

硬质合金中心钻AD-LDS

Carbide Starter Drill

特点 Features P.7

尺寸表 Dimension

AD-LDS P.49

AD-LS-LDS P.50

条件表 Cutting Condition P.55

■ 按钻头直径区分的加工对应表 P.57
Production Table by Drill Diameter

标识种类 Guide for Icons

1 材质 Tool Materials

CARBIDE 硬质合金
Tungsten Carbide

2 表面处理 Surface Treatment

EgiAs EgiAs 涂层
EgiAs Coating

WXL WXL 涂层
WXL Coating

3 直径的容许差 Tolerance for Drill Diameter

h8 表示钻头直径的容许差
Tolerance for drill diameter

4 柄部 Shank

SHANK h7 表示柄部精度
Tolerance for shank diameter

SHRINK FIT 推荐热缩刀柄
Suitable for the shrink holder system

5 螺旋角 Helix Angle

30° 表示钻头排屑槽的螺旋角
Helix angle of flute for drills

6 切削条件 Cutting Conditions

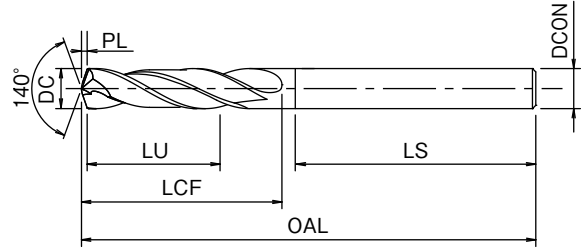
SPEED FEED 表示切削条件基准表所在页面
Indicates page number for cutting conditions

AD-2D/4D

AD-2D



AD-4D



单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深度 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8675200	2 - 3	2D	10	14	62	3	37.9	0.4	B ●
8677200		4D	16	20	66				
8670200	2	2D	10	14	62	4	36	0.4	B ●
8672200		4D	16	20	66				
8675210	2.1 - 3	2D	10	14	62	3	37.9	0.4	B ●
8677210		4D	16	20	66				
8670210	2.1	2D	10	14	62	4	36	0.4	B ●
8672210		4D	16	20	66				
8675220	2.2 - 3	2D	10	14	62	3	37.9	0.4	B ●
8677220		4D	16	20	66				
8670220	2.2	2D	10	14	62	4	36	0.4	B ●
8672220		4D	16	20	66				
8675230	2.3 - 3	2D	9	14	62	3	37.9	0.4	B ●
8677230		4D	15	20	66				
8670230	2.3	2D	9	14	62	4	36	0.4	B ●
8672230		4D	15	20	66				
8675240	2.4 - 3	2D	9	14	62	3	37.9	0.4	B ●
8677240		4D	15	20	66				

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深度 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8670240	2.4	2D	9	14	62	4	36	0.4	B ●
8672240		4D	15	20	66				
8675250	2.5 - 3	2D	9	14	62	3	37.9	0.5	B ●
8677250		4D	15	20	66				
8670250	2.5	2D	9	14	62	4	36	0.5	B ●
8672250		4D	15	20	66				
8675260	2.6 - 3	2D	9	14	62	3	37.9	0.5	B ●
8677260		4D	15	20	66				
8670260	2.6	2D	9	14	62	4	36	0.5	B ●
8672260		4D	15	20	66				
8675270	2.7 - 3	2D	9	14	62	3	37.9	0.5	B ●
8677270		4D	15	20	66				
8670270	2.7	2D	9	14	62	4	36	0.5	B ●
8672270		4D	15	20	66				
8670276	2.76	2D	9	14	62	4	36	0.5	B ●
8670278	2.78	2D	8	14	62	4	36	0.5	B ●
8675280	2.8 - 3	2D	8	14	62	3	37.9	0.5	B ●
8677280		4D	14	20	66				

● = 标准库存品 ● = Standard stock item

- 标识说明请参考p.2.
- 涂层可能会有颜色不均的情况, 但这并不影响刀具的性能.
- See p.2 for explanation of icons.
- Drills may have some discoloration, but it does not cause any performance problems.



FROM

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深度 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8670280	2.8	2D	8	14	62	4	36	0.5	B ●
8672280		4D	14	20	66				
8675290	2.9 - 3	2D	8	14	62	3	37.9	0.5	B ●
8677290		4D	14	20	66				
8670290	2.9	2D	8	14	62	4	36	0.5	B ●
8672290		4D	14	20	66				
8675300	3 - 3	2D	14	20	66	3	37.9	0.5	B ●
8677300		4D	22	28	74				
8670300	3	2D	14	20	66	4	36	0.5	B ●
8672300		4D	22	28	74				
8670310	3.1	2D	14	20	66	4	36	0.6	B ●
8672310		4D	22	28	74				
8670320	3.2	2D	14	20	66	4	36	0.6	B ●
8672320		4D	22	28	74				
8670330	3.3	2D	13	20	66	4	36	0.6	B ●
8672330		4D	21	28	74				
8670340	3.4	2D	13	20	66	4	36	0.6	B ●
8672340		4D	21	28	74				
8670350	3.5	2D	13	20	66	4	36	0.6	B ●
8672350		4D	21	28	74				
8670360	3.6	2D	13	20	66	4	36	0.7	B ●
8672360		4D	21	28	74				
8670366	3.66	2D	13	20	66	4	36	0.7	B ●
8670368	3.68	2D	13	20	66	4	36	0.7	B ●
8670370	3.7	2D	13	20	66	4	36	0.7	B ●
8672370		4D	21	28	74				

