

CMTéc

- ▶ S尖點設計可保護刀刃不易產生崩裂。
- ▶ 銑刀柄適合高速高進給鑽孔加工。
- ▶ 提供3D~7D鑽孔深度的加工需求。



平滑的刀刃設計
使排屑更加順暢

FIRE

鍍層適用於難切削材料



Dream Drills!

鑽削加工的利器

高效能鑽頭新里程碑

內冷型(油孔)設計- 深孔加工專用 可提供10D~30D的鑽削需求!

特殊螺旋孔直接給油大大提高了排屑效率。

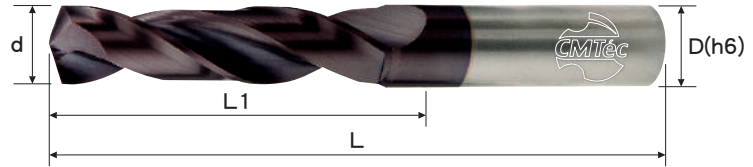
Excellent chip removal by spiral coolant hole.



鎢鋼高速鑽頭- 短刃型- 2刃(3倍長)

CARBIDE HIGH SPEED DRILLS- End Mill Shank- Short Flute- 2F(3xd)

· CDH20000F



※ 有效加工深度 = 3倍刃徑。
Cutting effective length = 3xd

※ 其他刃徑公差規格依需求生產。
Special tolerance(ϕ) is on request.



刃徑 d	公差 Tolerance
ϕ	h7

刃徑 d	溝長 L1	全長 L	柄徑 D	刃數 F	白刀訂購編號 Uncoated Order No.	鍍膜訂購編號 Coated Order No.
2.0	13	50	3	2	CDH20200	CDH20200F
2.1	13	50	3	2	CDH20210	CDH20210F
2.2	15	50	3	2	CDH20220	CDH20220F
2.3	15	50	3	2	CDH20230	CDH20230F
2.4	15	50	3	2	CDH20240	CDH20240F
2.5	16	50	3	2	CDH20250	CDH20250F
2.6	16	50	3	2	CDH20260	CDH20260F
2.7	16	50	3	2	CDH20270	CDH20270F
2.8	18	50	3	2	CDH20280	CDH20280F
2.9	18	50	3	2	CDH20290	CDH20290F
3.0	20	62	3	2	CDH20300	CDH20300F
3.1	20	62	4	2	CDH20310	CDH20310F
3.2	20	62	4	2	CDH20320	CDH20320F
3.3	20	62	4	2	CDH20330	CDH20330F
3.4	20	62	4	2	CDH20340	CDH20340F
3.5	20	62	4	2	CDH20350	CDH20350F
3.6	20	62	4	2	CDH20360	CDH20360F
3.7	20	62	4	2	CDH20370	CDH20370F
3.8	20	62	4	2	CDH20380	CDH20380F
3.9	20	62	4	2	CDH20390	CDH20390F
4.0	24	66	4	2	CDH20400	CDH20400F
4.1	24	66	5	2	CDH20410	CDH20410F
4.2	24	66	5	2	CDH20420	CDH20420F
4.3	24	66	5	2	CDH20430	CDH20430F
4.4	24	66	5	2	CDH20440	CDH20440F
4.5	24	66	5	2	CDH20450	CDH20450F
4.6	24	66	5	2	CDH20460	CDH20460F
4.7	24	66	5	2	CDH20470	CDH20470F
4.8	28	66	5	2	CDH20480	CDH20480F
4.9	28	66	5	2	CDH20490	CDH20490F
5.0	28	66	5	2	CDH20500	CDH20500F
5.1	28	66	6	2	CDH20510	CDH20510F
5.2	28	66	6	2	CDH20520	CDH20520F
5.3	28	66	6	2	CDH20530	CDH20530F
5.4	28	66	6	2	CDH20540	CDH20540F
5.5	28	66	6	2	CDH20550	CDH20550F
5.6	28	66	6	2	CDH20560	CDH20560F

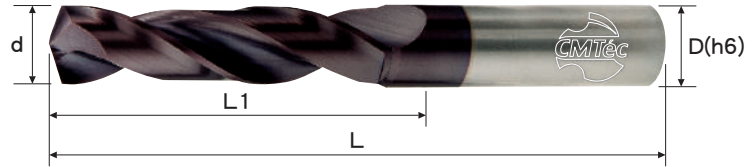
→ 切削條件表 P.561
Cutting Condition

→ 技術資料 P.630
Technical Data

鎢鋼高速鑽頭- 短刃型- 2刃(3倍長)

CARBIDE HIGH SPEED DRILLS- End Mill Shank- Short Flute- 2F(3×d)

· CDH20000F



※ 有效加工深度 = 3倍刃徑。
Cutting effective length = 3xd

※ 其他刃徑公差規格依需求生產。
Special tolerance(φ) is on request.



