

## スラスタードリル20Dタイプ

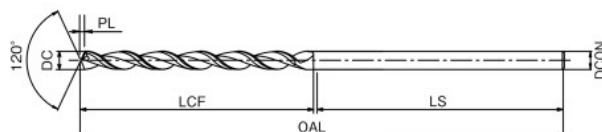
TDXL DRILL 20D TYPE

TDXL

切削条件 Cutting Conditions P.432

ハイスドリルで20Dまでの超深穴加工を実現しました。

HSS drills can achieve 20 × D



注1) 2012年6月生産分より先端コーティングに順次切替生産となります。

Start manufacturing with WXL Coating of tip from June 2012.

## 20D用 For 20D operation

| ツールNo.<br>EDP No. | 直径<br>DC  | 溝長<br>LCF | 全長<br>OAL | シャンク径<br>DCON | シャンク長<br>LS | 先端<br>PL | 在庫<br>Stock | 重量<br>(g) | 標準価格<br>(Yen) |
|-------------------|-----------|-----------|-----------|---------------|-------------|----------|-------------|-----------|---------------|
| 8623216           | 1.5 × 20D | 38        | 85        | 1.47          | 47          | 0.4      | —           | —         | —             |
| 8623217           | 1.6 × 20D | 40        | 85        | 1.57          | 47          | 0.5      | B           | 4         | 3,320         |
| 8623218           | 1.7 × 20D | 42        | 85        | 1.67          | 45          | 0.5      | —           | —         | —             |
| 8623219           | 1.8 × 20D | 44        | 85        | 1.77          | 43          | 0.5      | B           | 4         | 3,320         |
| 8623220           | 1.9 × 20D | 46        | 85        | 1.87          | 41          | 0.5      | —           | —         | —             |
| 8623221           | 2 × 20D   | 48        | 85        | 2             | 39          | 0.6      | ●           | 4         | 3,180         |
| 8623222           | 2.1 × 20D | 50        | 85        | 2.1           | 40          | 0.6      | ●           | 5         | 3,860         |
| 8623223           | 2.2 × 20D | 52        | 85        | 2.2           | 38          | 0.6      | ●           | 5         | 3,860         |
| 8623224           | 2.3 × 20D | 54        | 85        | 2.3           | 41          | 0.7      | ●           | 5         | 3,860         |
| 8623225           | 2.4 × 20D | 56        | 85        | 2.4           | 39          | 0.7      | ●           | 5         | 3,860         |
| 8623226           | 2.5 × 20D | 58        | 85        | 2.5           | 42          | 0.7      | ●           | 5         | 3,640         |
| 8623227           | 2.6 × 20D | 60        | 85        | 2.6           | 50          | 0.8      | ●           | 6         | 3,860         |
| 8623228           | 2.7 × 20D | 62        | 85        | 2.7           | 51          | 0.8      | ●           | 8         | 4,380         |
| 8623229           | 2.8 × 20D | 64        | 85        | 2.8           | 49          | 0.8      | ●           | 8         | 4,380         |
| 8623230           | 2.9 × 20D | 66        | 85        | 2.9           | 52          | 0.8      | ●           | 9         | 4,380         |
| 8623231           | 3 × 20D   | 68        | 85        | 3             | 50          | 0.9      | ●           | 9         | 4,120         |
| 8623232           | 3.1 × 20D | 70        | 85        | 3.1           | 53          | 0.9      | ●           | 10        | 4,920         |
| 8623233           | 3.2 × 20D | 72        | 85        | 3.2           | 51          | 0.9      | ●           | 10        | 4,920         |
| 8623234           | 3.3 × 20D | 74        | 85        | 3.3           | 49          | 1        | ●           | 10        | 4,920         |
| 8623235           | 3.4 × 20D | 76        | 85        | 3.4           | 50          | 1        | ●           | 12        | 5,670         |
| 8623236           | 3.5 × 20D | 78        | 85        | 3.5           | 48          | 1        | ●           | 13        | 4,660         |
| 8623237           | 3.6 × 20D | 80        | 85        | 3.6           | 46          | 1        | —           | —         | —             |
| 8623238           | 3.7 × 20D | 82        | 85        | 3.7           | 49          | 1.1      | B           | 11        | 4,930         |
| 8623239           | 3.8 × 20D | 84        | 85        | 3.8           | 52          | 1.1      | ●           | 12        | 5,610         |
| 8623240           | 3.9 × 20D | 86        | 85        | 3.9           | 50          | 1.1      | —           | —         | —             |
| 8623241           | 4 × 20D   | 88        | 85        | 4             | 48          | 1.2      | ●           | 12        | 5,320         |
| 8623242           | 4.1 × 20D | 90        | 85        | 4.1           | 59          | 1.2      | ●           | 14        | 6,710         |
| 8623243           | 4.2 × 20D | 92        | 85        | 4.2           | 57          | 1.2      | ●           | 14        | 5,610         |
| 8623244           | 4.3 × 20D | 94        | 85        | 4.3           | 60          | 1.2      | ●           | 15        | 6,320         |
| 8623245           | 4.4 × 20D | 96        | 85        | 4.4           | 58          | 1.3      | —           | —         | —             |
| 8623246           | 4.5 × 20D | 98        | 85        | 4.5           | 61          | 1.3      | B           | 17        | 6,050         |
| 8623247           | 4.6 × 20D | 100       | 85        | 4.6           | 59          | 1.3      | ●           | 18        | 7,270         |
| 8623248           | 4.7 × 20D | 102       | 85        | 4.7           | 57          | 1.4      | —           | —         | —             |
| 8623249           | 4.8 × 20D | 104       | 85        | 4.8           | 58          | 1.4      | B           | 19        | 7,270         |
| 8623250           | 4.9 × 20D | 106       | 85        | 4.9           | 56          | 1.4      | —           | —         | —             |

