

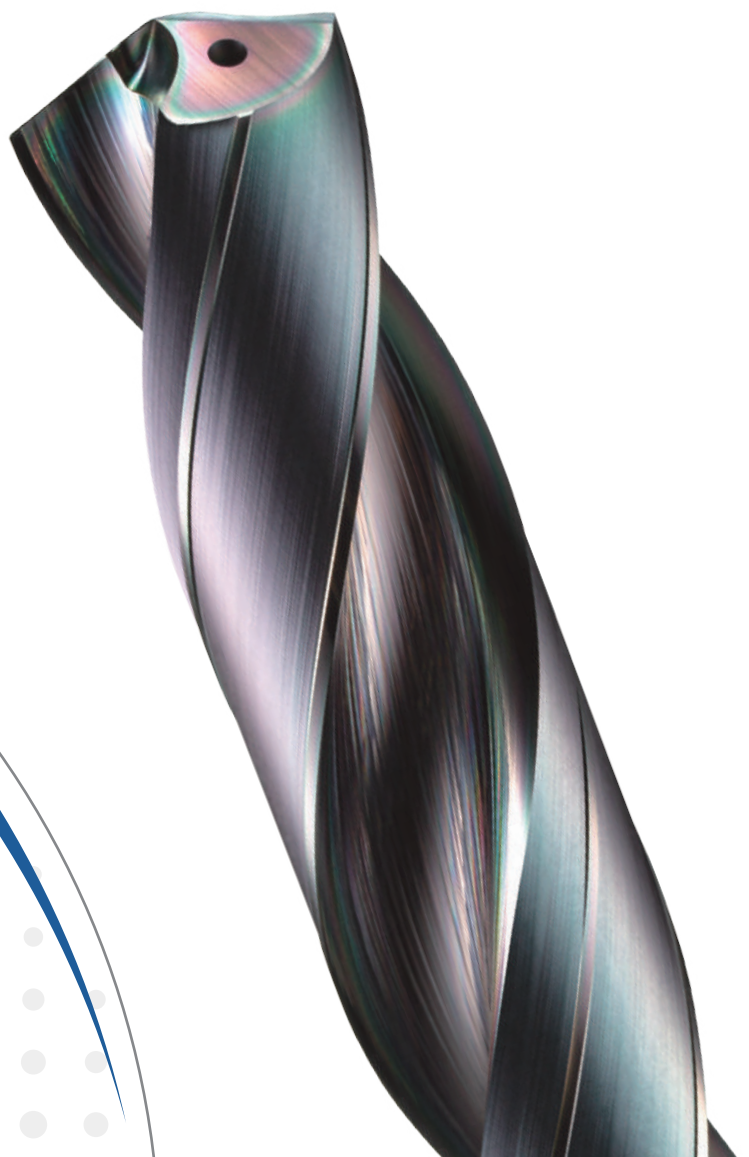


shaping your dreams

S-Drills

上海松江产硬质合金钻头系列

Vol.1



上海松江工厂

SONGJIANG FACTORY



2002

硬质合金铣刀
开始投产

Started production of
carbide endmills

工厂成立

Factory was established

2006

硬质合金钻头
开始投产

Started production of
carbide drills

ISO9001认证
再研磨/涂层服务
Acquired ISO9001 certification
started regrinding and
recoating services

2011

获评
【高新技术企业】

Rated as a [high-tech enterprise]

二期工厂建成

The second phase of
the plant was completed

2021

高新技术 持续更新

High-tech continuous updating

2004

2010

2013



奥斯机（上海）精密工具有限公司

作为 OSG 集团在中国最大的本土工厂，奥斯机（上海）精密工具有限公司一直致力于为中国制造业提供高品质、高性能的切削工具解决方案。工厂主营产品包含硬质合金钻头、铣刀及特殊刀具，除此之外工厂还提供再研磨、再涂层的服务。

产品也被广泛应用于汽车、航空航天、模具、工程机械等多个行业。

依托日本总部先进的技术支持与严格的品质管理体系，奥斯机（上海）精密工具有限公司不仅提供标准产品的设计与生产，更能根据客户需求定制个性化的加工方案。

工厂始终秉承“以技术创新推动制造进步”的理念，积极助力中国制造向高端、高效、高精度发展。

OSG (Shanghai) Precision Tool Co., Ltd.,

OSG (Shanghai) Precision Tool is the largest local manufacturing facility of the OSG Group in China. Since its founding, the company has been committed to delivering high-quality, high-performance cutting tool solutions to the Chinese manufacturing industry. Its core product offerings include carbide drills, end mills, and special tools. In addition, the facility provides tool regrinding and recoating services. These products are widely used across various industries, including automotive, aerospace, mold & die, and construction machinery.

With strong technical support and rigorous quality management systems from its Japanese headquarters, OSG (Shanghai) Precision Tool not only designs and manufactures standard products, but also offers customized machining solutions tailored to specific customer needs. Upholding the philosophy of "Driving Manufacturing Forward through Technological Innovation," the company actively contributes to the advancement of China's manufacturing industry toward higher-end, more efficient, and more precise production.

【高性能】硬质合金钻头系列 AD/ADO-DIN

High-Performance Carbide Drill Series

推荐用于多种加工材料的硬质合金钻头，通过兼顾刃尖刚性与切削阻力，实现了优异的适应性。采用具有高耐磨性和韧性的 EgiAs 涂层，实现长寿命化。

Recommended for a wide range of machining materials, combining cutting edge rigidity with low cutting resistance. It features the highly wear-resistant and tough EgiAs coating for extended tool life.



波浪形刃型带来低推力和 稳定扭矩，实现长寿命

Wave-shaped cutting edge provides low thrust and stable torque, contributing to long tool life.

锋利的刃尖设计 可应对多种被削材料

Sharp cutting edge design supports machining of various materials.

采用高耐磨性和高韧性的 EgiAs 涂层，进一步延长寿命

EgiAs coating with excellent wear resistance and toughness ensures extended durability.

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【高刚性】硬质合金钻头系列 AD/ADO-DIN Type-S

High Sense of Security Carbide Drill Series

通过强化钻头刚性，实现了卓越的加工稳定性与长寿命。即使在交叉孔或预钻孔等复杂工况下，也能维持稳定性能。不仅适用于通用材料，在不锈钢加工中也有出色表现

Enhanced drill rigidity delivers exceptional machining stability and long tool life. Stable performance is maintained even in challenging conditions such as cross holes or pre-drilled holes.

It performs excellently not only on general materials but also when machining stainless steel.



高刚性刃型提升了 加工稳定性与孔精度

High-rigidity cutting edge design ensures excellent machining stability and hole accuracy

R 型排屑槽设计有效降低 切削阻力并提升排屑性

R-gash reduces cutting resistance and enhances chip evacuation performance.

槽部抛光处理进一步 提升切屑排出性能

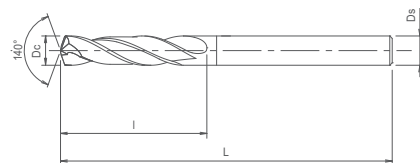
Polished flutes further improve chip evacuation efficiency

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AD-2D-DIN

高性能无油孔 2D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

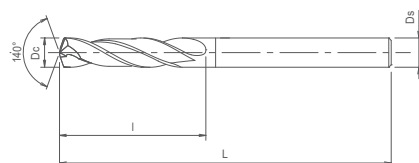
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30238090	0.9	41	6	3		M1x0.25	●
30238100	1	41	6	3			●
30238108	1.08	45	6	3			●
30238110	1.1	45	7	3			●
30238120	1.2	45	7	3			●
30238125	1.25	45	7	3		M1.4x0.3	●
30238127	1.27	45	7	3		M1.4x0.3	●
30238130	1.3	45	7	3			●
30238140	1.4	45	8	3			●
30238145	1.45	45	8	3			●
30238150	1.5	45	8	3		M1.6x0.2	●
30238153	1.53	45	9	3		M1.6x0.2	●
30238160	1.6	45	9	3			●
30238165	1.65	45	9	3			●
30238170	1.7	45	9	3			●
30238175	1.75	45	10	3			●
30238180	1.8	45	10	3		M2x0.4	●
30238183	1.83	45	10	3		M2x0.4	●
30238190	1.9	45	10	3			●
30238200	2	62	14	4			●
30238210	2.1	62	14	4			●
30238220	2.2	62	14	4			●
30238230	2.3	62	14	4			●
30238240	2.4	62	14	4			●
30238250	2.5	62	14	4	M3X0.5		●
30238260	2.6	62	14	4			●
30238270	2.7	62	14	4			●
30238276	2.76	62	14	4		M3X0.5	●
30238278	2.78	62	14	4		M3X0.5	●
30238280	2.8	62	14	4			●
30238290	2.9	62	14	4			●
30238300	3	62	20	6			●
30238310	3.1	62	20	6			●
30238320	3.2	62	20	6			●



AD-2D-DIN

高性能无油孔 2D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

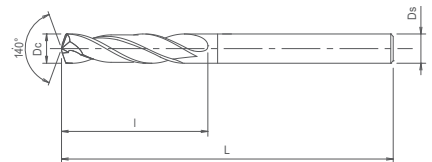
*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30238330	3.3	62	20	6	M4X0.7		●
30238340	3.4	62	20	6			●
30238350	3.5	62	20	6			●
30238360	3.6	62	20	6			●
30238366	3.66	62	20	6		M4X0.7	●
30238368	3.68	62	20	6		M4X0.7	●
30238370	3.7	62	20	6			●
30238380	3.8	66	24	6			●
30238390	3.9	66	24	6			●
30238400	4	66	24	6			●
30238410	4.1	66	24	6			●
30238420	4.2	66	24	6	M5X0.8		●
30238430	4.3	66	24	6			●
30238440	4.4	66	24	6			●
30238450	4.5	66	24	6			●
30238460	4.6	66	24	6			●
30238462	4.62	66	24	6		M5X0.8	●
30238464	4.64	66	24	6		M5X0.8	●
30238470	4.7	66	24	6			●
30238480	4.8	66	28	6			●
30238490	4.9	66	28	6			●
30238500	5	66	28	6	M6X1		●
30238510	5.1	66	28	6			●
30238520	5.2	66	28	6			●
30238530	5.3	66	28	6			●
30238540	5.4	66	28	6			●
30238550	5.5	66	28	6			●
30238552	5.52	66	28	6		M6X1	●
30238554	5.54	66	28	6		M6X1	●
30238560	5.6	66	28	6			●
30238570	5.7	66	28	6			●
30238580	5.8	66	28	6			●
30238590	5.9	66	28	6			●
30238600	6	66	28	6	M7X1		●

AD-2D-DIN

高性能无油孔 2D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

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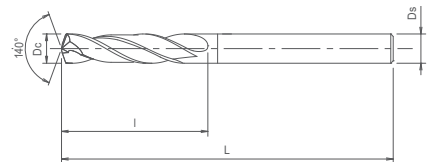
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30238610	6.1	79	34	8			●
30238620	6.2	79	34	8			●
30238630	6.3	79	34	8			●
30238640	6.4	79	34	8			●
30238650	6.5	79	34	8			●
30238660	6.6	79	34	8			●
30238670	6.7	79	34	8			●
30238680	6.8	79	34	8			●
30238690	6.9	79	34	8			●
30238700	7	79	34	8	M8X1		●
30238710	7.1	79	41	8			●
30238720	7.2	79	41	8			●
30238730	7.3	79	41	8			●
30238736	7.36	79	41	8		M8X1.25	●
30238738	7.38	79	41	8		M8X1.25	●
30238740	7.4	79	41	8			●
30238750	7.5	79	41	8			●
30238752	7.52	79	41	8		M8X1	●
30238754	7.54	79	41	8		M8X1	●
30238760	7.6	79	41	8			●
30238770	7.7	79	41	8			●
30238780	7.8	79	41	8			●
30238790	7.9	79	41	8			●
30238800	8	79	41	8	M9X1		●
30238810	8.1	89	47	10			●
30238820	8.2	89	47	10			●
30238830	8.3	89	47	10			●
30238840	8.4	89	47	10			●
30238850	8.5	89	47	10	M10X1.5		●
30238860	8.6	89	47	10			●
30238870	8.7	89	47	10			●
30238880	8.8	89	47	10			●
30238890	8.9	89	47	10			●
30238900	9	89	47	10	M10X1		●



