				■	■	■	■				
M	M1						■	■				
	M2						■	■				
	M3						■	■				
	M4						■	■				
K	K1				◪	■	◪	◪				
	K2				◪	■	◪	◪				
	K3				◪	■	◪	◪				
	K4				◪	■	◪	◪				
	K5				◪	■	◪	◪				
N	N1											
	N2											
	N3											
	N4											
	N5											
S	S1						◪	◪				
	S2						◪	◪				
	S3						◪	◪				
	S4						◪	◪				
H	H1											
	H2											

* 钻孔的公差和表面精度取决于工况

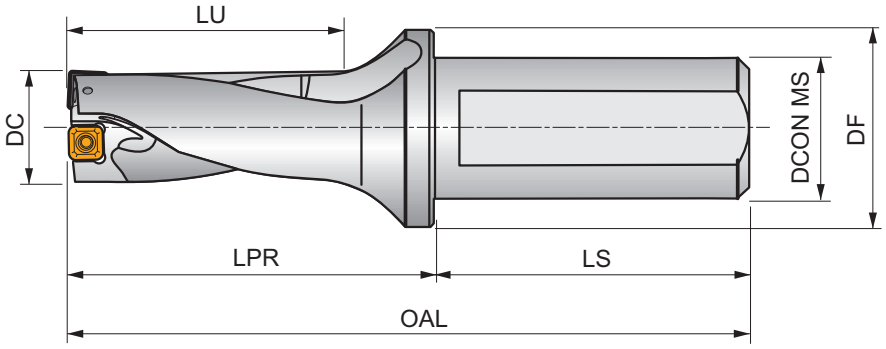
802D

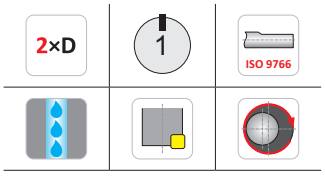
P M K N S H

PRAMET

S

2倍径802D内冷可转位刀片式钻头
高性能的可转位刀片式钻头的刀体，适用于盲孔和通孔，此外也可用于潜在的贯穿孔、偏心钻孔以及层叠板钻孔，螺旋插补，在凹面或斜面钻孔，啄钻，钻倒角和镗孔，直径从D15至D40的2倍径钻头。





Product	DC (mm)	APMX (mm)	OAL (mm)	LPR (mm)	LS (mm)	LU (mm)	DCON MS (mm)	DF (mm)	-D (mm)	D+ (mm)				kg	
802D-15-30-S25	15	30.00	121	65	56	34.5	25	35	0.25	0.35	EP253253	GI300	GI313	0.32	HM001
802D-16-32-S25	16	32.00	123	67	56	37	25	35	0.15	0.45	EP253253	GI300	GI313	0.32	HM001
802D-17-34-S25	17	34.00	125	69	56	39.5	25	35	0.10	0.50	EP253253	GI300	GI313	0.31	HM001
802D-18-36-S25	18	36.00	127	71	56	42	25	35	0.35	0.25	EP253253	GI301	GI314	0.31	HM002
802D-19-38-S25	19	38.00	129	73	56	44.5	25	35	0.15	0.45	EP253253	GI301	GI314	0.32	HM002
802D-20-40-S25	20	40.00	131	75	56	47	25	35	0.10	0.45	EP253253	GI302	GI315	0.35	HM003
802D-21-42-S25	21	42.00	133	77	56	49.5	25	35	0.10	0.50	EP253253	GI302	GI315	0.34	HM003
802D-22-44-S25	22	44.00	135	79	56	52	25	35	0.45	0.50	EP253253	GI303	GI316	0.35	HM004
802D-23-46-S25	23	46.00	137	81	56	54.5	25	35	0.35	0.50	EP253253	GI304	GI317	0.36	HM005
802D-24-48-S25	24	48.00	139	83	56	57	25	35	0.15	0.50	EP253253	GI304	GI317	0.37	HM005
802D-25-50-S32	25	50.00	145	85	60	57	32	42	0.15	0.50	EP324058	GI304	GI317	0.57	HM005
802D-26-52-S32	26	52.00	147	87	60	59.5	32	42	0.10	0.50	EP324058	GI304	GI317	0.58	HM005
802D-27-54-S32	27	54.00	149	89	60	62	32	42	0.50	0.30	EP324058	GI305	GI318	0.59	HM006
802D-28-56-S32	28	56.00	151	91	60	64.5	32	42	0.30	0.50	EP324058	GI306	GI319	0.61	HM007
802D-29-58-S32	29	58.00	153	93	60	67	32	42	0.20	0.50	EP324058	GI306	GI319	0.62	HM007
802D-30-60-S32	30	60.00	155	95	60	69.5	32	42	0.15	0.50	EP324058	GI306	GI319	0.67	HM007
802D-32-64-S32	32	64.00	159	99	60	70	32	42	0.50	0.35	EP324058	GI307	GI320	0.68	HM008
802D-32-64-S40	32	64.00	167	99	68	70	40	50	0.50	0.35	–	GI307	GI320	1.03	HM008
802D-34-68-S32	34	68.00	163	103	60	75	32	42	0.25	0.50	EP324058	GI307	GI320	0.73	HM008
802D-34-68-S40	34	68.00	171	103	68	75	40	50	0.25	0.50	–	GI307	GI320	1.07	HM008
802D-36-72-S32	36	72.00	167	107	60	80	32	42	0.10	0.50	EP324058	GI308	GI321	0.76	HM009
802D-36-72-S40	36	72.00	173	105	68	77.5	40	50	0.10	0.50	–	GI308	GI321	1.11	HM009
802D-38-76-S32	38	76.00	171	111	60	85	32	42	0.50	0.50	EP324058	GI308	GI321	0.83	HM009
802D-38-76-S40	38	76.00	179	111	68	85	40	50	0.50	0.50	–	GI308	GI321	1.17	HM009
802D-40-80-S32	40	80.00	175	115	60	90	32	42	0.20	0.50	EP324058	GI309	GI322	0.94	HM009
802D-40-80-S40	40	80.00	183	115	68	90	40	50	0.20	0.50	–	GI309	GI322	1.25	HM009

GI300	XPET 0502AP	SCET 050204-UD
GI301	XPET 0602AP	SCET 050204-UD
GI302	XPET 0602AP	SCET 060204-UD
GI303	XPET 0703AP	SCET 060204-UD
GI304	XPET 0703AP	SCET 070308-UD
GI305	XPET 0903AP	SCET 070308-UD
GI306	XPET 0903AP	SCET 09T308-UD
GI307	XPET 11T3AP	SCET 09T308-UD
GI308	XPET 11T3AP	SCET 120408-UD
GI309	XPET 12T3AP	SCET 120408-UD
GI313	XPET 0502AP-SD	SCET 050204-SD
GI314	XPET 0602AP-SD	SCET 050204-SD
GI315	XPET 0602AP-SD	SCET 060204-SD
GI316	XPET 0703AP-SD	SCET 060204-SD
GI317	XPET 0703AP-SD	SCET 070308-SD
GI318	XPET 0903AP-SD	SCET 070308-SD
GI319	XPET 0903AP-SD	SCET 09T308-SD
GI320	XPET 11T3AP-SD	SCET 09T308-SD
GI321	XPET 11T3AP-SD	SCET 120408-SD
GI322	XPET 12T3AP-SD	SCET 120408-SD

HM001	US 2245-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM002	US 2205-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM003	US 2205-T07P	0.9	US 2205-T07P	0.9	FLAG T07P
HM004	US 2506-T07P	1.2	US 2506-T07P	1.2	FLAG T07P
HM005	US 2507-T08P	1.2	US 3007-T08P	2.0	FLAG T08P
HM006	US 3007-T09P	2.0	US 3007-T09P	2.0	FLAG T09P
HM007	US 3007-T09P	2.0	US 3009-T09P	2.0	FLAG T09P
HM008	US 3510-T15P	3.0	US 3508-T15P	3.0	FLAG T15P
HM009	US 3510-T15P	3.0	US 5012-T15P	5.0	FLAG T15P

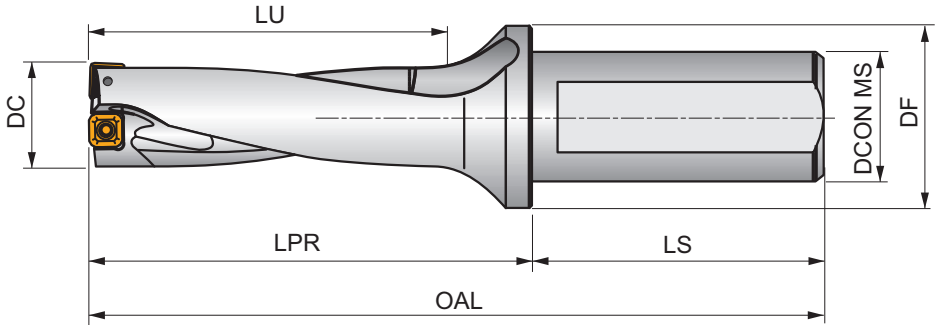
803D

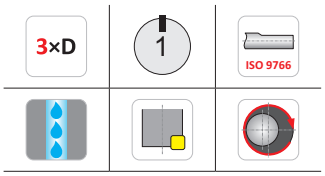
P M K N S H

PRAMET

S

3倍径803D内冷可转位刀片式钻头
高性能的可转位刀片式钻头的刀体，适用于盲孔和通孔，此外也可用于潜在的贯穿孔、偏心钻孔以及层叠板钻孔，螺旋插补，在凹面或斜面钻孔，啄钻，钻倒角和镗孔，直径从D15至D58的3倍径钻头。





Product	DC (mm)	APMX (mm)	OAL (mm)	LPR (mm)	LS (mm)	LU (mm)	DCON MS (mm)	DF (mm)	-D (mm)	D+ (mm)				kg	
803D-15-45-S25	15	45.00	136	80	56	49.5	25	35	0.25	0.35	EP253253	GI300	GI313	0.33	HM001
803D-15,5-46,5-S25	15.5	47.00	137.5	81.5	56	51.2	25	35	0.30	0.35	EP253253	GI300	GI313	0.31	HM001
803D-16-48-S25	16	48.00	139	83	56	53	25	35	0.15	0.45	EP253253	GI300	GI313	0.32	HM001
803D-16,5-49,5-S25	16.5	50.00	140.5	84.5	56	54.7	25	35	0.15	0.40	EP253253	GI300	GI313	0.32	HM001
803D-17-51-S25	17	51.00	142	86	56	56.5	25	35	0.10	0.50	EP253253	GI300	GI313	0.35	HM001
803D-17,5-52,5-S25	17.5	53.00	143.5	87.5	56	58.2	25	35	0.50	0.50	EP253253	GI301	GI314	0.32	HM002
803D-18-54-S25	18	54.00	145	89	56	60	25	35	0.35	0.25	EP253253	GI301	GI314	0.33	HM002
803D-18,5-55,5-S25	18.5	56.00	146.5	90.5	56	61.2	25	35	0.35	0.25	EP253253	GI301	GI314	0.34	HM002
803D-19-57-S25	19	57.00	148	92	56	63.5	25	35	0.15	0.45	EP253253	GI301	GI314	0.34	HM002
803D-19,5-58,5-S25	19.5	59.00	149.5	93.5	56	63.7	25	35	0.25	0.40	EP253253	GI302	GI315	0.34	HM003
803D-20-60-S25	20	60.00	151	95	56	67	25	35	0.10	0.45	EP253253	GI302	GI315	0.33	HM003
803D-20,5-61,5-S25	20.5	62.00	152.5	96.5	56	67.2	25	35	0.10	0.50	EP253253	GI302	GI315	0.36	HM003
803D-21-63-S25	21	63.00	154	98	56	70.5	25	35	0.10	0.50	EP253253	GI302	GI315	0.36	HM003
803D-21,5-64,5-S25	21.5	65.00	155.5	99.5	56	70.8	25	35	0.35	0.50	EP253253	GI303	GI316	0.37	HM004
803D-22-66-S25	22	66.00	157	101	56	74	25	35	0.45	0.50	EP253253	GI303	GI316	0.40	HM004
803D-22,5-67,5-S25	22.5	68.00	158.5	102.5	56	74.3	25	35	0.35	0.50	EP253253	GI304	GI317	0.42	HM005
803D-23-69-S25	23	69.00	160	104	56	77.5	25	35	0.35	0.50	EP253253	GI304	GI317	0.40	HM005
803D-23,5-70,5-S25	23.5	71.00	161.5	105.5	56	77.6	25	35	0.10	0.50	EP253253	GI304	GI317	0.40	HM005
803D-24-72-S25	24	72.00	163	107	56	81	25	35	0.15	0.50	EP253253	GI304	GI317	0.41	HM005
803D-24,5-73,5-S25	24.5	74.00	168.5	108.5	60	78.7	25	35	0.10	0.50	EP253253	GI304	GI317	0.45	HM005
803D-25-75-S32	25	75.00	170	110	60	82	32	42	0.15	0.50	EP324058	GI304	GI317	0.62	HM005
803D-25,5-76,5-S32	25.5	77.00	171.5	111.5	60	82.2	32	42	0.50	0.10	EP324058	GI304	GI317	0.63	HM005
803D-26-78-S32	26	78.00	173	113	60	85.5	32	42	0.10	0.50	EP324058	GI304	GI317	0.66	HM005
803D-26,5-79,5-S32	26.5	80.00	174.5	114.5	60	85.7	32	42	0.50	0.10	EP324058	GI305	GI318	0.67	HM006
803D-27-81-S32	27	81.00	176	116	60	89	32	42	0.50	0.30	EP324058	GI305	GI318	0.65	HM006
803D-28-84-S32	28	84.00	179	119	60	92.5	32	42	0.30	0.50	EP324058	GI306	GI319	0.68	HM007
803D-29-87-S32	29	87.00	182	122	60	96	32	42	0.20	0.50	EP324058	GI306	GI319	0.70	HM007

Product	DC (mm)	APMX (mm)	OAL (mm)	LPR (mm)	LS (mm)	LU (mm)	DCON MS (mm)	DF (mm)	-D (mm)	D+ (mm)				kg	
803D-30-90-S32	30	90.00	185	125	60	99.5	32	42	0.15	0.50	EP324058	GI306	GI319	0.73	HM007
803D-31-93-S32	31	93.00	188	128	60	103	32	42	0.15	0.50	EP324058	GI306	GI319	0.76	HM007
803D-32-96-S32	32	96.00	191	131	60	102	32	42	0.50	0.30	EP324058	GI307	GI320	0.79	HM008
803D-32-96-S40	32	96.00	199	131	68	102	40	50	0.50	0.30	–	GI307	GI320	1.14	HM008
803D-33-99-S32	33	99.00	194	134	60	105.5	32	42	0.50	0.50	EP324058	GI307	GI320	0.83	HM008
803D-33-99-S40	33	99.00	202	134	68	105.5	40	50	0.50	0.50	–	GI307	GI320	1.18	HM008
803D-34-102-S32	34	102.00	197	137	60	109	32	42	0.25	0.50	EP324058	GI307	GI320	0.86	HM008
803D-34-102-S40	34	102.00	205	137	68	109	40	50	0.25	0.50	–	GI307	GI320	1.12	HM008
803D-35-105-S32	35	105.00	200	140	60	112.5	32	42	0.25	0.50	EP324058	GI308	GI321	0.90	HM009
803D-35-105-S40	35	105.00	208	140	68	112.5	40	50	0.25	0.50	–	GI308	GI321	1.24	HM009
803D-36-108-S32	36	108.00	203	143	60	116	32	42	0.10	0.50	EP324058	GI308	GI321	0.91	HM009
803D-36-108-S40	36	108.00	211	143	68	116	40	50	0.10	0.50	–	GI308	GI321	1.25	HM009
803D-37-111-S32	37	111.00	206	146	60	119.5	32	42	0.10	0.50	EP324058	GI308	GI321	0.95	HM009
803D-37-111-S40	37	111.00	214	146	68	119.5	40	50	0.10	0.50	–	GI308	GI321	1.29	HM009
803D-38-114-S32	38	114.00	199	139	60	124.5	32	42	0.50	0.50	EP324058	GI308	GI321	1.00	HM009
803D-38-114-S40	38	114.00	217	149	68	123	40	50	0.50	0.50	–	GI308	GI321	1.34	HM009
803D-39-117-S32	38	114.00	209	149	60	123	32	42	0.40	0.50	EP324058	GI309	GI322	1.06	HM009
803D-39-117-S40	39	117.00	220	152	68	126.5	40	50	0.40	0.50	–	GI309	GI322	1.40	HM009
803D-40-120-S32	40	120.00	215	155	60	130	32	42	0.20	0.50	EP324058	GI309	GI322	1.12	HM009
803D-40-120-S40	40	120.00	223	155	68	130	40	50	0.20	0.50	–	GI309	GI322	1.46	HM009
803D-41-123-S40	41	123.00	219	149	70	133	40	50	0.20	0.50	–	GI309	GI322	1.48	HM009
803D-42-126-S40	42	126.00	221.5	152	70	136	40	50	0.15	0.50	–	GI309	GI322	1.52	HM009
803D-43-129-S40	43	129.00	224	154	70	139	40	50	0.10	0.50	–	GI309	GI322	1.58	HM009
803D-44-132-S40	44	132.00	226.5	157	70	142	40	50	0.50	0.50	–	GI310	GI323	1.63	HM010
803D-45-135-S40	45	135.00	230.5	161	70	144	40	55	0.50	0.50	–	GI311	GI324	1.73	HM010
803D-46-138-S40	46	138.00	235	165	70	148	40	55	0.50	0.50	–	GI311	GI324	1.82	HM010
803D-47-141-S40	47	141.00	237.5	168	70	151	40	55	0.50	0.50	–	GI311	GI324	1.90	HM010
803D-48-144-S40	48	144.00	240	170	70	154	40	55	0.50	0.50	–	GI311	GI324	1.98	HM010
803D-49-147-S40	49	147.00	242.5	173	70	157	40	55	0.30	0.50	–	GI311	GI324	2.06	HM010
803D-50-150-S40	50	150.00	246.5	177	70	160	40	58	0.15	0.50	–	GI311	GI324	2.18	HM010
803D-51-153-S40	51	153.00	249	179	70	163	40	58	0.15	0.50	–	GI311	GI324	2.24	HM010
803D-52-156-S40	52	156.00	251.5	182	70	166	40	58	0.50	0.50	–	GI312	GI325	2.20	HM010
803D-53-159-S40	53	159.00	254	184	70	169	40	58	0.50	0.50	–	GI312	GI325	2.29	HM010
803D-54-162-S40	54	162.00	257.5	188	70	173	40	58	0.50	0.50	–	GI312	GI325	2.39	HM010
803D-55-165-S40	55	165.00	260	190	70	176	40	58	0.50	0.50	–	GI312	GI325	2.46	HM010
803D-56-168-S40	56	168.00	264	194	70	179	40	58	0.50	0.50	–	GI312	GI325	2.59	HM010
803D-57-171-S40	57	171.00	266.5	197	70	182	40	58	0.35	0.50	–	GI312	GI325	2.70	HM010
803D-58-174-S40	58	174.00	270	200	70	186	40	58	0.15	0.50	–	GI312	GI325	2.83	HM010

	INT	EXT
GI300	XPET 0502AP	SCET 050204-UD
GI301	XPET 0602AP	SCET 050204-UD
GI302	XPET 0602AP	SCET 060204-UD
GI303	XPET 0703AP	SCET 060204-UD
GI304	XPET 0703AP	SCET 070308-UD
GI305	XPET 0903AP	SCET 070308-UD
GI306	XPET 0903AP	SCET 09T308-UD
GI307	XPET 11T3AP	SCET 09T308-UD
GI308	XPET 11T3AP	SCET 120408-UD
GI309	XPET 12T3AP	SCET 120408-UD
GI310	XPET 1504AP	SCET 120408-UD
GI311	XPET 1504AP	SCET 150512-UD
GI312	XPET 1904AP	SCET 150512-UD
GI313	XPET 0502AP-SD	SCET 050204-SD
GI314	XPET 0602AP-SD	SCET 050204-SD
GI315	XPET 0602AP-SD	SCET 060204-SD
GI316	XPET 0703AP-SD	SCET 060204-SD
GI317	XPET 0703AP-SD	SCET 070308-SD
GI318	XPET 0903AP-SD	SCET 070308-SD
GI319	XPET 0903AP-SD	SCET 09T308-SD

GI320	XPET 11T3AP-SD	SCET 09T308-SD
GI321	XPET 11T3AP-SD	SCET 120408-SD
GI322	XPET 12T3AP-SD	SCET 120408-SD
GI323	XPET 1504AP-SD	SCET 120408-SD
GI324	XPET 1504AP-SD	SCET 150512-SD
GI325	XPET 1904AP-SD	SCET 150512-SD

		Nm		Nm	
HM001	US 2245-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM002	US 2205-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM003	US 2205-T07P	0.9	US 2205-T07P	0.9	FLAG T07P
HM004	US 2506-T07P	1.2	US 2506-T07P	1.2	FLAG T07P
HM005	US 2507-T08P	1.2	US 3007-T08P	2.0	FLAG T08P
HM006	US 3007-T09P	2.0	US 3007-T09P	2.0	FLAG T09P
HM007	US 3007-T09P	2.0	US 3009-T09P	2.0	FLAG T09P
HM008	US 3510-T15P	3.0	US 3508-T15P	3.0	FLAG T15P
HM009	US 3510-T15P	3.0	US 5012-T15P	5.0	FLAG T15P
HM010	US 4011-T15P	3.5	US 5012-T15P	5.0	FLAG T15P