单位:mm Unit:mm

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8670380	3.8	2D	16	24	66	4	36	0.7	B ●
8672380		4D	28	36	74				
8670390	3.9	2D	16	24	66	4	36	0.7	B ●
8672390		4D	28	36	74				
8670400	4	2D	16	24	66	4	36	0.7	B ●
8672400		4D	28	36	74				
8675410	4.1 - 5	2D	16	24	66	5	37.9	0.7	B ●
8677410		4D	28	36	74				
8670410	4.1	2D	16	24	66	6	36	0.7	B ●
8672410		4D	28	36	74				
8675420	4.2 - 5	2D	16	24	66	5	37.9	0.8	B ●
8677420		4D	28	36	74				
8670420	4.2	2D	16	24	66	6	36	0.8	B ●
8672420		4D	28	36	74				
8675430	4.3 - 5	2D	15	24	66	5	37.9	0.8	B ●
8677430		4D	27	36	74				
8670430	4.3	2D	15	24	66	6	36	0.8	B ●
8672430		4D	27	36	74				
8675440	4.4 - 5	2D	15	24	66	5	37.9	0.8	B ●
8677440		4D	27	36	74				
8670440	4.4	2D	15	24	66	6	36	0.8	B ●
8672440		4D	27	36	74				
8675450	4.5 - 5	2D	15	24	66	5	37.9	0.8	B ●
8677450		4D	27	36	74				
8670450	4.5	2D	15	24	66	6	36	0.8	B ●
8672450		4D	27	36	74				

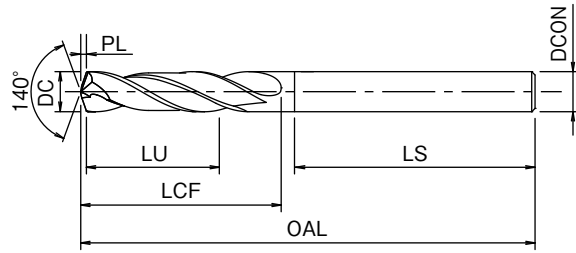
● = 标准库存品 ● = Standard stock item

NEXT



AD-2D/4D

- DC ≤ 4 X形横刃 X thinning
- 4 < DC R形横刃 R thinning



FROM

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深度 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8675460	4.6 - 5	2D	15	24	66	5	37.9	0.8	B ●
8677460		4D	27	36	74				
8670460	4.6	2D	15	24	66	6	36	0.8	B ●
8672460		4D	27	36	74				
8670462	4.62	2D	15	24	66	6	36	0.8	B ●
8670464	4.64	2D	15	24	66	6	36	0.8	B ●
8675470	4.7 - 5	2D	15	24	66	5	37.9	0.9	B ●
8677470		4D	27	36	74				
8670470	4.7	2D	15	24	66	6	36	0.9	B ●
8672470		4D	27	36	74				
8675480	4.8 - 5	2D	18	28	66	5	37.9	0.9	B ●
8677480		4D	34	44	82				
8670480	4.8	2D	18	28	66	6	36	0.9	B ●
8672480		4D	34	44	82				
8675490	4.9 - 5	2D	18	28	66	5	37.9	0.9	B ●
8677490		4D	34	44	82				
8670490	4.9	2D	18	28	66	6	36	0.9	B ●
8672490		4D	34	44	82				
8675500	5 - 5	2D	18	28	66	5	37.9	0.9	B ●
8677500		4D	34	44	82				
8670500	5	2D	18	28	66	6	36	0.9	B ●
8672500		4D	34	44	82				
8670510	5.1	2D	18	28	66	6	36	0.9	B ●
8672510		4D	34	44	82				
8670520	5.2	2D	18	28	66	6	36	0.9	B ●
8672520		4D	34	44	82				

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深度 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8670530	5.3	2D	17	28	66	6	36	1	B ●
8672530		4D	33	44	82				
8670540	5.4	2D	17	28	66	6	36	1	B ●
8672540		4D	33	44	82				
8670550	5.5	2D	17	28	66	6	36	1	B ●
8672550		4D	33	44	82				
8670552	5.52	2D	17	28	66	6	36	1	B ●
8670554	5.54	2D	17	28	66	6	36	1	B ●
8670560	5.6	2D	17	28	66	6	36	1	B ●
8672560		4D	33	44	82				
8670570	5.7	2D	17	28	66	6	36	1	B ●
8672570		4D	33	44	82				
8670580	5.8	2D	17	28	66	6	36	1.1	B ●
8672580		4D	33	44	82				
8670590	5.9	2D	16	28	66	6	36	1.1	B ●
8672590		4D	32	44	82				
8670600	6	2D	16	28	66	6	36	1.1	B ●
8672600		4D	32	44	82				
8675610	6.1 - 7	2D	22	34	79	7	37.9	1.1	B ●
8677610		4D	41	53	91				
8670610	6.1	2D	22	34	79	8	36	1.1	B ●
8672610		4D	41	53	91				
8675620	6.2 - 7	2D	22	34	79	7	37.9	1.1	B ●
8677620		4D	41	53	91				
8670620	6.2	2D	22	34	79	8	36	1.1	B ●
8672620		4D	41	53	91				