刃徑 d	公差 Tolerance
φ	h7

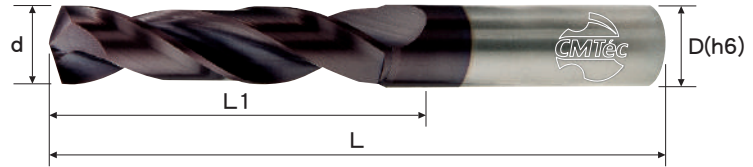
刃徑 d	溝長 L1	全長 L	柄徑 D	刃數 F	白刀訂購編號 Uncoated Order No.	鍍膜訂購編號 Coated Order No.
5.7	28	66	6	2	CDH20570	CDH20570F
5.8	28	66	6	2	CDH20580	CDH20580F
5.9	28	66	6	2	CDH20590	CDH20590F
6.0	28	66	6	2	CDH20600	CDH20600F
6.1	34	79	7	2	CDH20610	CDH20610F
6.2	34	79	7	2	CDH20620	CDH20620F
6.3	34	79	7	2	CDH20630	CDH20630F
6.4	34	79	7	2	CDH20640	CDH20640F
6.5	34	79	7	2	CDH20650	CDH20650F
6.6	34	79	7	2	CDH20660	CDH20660F
6.7	34	79	7	2	CDH20670	CDH20670F
6.8	34	79	7	2	CDH20680	CDH20680F
6.9	34	79	7	2	CDH20690	CDH20690F
7.0	34	79	7	2	CDH20700	CDH20700F
6.1	34	79	8	2	CDH20610080D	CDH20610080DF
6.2	34	79	8	2	CDH20620080D	CDH20620080DF
6.3	34	79	8	2	CDH20630080D	CDH20630080DF
6.4	34	79	8	2	CDH20640080D	CDH20640080DF
6.5	34	79	8	2	CDH20650080D	CDH20650080DF
6.6	34	79	8	2	CDH20660080D	CDH20660080DF
6.7	34	79	8	2	CDH20670080D	CDH20670080DF
6.8	34	79	8	2	CDH20680080D	CDH20680080DF
6.9	34	79	8	2	CDH20690080D	CDH20690080DF
7.0	34	79	8	2	CDH20700080D	CDH20700080DF
7.1	41	79	8	2	CDH20710	CDH20710F
7.2	41	79	8	2	CDH20720	CDH20720F
7.3	41	79	8	2	CDH20730	CDH20730F
7.4	41	79	8	2	CDH20740	CDH20740F
7.5	41	79	8	2	CDH20750	CDH20750F
7.6	41	79	8	2	CDH20760	CDH20760F
7.7	41	79	8	2	CDH20770	CDH20770F
7.8	41	79	8	2	CDH20780	CDH20780F
7.9	41	79	8	2	CDH20790	CDH20790F
8.0	41	79	8	2	CDH20800	CDH20800F
8.1	47	89	9	2	CDH20810	CDH20810F
8.2	47	89	9	2	CDH20820	CDH20820F
8.3	47	89	9	2	CDH20830	CDH20830F

→ 切削條件表 P.561 Cutting Condition
→ 技術資料 P.630 Technical Data

鎢鋼高速鑽頭- 短刃型- 2刃(3倍長)

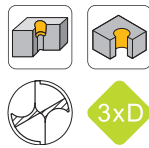
CARBIDE HIGH SPEED DRILLS- End Mill Shank- Short Flute- 2F(3xd)

· CDH20000F



※ 有效加工深度 = 3倍刃徑。
Cutting effective length = 3xd

※ 其他刃徑公差規格依需求生產。
Special tolerance(φ) is on request.



3xD

MG

FIRE

140°

30°

HRC 45

Cutting Table

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刃徑 d	公差 Tolerance
φ	h7

刃徑 d	溝長 L1	全長 L	柄徑 D	刃數 F	白刀訂購編號 Uncoated Order No.	鍍膜訂購編號 Coated Order No.
8.4	47	89	9	2	CDH20840	CDH20840F
8.5	47	89	9	2	CDH20850	CDH20850F
8.6	47	89	9	2	CDH20860	CDH20860F
8.7	47	89	9	2	CDH20870	CDH20870F
8.8	47	89	9	2	CDH20880	CDH20880F
8.9	47	89	9	2	CDH20890	CDH20890F
9.0	47	89	9	2	CDH20900	CDH20900F
8.1	47	89	10	2	CDH20810100D	CDH20810100DF
8.2	47	89	10	2	CDH20820100D	CDH20820100DF
8.3	47	89	10	2	CDH20830100D	CDH20830100DF
8.4	47	89	10	2	CDH20840100D	CDH20840100DF
8.5	47	89	10	2	CDH20850100D	CDH20850100DF
8.6	47	89	10	2	CDH20860100D	CDH20860100DF
8.7	47	89	10	2	CDH20870100D	CDH20870100DF
8.8	47	89	10	2	CDH20880100D	CDH20880100DF
8.9	47	89	10	2	CDH20890100D	CDH20890100DF
9.0	47	89	10	2	CDH20900100D	CDH20900100DF
9.1	47	89	10	2	CDH20910	CDH20910F
9.2	47	89	10	2	CDH20920	CDH20920F
9.3	47	89	10	2	CDH20930	CDH20930F
9.4	47	89	10	2	CDH20940	CDH20940F
9.5	47	89	10	2	CDH20950	CDH20950F
9.6	47	89	10	2	CDH20960	CDH20960F
9.7	47	89	10	2	CDH20970	CDH20970F
9.8	47	89	10	2	CDH20980	CDH20980F
9.9	47	89	10	2	CDH20990	CDH20990F
10.0	47	89	10	2	CDH21000	CDH21000F
10.2	55	102	11	2	CDH21020	CDH21020F
10.5	55	102	11	2	CDH21050	CDH21050F
10.8	55	102	11	2	CDH21080	CDH21080F
11.0	55	102	11	2	CDH21100	CDH21100F
10.2	55	102	12	2	CDH21020120D	CDH21020120DF
10.5	55	102	12	2	CDH21050120D	CDH21050120DF
10.8	55	102	12	2	CDH21080120D	CDH21080120DF
11.0	55	102	12	2	CDH21100120D	CDH21100120DF
11.2	55	102	12	2	CDH21120	CDH21120F
11.5	55	102	12	2	CDH21150	CDH21150F