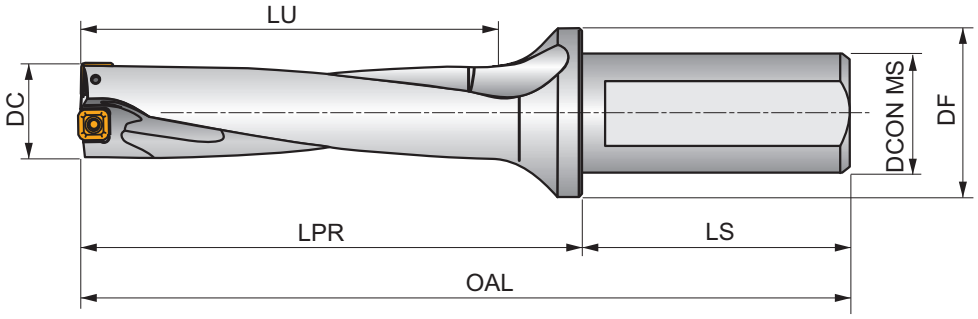
804D

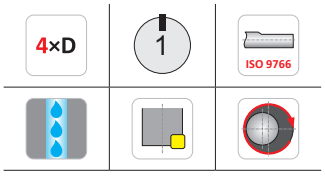
P M K N S H

PRAMET

S

4倍径804D内冷可转位刀片式钻头
高性能的可转位刀片式钻头的刀体，适用于盲孔和通孔，此外也可用于潜在的贯穿孔、偏心钻孔以及层叠板钻孔，螺旋插补，在凹面或斜面钻孔，啄钻，钻倒角和镗孔，直径从D17至D58的4倍径钻头。





Product	DC (mm)	APMX (mm)	OAL (mm)	LPR (mm)	LS (mm)	LU (mm)	DCON MS (mm)	DF (mm)	-D (mm)	D+ (mm)				kg	
804D-17-68-S25	17	68.00	149	93	56	73	25	35	0.10	0.50	–	GI300	GI313	0.34	HM001
804D-18-72-S25	18	72.00	153	97	56	77	25	35	0.35	0.25	–	GI301	GI314	0.35	HM002
804D-19-76-S25	19	76.00	157	101	56	81.5	25	35	0.15	0.45	–	GI301	GI314	0.36	HM002
804D-20-80-S25	20	80.00	161	105	56	85	25	35	0.10	0.45	–	GI302	GI315	0.37	HM003
804D-21-84-S25	21	84.00	165	109	56	89.5	25	35	0.10	0.50	–	GI302	GI315	0.43	HM003
804D-22-88-S25	22	88.00	169	113	56	94	25	35	0.45	0.50	–	GI303	GI316	0.45	HM004
804D-23-92-S25	23	92.00	173	117	56	98.5	25	35	0.35	0.50	–	GI304	GI317	0.44	HM005
804D-24-96-S25	24	96.00	177	121	56	103	25	35	0.15	0.50	–	GI304	GI317	0.45	HM005
804D-25-100-S32	25	100.00	185	125	60	105	32	42	0.15	0.50	–	GI304	GI317	0.67	HM005
804D-26-104-S32	26	104.00	189	129	60	109.5	32	42	0.10	0.50	–	GI304	GI317	0.70	HM005
804D-27-108-S32	27	108.00	193	133	60	114	32	42	0.50	0.30	–	GI305	GI318	0.71	HM006
804D-28-112-S32	28	112.00	197	137	60	118.5	32	42	0.30	0.50	–	GI306	GI319	0.75	HM007
804D-29-116-S32	29	116.00	201	141	60	123	32	42	0.20	0.50	–	GI306	GI319	0.78	HM007
804D-30-120-S32	30	120.00	205	145	60	127.5	32	42	0.15	0.50	–	GI306	GI319	0.82	HM007
804D-31-124-S32	31	124.00	209	149	60	132	32	42	0.15	0.50	–	GI306	GI319	0.85	HM007
804D-32-128-S32	32	128.00	213	153	60	136.5	32	42	0.50	0.30	–	GI307	GI320	0.90	HM008
804D-33-132-S32	33	132.00	217	157	60	141	32	42	0.50	0.50	–	GI307	GI320	0.95	HM008
804D-34-136-S32	34	136.00	221	161	60	145.5	32	42	0.25	0.50	–	GI307	GI320	0.99	HM008
804D-35-140-S32	35	140.00	225	165	60	149	32	42	0.25	0.50	–	GI308	GI321	1.04	HM009
804D-36-144-S32	36	144.00	229	169	60	153.5	32	42	0.10	0.50	–	GI308	GI321	1.05	HM009
804D-37-148-S32	37	148.00	233	173	60	158	32	42	0.10	0.50	–	GI308	GI321	1.11	HM009
804D-38-152-S32	38	152.00	237	177	60	162.5	32	42	0.50	0.50	–	GI308	GI321	1.18	HM009
804D-39-156-S32	39	156.00	241	181	60	167	32	42	0.40	0.50	–	GI309	GI322	1.25	HM009
804D-40-160-S32	40	160.00	245	185	60	171.5	32	42	0.20	0.50	–	GI309	GI322	1.33	HM009
804D-41-164-S40	41	164.00	259	189	70	172	40	50	0.20	0.50	–	GI309	GI322	1.68	HM009
804D-42-168-S40	42	168.00	263	193	70	176.5	40	50	0.15	0.50	–	GI309	GI322	1.76	HM009
804D-43-172-S40	43	172.00	267	197	70	181	40	50	0.10	0.50	–	GI309	GI322	1.83	HM009

Product	DC (mm)	APMX (mm)	OAL (mm)	LPR (mm)	LS (mm)	LU (mm)	DCON MS (mm)	DF (mm)	-D (mm)	D+ (mm)				kg	
804D-44-176-S40	44	176.00	271	201	70	185.5	40	50	0.50	0.50	–	GI310	GI323	1.91	HM010
804D-45-180-S40	45	180.00	275	205	70	187.5	40	55	0.50	0.50	–	GI311	GI324	2.02	HM010
804D-46-184-S40	46	184.00	279	209	70	192	40	55	0.50	0.50	–	GI311	GI324	2.12	HM010
804D-47-188-S40	47	188.00	283	213	70	196.5	40	55	0.50	0.50	–	GI311	GI324	2.22	HM010
804D-48-192-S40	48	192.00	287	217	70	201	40	55	0.50	0.50	–	GI311	GI324	2.33	HM010
804D-49-196-S40	49	196.00	291	221	70	205.5	40	55	0.30	0.50	–	GI311	GI324	2.45	HM010
804D-50-200-S40	50	200.00	295	225	70	208.5	40	58	0.15	0.50	–	GI311	GI324	2.58	HM010
804D-51-204-S40	51	204.00	299	229	70	213	40	58	0.15	0.50	–	GI311	GI324	2.68	HM010
804D-52-208-S40	52	208.00	303	233	70	217.5	40	58	0.50	0.50	–	GI312	GI325	2.64	HM010
804D-53-212-S40	53	212.00	307	237	70	222	40	58	0.50	0.50	–	GI312	GI325	2.76	HM010
804D-54-216-S40	54	216.00	311	241	70	226.5	40	58	0.50	0.50	–	GI312	GI325	2.90	HM010
804D-55-220-S40	55	220.00	315	245	70	231	40	58	0.50	0.50	–	GI312	GI325	3.00	HM010
804D-56-224-S40	56	224.00	319	249	70	235.5	40	58	0.50	0.50	–	GI312	GI325	3.15	HM010
804D-57-228-S40	57	228.00	323	253	70	240	40	58	0.35	0.50	–	GI312	GI325	3.30	HM010
804D-58-232-S40	58	232.00	327	257	70	244.5	40	58	0.15	0.50	–	GI312	GI325	3.46	HM010

	INT	EXT
GI300	XPET 0502AP	SCET 050204-UD
GI301	XPET 0602AP	SCET 050204-UD
GI302	XPET 0602AP	SCET 060204-UD
GI303	XPET 0703AP	SCET 060204-UD
GI304	XPET 0703AP	SCET 070308-UD
GI305	XPET 0903AP	SCET 070308-UD
GI306	XPET 0903AP	SCET 09T308-UD
GI307	XPET 11T3AP	SCET 09T308-UD
GI308	XPET 11T3AP	SCET 120408-UD
GI309	XPET 12T3AP	SCET 120408-UD
GI310	XPET 1504AP	SCET 120408-UD
GI311	XPET 1504AP	SCET 150512-UD
GI312	XPET 1904AP	SCET 150512-UD
GI313	XPET 0502AP-SD	SCET 050204-SD
GI314	XPET 0602AP-SD	SCET 050204-SD
GI315	XPET 0602AP-SD	SCET 060204-SD
GI316	XPET 0703AP-SD	SCET 060204-SD
GI317	XPET 0703AP-SD	SCET 070308-SD
GI318	XPET 0903AP-SD	SCET 070308-SD
GI319	XPET 0903AP-SD	SCET 09T308-SD
GI320	XPET 11T3AP-SD	SCET 09T308-SD
GI321	XPET 11T3AP-SD	SCET 120408-SD
GI322	XPET 12T3AP-SD	SCET 120408-SD
GI323	XPET 1504AP-SD	SCET 120408-SD
GI324	XPET 1504AP-SD	SCET 150512-SD
GI325	XPET 1904AP-SD	SCET 150512-SD

		Nm		Nm	
HM001	US 2245-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM002	US 2205-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM003	US 2205-T07P	0.9	US 2205-T07P	0.9	FLAG T07P
HM004	US 2506-T07P	1.2	US 2506-T07P	1.2	FLAG T07P
HM005	US 2507-T08P	1.2	US 3007-T08P	2.0	FLAG T08P
HM006	US 3007-T09P	2.0	US 3007-T09P	2.0	FLAG T09P
HM007	US 3007-T09P	2.0	US 3009-T09P	2.0	FLAG T09P
HM008	US 3510-T15P	3.0	US 3508-T15P	3.0	FLAG T15P
HM009	US 3510-T15P	3.0	US 5012-T15P	5.0	FLAG T15P
HM010	US 4011-T15P	3.5	US 5012-T15P	5.0	FLAG T15P

805D

P M K N S H

PRAMET

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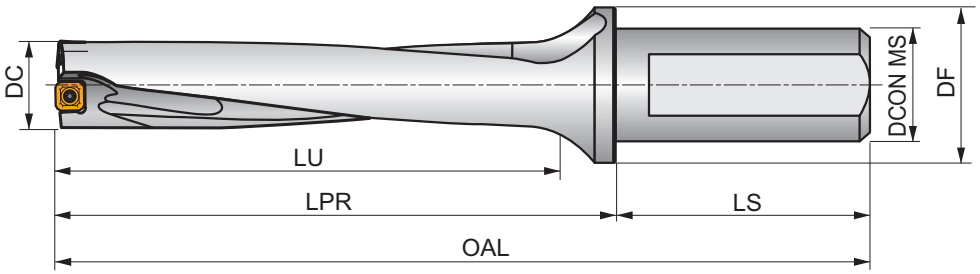
5倍径805D内冷可转位刀片式钻头
高性能的可转位刀片式钻头的刀体，适用于盲孔和通孔，此外也可用于潜在的贯穿孔、偏心钻孔以及层叠板钻孔，螺旋插补，在凹面或斜面钻孔，啄钻，钻倒角和镗孔，直径从D19至D31的5倍径的钻头。



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Product	DC (mm)	APMX (mm)	OAL (mm)	LPR (mm)	LS (mm)	LU (mm)	DCON MS (mm)	DF (mm)	-D (mm)	D+ (mm)				kg	
805D-19-95-S25	19	95.00	176	120	56	100.5	25	35	0.15	0.45	–	GI301	GI314	0.38	HM002
805D-20-100-S25	20	100.00	181	125	56	105	25	35	0.10	0.45	–	GI302	GI315	0.40	HM003
805D-21-105-S25	21	105.00	186	130	56	110.5	25	35	0.10	0.50	–	GI302	GI315	0.42	HM003
805D-22-110-S25	22	110.00	191	135	56	116	25	35	0.45	0.50	–	GI303	GI316	0.45	HM004
805D-23-115-S25	23	115.00	196	140	56	121.5	25	35	0.35	0.50	–	GI304	GI317	0.48	HM005
805D-24-120-S25	24	120.00	201	145	56	127	25	35	0.15	0.50	–	GI304	GI317	0.49	HM005
805D-25-125-S32	25	125.00	210	150	60	130	32	42	0.15	0.50	–	GI304	GI317	0.72	HM005
805D-26-130-S32	26	130.00	215	155	60	135.5	32	42	0.10	0.50	–	GI304	GI317	0.82	HM005
805D-27-135-S32	27	135.00	220	160	60	141	32	42	0.50	0.30	–	GI305	GI318	0.78	HM006
805D-28-140-S32	28	140.00	225	165	60	146.5	32	42	0.30	0.50	–	GI306	GI319	0.82	HM007
805D-29-145-S32	29	145.00	230	170	60	152	32	42	0.20	0.50	–	GI306	GI319	0.86	HM007
805D-30-150-S32	30	150.00	235	175	60	157.5	32	42	0.15	0.50	–	GI306	GI319	0.90	HM007
805D-31-155-S32	31	155.00	240	180	60	163	32	42	0.15	0.50	–	GI306	GI319	0.95	HM007

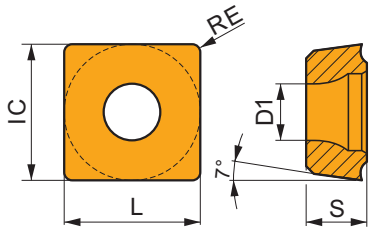
	INT	EXT
GI301	XPET 0602AP	SCET 050204-UD
GI302	XPET 0602AP	SCET 060204-UD
GI303	XPET 0703AP	SCET 060204-UD
GI304	XPET 0703AP	SCET 070308-UD
GI305	XPET 0903AP	SCET 070308-UD
GI306	XPET 0903AP	SCET 09T308-UD
GI314	XPET 0602AP-SD	SCET 050204-SD
GI315	XPET 0602AP-SD	SCET 060204-SD
GI316	XPET 0703AP-SD	SCET 060204-SD
GI317	XPET 0703AP-SD	SCET 070308-SD
GI318	XPET 0903AP-SD	SCET 070308-SD
GI319	XPET 0903AP-SD	SCET 09T308-SD

		Nm		Nm	
HM002	US 2205-T07P	0.9	US 2245-T07P	0.9	FLAG T07P
HM003	US 2205-T07P	0.9	US 2205-T07P	0.9	FLAG T07P
HM004	US 2506-T07P	1.2	US 2506-T07P	1.2	FLAG T07P
HM005	US 2507-T08P	1.2	US 3007-T08P	2.0	FLAG T08P
HM006	US 3007-T09P	2.0	US 3007-T09P	2.0	FLAG T09P
HM007	US 3007-T09P	2.0	US 3009-T09P	2.0	FLAG T09P

SCET

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0502	5.556	2.40	5.56	2.38
0602	6.350	2.90	6.35	2.38
0703	7.937	3.50	7.94	3.18
09T3	9.525	4.50	9.53	3.97
1204	12.700	5.60	12.70	4.76
1505	15.875	5.60	15.88	5.56



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
	SCET 050204-UD 0,12 SCET 060204-UD 0,15 SCET 070308-UD 0,15 SCET 09T308-UD 0,15 SCET 120408-UD 0,20 SCET 150512-UD 0,20																			
SCET 050204-UD:D8330	●	0.4	165	0.08	–	–	–	–	155	0.08	–	–	–	–	–	–	–	–	–	–
SCET 050204-UD:D9335	●	0.4	240	0.08	–	–	–	–	225	0.08	–	–	–	–	–	–	–	–	–	–
SCET 060204-UD:D8330	●	0.4	165	0.11	–	–	–	–	155	0.11	–	–	–	–	–	–	–	–	–	–
SCET 060204-UD:D9335	●	0.4	240	0.11	–	–	–	–	225	0.11	–	–	–	–	–	–	–	–	–	–
SCET 070308-UD:D8330	⧗	0.8	165	0.13	–	–	–	–	155	0.13	–	–	–	–	–	–	–	–	–	–
SCET 070308-UD:D9335	⧗	0.8	240	0.13	–	–	–	–	225	0.13	–	–	–	–	–	–	–	–	–	–
SCET 09T308-UD:D8330	⧗	0.8	165	0.14	–	–	–	–	155	0.14	–	–	–	–	–	–	–	–	–	–
SCET 09T308-UD:D9335	⧗	0.8	240	0.14	–	–	–	–	225	0.14	–	–	–	–	–	–	–	–	–	–
SCET 120408-UD:D8330	⧗	0.8	165	0.16	–	–	–	–	155	0.16	–	–	–	–	–	–	–	–	–	–
SCET 120408-UD:D9335	⧗	0.8	240	0.16	–	–	–	–	225	0.16	–	–	–	–	–	–	–	–	–	–
SCET 150512-UD:D8330	⧗	1.2	165	0.18	–	–	–	–	155	0.18	–	–	–	–	–	–	–	–	–	–
SCET 150512-UD:D9335	⧗	1.2	240	0.18	–	–	–	–	225	0.18	–	–	–	–	–	–	–	–	–	–
	SCET 050204-SD 0,04 SCET 060204-SD 0,06 SCET 070308-SD 0,08 SCET 09T308-SD 0,10 SCET 120408-SD 0,10 SCET 150512-SD 0,10																			
SCET 050204-SD:D8330	●	0.4	165	0.08	–	95	0.07	–	155	0.08	–	–	–	–	40	0.06	–	–	–	–
SCET 050204-SD:D9335	●	0.4	240	0.08	–	140	0.07	–	225	0.08	–	–	–	–	60	0.06	–	–	–	–
SCET 060204-SD:D8330	●	0.4	165	0.11	–	95	0.09	–	155	0.11	–	–	–	–	40	0.07	–	–	–	–
SCET 060204-SD:D9335	●	0.4	240	0.11	–	140	0.09	–	225	0.11	–	–	–	–	60	0.07	–	–	–	–
SCET 070308-SD:D8330	⧗	0.8	165	0.13	–	95	0.11	–	155	0.13	–	–	–	–	40	0.09	–	–	–	–
SCET 070308-SD:D9335	⧗	0.8	240	0.13	–	140	0.11	–	225	0.13	–	–	–	–	60	0.09	–	–	–	–
SCET 09T308-SD:D8330	⧗	0.8	165	0.14	–	95	0.13	–	155	0.14	–	–	–	–	40	0.10	–	–	–	–
SCET 09T308-SD:D9335	⧗	0.8	240	0.14	–	140	0.13	–	225	0.14	–	–	–	–	60	0.10	–	–	–	–
SCET 120408-SD:D8330	⧗	0.8	165	0.16	–	95	0.14	–	155	0.16	–	–	–	–	40	0.11	–	–	–	–
SCET 120408-SD:D9335	⧗	0.8	240	0.16	–	140	0.14	–	225	0.16	–	–	–	–	60	0.11	–	–	–	–
SCET 150512-SD:D8330	⧗	1.2	165	0.18	–	95	0.16	–	155	0.18	–	–	–	–	40	0.12	–	–	–	–
SCET 150512-SD:D9335	⧗	1.2	240	0.18	–	140	0.16	–	225	0.18	–	–	–	–	60	0.12	–	–	–	–

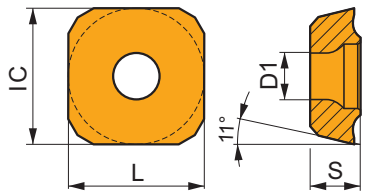
用于外侧刀片的通用UD槽型

用于外侧刀片的锋利SD槽型

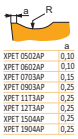
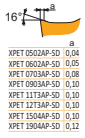
XPET

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0502	5.556	2.40	5.56	2.38
0602	6.350	2.60	6.35	2.38
0703	7.937	2.90	7.94	3.18
0903	9.525	3.50	9.53	3.18
11T3	11.509	3.90	11.50	3.97
12T3	12.700	3.90	12.70	3.97
1504	15.875	4.50	15.88	4.76
1904	19.050	4.50	19.05	4.76



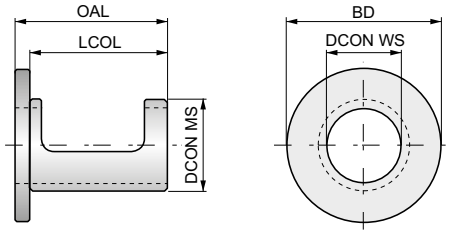
线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
			用于中心刀片的通用槽型																	
XPET 0502AP:D8345		–	165	0.08	–	–	–	–	155	0.08	–	–	–	–	–	–	–	–	–	–
XPET 0602AP:D8345		–	165	0.11	–	–	–	–	155	0.11	–	–	–	–	–	–	–	–	–	–
XPET 0703AP:D8345		–	165	0.13	–	–	–	–	155	0.13	–	–	–	–	–	–	–	–	–	–
XPET 0903AP:D8345		–	165	0.14	–	–	–	–	155	0.14	–	–	–	–	–	–	–	–	–	–
XPET 11T3AP:D8345		–	165	0.16	–	–	–	–	155	0.16	–	–	–	–	–	–	–	–	–	–
XPET 12T3AP:D8345		–	165	0.16	–	–	–	–	155	0.16	–	–	–	–	–	–	–	–	–	–
XPET 1504AP:D8345		–	165	0.18	–	–	–	–	155	0.18	–	–	–	–	–	–	–	–	–	–
XPET 1904AP:D8345		–	165	0.18	–	–	–	–	155	0.18	–	–	–	–	–	–	–	–	–	–
			用于中心刀片的锋利SD槽型																	
XPET 0502AP-SD:D8345		–	165	0.08	–	95	0.07	–	155	0.08	–	–	–	–	40	0.06	–	–	–	–
XPET 0602AP-SD:D8345		–	165	0.11	–	95	0.09	–	155	0.11	–	–	–	–	40	0.07	–	–	–	–
XPET 0703AP-SD:D8345		–	165	0.13	–	95	0.11	–	155	0.13	–	–	–	–	40	0.09	–	–	–	–
XPET 0903AP-SD:D8345		–	165	0.14	–	95	0.13	–	155	0.14	–	–	–	–	40	0.10	–	–	–	–
XPET 11T3AP-SD:D8345		–	165	0.16	–	95	0.14	–	155	0.16	–	–	–	–	40	0.11	–	–	–	–
XPET 12T3AP-SD:D8345		–	165	0.16	–	95	0.14	–	155	0.16	–	–	–	–	40	0.11	–	–	–	–
XPET 1504AP-SD:D8345		–	165	0.18	–	95	0.16	–	155	0.18	–	–	–	–	40	0.12	–	–	–	–
XPET 1904AP-SD:D8345		–	165	0.18	–	95	0.16	–	155	0.18	–	–	–	–	40	0.12	–	–	–	–