AD-2D-DIN

高性能无油孔 2D 硬质合金钻头系列



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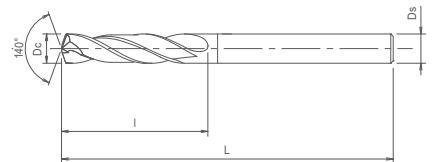
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30238910	9.1	89	47	10			●
30238920	9.2	89	47	10			●
30238924	9.24	89	47	10		M10X1.5	●
30238926	9.26	89	47	10		M10X1.5	●
30238930	9.3	89	47	10			●
30238936	9.36	89	47	10		M10X1.25	●
30238938	9.38	89	47	10		M10X1.25	●
30238940	9.4	89	47	10			●
30238950	9.5	89	47	10	M11X1.5		●
30238952	9.52	89	47	10		M10X1	●
30238954	9.54	89	47	10		M10X1	●
30238960	9.6	89	47	10			●
30238970	9.7	89	47	10			●
30238980	9.8	89	47	10			●
30238990	9.9	89	47	10			●
30239000	10	89	47	10	M11X1		●
30239010	10.1	102	55	12			●
30239020	10.2	102	55	12			●
30239030	10.3	102	55	12			●
30239040	10.4	102	55	12			●
30239050	10.5	102	55	12	M12X1.5		●
30239060	10.6	102	55	12			●
30239070	10.7	102	55	12			●
30239080	10.8	102	55	12			●
30239090	10.9	102	55	12			●
30239100	11	102	55	12	M12X1		●
30239110	11.1	102	55	12		M12X1.75	●
30239120	11.2	102	55	12			●
30239122	11.22	102	55	12		M12X1.5	●
30239124	11.24	102	55	12		M12X1.5	●
30239130	11.3	102	55	12			●
30239136	11.36	102	55	12		M12X1.25	●
30239138	11.38	102	55	12		M12X1.25	●
30239140	11.4	102	55	12			●



AD-2D-DIN

高性能无油孔 2D 硬质合金钻头系列



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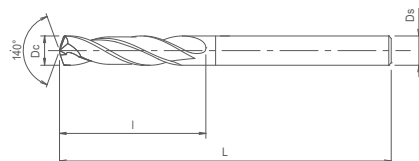
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30239150	11.5	102	55	12		M12X1	●
30239160	11.6	102	55	12			●
30239170	11.7	102	55	12			●
30239180	11.8	102	55	12			●
30239190	11.9	102	55	12			●
30239200	12	102	55	12	M14X2		●
30239210	12.1	107	60	14			●
30239220	12.2	107	60	14			●
30239230	12.3	107	60	14			●
30239240	12.4	107	60	14			●
30239250	12.5	107	60	14	M14X1.5		●
30239260	12.6	107	60	14			●
30239270	12.7	107	60	14			●
30239280	12.8	107	60	14			●
30239290	12.9	107	60	14			●
30239300	13	107	60	14	M14X1	M14X2	●
30239310	13.1	107	60	14			●
30239320	13.2	107	60	14		M14X1.5	●
30239330	13.3	107	60	14		M14X1.5	●
30239340	13.4	107	60	14			●
30239350	13.5	107	60	14	M15X1.5		●
30239360	13.6	107	60	14			●
30239370	13.7	107	60	14			●
30239380	13.8	107	60	14			●
30239390	13.9	107	60	14			●
30239400	14	107	60	14	M16X2		●
30239410	14.1	115	65	16			●
30239420	14.2	115	65	16			●
30239430	14.3	115	65	16			●
30239440	14.4	115	65	16			●
30239450	14.5	115	65	16	M16X1.5		●
30239460	14.6	115	65	16			●
30239470	14.7	115	65	16			●
30239480	14.8	115	65	16			●



AD-2D-DIN

高性能无油孔 2D 硬质合金钻头系列



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*) 表中对应尺寸丝锥仅供参考

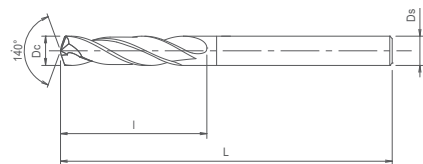
The tap sizes listed in the table are for reference purposes only.

单位: mm Unit: mm

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AD-4D-DIN

高性能无油孔 4D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

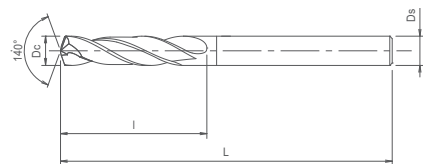
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30240090	0.9	41	9	3		M1x0.25	●
30240100	1	41	9	3			●
30240108	1.08	45	10	3			●
30240110	1.1	45	10	3			●
30240120	1.2	45	11	3			●
30240125	1.25	45	11	3		M1.4x0.3	●
30240127	1.27	45	11	3		M1.4x0.3	●
30240130	1.3	45	11	3			●
30240140	1.4	45	12	3			●
30240145	1.45	45	12	3			●
30240150	1.5	45	12	3		M1.6x0.2	●
30240153	1.53	45	12	3		M1.6x0.2	●
30240160	1.6	45	13	3			●
30240165	1.65	45	13	3			●
30240170	1.7	45	13	3			●
30240175	1.75	45	14	3			●
30240180	1.8	45	14	3		M2x0.4	●
30240183	1.83	45	14	3		M2x0.4	●
30240190	1.9	45	14	3			●
30240200	2	66	20	4			●
30240210	2.1	66	20	4			●
30240220	2.2	66	20	4			●
30240230	2.3	66	20	4			●
30240240	2.4	66	20	4			●
30240250	2.5	66	20	4	M3X0.5		●
30240260	2.6	66	20	4			●
30240270	2.7	66	20	4			●
30240280	2.8	66	20	4			●
30240290	2.9	66	20	4			●
30240300	3	66	28	6			●
30240310	3.1	66	28	6			●
30240320	3.2	66	28	6			●
30240330	3.3	66	28	6	M4X0.7		●
30240340	3.4	66	28	6			●



AD-4D-DIN

高性能无油孔 4D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

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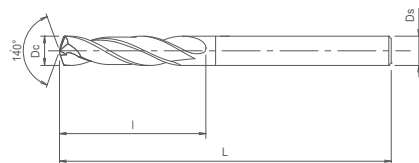
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30240350	3.5	66	28	6			●
30240360	3.6	66	28	6			●
30240370	3.7	66	28	6			●
30240380	3.8	74	36	6			●
30240390	3.9	74	36	6			●
30240400	4	74	36	6			●
30240410	4.1	74	36	6			●
30240420	4.2	74	36	6	M5X0.8		●
30240430	4.3	74	36	6			●
30240440	4.4	74	36	6			●
30240450	4.5	74	36	6			●
30240460	4.6	74	36	6			●
30240470	4.7	74	36	6			●
30240480	4.8	82	44	6			●
30240490	4.9	82	44	6			●
30240500	5	82	44	6	M6X1		●
30240510	5.1	82	44	6			●
30240520	5.2	82	44	6			●
30240530	5.3	82	44	6			●
30240540	5.4	82	44	6			●
30240550	5.5	82	44	6			●
30240560	5.6	82	44	6			●
30240570	5.7	82	44	6			●
30240580	5.8	82	44	6			●
30240590	5.9	82	44	6			●
30240600	6	82	44	6	M7X1		●
30240610	6.1	91	53	8			●
30240620	6.2	91	53	8			●
30240630	6.3	91	53	8			●
30240640	6.4	91	53	8			●
30240650	6.5	91	53	8			●
30240660	6.6	91	53	8			●
30240670	6.7	91	53	8			●
30240680	6.8	91	53	8			●



AD-4D-DIN

高性能无油孔 4D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

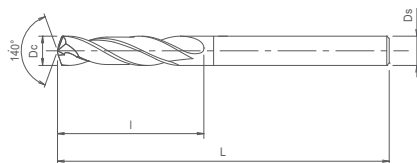
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30240690	6.9	91	53	8			●
30240700	7	91	53	8	M8X1		●
30240710	7.1	91	53	8			●
30240720	7.2	91	53	8			●
30240730	7.3	91	53	8			●
30240740	7.4	91	53	8			●
30240750	7.5	91	53	8			●
30240760	7.6	91	53	8			●
30240770	7.7	91	53	8			●
30240780	7.8	91	53	8			●
30240790	7.9	91	53	8			●
30240800	8	91	53	8	M9X1		●
30240810	8.1	103	61	10			●
30240820	8.2	103	61	10			●
30240830	8.3	103	61	10			●
30240840	8.4	103	61	10			●
30240850	8.5	103	61	10	M10X1.5		●
30240860	8.6	103	61	10			●
30240870	8.7	103	61	10			●
30240880	8.8	103	61	10			●
30240890	8.9	103	61	10			●
30240900	9	103	61	10	M10X1		●
30240910	9.1	103	61	10			●
30240920	9.2	103	61	10			●
30240930	9.3	103	61	10			●
30240940	9.4	103	61	10			●
30240950	9.5	103	61	10	M11X1.5		●
30240960	9.6	103	61	10			●
30240970	9.7	103	61	10			●
30240980	9.8	103	61	10			●
30240990	9.9	103	61	10			●
30241000	10	103	61	10	M11X1		●
30241010	10.1	118	71	12			●
30241020	10.2	118	71	12			●



AD-4D-DIN

高性能无油孔 4D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

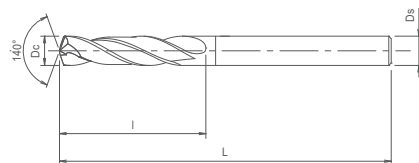
*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30241030	10.3	118	71	12			●
30241040	10.4	118	71	12			●
30241050	10.5	118	71	12	M12X1.5		●
30241060	10.6	118	71	12			●
30241070	10.7	118	71	12			●
30241080	10.8	118	71	12			●
30241090	10.9	118	71	12			●
30241100	11	118	71	12	M12X1		●
30241110	11.1	118	71	12		M12X1.75	●
30241120	11.2	118	71	12			●
30241130	11.3	118	71	12			●
30241140	11.4	118	71	12			●
30241150	11.5	118	71	12		M12X1	●
30241160	11.6	118	71	12			●
30241170	11.7	118	71	12			●
30241180	11.8	118	71	12			●
30241190	11.9	118	71	12			●
30241200	12	118	71	12	M14X2		●
30241210	12.1	124	77	14			●
30241220	12.2	124	77	14			●
30241230	12.3	124	77	14			●
30241240	12.4	124	77	14			●
30241250	12.5	124	77	14	M14X1.5		●
30241260	12.6	124	77	14			●
30241270	12.7	124	77	14			●
30241280	12.8	124	77	14			●
30241290	12.9	124	77	14			●
30241300	13	124	77	14	M14X1	M14X2	●
30241310	13.1	124	77	14			●
30241320	13.2	124	77	14		M14X1.5	●
30241330	13.3	124	77	14		M14X1.5	●
30241340	13.4	124	77	14			●
30241350	13.5	124	77	14	M15X1.5		●
30241360	13.6	124	77	14			●

AD-4D-DIN

高性能无油孔 4D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

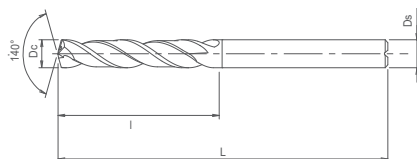
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30241370	13.7	124	77	14			●
30241380	13.8	124	77	14			●
30241390	13.9	124	77	14			●
30241400	14	124	77	14	M16X2		●
30241410	14.1	133	83	16			●
30241420	14.2	133	83	16			●
30241430	14.3	133	83	16			●
30241440	14.4	133	83	16			●
30241450	14.5	133	83	16	M16X1.5		●
30241460	14.6	133	83	16			●
30241470	14.7	133	83	16			●
30241480	14.8	133	83	16			●
30241490	14.9	133	83	16			●
30241500	15	133	83	16		M16X2	●
30241510	15.1	133	83	16			●
30241520	15.2	133	83	16			●
30241530	15.3	133	83	16		M16X1.5	●
30241540	15.4	133	83	16			●
30241550	15.5	133	83	16	M18X2.5		●
30241560	15.6	133	83	16			●
30241570	15.7	133	83	16			●
30241580	15.8	133	83	16			●
30241590	15.9	133	83	16			●
30241600	16	133	83	16	M18X2		●
30241650	16.5	143	93	18	M18X1.5		●
30241700	17	143	93	18			●
30241750	17.5	143	93	18	M20X2.5		●
30241800	18	143	93	18	M20X2		●
30241850	18.5	153	101	20	M20X1.5		●
30241900	19	153	101	20			●
30241950	19.5	153	101	20	M22X2.5		●
30242000	20	153	101	20	M22X2		●



