

## D425TX-2 超微粒鎢鋼塗層平頭鑽

## Flat Bottom Drills

MG  
CarbideAlTiSiN  
TX

## Work Material

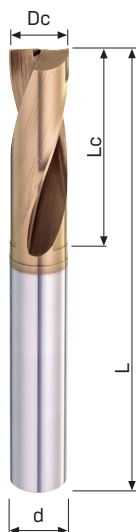
P	H	M	K	N	S
●	●	○	●	○	○

P 鋼鐵  
SteelH 硬化鋼 <38HRC  
Hardened SteelH 硬化鋼 <48HRC  
Hardened SteelM 不銹鋼  
Stainless SteelK 鑄鐵  
Cast IronS 鈦合金  
TitaniumS 鎳  
NickelS 高溫合金  
High Temp Alloys

## Feature of product:

鑽尖0°設計可避免在非平面鑽孔時  
偏移或歪斜，可利用於沉頭孔、斜  
面、曲面...等非平面鑽孔加工。

搭配AlTiSiN塗層提升刀具整體壽命  
，提升加工效能以及刀具使用效率。



Dc h7	Lc mm	L mm	d h6	AlTiSiN D425TX-2
1	3	50	3	●
1.1	4	50	3	●
1.2	4	50	3	●
1.3	4	50	3	●
1.4	5	50	3	●
1.5	5	50	3	●
1.6	5	50	3	●
1.7	6	50	3	●
1.8	6	50	3	●
1.9	7	50	3	●
2	7	50	4	●
2.1	8	50	4	●
2.2	8	50	4	●
2.3	8	50	4	●
2.4	9	50	4	●
2.5	9	50	4	●
2.6	9	50	4	●
2.7	10	50	4	●
2.8	10	50	4	●
2.9	11	50	4	●
3	11	50	6	●
3.1	12	50	6	●
3.2	12	50	6	●
3.3	12	50	6	●
3.4	13	50	6	●
3.5	13	50	6	●
3.6	13	50	6	●
3.7	14	50	6	●
3.8	14	50	6	●
3.9	14	50	6	●
4	14	50	6	●
4.1	15	60	6	●
4.2	15	60	6	●
4.3	15	60	6	●
4.4	16	60	6	●
4.5	16	60	6	●
4.6	16	60	6	●
4.7	18	60	6	●
4.8	18	60	6	●
4.9	18	60	6	●
5	18	60	6	●
5.1	19	60	6	●
5.2	19	60	6	●
5.3	19	60	6	●
5.4	20	60	6	●
5.5	20	60	6	●
5.6	20	60	6	●
5.7	21	60	6	●
5.8	21	60	6	●
5.9	21	60	6	●
6	21	60	6	●
6.1	22	70	6	●
6.2	22	70	6	●
6.3	22	70	6	●
6.4	23	70	6	●
6.5	23	70	6	●
6.6	23	70	6	●
6.7	24	70	6	●
6.8	24	70	6	●
6.9	24	70	6	●

Code No. D425TX-2-Dc

Dc h7	Lc mm	L mm	d h6	AlTiSiN D425TX-2
7	24	70	6	●
7.1	26	70	6	●
7.2	26	70	6	●
7.3	26	70	6	●
7.4	27	70	6	●
7.5	27	70	6	●
7.6	27	70	6	●
7.7	28	70	6	●
7.8	28	70	6	●
7.9	28	70	6	●
8	28	70	8	●
8.1	29	80	8	●
8.2	29	80	8	●
8.3	29	80	8	●
8.4	30	80	8	●
8.5	30	80	8	●
8.6	30	80	8	●
8.7	32	80	8	●
8.8	32	80	8	●
8.9	32	80	8	●
9	32	80	8	●
9.1	33	80	8	●
9.2	33	80	8	●
9.3	33	80	8	●
9.4	34	80	8	●
9.5	34	80	8	●
9.6	34	80	8	●
9.7	35	80	8	●
9.8	35	80	8	●
9.9	35	80	8	●
10	35	80	10	●
10.1	36	90	10	●
10.2	36	90	10	●
10.3	36	90	10	●
10.4	37	90	10	●
10.5	37	90	10	●
10.6	37	90	10	●
10.7	38	90	10	●
10.8	38	90	10	●
10.9	38	90	10	●
11	38	90	10	●
11.1	40	90	10	●
11.2	40	90	10	●
11.3	40	90	10	●
11.4	41	90	10	●
11.5	41	90	10	●
11.6	41	90	10	●
11.7	42	90	10	●
11.8	42	90	10	●
11.9	42	90	10	●
12	42	90	12	●
12.5	44	100	12	●
13	45	100	12	●
13.5	48	100	12	○
14	49	105	12	○
14.5	51	105	12	○
15	52	105	12	○
15.5	55	115	12	○
16	56	115	16	○