EP

PRAMET

可转位刀片式钻头的调整套
用于调整浅孔钻切削直径的偏心套，可安装于?32或?40的侧固刀柄，通过旋转偏心套以调整切削外径。



DCON MS 公差h6; RE +0/-0.02 mm

Product	DCON WS (mm)	DCON MS (mm)	BD (mm)	OAL (mm)	LCOL (mm)	kg
EP253253	25.00	32.00	53.00	53.0	48	0.15
EP324058	32.00	40.00	58.00	58.0	53	0.19
EP405085-F	40.00	50.00	76.00	85.0	80	0.25

材料代码(BMC)	HM	HM	HM	HM	HM
涂层	Bright	Bright	Bright	Bright	Bright
基本标准组(BSG)	DIN 8093	DIN 8093	DIN 8050	DIN 8094	DIN 8051
旋向(切削方向)	R	R	R	R	R
柄部		DIN 6535HA			
铰刀形式	B	B	A	B	A
可达到的孔公差 (TCHA)	H7	ø.95-5.5 +0.004 ø5.51-12 +0.005	H7	H7	H7

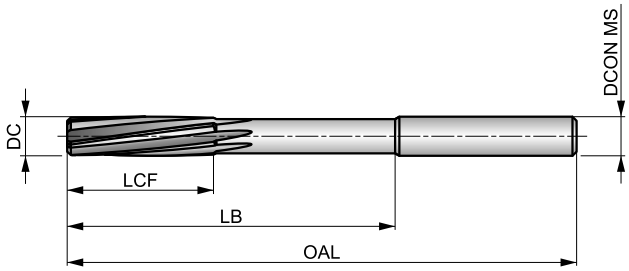
产品系列代码	B400	B481	B441	B411	B442
PSF切削直径范围	1.00 - 20.00	0.98 - 12.05	10.00 - 20.00	5.00 - 30.00	10.00 - 20.00
	250	251	253	254	255
P P1	■	■	■	■	■
P P2	■	■	■	■	■
P P3	■	■	■	■	■
P P4	■	■	■	■	■
M M1	◩	◩	◩	◩	◩
M M2	◩	◩	◩	◩	◩
M M3					
M M4					
K K1	■	■	■	■	■
K K2	■	■	■	■	■
K K3	■	■	■	■	■
K K4					
K K5	■	■	■	■	■
N N1	■	■	■	■	■
N N2	■	■	■	■	■
N N3	■	■	■	■	■
N N4	◩	◩	◩	◩	◩
N N5					
S S1					
S S2					
S S3					
S S4					
H H1					
H H2					
H H3					
H H4					

■推荐使用 ◩可以使用

B400

DORMER

合金机用直柄铰刀，孔径精度H7，表面光亮处理。
一种用于孔径公差H7的精加工铰刀，加工硬材料和研磨材料具有卓越的性能和延长的刀具寿命，极不等分的螺旋槽设计从而减少振动并改善孔径尺寸、圆度和表面质量。



HM	Bright	DIN 8093
R		B
H7		

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■23 B	■26 B	■27 B	■20 B	■18 B	■16 C	■16 B	■13 B	■11 C	■10 B	■8 C	■7 C	◪10 C	◪8 C
M2.1	**M2.2**	**M2.3**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**
◪9 C	◪7 C	◪6 B	■20 D	■15 D	■11 D	■21 D	■17 D	■14 D	■18 D	■14 D	■11 D	■19 D	■15 D
K5.3	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**		
■11 D	◪60 D	■45 D	■30 D	■38 D	■35 D	■25 D	■64 E	■38 E	◪19 E	◪35 C	◪30 C		

DCON MS公差h6; DC>= 14 mm 硬质合金镶片

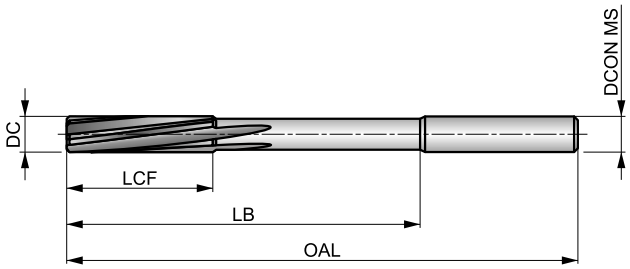
Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	DCON MS (mm)
B4001.0	1.00	34.0	5.5	15.00	3	1.00
B4001.2	1.20	38.0	7.5	16.50	3	1.20
B4001.4	1.40	40.0	8.0	18.00	3	1.50
B4001.5	1.50	40.0	8.0	18.00	3	1.50
B4001.6	1.60	43.0	9.0	20.00	3	1.60
B4001.8	1.80	46.0	10.0	22.00	4	1.80
B4002.0	2.00	49.0	11.0	24.00	4	2.00
B4002.2	2.20	53.0	12.0	25.00	4	2.20
B4002.5	2.50	57.0	14.0	29.00	4	2.50
B4002.8	2.80	61.0	15.0	33.00	6	3.00
B4003.0	3.00	61.0	15.0	33.00	6	3.00
B4003.2	3.20	65.0	16.0	37.00	6	3.20
B4003.5	3.50	70.0	18.0	42.00	6	3.50
B4004.0	4.00	75.0	19.0	47.00	6	4.00

Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	DCON MS (mm)
B4004.5	4.50	80.0	21.0	52.00	6	4.50
B4005.0	5.00	86.0	23.0	58.00	6	5.00
B4005.5	5.50	93.0	26.0	57.00	6	5.60
B4006.0	6.00	93.0	26.0	57.00	6	5.60
B4006.5	6.50	101.0	28.0	65.00	6	6.30
B4007.0	7.00	109.0	31.0	73.00	6	7.10
B4008.0	8.00	117.0	33.0	81.00	6	8.00
B4009.0	9.00	125.0	36.0	85.00	6	9.00
B40010.0	10.00	133.0	38.0	93.00	6	10.00
B40012.0	12.00	151.0	44.0	111.00	6	10.00
B40014.0	14.00	160.0	47.0	115.00	6	12.50
B40016.0	16.00	170.0	52.0	125.00	6	12.50
B40018.0	18.00	182.0	56.0	137.00	6	14.00
B40020.0	20.00	195.0	60.0	147.00	6	16.00

B481

DORMER

合金机用直柄铰刀，孔径精度增量0.01mm，表面光亮处理。
用于数控机床的高性能直柄钻头，不同的增量尺寸能够加工精确的孔径和公差，适用于加工硬材料和研磨材料优质的合金刃口，能够极大地提高性能并延长刀具寿命，极不等分的螺旋槽设计从而减少振动。



HM	Bright	DIN 8093
R	DIN 6535HA	B
ø.95-5.5 +0.004 ø5.51-12 +0.005		

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■23 B	■26 B	■27 B	■20 B	■18 B	■16 C	■16 B	■13 B	■11 C	■10 B	■8 C	■7 C	◪10 C	◪8 C
M2.1	**M2.2**	**M2.3**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**
◪9 C	◪7 C	◪6 B	■20 D	■15 D	■11 D	■21 D	■17 D	■14 D	■18 D	■14 D	■11 D	■19 D	■15 D
K5.3	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**		
■11 D	◪60 D	■45 D	■30 D	■38 D	■35 D	■25 D	■64 E	■38 E	◪19 E	◪35 C	◪30 C		

DCON MS公差h6

Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	DCON MS (mm)
B4810.98	0.98	50.0	6.0	22.00	3	3.00
B4810.99	0.99	50.0	6.0	22.00	3	3.00
B4811.03	1.03	50.0	6.0	22.00	3	3.00
B4811.50	1.50	50.0	9.0	22.00	3	3.00
B4811.51	1.51	50.0	10.0	22.00	3	3.00
B4811.52	1.52	50.0	10.0	22.00	3	3.00
B4811.53	1.53	50.0	10.0	22.00	3	3.00
B4811.98	1.98	50.0	12.0	22.00	4	3.00
B4811.99	1.99	50.0	12.0	22.00	4	3.00
B4812.00	2.00	50.0	12.0	22.00	4	3.00
B4812.01	2.01	50.0	12.0	22.00	4	3.00
B4812.02	2.02	50.0	12.0	22.00	4	3.00
B4812.03	2.03	50.0	12.0	22.00	4	3.00
B4812.48	2.48	60.0	16.0	32.00	4	3.00
B4812.49	2.49	60.0	16.0	32.00	4	3.00
B4812.50	2.50	60.0	16.0	32.00	4	3.00
B4812.51	2.51	60.0	16.0	32.00	4	3.00
B4812.52	2.52	60.0	16.0	32.00	4	3.00
B4812.53	2.53	60.0	16.0	32.00	4	3.00
B4812.97	2.97	65.0	17.0	37.00	6	4.00
B4812.98	2.98	65.0	17.0	37.00	6	4.00
B4812.99	2.99	65.0	17.0	37.00	6	4.00
B4813.00	3.00	65.0	17.0	37.00	6	4.00
B4813.01	3.01	65.0	17.0	37.00	6	4.00
B4813.02	3.02	65.0	17.0	37.00	6	4.00
B4813.03	3.03	65.0	17.0	37.00	6	4.00
B4813.97	3.97	75.0	19.0	47.00	6	4.00

Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	DCON MS (mm)
B4813.98	3.98	75.0	19.0	47.00	6	4.00
B4813.99	3.99	75.0	19.0	47.00	6	4.00
B4814.00	4.00	75.0	19.0	47.00	6	4.00
B4814.01	4.01	75.0	19.0	47.00	6	4.00
B4814.02	4.02	75.0	19.0	47.00	6	4.00
B4814.03	4.03	75.0	19.0	47.00	6	4.00
B4814.97	4.97	93.0	23.0	57.00	6	6.00
B4814.98	4.98	93.0	23.0	57.00	6	6.00
B4814.99	4.99	93.0	23.0	57.00	6	6.00
B4815.00	5.00	93.0	23.0	57.00	6	6.00
B4815.01	5.01	93.0	23.0	57.00	6	6.00
B4815.02	5.02	93.0	23.0	57.00	6	6.00
B4815.03	5.03	93.0	23.0	57.00	6	6.00
B4815.97	5.97	93.0	26.0	57.00	6	6.00
B4815.98	5.98	93.0	26.0	57.00	6	6.00
B4815.99	5.99	93.0	26.0	57.00	6	6.00
B4816.00	6.00	93.0	26.0	57.00	6	6.00
B4816.01	6.01	93.0	26.0	57.00	6	6.00
B4816.02	6.02	93.0	26.0	57.00	6	6.00
B4816.03	6.03	93.0	26.0	57.00	6	6.00
B4817.97	7.97	117.0	33.0	81.00	6	8.00
B4817.98	7.98	117.0	33.0	81.00	6	8.00
B4817.99	7.99	117.0	33.0	81.00	6	8.00
B4818.00	8.00	117.0	33.0	81.00	6	8.00
B4818.01	8.01	117.0	33.0	81.00	6	8.00
B4818.02	8.02	117.0	33.0	81.00	6	8.00
B4818.03	8.03	117.0	33.0	81.00	6	8.00

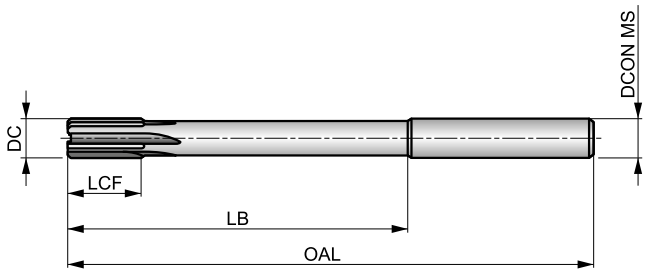
Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	DCON MS (mm)
B4818.04	8.04	117.0	33.0	81.00	6	8.00
B4819.97	9.97	133.0	38.0	93.00	6	10.00
B4819.98	9.98	133.0	38.0	93.00	6	10.00
B4819.99	9.99	133.0	38.0	93.00	6	10.00
B48110.00	10.00	133.0	38.0	93.00	6	10.00
B48110.01	10.01	133.0	38.0	93.00	6	10.00
B48110.02	10.02	133.0	38.0	93.00	6	10.00
B48110.03	10.03	133.0	38.0	93.00	6	10.00
B48110.04	10.04	133.0	38.0	93.00	6	10.00

Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	DCON MS (mm)
B48110.05	10.05	133.0	38.0	93.00	6	10.00
B48111.98	11.98	151.0	44.0	106.00	6	12.00
B48111.99	11.99	151.0	44.0	106.00	6	12.00
B48112.00	12.00	151.0	44.0	106.00	6	12.00
B48112.01	12.01	151.0	44.0	106.00	6	12.00
B48112.02	12.02	151.0	44.0	106.00	6	12.00
B48112.03	12.03	151.0	44.0	106.00	6	12.00
B48112.04	12.04	151.0	44.0	106.00	6	12.00
B48112.05	12.05	151.0	44.0	106.00	6	12.00

B441

DORMER

合金镶片机用直柄铰刀，孔径精度H7，表面光亮处理。
头部钎焊的硬质合金刀尖能够延长刀具寿命，在加工公差H7级孔时具有优异的性能，采用极不等分槽设计，减少振动，提高铰孔精度、圆度和表面光洁度，在数控机床上有着优异的性能。



HM	Bright	DIN 8050
R		A
H7		

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■23 B	■26 B	■27 B	■20 B	■18 B	■16 C	■16 B	■13 B	■11 C	■10 B	■8 C	■7 C	◪10 C	◪8 C
M2.1	**M2.2**	**M2.3**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**
◪9 C	◪7 C	◪6 B	■20 D	■15 D	■11 D	■21 D	■17 D	■14 D	■18 D	■14 D	■11 D	■19 D	■15 D
K5.3	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**		
■11 D	◪60 D	■45 D	■30 D	■38 D	■35 D	■25 D	■64 E	■38 E	◪19 E	◪35 C	◪30 C		

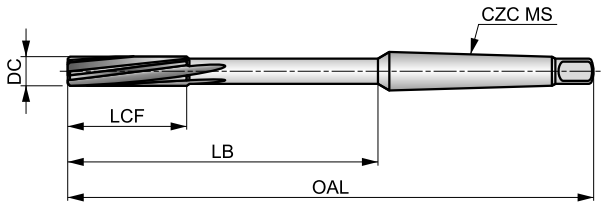
DCON MS公差h9; 硬质合金镶片

Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	DCON MS (mm)
B44110.0	10.00	133.0	19.0	87.00	6	10.00
B44111.0	11.00	142.0	19.0	96.00	6	10.00
B44112.0	12.00	151.0	19.0	105.00	6	10.00
B44113.0	13.00	151.0	19.0	105.00	6	10.00
B44114.0	14.00	160.0	19.0	110.00	6	12.50
B44115.0	15.00	162.0	19.0	112.00	6	12.50
B44116.0	16.00	170.0	22.0	120.00	6	12.50
B44117.0	17.00	175.0	22.0	123.00	6	14.00
B44118.0	18.00	182.0	22.0	130.00	6	14.00
B44119.0	19.00	189.0	22.0	131.00	6	16.00
B44120.0	20.00	195.0	22.0	137.00	6	16.00

B411

DORMER

合金镶片机用锥柄铰刀，孔径精度H7，表面光亮处理。
钎焊硬质合金刀片可显著提高性能，并在加工硬材料和研磨材料时延长刀具寿命。采用极不等分槽设计，能够有效减少振动并提高孔的对称性、尺寸精度和光洁度。



HM	Bright	DIN 8094
R		B
H7		

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■23 B	■26 B	■27 B	■20 B	■18 B	■16 C	■16 B	■13 B	■11 C	■10 B	■8 C	■7 C	◪10 C	◪8 C
M2.1	**M2.2**	**M2.3**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**
◪9 C	◪7 C	◪6 B	■20 D	■15 D	■11 D	■21 D	■17 D	■14 D	■18 D	■14 D	■11 D	■19 D	■15 D
K5.3	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**		
■11 D	◪60 D	■45 D	■30 D	■38 D	■35 D	■25 D	■64 E	■38 E	◪19 E	◪35 C	◪30 C		

DC <= 16mm 硬质合金刀头; DC > 16mm 硬质合金镶片

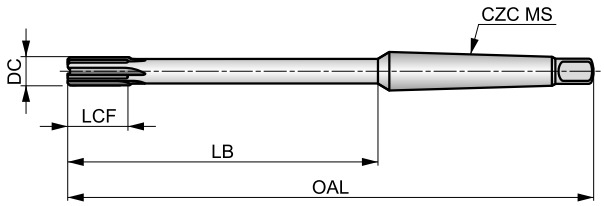
Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	CZC MS
B4115.0	5.00	133.0	23.0	67.50	6	MK 1
B4116.0	6.00	138.0	26.0	72.50	6	MK 1
B4117.0	7.00	150.0	31.0	84.50	6	MK 1
B4118.0	8.00	156.0	33.0	90.50	6	MK 1
B4119.0	9.00	162.0	36.0	96.50	6	MK 1
B41110.0	10.00	168.0	38.0	102.50	6	MK 1
B41112.0	12.00	182.0	44.0	116.50	6	MK 1
B41114.0	14.00	189.0	47.0	123.50	8	MK 1
B41115.0	15.00	204.0	50.0	124.00	8	MK 2
B41116.0	16.00	210.0	52.0	130.00	8	MK 2
B41117.0	17.00	214.0	54.0	134.00	6	MK 2
B41118.0	18.00	219.0	56.0	139.00	6	MK 2
B41119.0	19.00	223.0	58.0	143.00	6	MK 2
B41120.0	20.00	228.0	60.0	148.00	6	MK 2
B41122.0	22.00	237.0	64.0	157.00	6	MK 2
B41124.0	24.00	268.0	68.0	169.00	8	MK 3
B41125.0	25.00	268.0	68.0	169.00	8	MK 3
B41126.0	26.00	273.0	70.0	174.00	8	MK 3
B41130.0	30.00	281.0	73.0	182.00	8	MK 3

B442

DORMER

合金镶片机用锥柄铰刀，孔径精度H7，表面光亮处理。
采用极不等分槽设计，减少振动，提高铰孔精度、圆度和表面光洁度，45°导锥确保了定位精度和定心，从而提高切削性能并改善孔的质量，钎焊的硬质合金刀尖能够延长刀具寿命，并具有优异的性能。

HM	Bright	DIN 8051
R		A
H7		



工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页279开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■23 B	■26 B	■27 B	■20 B	■18 B	■16 C	■16 B	■13 B	■11 C	■10 B	■8 C	■7 C	◪10 C	◪8 C
M2.1	**M2.2**	**M2.3**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**	**K3.3**	**K5.1**	**K5.2**
◪9 C	◪7 C	◪6 B	■20 D	■15 D	■11 D	■21 D	■17 D	■14 D	■18 D	■14 D	■11 D	■19 D	■15 D
K5.3	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**	**N2.3**	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**N4.2**		
■11 D	◪60 D	■45 D	■30 D	■38 D	■35 D	■25 D	■64 E	■38 E	◪19 E	◪35 C	◪30 C		

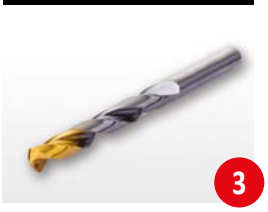
Product	DC (mm)	OAL (mm)	LCF (mm)	LB (mm)	NOF	CZC MS
B44210.0	10.00	168.0	19.0	102.50	6	MK 1
B44212.0	12.00	182.0	19.0	116.50	6	MK 1
B44214.0	14.00	189.0	19.0	123.50	6	MK 1
B44215.0	15.00	204.0	19.0	124.00	6	MK 2
B44216.0	16.00	210.0	22.0	130.00	6	MK 2
B44217.0	17.00	214.0	22.0	134.00	6	MK 2
B44218.0	18.00	219.0	22.0	139.00	6	MK 2
B44219.0	19.00	223.0	22.0	143.00	6	MK 2
B44220.0	20.00	228.0	22.0	148.00	6	MK 2

说明

钻头 – 页面概览

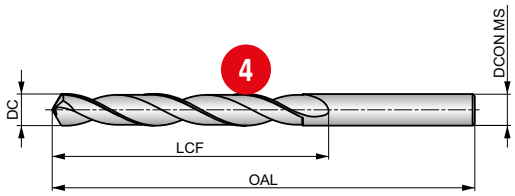
1 **R003**

DORMER


3

整硬合金钻头，TiN 尖端涂层

多功能入门级钻头，钻尖角度为 120°，采用4后面分离式钻尖，可降低阻力，CTW 刀槽结构可提高穿透率。TiN刀尖涂层可提高性能并延长刀具寿命。适用于各种工件材料，包括数控机床和普通机床。 2



HM	DIN 338	4×D
120°	TiN-Tip	5
λ 20-35°	R	DC h7

工件材料组的适用性，线速度(m/min)的起始值和进料Alpha代码。表与饲料每转可以找到从页XY开始。

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	K1.1	K1.2
■ 99 S	■ 111 S	■ 115 S	■ 85 S	■ 75 S	■ 66 S	■ 66 S	■ 53 S	■ 45 S	■ 40 S	■ 34 S	■ 27 S	■ 75 T	■ 56 T
K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	6 1.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2
■ 42 T	■ 68 T	■ 55 T	■ 44 T	■ 60 T	■ 46 T	■ 37 T	55 T	◪ 42 T	◪ 31 T	◪ 26 T	◪ 22 T	■ 63 T	■ 47 T
K5.3	N1.1	N1.2	N1.3	N2.1	N2.2	N2.3	N3.1	N3.2	N4.1	N4.2	H1.1	H2.1	H3.1
■ 37 T	■ 150 V	■ 113 V	■ 75 V	◪ 129 V	◪ 116 V	◪ 84 V	■ 317 V	■ 190 V	■ 60 U	■ 100 U	◪ 34 S	◪ 20 S	◪ 22 S

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R0031.0	–	1.00	0.0394	12.0	34.0	1.00
R003N60	N60	1.02	0.0400	12.0	34.0	1.02
R0031.1	–	1.10	0.0433	14.0	36.0	1.10
R003N56	N56	1.18	0.0465	16.0	38.0	1.18
R[illegible]64	3/64	1.19	0.0469	[illegible]16.0	38.0	1.19
R[illegible] 7	–	1.20	0.047[illegible] 8	[illegible]6.0	38.0	1.20
R0031.3	–	1.30	0.0512	16.0	38.0	1.30
R003N54	N54	1.40	0.0550	18.0	40.0	1.40
R0031.4	–	1.40	0.0551	18.0	40.0	1.40
R0031.5	–	1.50	0.0591	18.0	40.0	1.50
R003N53	N53	1.51	0.0595	20.0	43.0	1.51
R0031/16	1/16	1.59	0.0625	20.0	43.0	1.59
R0031.6	–	1.60	0.0630	20.0	43.0	1.60
R003N52	N52	1.61	0.0635	20.0	43.0	1.61