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NEXT



FROM

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8675630	6.3 - 7	2D	22	34	79	7	37.9	1.1	●
8677630		4D	41	53	91		37.9	1.1	●
8670630	6.3	2D	22	34	79	8	36	1.1	●
8672630		4D	41	53	91		36	1.1	●
8675640	6.4 - 7	2D	21	34	79	7	37.9	1.2	●
8677640		4D	40	53	91		37.9	1.2	●
8670640	6.4	2D	21	34	79	8	36	1.2	●
8672640		4D	40	53	91		36	1.2	●
8675650	6.5 - 7	2D	21	34	79	7	37.9	1.2	●
8677650		4D	40	53	91		37.9	1.2	●
8670650	6.5	2D	21	34	79	8	36	1.2	●
8672650		4D	40	53	91		36	1.2	●
8675660	6.6 - 7	2D	21	34	79	7	37.9	1.2	●
8677660		4D	40	53	91		37.9	1.2	●
8670660	6.6	2D	21	34	79	8	36	1.2	●
8672660		4D	40	53	91		36	1.2	●
8675670	6.7 - 7	2D	21	34	79	7	37.9	1.2	●
8677670		4D	40	53	91		37.9	1.2	●
8670670	6.7	2D	21	34	79	8	36	1.2	●
8672670		4D	40	53	91		36	1.2	●
8675680	6.8 - 7	2D	21	34	79	7	37.9	1.2	●
8677680		4D	40	53	91		37.9	1.2	●
8670680	6.8	2D	21	34	79	8	36	1.2	●
8672680		4D	40	53	91		36	1.2	●
8675690	6.9 - 7	2D	20	34	79	7	37.9	1.3	●
8677690		4D	39	53	91		37.9	1.3	●

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8670690	6.9	2D	20	34	79	8	36	1.3	●
8672690		4D	39	53	91		36	1.3	●
8675700	7 - 7	2D	20	34	79	7	37.9	1.3	●
8677700		4D	39	53	91		37.9	1.3	●
8670700	7	2D	20	34	79	8	36	1.3	●
8672700		4D	39	53	91		36	1.3	●
8670710	7.1	2D	27	41	79	8	36	1.3	●
8672710		4D	39	53	91		36	1.3	●
8670720	7.2	2D	27	41	79	8	36	1.3	●
8672720		4D	39	53	91		36	1.3	●
8670730	7.3	2D	27	41	79	8	36	1.3	●
8672730		4D	39	53	91		36	1.3	●
8670736	7.36	2D	26	41	79	8	36	1.3	●
8670738	7.38	2D	26	41	79	8	36	1.3	●
8670740	7.4	2D	26	41	79	8	36	1.3	●
8672740		4D	38	53	91		36	1.3	●
8670750	7.5	2D	26	41	79	8	36	1.4	●
8672750		4D	38	53	91		36	1.4	●
8670752	7.52	2D	26	41	79	8	36	1.4	●
8670754	7.54	2D	26	41	79	8	36	1.4	●
8670760	7.6	2D	26	41	79	8	36	1.4	●
8672760		4D	38	53	91		36	1.4	●
8670770	7.7	2D	26	41	79	8	36	1.4	●
8672770		4D	38	53	91		36	1.4	●
8670780	7.8	2D	26	41	79	8	36	1.4	●
8672780		4D	38	53	91		36	1.4	●

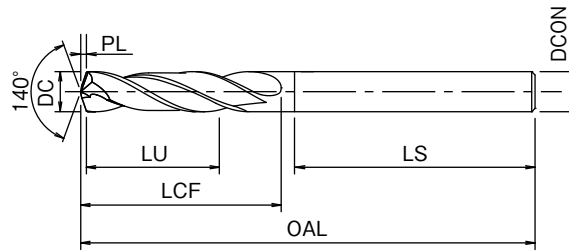
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NEXT



AD-2D/4D

- DC ≤ 4 X形横刃 X thinning
- 4 < DC R形横刃 R thinning



FROM

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深度 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8670790	7.9	2D	25	41	79	8	36	1.4	B ●
8672790		4D	37	53	91				
8670800	8	2D	25	41	79	8	36	1.5	B ●
8672800		4D	37	53	91				
8675810	8.1 - 9	2D	31	47	89	9	41.9	1.5	B ●
8677810		4D	45	61	103				
8670810	8.1	2D	31	47	89	10	40	1.5	B ●
8672810		4D	45	61	103				
8675820	8.2 - 9	2D	31	47	89	9	41.9	1.5	B ●
8677820		4D	45	61	103				
8670820	8.2	2D	31	47	89	10	40	1.5	B ●
8672820		4D	45	61	103				
8675830	8.3 - 9	2D	31	47	89	9	41.9	1.5	B ●
8677830		4D	45	61	103				
8670830	8.3	2D	31	47	89	10	40	1.5	B ●
8672830		4D	45	61	103				
8675840	8.4 - 9	2D	30	47	89	9	41.9	1.5	B ●
8677840		4D	44	61	103				
8670840	8.4	2D	30	47	89	10	40	1.5	B ●
8672840		4D	44	61	103				
8675850	8.5 - 9	2D	30	47	89	9	41.9	1.5	B ●
8677850		4D	44	61	103				
8670850	8.5	2D	30	47	89	10	40	1.5	B ●
8672850		4D	44	61	103				
8675860	8.6 - 9	2D	30	47	89	9	41.9	1.6	B ●
8677860		4D	44	61	103				

