

清除折损丝锥用

EX HARD DRILLS FOR REMOVING TAPS

EX-H-DRL



CARBIDE

SHANK
h7

用于折损丝锥的清除、淬火钢 (58~69HRC) 等加工、合金的补孔加工。
This drill is used for: removing broken taps, drilling after heat treatment, drilling
stellite or drilling quenched and tempered steels (58~68HRC).

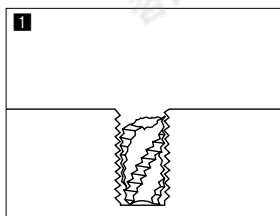
单位:mm Unit:mm

商品号 EDP NO.	直径 DC	槽长 LCF	全长 OAL	柄径 DCON	柄长 LS	先端 PL	先端角 SIG	适应破损丝锥						库存 Stock	重量 (g)
								直槽丝锥		刃倾角丝锥		螺旋槽丝锥			
87700	2-6 打包 (5 把组)														57
87702	2	10	30	2	19.3	0.6	118°	M 3	No.4, No.5, No.6	M 3	No.4, No.5	M 3	No.4, No.5, No.6	3	
87703	3	15	40	3	24.1	0.9		M 4, M 5	No.8, No.10	M 4	No.8, No.10	M 4, M 5	No.8, No.10	5	
87704	4	20	45	4	24	1.2		M 6	1/4, 5/16	M 5, M 6	1/4	M 6	1/4, 5/16	8	
87705	5	25	50	5	23.9	1.5		M 8, M10	3/8		5/16	M 8, M10	3/8	12	
87706	6	30	60	6	28.8	1.8		M 12	7/16, 1/2	M 8	3/8	M 12	7/16, 1/2	21	
87707	7	35	80	8	43.6	2.1		M 14	9/16	M10	7/16	M 14	9/16	46	
87708	8	40						M 16	5/8	M12	1/2	M 16	5/8	48	
87709	9	45	100	10	53.6	2.7		M 18	3/4	M14	9/16	M 18	3/4	89	
87710	10	50						M 20		M16	5/8	M 20		93	
87781	11	55	110	12	53.5	3.3		M 22	7/8	M18		M 22	7/8	137	
87782	12	60						M 24	1	M20	3/4	M 24	1	141	

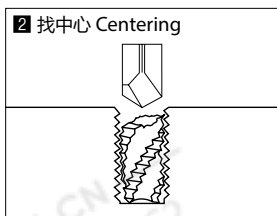
1. 钻头直径的选定请按下列公式 (D = 丝锥大径, d = 钻头直径)
直槽丝锥, 螺旋槽丝锥 $0.46D < d < 0.75D$, 刃倾角丝锥 $0.6D < d < 0.75D$ 。
2. 亦可按 $\phi 2, 3, 4, 5, 6$ 米成套订购 (工具编号 No.87700)
3. 切削油剂请参考 P.958。

1. For drill diameter selection, use the method outlined below.
(D=tap dia. d=drill dia.)
Straight Fluted taps, Spiral Fluted taps : $0.46D < d < 0.75D$
Spiral Pointed taps : $0.6D < d < 0.75D$
2. Drills are available as a 5pcs. set (EDP No. 87700) for $\phi 2$ through $\phi 6$.
3. Cutting fluid : Please refer to p.958.

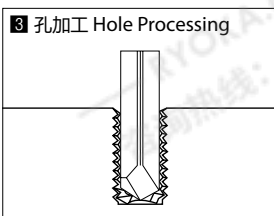
清除破损丝锥的步骤 Work Procedure for Removing Damaged Tap in Hole



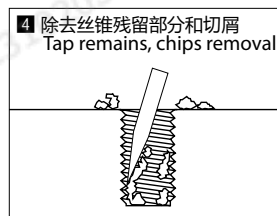
将工件固定紧, 使钻头置于破损丝锥的中心位置。如果丝锥是于孔外折断的, 那么将断处削平, 则易于找到丝锥的中心点。
Position the drill at the center of the damaged tap, securing both the workpiece and the drill firmly. When the head of the damaged tap is protruding, grind the damaged surface flat to make the center of the damaged tap easier to drill.



进行找中心加工时, 无需供油, 请使用微速谨慎进行。如果使用的钻头尺寸比步骤3中所使用的更大, 则加工可以更加容易。
Make an initial, centered approach by drilling lightly, then quickly withdrawing the drill. For this step, do not use lubrication.



参照上表选择合适的钻头。注意速度要保持一定, 要经常停下钻头, 将碎屑取出, 要用优质的切削液。
Select an appropriate drill by consulting the table. Drill the hole at a fixed speed, stopping the operation occasionally to remove chip waste. In addition, use plenty of high quality cutting fluid.



在破损丝锥上钻孔完毕后, 可用尖锐之物将丝锥的碎屑取出。
Once the hole has been cleared, the peripheral remnants of the tap can be removed with ease. Once the hole is cleaned, tapping can be resumed.

※ 亦可用于淬火钢上的补孔加工。

* For drilling after heat treatment, follow the instructions above.

切削条件以及注意点 Cutting Conditions and Procedures to Note.

1. 请将切削速度定为 20~25m/min.
2. 手动进给量为 0.01~0.05m/rev.
3. 请使用对应直径的有刚性的刀柄。
4. 请选择优质的切削液, 强制注油。
5. 不适用于软钢, 铝, 铜等较柔软的加工材料。
6. 请定期进行修磨, 保持刀尖锋利。
7. 在淬火钢等的通孔加工过程中, 为了防止在钻穿时扭矩突然增大, 若能在底下垫些东西, 能防止切屑。

1. Use a drilling speed of 20-25 m/min.
2. Hand feed of 0.01mm - 0.05mm/rev. is the norm.
3. Use a rigid holder.
4. Select a high quality cutting oil and apply sufficient amounts.
5. This tool should not be used to drill soft steel, aluminium alloy equivalents, or other soft materials.
6. Resharpening should be done periodically.
7. For through hole processing of heat treated steel etc., using a cut off - positioned under the work material - to prevent breakage caused by sudden torque.

●=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.

■记号说明请参考P1页。 See p.1 for explanation of icons.

钻头
DRILLS

SPECIFICATION
CHARTS
形状
尺寸表

丝锥
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倒角

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平头钻/
沉头钻

CARBIDE
REAMER
硬质合金
铰刀