D908 超微粒鎢鋼中心鑽頭60°
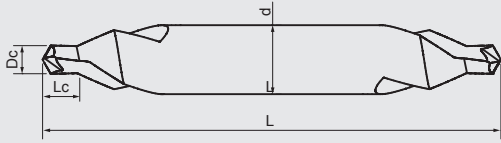
Combined Drills and Countersink 60°

60° Combined drill and countersink centre drill.　　中心頂針孔60°錐度。

| VHM Carbide | Uncoated Bright | 60° | 2 | DIN 333 | 120° | Steel Cast Iron AL. Copper |

Improved strength design for cutting different steels below 48HRC, cast iron, aluminium and copper.

Application for centre hole preparations for lathe and Cylindrical grinding.
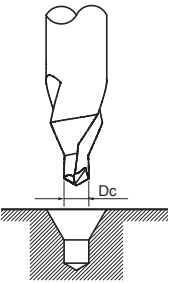
加強度更適用切削48HRC以下的各種鋼材、鑄鐵、鋁合金、銅合金。

| P |
| H |
| K |
| N |

DIN 333 Standard Length

Dc h7	Lc mm	L mm	d h5	D908 60°					
0.5	0.8	38	3	●					
0.8	1.1	38	3	●					
1	1.3	38	3	●					
1.25	1.6	38	3	●					
1.6	2	38	4	●					
2	2.5	50	5	●					
2.5	3.1	50	6	●					
3.15	3.9	63	8	●					
4	5	66	10	●					
5	6.3	73	12	●					

切削條件
Cutting Conditions

D908		
	cutting speed Vc (m/min)	feed per tooth fz(mm)
Carbon Steel Materials		
GRI Carbon Steel	30	0.01xDc
P GR2 <24HRC Low-alloyed Steel	30	0.01xDc
GR3 <30HRC Hi-alloyed Steel	20	0.01xDc
Hardened Steel Materials		
GR4 30-38HRC Hardened Steel	10	0.008xDc
H GR5 38-48HRC Hardened Steel	10	0.006xDc
Cast Lron Materials		
GR9-1 Grey cast iron	30	0.01xDc
K GR9-2 Nodular cast iron	35	0.01xDc
Aluminium Steel Materials		
GRI0-1 Wrought Aluminium alloys	60	0.016xDc
GRI0-2 Aluminium cast alloys <10%	60	0.016xDc
GRI0-3 Aluminium cast alloys >10%	55	0.014xDc
N **Copper Steel Materials**		
GRII-1 Pure Copper	30	0.01xDc
GRII-2 Brass	30	0.01xDc
GRII-2 Bronze	30	0.01xDc

All cutting data serve for orientation only and should be adapted individually to the technical conditions on location
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。