ADO-3D-DIN

高性能内冷油孔 3D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

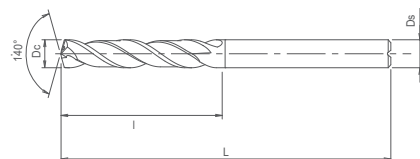
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
8728200	2	66	14	3			●
8728210	2.1	66	14	3			●
8728220	2.2	66	14	3			●
8728230	2.3	66	14	3			●
8728240	2.4	66	14	3			●
8728250	2.5	66	18	3	M3X0.5		●
8728260	2.6	66	18	3			●
8728265	2.65	66	18	3			●
8728270	2.7	66	18	3			●
8728280	2.8	66	18	3			●
8728290	2.9	66	18	3			●
8728300	3	62	20	6			●
8728310	3.1	62	20	6			●
8728315	3.15	62	20	6			●
8728320	3.2	62	20	6			●
8728330	3.3	62	20	6	M4X0.7		●
8728340	3.4	62	20	6			●
8728350	3.5	62	20	6			●
8728360	3.6	62	20	6			●
8728370	3.7	62	20	6			●
8728375	3.75	62	20	6			●
8728380	3.8	66	24	6			●
8728390	3.9	66	24	6			●
8728400	4	66	24	6			●
8728410	4.1	66	24	6			●
8728420	4.2	66	24	6	M5X0.8		●
8728430	4.3	66	24	6			●
8728440	4.4	66	24	6			●
8728450	4.5	66	24	6			●
8728460	4.6	66	24	6			●
8728470	4.7	66	24	6			●
8728480	4.8	66	28	6			●
8728490	4.9	66	28	6			●
8728500	5	66	28	6	M6X1		●



ADO-3D-DIN

高性能内冷油孔 3D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品 (请确认库存)

*) 表中对应尺寸丝锥仅供参考

The tap sizes listed in the table are for reference purposes only.

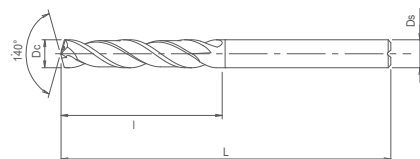
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
8728510	5.1	66	28	6			●
8728520	5.2	66	28	6			●
8728525	5.25	66	28	6	M6X0.75		●
8728530	5.3	66	28	6			●
8728540	5.4	66	28	6			●
8728550	5.5	66	28	6			●
8728560	5.6	66	28	6			●
8728570	5.7	66	28	6			●
8728580	5.8	66	28	6			●
8728590	5.9	66	28	6			●
8728600	6	66	28	6	M7X1		●
8728610	6.1	79	34	8			●
8728620	6.2	79	34	8			●
8728625	6.25	79	34	8	M7X0.75		●
8728630	6.3	79	34	8			●
8728640	6.4	79	34	8			●
8728650	6.5	79	34	8			●
8728660	6.6	79	34	8			●
8728670	6.7	79	34	8			●
8728675	6.75	79	34	8	M8X1.25		●
8728680	6.8	79	34	8			●
8728690	6.9	79	34	8			●
8728700	7	79	34	8	M8X1		●
8728710	7.1	79	41	8			●
8728720	7.2	79	41	8			●
8728725	7.25	79	41	8	M8x0.75		●
8728730	7.3	79	41	8			●
8728740	7.4	79	41	8			●
8728750	7.5	79	41	8			●
8728760	7.6	79	41	8			●
8728770	7.7	79	41	8			●
8728775	7.75	79	41	8	M9X1.25		●
8728780	7.8	79	41	8			●
8728790	7.9	79	41	8			●



ADO-3D-DIN

高性能内冷油孔 3D 硬质合金钻头系列



P Cs0.25%	P C>0.25% Cs0.45%	P C>0.45%	P SCM	K FC	K FCD	H 25~35HRC	H 35~45HRC	H 45~50HRC	M SUS	N AC/ADC
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库存标记: ● 标准库存品 ○ 准标准库存品 (请确认库存)

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

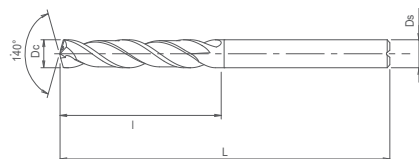
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
8728800	8	79	41	8	M9X1		●
8728810	8.1	89	47	10			●
8728820	8.2	89	47	10			●
8728825	8.25	89	47	10	M9X0.75		●
8728830	8.3	89	47	10			●
8728840	8.4	89	47	10			●
8728850	8.5	89	47	10	M10X1.5		●
8728860	8.6	89	47	10			●
8728870	8.7	89	47	10			●
8728875	8.75	89	47	10	M10X1.25		●
8728880	8.8	89	47	10			●
8728890	8.9	89	47	10			●
8728900	9	89	47	10	M10X1		●
8728910	9.1	89	47	10			●
8728920	9.2	89	47	10			●
8728925	9.25	89	47	10	M10X0.75	M10X1.5	●
8728930	9.3	89	47	10			●
8728940	9.4	89	47	10			●
8728950	9.5	89	47	10	M11X1.5		●
8728960	9.6	89	47	10			●
8728970	9.7	89	47	10			●
8728975	9.75	89	47	10	M11x1.25		●
8728980	9.8	89	47	10			●
8728990	9.9	89	47	10			●
8729000	10	89	47	10	M11X1		●
8729010	10.1	102	55	12			●
8729020	10.2	102	55	12			●
8729025	10.25	102	55	12	M12X1.75		●
8729030	10.3	102	55	12			●
8729040	10.4	102	55	12			●
8729050	10.5	102	55	12	M12X1.5		●
8729060	10.6	102	55	12			●
8729070	10.7	102	55	12			●
8729075	10.75	102	55	12	M12X1.25		●



ADO-3D-DIN

高性能内冷油孔 3D 硬质合金钻头系列



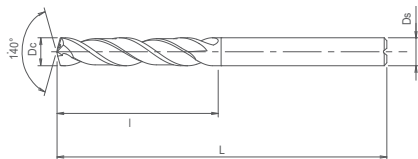
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
8729080	10.8	102	55	12			●
8729090	10.9	102	55	12			●
8729100	11	102	55	12	M12X1		●
8729110	11.1	102	55	12		M12X1.75	●
8729120	11.2	102	55	12			●
8729130	11.3	102	55	12			●
8729140	11.4	102	55	12			●
8729150	11.5	102	55	12		M12X1	●
8729160	11.6	102	55	12			●
8729170	11.7	102	55	12			●
8729180	11.8	102	55	12			●
8729190	11.9	102	55	12			●
8729200	12	102	55	12	M14X2		●
8729210	12.1	107	60	14			●
8729220	12.2	107	60	14			●
8729230	12.3	107	60	14			●
8729240	12.4	107	60	14			●
8729250	12.5	107	60	14	M14X1.5		●
8729260	12.6	107	60	14			●
8729270	12.7	107	60	14			●
8729275	12.75	107	60	14	M14X1.25		●
8729280	12.8	107	60	14			●
8729290	12.9	107	60	14			●
8729300	13	107	60	14	M14X1	M14X2	●
8729310	13.1	107	60	14			●
8729320	13.2	107	60	14		M14X1.5	●
8729330	13.3	107	60	14		M14X1.5	●
8729340	13.4	107	60	14			●
8729350	13.5	107	60	14	M15X1.5		●
8729360	13.6	107	60	14			●
8729370	13.7	107	60	14			●
8729380	13.8	107	60	14			●
8729390	13.9	107	60	14			●
8729400	14	107	60	14	M16X2		●



ADO-3D-DIN

高性能内冷油孔 3D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品 (请确认库存)

*) 表中对应尺寸丝锥仅供参考

The tap sizes listed in the table are for reference purposes only.

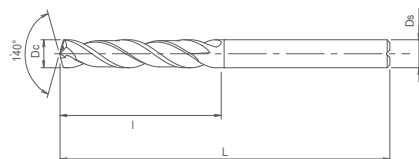
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
8729410	14.1	115	65	16	M16X1.5		●
8729420	14.2	115	65	16			●
8729430	14.3	115	65	16			●
8729440	14.4	115	65	16			●
8729450	14.5	115	65	16			●
8729460	14.6	115	65	16			●
8729470	14.7	115	65	16			●
8729480	14.8	115	65	16			●
8729490	14.9	115	65	16			●
8729500	15	115	65	16		M16X2	●
8729510	15.1	115	65	16			●
8729520	15.2	115	65	16			●
8729530	15.3	115	65	16		M16X1.5	●
8729540	15.4	115	65	16	M18X2.5		●
8729550	15.5	115	65	16			●
8729560	15.6	115	65	16			●
8729570	15.7	115	65	16			●
8729580	15.8	115	65	16			●
8729590	15.9	115	65	16			●
8729600	16	115	65	16	M18X2		●
8729650	16.5	123	73	18	M18X1.5		●
8729700	17	123	73	18			●
8729750	17.5	123	73	18	M20X2.5		●
8729800	18	123	73	18	M20X2		●
8729850	18.5	131	79	20	M20X1.5		●
8729900	19	131	79	20			●
8729950	19.5	131	79	20	M22X2.5		●
8730000	20	131	79	20	M22X2		●



ADO-5D-DIN

高性能内冷油孔 5D 硬质合金钻头系列



库存标记: ● 标准库存品 ○ 非标准库存品 (请确认库存)

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

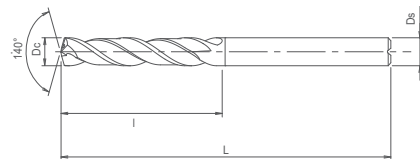
单位: mm Unit: mm

EDP No.	刃径 D_c	全长 L	槽长 l	柄径 D_s	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
8730200	2	66	20	3			●
8730210	2.1	66	20	3			●
8730220	2.2	66	20	3			●
8730230	2.3	66	20	3			●
8730240	2.4	66	20	3			●
8730250	2.5	66	24	3	M3X0.5		●
8730260	2.6	66	24	3			●
8730265	2.65	66	24	3			●
8730276	2.76	66	24	3		M3X0.5	●
8730278	2.78	66	24	3		M3X0.5	●
8730280	2.8	66	24	3			●
8730290	2.9	66	24	3			●
8730300	3	66	28	6			●
8730310	3.1	66	28	6			●
8730315	3.15	66	28	6			●
8730320	3.2	66	28	6			●
8730330	3.3	66	28	6	M4X0.7		●
8730340	3.4	66	28	6			●
8730350	3.5	66	28	6			●
8730360	3.6	66	28	6			●
8730366	3.66	66	28	6		M4X0.7	●
8730368	3.68	66	28	6		M4X0.7	●
8730370	3.7	66	28	6			●
8730375	3.75	66	28	6			●
8730380	3.8	74	36	6			●
8730390	3.9	74	36	6			●
8730400	4	74	36	6			●
8730410	4.1	74	36	6			●
8730420	4.2	74	36	6	M5X0.8		●
8730430	4.3	74	36	6			●
8730440	4.4	74	36	6			●
8730450	4.5	74	36	6			●
8730460	4.6	74	36	6			●
8730462	4.62	74	36	6		M5X0.8	●