→ 切削條件表
Cutting Condition

P.561

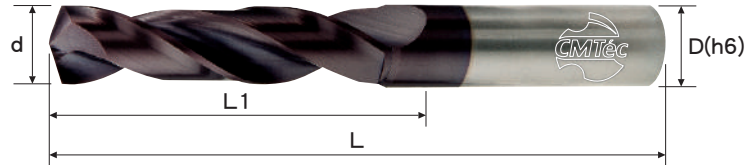
→ 技術資料
Technical Data

P.630

鎢鋼高速鑽頭- 標準型- 2刃(5倍長)

CARBIDE HIGH SPEED DRILLS- End Mill Shank- Standard- 2F(5×d)

· CDHF20000F



規格DIN6537

※ 有效加工深度 = 5倍刃徑。
Cutting effective length = 5xd

※ 其他刃徑公差規格依需求生產。
Special tolerance(ϕ) is on request.



刃徑 d	公差 Tolerance
ϕ	h7

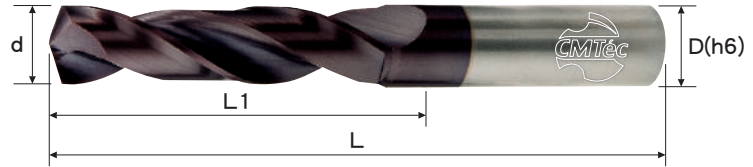
刃徑 d	溝長 L1	全長 L	柄徑 D	刃數 F	鍍膜訂購編號 coated Order No.
3.0	28	66	6	2	CDHF20300F
3.1	28	66	6	2	CDHF20310F
3.2	28	66	6	2	CDHF20320F
3.3	28	66	6	2	CDHF20330F
3.4	28	66	6	2	CDHF20340F
3.5	28	66	6	2	CDHF20350F
3.6	28	66	6	2	CDHF20360F
3.7	28	66	6	2	CDHF20370F
3.8	36	74	6	2	CDHF20380F
3.9	36	74	6	2	CDHF20390F
4.0	36	74	6	2	CDHF20400F
4.1	36	74	6	2	CDHF20410F
4.2	36	74	6	2	CDHF20420F
4.3	36	74	6	2	CDHF20430F
4.4	36	74	6	2	CDHF20440F
4.5	36	74	6	2	CDHF20450F
4.6	36	74	6	2	CDHF20460F
4.7	36	74	6	2	CDHF20470F
4.8	44	82	6	2	CDHF20480F
4.9	44	82	6	2	CDHF20490F
5.0	44	82	6	2	CDHF20500F
5.1	44	82	6	2	CDHF20510F
5.2	44	82	6	2	CDHF20520F
5.3	44	82	6	2	CDHF20530F
5.4	44	82	6	2	CDHF20540F
5.5	44	82	6	2	CDHF20550F
5.6	44	82	6	2	CDHF20560F
5.7	44	82	6	2	CDHF20570F
5.8	44	82	6	2	CDHF20580F
5.9	44	82	6	2	CDHF20590F
6.0	44	82	6	2	CDHF20600F
6.1	53	91	8	2	CDHF20610F
6.2	53	91	8	2	CDHF20620F
6.3	53	91	8	2	CDHF20630F

→ 切削條件表 Cutting Condition P.561 → 技術資料 Technical Data P.630

鎢鋼高速鑽頭- 標準型- 2刃(5倍長)

CARBIDE HIGH SPEED DRILLS- End Mill Shank- Standard- 2F(5×d)

· CDHF20000F



規格DIN6537

※ 有效加工深度 = 5倍刃徑。
Cutting effective length = 5xd

※ 其他刃徑公差規格依需求生產。
Special tolerance(ϕ) is on request.



刃徑 d	公差 Tolerance
ϕ	h7

刃徑 d	溝長 L1	全長 L	柄徑 D	刃數 F	鍍膜訂購編號 Coated Order No.
6.4	53	91	8	2	CDHF20640F
6.5	53	91	8	2	CDHF20650F
6.6	53	91	8	2	CDHF20660F
6.7	53	91	8	2	CDHF20670F
6.8	53	91	8	2	CDHF20680F
6.9	53	91	8	2	CDHF20690F
7.0	53	91	8	2	CDHF20700F
7.1	53	91	8	2	CDHF20710F
7.2	53	91	8	2	CDHF20720F
7.3	53	91	8	2	CDHF20730F
7.4	53	91	8	2	CDHF20740F
7.5	53	91	8	2	CDHF20750F
7.6	53	91	8	2	CDHF20760F
7.7	53	91	8	2	CDHF20770F
7.8	53	91	8	2	CDHF20780F
7.9	53	91	8	2	CDHF20790F
8.0	53	91	8	2	CDHF20800F
8.1	61	103	10	2	CDHF20810F
8.2	61	103	10	2	CDHF20820F
8.3	61	103	10	2	CDHF20830F
8.4	61	103	10	2	CDHF20840F
8.5	61	103	10	2	CDHF20850F
8.6	61	103	10	2	CDHF20860F
8.7	61	103	10	2	CDHF20870F
8.8	61	103	10	2	CDHF20880F
8.9	61	103	10	2	CDHF20890F
9.0	61	103	10	2	CDHF20900F
9.1	61	103	10	2	CDHF20910F
9.2	61	103	10	2	CDHF20920F
9.3	61	103	10	2	CDHF20930F
9.4	61	103	10	2	CDHF20940F
9.5	61	103	10	2	CDHF20950F
9.6	61	103	10	2	CDHF20960F
9.7	61	103	10	2	CDHF20970F
9.8	61	103	10	2	CDHF20980F
9.9	61	103	10	2	CDHF20990F
10.0	61	103	10	2	CDHF21000F