単位:mm Unit:mm

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|-------------------|-----------|-----------|-----------|---------------|-------------|----------|-------------|-----------|---------------|
| 8623250           | 5 × 20D   | 116       | 175       | 5             | 59          | 1.4      | ●           | 24        | 6,900         |
| 8623251           | 5.1 × 20D | 118       | 175       | 5.1           | 62          | 1.5      | B           | 25        | 7,320         |
| 8623252           | 5.2 × 20D | 120       | 175       | 5.2           | 60          | 1.5      | ●           | 25        | 7,320         |
| 8623253           | 5.3 × 20D | 122       | 175       | 5.3           | 58          | 1.5      | —           | —         | —             |
| 8623254           | 5.4 × 20D | 124       | 175       | 5.4           | 56          | 1.6      | —           | —         | —             |
| 8623255           | 5.5 × 20D | 128       | 175       | 5.5           | 57          | 1.6      | B           | 28        | 7,780         |
| 8623256           | 5.6 × 20D | 130       | 175       | 5.6           | 55          | 1.6      | —           | —         | —             |
| 8623257           | 5.7 × 20D | 132       | 175       | 5.7           | 58          | 1.6      | ●           | 30        | 10,300        |
| 8623258           | 5.8 × 20D | 134       | 175       | 5.8           | 66          | 1.7      | B           | 32        | 10,300        |
| 8623259           | 5.9 × 20D | 136       | 175       | 5.9           | 64          | 1.7      | —           | —         | —             |
| 8623260           | 6 × 20D   | 138       | 175       | 6             | 62          | 1.7      | B           | 34        | 8,880         |
| 8623261           | 6.1 × 20D | 140       | 175       | 6.1           | 60          | 1.8      | —           | —         | —             |
| 8623262           | 6.2 × 20D | 144       | 175       | 6.2           | 56          | 1.8      | —           | —         | —             |
| 8623263           | 6.3 × 20D | 146       | 175       | 6.3           | 54          | 1.8      | B           | 39        | 14,800        |
| 8623264           | 6.4 × 20D | 148       | 175       | 6.4           | 52          | 1.8      | —           | —         | —             |
| 8623265           | 6.5 × 20D | 150       | 175       | 6.5           | 75          | 1.9      | B           | 47        | 10,300        |
| 8623266           | 6.6 × 20D | 152       | 175       | 6.6           | 73          | 1.9      | —           | —         | —             |
| 8623267           | 6.7 × 20D | 154       | 175       | 6.7           | 71          | 1.9      | —           | —         | —             |
| 8623268           | 6.8 × 20D | 158       | 175       | 6.8           | 67          | 2        | ●           | 50        | 12,400        |
| 8623269           | 6.9 × 20D | 160       | 175       | 6.9           | 70          | 2        | B           | 52        | 12,400        |
| 8623270           | 7 × 20D   | 162       | 175       | 7             | 68          | 2        | ●           | 53        | 11,700        |
| 8623271           | 7.1 × 20D | 164       | 175       | 7.1           | 66          | 2        | —           | —         | —             |
| 8623272           | 7.2 × 20D | 166       | 175       | 7.2           | 69          | 2.1      | —           | —         | —             |
| 8623273           | 7.3 × 20D | 168       | 175       | 7.3           | 67          | 2.1      | —           | —         | —             |
| 8623274           | 7.4 × 20D | 172       | 175       | 7.4           | 63          | 2.1      | —           | —         | —             |
| 8623275           | 7.5 × 20D | 174       | 175       | 7.5           | 71          | 2.2      | B           | 63        | 13,300        |
| 8623276           | 7.6 × 20D | 176       | 175       | 7.6           | 69          | 2.2      | —           | —         | —             |
| 8623277           | 7.7 × 20D | 178       | 175       | 7.7           | 67          | 2.2      | —           | —         | —             |
| 8623278           | 7.8 × 20D | 180       | 175       | 7.8           | 65          | 2.3      | —           | —         | —             |
| 8623279           | 7.9 × 20D | 182       | 175       | 7.9           | 63          | 2.3      | —           | —         | —             |
| 8623280           | 8 × 20D   | 184       | 175       | 8             | 71          | 2.3      | ●           | 74        | 15,100        |
| 8623281           | 8.1 × 20D | 188       | 175       | 8.1           | 67          | 2.3      | B           | 75        | 18,800        |
| 8623282           | 8.2 × 20D | 190       | 175       | 8.2           | 70          | 2.4      | ●           | 79        | 18,800        |
| 8623283           | 8.3 × 20D | 192       | 175       | 8.3           | 68          | 2.4      | —           | —         | —             |
| 8623284           | 8.4 × 20D | 194       | 175       | 8.4           | 66          | 2.4      | —           | —         | —             |