Product	DC (inch)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
R0032.3	–	2.30	0.0906	27.0	53.0	2.30
R0033/32	3/32	2.38	0.0937	30.0	57.0	2.38
R0032.4	–	2.40	0.0945	30.0	57.0	2.40
R003N41	N41	2.44	0.0960	30.0	57.0	2.44
R0032.5	–	2.50	0.0984	30.0	57.0	2.50
R003N39	N39	2.53	0.0995	30.0	57.0	2.53
R003N38	N38	2.58	0.1015	30.0	57.0	2.58
R0032.6	–	2.60	0.1024	30.0	57.0	2.60
R003N37	N37	2.64	0.1040	30.0	57.0	2.64
R0032.7	–	2.70	0.1063	33.0	61.0	2.70
R003N36	N36	2.71	0.1065	33.0	61.0	2.71
R0037/64	7/64	2.78	0.1094	33.0	61.0	2.78
R0032.8	–	2.80	0.1102	33.0	61.0	2.80
R003N33	N33	2.87	0.1130	33.0	61.0	2.87

图号	描述
1	钻头名称
2	产品描述
3	图示照片
4	刀具示意图

图号	描述
5	产品特点
6	推荐的材料组，包括速度和进给指导
7	产品代码
8	产品尺寸

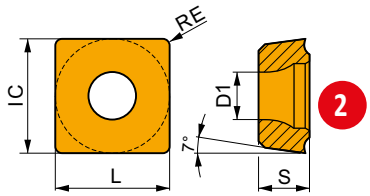
刀片 – 页面概览

1 **SCET**

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0502	5.556	2.[illegible]	5.56	2.38
0602	6.350	2.90	6.35	2.38
0703	7.937	3.50	7.94	3.18
09T3	9.525	4.50	9.53	3.97
1204	12.700	5.60	12.70	4.76
1505	15.875	5.60	15.88	5.56

3



线速度(vc)，进给量(f)和切深(ap)的适用性和起始值。参考我们的Machining Calculator app，以获得进一步的计算。

Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/rev)	P ap (mm)	M vc (m/min)	M f (mm/rev)	M ap (mm)	K vc (m/min)	K f (mm/rev)	K ap (mm)	N vc (m/min)	N f (mm/rev)	N ap (mm)	S vc (m/min)	S f (mm/rev)	S ap (mm)	H vc (m/min)	H f (mm/rev)	H ap (mm)
4	5		6			10 用于外侧刀片的通用UD槽型														
SCET 050204-UD:D8330	●	0.4	165	0.08	–	–	–	–	155	0.08	–	–	–	–	–	–	–	–	–	–
SCET 050204-UD:D9335	●	0.4	240	0.08	–	–	–	–	225	0.08	–	–	–	–	–	–	–	–	–	–
SCET 060204-UD:D8330	●	0.4	165	0.11	–	–	–	–	155	0.11	–	–	–	–	–	–	–	–	–	–
SCET 060204-UD:D9335	●	0.4	240	0.11	–	–	–	–	225	0.11	–	–	–	–	–	–	–	–	–	–
SCET 07[illegible]UD:D8330	●	0.4	165	0.13	–	–	–	–	155	0.13	–	–	–	–	–	–	–	–	–	–
SCET 07[illegible]UD:D9335	●	0.4	240	0.13	–	–	–	–	225	0.13	–	–	–	–	–	–	–	–	–	–
SCET 09T308-UD:D8330	⧗	0.8	165	0.14	–	–	–	–	155	0.14	–	–	–	–	–	–	–	–	–	–
SCET 09T308-UD:D9335	⧗	0.8	240	0.14	–	–	–	–	225	0.14	–	–	–	–	–	–	–	–	–	–
SCET 120408-UD:D8330	⧗	0.8	165	0.16	–	–	–	–	155	0.16	–	–	–	–	–	–	–	–	–	–
SCET 120408-UD:D9335	⧗	0.8	240	0.16	–	–	–	–	225	0.16	–	–	–	–	–	–	–	–	–	–
SCET 150512-UD:D8330	⧗	1.2	165	0.18	–	–	–	–	155	0.18	–	–	–	–	–	–	–	–	–	–
SCET 150512-UD:D9335	⧗	1.2	240	0.18	–	–	–	–	225	0.18	–	–	–	–	–	–	–	–	–	–

7 8 9 11

图号	描述
1	刀片名称
2	刀片示意图
3	刀片尺寸表 (mm)
4	典型刀片的图片
5	主切削刃廓形
6	图标 - 具体特点和切削刃类型

图号	描述
7	ISO刀片代码: 涂层
8	工况
9	刀片半径 (mm)
10	槽型描述
11	刀片应用领域

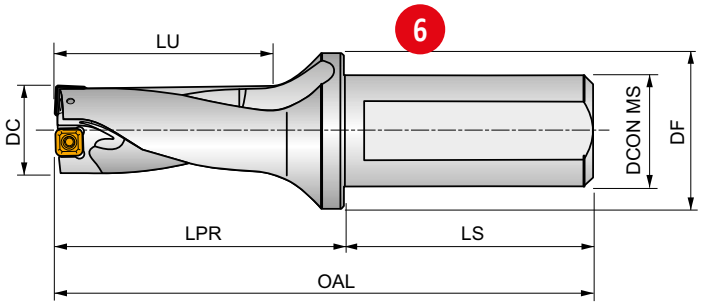
Typical page with drilling inserts displayed – specific page details will differ.

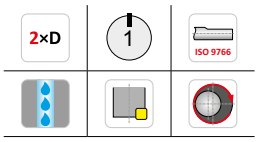
可转位钻头 – 页面概览

1 **802D** P M K N S H 2 PRAMET S 3

5

2倍径802D内冷可转位刀片式钻头
高性能的可转位刀片式钻头的刀体，适用于盲孔和通孔，此外也可用于潜在的贯穿孔、偏心钻孔以及层叠板钻孔，螺旋插补，在凹面或斜面钻孔，啄钻，钻倒角和镗孔，直径从?15至?40的2倍径钻头。 4





7

8

Product	DC [mm]	APMX [mm]	OAL [mm]	LPR [mm]	LS [mm]	LU [mm]	DCON MS [mm]	DF [mm]	-D [mm]	D+ [mm]				kg	
802D-15-30-S25	15	30.00	121	65	56	34.5	25	35	0.25	0.35	EP253253	GI300	GI313	0.30	HM001
802D-16-32-S25	16	32.00	123	67	56	37	25	35	0.15	0.45	EP253253	GI300	GI313	0.30	HM001
802D-17-34-S25	17	34.00	125	69	56	39.5	25	35	0.[illegible]	[illegible].50	EP253253	GI300	GI313	0.31	HM001
802D-18-36-S25	18	36.00	127	71	56	42	25	35	0.35	0.25	EP253253	GI301	GI314	0.31	HM002
802D-19-38-S25	19	38.00	129	73	56	44.5	25	35	0.15	0.45	EP253253	GI301	GI314	0.32	HM002
802D-20-40-S25	20	40.00	131	75	56	47	25	35	0.10	0.45	EP253253	GI302	GI315	0.33	HM003
802D-21-42-S25	21	42.00	133	77	56	49.5	25	35	0.10	0.50	EP253253	GI302	GI315	0.34	HM003
802D-22-44-S25	22	44.00	135	79	56	52	25	35	0.45	0.50	EP253253	GI303	GI316	0.35	HM004
802D-23-46-S25	23	46.00	137	81	56	54.5	25	35	0.35	0.50	EP253253	GI304	GI317	0.36	HM005
802D-24-48-S25	24	48.00	139	83	56	57	25	35	0.15	0.50	EP253253	GI304	GI317	0.37	HM005

9 10 11 12 13 14 15 16

GI300	XPET 0502AP	SCET 050204-UD
GI301	XPET 0602AP	SCET 050204-UD
GI302	XPET 0602AP	SCET 060204-UD
GI303	XPET 0703AP	SCET 060204-UD
GI304	XPET 0703AP	SCET 070308-UD
GI305	XPET 0903AP	SCET 070308-UD
GI306	XPET 0903AP	SCET 09T308-UD
GI307	XPET 11T3AP	SCET 09T308-UD
GI308	XPET 11T3AP	SCET 120408-UD
GI309	XPET 12T3AP	SCET 120408-UD
GI313	XPET 0502AP-SD	SCET 050204-SD
GI314	XPET 0602AP-SD	SCET 050204-SD
GI315	XPET 0602AP-SD	SCET 060204-SD
GI316	XPET 0703AP-SD	SCET 060204-SD
GI317	XPET 0703AP-SD	SCET 070308-SD

17 18

GI300	XPET 0502AP	SCET 050204-UD
GI301	XPET 0602AP	SCET 050204-UD
GI302	XPET 0602AP	SCET 060204-UD
GI303	XPET 0703AP	SCET 060204-UD
GI304	XPET 0703AP	SCET 070308-UD

19

所示为带钻孔刀架的典型页面 - 具体页面详情可能有所不同。

可转位钻头 – 页面概览

图号	描述
1	钻头名称
2	推荐的材料组
3	刀片夹紧系统
4	刀具描述
5	图示照片
6	刀具示意图
7	产品特点
8	产品应用
9	刀具代码
10	刀具尺寸

图号	描述
11	径向设置 (mm)
12	可调节轴套
13	带断屑器UD的兼容刀片组[1)、2)]
14	带断屑器SD的兼容刀片组[1)、2)]
15	重量 (kg)
16	备件组[1)]
17	带断屑器UD的兼容刀片
18	带断屑器SD的兼容刀片
19	备件

[1)] 兼容刀片组和备件的代码仅供本目录使用。不可用于订购。

[2)] 外部(SCET)和内部(XPET)刀片必须始终配有相同的断屑器(请注意:UD断屑器并不明显包含在XPET刀片的名称中–例如XPET 0502AP);正确选择断屑器(UD vs SD)所需的信息可以在刀片包装上找到。

图标概览

通用图标

■	主要使用
◪	可以使用

基本标准组(BSG)

DIN 1897	DIN1897-短钻头标准
DIN 1899	DIN1899-微型钻头标准
DIN 338	DIN338-直柄钻头标准
NAS 907	NAS907-航空钻头标准
DIN 340	DIN340-丝锥长度钻头标准
DIN 1869-1	DIN1869/1-直柄超长钻头标准
DIN 1869-2	DIN1869/2-直柄超长钻头标准
DIN 1869-3	DIN1869/60-100°锪孔钻-直柄超长钻头标准
DIN 1870(2)	DIN1870(2)-莫氏锥柄超长钻头标准
DIN 345	DIN345-莫氏锥柄钻头标准
DIN 8374	DIN8374-直柄阶梯钻头标准
DIN 8376	DIN8376-阶梯钻头标准
DIN 333A	DIN333A-中心钻头标准

DIN 6539	DIN6539
DIN 6537K	DIN6537K
DIN 6537L	DIN6537L
DIN 333R	DIN333R-直柄锪钻标准
DIN 334C	DIN334C-直柄锪钻标准
DIN 335A	DIN335A-直柄锪钻标准
DIN 335C	DIN335C-直柄锪钻标准
DIN 334D	DIN334D-莫氏锥柄锪钻标准
DIN 335D	DIN335D-莫氏锥柄锪钻标准
DIN 373	DIN373-扩孔标准
BS 328	BS328-钻头和铰刀标准
DIN 206	DIN206-手用铰刀标准
DIN 208	DIN208-莫氏锥柄卡装铰刀标准

DIN 212	DIN212-机用铰刀标准
DIN 2179	DIN2179-直柄锥形销铰刀标准
DIN 2180	DIN2180-莫氏锥柄锥形销铰刀标准
DIN 311	DIN311-莫氏锥柄桥式铰刀标准
DIN 8050	DIN8050-直柄铰刀标准
DIN 8051	DIN8051-莫氏锥柄铰刀标准
DIN 8093	DIN8093-直柄铰刀标准
DIN 8094	DIN8094-莫氏锥柄铰刀标准
DIN 9	DIN9-锥形销铰刀标准
DIN ANSI	DIN/ANSI标准
ANSI	ANSI-丝锥标准
DORMER	Dormer标准

有用长度直径比(ULDR)

1×D	1xD可用刀具深径比
1.25×D	1.25xD可用刀具深径比
1.5×D	1.5xD可用刀具深径比
2×D	2xD可用刀具深径比
2.5×D	2.5xD可用刀具深径比
3×D	3xD可用刀具深径比

3.5×D	60-100°锪孔钻.5×D可用刀具深径比
4×D	4xD可用刀具深径比
5×D	5xD可用刀具深径比
6×D	6xD可用刀具深径比
8×D	8xD可用刀具深径比
10×D	10xD可用刀具深径比

12×D	12xD可用刀具深径比
15×D	15xD可用刀具深径比
20×D	20xD可用刀具深径比
25×D	25xD可用刀具深径比

图标概览

应用角度

118°	钻尖角118°	120°	点钻尖120°	82°	82°锪孔钻
120°	钻尖角120°	150°	点钻尖150°	90°	90°锪孔钻
122°	钻尖角122°	90°	90°倒角的预钻孔(用于丝锥)	100°	100°锪孔钻
130°	钻尖130°	90°	阶梯钻头(用于紧固件)90°锪孔	60-100°	60-100°锪孔钻
135°	钻尖135°	180°	阶梯钻头(用于紧固件)180°锪孔	60°	60°锪孔中心钻
140°	钻尖140°	180°	180°沉孔	R	锪孔中心钻半径
90°	点钻尖90°	20°	20°锥形钻头		
90°/120°	点钻尖90°/120°	60°	60°锪孔钻		

柄部

	圆柱柄/直柄		圆柱柄，带方形头	ISO 9766	通用刀柄
DIN 6535HA	DIN6535HA圆柱刀柄		圆柱柄，带六角头		圆柱柄，带法兰
	圆柱柄，带扁尾		莫氏锥柄	ISO 9766	ISO9766圆柱柄(有或没有平面)
	圆柱柄，带3平头		缩径圆柱柄	DIN 6535HB DIN 6535HE	DIN6535-HB(侧固)或HE(哨形凹槽)刀柄

螺旋形式

CTW	芯厚持续减薄设计	λ>35°	大螺旋槽设计	λ20-35°	标准螺旋槽设计
λ32-40°	大螺旋槽设计	VA	特殊钻尖减薄设计		

旋向(切削方向)

L	左旋/切削	R	右旋/切削

冷却液 (CSP)

	内冷刀具设计

切削直径公差等级(TCDC)

DC h6	h6-工业标准刀具公差带(基于直径范围)	DC h8	h8-工业标准刀具公差带(基于直径范围)
DC h7	h7-工业标准刀具公差带(基于直径范围)	DC m7	m7-工业标准刀具公差带(基于直径范围)

图标概览

可达到的孔公差(TCHA)

H7	H7-工业标准孔公差带(基于直径范围)	k11	k11-工业标准刀具公差带(基于直径范围)	ø.95-5.5 +0.004 / ø5.51-12 +0.005	高精度孔公差带(基于直径范围)

铰刀形式

A	DIN A类型-直槽丝锥,右旋切削	B	DIN B类型-左旋小螺旋角,右旋切削

锥度-毫米(锥度比率) (锥度比率) - 公制

1:50	锥度(每50mm锥度1mm)	1:48	锥度(每英尺锥度1/4英寸)

钻孔操作

	盲孔钻孔-推荐使用		叠放物料钻孔-推荐使用		镗孔-推荐使用
	通孔钻孔-推荐使用		螺旋插补钻孔-推荐使用		盲孔镗孔-推荐使用
	斜面钻孔-推荐使用		焊缝钻孔-推荐使用		通孔镗孔-推荐使用
	曲面钻孔-推荐使用		断续切削-推荐使用		螺旋插补镗孔-推荐使用
	钻出斜面-推荐使用		倒角(切斜边)-推荐使用		镗孔至肩部-推荐使用
	钻现有孔-推荐使用		孔中倒角(切斜边)-推荐使用		交叉通孔镗孔-推荐使用

刀片特征

	适用于韧性材料(长切屑)	U	应用广泛的多用途选项
	重载作业条件	S	刃口S型倒棱

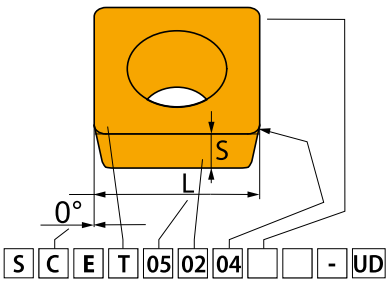
刀具的一般特点

1	每转1个有效齿		整体设计		偏心加工的可能性

其它图标

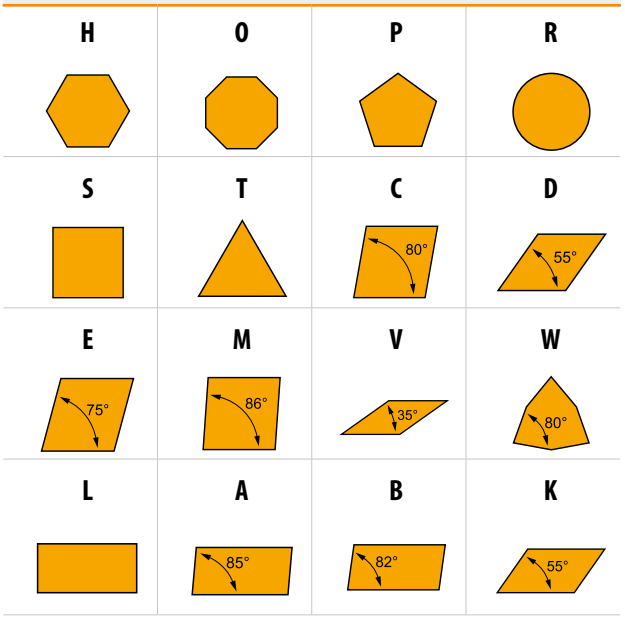
Nm	螺钉夹紧力矩 (Nm)	S	系统 S	f	进给 (mm/rev)

ISO代码 - 刀片

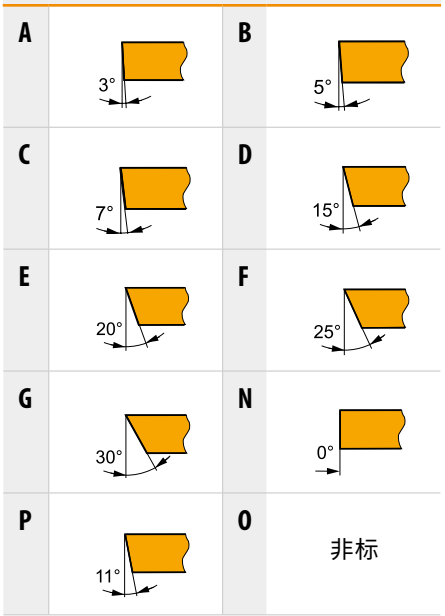


	1	2	3	4
ISO	S	C	E	T
ANSI	S	C	E	T

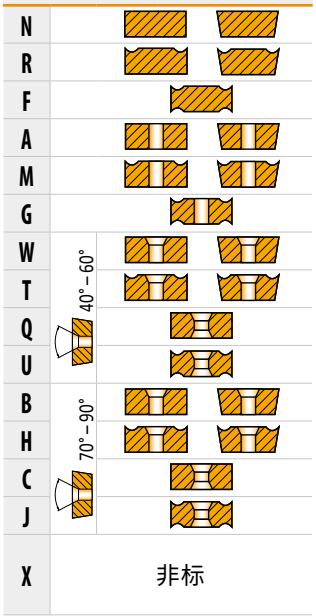
1 ISO代码 - 刀片



2 刀片后角

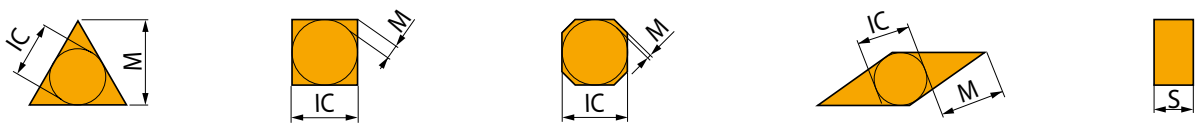


4 刀片类型



3 公差

	(mm)			(")		
	M (±)	S (±)	IC (±)	M (±)	S (±)	IC (±)
A	0.005	0.025	0.025	.0002"	.001"	.0010"
F	0.005	0.025	0.013	.0002"	.001"	.0005"
C	0.013	0.025	0.025	.0005"	.001"	.0010"
H	0.013	0.025	0.013	.0005"	.001"	.0005"
E	0.025	0.025	0.025	.0010"	.001"	.0010"
G	0.025	0.130	0.025	.0010"	.005"	.0010"
J	0.005	0.025	0.05 – 0.13	.0002"	.001"	.002 – 0.005"
K	0.013	0.025	0.05 – 0.13	.0005"	.001"	.002 – 0.005"
L	0.025	0.025	0.05 – 0.13	.0010"	.001"	.002 – 0.005"
M	0.08 – 0.18	0.130	0.05 – 0.13	.003 – 0.007"	.005"	.002 – 0.005"
N	0.08 – 0.18	0.025	0.05 – 0.13	.003 – 0.007"	.001"	.002 – 0.005"
U	0.05 – 0.38	0.130	0.05 – 0.13	.005 – 0.015"	.005"	.003 – 0.010"



ISO代码 - 刀片

5	6	7	8	9		10
05	02	04			–	UD
1.8	1.5	1			–	UD

5 刀片切削刃长度(刀片尺寸)

d=IC (mm)	(in)	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32″	1.2												
4.76					04	08	04	05	04	04	08	L3		
	3/16″	1.5												
5.56					05	09	05	06	05	05	09	03		
	7/32″	1.8												
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4″	2												
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16″	2.5												
9.525		05	04	07	09	16	09	11	09	09	16	06	09	16
	3/8″	3												
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2″	4												
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8″	5												
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4″	6												
25.40		14	10	18	25	44	25	31	26	25	44	17	25	
	1″	8												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4″	10												