→ 切削條件表
Cutting Condition

P.561

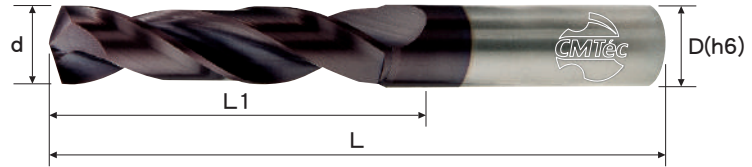
→ 技術資料
Technical Data

P.630

鎢鋼高速鑽頭- 長刃型- 2刃(7倍長)

CARBIDE HIGH SPEED DRILLS- End Mill Shank- Long Flute- 2F(7×d)

· CDHS20000F



- ※ 有效加工深度 = 7倍刃徑。
Cutting effective length = 7xd
- ※ 有效加工深度(10、12、15)倍長
依需求生產。
Cutting effective length(10xd,
12xd, 15xd) are on request.
- ※ 其他刃徑公差規格依需求生產。
Special tolerance(ϕ) is on request.



刃徑 d	公差 Tolerance
ϕ	h7

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刃徑 d	溝長 L1	全長 L	柄徑 D	刃數 F	鍍膜訂購編號 Coated Order No.
0.5	4.0	47	3	2	CDHS20050F
0.6	4.8	47	3	2	CDHS20060F
0.7	5.6	47	3	2	CDHS20070F
0.8	6.4	47	3	2	CDHS20080F
0.9	7.2	47	3	2	CDHS20090F
1.0	8.0	47	3	2	CDHS20100F
1.1	8.8	47	3	2	CDHS20110F
1.2	10.8	52	3	2	CDHS20120F
1.3	11.7	52	3	2	CDHS20130F
1.4	12.6	52	3	2	CDHS20140F
1.5	13.5	52	3	2	CDHS20150F
1.6	14.4	52	3	2	CDHS20160F
1.7	15.3	52	3	2	CDHS20170F
1.8	16.2	52	3	2	CDHS20180F
1.9	17.1	52	3	2	CDHS20190F
2.0	18.0	63	4	2	CDHS20200F
2.1	18.9	63	4	2	CDHS20210F
2.2	19.8	63	4	2	CDHS20220F
2.3	20.7	63	4	2	CDHS20230F
2.4	21.6	63	4	2	CDHS20240F
2.5	22.5	63	4	2	CDHS20250F
2.6	23.4	67	4	2	CDHS20260F
2.7	24.3	67	4	2	CDHS20270F
2.8	25.2	67	4	2	CDHS20280F
2.9	26.1	67	4	2	CDHS20290F
3.0	30.0	70	6	2	CDHS20300F
3.1	30.0	70	6	2	CDHS20310F
3.2	30.0	70	6	2	CDHS20320F
3.3	30.0	70	6	2	CDHS20330F
3.4	35.5	75	6	2	CDHS20340F
3.5	35.5	75	6	2	CDHS20350F
3.6	35.5	75	6	2	CDHS20360F
3.7	35.5	75	6	2	CDHS20370F
3.8	37.5	75	6	2	CDHS20380F
3.9	37.5	75	6	2	CDHS20390F
4.0	37.5	75	6	2	CDHS20400F
4.1	37.5	75	6	2	CDHS20410F

→ 切削條件表
Cutting Condition

P.563

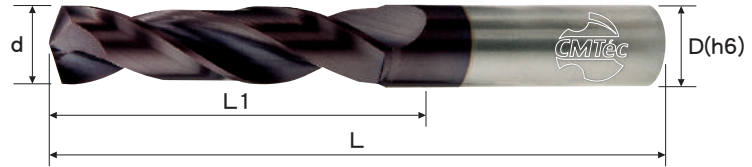
→ 技術資料
Technical Data

P.630

鎢鋼高速鑽頭- 長刃型- 2刃(7倍長)

CARBIDE HIGH SPEED DRILLS- End Mill Shank- Long Flute- 2F(7×d)

· CDHS20000F



- ※ 有效加工深度 = 7倍刃徑。
Cutting effective length = 7xd
- ※ 有效加工深度(10、12、15)倍長
依需求生產。
Cutting effective length(10xd,
12xd, 15xd) are on request.
- ※ 其他刃徑公差規格依需求生產。
Special tolerance(ϕ) is on request.