ADO-5D-DIN

高性能内冷油孔 5D 硬质合金钻头系列



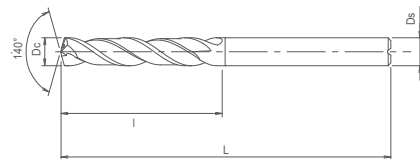
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
8730464	4.64	74	36	6		M5X0.8	●
8730470	4.7	74	36	6			●
8730480	4.8	82	44	6			●
8730490	4.9	82	44	6			●
8730500	5	82	44	6	M6X1		●
8730510	5.1	82	44	6			●
8730520	5.2	82	44	6			●
8730525	5.25	82	44	6	M6X0.75		●
8730530	5.3	82	44	6			●
8730540	5.4	82	44	6			●
8730550	5.5	82	44	6			●
8730552	5.52	82	44	6		M6X1	●
8730554	5.54	82	44	6		M6X1	●
8730560	5.6	82	44	6			●
8730570	5.7	82	44	6			●
8730580	5.8	82	44	6			●
8730590	5.9	82	44	6			●
8730600	6	82	44	6	M7X1		●
8730610	6.1	91	53	8			●
8730620	6.2	91	53	8			●
8730625	6.25	91	53	8	M7X0.75		●
8730630	6.3	91	53	8			●
8730640	6.4	91	53	8			●
8730650	6.5	91	53	8			●
8730660	6.6	91	53	8			●
8730670	6.7	91	53	8			●
8730675	6.75	91	53	8	M8X1.25		●
8730680	6.8	91	53	8			●
8730690	6.9	91	53	8			●
8730700	7	91	53	8	M8X1		●
8730710	7.1	91	53	8			●
8730720	7.2	91	53	8			●
8730725	7.25	91	53	8	M8x0.75		●
8730730	7.3	91	53	8			●



ADO-5D-DIN

高性能内冷油孔 5D 硬质合金钻头系列



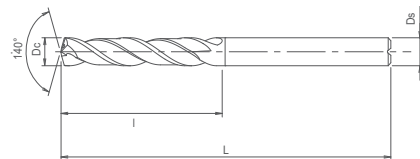
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
8730736	7.36	91	53	8		M8X1.25	●
8730738	7.38	91	53	8		M8X1.25	●
8730740	7.4	91	53	8			●
8730750	7.5	91	53	8			●
8730752	7.52	91	53	8		M8X1	●
8730754	7.54	91	53	8		M8X1	●
8730760	7.6	91	53	8			●
8730770	7.7	91	53	8			●
8730775	7.75	91	53	8	M9X1.25		●
8730780	7.8	91	53	8			●
8730790	7.9	91	53	8			●
8730800	8	91	53	8	M9X1		●
8730810	8.1	103	61	10			●
8730820	8.2	103	61	10			●
8730825	8.25	103	61	10	M9X0.75		●
8730830	8.3	103	61	10			●
8730840	8.4	103	61	10			●
8730850	8.5	103	61	10	M10X1.5		●
8730860	8.6	103	61	10			●
8730870	8.7	103	61	10			●
8730875	8.75	103	61	10	M10X1.25		●
8730880	8.8	103	61	10			●
8730890	8.9	103	61	10			●
8730900	9	103	61	10	M10X1		●
8730910	9.1	103	61	10			●
8730920	9.2	103	61	10			●
8730924	9.24	103	61	10		M10X1.5	●
8730925	9.25	103	61	10	M10X0.75	M10X1.5	●
8730926	9.26	103	61	10		M10X1.5	●
8730930	9.3	103	61	10			●
8730936	9.36	103	61	10		M10X1.25	●
8730938	9.38	103	61	10		M10X1.25	●
8730940	9.4	103	61	10			●
8730950	9.5	103	61	10	M11X1.5		●



ADO-5D-DIN

高性能内冷油孔 5D 硬质合金钻头系列



P C≤0.25%	P C>0.25% C≤0.45%	P C>0.45%	P SCM	K FC	K FCD	H 25~35HRC	H 35~45HRC	H 45~50HRC	M SUS	N AC/ADC
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库存标记：● 标准库存品 ○ 非标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

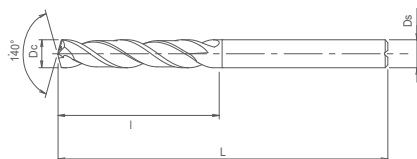
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
8730952	9.52	103	61	10		M10X1	●
8730954	9.54	103	61	10		M10X1	●
8730960	9.6	103	61	10			●
8730970	9.7	103	61	10			●
8730975	9.75	103	61	10	M11x1.25		●
8730980	9.8	103	61	10			●
8730990	9.9	103	61	10			●
8731000	10	103	61	10	M11X1		●
8731010	10.1	118	71	12			●
8731020	10.2	118	71	12			●
8731025	10.25	118	71	12	M12X1.75		●
8731030	10.3	118	71	12			●
8731040	10.4	118	71	12			●
8731050	10.5	118	71	12	M12X1.5		●
8731060	10.6	118	71	12			●
8731070	10.7	118	71	12			●
8731075	10.75	118	71	12	M12X1.25		●
8731080	10.8	118	71	12			●
8731090	10.9	118	71	12			●
8731100	11	118	71	12	M12X1		●
8731110	11.1	118	71	12		M12X1.75	●
8731120	11.2	118	71	12			●
8731122	11.22	118	71	12		M12X1.5	●
8731124	11.24	118	71	12		M12X1.5	●
8731130	11.3	118	71	12			●
8731136	11.36	118	71	12		M12X1.25	●
8731138	11.38	118	71	12		M12X1.25	●
8731140	11.4	118	71	12			●
8731150	11.5	118	71	12		M12X1	●
8731160	11.6	118	71	12			●
8731170	11.7	118	71	12			●
8731180	11.8	118	71	12			●
8731190	11.9	118	71	12			●
8731200	12	118	71	12	M14X2		●



ADO-5D-DIN

高性能内冷油孔 5D 硬质合金钻头系列



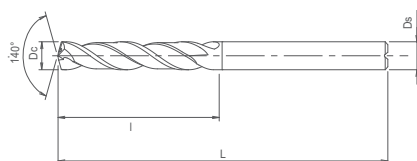
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
8731210	12.1	124	77	14			●
8731220	12.2	124	77	14			●
8731230	12.3	124	77	14			●
8731240	12.4	124	77	14			●
8731250	12.5	124	77	14	M14X1.5		●
8731260	12.6	124	77	14			●
8731270	12.7	124	77	14			●
8731275	12.75	124	77	14	M14X1.25		●
8731280	12.8	124	77	14			●
8731290	12.9	124	77	14			●
8731300	13	124	77	14	M14X1	M14X2	●
8731310	13.1	124	77	14			●
8731320	13.2	124	77	14		M14X1.5	●
8731325	13.25	124	77	14		M14X1.5	●
8731330	13.3	124	77	14		M14X1.5	●
8731340	13.4	124	77	14			●
8731350	13.5	124	77	14	M15X1.5		●
8731360	13.6	124	77	14			●
8731370	13.7	124	77	14			●
8731380	13.8	124	77	14			●
8731390	13.9	124	77	14			●
8731400	14	124	77	14	M16X2		●
8731410	14.1	133	83	16			●
8731420	14.2	133	83	16			●
8731430	14.3	133	83	16			●
8731440	14.4	133	83	16			●
8731450	14.5	133	83	16	M16X1.5		●
8731460	14.6	133	83	16			●
8731470	14.7	133	83	16			●
8731480	14.8	133	83	16			●
8731490	14.9	133	83	16			●
8731500	15	133	83	16		M16X2	●
8731510	15.1	133	83	16			●
8731520	15.2	133	83	16			●



ADO-5D-DIN

高性能内冷油孔 5D 硬质合金钻头系列



库存标记: ● 标准库存品 ○ 准标准库存品 (请确认库存)

*) 表中对应尺寸丝锥仅供参考

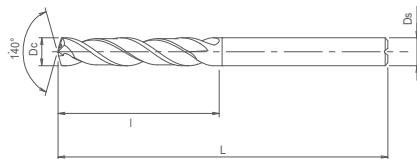
The tap sizes listed in the table are for reference purposes only

单位: mm Unit: mm

[illegible]

ADO-8D-DIN

高性能内冷油孔 8D 硬质合金钻头系列



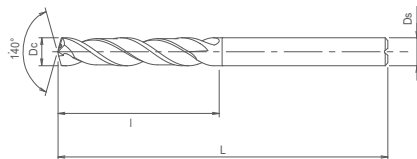
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30243030	3	76	33	6			●
30243031	3.1	76	34	6			●
30243032	3.2	76	35	6			●
30243033	3.3	76	36	6	M4X0.7		●
30243034	3.4	81	37	6			●
30243035	3.5	81	39	6			●
30243036	3.6	81	40	6			●
30243037	3.7	81	41	6			●
30243038	3.8	86	42	6			●
30243039	3.9	86	43	6			●
30243040	4	86	44	6			●
30243041	4.1	86	45	6			●
30243042	4.2	86	46	6	M5X0.8		●
30243043	4.3	92	47	6			●
30243044	4.4	92	48	6			●
30243045	4.5	92	50	6			●
30243046	4.6	92	51	6			●
30243047	4.7	92	52	6			●
30243048	4.8	95	53	6			●
30243049	4.9	95	54	6			●
30243050	5	95	55	6	M6X1		●
30243051	5.1	106	56	6			●
30243052	5.2	106	57	6			●
30243053	5.3	106	58	6			●
30243054	5.4	106	59	6			●
30243055	5.5	106	61	6			●
30243056	5.6	106	62	6			●
30243057	5.7	106	63	6			●
30243058	5.8	106	64	6			●
30243059	5.9	106	65	6			●
30243060	6	106	66	6	M7X1		●
30243061	6.1	117	67	8			●
30243062	6.2	117	68	8			●
30243063	6.3	117	69	8			●



ADO-8D-DIN

高性能内冷油孔 8D 硬质合金钻头系列



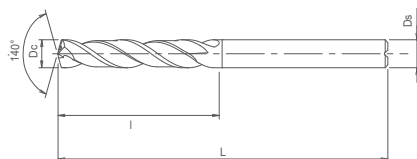
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30243064	6.4	117	70	8			●
30243065	6.5	117	72	8			●
30243066	6.6	117	73	8			●
30243067	6.7	117	74	8			●
30243068	6.8	117	75	8			●
30243069	6.9	117	76	8			●
30243070	7	117	77	8	M8X1		●
30243071	7.1	128	78	8			●
30243072	7.2	128	79	8			●
30243073	7.3	128	80	8			●
30243074	7.4	128	81	8			●
30243075	7.5	128	83	8			●
30243076	7.6	128	84	8			●
30243077	7.7	128	85	8			●
30243078	7.8	128	86	8			●
30243079	7.9	128	87	8			●
30243080	8	128	88	8	M9X1		●
30243081	8.1	142	89	10			●
30243082	8.2	142	90	10			●
30243083	8.3	142	91	10			●
30243084	8.4	142	92	10			●
30243085	8.5	142	94	10	M10X1.5		●
30243086	8.6	142	95	10			●
30243087	8.7	142	96	10			●
30243088	8.8	142	97	10			●
30243089	8.9	142	98	10			●
30243090	9	142	99	10	M10X1		●
30243091	9.1	153	100	10			●
30243092	9.2	153	101	10			●
30243093	9.3	153	102	10			●
30243094	9.4	153	103	10			●
30243095	9.5	153	105	10	M11X1.5		●
30243096	9.6	153	106	10			●
30243097	9.7	153	107	10			●



ADO-8D-DIN

高性能内冷油孔 8D 硬质合金钻头系列



库存标记: ● 标准库存品 ○ 准标准库存品 (请确认库存)

*) 表中对应尺寸丝锥仅供参考

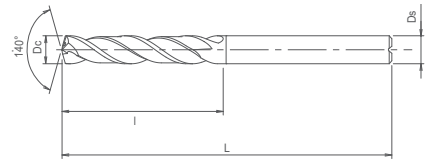
The tap sizes listed in the table are for reference purposes only.