6 刀片厚度

	S (mm)	S (″)
01	1.59	1/16″
T1	1.98	5/64″
02	2.38	3/32″
03	3.18	1/8″
T3	3.97	5.32″
04	4.76	3/16″
05	5.56	7/32″
06	6.35	1/4″
07	7.94	5/16″
09	9.52	3/8″

7 刀片圆角

	RE (mm)	RE (″)
00	0	0″
02	0.2	1/128″
04	0.4	1/64″
08	0.8	1/32″
12	1.2	3/64″
16	1.6	1/16″
24	2.4	3/32″
32	3.2	1/8″

圆刀片

d=I.C.	
(″)	00
(mm)	M0

ANSI

5 内切圆

Symbol	d=I.C. (mm)	d=I.C. (″)
1	3.175	1/8″
1.2	3.969	5/32″
1.5	4.763	3/16″
1.8	5.556	7/32″
2	6.350	1/4″
2.5	7.938	5/16″
3	9.525	3/8″
4	12.700	1/2″
5	15.875	5/8″
6	19.050	3/4″
7	22.225	7/8″
8	25.400	1″
10	31.750	5/4″
12	38.100	6/4″

6 刀片厚度

Symbol	S (mm)	S (″)
1	1.588	1/16″
1.2	1.984	5/64″
1.5	2.381	3/32″
2	3.175	1/8″
2.5	3.969	5/32″
3	4.763	3/16″
3.5	5.556	7/32″
4	6.350	1/4″
5	7.938	5/16″
6	9.525	3/8″
7	11.113	7/16″
8	12.700	1/2″
9	14.288	9/16″
10	15.875	5/8″

7 刀片圆角

Symbol	RE (mm)	RE (″)
0	0	0″
0.2	0.099	1/256″
0.5	0.198	1/128″
1	0.397	1/64″
2	0.794	1/32″
3	1.191	3/64″
4	1.588	1/16″
5	1.984	5/64″
6	2.381	3/32″
7	2.778	7/64″
8	3.175	1/8″
10	3.969	5/32″
12	4.763	3/16″
14	5.556	7/32″
16	6.350	1/4″

8 刀片切削刃处理类型

F	锋利刃口	E	刃口圆弧倒棱
T	刃口T型倒棱	S	刃口S型倒棱
K	刃口两次倒棱	P	刃口两次S型倒棱

9 进给方向

R	进给 ←	N	进给 ← → 进给
L	→ 进给		

10 断屑槽类型

钻头的标示代码

1	2	3		4		5		6	7
8	05	D	–	19	–	95	–	S	25

1 刀具类型	
8	可转位钻头

2 长径比	
02	2 × DC
03	3 × DC
04	4 × DC
05	5 × DC

3 类型	
D	钻头

4 直径	
15.5	DC = 15.5 mm
19	DC = 19 mm

5 最大钻削深度	
35	35 mm
95	95 mm
140	140 mm

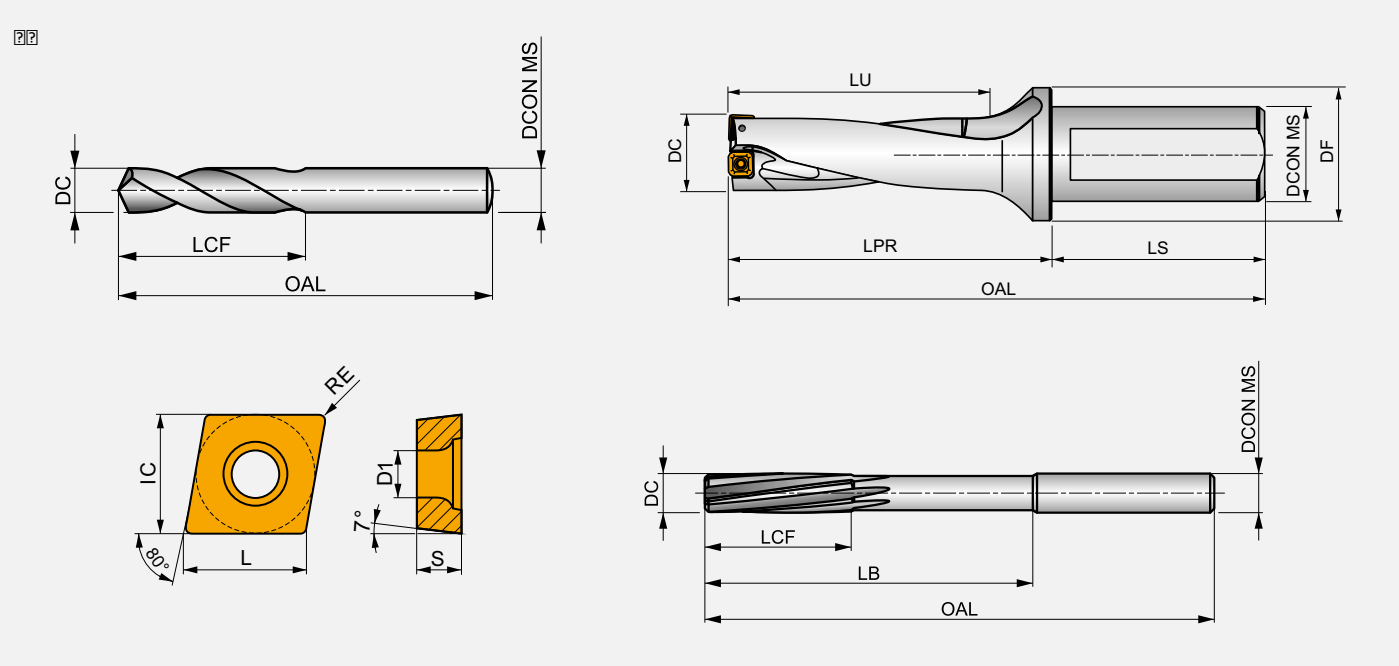
6 柄部类型	
E	惠氏夹紧
S	ISO 9766

7 柄部直径	
25	DCON MS = 25 mm
32	DCON MS = 32 mm
40	DCON MS = 40 mm

ISO 13399标准规定的切削刀具参数

所有的切削刀具都是根据ISO 13399标准定义的一系列参数。本目录中包含使用的所有参数及其定义。

ISO 13399是一种国际切削刀具信息标准。这一标准提供的切削刀具的信息在不同系统和供应商间都能通用。使用按照标准清晰定义的刀具，所有软件均可处理，从而沟通质量更好，系统之间的电子数据交换更顺畅。参数采集过程将更有效且质量更高。该标准从根本上节省了时间并为质量提供了额外的保证。通用语言对于不同系统而言是非常重要的，也更便于用户使用。这将为您节省大量时间，并通过我们的40,000种可靠且可索引的工具更轻松地收集高质量数据。使用ISO 13399兼容系统将无需先人工解读纸质样本的数据再将其输入您的系统。



ISO 13399	描述
BD	钻体直径
BDX	钻体最大直径
CZC MS	机器侧连接尺寸代码
D1	固定孔直径
DC	切削直径
DCN	最小切削直径
DCON MS	柄部尺寸
DCON WS	工件侧连接直径
DCX	最大切削直径
DHUB	毂直径
FLGT	法兰厚度
IC	内切圆直径
L	切削刃长度
LB	刀体长度
LF	功能长度
LPR	伸出长度
LU	有效长度_（最大推荐值）
OAL	总长度
RE	刀尖半径
S	刀片厚度
WF	工作宽度
APMX	最大切削深度
D1	固定孔直径
DC_1	第一步切削的切削直径
DC_2	第二步切削的切削直径

ISO 13399	描述
DF	法兰直径
DH	刀头直径
GPD	导向钻头直径
GPL	导向钻头长度
H	刀柄高度
HSD	驱动部分尺寸
IC	内切圆直径
LCF	容屑槽长度
LCOL	夹头长度
LDC	参考点PK的距离
LH	刀头长度
LS	刀柄长度
LSC	夹持长度
NOF	刃数
PLGL	塞长度
RCSK	埋头半径
RE	刀尖半径
SDI	阶梯直径增量
SDL	阶梯直径长度
SDL_1	第一步切削的阶梯直径长度
SDL_2	第二步切削的阶梯直径长度
TDZ	螺纹直径尺寸
THLGTH	螺纹长度
WSC	方头宽度

导航工具材料

刀具材料

高速钢	HSS	一种可加工性及性能均非常卓越的中合金高速钢。高速钢具有良好的硬度、韧度和耐磨性，使其在广泛的应用领域均具有吸引力，例如钻头和丝锥。
钴高速钢	HSS-E	此高速钢含有钴，用于提高热硬度。HSCo的成分兼具良好的韧度和硬度。其切削加工性和耐磨性均极佳，非常适合生产钻头、丝锥、铰刀和铣刀。
硬质合金和高速钢	HSS HM	复合硬质合金和高速钢材料通常以高温铜焊合金作为接触面连接在一起。这种刀具材料的铜焊组合既提供具有高抗压强度、高硬度和高耐磨性的整体硬质合金切削部分，又可提供具有出色挠曲强度和韧度的高速钢刀体。
硬质合金材料（或硬质材料）	HM	烧结粉末冶金基板，由金属硬质合金复合材料和粘结金属组成。最核心的原材料是碳化钨（WC）。碳化钨有助于提高材料硬度。碳化钽（TaC）、碳化钛（TiC）和碳化铌（NbC）是碳化钨的补充材料，可以根据需要调整碳化钨的性能。这三种材料被称为立方碳化物。钴（Co）起到粘结剂的作用，将材料粘结在一起。 硬质合金材料的特点是抗压强度高、硬度高，因此具有出色的耐磨性，但其抗弯强度和韧度有限。硬质合金用于丝锥、铰刀、铣刀、钻头和螺纹铣刀。

表面处理

抛光（无涂层）	Bright	抛光处理（表面无涂层）可改善软质金属或有色金属材料、塑料和复合材料的切屑流，并保持切削刃锋利。
光亮镀镍	Bright	光亮镀镍表面可防止淬硬钢钻体生锈、腐蚀，并且可以改善排屑。
抛光和蒸汽回火组合	Bright ST	抛光和蒸汽回火的组合非常有效，因为蓝色氧化多孔表面可以起到锁住切削液并将其吸入孔中的作用，而抛光表面则有助于排屑。该组合通过在回火后磨削光亮表面来实现。
蒸汽回火	ST	蒸汽回火使蓝色氧化物表面具有很强的附着力，能够保留切削液和防止切屑与刀具熔焊，从而抵消了积屑瘤的形成。蒸汽回火可应用于任何抛光刀具，但最有效的是用于钻头和丝锥。
青铜回火	Bronze	青铜回火在刀具表面形成一层光滑的薄青铜氧化层。它与蒸汽回火相似，有助于防止切屑进入刀具焊接区，并有助于排屑。青铜回火可应用于任何抛光刀具，并且也可在一些刀具上与蒸汽回火配合应用。
蒸汽和青铜色回火的组合表面处理	ST Bronze	蒸汽和青铜色回火的组合非常有效，因为蓝色氧化多孔表面可以起到锁住切削液并将其吸入孔中的作用，而青铜表面则有助于排屑。两种表面处理都可为刀具增加一定程度的表面保护。这些组合通过使用两种不同的回火循环来实现。

表面涂层

抛光和TiN（刀尖涂层）氮化钛（TiN）	TiN-Tip TiN	氮化钛是一种采用物理气相沉积技术（PVD）制备的金色陶瓷涂层， 兼具高硬度和低摩擦性能，能够实现更长的刀具寿命和/或为没有涂层的刀具提供更好的切削性能。
氮化钛铝涂层（TiAlN、TiAlN-Top和X-CEED）	TiAlN TiAlN Top	氮化钛铝是一种采用PVD涂层技术的多层陶瓷涂层，具有较高的韧性和氧化稳定性。这些特性使其非常适合更高的速度和进给量，同时改善了刀具寿命。TiAlN用于钻孔、攻丝和铣削应用，也适用于不需要冷却剂的加工。 TiAlN-Top涂层与TiAlN相同，但采用了后涂层工艺，可以消除缺陷，进而增强切屑流并减少积屑瘤。
Ti-phon（TiAlCrSiN）	Ti-phon	Ti-phon涂层是一种类似TiAlN的涂层，但特别为天龙钻刀头加入了铬（Cr）和硅（Si），以防止边缘堆积，并且显著改善了切屑流。该涂层具有高红硬性、高抗氧化性和优异的润滑性，适用于机械和热应力大、高速和高进给率的加工应用。这些涂层性能可带来卓越的耐磨性和切刃强度。
氮碳化铝钛（AlTiCN）	AlTiCN	氮炭化铝钛（AlTiCN）是一种PVD涂层，专门设计用于满足医疗器械行业的严格要求。而由于具备高质量的薄膜技术、出色的微硬度和附着力，它同样适用于某些刀具操作。

钻孔涂层

涂层识别	应用范围	应用	进给	切削速度	抗不良作业条件的能力	涂层	颜色	基体	冷却优势	涂层说明
D9335	P20 - P35 M15 - M30 K15 - K35 S10 - S20	■ ■ ■ ◪	▲▲▲▲	▲▲▲▲	▲▲▲▲	MT-CVD		FGM	+ + +	此涂层推荐用于可转位钻头中的外部刀片，它更适合较高的切削速度和进给。
D8330	P20 - P35 M15 - M30 K15 - K35 S10 - S20	■ ■ ■ ◪	▲▲▲▲	▲▲▲▲	▲▲▲▲	PVD		submicron H	+ + +	通用涂层，适用于可转位钻头中的外部刀片，可用于大多数材料，并且具有出色的运行可靠性。
D8345	P30 - P50 M20 - M40 K30 - K40 S20 - S30	■ ■ ■ ◪	▲▲▲▲	▲▲▲▲	▲▲▲▲+	PVD		submicron H	+ + +	通用涂层，适用于可转位钻头的中央刀片，韧性极佳，适合大多数材料。

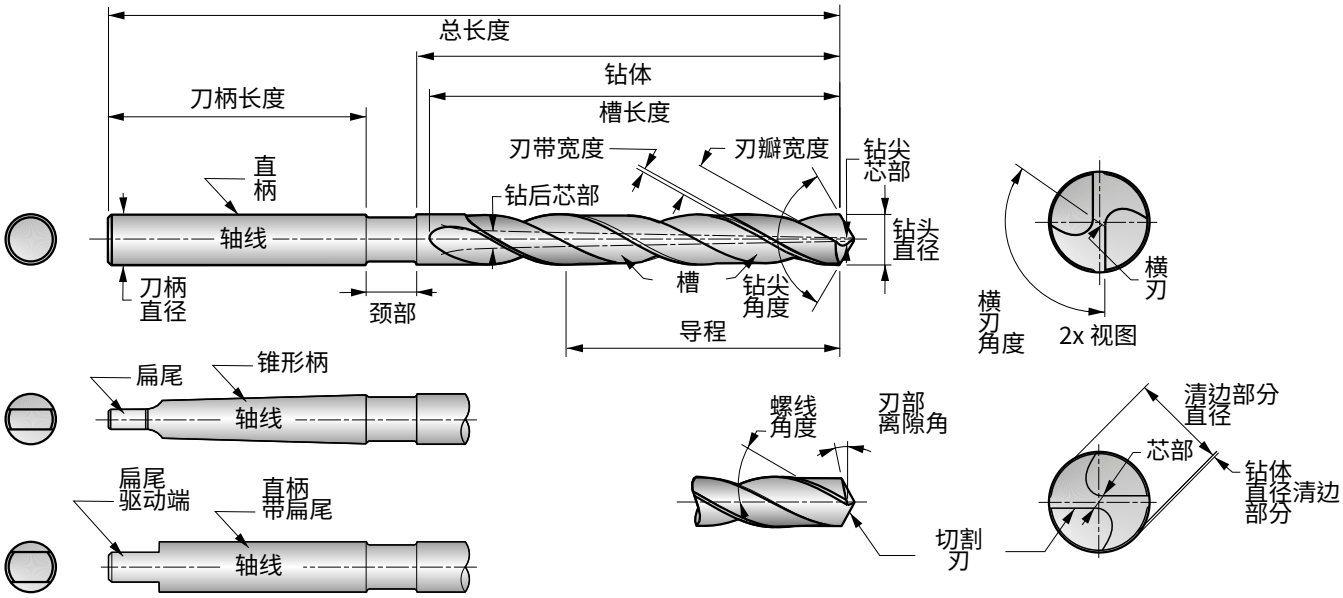
基体	
submicron H	WC-Co基体, 细颗粒度 (< 1 µm)
FGM	功能梯度基体

涂层	
MT-CVD	中温CVD涂层
PVD	物理涂层

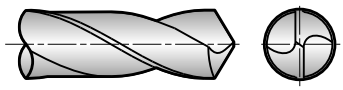
切削液的优点	
+ + +	必须使用冷却剂

整体硬质合金钻头和高速钢钻头 - 技术信息

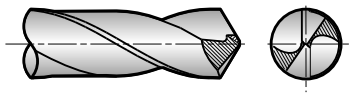
钻头术语



- 轴线—形成钻头纵向中心线的假想直线。
- 倒锥—钻体直径从前向后逐渐减小。
- 钻体—钻头从钻柄或钻颈伸出到切割刃外角的部分。
- 钻体间隙直径—棱上被切除以免与孔壁粘结的部分。
- 横刃—与切割刃相连的芯端部的切刃。
- 横刃角度—从钻头端部观看，横刃与切割刃间的夹角。
- 间隙直径—钻棱切除部分的直径。
- 钻头—具有一个或多个切割刃的旋转端切削刀具，并且有一个或多个螺旋式或直槽丝锥，用于切屑通过和切削液进入。
- 钻头直径—从钻尖处测量的钻头边缘直径。
- 槽长度—从切割刃外角到槽最后端的长度。包括用于生成槽形的刀具延伸部分，因此不等同于槽的可用长度。
- 槽—螺旋形或直形凹槽或者在钻体内形成，以提供切割刃，允许排屑及让切削液到达切割刃。
- 螺旋角—由棱的导程边缘形成的角度，有一个包含钻头轴线的平面。
- 棱—钻体的周侧部分，位于相邻槽之间。
- 刃瓣宽度—导程边缘与棱跟部之间的距离；与导程边缘成直角进行测量。
- 导程—沿圆周一圈的棱导程边缘的轴向前进距离。
- 刃部离隙角—刃部外角处的轴向离隙角；通过投影到刃部外角处与圆周相切的平面测量。
- 刃部—从横切刃延伸到圆周的双槽钻头的切削刃。
- 刃带—未切除的棱的圆柱部分，用于提供间隙。
- 颈部—钻体与钻柄间的缩径部分。
- 总长度—从钻柄最末端到切割刃外角的长度。既不包括通常用于直柄钻头的锥形柄端，也不包括用于直柄钻头和锥形柄钻头的锥形切削钻尖。
- 钻尖—钻头的切削端，由棱端和芯部组成。其形状类似一个圆锥体，但与真正的圆锥体不同的是，切割刃后留有间隙。
- 常规型—常规钻尖为钻尖夹角118°，其应用最为广泛的原因是在加工各种材料的效果都令人满意。但可能存在的限制是，直横刃会令钻尖出现漂移，因此往往需要在加工孔时进行定点，以提高粘度。

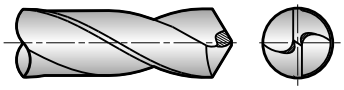


- 分离式—分离式钻尖（通常称为曲轴钻尖）是一种最初开发用于在汽车曲轴上加工深油孔的钻头。自诞生以来，分离式钻尖得到广泛应用，提供钻尖夹角118°和135°两种型号。其主要优势在于可以降低推力，并且可以消除钻尖漂移。这种钻尖在用于便携式钻机或不能使用衬套的钻孔应用时具有明显优势。分离式钻尖还有两个延伸至钻头中心的正前角切削刃，可以作为断屑器生成易于排出的细小切屑。



整体硬质合金钻头和高速钢钻头 - 技术信息

- 切口式—切口式钻尖为钻削难加工合金而开发， 通常集成在重型芯部钻头上，令钻尖可以承受加工这些材料时所需的更高推力负荷。与分离式钻尖一样，切口式钻尖包含两个向钻头中心延伸的附加正前角切削刃。这些二级切割刃延伸至不到初始切割刃的一半，有助于切屑控制并降低钻削难加工材料时的扭矩。切口式钻尖可以集成到钻尖夹角118°和135°钻头上，令其适合钻削各种材料。



- 钻尖角度—切割刃间的夹角，投射至与钻头轴平行并与两个切割刃平行的平面上。
- 刃部相对高度—钻头切削刃之间指示器读数之差。与切割刃成直角进行测量，位于与刀具轴的特定距离处。
- 刀柄—用于保持及驱动的钻头部分。
- 扁尾—锥形柄的扁平端部，用来安装在插口的驱动槽中。
- 扁尾驱动—位于直柄最末端的两个相对平行的驱动平面。
- 锥形柄—带锥形柄的钻头，适合直接装配到机器的心轴、传动轴套或插口中。锥形柄通常有一个扁尾。
- 芯部—连接棱的钻体中心部分。芯部最末端在双槽钻头上形成横刃。
- 芯部厚度—钻尖处的芯部厚度，除非标注了另一个指定位置。

关于钻孔的一般提示

1. 选择最适合应用的钻头，仔细考虑要加工的材料、机床的性能和使用的冷却剂。

2. 如果在部件和机器的刀具心轴内挠性高，可能会导致钻头以及部件和机器损坏 - 在任何时候都要确保最大稳定性。这可以通过选择应用允许的最短钻头来改善。

3. 刀柄是钻孔操作的一个重要方面，不能让钻头在刀架中滑动或移动。

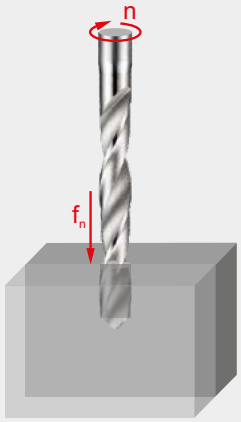
4. 莫氏锥柄钻头的正确使用取决于刀具锥形表面和刀架间的有效配合。应使用软面锤将钻头敲入刀架。