※ Mark: ○, On request, no stock

※ 記號○, 可訂購規格, 無現貨

## D425TX-2 切削條件參考表

## Recommended Milling Conditions

## Borehole parameters 鑽孔參數

被削材 Work Material		GR.1 碳鋼 Carbon Steel		GR.2 低合金鋼 Low-alloyed Steel (~24HRC)		GR.3 高合金鋼 Hi-alloyed Steel (~30HRC)		GR.8 不銹鋼 Stainless Steel		GR.9 鑄鐵 Cast Iron		GR.12 鋁合金 Aluminium	
切削速度 Vc m/min		55~70		55~70		55~70		25~30		55~70		100~110	
型號 Code No.	刃徑 Dc	RPM 迴轉速度 (min-l)	Feed 進給速度 (mm/rev)	RPM 迴轉速度 (min-l)	Feed 進給速度 (mm/rev)	RPM 迴轉速度 (min-l)	Feed 進給速度 (mm/rev)	RPM 迴轉速度 (min-l)	Feed 進給速度 (mm/rev)	RPM 迴轉速度 (min-l)	Feed 進給速度 (mm/rev)	RPM 迴轉速度 (min-l)	Feed 進給速度 (mm/rev)
D425TX-2-1	1	18,000	450	14,300	358	12,700	318	7,900	55	18,000	450	31,800	636
D425TX-2-1.5	1.5	13,500	473	10,000	350	8,400	294	5,300	53	13,500	473	21,200	424
D425TX-2-2	2	9,500	380	7,900	316	6,700	268	4,700	71	9,500	380	17,500	875
D425TX-2-2.5	2.5	7,900	395	6,600	330	5,700	285	3,800	57	7,900	395	14,000	840
D425TX-2-3	3	7,900	474	7,900	474	6,800	408	3,100	186	7,900	474	11,600	696
D425TX-2-4	4	5,900	472	5,900	472	5,100	408	2,300	184	5,900	472	8,700	696
D425TX-2-5	5	4,700	470	4,700	470	4,100	410	1,900	190	4,700	470	7,000	700
D425TX-2-6	6	3,900	507	3,900	507	3,400	442	1,500	195	3,900	507	5,800	754
D425TX-2-7	7	3,400	476	3,400	476	3,000	420	1,300	182	3,400	476	5,100	740
D425TX-2-8	8	2,900	435	2,900	435	2,500	375	1,100	165	2,900	435	4,300	688
D425TX-2-9	9	2,600	416	2,600	416	2,250	360	1,000	160	2,600	416	3,900	780
D425TX-2-10	10	2,300	391	2,300	391	2,000	340	950	162	2,300	391	3,500	700
D425TX-2-11	11	2,100	378	2,100	378	1,800	324	850	153	2,100	378	3,100	682
D425TX-2-12	12	1,900	380	1,900	380	1,700	340	790	158	1,900	380	2,900	696
D425TX-2-13	13	1,800	360	1,800	360	1,600	320	740	148	1,800	360	2,700	675
D425TX-2-14	14	1,650	363	1,650	363	1,500	330	690	152	1,650	363	2,500	650
D425TX-2-15	15	1,500	345	1,500	345	1,400	322	640	147	1,500	345	2,300	621
D425TX-2-16	16	1,400	350	1,400	350	1,200	300	590	148	1,400	350	2,100	588
切入深度 (mm)		ap:2.0D		ap:2.0D		ap:2.0D		ap:2.0D		ap:2.0D		ap:2.0	

1. Please work with good rigidity / high precision facilities and collet chuck.
2. Please choose proper cutting fluid.
3. The cutting data is reference value only. Please adjust it according to your real working conditions.
4. If RPM is lower the reference value, the Feed rate (fz) and RPM should be reduced by the same proportion.
5. If vibration occurs during cutting, please reduce cutting parameter.

1. 請使用剛性好、精度高的設備和夾具。
2. 請選擇適用於工件材料的切削液。
3. 此切削條件表中的數值為切削條件的基準值，實際加工時，請考慮加工形狀、目的、使用機台等因素，對切削條件進行調整。
4. 如果機台轉速低於表中所列數值，則進給速度應與轉速按同一比例降低。
5. 切削加工時如果發生振顫，請降低切削條件。