单位: mm Unit: mm

[illegible]

ADO-10D-DIN

高性能内冷油孔 10D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 非标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

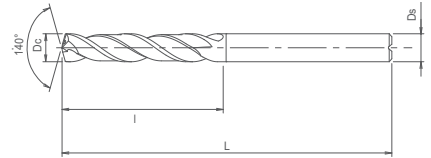
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	库存 Stock
30253300	3	89	48	6	●
30253310	3.1	89	48	6	○
30253320	3.2	89	48	6	○
30253330	3.3	89	48	6	○
30253340	3.4	89	48	6	○
30253350	3.5	101	60	6	●
30253360	3.6	101	60	6	○
30253370	3.7	101	60	6	○
30253380	3.8	101	60	6	○
30253390	3.9	101	60	6	○
30253400	4	101	60	6	●
30253410	4.1	101	60	6	○
30253420	4.2	101	60	6	○
30253430	4.3	108	68	6	○
30253440	4.4	108	68	6	○
30253450	4.5	108	68	6	●
30253460	4.6	108	68	6	○
30253470	4.7	108	68	6	○
30253480	4.8	115	75	6	○
30253490	4.9	115	75	6	○
30253500	5	115	75	6	●
30253510	5.1	115	75	6	○
30253520	5.2	115	75	6	○
30253530	5.3	115	75	6	○
30253540	5.4	125	86	6	○
30253550	5.5	125	86	6	●
30253560	5.6	125	86	6	○
30253570	5.7	125	86	6	○
30253580	5.8	125	86	6	○
30253590	5.9	125	86	6	○
30253600	6	125	86	6	●
30253610	6.1	140	100	8	○
30253620	6.2	140	100	8	○
30253630	6.3	140	100	8	○



ADO-10D-DIN

高性能内冷油孔 10D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 非标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

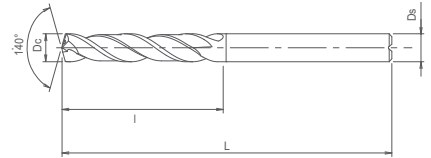
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	库存 Stock
30253640	6.4	140	100	8	○
30253650	6.5	140	100	8	●
30253660	6.6	140	100	8	○
30253670	6.7	140	100	8	○
30253680	6.8	140	100	8	○
30253690	6.9	140	100	8	○
30253700	7	140	100	8	●
30253710	7.1	160	120	8	○
30253720	7.2	160	120	8	○
30253730	7.3	160	120	8	○
30253740	7.4	160	120	8	○
30253750	7.5	160	120	8	●
30253760	7.6	160	120	8	○
30253770	7.7	160	120	8	○
30253780	7.8	160	120	8	○
30253790	7.9	160	120	8	○
30253800	8	160	120	8	●
30253810	8.1	179	135	10	○
30253820	8.2	179	135	10	○
30253830	8.3	179	135	10	○
30253840	8.4	179	135	10	○
30253850	8.5	179	135	10	●
30253860	8.6	179	135	10	○
30253870	8.7	179	135	10	○
30253880	8.8	179	135	10	○
30253890	8.9	179	135	10	○
30253900	9	179	135	10	●
30253910	9.1	194	150	10	○
30253920	9.2	194	150	10	○
30253930	9.3	194	150	10	○
30253940	9.4	194	150	10	○
30253950	9.5	194	150	10	●
30253960	9.6	194	150	10	○
30253970	9.7	194	150	10	○



ADO-10D-DIN

高性能内冷油孔 10D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 非标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

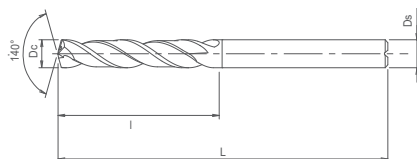
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	库存 Stock
30253980	9.8	194	150	10	○
30253990	9.9	194	150	10	○
30254000	10	194	150	10	●
30254010	10.1	214	165	12	○
30254020	10.2	214	165	12	○
30254030	10.3	214	165	12	○
30254040	10.4	214	165	12	○
30254050	10.5	214	165	12	●
30254060	10.6	214	165	12	○
30254070	10.7	214	165	12	○
30254080	10.8	214	165	12	○
30254090	10.9	214	165	12	○
30254100	11	214	165	12	●
30254110	11.1	230	180	12	○
30254120	11.2	230	180	12	○
30254130	11.3	230	180	12	○
30254140	11.4	230	180	12	○
30254150	11.5	230	180	12	●
30254160	11.6	230	180	12	○
30254170	11.7	230	180	12	○
30254180	11.8	230	180	12	○
30254190	11.9	230	180	12	○
30254200	12	230	180	12	●
30254210	12.1	242	195	14	○
30254220	12.2	242	195	14	○
30254230	12.3	242	195	14	○
30254240	12.4	242	195	14	○
30254250	12.5	242	195	14	●
30254260	12.6	242	195	14	○
30254270	12.7	242	195	14	○
30254280	12.8	242	195	14	○
30254290	12.9	242	195	14	○
30254300	13	242	195	14	●
30254310	13.1	260	210	14	○



ADO-10D-DIN

高性能内冷油孔 10D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

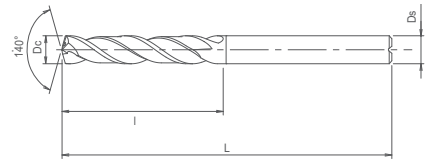
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	库存 Stock
30254320	13.2	260	210	14	○
30254330	13.3	260	210	14	○
30254340	13.4	260	210	14	○
30254350	13.5	260	210	14	●
30254360	13.6	260	210	14	○
30254370	13.7	260	210	14	○
30254380	13.8	260	210	14	○
30254390	13.9	260	210	14	○
30254400	14	260	210	14	●
30254410	14.1	275	225	16	○
30254420	14.2	275	225	16	○
30254430	14.3	275	225	16	○
30254440	14.4	275	225	16	○
30254450	14.5	275	225	16	●
30254460	14.6	275	225	16	○
30254470	14.7	275	225	16	○
30254480	14.8	275	225	16	○
30254490	14.9	275	225	16	○
30254500	15	275	225	16	●
30254510	15.1	290	240	16	○
30254520	15.2	290	240	16	○
30254530	15.3	290	240	16	○
30254540	15.4	290	240	16	○
30254550	15.5	290	240	16	●
30254560	15.6	290	240	16	○
30254570	15.7	290	240	16	○
30254580	15.8	290	240	16	○
30254590	15.9	290	240	16	○
30254600	16	290	240	16	●



ADO-15D-DIN

高性能内冷油孔 15D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 非标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

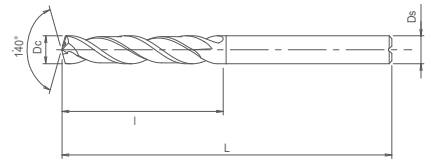
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	库存 Stock
30255300	3	101	60	6	●
30255310	3.1	101	60	6	○
30255320	3.2	101	60	6	○
30255330	3.3	101	60	6	○
30255340	3.4	101	60	6	○
30255350	3.5	116	75	6	●
30255360	3.6	116	75	6	○
30255370	3.7	116	75	6	○
30255380	3.8	116	75	6	○
30255390	3.9	116	75	6	○
30255400	4	116	75	6	●
30255410	4.1	116	75	6	○
30255420	4.2	116	75	6	○
30255430	4.3	125	85	6	○
30255440	4.4	125	85	6	○
30255450	4.5	125	85	6	●
30255460	4.6	125	85	6	○
30255470	4.7	125	85	6	○
30255480	4.8	135	95	6	○
30255490	4.9	135	95	6	○
30255500	5	135	95	6	●
30255510	5.1	135	95	6	○
30255520	5.2	135	95	6	○
30255530	5.3	135	95	6	○
30255540	5.4	149	110	6	○
30255550	5.5	149	110	6	●
30255560	5.6	149	110	6	○
30255570	5.7	149	110	6	○
30255580	5.8	149	110	6	○
30255590	5.9	149	110	6	○
30255600	6	149	110	6	●
30255610	6.1	165	125	8	○
30255620	6.2	165	125	8	○
30255630	6.3	165	125	8	○



ADO-15D-DIN

高性能内冷油孔 15D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 非标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

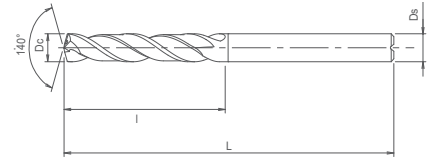
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	库存 Stock
30255640	6.4	165	125	8	○
30255650	6.5	165	125	8	●
30255660	6.6	165	125	8	○
30255670	6.7	165	125	8	○
30255680	6.8	165	125	8	○
30255690	6.9	165	125	8	○
30255700	7	165	125	8	●
30255710	7.1	185	145	8	○
30255720	7.2	185	145	8	○
30255730	7.3	185	145	8	○
30255740	7.4	185	145	8	○
30255750	7.5	185	145	8	●
30255760	7.6	185	145	8	○
30255770	7.7	185	145	8	○
30255780	7.8	185	145	8	○
30255790	7.9	185	145	8	○
30255800	8	185	145	8	●
30255810	8.1	204	160	10	○
30255820	8.2	204	160	10	○
30255830	8.3	204	160	10	○
30255840	8.4	204	160	10	○
30255850	8.5	204	160	10	●
30255860	8.6	204	160	10	○
30255870	8.7	204	160	10	○
30255880	8.8	204	160	10	○
30255890	8.9	204	160	10	○
30255900	9	204	160	10	●
30255910	9.1	224	180	10	○
30255920	9.2	224	180	10	○
30255930	9.3	224	180	10	○
30255940	9.4	224	180	10	○
30255950	9.5	224	180	10	●
30255960	9.6	224	180	10	○
30255970	9.7	224	180	10	○



ADO-15D-DIN

高性能内冷油孔 15D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 非标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

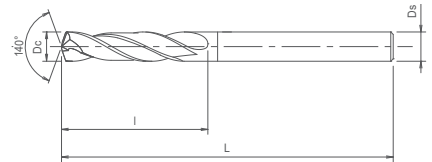
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	库存 Stock
30255980	9.8	224	180	10	○
30255990	9.9	224	180	10	○
30256000	10	224	180	10	●
30256010	10.1	249	200	12	○
30256020	10.2	249	200	12	○
30256030	10.3	249	200	12	○
30256040	10.4	249	200	12	○
30256050	10.5	249	200	12	●
30256060	10.6	249	200	12	○
30256070	10.7	249	200	12	○
30256080	10.8	249	200	12	○
30256090	10.9	249	200	12	○
30256100	11	249	200	12	●
30256110	11.1	265	215	12	○
30256120	11.2	265	215	12	○
30256130	11.3	265	215	12	○
30256140	11.4	265	215	12	○
30256150	11.5	265	215	12	●
30256160	11.6	265	215	12	○
30256170	11.7	265	215	12	○
30256180	11.8	265	215	12	○
30256190	11.9	265	215	12	○
30256200	12	265	215	12	●
30256210	12.1	295	248	14	○
30256220	12.2	295	248	14	○
30256230	12.3	295	248	14	○
30256240	12.4	295	248	14	○
30256250	12.5	295	248	14	●
30256260	12.6	295	248	14	○
30256270	12.7	295	248	14	○
30256280	12.8	295	248	14	○
30256290	12.9	295	248	14	○
30256300	13	295	248	14	●



AD-2D-DIN Type-S

高刚性型无油孔 2D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

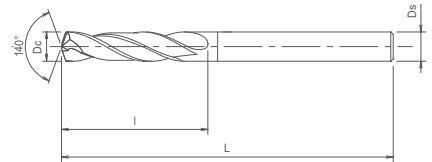
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30245200	2	45	10	4			●
30245210	2.1	45	10	4			○
30245220	2.2	45	11	4			●
30245230	2.3	45	11	4			●
30245240	2.4	45	12	4			●
30245250	2.5	45	12	4	M3X0.5		●
30245260	2.6	45	12	4			●
30245270	2.7	45	14	4			○
30245278	2.78	45	14	4		M3X0.5	●
30245280	2.8	45	14	4		M3X0.5	●
30245290	2.9	45	14	4			○
30245300	3	62	20	6			●
30245310	3.1	62	20	6			●
30245320	3.2	62	20	6			●
30245330	3.3	62	20	6	M4X0.7		●
30245340	3.4	62	20	6			●
30245350	3.5	62	20	6			●
30245360	3.6	62	20	6			○
30245368	3.68	62	20	6		M4X0.7	●
30245370	3.7	62	20	6		M4X0.7	○
30245380	3.8	66	24	6			●
30245390	3.9	66	24	6			●
30245400	4	66	24	6			●
30245410	4.1	66	24	6			●
30245420	4.2	66	24	6	M5X0.8		●
30245430	4.3	66	24	6			●
30245440	4.4	66	24	6			○
30245450	4.5	66	24	6			●
30245460	4.6	66	24	6		M5X0.8	○
30245464	4.64	66	24	6		M5X0.8	●
30245470	4.7	66	24	6			○
30245480	4.8	66	28	6			○
30245490	4.9	66	28	6			●
30245500	5	66	28	6	M6X1		●