刃徑 d	公差 Tolerance
ϕ	h7

刃徑 d	溝長 L1	全長 L	柄徑 D	刃數 F	鍍膜訂購編號 Coated Order No.
4.2	37.5	75	6	2	CDHS20420F
4.3	45.0	85	6	2	CDHS20430F
4.4	45.0	85	6	2	CDHS20440F
4.5	45.0	85	6	2	CDHS20450F
4.6	45.0	85	6	2	CDHS20460F
4.7	45.0	85	6	2	CDHS20470F
4.8	50.0	90	6	2	CDHS20480F
4.9	50.0	90	6	2	CDHS20490F
5.0	50.0	90	6	2	CDHS20500F
5.1	50.0	90	6	2	CDHS20510F
5.3	50.0	90	6	2	CDHS20530F
5.5	57.0	97	6	2	CDHS20550F
6.0	57.0	97	6	2	CDHS20600F
6.5	66.0	106	8	2	CDHS20650F
6.8	66.0	106	8	2	CDHS20680F
6.9	66.0	106	8	2	CDHS20690F
7.0	76.0	116	8	2	CDHS20700F
7.5	76.0	116	8	2	CDHS20750F
7.6	76.0	116	8	2	CDHS20760F
7.7	76.0	116	8	2	CDHS20770F
7.8	76.0	116	8	2	CDHS20780F
8.0	76.0	116	8	2	CDHS20800F
8.2	87.0	131	10	2	CDHS20820F
8.5	87.0	131	10	2	CDHS20850F
8.6	87.0	131	10	2	CDHS20860F
9.0	87.0	131	10	2	CDHS20900F
9.2	87.0	131	10	2	CDHS20920F
9.5	95.0	139	10	2	CDHS20950F
9.8	95.0	139	10	2	CDHS20980F
10.0	95.0	139	10	2	CDHS21000F
10.2	106.0	155	12	2	CDHS21020F
10.3	106.0	155	12	2	CDHS21030F
10.5	106.0	155	12	2	CDHS21050F
10.7	106.0	155	12	2	CDHS21070F
11.0	106.0	155	12	2	CDHS21100F
11.5	114.0	163	12	2	CDHS21150F
12.0	114.0	163	12	2	CDHS21200F

→ 切削條件表 P.563 → 技術資料 P.630
Cutting Condition Technical Data

鎢鋼高速內冷鑽頭- 短刃型- 2刃(3倍長)

CARBIDE HIGH SPEED DRILLS- End Mill Shank- Coolant Hole- Short Flute- 2F(3×d)

· CDHC20000F



規格DIN6537

※ 有效加工深度 = 3倍刃徑。
Cutting effective length = 3xd

※ 其他刃徑公差規格依需求生產。
Special tolerance(φ) is on request.

刃徑 d	公差 Tolerance
φ	h7



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刃徑 d	溝長 L1	全長 L	柄徑 D	刃數 F	鍍膜訂購編號 Coated Order No.
4.0	24	66	6	2	CDHC20400F
4.5	24	66	6	2	CDHC20450F
5.0	28	66	6	2	CDHC20500F
5.5	28	66	6	2	CDHC20550F
6.0	28	66	6	2	CDHC20600F
6.5	34	79	8	2	CDHC20650F
7.0	34	79	8	2	CDHC20700F
7.5	41	79	8	2	CDHC20750F
8.0	41	79	8	2	CDHC20800F
8.5	47	89	10	2	CDHC20850F
9.0	47	89	10	2	CDHC20900F
9.5	47	89	10	2	CDHC20950F
10.0	47	89	10	2	CDHC21000F
10.5	55	102	12	2	CDHC21050F
11.0	55	102	12	2	CDHC21100F
11.5	55	102	12	2	CDHC21150F
12.0	55	102	12	2	CDHC21200F
12.5	60	107	14	2	CDHC21250F
13.0	60	107	14	2	CDHC21300F
13.5	60	107	14	2	CDHC21350F
14.0	60	107	14	2	CDHC21400F
14.5	65	115	16	2	CDHC21450F
15.0	65	115	16	2	CDHC21500F
15.5	65	115	16	2	CDHC21550F
16.0	65	115	16	2	CDHC21600F
16.5	73	123	18	2	CDHC21650F
17.0	73	123	18	2	CDHC21700F
17.5	73	123	18	2	CDHC21750F
18.0	73	123	18	2	CDHC21800F
18.5	79	131	20	2	CDHC21850F
19.0	79	131	20	2	CDHC21900F
19.5	79	131	20	2	CDHC21950F
20.0	79	131	20	2	CDHC22000F

→ 切削條件表 P.562
Cutting Condition

→ 技術資料 P.630
Technical Data

鎢鋼高速內冷鑽頭- 標準型- 2刃(5倍長)

CARBIDE HIGH SPEED DRILLS- End Mill Shank- Coolant Hole- Standard- 2F(5×d)

· CDHCF20000F



規格DIN6537

※ 有效加工深度= 5倍刃徑。
Cutting effective length = 5xd

※ 其他刃徑公差規格依需求生產。
Special tolerance(φ) is on request.



刃徑 d	公差 Tolerance
φ	h7

刃徑 d	溝長 L1	全長 L	柄徑 D	刃數 F	鍍膜訂購編號 Coated Order No.
4.0	36	74	6	2	CDHCF20400F
4.5	36	74	6	2	CDHCF20450F
5.0	44	82	6	2	CDHCF20500F
5.5	44	82	6	2	CDHCF20550F
6.0	44	82	6	2	CDHCF20600F
6.5	53	91	8	2	CDHCF20650F
7.0	53	91	8	2	CDHCF20700F
7.5	53	91	8	2	CDHCF20750F
8.0	53	91	8	2	CDHCF20800F
8.5	61	103	10	2	CDHCF20850F
9.0	61	103	10	2	CDHCF20900F
9.5	61	103	10	2	CDHCF20950F
10.0	61	103	10	2	CDHCF21000F
10.5	71	118	12	2	CDHCF21050F
11.0	71	118	12	2	CDHCF21100F
11.5	71	118	12	2	CDHCF21150F
12.0	71	118	12	2	CDHCF21200F
12.5	77	127	14	2	CDHCF21250F
13.0	77	127	14	2	CDHCF21300F
13.5	77	127	14	2	CDHCF21350F
14.0	77	127	14	2	CDHCF21400F
14.5	83	133	16	2	CDHCF21450F
15.0	83	133	16	2	CDHCF21500F
15.5	83	133	16	2	CDHCF21550F
16.0	83	133	16	2	CDHCF21600F
16.5	93	143	18	2	CDHCF21650F
17.0	93	143	18	2	CDHCF21700F
17.5	93	143	18	2	CDHCF21750F
18.0	93	143	18	2	CDHCF21800F
18.5	101	153	20	2	CDHCF21850F
19.0	101	153	20	2	CDHCF21900F
19.5	101	153	20	2	CDHCF21950F
20.0	101	153	20	2	CDHCF22000F