单位:mm Unit:mm

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8670860	8.6	2D	30	47	89	10	40	1.6	B ●
8672860		4D	44	61	103				
8675870	8.7 - 9	2D	30	47	89	9	41.9	1.6	B ●
8677870		4D	44	61	103				
8670870	8.7	2D	30	47	89	10	40	1.6	B ●
8672870		4D	44	61	103				
8675880	8.8 - 9	2D	30	47	89	9	41.9	1.6	B ●
8677880		4D	44	61	103				
8670880	8.8	2D	30	47	89	10	40	1.6	B ●
8672880		4D	44	61	103				
8675890	8.9 - 9	2D	29	47	89	9	41.9	1.6	B ●
8677890		4D	43	61	103				
8670890	8.9	2D	29	47	89	10	40	1.6	B ●
8672890		4D	43	61	103				
8675900	9 - 9	2D	29	47	89	9	41.9	1.6	B ●
8677900		4D	43	61	103				
8670900	9	2D	29	47	89	10	40	1.6	B ●
8672900		4D	43	61	103				
8670910	9.1	2D	29	47	89	10	40	1.7	B ●
8672910		4D	43	61	103				
8670920	9.2	2D	29	47	89	10	40	1.7	B ●
8672920		4D	43	61	103				
8670924	9.24	2D	29	47	89	10	40	1.7	B ●
8670926	9.26	2D	29	47	89	10	40	1.7	B ●
8670930	9.3	2D	29	47	89	10	40	1.7	B ●
8672930		4D	43	61	103				

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NEXT



FROM

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8670936	9.36	2D	28	47	89	10	40	1.7	B ●
8670938	9.38	2D	28	47	89	10	40	1.7	B ●
8670940	9.4	2D	28	47	89	10	40	1.7	B ●
8672940		4D	42	61	103		40	1.7	
8670950	9.5	2D	28	47	89	10	40	1.7	B ●
8672950		4D	42	61	103		40	1.7	
8670952	9.52	2D	28	47	89	10	40	1.7	B ●
8670954	9.54	2D	28	47	89	10	40	1.7	B ●
8670960	9.6	2D	28	47	89	10	40	1.7	B ●
8672960		4D	42	61	103		40	1.7	
8670970	9.7	2D	28	47	89	10	40	1.8	B ●
8672970		4D	42	61	103		40	1.8	
8670980	9.8	2D	28	47	89	10	40	1.8	B ●
8672980		4D	42	61	103		40	1.8	
8670990	9.9	2D	27	47	89	10	40	1.8	B ●
8672990		4D	41	61	103		40	1.8	
8671000	10	2D	27	47	89	10	40	1.8	B ●
8673000		4D	41	61	103		40	1.8	
8676010	10.1 - 11	2D	35	55	102	11	46.9	1.8	B ●
8678010		4D	51	71	118		46.9	1.8	
8671010	10.1	2D	35	55	102	12	45	1.8	B ●
8673010		4D	51	71	118		45	1.8	
8676020	10.2 - 11	2D	35	55	102	11	46.9	1.9	B ●
8678020		4D	51	71	118		46.9	1.9	
8671020	10.2	2D	35	55	102	12	45	1.9	B ●
8673020		4D	51	71	118		45	1.9	

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8676030	10.3 - 11	2D	35	55	102	11	46.9	1.9	B ●
8678030		4D	51	71	118		46.9	1.9	
8671030	10.3	2D	35	55	102	12	45	1.9	B ●
8673030		4D	51	71	118		45	1.9	
8676040	10.4 - 11	2D	34	55	102	11	46.9	1.9	B ●
8678040		4D	50	71	118		46.9	1.9	
8671040	10.4	2D	34	55	102	12	45	1.9	B ●
8673040		4D	50	71	118		45	1.9	
8676050	10.5 - 11	2D	34	55	102	11	46.9	1.9	B ●
8678050		4D	50	71	118		46.9	1.9	
8671050	10.5	2D	34	55	102	12	45	1.9	B ●
8673050		4D	50	71	118		45	1.9	
8676060	10.6 - 11	2D	34	55	102	11	46.9	1.9	B ●
8678060		4D	50	71	118		46.9	1.9	
8671060	10.6	2D	34	55	102	12	45	1.9	B ●
8673060		4D	50	71	118		45	1.9	
8676070	10.7 - 11	2D	34	55	102	11	46.9	1.9	B ●
8678070		4D	50	71	118		46.9	1.9	
8671070	10.7	2D	34	55	102	12	45	1.9	B ●
8673070		4D	50	71	118		45	1.9	
8676080	10.8 - 11	2D	34	55	102	11	46.9	2	B ●
8678080		4D	50	71	118		46.9	2	
8671080	10.8	2D	34	55	102	12	45	2	B ●
8673080		4D	50	71	118		45	2	
8676090	10.9 - 11	2D	33	55	102	11	46.9	2	B ●
8678090		4D	49	71	118		46.9	2	