AD-2D-DIN Type-S

高刚性型无油孔 2D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

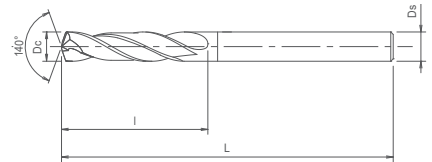
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30245510	5.1	66	28	6			●
30245520	5.2	66	28	6			●
30245530	5.3	66	28	6			○
30245540	5.4	66	28	6			○
30245550	5.5	66	28	6		M6X1	●
30245554	5.54	66	28	6		M6X1	●
30245560	5.6	66	28	6			●
30245570	5.7	66	28	6			○
30245580	5.8	66	28	6			●
30245590	5.9	66	28	6			○
30245600	6	66	28	6	M7X1		●
30245610	6.1	79	34	8			○
30245620	6.2	79	34	8			○
30245630	6.3	79	34	8			○
30245640	6.4	79	34	8			○
30245650	6.5	79	34	8			●
30245660	6.6	79	34	8			○
30245670	6.7	79	34	8			○
30245680	6.8	79	34	8			●
30245690	6.9	79	34	8			●
30245700	7	79	34	8	M8X1		●
30245710	7.1	79	41	8			○
30245720	7.2	79	41	8			○
30245730	7.3	79	41	8			○
30245738	7.38	79	41	8		M8X1.25	●
30245740	7.4	79	41	8			●
30245750	7.5	79	41	8		M8X1	●
30245754	7.54	79	41	8		M8X1	○
30245760	7.6	79	41	8			○
30245770	7.7	79	41	8			○
30245780	7.8	79	41	8			○
30245790	7.9	79	41	8			○
30245800	8	79	41	8	M9X1		●
30245810	8.1	89	47	10			○



AD-2D-DIN Type-S

高刚性型无油孔 2D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

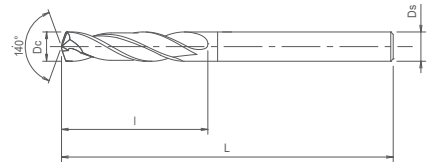
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30245820	8.2	89	47	10			○
30245830	8.3	89	47	10			○
30245840	8.4	89	47	10			○
30245850	8.5	89	47	10	M10X1.5		●
30245860	8.6	89	47	10			●
30245870	8.7	89	47	10			○
30245880	8.8	89	47	10			●
30245890	8.9	89	47	10			○
30245900	9	89	47	10	M10X1		●
30245910	9.1	89	47	10			○
30245920	9.2	89	47	10		M10X1.5	○
30245926	9.26	89	47	10		M10X1.5	○
30245930	9.3	89	47	10			○
30245940	9.4	89	47	10		M10X1.25	○
30245950	9.5	89	47	10	M11X1.5	M10X1	○
30245954	9.54	89	47	10		M10X1	○
30245960	9.6	89	47	10			○
30245970	9.7	89	47	10			○
30245980	9.8	89	47	10			○
30245990	9.9	89	47	10			○
30246000	10	89	47	10	M11X1		●
30246010	10.1	102	55	12			○
30246020	10.2	102	55	12			●
30246030	10.3	102	55	12			●
30246040	10.4	102	55	12			○
30246050	10.5	102	55	12	M12X1.5		●
30246060	10.6	102	55	12			●
30246070	10.7	102	55	12			○
30246080	10.8	102	55	12			○
30246090	10.9	102	55	12			○
30246100	11	102	55	12	M12X1		●
30246110	11.1	102	55	12		M12X1.75	○
30246120	11.2	102	55	12		M12X1.5	○
30246130	11.3	102	55	12			○



AD-2D-DIN Type-S

高刚性型无油孔 2D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

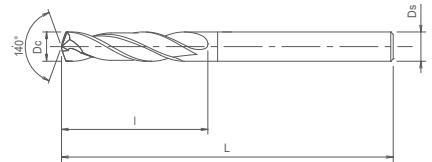
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30246140	11.4	102	55	12		M12X1.25	○
30246150	11.5	102	55	12		M12X1	○
30246160	11.6	102	55	12			○
30246170	11.7	102	55	12			●
30246180	11.8	102	55	12			○
30246190	11.9	102	55	12			○
30246200	12	102	55	12	M14X2		●
30246210	12.1	107	60	14			○
30246220	12.2	107	60	14			○
30246230	12.3	107	60	14			○
30246240	12.4	107	60	14			○
30246250	12.5	107	60	14	M14X1.5		○
30246260	12.6	107	60	14			●
30246270	12.7	107	60	14			○
30246280	12.8	107	60	14			○
30246290	12.9	107	60	14			○
30246300	13	107	60	14	M14X1	M14X2	●
30246310	13.1	107	60	14			○
30246320	13.2	107	60	14		M14X1.5	○
30246330	13.3	107	60	14		M14X1.5	○
30246340	13.4	107	60	14			○
30246350	13.5	107	60	14	M15X1.5		○
30246360	13.6	107	60	14			○
30246370	13.7	107	60	14			○
30246380	13.8	107	60	14			○
30246390	13.9	107	60	14			○
30246400	14	107	60	14	M16X2		●
30246410	14.1	115	65	16			○
30246420	14.2	115	65	16			○
30246430	14.3	115	65	16			○
30246440	14.4	115	65	16			○
30246450	14.5	115	65	16	M16X1.5		○
30246460	14.6	115	65	16			○
30246470	14.7	115	65	16			○



AD-2D-DIN Type-S

高刚性型无油孔 2D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 非标准库存品（请确认库存）

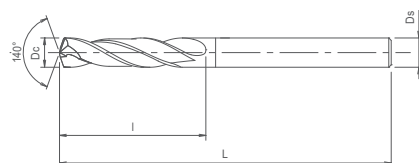
*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30246480	14.8	115	65	16			○
30246490	14.9	115	65	16			○
30246500	15	115	65	16		M16X2	●
30246510	15.1	115	65	16			○
30246520	15.2	115	65	16			○
30246530	15.3	115	65	16		M16X1.5	○
30246540	15.4	115	65	16			○
30246550	15.5	115	65	16	M18X2.5		○
30246560	15.6	115	65	16			○
30246570	15.7	115	65	16			○
30246580	15.8	115	65	16			○
30246590	15.9	115	65	16			○
30246600	16	115	65	16	M18X2		●
30246610	16.1	123	73	18			○
30246620	16.2	123	73	18			○
30246630	16.3	123	73	18			○
30246640	16.4	123	73	18			○
30246650	16.5	123	73	18	M18X1.5		○
30246660	16.6	123	73	18			○
30246670	16.7	123	73	18			○
30246680	16.8	123	73	18		M18X2.5	○
30246690	16.9	123	73	18			○
30246700	17	123	73	18			○
30246710	17.1	123	73	18			○
30246720	17.2	123	73	18			○
30246730	17.3	123	73	18		M18x1.5	○
30246740	17.4	123	73	18			○
30246750	17.5	123	73	18	M20X2.5		○
30246760	17.6	123	73	18			○
30246770	17.7	123	73	18	M20X2.5		○
30246780	17.8	123	73	18			○
30246790	17.9	123	73	18			○
30246800	18	123	73	18	M20X2		○
30246810	18.1	131	79	20			○



高刚性型无油孔 2D 硬质合金钻头系列



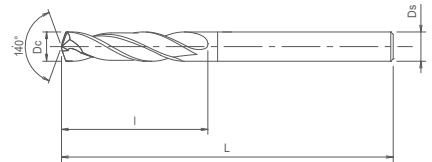
The tap sizes listed in the table are for reference purposes only.

单位: mm Unit: mm



AD-4D-DIN Type-S

高刚性型无油孔 4D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

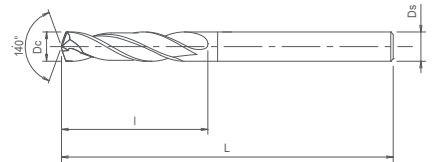
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30247200	2	55	18	4			●
30247210	2.1	55	18	4			○
30247220	2.2	55	19	4			○
30247230	2.3	55	19	4			●
30247240	2.4	55	20	4			○
30247250	2.5	55	20	4	M3X0.5		●
30247260	2.6	55	20	4			○
30247270	2.7	55	22	4			○
30247278	2.78	55	22	4		M3X0.5	○
30247280	2.8	55	22	4		M3X0.5	●
30247290	2.9	55	22	4			○
30247300	3	66	28	6			●
30247310	3.1	66	28	6			○
30247320	3.2	66	28	6			○
30247330	3.3	66	28	6	M4X0.7		●
30247340	3.4	66	28	6			●
30247350	3.5	66	28	6			●
30247360	3.6	66	28	6			●
30247368	3.68	66	28	6		M4X0.7	○
30247370	3.7	66	28	6		M4X0.7	○
30247380	3.8	74	36	6			○
30247390	3.9	74	36	6			●
30247400	4	74	36	6			●
30247410	4.1	74	36	6			○
30247420	4.2	74	36	6	M5X0.8		●
30247430	4.3	74	36	6			●
30247440	4.4	74	36	6			●
30247450	4.5	74	36	6			●
30247460	4.6	74	36	6		M5X0.8	●
30247464	4.64	74	36	6		M5X0.8	○
30247470	4.7	74	36	6			○
30247480	4.8	82	44	6			○
30247490	4.9	82	44	6			○
30247500	5	82	44	6	M6X1		●



AD-4D-DIN Type-S

高刚性型无油孔 4D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

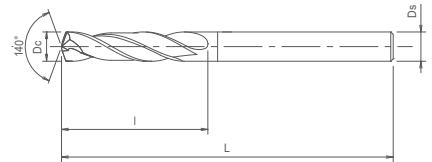
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30247510	5.1	82	44	6			●
30247520	5.2	82	44	6			●
30247530	5.3	82	44	6			○
30247540	5.4	82	44	6			○
30247550	5.5	82	44	6		M6X1	●
30247554	5.54	82	44	6		M6X1	○
30247560	5.6	82	44	6			○
30247570	5.7	82	44	6			○
30247580	5.8	82	44	6			○
30247590	5.9	82	44	6			○
30247600	6	82	44	6	M7X1		●
30247610	6.1	91	53	8			○
30247620	6.2	91	53	8			○
30247630	6.3	91	53	8			○
30247640	6.4	91	53	8			○
30247650	6.5	91	53	8			○
30247660	6.6	91	53	8			○
30247670	6.7	91	53	8			○
30247680	6.8	91	53	8			●
30247690	6.9	91	53	8			●
30247700	7	91	53	8	M8X1		●
30247710	7.1	91	53	8			○
30247720	7.2	91	53	8			○
30247730	7.3	91	53	8			○
30247738	7.38	91	53	8		M8X1.25	○
30247740	7.4	91	53	8			●
30247750	7.5	91	53	8		M8X1	○
30247754	7.54	91	53	8		M8X1	○
30247760	7.6	91	53	8			○
30247770	7.7	91	53	8			○
30247780	7.8	91	53	8			○
30247790	7.9	91	53	8			○
30247800	8	91	53	8	M9X1		●
30247810	8.1	103	61	10			○



AD-4D-DIN Type-S

高刚性型无油孔 4D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

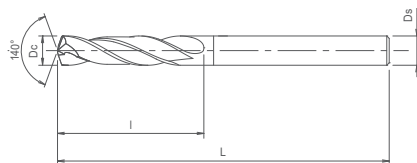
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30247820	8.2	103	61	10			○
30247830	8.3	103	61	10			○
30247840	8.4	103	61	10			○
30247850	8.5	103	61	10	M10X1.5		●
30247860	8.6	103	61	10			●
30247870	8.7	103	61	10			●
30247880	8.8	103	61	10			●
30247890	8.9	103	61	10			○
30247900	9	103	61	10	M10X1		●
30247910	9.1	103	61	10			○
30247920	9.2	103	61	10		M10X1.5	○
30247926	9.26	103	61	10		M10X1.5	○
30247930	9.3	103	61	10			●
30247940	9.4	103	61	10		M10X1.25	○
30247950	9.5	103	61	10	M11X1.5	M10X1	○
30247954	9.54	103	61	10		M10X1	●
30247960	9.6	103	61	10			○
30247970	9.7	103	61	10			○
30247980	9.8	103	61	10			○
30247990	9.9	103	61	10			○
30248000	10	103	61	10	M11X1		●
30248010	10.1	118	71	12			○
30248020	10.2	118	71	12			○
30248030	10.3	118	71	12			●
30248040	10.4	118	71	12			○
30248050	10.5	118	71	12	M12X1.5		○
30248060	10.6	118	71	12			○
30248070	10.7	118	71	12			○
30248080	10.8	118	71	12			○
30248090	10.9	118	71	12			○
30248100	11	118	71	12	M12X1		●
30248110	11.1	118	71	12		M12X1.75	●
30248120	11.2	118	71	12		M12X1.5	○
30248130	11.3	118	71	12			○