5. 根据特定钻孔作业的要求，使用推荐的合适冷却剂和润滑剂。在使用冷却剂和润滑剂时，确保供应充足，特别是在钻尖部位。

6. 钻孔时的排屑是确保正确钻孔步骤的关键。切勿让切屑留在槽中。

7. 再次研磨钻头时，始终确保正确的钻尖几何形状并去除所有磨损。

钻孔进给率表



每转进给量 (f_n，单位mm/rev)
根据工况，可能需要将这些值调整为± 25%

如何使用此表格查找每转进给量 (f_n)：

1. 在产品页找到您的字母代码（例如：46J、“J”是字母代码）。
2. 在表格第一行找到与您切削应用最接近的直径。
3. 在表格左列找到您的字母代码。
4. 直径和字母代码的交点（单元格）是每转进给量 (f_n)。

进给率（mm/rev）	ø DC (mm)																		
	0.15	0.50	1.00	2.00	3.00	4.00	5.00	6.00	8.00	10.00	12.00	15.00	16.00	20.00	25.00	30.00	40.00	50.00	100.00
A	0.003	0.006	0.012	0.023	0.029	0.032	0.036	0.042	0.054	0.062	0.069	0.082	0.086	0.110	0.125	0.135	0.155	0.175	0.263
B	0.004	0.007	0.014	0.028	0.037	0.041	0.046	0.053	0.067	0.080	0.090	0.103	0.108	0.135	0.153	0.165	0.188	0.208	0.312
C	0.004	0.008	0.015	0.032	0.044	0.050	0.056	0.064	0.080	0.098	0.110	0.125	0.130	0.160	0.180	0.195	0.220	0.240	0.360
D	0.004	0.008	0.016	0.038	0.053	0.060	0.068	0.078	0.098	0.119	0.130	0.149	0.155	0.188	0.210	0.228	0.253	0.275	0.413
E	0.004	0.009	0.017	0.043	0.062	0.071	0.080	0.092	0.115	0.140	0.150	0.173	0.180	0.215	0.240	0.260	0.285	0.310	0.465
F	0.005	0.009	0.018	0.050	0.073	0.084	0.095	0.109	0.138	0.165	0.178	0.202	0.210	0.248	0.275	0.295	0.320	0.343	0.515
G	0.005	0.010	0.019	0.056	0.084	0.096	0.109	0.126	0.160	0.190	0.205	0.231	0.240	0.280	0.310	0.330	0.355	0.375	0.563
H	0.005	0.010	0.020	0.066	0.102	0.116	0.130	0.150	0.190	0.228	0.243	0.271	0.280	0.320	0.355	0.375	0.398	0.418	0.627
I	0.005	0.011	0.021	0.076	0.119	0.134	0.150	0.173	0.220	0.265	0.280	0.310	0.320	0.360	0.400	0.420	0.440	0.460	0.690
J	0.006	0.012	0.024	0.084	0.135	0.152	0.170	0.197	0.250	0.298	0.315	0.349	0.360	0.405	0.445	0.465	0.485	0.503	0.755
K	0.007	0.013	0.026	0.092	0.150	0.170	0.190	0.220	0.280	0.330	0.350	0.388	0.400	0.450	0.490	0.510	0.530	0.545	0.818
L	0.007	0.014	0.028	0.101	0.165	0.186	0.208	0.240	0.305	0.360	0.385	0.419	0.430	0.485	0.525	0.545	0.568	0.588	0.882
M	0.008	0.015	0.030	0.110	0.180	0.202	0.225	0.260	0.330	0.390	0.420	0.450	0.460	0.520	0.560	0.580	0.605	0.630	0.945
N	0.008	0.016	0.032	0.119	0.195	0.218	0.242	0.280	0.355	0.420	0.455	0.481	0.490	0.555	0.595	0.615	0.642	0.672	1.008
S	0.002	0.004	0.008	0.014	0.020	0.025	0.030	0.037	0.050	0.080	0.100	0.123	0.130	0.150	0.170	0.190	0.220	0.240	–
T	0.004	0.008	0.015	0.028	0.040	0.050	0.060	0.070	0.090	0.110	0.130	0.160	0.170	0.190	0.210	0.230	0.260	0.275	–
U	0.007	0.013	0.026	0.048	0.070	0.080	0.090	0.107	0.140	0.170	0.200	0.223	0.230	0.240	0.270	0.300	0.360	0.375	–
V	0.010	0.019	0.038	0.069	0.100	0.115	0.130	0.153	0.200	0.250	0.280	0.310	0.320	0.340	0.400	0.440	0.510	0.530	–
W	0.012	0.025	0.049	0.089	0.130	0.150	0.170	0.200	0.260	0.330	0.380	0.418	0.430	0.450	0.470	0.490	0.520	0.540	–
X	0.014	0.028	0.056	0.103	0.150	0.180	0.210	0.250	0.330	0.420	0.480	0.533	0.550	0.580	–	–	–	–	–
Y	0.017	0.034	0.068	0.124	0.180	0.220	0.260	0.317	0.430	0.550	0.700	0.700	0.700	0.740	–	–	–	–	–
Z	0.024	0.047	0.094	0.172	0.250	0.325	0.400	0.533	0.800	1.000	1.100	1.175	1.200	1.200	–	–	–	–	–

公式（公制）			术语	公式（英制）		
$v_c = \frac{n \times DC \times \pi}{1000}$	v_c	(m/min)	线速度	SFM	(ft/min)	$SFM = \frac{RPM \times DC \times \pi}{12}$
$n = \frac{v_c \times 1000}{DC \times \pi}$	n	(rev/min)	主轴转速	RPM	(rev/min)	$RPM = \frac{SFM \times 12}{DC \times \pi}$
$V_f = f_z \times z \times n$	V_f	(mm/min)	进给率	IPM	(in/min)	$IPM = IPT \times T \times RPM$
$f_z = \frac{V_f}{z \times n}$	f_z	(mm/tooth)	每齿进给量	IPT	(in/tooth)	$IPT = \frac{IPM}{T \times RPM}$
$Q = \frac{V_f \times a_p \times a_e}{1000}$	DC	(mm)	切削直径	DC	(in)	$MRR = IPM \times DOC \times WOC$
	z	(–)	齿数	T	(–)	
	a_p	(mm)	切削深度	DOC	(in)	
	a_e	(mm)	切削宽度	WOC	(in)	
	Q	(cm^3/min)	金属去除率	MRR	(in^3/min)	

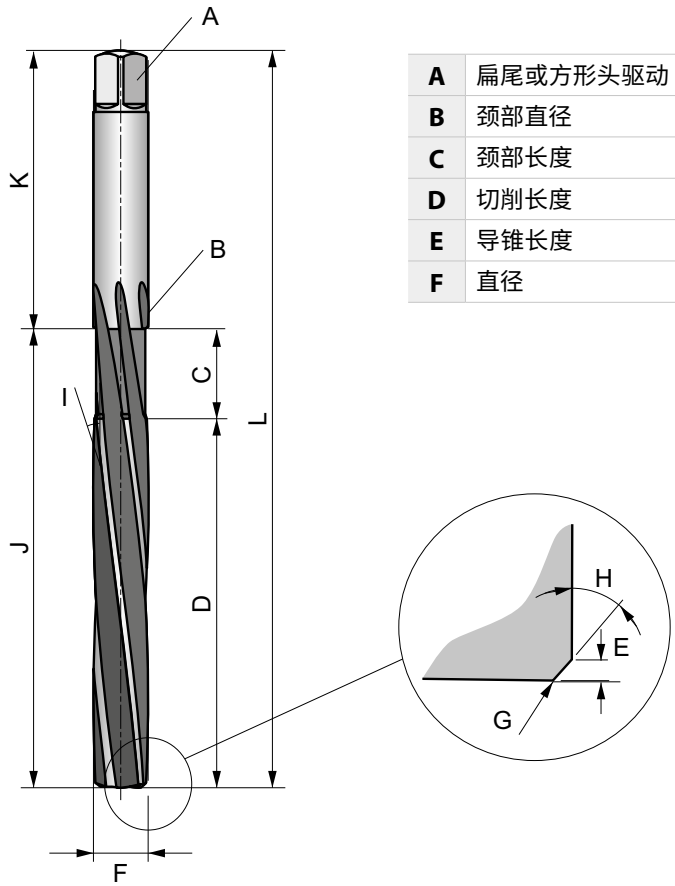
通用 - 技术信息

切削速度表格

		Vc															
m/min		5	8	10	15	20	25	30	40	50	60	70	80	90	100	110	150
SFM (feet/min)		16	26	32	50	66	82	98	130	165	197	230	262	296	330	362	495
Ø		RPM															
mm	in																
1.00	–	1592	2546	3183	4775	6366	7958	9549	12732	15916	19099	22282	25465	28648	31831	35014	47747
1.50	–	1061	1698	2122	3183	4244	5305	6366	8488	10610	12732	14854	16977	19099	21221	23343	31831
2.00	–	796	1273	1592	2387	3183	3979	4775	6366	7958	9549	11141	12732	14324	15916	17507	23873
2.50	–	637	1019	1273	1910	2546	3183	3820	5093	6366	7639	8913	10186	11459	12732	14006	19099
3.00	–	531	849	1061	1592	2122	2653	3183	4244	5305	6366	7427	8488	9549	10610	11671	15916
3.18	1/8	500	801	1001	1501	2002	2502	3003	4004	5005	6006	7007	8008	9009	10010	11011	15015
3.50	–	455	728	909	1364	1819	2274	2728	3638	4547	5457	6366	7276	8185	9095	10004	13642
4.00	–	398	637	796	1194	1592	1989	2387	3183	3979	4775	5570	6366	7162	7958	8754	11937
4.50	–	354	566	707	1061	1415	1768	2122	2829	3537	4244	4951	5659	6366	7074	7781	10610
4.76	3/16	334	535	669	1003	1337	1672	2006	2675	3344	4012	4681	5350	6018	6687	7356	10031
5.00	–	318	509	637	955	1273	1592	1910	2546	3183	3820	4456	5093	5730	6366	7003	9549
6.00	–	265	424	531	796	1061	1326	1592	2122	2653	3183	3714	4244	4775	5305	5836	7958
6.35	1/4	251	401	501	752	1003	1253	1504	2005	2506	3008	3509	4010	4511	5013	5514	7519
7.00	–	227	364	455	682	909	1137	1364	1819	2274	2728	3183	3638	4093	4547	5002	6821
7.94	5/16	200	321	401	601	802	1002	1203	1604	2004	2405	2806	3207	3608	4009	4410	6013
8.00	–	199	318	398	597	796	995	1194	1592	1989	2387	2785	3183	3581	3979	4377	5968
9.00	–	177	283	354	531	707	884	1061	1415	1768	2122	2476	2829	3183	3537	3890	5305
9.53	3/8	167	267	334	501	668	835	1002	1336	1670	2004	2338	2672	3006	3340	3674	5010
10.00		159	255	318	477	637	796	955	1273	1592	1910	2228	2546	2865	3183	3501	4775
11.11	7/16	143	229	287	430	573	716	860	1146	1433	1719	2006	2292	2579	2865	3152	4298
12.00		133	212	265	398	531	663	796	1061	1326	1592	1857	2122	2387	2653	2918	3979
12.70	1/2	125	201	251	376	501	627	752	1003	1253	1504	1754	2005	2256	2506	2757	3760
14.00		114	182	227	341	455	568	682	909	1137	1364	1592	1819	2046	2274	2501	3410
14.29	9/16	111	178	223	334	446	557	668	891	1114	1337	1559	1782	2005	2228	2450	3341
15.00	–	106	170	212	318	424	531	637	849	1061	1273	1485	1698	1910	2122	2334	3183
15.88	5/8	100	160	200	301	401	501	601	802	1002	1203	1403	1604	1804	2004	2205	3007
16.00	–	99	159	199	298	398	497	597	796	995	1194	1393	1592	1790	1989	2188	2984
17.46	11/16	91	146	182	273	365	456	547	729	912	1094	1276	1458	1641	1823	2005	2735
18.00	–	88	141	177	265	354	442	531	707	884	1061	1238	1415	1592	1768	1945	2653
19.05	3/4	84	134	167	251	334	418	501	668	835	1003	1170	1337	1504	1671	1838	2506
20.00	–	80	127	159	239	318	398	477	637	796	955	1114	1273	1432	1592	1751	2387
24.00	–	66	106	133	199	265	332	398	531	663	796	928	1061	1194	1326	1459	1989
25.00	–	64	102	127	191	255	318	382	509	637	764	891	1019	1146	1273	1401	1910
27.00	–	59	94	118	177	236	295	354	472	589	707	825	943	1061	1179	1297	1768
30.00	–	53	85	106	159	212	265	318	424	531	637	743	849	955	1061	1167	1592
32.00	–	50	80	99	149	199	249	298	398	497	597	696	796	895	995	1094	1492
36.00	–	44	71	88	133	177	221	265	354	442	531	619	707	796	884	973	1326
40.00	–	40	64	80	119	159	199	239	318	398	477	557	637	716	796	875	1194
50.00	–	32	51	64	95	127	159	191	255	318	382	446	509	573	637	700	955

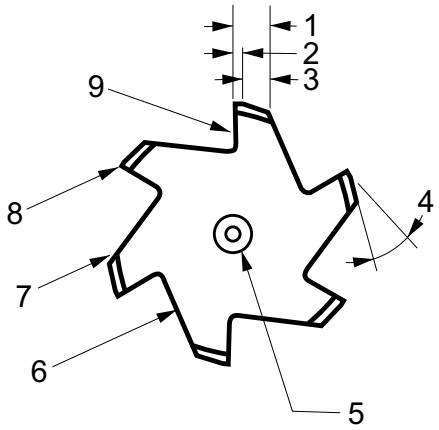
铰孔 - 技术信息

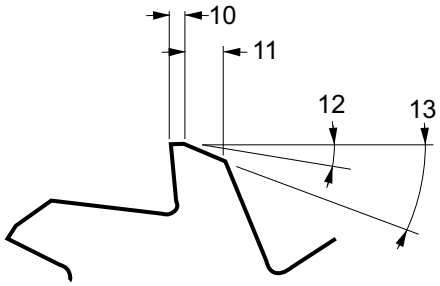
铰刀定义 / 术语



A	扁尾或方形头驱动
B	颈部直径
C	颈部长度
D	切削长度
E	导锥长度
F	直径

G	导锥
H	导锥角
I	螺旋角
J	钻体长度
K	刀柄长度
L	总长度





1	刃瓣宽度
2	圆周刃带
3	清边
4	后角
5	中心孔
6	槽
7	刃背尖角
8	切削刃
9	前面

10	主后角宽度
11	副后角宽度
12	主后角
13	次后角

铰孔 - 技术信息

铰刀

为了得到最好的铰削效果，必须使铰刀能真正地进行“工作”。常见的错误是在预钻孔时留下的铰削余量太少。如果铰削余量不足的话，铰刀在加工时实际上只是在对孔壁作摩擦而不是切削。这样铰刀会很快磨损，也就丧失了正确的直径尺寸。同样重要的是，预钻孔的铰削余量也不能留得太多 (见后面的铰削余量表)。

1. 为特定应用场合选择最合适的铰刀型号，并选择最佳的速度和进给量，确保预钻孔有正确的直径尺寸。
2. 工件必须夹持牢固，机床主轴不应有间隙。
3. 夹持直柄铰刀的夹头必须是高质量的，若铰刀在夹头内滑动的话，在作自动进给时铰刀可能会断裂。
4. 应使铰刀伸出机床主轴的悬伸量尽可能最短。
5. 采用推荐的冷却液以延长铰刀的寿命，并确保冷却液能到达切削刃部位。由于铰削不是重负荷切削，采用 40:1 稀释的乳化油一般 就能满足要求。在对灰铸铁作干切削时，也可采用压缩空气来作冷却。
6. 不要让切屑堵塞铰刀的容屑槽。
7. 在对铰刀进行重磨之前，先把它放在双顶尖之间检查其同心度。在大部分情况下，只需对铰刀的导锥部分进行修磨。
8. 保持铰刀的锋利度，经常修磨铰刀会有较好的经济性。要知道铰刀只用其锥形部分来进行切削工作，而不是其圆柱刃带部分，这一点很重要。因此只有铰刀的锥形部分需要修磨。修磨的精度对铰孔质量和铰刀寿命都有很大影响。

铰削余量

推荐的铰削余量与工件材料和预钻孔的表面光洁度有关。下表给出了确定铰削余量的一般原则：

铰孔尺寸 (mm)	采用预钻孔时	采用预扩孔时
小于 4	0.1	0.1
大于 4 至 11	0.2	0.15
大于 11 至 39	0.3	0.2
大于 39 至 50	0.4	0.3

铰孔尺寸 (英寸)	采用预钻孔时	采用预扩孔时
小于 3/16″	0.004″	0.004″
3/16″ 至 ½″	0.008″	0.006″
½″ 至 1.½″	0.010″	0.008″
1.½″ 至 2″	0.016″	0.010″

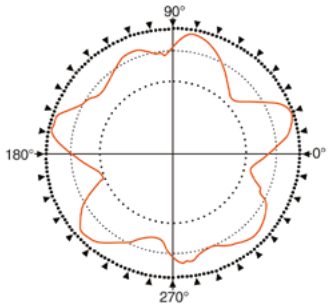
手动 / 机械铰孔

手用铰刀和机用铰刀对于加工相同的成品孔尺寸具有同样的效果，具体使用哪一种方式必须根据应用予以考虑。出于对准需要，手用铰刀具有长丝锥导程，而机用铰刀仅有一个45度倒角。机用铰刀只在丝锥导程上进行切割，而手用铰刀则在丝锥导程和倒角上进行切割。

最常见的铰刀均为左螺旋结构，因为主要的应用涉及通孔，需要向前推进切屑。对于盲孔，推荐带直槽丝锥或右螺旋的铰刀。
最有效的铰孔条件取决于应用、材料、孔质量要求、切削量、润滑等其它因素。机用铰刀的表面速度和进给的通用指南可参见铰刀WMG和进给表 (参见多马目录或产品选择器) 及切削量表。
铰刀上差别极大的间距意味着每个齿的分隔是不同的。因为没有两颗彼此完全相反的齿，铰刀铰出的孔的圆度差在1和2 μm之间。这与传统不等间距可达10μm的误差相比差距明显。

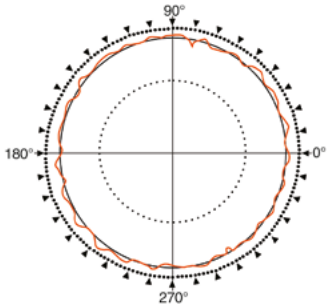
硬质合金铰刀 - 比较间距 / EU间距

不等间距
圆度误差可达10 μm



圆度结果

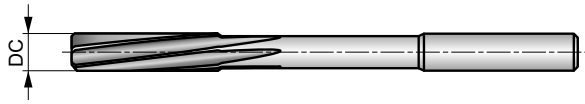
极度不等间距
圆度误差可达1 - 2 μm



圆度结果

铰孔 – 公差限值 - 技术信息

公差极限



1. 在标准铰刀的切削直径上
   在测量直径 (DC) 时，要横跨圆周刃带来测量紧邻铰刀导锥或圆锥导 向的圆柱部分尺寸。铰刀公差按照 DIN 1420，可加工出 H7 的孔。

铰刀公差			
直径 (mm)		公差极限 (mm)	
大于	小于等于	上公差 +	下公差 +
–	3	0.008	0.004
3	6	0.010	0.005
6	10	0.012	0.006
10	18	0.015	0.008

铰刀公差			
直径 (mm)		公差极限 (mm)	
大于	小于等于	上公差 +	下公差 +
18	30	0.017	0.009
30	50	0.021	0.012
50	80	0.025	0.014

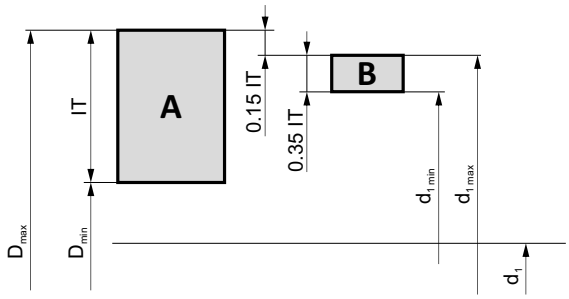
2. 在 H7 的孔上
   对于精加工的孔来说，最常见的公差就是 H7 (见下表)。若需其他的公差，可用第 3 点下面的图表来计算出铰刀的公差位置和公差带宽度。

孔的公差			
直径(mm)		公差极限(mm)	
大于	小于等于	上公差 +	下公差 +
–	3	0.010	0
3	6	0.012	0
6	10	0.015	0
10	18	0.018	0

孔的公差			
直径(mm)		公差极限(mm)	
大于	小于等于	上公差 +	下公差 +
18	30	0.021	0
30	50	0.025	0
50	80	0.030	0

3. 如果需要铰出特殊的孔公差，比如 D8，可利用这里的经验公式来确定此特殊铰刀的尺寸：

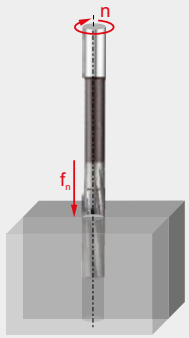
直径的公差带宽度								
公差带宽度 (微米)	大于 1 至 3	大于 3 至 6	大于 6 至 10	大于 10 至 18	大于 18 至 30	大于 30 至 50	大于 50 至 80	大于 80 至 120
IT5	4	5	6	8	9	11	13	15
IT6	6	8	9	11	13	16	19	22
IT7	10	12	15	18	21	25	30	35
IT8	14	18	22	27	33	39	46	54
IT9	25	30	36	43	52	62	74	87
IT10	40	48	58	70	84	100	120	140
IT11	60	75	90	110	130	160	190	220
IT12	100	120	150	180	210	250	300	350



A = 孔的公差
B = 铰刀公差
IT = 公差带宽度
D_{max} = 孔的最大直径
D_{min} = 孔的最小直径
d_1 = 公称直径
$d_{1\,max}$ = 铰刀最大直径
$d_{1\,min}$ = 铰刀最小直径

例如：10 mm 的孔，公差为 D8，最大直径 = 10.062，最小直径 = 10.040，孔公差 (IT8) = 0.022
最大尺寸极限：0.15 x 孔公差 (IT8) = 0.0033，圆整后 = 0.004
最小尺寸极限：0.35 x 孔公差 (IT8) = 0.0077，圆整后 = 0.008
铰刀最大尺寸极限 = 10.062 - 0.004 = 10.058
铰刀最小尺寸极限 = 10.058 - 0.008 = 10.050

