

D42ITX 超微粒鎢鋼塗層高速鑽頭

High Performance Drills

Code No. D42ITX-Dc

MG
Carbide

AlTiSiN
TX



Work Material

P	H	M	K	N	S
●	●	○	●	○	○

P 鋼鐵
Steel

H 硬化鋼 <38HRC
Hardened Steel

H 硬化鋼 <48HRC
Hardened Steel

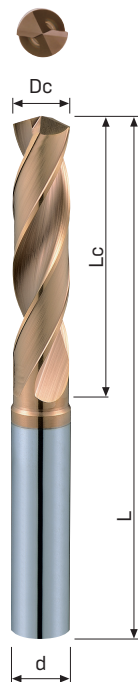
M 不銹鋼
Stainless Steel

K 鑄鐵
Cast Iron

S 鈦合金
Titanium

S 鎳
Nickel

S 高溫合金
High Temp Alloys



Dc h7	Lc mm	L mm	d h6	AlTiSiN D42ITX	Dc h7	Lc mm	L mm	d h6	AlTiSiN D42ITX
1	6	50	3	●	7	34	79	7	●
1.1	6	50	3	●	7.1	41	79	8	●
1.2	6	50	3	●	7.2	41	79	8	●
1.3	6	50	3	●	7.3	41	79	8	●
1.4	6	50	3	●	7.4	41	79	8	●
1.5	6	50	3	●	7.5	41	79	8	●
1.6	8	50	3	●	7.6	41	79	8	●
1.7	8	50	3	●	7.7	41	79	8	●
1.8	8	50	3	●	7.8	41	79	8	●
1.9	8	50	3	●	7.9	41	79	8	●
2	8	50	3	●	8	41	79	8	●
2.1	10	62	3	●	8.1	47	89	9	●
2.2	10	62	3	●	8.2	47	89	9	●
2.3	10	62	3	●	8.3	47	89	9	●
2.4	10	62	3	●	8.4	47	89	9	●
2.5	10	62	3	●	8.5	47	89	9	●
2.6	13	62	3	●	8.6	47	89	9	●
2.7	13	62	3	●	8.7	47	89	9	●
2.8	13	62	3	●	8.8	47	89	9	●
2.9	13	62	3	●	8.9	47	89	9	●
3	13	62	3	●	9	47	89	9	●
3.1	19	66	4	●	9.1	47	89	10	●
3.2	19	66	4	●	9.2	47	89	10	●
3.3	19	66	4	●	9.3	47	89	10	●
3.4	19	66	4	●	9.4	47	89	10	●
3.5	19	66	4	●	9.5	47	89	10	●
3.6	21	66	4	●	9.6	47	89	10	●
3.7	21	66	4	●	9.7	47	89	10	●
3.8	21	66	4	●	9.8	47	89	10	●
3.9	21	66	4	●	9.9	47	89	10	●
4	21	66	4	●	10	47	89	10	●
4.1	23	66	5	●	10.1	55	102	11	●
4.2	23	66	5	●	10.2	55	102	11	●
4.3	23	66	5	●	10.3	55	102	11	●
4.4	23	66	5	●	10.4	55	102	11	●
4.5	23	66	5	●	10.5	55	102	11	●
4.6	25	66	5	●	10.6	55	102	11	●
4.7	25	66	5	●	10.7	55	102	11	●
4.8	25	66	5	●	10.8	55	102	11	●
4.9	25	66	5	●	10.9	55	102	11	●
5	25	66	5	●	11	55	102	11	●
5.1	28	66	6	●	11.1	55	102	12	●
5.2	28	66	6	●	11.2	55	102	12	●
5.3	28	66	6	●	11.3	55	102	12	●
5.4	28	66	6	●	11.4	55	102	12	●
5.5	28	66	6	●	11.5	55	102	12	●
5.6	28	66	6	●	11.6	55	102	12	●
5.7	28	66	6	●	11.7	55	102	12	●
5.8	28	66	6	●	11.8	55	102	12	●
5.9	28	66	6	●	11.9	55	102	12	●
6	28	66	6	●	12	55	102	12	●
6.1	34	79	7	●	12.5	60	107	13	●
6.2	34	79	7	●	13	60	107	13	●
6.3	34	79	7	●	13.5	60	107	14	●
6.4	34	79	7	●	14	60	107	14	●
6.5	34	79	7	●	14.5	65	115	15	●
6.6	34	79	7	●	15	65	115	15	●
6.7	34	79	7	●	15.5	65	115	16	●
6.8	34	79	7	●	16	65	115	16	●
6.9	34	79	7	●					

Feature of product:

JIS 3XD鑽頭

具有減少軸向力的140° S型鑽尖設計。

高排屑的溝槽形狀設計。

採用奈米多層膜塗層具有優異的潤滑及耐磨性。

適用切削HRC48以下的各種鋼材、鑄鐵...等材料鑽孔應用。

適合3倍Dc鑽孔深度。

D421TX 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.4 硬化鋼 Hardened Steel (30~38HRC)		GR.5 硬化鋼 Hardened Steel (38~48HRC)		GR.9 鑄鐵 Cast Iron	
切削速度 Vc m/min		60~100		60~100		60~100		40~65		30~45		60~100	
型號 Code No.	刃徑 Dc	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/rev)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/rev)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/rev)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/rev)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/rev)	RPM 迴轉速度 (min-1)	Feed 進給速度 (mm/rev)
D421TX-1	1	19,000	0.03	19,000	0.03	19,000	0.03	12,000	0.02	10,000	0.02	19,000	0.03
D421TX-1.5	1.5	15,000	0.04	15,000	0.04	15,000	0.04	9,800	0.04	8,000	0.04	15,000	0.04
D421TX-2	2	11,000	0.06	11,000	0.06	11,000	0.06	7,600	0.06	6,000	0.06	11,000	0.06
D421TX-2.5	2.5	9,500	0.07	9,500	0.07	9,500	0.07	6,300	0.07	5,000	0.07	9,500	0.07
D421TX-3	3	8,000	0.09	8,000	0.09	8,000	0.09	5,000	0.09	4,000	0.09	8,000	0.09
D421TX-3.5	3.5	7,100	0.09	7,100	0.09	7,100	0.09	4,400	0.09	3,900	0.09	7,100	0.09
D421TX-4	4	6,300	0.10	6,300	0.10	6,300	0.10	3,800	0.10	3,800	0.10	6,300	0.10
D421TX-4.5	4.5	5,600	0.11	5,600	0.11	5,600	0.11	3,400	0.11	3,400	0.11	5,600	0.11
D421TX-5	5	5,000	0.12	5,000	0.12	5,000	0.12	3,000	0.12	3,000	0.12	5,000	0.12
D421TX-5.5	5.5	4,600	0.13	4,600	0.13	4,600	0.13	2,800	0.13	2,800	0.13	4,600	0.13
D421TX-6	6	4,200	0.14	4,200	0.14	4,200	0.14	2,600	0.14	2,600	0.14	4,200	0.14
D421TX-6.5	6.5	3,950	0.14	3,950	0.14	3,950	0.14	2,400	0.14	2,400	0.14	3,950	0.14
D421TX-7	7	3,700	0.15	3,700	0.15	3,700	0.15	2,250	0.15	2,250	0.15	3,700	0.15
D421TX-7.5	7.5	3,450	0.15	3,450	0.15	3,450	0.15	2,050	0.15	2,050	0.15	3,450	0.15
D421TX-8	8	3,200	0.16	3,200	0.16	3,200	0.16	1,900	0.16	1,900	0.16	3,200	0.16
D421TX-8.5	8.5	3,000	0.16	3,000	0.16	3,000	0.16	1,825	0.16	1,825	0.16	3,000	0.16
D421TX-9	9	2,870	0.17	2,870	0.17	2,870	0.17	1,750	0.17	1,750	0.17	2,870	0.17
D421TX-9.5	9.5	2,700	0.17	2,700	0.17	2,700	0.17	1,675	0.17	1,675	0.17	2,700	0.17
D421TX-10	10	2,550	0.18	2,550	0.18	2,550	0.18	1,600	0.18	1,600	0.18	2,550	0.18
D421TX-10.5	10.5	2,420	0.18	2,420	0.18	2,420	0.18	1,525	0.18	1,525	0.18	2,420	0.18
D421TX-11	11	2,320	0.19	2,320	0.19	2,320	0.19	1,450	0.19	1,450	0.19	2,320	0.19
D421TX-11.5	11.5	2,200	0.19	2,200	0.19	2,200	0.19	1,375	0.19	1,375	0.19	2,200	0.19
D421TX-12	12	2,100	0.20	2,100	0.20	2,100	0.20	1,300	0.20	1,300	0.20	2,100	0.20
D421TX-12.5	12.5	2,025	0.20	2,025	0.20	2,025	0.20	1,250	0.20	1,250	0.20	2,025	0.20
D421TX-13	13	1,950	0.21	1,950	0.21	1,950	0.21	1,200	0.21	1,200	0.21	1,950	0.21
D421TX-13.5	13.5	1,875	0.21	1,875	0.21	1,875	0.21	1,150	0.21	1,150	0.21	1,875	0.21
D421TX-14	14	1,800	0.22	1,800	0.22	1,800	0.22	1,100	0.22	1,100	0.22	1,800	0.22
D421TX-14.5	14.5	1,750	0.22	1,750	0.22	1,750	0.22	1,055	0.22	1,055	0.22	1,750	0.22
D421TX-15	15	1,700	0.23	1,700	0.23	1,700	0.23	1,025	0.23	1,025	0.23	1,700	0.23
D421TX-15.5	15.5	1,650	0.23	1,650	0.23	1,650	0.23	980	0.24	980	0.24	1,650	0.23
D421TX-16	16	1,600	0.25	1,600	0.25	1,600	0.25	950	0.25	950	0.25	1,600	0.25

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。