AD-4D-DIN Type-S

高刚性型无油孔 4D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

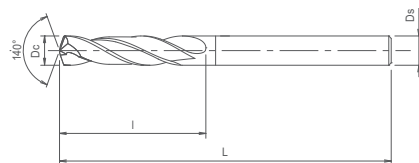
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30248140	11.4	118	71	12		M12X1.25	○
30248150	11.5	118	71	12		M12X1	○
30248160	11.6	118	71	12			○
30248170	11.7	118	71	12			○
30248180	11.8	118	71	12			○
30248190	11.9	118	71	12			○
30248200	12	118	71	12	M14X2		●
30248210	12.1	124	77	14			○
30248220	12.2	124	77	14			○
30248230	12.3	124	77	14			○
30248240	12.4	124	77	14			○
30248250	12.5	124	77	14	M14X1.5		○
30248260	12.6	124	77	14			○
30248270	12.7	124	77	14			○
30248280	12.8	124	77	14			○
30248290	12.9	124	77	14			○
30248300	13	124	77	14	M14X1	M14X2	●
30248310	13.1	124	77	14			○
30248320	13.2	124	77	14		M14X1.5	○
30248330	13.3	124	77	14		M14X1.5	○
30248340	13.4	124	77	14			○
30248350	13.5	124	77	14	M15X1.5		○
30248360	13.6	124	77	14			○
30248370	13.7	124	77	14			○
30248380	13.8	124	77	14			○
30248390	13.9	124	77	14			○
30248400	14	124	77	14	M16X2		●
30248410	14.1	133	83	16			○
30248420	14.2	133	83	16			○
30248430	14.3	133	83	16			○
30248440	14.4	133	83	16			○
30248450	14.5	133	83	16	M16X1.5		○
30248460	14.6	133	83	16			○
30248470	14.7	133	83	16			○



AD-4D-DIN Type-S

高刚性型无油孔 4D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 非标准库存品（请确认库存）

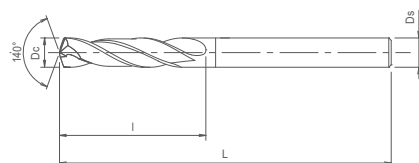
*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

单位：mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30248480	14.8	133	83	16			○
30248490	14.9	133	83	16			○
30248500	15	133	83	16		M16X2	●
30248510	15.1	133	83	16			○
30248520	15.2	133	83	16			○
30248530	15.3	133	83	16		M16X1.5	○
30248540	15.4	133	83	16			○
30248550	15.5	133	83	16	M18X2.5		○
30248560	15.6	133	83	16			○
30248570	15.7	133	83	16			○
30248580	15.8	133	83	16			○
30248590	15.9	133	83	16			○
30248600	16	133	83	16	M18X2		●
30248610	16.1	143	93	18			○
30248620	16.2	143	93	18			○
30248630	16.3	143	93	18			○
30248640	16.4	143	93	18			○
30248650	16.5	143	93	18	M18X1.5		○
30248660	16.6	143	93	18			○
30248670	16.7	143	93	18			○
30248680	16.8	143	93	18		M18X2.5	●
30248690	16.9	143	93	18			○
30248700	17	143	93	18			●
30248710	17.1	143	93	18			○
30248720	17.2	143	93	18			○
30248730	17.3	143	93	18		M18x1.5	●
30248740	17.4	143	93	18			○
30248750	17.5	143	93	18	M20X2.5		○
30248760	17.6	143	93	18			○
30248770	17.7	143	93	18	M20X2.5		●
30248780	17.8	143	93	18			○
30248790	17.9	143	93	18			○
30248800	18	143	93	18	M20X2		●
30248810	18.1	153	101	20			○



高刚性型无油孔 4D 硬质合金钻头系列



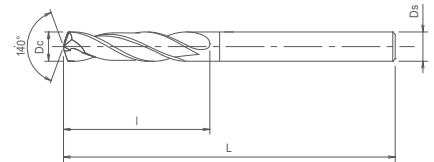
The tap sizes listed in the table are for reference purposes only.

单位: mm Unit: mm



ADO-3D-DIN Type-S

高刚性型带油孔 3D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

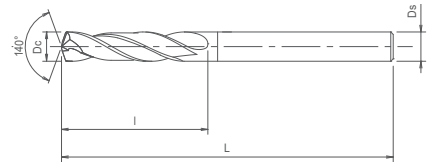
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30249300	3	62	20	6			●
30249310	3.1	62	20	6			○
30249320	3.2	62	20	6			○
30249330	3.3	62	20	6	M4X0.7		●
30249340	3.4	62	20	6			●
30249350	3.5	62	20	6			●
30249360	3.6	62	20	6			○
30249368	3.68	62	20	6		M4X0.7	●
30249370	3.7	62	20	6		M4X0.7	○
30249380	3.8	66	24	6			○
30249390	3.9	66	24	6			○
30249400	4	66	24	6			●
30249410	4.1	66	24	6			○
30249420	4.2	66	24	6	M5X0.8		●
30249430	4.3	66	24	6			●
30249440	4.4	66	24	6			○
30249450	4.5	66	24	6			○
30249460	4.6	66	24	6		M5X0.8	○
30249464	4.64	66	24	6		M5X0.8	●
30249470	4.7	66	24	6			○
30249480	4.8	66	28	6			○
30249490	4.9	66	28	6			○
30249500	5	66	28	6	M6X1		●
30249510	5.1	66	28	6			●
30249520	5.2	66	28	6			○
30249530	5.3	66	28	6			○
30249540	5.4	66	28	6			○
30249550	5.5	66	28	6		M6X1	○
30249554	5.54	66	28	6		M6X1	●
30249560	5.6	66	28	6			○
30249570	5.7	66	28	6			○
30249580	5.8	66	28	6			○
30249590	5.9	66	28	6			○
30249600	6	66	28	6	M7X1		●



ADO-3D-DIN Type-S

高刚性型带油孔 3D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

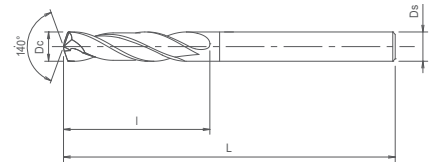
单位：mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30249610	6.1	79	34	8			○
30249620	6.2	79	34	8			○
30249630	6.3	79	34	8			○
30249640	6.4	79	34	8			○
30249650	6.5	79	34	8			○
30249660	6.6	79	34	8			○
30249670	6.7	79	34	8			○
30249680	6.8	79	34	8			●
30249690	6.9	79	34	8			○
30249700	7	79	34	8	M8X1		●
30249710	7.1	79	41	8			○
30249720	7.2	79	41	8			○
30249730	7.3	79	41	8			○
30249738	7.38	79	41	8		M8X1.25	○
30249740	7.4	79	41	8			○
30249750	7.5	79	41	8		M8X1	○
30249754	7.54	79	41	8		M8X1	●
30249760	7.6	79	41	8			○
30249770	7.7	79	41	8			○
30249780	7.8	79	41	8			●
30249790	7.9	79	41	8			○
30249800	8	79	41	8	M9X1		●
30249810	8.1	89	47	10			○
30249820	8.2	89	47	10			○
30249830	8.3	89	47	10			○
30249840	8.4	89	47	10			○
30249850	8.5	89	47	10	M10X1.5		●
30249860	8.6	89	47	10			●
30249870	8.7	89	47	10			○
30249880	8.8	89	47	10			○
30249890	8.9	89	47	10			●
30249900	9	89	47	10	M10X1		●
30249910	9.1	89	47	10			●
30249920	9.2	89	47	10		M10X1.5	●



ADO-3D-DIN Type-S

高刚性型带油孔 3D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

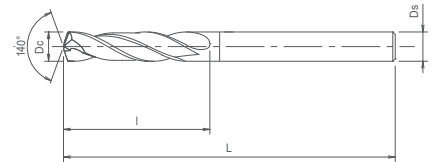
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30249926	9.26	103	61	10		M10X1.5	○
30249930	9.3	89	47	10			○
30249940	9.4	89	47	10		M10X1.25	○
30249950	9.5	89	47	10	M11X1.5	M10X1	●
30249954	9.54	89	47	10		M10X1	○
30249960	9.6	89	47	10			○
30249970	9.7	89	47	10			○
30249980	9.8	89	47	10			○
30249990	9.9	89	47	10			○
30250000	10	89	47	10	M11X1		●
30250010	10.1	102	55	12			○
30250020	10.2	102	55	12			○
30250030	10.3	102	55	12			●
30250040	10.4	102	55	12			○
30250050	10.5	102	55	12	M12X1.5		●
30250060	10.6	102	55	12			○
30250070	10.7	102	55	12			●
30250080	10.8	102	55	12			●
30250090	10.9	102	55	12			○
30250100	11	102	55	12	M12X1		●
30250110	11.1	102	55	12		M12X1.75	○
30250120	11.2	102	55	12		M12X1.5	○
30250130	11.3	102	55	12			○
30250140	11.4	102	55	12		M12X1.25	○
30250150	11.5	102	55	12		M12X1	○
30250160	11.6	102	55	12			○
30250170	11.7	102	55	12			○
30250180	11.8	102	55	12			○
30250190	11.9	102	55	12			○
30250200	12	102	55	12	M14X2		●
30250210	12.1	107	60	14			○
30250220	12.2	107	60	14			○
30250230	12.3	107	60	14			○
30250240	12.4	107	60	14			○



ADO-3D-DIN Type-S

高刚性型带油孔 3D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

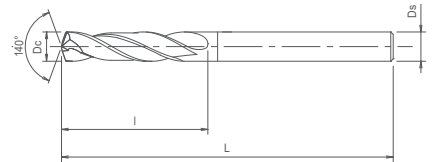
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30250250	12.5	107	60	14	M14X1.5		○
30250260	12.6	107	60	14			○
30250270	12.7	107	60	14			○
30250280	12.8	107	60	14			○
30250290	12.9	107	60	14			○
30250300	13	107	60	14	M14X1	M14X2	●
30250310	13.1	107	60	14			○
30250320	13.2	107	60	14		M14X1.5	○
30250330	13.3	107	60	14		M14X1.5	○
30250340	13.4	107	60	14			○
30250350	13.5	107	60	14	M15X1.5		○
30250360	13.6	107	60	14			○
30250370	13.7	107	60	14			○
30250380	13.8	107	60	14			○
30250390	13.9	107	60	14			○
30250400	14	107	60	14	M16X2		●
30250410	14.1	115	65	16			○
30250420	14.2	115	65	16			○
30250430	14.3	115	65	16			○
30250440	14.4	115	65	16			○
30250450	14.5	115	65	16	M16X1.5		○
30250460	14.6	115	65	16			○
30250470	14.7	115	65	16			○
30250480	14.8	115	65	16			○
30250490	14.9	115	65	16			○
30250500	15	115	65	16		M16X2	●
30250510	15.1	115	65	16			●
30250520	15.2	115	65	16			○
30250530	15.3	115	65	16		M16X1.5	○
30250540	15.4	115	65	16			○
30250550	15.5	115	65	16	M18X2.5		○
30250560	15.6	115	65	16			○
30250570	15.7	115	65	16			○
30250580	15.8	115	65	16			○