铰刀进给率表

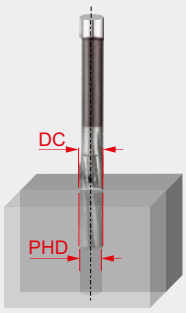


每转进给量 (f_n，单位mm/rev)
根据工况，可能需要将这些值调整为± 15%

如何使用此表格查找每转进给量 (f_n)：

1. 在产品页找到您的字母代码（例如：21C、“C”是字母代码）。
2. 在表格第一行找到与您切削应用最接近的直径。
3. 在表格左列找到您的字母代码。
4. 直径和字母代码的交点（单元格）是每转进给量 (f_n)。

进给率 (mm/rev)	ø DC (mm)																		
	1.00	1.50	2.00	3.00	4.00	5.00	6.00	7.00	8.00	10.00	12.00	15.00	16.00	20.00	25.00	30.00	40.00	50.00	80.00
A	0.030	0.045	0.055	0.078	0.090	0.100	0.125	0.137	0.150	0.170	0.185	0.210	0.220	0.250	0.280	0.320	0.390	0.440	0.500
B	0.035	0.055	0.072	0.110	0.130	0.150	0.165	0.172	0.180	0.210	0.240	0.270	0.280	0.310	0.360	0.400	0.500	0.550	0.600
C	0.040	0.065	0.085	0.135	0.160	0.185	0.200	0.210	0.220	0.260	0.285	0.325	0.335	0.390	0.440	0.480	0.600	0.680	0.750
D	0.050	0.080	0.110	0.160	0.180	0.200	0.235	0.253	0.270	0.320	0.360	0.400	0.410	0.470	0.540	0.600	0.730	0.850	0.950
E	0.065	0.100	0.140	0.180	0.215	0.250	0.300	0.325	0.350	0.390	0.430	0.485	0.500	0.530	0.640	0.750	0.910	1.100	1.200
F	0.090	0.140	0.180	0.260	0.305	0.350	0.395	0.417	0.440	0.500	0.550	0.610	0.630	0.700	0.800	0.930	1.200	1.500	1.650



使用
机用铰刀（余量为mm）时的加工余量 预加工孔直径
PHD = DC - MA

如何使用此表格获得正确的预加工孔直径（PHD）：

2. 在表格第一行找到切削应用的直径范围。
2. 在表格左列找到您的ISO组代码（例如：对于不锈钢，ISO组代码为“M”）
3. 直径范围和ISO组代码的交点（单元格）是加工余量（MA）
4. 从铰孔直径中减去加工余量即为预加工孔直径（PHD）。

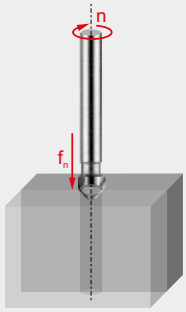
（例如：用于6 mm孔，钢（P），PHD为5.85 mm）

ISO组	ø DC (mm)											
	1.00	5.00	5.00	8.00	8.00	12.00	12.00	16.00	16.00	30.00	30.00	80.00
P	0.10		0.15		0.20		0.20		0.30		0.30	
M	0.08		0.10		0.10		0.20		0.20		0.30	
K	0.10		0.15		0.20		0.20		0.30		0.30	
N	0.10		0.15		0.20		0.20		0.30		0.30	
S	0.05		0.10		0.10		0.15		0.20		0.20	
H	0.05		0.05		0.10		0.10		0.15		0.20	

注意钻头的加工公差，刀具直径与加工的孔直径不同！

注意：使用手用铰刀时的推荐余量为0.05至0.10 mm

锪钻进给率表



每转进给量（f_n，单位mm/rev）
根据工况，可能需要将这些值调整为± 15%

如何使用此表格查找每转进给量（f_n）：

1. 在产品页找到您的字母代码（例如：23E、“E”是字母代码）。
2. 在表格第一行找到与您切削应用最接近的直径。
3. 在表格左列找到您的字母代码。
4. 直径和字母代码的交点（单元格）是每转进给量（fn）。

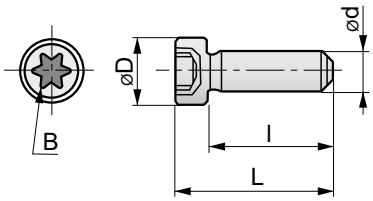
		ø DC (mm)									
		6.00	8.00	10.00	16.00	20.00	25.00	32.00	40.00	60.00	80.00
进给率 (mm/rev)	A	0.030	0.040	0.050	0.060	0.080	0.090	0.100	0.120	0.140	0.160
	B	0.040	0.050	0.060	0.080	0.100	0.120	0.140	0.160	0.180	0.200
	C	0.050	0.060	0.080	0.100	0.120	0.140	0.160	0.180	0.200	0.220
	D	0.060	0.080	0.100	0.120	0.150	0.180	0.200	0.220	0.250	0.280
	E	0.080	0.100	0.120	0.150	0.180	0.200	0.250	0.270	0.300	0.320
	F	0.090	0.110	0.130	0.160	0.190	0.210	0.260	0.290	0.330	0.360
	G	0.100	0.120	0.150	0.180	0.200	0.220	0.280	0.320	0.360	0.400
	H	0.120	0.150	0.180	0.200	0.220	0.250	0.300	0.350	0.400	0.450

天龙钻 - 技术信息

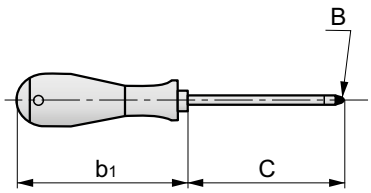
扭矩表格

					扭矩值 Nm（公制系统）	扭矩值 in/lbs（英制系统）
H860	H861	天龙钻刀头 ø 公制范围	天龙钻刀头 ø 分数形式范围	天龙钻刀头 ø 小数形式尺寸范围（最小 / 最大）		
H860N1	**H861N1**	12.0 mm – 15.5 mm	15/32“ – 39/64“	0.4688“ – 0.6102“	0.75 – 0.99	6.6 – 8.8
H860N2	**H861N2**	15.6 mm – 18.5 mm	5/8“ – 23/32“	0.6142“ – 0.7283v	0.93 – 1.24	8.2 – 11.0
H860N3	**H861N3**	18.6 mm – 21.5 mm	47/64“ – 27/32“	0.7323“ – 0.8465“	1.84 – 2.44	16.3 – 21.6
H860N4	**H861N3**	22.0 mm – 24.5 mm	55/64“ – 31/32“	0.8594“ – 0.9688“	2.73 – 3.72	24.2 – 32.9
H860N5	**H861N4**	25.0 mm – 27.5 mm	63/64“ – 1-3/32“	0.9843“ – 1.0938“	4.14 – 5.52	36.6 – 48.8
H860N6	**H861N5**	28.0 mm – 33.5 mm	1-7/64“ – 1-19/64“	1.1024“ – 1.3189“	4.97 – 6.63	44.0 – 58.7
H860N7	**H861N6**	34.0 mm – 42.0 mm	1-11/32“ – 1-5/8“	1.3386“ – 1.6535“	7.2	63.7

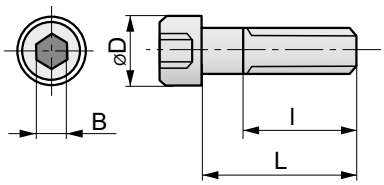
螺钉和螺丝刀数据



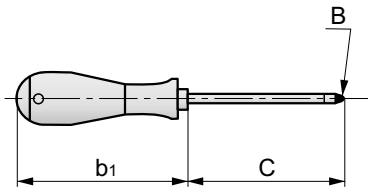
e代码	d	螺距	L (mm)	l (mm)	D (mm)	B
H860N1	M2.2	0.45	7.5	5.7	3.5	8IP
H860N2	M2.5	0.45	9.0	7.0	4.1	10IP
H860N3	M3.0	0.50	10.5	8.0	4.9	15IP
H860N4	M3.5	0.60	11.5	8.8	5.5	15IP
H860N5	M4.0	0.70	12.5	9.5	6.0	20IP
H860N6	M4.5	0.75	14.3	10.8	6.8	25IP



e代码	B	C	b1
H861N1	8IP	60	104
H861N2	10IP	80	111
H861N3	15IP	80	111
H861N4	20IP	100	118
H861N5	25IP	100	118

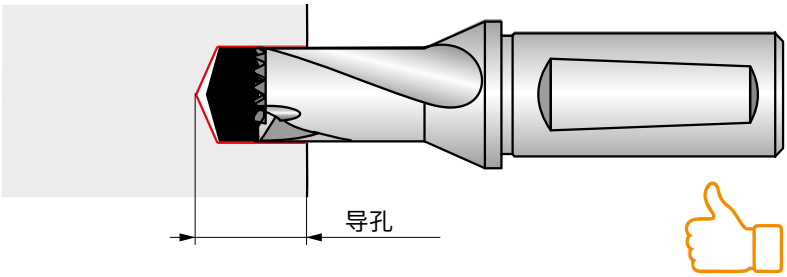


e代码	d	螺距	L (mm)	l (mm)	D (mm)	B
H860N7	M5.0	0.8	15	full	8.5	4

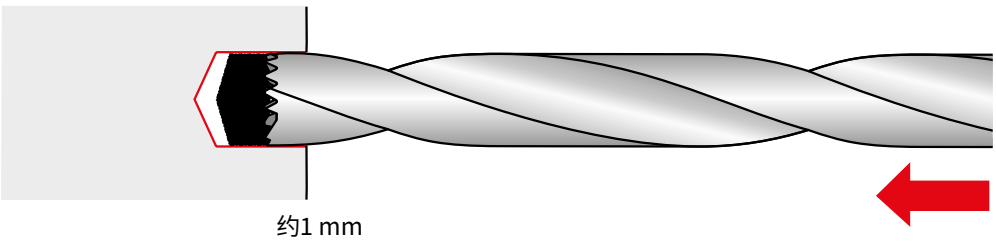


e代码	B	C	b1
H861N6	4	75	111

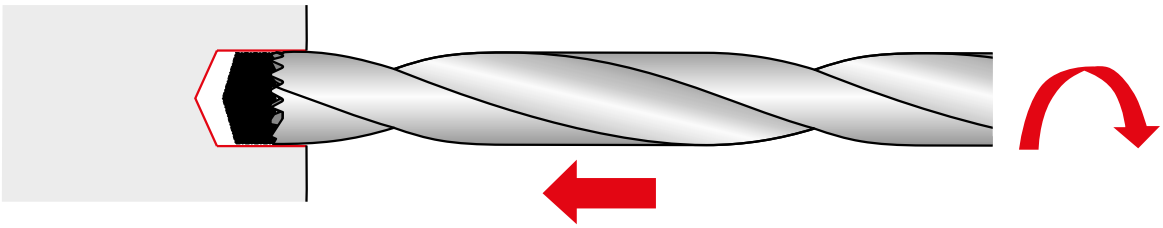
对于8xD和12xD钻孔应用特殊程序



以相同的天龙钻刀头直径钻一个导孔（1.5xD至3xD深度）（如果需要，检查钻头径向跳动，最大+/ 0.05 mm）。

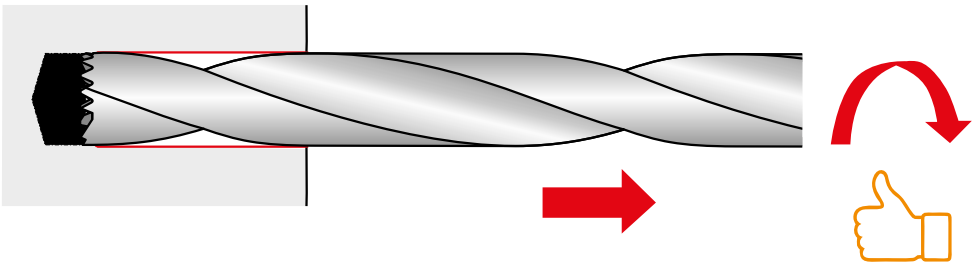


将8xD或12xD钻体插入导孔，最大转速500 rpm，至预钻导孔深度上方约1 mm。



开启冷却剂液流并将转速升高至推荐值（转每分）。
注意：在到达推荐的转速前，请短暂停留，不要开始进给。

钻到需要的深度，不要啄孔。



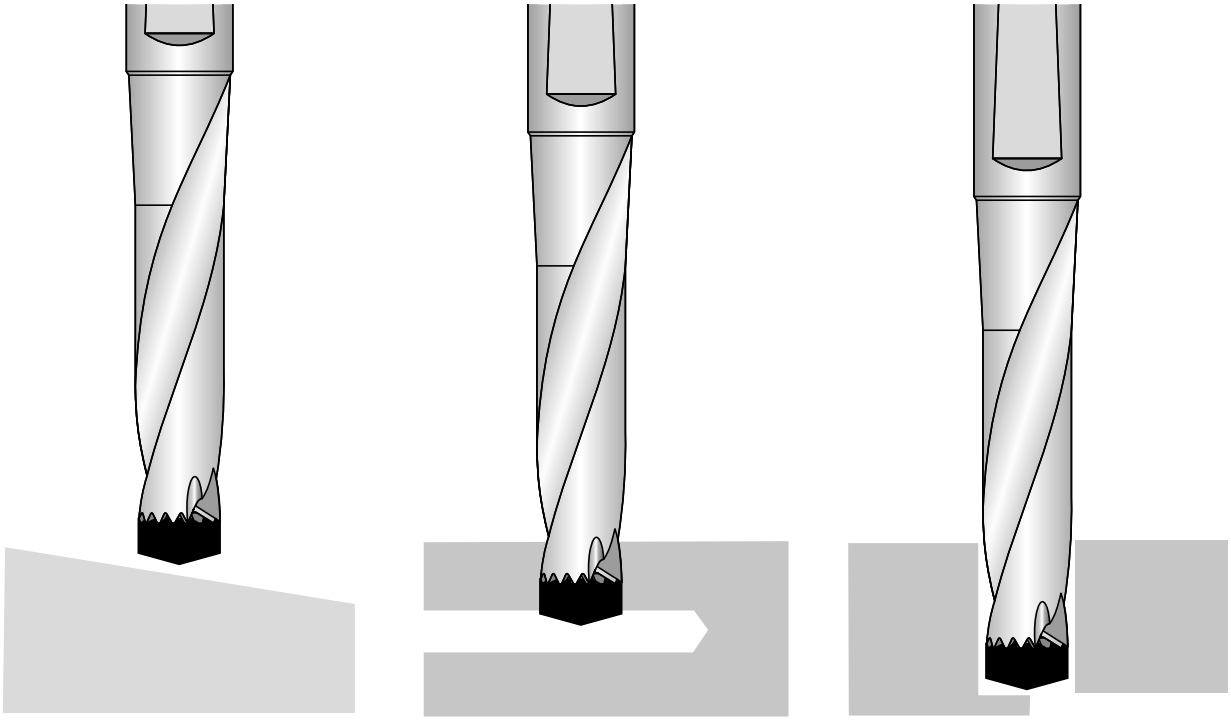
到达所需深度时，回退钻头约0.1 mm至0.5 mm，并将转速降低至500 rpm，然后以正常进给完全缩回。注意：以更高的心轴速度回退钻头可能会产生跳动或破坏孔表面和公差，从而导致孔肩损坏。

天龙钻钻孔提示

冷却剂
为确保最佳的排屑和刀具性能，推荐使用冷却剂。对于大多数应用，推荐的乳化液冷却剂浓度为6 – 8%，冷却剂压力为20 bar（290 PSI）或更高。对于高强度钢、不锈钢和难钻孔的应用，使用10-12%的更高浓度。在这些应用中，特别是不锈钢加工时，推荐在机器上使用最大冷却剂压力。天龙钻冷却剂孔改善了芯部强度和切削刃降热效果，从而提高了生产率，延长了刀具寿命。

刀架
始终使用可为钻头和机器心轴之间提供良好同心度的刀架和夹头。使用一个正向挡块防止刀具退入刀架。必须精确检查并保持刀具总成的径向跳动。

工件
稳固的刚性工件可以令挠度保持在最小，实现更佳的精度和孔位准确度。
进给
避免钻头进给不足非常重要，否则会导致钻头停歇和钝化。尤其是在加工硬质材料时， 足够高的进给率能够确保形成合适的切屑。



位于斜面上的
进口或出口

通孔
交叉孔

出口处有中断

在进行这些钻孔作业时，通常建议将进给率减小至1/3（33%）。钻削进口角度超过10°的表面 – 应首先将表面铣平。

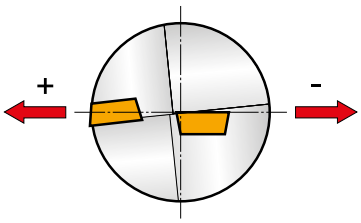
可转位钻头的加工数据

径向调节

孔径调节和设置建议
可转位钻头其可偏心布置，以加工孔径小于或者大于实际钻头直径的孔。
径向调节值参见钻头数据主表。

旋转刀具
在使用80xD系列回转钻头时，推荐使用可调节刀杆实现精密孔径IT10 设置。

固定刀具
在安装钻头时，确保钻头中心线与工件中心线重合。为了加工更大孔径，偏置钻头，使外缘刀片偏离工件中心线。



刀具寿命

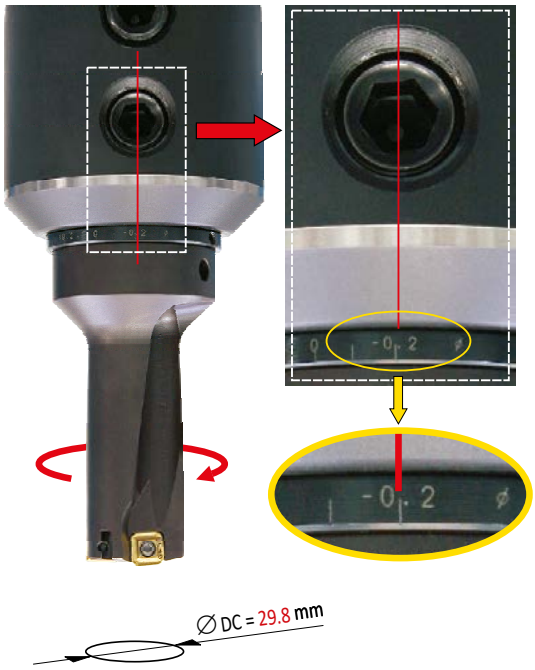
如果在最大点测量的侧面磨损超过0.2 ÷ 0.4毫米，则该刀片不应继续使用。
本产品目录中提到的切削速度均指周边刀片，使用寿命为7米钻孔深度这一条件为前提（使用时间为20 ÷ 30 分钟）。

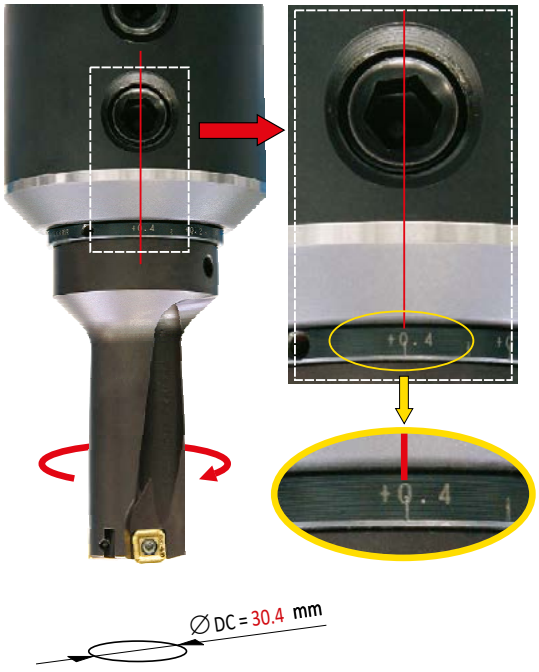
EP 可调节套

钻柄直径	钻柄直径	范围
25	15 – 24	+0.4 – -0.2
32	24.5 – 40	+0.4 – -0.2

直径调节 – 用于加工中心

Diameter adjustment range





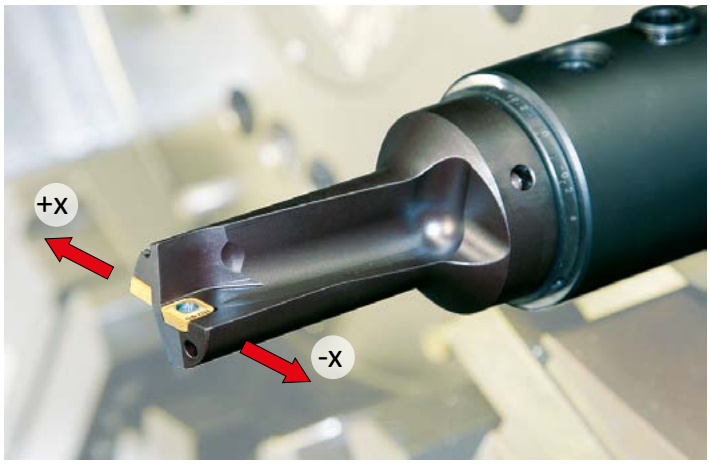
EP

可调节套

钻柄直径	钻柄直径	范围
25	15 – 24	+0.2 – -0.15
32	24.5 – 40	+0.2 – -0.15

中心高度调节 – 用于车床加工

中心高度调节范围



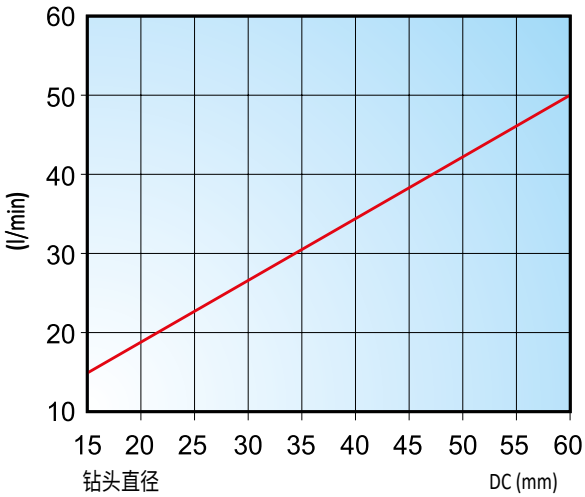
U钻刀片加工数据

推荐冷却液压力

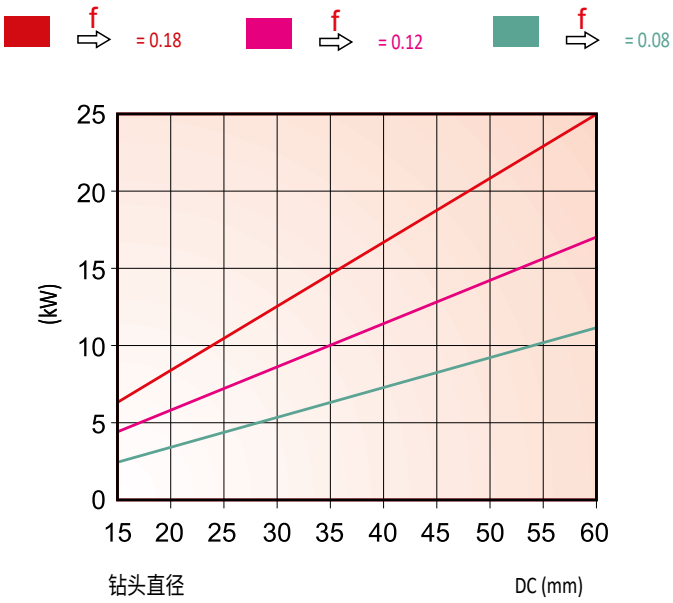
钻削直径 DC (mm)	切削液压力	
	钻头长度	
	2.0 – 2.5 DC	3.0 – 5.0 DC
15 – 25	6 bar	12 bar
26 – 40	4.5 bar	9 bar
> 40	3 bar	6 bar