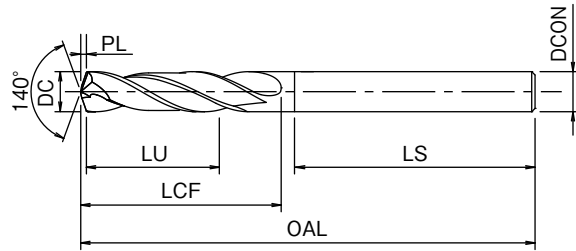
● = 标准库存品 ● = Standard stock item

NEXT



AD-2D/4D

- DC ≤ 4 X形横刃 X thinning
- 4 < DC R形横刃 R thinning



CARBIDE EgiAs h8 30° SHRINK FIT SPEED FEED P51

FROM

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8671090	10.9	2D	33	55	102	12	45	2	●
8673090		4D	49	71	118		45	2	●
8676100	11 - 11	2D	33	55	102	11	46.9	2	●
8678100		4D	49	71	118		46.9	2	●
8671100	11	2D	33	55	102	12	45	2	●
8673100		4D	49	71	118		45	2	●
8671110	11.1	2D	33	55	102	12	45	2	●
8673110		4D	49	71	118		45	2	●
8671120	11.2	2D	33	55	102	12	45	2	●
8673120		4D	49	71	118		45	2	●
8671122	11.22	2D	33	55	102	12	45	2	●
8671124	11.24	2D	33	55	102	12	45	2	●
8671130	11.3	2D	33	55	102	12	45	2.1	●
8673130		4D	49	71	118		45	2.1	●
8671136	11.36	2D	32	55	102	12	45	2.1	●
8671138	11.38	2D	32	55	102	12	45	2.1	●
8671140	11.4	2D	32	55	102	12	45	2.1	●
8673140		4D	48	71	118		45	2.1	●
8671150	11.5	2D	32	55	102	12	45	2.1	●
8673150		4D	48	71	118		45	2.1	●
8671160	11.6	2D	32	55	102	12	45	2.1	●
8673160		4D	48	71	118		45	2.1	●
8671170	11.7	2D	32	55	102	12	45	2.1	●
8673170		4D	48	71	118		45	2.1	●
8671180	11.8	2D	32	55	102	12	45	2.1	●
8673180		4D	48	71	118		45	2.1	●

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8671190	11.9	2D	31	55	102	12	45	2.2	●
8673190		4D	47	71	118		45	2.2	●
8671200	12	2D	31	55	102	12	45	2.2	●
8673200		4D	47	71	118		45	2.2	●
8678210	12.1 - 13	4D	53	77	124	13	45	2.2	●
8671210	12.1	2D	36	60	107	14	45	2.2	●
8673210		4D	53	77	124		45	2.2	●
8678220	12.2 - 13	4D	53	77	124	13	45	2.2	●
8671220	12.2	2D	36	60	107	14	45	2.2	●
8673220		4D	53	77	124		45	2.2	●
8678230	12.3 - 13	4D	53	77	124	13	45	2.2	●
8671230	12.3	2D	36	60	107	14	45	2.2	●
8673230		4D	53	77	124		45	2.2	●
8678240	12.4 - 13	4D	52	77	124	13	45	2.3	●
8671240	12.4	2D	35	60	107	14	45	2.3	●
8673240		4D	52	77	124		45	2.3	●
8678250	12.5 - 13	4D	52	77	124	13	45	2.3	●
8671250	12.5	2D	35	60	107	14	45	2.3	●
8673250		4D	52	77	124		45	2.3	●
8678260	12.6 - 13	4D	52	77	124	13	45	2.3	●
8671260	12.6	2D	35	60	107	14	45	2.3	●
8673260		4D	52	77	124		45	2.3	●
8678270	12.7 - 13	4D	52	77	124	13	45	2.3	●
8671270	12.7	2D	35	60	107	14	45	2.3	●
8673270		4D	52	77	124		45	2.3	●
8678280	12.8 - 13	4D	52	77	124	13	45	2.3	●

● = 标准库存品 ● = Standard stock item

- 标识说明请参考p.2.
- 涂层可能会有颜色不均的情况, 但这并不影响刀具的性能.
- See p.2 for explanation of icons.
- Drills may have some discoloration, but it does not cause any performance problems.

NEXT



FROM

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8671280	12.8	2D	35	60	107	14	45	2.3	●
8673280		4D	52	77	124		45	2.3	●
8678290	12.9 - 13	4D	51	77	124	13	45	2.3	B ●
8671290	12.9	2D	34	60	107	14	45	2.3	●
8673290		4D	51	77	124		45	2.3	●
8678300	13 - 13	4D	51	77	124	13	45	2.4	B ●
8671300	13	2D	34	60	107	14	45	2.4	●
8673300		4D	51	77	124		45	2.4	●
8671310	13.1	2D	34	60	107	14	45	2.4	●
8673310		4D	51	77	124		45	2.4	●
8671320	13.2	2D	34	60	107	14	45	2.4	●
8673320		4D	51	77	124		45	2.4	●
8671330	13.3	2D	34	60	107	14	45	2.4	●
8673330		4D	51	77	124		45	2.4	●
8671340	13.4	2D	33	60	107	14	45	2.4	●
8673340		4D	50	77	124		45	2.4	●
8671350	13.5	2D	33	60	107	14	45	2.5	●
8673350		4D	50	77	124		45	2.5	●
8671360	13.6	2D	33	60	107	14	45	2.5	●
8673360		4D	50	77	124		45	2.5	●
8671370	13.7	2D	33	60	107	14	45	2.5	●
8673370		4D	50	77	124		45	2.5	●
8671380	13.8	2D	33	60	107	14	45	2.5	●
8673380		4D	50	77	124		45	2.5	●
8671390	13.9	2D	32	60	107	14	45	2.5	●
8673390		4D	49	77	124		45	2.5	●