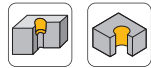
鎢鋼高速內冷鑽頭- 長刃型- 2刃(7倍長)

CARBIDE HIGH SPEED DRILLS- End Mill Shank- Coolant Hole- Long Flute- 2F(7×d)

· CDHCS20000F



- ※ 有效加工深度 = 7倍刃徑。
Cutting effective length = 7xd
- ※ 有效加工深度(10、12、15)倍長
依需求生產。
Cutting effective length(10xd,
12xd, 15xd) are on request.
- ※ 其他刃徑公差規格依需求生產。
Special tolerance(ϕ) is on request.



刃徑 d	公差 Tolerance
ϕ	h7

刃徑 d	溝長 L1	全長 L	柄徑 D	刃數 F	鍍膜訂購編號 Coated Order No.
5.0	50	90	6	2	CDHCS20500F
5.1	50	90	6	2	CDHCS20510F
5.3	50	90	6	2	CDHCS20530F
5.5	57	97	6	2	CDHCS20550F
6.0	57	97	6	2	CDHCS20600F
6.5	66	106	8	2	CDHCS20650F
6.8	66	106	8	2	CDHCS20680F
6.9	66	106	8	2	CDHCS20690F
7.0	76	116	8	2	CDHCS20700F
7.5	76	116	8	2	CDHCS20750F
7.6	76	116	8	2	CDHCS20760F
7.7	76	116	8	2	CDHCS20770F
7.8	76	116	8	2	CDHCS20780F
8.0	76	116	8	2	CDHCS20800F
8.2	87	131	10	2	CDHCS20820F
8.5	87	131	10	2	CDHCS20850F
8.6	87	131	10	2	CDHCS20860F
9.0	87	131	10	2	CDHCS20900F
9.2	87	131	10	2	CDHCS20920F
9.5	95	139	10	2	CDHCS20950F
9.8	95	139	10	2	CDHCS20980F
10.0	95	139	10	2	CDHCS21000F
10.2	106	155	12	2	CDHCS21020F
10.3	106	155	12	2	CDHCS21030F
10.5	106	155	12	2	CDHCS21050F
10.7	106	155	12	2	CDHCS21070F
11.0	106	155	12	2	CDHCS21100F
11.5	114	163	12	2	CDHCS21150F
12.0	114	163	12	2	CDHCS21200F
12.1	133	182	14	2	CDHCS21210F
12.3	133	182	14	2	CDHCS21230F
12.5	133	182	14	2	CDHCS21250F
13.0	133	182	14	2	CDHCS21300F
13.5	133	182	14	2	CDHCS21350F
14.0	133	182	14	2	CDHCS21400F
14.1	152	204	16	2	CDHCS21410F
14.5	152	204	16	2	CDHCS21450F
15.0	152	204	16	2	CDHCS21500F
15.5	152	204	16	2	CDHCS21550F
15.7	152	204	16	2	CDHCS21570F
16.0	152	204	16	2	CDHCS21600F

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Table 52

CDH 鎢鋼短刃型高速鑽頭- 2刃(3倍長)(鍍膜) 切削條件表

SOLID CARBIDE DRILLS- DRILLING CONDITION TABLE

加工材質 Material	碳素鋼 Carbon Steels		合金鋼 Alloy Steels		合金鋼 Alloy Steels		不銹鋼 Stainless Steels		鑄鐵 Cast Iron	
工件料號 Material Code	S35C,S45C,S50C		SCM,SKT,SKD		SCM,SKT,SKD		SUS304		FC,FCD	
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		—		HRC<30	
切削速度 Vc	120m/min		100m/min		60m/min		40m/min		130m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
3mm	12,740	1,040	10,620	770	6,370	510	4,250	290	13,800	1,080
4mm	9,550	1,040	7,960	770	4,780	510	3,180	290	10,350	1,080
5mm	7,640	780	6,370	590	3,820	380	2,550	220	8,280	810
6mm	6,370	780	5,310	590	3,190	350	2,120	220	6,900	810
8mm	4,780	720	3,980	540	2,390	350	1,590	200	5,180	760
10mm	3,820	640	3,180	490	1,910	320	1,270	180	4,140	680
12mm	3,180	600	2,650	430	1,590	290	1,060	160	3,450	610
14mm	2,730	600	2,270	430	1,370	290	910	160	2,960	610
16mm	2,390	490	1,990	380	1,190	260	800	140	2,590	530
18mm	2,120	490	1,770	380	1,060	260	710	140	2,300	530
20mm	1,910	390	1,590	300	960	210	640	110	2,070	420
備註 Remarks	※ 未鍍膜鑽頭，請依照上表，減少30%左右轉速和進給量。 Uncoated Drills Reduce 30% RPM & FEED From Coating One.									