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直径 DC 8.5 ~ 12 NEXT

製品検索サイトから見積依頼書・注文書を作成できます ▶▶▶ P.6

| 被削材<br>Work Material | 低炭素鋼<br>軟鋼<br>Low Carbon Steel<br>Mild Steel | 中炭素鋼<br>Medium Carbon Steel | 高炭素鋼<br>High Carbon Steel | 合金鋼<br>Alloy Steel | 調質鋼<br>Hardened Steel | 焼入鋼<br>Quenched and Tempered Steel | ステンレス鋼<br>Stainless Steel | 工具鋼<br>Tool Steel | 鋳鉄<br>Cast Iron | ダクタイル鋳鉄<br>Ductile Cast Iron | 銅合金<br>Copper Alloy | アルミ展伸材<br>Aluminum | アルミ合金鋳物<br>Aluminum Alloy Casting | チタン合金<br>Titanium Alloy | インコネル<br>Inconel | 複合材料<br>Composite Material | マグネシウム合金<br>(MMC)<br>Magnesium Alloy | 金属基複合材料<br>(MMC)<br>Metal Matrix Composites |
|----------------------|----------------------------------------------|-----------------------------|---------------------------|--------------------|-----------------------|------------------------------------|---------------------------|-------------------|-----------------|------------------------------|---------------------|--------------------|-----------------------------------|-------------------------|------------------|----------------------------|--------------------------------------|---------------------------------------------|
| 製品記号<br>Abbreviation | C~0.25%                                      | 0.25~0.45%                  | 0.45%~                    | SCM                | ~35 HRC               | 35~45 HRC                          | 45~50 HRC                 | 50~62 HRC         | 62~70 HRC       | SUS                          | SKD SKS             | FC                 | FCD                               | Cu                      | AL               | AC                         | CFRP                                 | AZ91D                                       |
| TDXL                 | ○                                            | ○                           | ○                         | ○                  |                       |                                    |                           |                   |                 |                              | ○                   | ○                  | ○                                 |                         |                  |                            | ○                                    |                                             |

在庫記号について Inventory symbols

● = 標準在庫品 Standard stock item  
○ = 準標準在庫品 (在庫をご確認下さい。) Limited standard stock item

□ = 特定代理店在庫品 Stocked by specific distributors. Contact us for price & availability.

▲ = 新製品及び後継品へ切り替え生産 (在庫をご確認下さい。)  
Scheduled to be replaced by new product or successor item

△ = 生産中止品 (在庫をご確認下さい。)  
Discontinued item

■ アイコンの説明はP.1をご覧ください。 See p.1 for explanation of icons.