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8671400	14	2D	32	60	107	14	45	2.5	●
8673400		4D	49	77	124		45	2.5	●
8678410	14.1 - 15	4D	55	83	133	15	48	2.6	B ●
8671410	14.1	2D	37	65	115	16	48	2.6	●
8673410		4D	55	83	133		48	2.6	●
8678420	14.2 - 15	4D	55	83	133	15	48	2.6	B ●
8671420	14.2	2D	37	65	115	16	48	2.6	●
8673420		4D	55	83	133		48	2.6	●
8678430	14.3 - 15	4D	55	83	133	15	48	2.6	B ●
8671430	14.3	2D	37	65	115	16	48	2.6	●
8673430		4D	55	83	133		48	2.6	●
8678440	14.4 - 15	4D	54	83	133	15	48	2.6	B ●
8671440	14.4	2D	36	65	115	16	48	2.6	●
8673440		4D	54	83	133		48	2.6	●
8678450	14.5 - 15	4D	54	83	133	15	48	2.6	B ●
8671450	14.5	2D	36	65	115	16	48	2.6	●
8673450		4D	54	83	133		48	2.6	●
8678460	14.6 - 15	4D	54	83	133	15	48	2.7	B ●
8671460	14.6	2D	36	65	115	16	48	2.7	●
8673460		4D	54	83	133		48	2.7	●
8678470	14.7 - 15	4D	54	83	133	15	48	2.7	B ●
8671470	14.7	2D	36	65	115	16	48	2.7	●
8673470		4D	54	83	133		48	2.7	●
8678480	14.8 - 15	4D	54	83	133	15	48	2.7	B ●
8671480	14.8	2D	36	65	115	16	48	2.7	●
8673480		4D	54	83	133		48	2.7	●

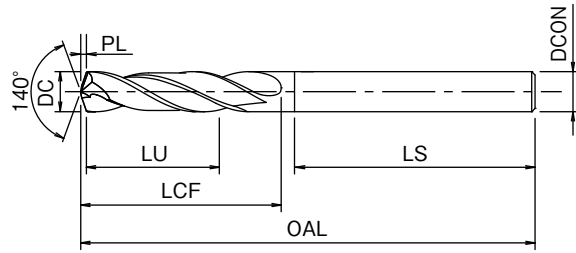
● = 标准库存品 ● = Standard stock item

NEXT



AD-2D/4D

- DC ≤ 4 X形横刃 X thinning
- 4 < DC R形横刃 R thinning



FROM

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深度 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8678490	14.9 - 15	4D	53	83	133	15	48	2.7	B ●
8671490	14.9	2D	35	65	115	16	48	2.7	B ●
8673490		4D	53	83	133				B ●
8678500	15 - 15	4D	53	83	133	15	48	2.7	B ●
8671500	15	2D	35	65	115	16	48	2.7	B ●
8673500		4D	53	83	133				B ●
8671510	15.1	2D	35	65	115	16	48	2.7	B ●
8673510		4D	53	83	133				B ●
8671520	15.2	2D	35	65	115	16	48	2.8	B ●
8673520		4D	53	83	133				B ●
8671530	15.3	2D	35	65	115	16	48	2.8	B ●
8673530		4D	53	83	133				B ●
8671540	15.4	2D	34	65	115	16	48	2.8	B ●
8673540		4D	52	83	133				B ●
8671550	15.5	2D	34	65	115	16	48	2.8	B ●
8673550		4D	52	83	133				B ●
8671560	15.6	2D	34	65	115	16	48	2.8	B ●
8673560		4D	52	83	133				B ●
8671570	15.7	2D	34	65	115	16	48	2.9	B ●
8673570		4D	52	83	133				B ●
8671580	15.8	2D	34	65	115	16	48	2.9	B ●
8673580		4D	52	83	133				B ●
8671590	15.9	2D	33	65	115	16	48	2.9	B ●
8673590		4D	51	83	133				B ●

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深度 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
8671600	16	2D	33	65	115	16	48	2.9	B ●
8673600		4D	51	83	133				B ●
	16.1	2D	41	73	123	18	48	2.9	□
		4D	61	93	143				□
	16.2	2D	41	73	123	18	48	2.9	□
		4D	61	93	143				□
	16.3	2D	41	73	123	18	48	3	□
		4D	61	93	143				□
	16.4	2D	40	73	123	18	48	3	□
		4D	60	93	143				□
8678650	16.5 - 17	4D	60	93	143	17	48	3	B ●
8671650	16.5	2D	40	73	123	18	48	3	B ●
8673650		4D	60	93	143				B ●
	16.6	2D	40	73	123	18	48	3	□
		4D	60	93	143				□
	16.7	2D	40	73	123	18	48	3	□
		4D	60	93	143				□
	16.8	2D	40	73	123	18	48	3.1	□
		4D	60	93	143				□
	16.9	2D	40	73	123	18	48	3.1	□
		4D	60	93	143				□
8678700	17 - 17	4D	59	93	143	17	48	3.1	B ●
8671700	17	2D	39	73	123	18	48	3.1	B ●
8673700		4D	59	93	143				B ●

- 标识说明请参考p.2.
- 涂层可能会有颜色不均的情况, 但这并不影响刀具的性能.
- See p.2 for explanation of icons.
- Drills may have some discoloration, but it does not cause any performance problems.

- = 标准库存品 ● = Standard stock item
- = 特定代理店库存品 □ = Stocked by specific distributors.
- Contact us for price & availability.