※ 切削公式 Cutting Formula : S(主軸轉速) = Vc(切削速度) × 1000 / D(外徑) / π (3.14) F(進給速度) = f(每轉進給量) × S(主軸轉速)

Table 53

CDHF 鎢鋼標準型高速鑽頭- 2刃(5倍長)(鍍膜) 切削條件表

SOLID CARBIDE DRILLS- DRILLING CONDITION TABLE

加工材質 Material	碳素鋼 Carbon Steels		合金鋼 Alloy Steels		合金鋼 Alloy Steels		不銹鋼 Stainless Steels		鑄鐵 Cast Iron	
工件料號 Material Code	S35C,S45C,S50C		SCM,SKT,SKD		SCM,SKT,SKD		SUS304		GG40	
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		—		HRC<30	
切削速度 Vc	120m/min		100m/min		60m/min		40m/min		130m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
3mm	12,740	930	10,620	690	6,370	470	4,250	260	13,800	970
4mm	9,550	930	7,960	690	4,780	470	3,180	260	10,350	970
5mm	7,640	700	6,370	520	3,820	350	2,550	200	8,280	730
6mm	6,370	700	5,310	520	3,190	350	2,120	200	6,900	730
8mm	4,780	660	3,980	490	2,390	320	1,590	180	5,180	680
10mm	3,820	580	3,180	430	1,910	280	1,270	160	4,140	610
12mm	3,180	530	2,650	390	1,590	270	1,060	150	3,450	550
14mm	2,730	530	2,270	390	1,370	270	910	150	2,960	550
16mm	2,390	450	1,990	350	1,190	240	800	130	2,590	470
18mm	2,120	450	1,770	350	1,060	240	710	130	2,300	470
20mm	1,910	360	1,590	280	960	190	640	100	2,070	380
備註 Remarks	※ 未鍍膜鑽頭，請依照上表，減少30%左右轉速和進給量。 Uncoated Drills Reduce 30% RPM & FEED From Coating One.									

※ 切削公式 Cutting Formula : S(主軸轉速) = Vc(切削速度) × 1000 / D(外徑) / π (3.14) F(進給速度) = f(每轉進給量) × S(主軸轉速)

- 當加工聲音尖銳時，請調降主軸轉速(S) (10~40%)。 When the sound is piercing, please lower the spindle speed(S) (10~40%).
- 當機台震動太大時，請調降進給速度(F) (10~40%)。 When the machine is vibrating, please decrease the feed rate(F) (10~40%).
- 當主軸負載太大時，請調降進給速度(F) (10~40%)。 When the spindle load is high, please decrease the feed rate(F) (10~40%).
- 以上數據為建議值，適當的條件仍需視機台狀況，夾治具品質，潤滑冷卻系統...等而改變。
These are recommended values which depend on the condition of the machine, fixture, lubricating & cooling systems... etc. They may have to be adapted.

Table 54

CDHC 鎢鋼短刃內冷型高速鑽頭-2刃(3倍長)(鍍膜) 切削條件表

SOLID CARBIDE DRILLS- DRILLING CONDITION TABLE

加工材質 Material	碳素鋼 Carbon Steels		合金鋼 Alloy Steels		合金鋼 Alloy Steels		不銹鋼 Stainless Steels		鑄鐵 Cast Iron	
工件料號 Material Code	S35C,S45C,S50C		SCM,SKT,SKD		SCM,SKT,SKD		SUS304		FC,FCD	
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		—		HRC<30	
切削速度 Vc	150m/min		135m/min		70m/min		60m/min		160m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
4mm	11,940	1,130	10,750	860	5,570	570	4,780	320	12,740	1,180
5mm	9,550	860	8,600	640	4,460	430	3,820	240	10,190	890
6mm	7,960	860	7,170	640	3,720	430	3,180	240	8,490	890
8mm	5,970	790	5,370	590	2,790	400	2,390	220	6,370	830
10mm	4,780	710	4,300	530	2,230	360	1,910	200	5,100	740
12mm	3,980	660	3,580	490	1,860	330	1,590	180	4,250	740
14mm	3,410	660	3,070	490	1,590	330	1,360	180	3,640	660
16mm	2,990	560	2,690	420	1,390	280	1,190	160	3,180	570
18mm	2,650	560	2,390	420	1,240	280	1,060	160	2,830	570
20mm	2,390	450	2,150	340	1,120	220	960	130	2,550	460
備註 Remarks	※ 未鍍膜鑽頭，請依照上表，減少30%左右轉速和進給量。 Uncoated Drills Reduce 30% RPM & FEED From Coating One.									

※ 切削公式 Cutting Formula : S(主軸轉速) = Vc(切削速度) × 1000 / D(外徑) / π (3.14) F(進給速度) = f(每轉進給量) × S(主軸轉速)

Table 55

CDHCF 鎢鋼標準內冷型高速鑽頭-2刃(5倍長)(鍍膜) 切削條件表

SOLID CARBIDE DRILLS- DRILLING CONDITION TABLE

加工材質 Material	碳素鋼 Carbon Steels		合金鋼 Alloy Steels		合金鋼 Alloy Steels		不銹鋼 Stainless Steels		鑄鐵 Cast Iron	
工件料號 Material Code	S35C,S45C,S50C		SCM,SKT,SKD		SCM,SKT,SKD		SUS304		FC,FCD	
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		—		HRC<30	
切削速度 Vc	150m/min		135m/min		70m/min		60m/min		160m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
4mm	11,940	1,020	10,750	770	5,570	510	4,780	280	12,740	1,060
5mm	9,550	770	8,600	570	4,460	380	3,820	210	10,190	800
6mm	7,960	770	7,170	570	3,720	380	3,180	210	8,490	800
8mm	5,970	720	5,370	540	2,790	350	2,390	200	6,370	740
10mm	4,780	640	4,300	490	2,230	320	1,910	180	5,100	660
12mm	3,980	570	3,580	430	1,860	290	1,590	160	4,250	610
14mm	3,410	570	3,070	430	1,590	290	1,360	160	3,640	610
16mm	2,990	490	2,690	380	1,390	260	1,190	140	3,180	530
18mm	2,650	490	2,390	380	1,240	260	1,060	140	2,830	530
20mm	2,390	390	2,150	300	1,120	210	960	110	2,550	420
備註 Remarks	※ 未鍍膜鑽頭，請依照上表，減少30%左右轉速和進給量。 Uncoated Drills Reduce 30% RPM & FEED From Coating One.									