冷却液流量要求

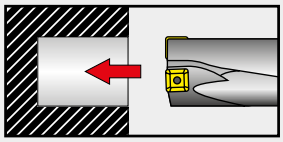
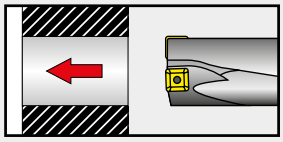
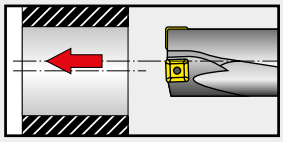
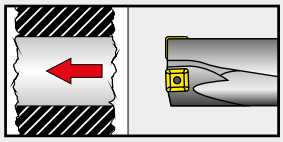
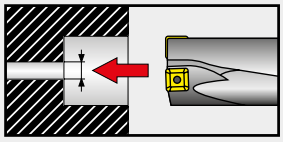
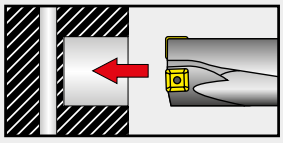
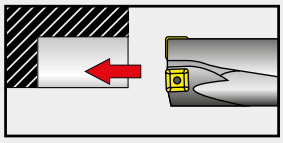
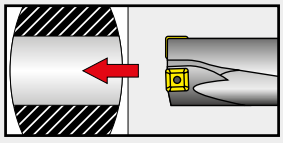
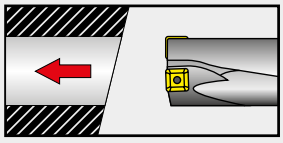
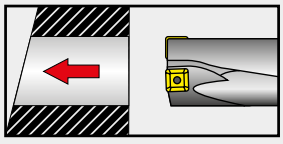
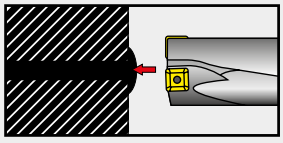
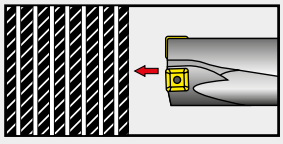
干式钻孔
铸铁和钢的钻孔加工可以不使用冷却液,但要求钻头内部加压空冷方式。



净功耗



常用加工数据

	盲孔钻削 请勿使用倒角钻头。
	通孔钻削 请勿使用倒角钻头。 可转位钻头钻通材料时可能产生铁屑圆盘。该圆盘伴随工件旋转时会高速飞出。为保护操作员的安全，务必在机床周围设置防护装置。
	偏心钻孔 降低可转位钻头的进给量, 建议低于推荐值, 参考可转位刀片的描述.并请勿超过径向调节值。
	不平坦表面和铸造表面钻孔 在两可转位刀片完全钻入之前应降低进给量。
	中心钻孔引导扩孔和钻孔 如果预钻孔直径大于 1/4 钻头直径，则降低进给量。 为避免损坏钻尖，请勿使用整体钻头。
	钻孔与现有孔交叉 钻孔与现有孔交叉时降低进给量至50%, 现有孔直径不应大于0.25XD
	断续切削和插铣 降低可转位钻头的进给量至低于推荐值, 参考刀片描述.
	曲面上钻孔 在进出孔时,可降低进给速度至50%
	在斜面上开始钻孔 如果斜面倾斜角超过 5°，在两转位刀片完全钻入之前,应降低进给量至50%.
	退出斜孔 如果退出角超过 5°，应降低退刀时的进给量至50%.
	在焊缝上钻孔 在开始钻孔之前，应锪平面。降低进给量至50%，直至完全钻入焊接材料中
	叠放物料钻孔 避免层间间隔大于0.2 mm。部件必须可靠固定。必要时降低进给。

可转位钻头 - 推荐的切削工况

802D, 803D (XPET..AP, SCET..-UD)

f ⇨

	D9335	D8330	D8345	ø 15	ø 20	ø 25	ø 30	ø 40	ø 58
P1	■	■	■	0.07	0.08	0.09	0.10	0.12	0.16
P2	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
P3	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
P4	■	■	■	0.12	0.14	0.16	0.18	0.22	0.30
K1	■	■	■	0.14	0.16	0.19	0.21	0.26	0.34
K2	■	■	■	0.14	0.16	0.19	0.21	0.26	0.34
K3	■	■	■	0.14	0.16	0.19	0.21	0.26	0.34
K4	■	■	■	0.14	0.16	0.19	0.21	0.26	0.34
K5	■	■	■	0.14	0.16	0.19	0.21	0.26	0.34

802D, 803D (XPET..AP-SD, SCET..-SD)

f ⇨

	D9335	D8330	D8345	ø 15	ø 20	ø 25	ø 30	ø 40	ø 58
P1	■	■	■	0.08	0.09	0.10	0.11	0.14	0.18
P2	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
P3	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
P4	■	■	■	–	–	–	–	–	–
K1	◪	◪	◪	0.08	0.09	0.10	0.11	0.14	0.18
K2	◪	◪	◪	0.11	0.13	0.15	0.17	0.21	0.28
K3	◪	◪	◪	0.12	0.14	0.16	0.18	0.22	0.24
K4	◪	◪	◪	0.13	0.15	0.18	0.20	0.24	0.32
K5	◪	◪	◪	0.14	0.16	0.19	0.21	0.25	0.33
M1	■	■	■	0.12	0.14	0.16	0.18	0.22	0.30
M2	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
M3	■	■	■	0.07	0.08	0.09	0.10	0.12	0.16
M4	■	■	■	0.07	0.08	0.09	0.10	0.12	0.16
S1	◪	◪	◪	0.08	0.09	0.10	0.11	0.14	0.18
S2	◪	◪	◪	0.08	0.09	0.10	0.11	0.14	0.18
S3	◪	◪	◪	0.07	0.08	0.09	0.10	0.12	0.16
S4	◪	◪	◪	0.07	0.08	0.09	0.10	0.12	0.16

804D (XPET..AP, SCET..-UD)

f ⇨

	D9335	D8330	D8345	ø 15	ø 20	ø 25	ø 30	ø 40	ø 58
P1	■	■	■	0.06	0.07	0.08	0.09	0.10	0.14
P2	■	■	■	0.10	0.12	0.14	0.16	0.19	0.25
P3	■	■	■	0.12	0.14	0.16	0.18	0.22	0.30
P4	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
K1	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K2	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K3	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K4	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K5	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32

可转位钻头 - 推荐的切削工况

804D (XPET..AP-SD, SCET..-SD)

f ⇨

	D9335	D8330	D8345	ø 15	ø 20	ø 25	ø 30	ø 40	ø 58
P1	■	■	■	0.07	0.08	0.09	0.10	0.12	0.16
P2	■	■	■	0.10	0.12	0.14	0.16	0.19	0.25
P3	■	■	■	0.12	0.14	0.16	0.18	0.22	0.30
P4	■	■	■	–	–	–	–	–	–
K1	◪	◪	◪	0.07	0.08	0.09	0.10	0.12	0.16
K2	◪	◪	◪	0.10	0.12	0.14	0.16	0.19	0.25
K3	◪	◪	◪	0.11	0.13	0.15	0.17	0.20	0.27
K4	◪	◪	◪	0.12	0.14	0.16	0.18	0.22	0.30
K5	◪	◪	◪	0.14	0.16	0.19	0.21	0.25	0.33
M1	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
M2	■	■	■	0.10	0.12	0.14	0.16	0.19	0.25
M3	■	■	■	0.06	0.07	0.08	0.09	0.10	0.14
M4	■	■	■	0.06	0.07	0.08	0.09	0.10	0.14
S1	◪	◪	◪	0.07	0.08	0.09	0.10	0.12	0.16
S2	◪	◪	◪	0.07	0.08	0.09	0.10	0.12	0.16
S3	◪	◪	◪	0.06	0.07	0.08	0.09	0.10	0.14
S4	◪	◪	◪	0.06	0.07	0.08	0.09	0.10	0.14

805D (XPET..AP, SCET..-UD)

f ⇨

	D9335	D8330	D8345	ø 15	ø 20	ø 25	ø 30	ø 40	ø 58
P1	■	■	■	0.06	0.07	0.08	0.09	0.10	0.14
P2	■	■	■	0.10	0.12	0.14	0.16	0.19	0.25
P3	■	■	■	0.12	0.14	0.16	0.18	0.22	0.30
P4	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
K1	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K2	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K3	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K4	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32
K5	■	■	■	0.13	0.15	0.18	0.20	0.24	0.32

805D (XPET..AP-SD, SCET..-SD)

f ⇨

	D9335	D8330	D8345	ø 15	ø 20	ø 25	ø 30	ø 40	ø 58
P1	■	■	■	0.07	0.08	0.09	0.10	0.12	0.16
P2	■	■	■	0.10	0.12	0.14	0.16	0.19	0.25
P3	■	■	■	0.12	0.14	0.16	0.18	0.22	0.30
P4	■	■	■	–	–	–	–	–	–
K1	◪	◪	◪	0.07	0.08	0.09	0.10	0.12	0.16
K2	◪	◪	◪	0.10	0.12	0.14	0.16	0.19	0.25
K3	◪	◪	◪	0.11	0.13	0.15	0.17	0.20	0.27
K4	◪	◪	◪	0.12	0.14	0.16	0.18	0.22	0.30
K5	◪	◪	◪	0.12	0.14	0.16	0.18	0.22	0.30
M1	■	■	■	0.11	0.13	0.15	0.17	0.21	0.28
M2	■	■	■	0.10	0.12	0.14	0.16	0.19	0.25
M3	■	■	■	0.06	0.07	0.08	0.09	0.10	0.14
M4	■	■	■	0.06	0.07	0.08	0.09	0.10	0.14
S1	◪	◪	◪	0.07	0.08	0.09	0.10	0.12	0.16
S2	◪	◪	◪	0.07	0.08	0.09	0.10	0.12	0.16
S3	◪	◪	◪	0.06	0.07	0.08	0.09	0.10	0.14
S4	◪	◪	◪	0.06	0.07	0.08	0.09	0.10	0.14

切削参数计算公式

术语和公式		
参数	**公式**	**单位**
主轴转数	$n = \frac{v_c \cdot 1000}{DC \cdot \pi}$	(转.min^{-1})
切削速度	$v_c = \frac{\pi \cdot DC \cdot n}{1000}$	(m/min)
工作台进给	$v_f = n \cdot f$	(mm/min)
孔的横截面面积	$A = \frac{\pi \cdot DC^2}{4}$	(mm^2)
金属去除率	$Q = \frac{v_f \cdot A}{1000}$	(cm^3/min)
加工时间	$T_c = \frac{L + h}{v_f}$	(min/每个孔)

DC	钻头直径	(mm)	*h*	进给之前从钻尖到工件的间距	(mm)
f	每转进给	(mm/rev)	*L*	孔深	(mm)

螺钉锁紧扭矩推荐

	Nm					
US 2245-T07P	0.9	FLAG T07P	M 2.2	5.3	D-T7P	MR-0.8-2.0 vario
US 2205-T07P	0.9	FLAG T07P	M2.2	5.4	D-T7P	MR-0.8-2.0 vario
US 2506-T07P	1.2	FLAG T07P	M 2.5	6	D-T7P	MR-0.8-2.0 vario
US 2507-T08P	1.2	FLAG T08P	M 2.5	7	D-T8P	MR-0.8-2.0 vario
US 3007-T08P	2.0	FLAG T08P	M 3	7	D-T8P	MR-1.0-5.0 vario
US 3007-T09P	2.0	FLAG T09P	M 3	7.4	D-T9P	MR-1.0-5.0 vario
US 3009-T09P	2.0	FLAG T09P	M 3	8.7	D-T9P	MR-1.0-5.0 vario
US 3508-T15P	3.0	FLAG T15P	M 3.5	8.3	D-T15P	MR-1.0-5.0 vario
US 3510-T15P	3.0	FLAG T15P	M 3.5	10.6	D-T15P	MR-1.0-5.0 vario
US 4011-T15P	3.5	FLAG T15P	M 4	10.7	D-T15P	MR-1.0-5.0 vario
US 5012-T15P	5.0	FLAG T15P	M 5	12.2	D-T15P	MR-1.0-5.0 vario

WMG（加工材料组）

ISO组		WMG（加工材料组）				硬度 (HB或HRC)	极限抗拉强度 (MPa)
P	P1	P1.1	易切削钢（可加工性较高的碳钢）		硫化	< 240 HB	≤ 830
		P1.2			硫化和磷化	< 180 HB	≤ 620
		P1.3			硫化/磷化和含铅	< 180 HB	≤ 620
	P2	P2.1	普通碳钢（主要由铁和碳组成的钢）		含<0.25%C	< 180 HB	≤ 620
		P2.2			含<0.55%C	< 240 HB	≤ 830
		P2.3			含>0.55%C	< 300 HB	≤ 1030
	P3	P3.1	合金钢（碳钢，合金含量≤10%）		退火	< 180 HB	≤ 620
		P3.2			硬化与回火	180 – 260 HB	> 620 ≤ 900
		P3.3				260 – 360 HB	> 900 ≤ 1240
	P4	P4.1	工具钢（特种合金钢，用于刀具、模具）		退火	< 26 HRC	≤ 900
		P4.2			硬化与回火	26 – 39 HRC	> 900 ≤ 1240
		P4.3				39 – 45 HRC	> 1240 ≤ 1450
M	M1	M1.1	铁素体不锈钢（直铬非硬化合金）			< 160 HB	≤ 520
		M1.2				160 – 220 HB	> 520 ≤ 700
	M2	M2.1	马氏体不锈钢（直铬可硬化合金）		退火	< 200 HB	≤ 670
		M2.2			淬火加回火	200 – 280 HB	> 670 ≤ 950
		M2.3			沉淀硬化	280 – 380 HB	> 950 ≤ 1300
	M3	M3.1	奥氏体不锈钢（铬镍和铬镍锰合金）			< 200 HB	≤ 750
		M3.2				200 – 260 HB	> 750 ≤ 870
		M3.3				260 – 300 HB	> 870 ≤ 1040
	M4	M4.1	奥氏体-铁素体（双相）或 高级奥氏体不锈钢			< 300 HB	≤ 990
		M4.2	沉淀硬化奥氏体不锈钢			300 – 380 HB	≤ 1320
K	K1	K1.1	灰口铸铁（ASTM A48）或汽车用灰铸铁（ASTM A159）（具有片状石墨微结构的铁碳铸件）		铁素体或铁素体-珠光体	< 180 HB	≤ 190
		K1.2			铁素体-珠光体或珠光体	180 – 240 HB	> 190 ≤ 310
		K1.3			珠光体	240 – 280 HB	> 310 ≤ 390
	K2	K2.1	可锻铸铁（ASTM A602）（无石墨结构的铁碳铸件）		铁素体	< 160 HB	≤ 400
		K2.2			铁素体或珠光体	160 – 200 HB	> 400 ≤ 550
		K2.3			珠光体	200 – 240 HB	> 550 ≤ 660
	K3	K3.1	延性铸铁（ASTM A536）（有石墨结构的铁碳铸件）		铁素体	< 180 HB	≤ 560
		K3.2			铁素体或珠光体	180 – 220 HB	> 560 ≤ 680
		K3.3			珠光体	220 – 260 HB	> 680 ≤ 800
	K4	K4.1	奥氏体灰口铸铁（ASTM A436）（具有奥氏体片状石墨组织的铁碳合金铸件）			< 180 HB	≤ 190
		K4.2	奥氏体延性铸铁（ASTM A439或ASTM A571）（具有奥氏体球墨结构铁碳合金铸件）			< 240 HB	≤ 740
		K4.3	等温淬火球墨铸铁（ASTM A897）（具有奥氏体组织的铁碳合金铸件）			< 280 HB	> 840 ≤ 980
		K4.4				280 – 320 HB	> 980 ≤ 1130
		K4.5				320 – 360 HB	> 1130 ≤ 1280
	K5	K5.1	蠕墨铸铁CGI（ASTM A842）（具有蠕虫状石墨结构的铁碳铸件）		铁素体	< 180 HB	≤ 400
		K5.2			铁素体-珠光体	180 – 220 HB	> 400 ≤ 450
		K5.3			珠光体	220 – 260 HB	> 450 ≤ 500
N	N1	N1.1	工业纯锻铝			< 60 HB	≤ 240
		N1.2	锻铝合金		中硬质回火	60 – 100 HB	> 240 ≤ 400
		N1.3			全硬质回火	100 – 150 HB	> 400 ≤ 590
	N2	N2.1	铸铝合金			< 75 HB	≤ 240
		N2.2				75 – 90 HB	> 240 ≤ 270
		N2.3				90 – 140 HB	> 270 ≤ 440
	N3	N3.1	易切削铜合金材料，具有出色机械加工性能			–	–
		N3.2	短切屑铜合金，具有良好至中等的机械加工性能			–	–
		N3.3	电解铜和长切屑铜合金，具有中等至较差的机械加工性能			–	–
	N4	N4.1	热塑性聚合物			–	–
		N4.2	热固性聚合物			–	–
		N4.3	增强型聚合物或复合材料			–	–
	N5	N5.1	石墨			–	–
S	S1	S1.1	钛或钛合金			< 200 HB	≤ 660
		S1.2				200 – 280 HB	> 660 ≤ 950
		S1.3				280 – 360 HB	> 950 ≤ 1200
	S2	S2.1	铁基高温合金			< 200 HB	≤ 690
		S2.2				200 – 280 HB	> 690 ≤ 970
	S3	S3.1	镍基高温合金			< 280 HB	≤ 940
		S3.2				280 – 360 HB	> 940 ≤ 1200
	S4	S4.1	钴基高温合金			< 240 HB	≤ 800
		S4.2				240 – 320 HB	> 800 ≤ 1070
H	H1	H1.1	冷硬铸铁			< 440 HB	–
	H2	H2.1	硬化铸铁			< 55 HRC	–
		H2.2				> 55 HRC	–
	H3	H3.1	硬化钢 < 55 HRC			< 51 HRC	–
		H3.2				51 – 55 HRC	–
	H4	H4.1	硬化钢 > 55 HRC			55 – 59 HRC	–
		H4.2				> 59 HRC	–

硬度转换表

强度 (MPa)	硬度			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
285	86	**90**	1190	–
320	95	**100**	56.2	–
350	105	**110**	62.3	–
385	114	**120**	66.7	–
415	124	**130**	71.2	–
450	133	**140**	75.0	–
480	143	**150**	78.7	–
510	152	**160**	81.7	–
545	162	**170**	85.8	–
575	171	**180**	87.1	–
610	181	**190**	89.5	–
640	190	**200**	91.5	–
675	199	**210**	93.5	–
705	209	**220**	95	–
740	219	**230**	96.7	–
770	228	**240**	98.1	–
800	238	**250**	99.5	–
820	242	**255**	–	23.1
850	252	**265**	–	24.8
880	261	**275**	–	26.4
900	266	**280**	–	27.1
930	276	**290**	–	28.5
950	280	**295**	–	29.2
995	295	**310**	–	31.0
1030	304	**320**	–	32.2
1060	314	**330**	–	33.3
1095	323	**340**	–	34.4
1125	333	**350**	–	35.5
1155	342	**360**	–	36.6

强度 (MPa)	硬度			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
1190	352	**370**	–	37.7
1220	361	**380**	–	38.8
1255	371	**390**	–	39.8
1290	380	**400**	–	40.8
1320	390	**410**	–	41.8
1350	399	**420**	–	42.7
1385	409	**430**	–	43.6
1420	418	**440**	–	44.5
1455	428	**450**	–	45.3
1485	437	**460**	–	46.1
1520	447	**470**	–	46.9
1555	456	**480**	–	47.7
1595	466	**490**	–	48.4
1630	475	**500**	–	49.1
1665	485	**510**	–	49.8
1700	494	**520**	–	50.5
1740	504	**530**	–	51.1
1775	513	**540**	–	51.7
1810	523	**550**	–	52.3
1845	532	**560**	–	53.0
1880	542	**570**	–	53.6
1920	551	**580**	–	54.1
1955	561	**590**	–	54.7
1995	570	**600**	–	55.2
2030	580	**610**	–	55.7
2070	589	**620**	–	56.3
2105	599	**630**	–	56.8
2145	608	**640**	–	57.3
2180	618	**650**	–	57.8

SIMPLY RELIABLE

作为你可以通过切屑判断工件质量的专业公司。该切屑是清洁和简单的形状这本身就在讲述了一个故事。这是一个清晰和一致的信号，这就是为什么我们使用它作为简洁可靠的符号。

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