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FROM

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
	17.1	2D	39	73	123	18	48	3.1	<input type="checkbox"/>
		4D	59	93	143		48	3.1	<input type="checkbox"/>
	17.2	2D	39	73	123	18	48	3.1	<input type="checkbox"/>
		4D	59	93	143		48	3.1	<input type="checkbox"/>
	17.3	2D	39	73	123	18	48	3.1	<input type="checkbox"/>
		4D	59	93	143		48	3.1	<input type="checkbox"/>
	17.4	2D	39	73	123	18	48	3.2	<input type="checkbox"/>
		4D	59	93	143		48	3.2	<input type="checkbox"/>
8671750	17.5	2D	38	73	123	18	48	3.2	<input checked="" type="checkbox"/>
8673750		4D	58	93	143		48	3.2	<input checked="" type="checkbox"/>
	17.6	2D	38	73	123	18	48	3.2	<input type="checkbox"/>
		4D	58	93	143		48	3.2	<input type="checkbox"/>
	17.7	2D	38	73	123	18	48	3.2	<input type="checkbox"/>
		4D	58	93	143		48	3.2	<input type="checkbox"/>
	17.8	2D	38	73	123	18	48	3.2	<input type="checkbox"/>
		4D	58	93	143		48	3.2	<input type="checkbox"/>
	17.9	2D	38	73	123	18	48	3.3	<input type="checkbox"/>
		4D	58	93	143		48	3.3	<input type="checkbox"/>
8671800	18	2D	37	73	123	18	48	3.3	<input checked="" type="checkbox"/>
8673800		4D	57	93	143		48	3.3	<input checked="" type="checkbox"/>
	18.1	2D	43	79	131	20	50	3.3	<input type="checkbox"/>
		4D	65	101	153		50	3.3	<input type="checkbox"/>
	18.2	2D	43	79	131	20	50	3.3	<input type="checkbox"/>
		4D	65	101	153		50	3.3	<input type="checkbox"/>

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
	18.3	2D	43	79	131	20	50	3.3	<input type="checkbox"/>
		4D	65	101	153		50	3.3	<input type="checkbox"/>
	18.4	2D	43	79	131	20	50	3.3	<input type="checkbox"/>
		4D	65	101	153		50	3.3	<input type="checkbox"/>
8678850	18.5 - 19	4D	64	101	153	19	50	3.4	<input checked="" type="checkbox"/>
8671850		2D	42	79	131		20	50	3.4
8673850	4D	64	101	153	50	3.4		<input checked="" type="checkbox"/>	
	18.6	2D	42	79	131	20	50	3.4	<input type="checkbox"/>
		4D	64	101	153		50	3.4	<input type="checkbox"/>
	18.7	2D	42	79	131	20	50	3.4	<input type="checkbox"/>
		4D	64	101	153		50	3.4	<input type="checkbox"/>
	18.8	2D	42	79	131	20	50	3.4	<input type="checkbox"/>
		4D	64	101	153		50	3.4	<input type="checkbox"/>
	18.9	2D	42	79	131	20	50	3.4	<input type="checkbox"/>
		4D	64	101	153		50	3.4	<input type="checkbox"/>
8678900	19 - 19	4D	63	101	153	19	50	3.5	<input checked="" type="checkbox"/>
8671900	19	2D	41	79	131	20	50	3.5	<input checked="" type="checkbox"/>
8673900		4D	63	101	153		50	3.5	<input checked="" type="checkbox"/>
	19.1	2D	41	79	131	20	50	3.5	<input type="checkbox"/>
		4D	63	101	153		50	3.5	<input type="checkbox"/>
	19.2	2D	41	79	131	20	50	3.5	<input type="checkbox"/>
		4D	63	101	153		50	3.5	<input type="checkbox"/>
	19.3	2D	41	79	131	20	50	3.5	<input type="checkbox"/>
		4D	63	101	153		50	3.5	<input type="checkbox"/>

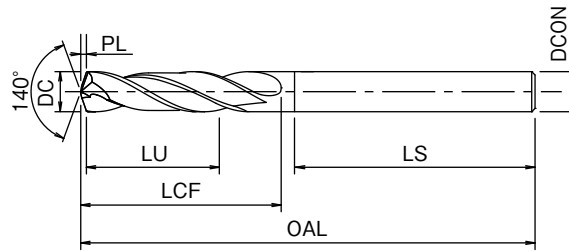
= 标准库存品 ● = Standard stock item
 = 特定代理店库存品 □ = Stocked by specific distributors.
 Contact us for price & availability.

NEXT



AD-2D/4D

- DC ≤ 4 X形横刃 X thinning
- 4 < DC R形横刃 R thinning



CARBIDE EgiAs h8 30° SHRINK FIT SPEED FEED P51

FROM

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深度 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
	19.4	2D	41	79	131	20	50	3.5	<input type="checkbox"/>
		4D	63	101	153		50	3.5	<input type="checkbox"/>
8671950	19.5	2D	40	79	131	20	50	3.5	●
8673950		4D	62	101	153		50	3.5	●
	19.6	2D	40	79	131	20	50	3.6	<input type="checkbox"/>
		4D	62	101	153		50	3.6	<input type="checkbox"/>
	19.7	2D	40	79	131	20	50	3.6	<input type="checkbox"/>
		4D	62	101	153		50	3.6	<input type="checkbox"/>

单位:mm Unit:mm

商品号 EDP No.	直径 - 柄径 DC - DCON	类型 Type	有效加工深度 LU	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	库存 Stock
	19.8	2D	40	79	131	20	50	3.6	<input type="checkbox"/>
		4D	62	101	153		50	3.6	<input type="checkbox"/>
	19.9	2D	40	79	131	20	50	3.6	<input type="checkbox"/>
		4D	62	101	153		50	3.6	<input type="checkbox"/>
8672000	20	2D	39	79	131	20	50	3.6	●
8674000		4D	61	101	153		50	3.6	●

● = 标准库存品 ● = Standard stock item
 □ = 特定代理店库存品 □ = Stocked by specific distributors.
 Contact us for price & availability.