※ 切削公式 Cutting Formula : S(主軸轉速) = Vc(切削速度) × 1000 / D(外徑) / π (3.14) F(進給速度) = f(每轉進給量) × S(主軸轉速)

1. 當加工聲音尖銳時，請調降主軸轉速(S) (10~40%)。 When the sound is piercing, please lower the spindle speed(S) (10~40%).
2. 當機台震動太大時，請調降進給速度(F) (10~40%)。 When the machine is vibrating, please decrease the feed rate(F) (10~40%).
3. 當主軸負載太大時，請調降進給速度(F) (10~40%)。 When the spindle load is high, please decrease the feed rate(F) (10~40%).
4. 以上數據為建議值，適當的條件仍需視機台狀況，夾治具品質，潤滑冷卻系統...等而改變。
These are recommended values which depend on the condition of the machine, fixture, lubricating & cooling systems... etc. They may have to be adapted.

Table 56

CDHCS 鎢鋼長刃內冷型高速鑽頭-2刃(7倍長)(鍍膜) 切削條件表

SOLID CARBIDE DRILLS- DRILLING CONDITION TABLE

加工材質 Material	碳素鋼 Carbon Steels		合金鋼 Alloy Steels		合金鋼 Alloy Steels		不銹鋼 Stainless Steels		鑄鐵 Cast Iron	
工件料號 Material Code	S35C,S45C,S50C		SCM,SKT,SKD		SCM,SKT,SKD		SUS304		FC,FCD	
硬度 Hardness	HRC<20		HRC20~30		HRC30~45		—		HRC<30	
切削速度 Vc	120m/min		85m/min		50m/min		40m/min		130m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
3mm	12,700	910	10,600	680	5,310	450	4,200	250	13,800	950
4mm	9,500	910	8,000	680	3,980	450	3,100	250	10,300	950
5mm	7,600	690	6,400	510	3,190	340	2,500	190	8,200	710
6mm	6,400	690	5,300	510	2,650	340	2,100	190	6,900	710
8mm	4,800	640	4,000	470	1,990	320	1,600	180	5,100	670
10mm	3,800	560	3,200	430	1,590	280	1,300	160	4,100	590
12mm	3,200	510	2,600	390	1,330	270	1,000	150	3,500	530
14mm	2,700	510	2,300	390	1,140	270	910	150	3,000	530
16mm	2,400	450	2,000	330	995	210	700	120	2,300	470
18mm	2,100	450	1,800	330	890	210	700	120	2,300	470
20mm	1,900	360	1,600	260	800	170	650	100	2,000	380
備註 Remarks	※ 未鍍膜鑽頭，請依照上表，減少30%左右轉速和進給量。 Uncoated Drills Reduce 30% RPM & FEED From Coating One.									

※ 切削公式 Cutting Formula : S(主軸轉速) = Vc(切削速度) × 1000 / D(外徑) / π (3.14) F(進給速度) = f(每轉進給量) × S(主軸轉速)

Table 57

鎢鋼銅鋁用直刃鑽鉸刀(白刀) 切削條件表

SOLID CARBIDE DRILLS- DRILLING CONDITION TABLE

加工材質 Material	鑄鐵 Cast Iron		青銅 Bronze		鋁合金 Aluminum Alloys	
工件料號 Material Code	FC,FCD		—		Al 5052 / 6061 / 7075	
硬度 Hardness	HRC<30		HRC≤25		—	
切削速度 Vc	120m/min		80m/min		140m/min	
外徑 Diameter	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)	S (rpm)	F (mm/min)
5mm	7,640	960	5,100	410	8,920	1,430
6mm	6,370	800	4,250	340	7,430	1,190
8mm	4,780	600	3,190	260	5,570	890
10mm	3,820	480	2,550	200	4,460	710
12mm	3,190	400	2,120	170	3,720	600
16mm	2,390	300	1,590	130	2,790	450
20mm	1,910	240	1,270	100	2,230	360
備註 Remarks						

※ 切削公式 Cutting Formula : S(主軸轉速) = Vc(切削速度) × 1000 / D(外徑) / π (3.14) F(進給速度) = f(每轉進給量) × S(主軸轉速)

- 當加工聲音尖銳時，請調降主軸轉速(S) (10~40%)。When the sound is piercing, please lower the spindle speed(S) (10~40%).
- 當機台震動太大時，請調降進給速度(F) (10~40%)。When the machine is vibrating, please decrease the feed rate(F) (10~40%).
- 當主軸負載太大時，請調降進給速度(F) (10~40%)。When the spindle load is high, please decrease the feed rate(F) (10~40%).
- 以上數據為建議值，適當的條件仍需視機台狀況，夾治具品質，潤滑冷卻系統...等而改變。

These are recommended values which depend on the condition of the machine, fixture, lubricating & cooling systems... etc. They may have to be adapted.