

D400 超微粒鎢鋼微小徑鑽頭

Micro Precision Drills

Small diameter with drill point angle 130°

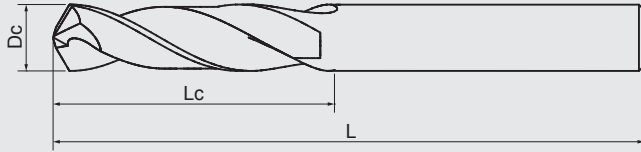
Design with sharp and strength drill point shape.

Diameter specification from 0.2mm to 1.4mm in step of 0.05mm.

130° 鑽尖小徑鑽頭。

兼具銳利度和強度的鑽尖形狀設計。

刃徑從0.2mm-1.4mm，每0.05mm為一種尺寸。



VHM
Carbide

Uncoated
Bright



DIN
1899



AL, Cu,
PVC,
Copper

Application for drilling aluminium, copper, plastic materials...and etc.

適用切削於鋁合金、銅合金、塑膠...等材料鑽孔應用。

P
K
N

Standard Length

Dc h7	Lc mm	L mm	d h6	D400 Bright					
0.2	1.2	25	1	●					
0.25	1.5	25	1	●					
0.3	1.9	25	1	●					
0.35	2.4	25	1	●					
0.4	3	25	1	●					
0.45	3	25	1	●					
0.5	3.4	25	1	●					
0.55	3.9	25	1	●					
0.6	3.9	25	1	●					
0.65	4.2	25	1	●					
0.7	4.8	25	1	●					
0.75	4.8	25	1	●					
0.8	5.3	25	1.5	●					
0.85	5.3	25	1.5	●					
0.9	6	25	1.5	●					
0.95	6	25	1.5	●					
1	6.8	25	1.5	●					
1.05	6.8	25	1.5	●					
1.1	7.6	25	1.5	●					
1.15	7.6	25	1.5	●					
1.2	8.5	25	1.5	●					
1.25	8.5	25	1.5	●					
1.3	8.5	25	1.5	●					
1.35	9.5	25	1.5	●					
1.4	9.5	25	1.5	●					

切削條件

Cutting Conditions

D400			
	cutting speed Vc (m/min)	feed per tooth fz (mm)	
Carbon Steel Materials			
P	GR1 Carbon Steel	40	0.008xDc
	GR2 <24HRC Low-alloyed Steel	30	0.008xDc
	GR3 <30HRC Hi-alloyed Steel	20	0.008xDc
Cast Iron Materials			
K	GR9-1 Grey cast iron	40	0.008xDc
	GR9-2 Nodular cast iron	40	0.008xDc
Aluminium Steel Materials			
G	GR10-1 Wrought Aluminium alloys	200	0.01xDc
	GR10-2 Aluminium cast alloys <10%	200	0.01xDc
	GR10-3 Aluminium cast alloys >10%	180	0.01xDc
Copper Steel Materials			
N	GR11-1 Pure Copper	60	0.01xDc
	GR11-2 Brass	60	0.01xDc
	GR11-2 Bronze	60	0.01xDc
Plastics Steel Materials			
	GR12 Plastics	100	0.01xDc
FRP CFRP Steel Materials			
	GR13 FRP CFRP Composite Material	80	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。