- 标识说明请参考p.2。
- 涂层可能会有颜色不均的情况，但这并不影响刀具的性能。
- See p.2 for explanation of icons.
- Drills may have some discoloration, but it does not cause any performance problems.

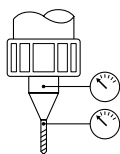


AD-2D/4D

加工材料 Work Material	软钢·低碳素钢·合金钢 Mild Steel · Low Carbon Steel · Alloy Steel (C<0.3%) SS400 · SCM ~710N/mm ²		碳素钢 Carbon Steel S35C · S50C ~210HB ~710N/mm ²		合金钢 Alloy Steel SCM · SCr · SNCM 16~28HRC 710~900N/mm ²	
切削速度 Cutting Speed	70~120m/min		60~120m/min		60~120m/min	
直径 Drill Dia. (mm)	转速 Speed (min ⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min ⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min ⁻¹)	进给量 Feed Rate (mm/rev)
2	12,000	0.06 ~ 0.08	10,400	0.06 ~ 0.08	10,400	0.06 ~ 0.08
4	8,000	0.08 ~ 0.16	7,200	0.08 ~ 0.16	7,200	0.08 ~ 0.16
6	5,300	0.12 ~ 0.24	4,800	0.12 ~ 0.24	4,800	0.12 ~ 0.24
8	4,000	0.16 ~ 0.28	3,600	0.16 ~ 0.28	3,600	0.16 ~ 0.28
10	3,200	0.2 ~ 0.3	2,900	0.2 ~ 0.3	2,900	0.2 ~ 0.3
12	2,700	0.21 ~ 0.3	2,400	0.21 ~ 0.3	2,400	0.21 ~ 0.3
14	2,300	0.22 ~ 0.35	2,050	0.22 ~ 0.35	2,050	0.22 ~ 0.35
16	2,000	0.25 ~ 0.36	1,800	0.25 ~ 0.36	1,800	0.25 ~ 0.36
18	1,800	0.28 ~ 0.38	1,600	0.28 ~ 0.38	1,600	0.28 ~ 0.38
20	1,600	0.3 ~ 0.4	1,450	0.3 ~ 0.4	1,450	0.3 ~ 0.4

加工材料 Work Material	合金钢 Alloy Steel SCM · SCr · SNCM 28~35HRC 900~1,100N/mm ²		铸铁 Cast Iron FC250 ~350N/mm ²		球墨铸铁 Ductile Cast Iron FCD450 FCD600 400~600N/mm ²	
切削速度 Cutting Speed	50~90m/min		60~120m/min		50~100m/min	
直径 Drill Dia. (mm)	转速 Speed (min ⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min ⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min ⁻¹)	进给量 Feed Rate (mm/rev)
2	8,800	0.06 ~ 0.08	10,400	0.06 ~ 0.08	9,600	0.06 ~ 0.08
4	5,600	0.08 ~ 0.16	7,200	0.08 ~ 0.16	6,000	0.08 ~ 0.16
6	3,700	0.12 ~ 0.24	4,800	0.12 ~ 0.24	4,000	0.12 ~ 0.24
8	2,800	0.16 ~ 0.28	3,600	0.16 ~ 0.28	3,000	0.16 ~ 0.28
10	2,200	0.2 ~ 0.3	2,900	0.2 ~ 0.3	2,400	0.2 ~ 0.3
12	1,900	0.21 ~ 0.3	2,400	0.21 ~ 0.3	2,000	0.21 ~ 0.3
14	1,400	0.22 ~ 0.35	2,050	0.22 ~ 0.35	1,700	0.22 ~ 0.35
16	1,200	0.25 ~ 0.36	1,800	0.25 ~ 0.36	1,500	0.25 ~ 0.36
18	1,050	0.28 ~ 0.38	1,600	0.28 ~ 0.38	1,350	0.28 ~ 0.38
20	950	0.3 ~ 0.4	1,450	0.3 ~ 0.4	1,200	0.3 ~ 0.4

1. 此切削条件基准表适用于水溶性切削油剂。
2. 请使用稀释20倍以下的优质水溶性切削油剂。
3. 使用油性切削油剂或水溶性切削油剂稀释倍率超过20倍时，切削速度请下调30%。
4. 此切削条件基准表适用于孔深在3D以下的情况。
5. 安装钻头时，请使用无损伤、无油污的夹具，钻头振动控制在0.02mm以下。
6. 请保持加工材料在不变形、不弯曲、不振动的状态下。
7. 机器转速无法达到上述切削速度时，请尽可能使用高转速。另外，此情况可能会导致寿命降低。



1. The indicated speeds and feeds are for drilling with water-soluble coolant.
2. Water-soluble high density coolant (less than 20 times dilution) is recommended.
3. When using non-water-soluble or water-soluble coolant (over 20 times dilution), reduce cutting speed by 30%.
4. These conditions are for drilling depth under 3 times the drill diameter.
5. Equip the drill with a scratch- and dust-free collet and minimize drill deflection to less than 0.02mm.
6. Fasten the work material to reduce the possibility of work deformation, deflection of machined surface, or vibration.
7. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible. Tool life may be decreased.