ADO-3D-DIN Type-S

高刚性型带油孔 3D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

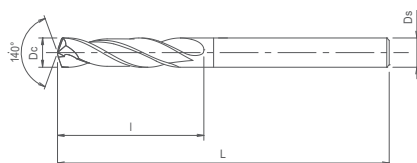
*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30250590	15.9	115	65	16			○
30250600	16	115	65	16	M18X2		●
30250610	16.1	123	73	18			○
30250620	16.2	123	73	18			○
30250630	16.3	123	73	18			○
30250640	16.4	123	73	18			○
30250650	16.5	123	73	18	M18X1.5		○
30250660	16.6	123	73	18			○
30250670	16.7	123	73	18			○
30250680	16.8	123	73	18		M18X2.5	●
30250690	16.9	123	73	18			○
30250700	17	123	73	18			●
30250710	17.1	123	73	18			○
30250720	17.2	123	73	18			○
30250730	17.3	123	73	18		M18x1.5	●
30250740	17.4	123	73	18			○
30250750	17.5	123	73	18	M20X2.5		○
30250760	17.6	123	73	18			○
30250770	17.7	123	73	18	M20X2.5		●
30250780	17.8	123	73	18			○
30250790	17.9	123	73	18			○
30250800	18	123	73	18	M20X2		●
30250810	18.1	131	79	20			○
30250820	18.2	131	79	20			○
30250830	18.3	131	79	20			○
30250840	18.4	131	79	20			○
30250850	18.5	131	79	20	M20X1.5		○
30250860	18.6	131	79	20			○
30250870	18.7	131	79	20			○
30250880	18.8	131	79	20		M20X2.5	●
30250890	18.9	131	79	20			○
30250900	19	131	79	20			●
30250910	19.1	131	79	20			○
30250920	19.2	131	79	20			○



高刚性型带油孔 3D 硬质合金钻头系列



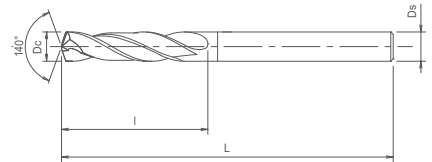
*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

单位: mm Unit: mm



ADO-5D-DIN Type-S

高刚性型带油孔 5D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

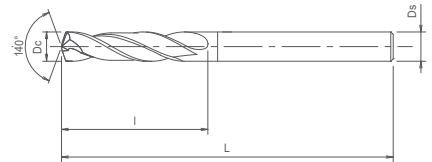
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30251300	3	66	28	6			●
30251310	3.1	66	28	6			○
30251320	3.2	66	28	6			○
30251330	3.3	66	28	6	M4X0.7		●
30251340	3.4	66	28	6			○
30251350	3.5	66	28	6			○
30251360	3.6	66	28	6			○
30251368	3.68	66	28	6		M4X0.7	●
30251370	3.7	66	28	6		M4X0.7	○
30251380	3.8	74	36	6			○
30251390	3.9	74	36	6			○
30251400	4	74	36	6			●
30251410	4.1	74	36	6			○
30251420	4.2	74	36	6	M5X0.8		●
30251430	4.3	74	36	6			●
30251440	4.4	74	36	6			○
30251450	4.5	74	36	6			○
30251460	4.6	74	36	6		M5X0.8	●
30251464	4.64	74	36	6		M5X0.8	●
30251470	4.7	74	36	6			○
30251480	4.8	82	44	6			○
30251490	4.9	82	44	6			○
30251500	5	82	44	6	M6X1		●
30251510	5.1	82	44	6			●
30251520	5.2	82	44	6			○
30251530	5.3	82	44	6			○
30251540	5.4	82	44	6			○
30251550	5.5	82	44	6		M6X1	●
30251554	5.54	82	44	6		M6X1	●
30251560	5.6	82	44	6			○
30251570	5.7	82	44	6			○
30251580	5.8	82	44	6			○
30251590	5.9	82	44	6			○
30251600	6	82	44	6	M7X1		●



ADO-5D-DIN Type-S

高刚性型带油孔 5D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

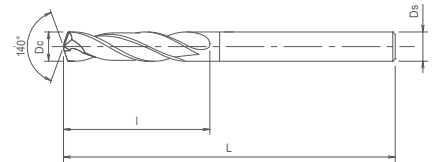
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30251610	6.1	91	53	8			○
30251620	6.2	91	53	8			○
30251630	6.3	91	53	8			○
30251640	6.4	91	53	8			○
30251650	6.5	91	53	8			○
30251660	6.6	91	53	8			○
30251670	6.7	91	53	8			○
30251680	6.8	91	53	8			●
30251690	6.9	91	53	8			○
30251700	7	91	53	8	M8X1		●
30251710	7.1	91	53	8			○
30251720	7.2	91	53	8			○
30251730	7.3	91	53	8			○
30251738	7.38	91	53	8		M8X1.25	●
30251740	7.4	91	53	8			○
30251750	7.5	91	53	8		M8X1	○
30251754	7.54	91	53	8		M8X1	○
30251760	7.6	91	53	8			○
30251770	7.7	91	53	8			○
30251780	7.8	91	53	8			○
30251790	7.9	91	53	8			○
30251800	8	91	53	8	M9X1		●
30251810	8.1	103	61	10			●
30251820	8.2	103	61	10			○
30251830	8.3	103	61	10			○
30251840	8.4	103	61	10			○
30251850	8.5	103	61	10	M10X1.5		●
30251860	8.6	103	61	10			●
30251870	8.7	103	61	10			○
30251880	8.8	103	61	10			○
30251890	8.9	103	61	10			○
30251900	9	103	61	10	M10X1		●
30251910	9.1	103	61	10			○
30251920	9.2	103	61	10		M10X1.5	○



ADO-5D-DIN Type-S

高刚性型带油孔 5D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

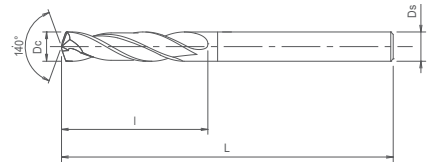
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30251926	9.26	103	61	10		M10X1.5	○
30251930	9.3	103	61	10			○
30251940	9.4	103	61	10		M10X1.25	○
30251950	9.5	103	61	10	M11X1.5	M10X1	○
30251954	9.54	103	61	10		M10X1	○
30251960	9.6	103	61	10			○
30251970	9.7	103	61	10			○
30251980	9.8	103	61	10			○
30251990	9.9	103	61	10			○
30252000	10	103	61	10	M11X1		●
30252010	10.1	118	71	12			○
30252020	10.2	118	71	12			○
30252030	10.3	118	71	12			●
30252040	10.4	118	71	12			○
30252050	10.5	118	71	12	M12X1.5		●
30252060	10.6	118	71	12			○
30252070	10.7	118	71	12			○
30252080	10.8	118	71	12			○
30252090	10.9	118	71	12			○
30252100	11	118	71	12	M12X1		●
30252110	11.1	118	71	12		M12X1.75	○
30252120	11.2	118	71	12		M12X1.5	○
30252130	11.3	118	71	12			○
30252140	11.4	118	71	12		M12X1.25	○
30252150	11.5	118	71	12		M12X1	○
30252160	11.6	118	71	12			○
30252170	11.7	118	71	12			○
30252180	11.8	118	71	12			○
30252190	11.9	118	71	12			○
30252200	12	118	71	12			●
30252210	12.1	124	77	14			○
30252220	12.2	124	77	14			○
30252230	12.3	124	77	14			○
30252240	12.4	124	77	14			○



ADO-5D-DIN Type-S

高刚性型带油孔 5D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

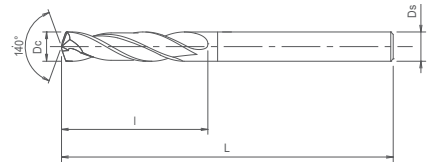
单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 l	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30252250	12.5	124	77	14			●
30252260	12.6	124	77	14			●
30252270	12.7	124	77	14			○
30252280	12.8	124	77	14			○
30252290	12.9	124	77	14			○
30252300	13	124	77	14			●
30252310	13.1	124	77	14			○
30252320	13.2	124	77	14			○
30252330	13.3	124	77	14			●
30252340	13.4	124	77	14			○
30252350	13.5	124	77	14			○
30252360	13.6	124	77	14			○
30252370	13.7	124	77	14			○
30252380	13.8	124	77	14			○
30252390	13.9	124	77	14			○
30252400	14	124	77	14			●
30252410	14.1	133	83	16			●
30252420	14.2	133	83	16			●
30252430	14.3	133	83	16			○
30252440	14.4	133	83	16			○
30252450	14.5	133	83	16			○
30252460	14.6	133	83	16			○
30252470	14.7	133	83	16			○
30252480	14.8	133	83	16			●
30252490	14.9	133	83	16			○
30252500	15	133	83	16			●
30252510	15.1	133	83	16			●
30252520	15.2	133	83	16			○
30252530	15.3	133	83	16			●
30252540	15.4	133	83	16			○
30252550	15.5	133	83	16			●
30252560	15.6	133	83	16			○
30252570	15.7	133	83	16			○
30252580	15.8	133	83	16			○



ADO-5D-DIN Type-S

高刚性型带油孔 5D 硬质合金钻头系列



库存标记：● 标准库存品 ○ 准标准库存品（请确认库存）

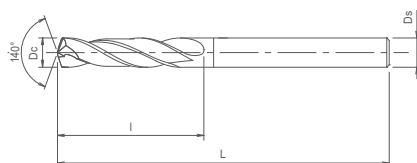
*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

单位: mm Unit: mm

EDP No.	刃径 Dc	全长 L	槽长 I	柄径 Ds	切削丝锥 Cutting Tap	挤压丝锥 Forming Tap	库存 Stock
30252590	15.9	133	83	16			○
30252600	16	133	83	16			●
30252610	16.1	143	93	18			○
30252620	16.2	143	93	18			○
30252630	16.3	143	93	18			○
30252640	16.4	143	93	18			○
30252650	16.5	143	93	18			●
30252660	16.6	143	93	18			○
30252670	16.7	143	93	18			○
30252680	16.8	143	93	18			●
30252690	16.9	143	93	18			○
30252700	17	143	93	18			●
30252710	17.1	143	93	18			○
30252720	17.2	143	93	18			○
30252730	17.3	143	93	18			●
30252740	17.4	143	93	18			○
30252750	17.5	143	93	18			●
30252760	17.6	143	93	18			○
30252770	17.7	143	93	18			●
30252780	17.8	143	93	18			○
30252790	17.9	143	93	18			○
30252800	18	143	93	18			●
30252810	18.1	153	101	20			○
30252820	18.2	153	101	20			○
30252830	18.3	153	101	20			○
30252840	18.4	153	101	20			○
30252850	18.5	153	101	20			○
30252860	18.6	153	101	20			○
30252870	18.7	153	101	20			○
30252880	18.8	153	101	20			●
30252890	18.9	153	101	20			○
30252900	19	153	101	20			○
30252910	19.1	153	101	20			○
30252920	19.2	153	101	20			○



高刚性型带油孔 5D 硬质合金钻头系列



*) 表中对应尺寸丝锥仅供参考
The tap sizes listed in the table are for reference purposes only.

单位: mm Unit: mm



Cutting Conditions

切削条件推荐表

AD-2D/4D-DIN

加工材料 Work Material	软钢·低碳钢·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	
	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)
1	12,700	0.01 ~ 0.03	12,000	0.01 ~ 0.03	12,000	0.02 ~ 0.04
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	
	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)
1	10,000	0.01 ~ 0.03	12,000	0.02 ~ 0.04	11,000	0.02 ~ 0.04
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. 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. For machines that cannot achieve the speeds indicated in the table please set rotation as high as possible. Tool life may be decreased.



切削条件推荐表

ADO-3D/5D/8D-DIN

加工材料 Work Material	软钢·低碳钢 Mild Steel · Low Carbon Steel S5400 · S10C ~ 150HB ~ 500N/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		合金钢 Alloy Steel SCM · SCR · SNCM 28 ~ 35HRC 900 ~ 1,100N/mm ²	
	80~120m/min		80~160m/min		80~120m/min		60~90m/min	
	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)	转速 Speed (min ⁻¹)	进给量 Feed Rate (mm/rev)
直径 Drill Dia. (mm)								
2	12,700	0.04 ~ 0.08	12,700	0.04 ~ 0.08	12,700	0.04 ~ 0.08	11,100	0.04 ~ 0.08
3	10,600	0.06 ~ 0.12	10,600	0.06 ~ 0.12	10,600	0.06 ~ 0.12	7,400	0.06 ~ 0.12
4	8,000	0.08 ~ 0.16	8,000	0.08 ~ 0.16	8,000	0.08 ~ 0.16	5,600	0.08 ~ 0.16
5	6,400	0.1 ~ 0.2	6,400	0.1 ~ 0.2	6,400	0.1 ~ 0.2	4,500	0.1 ~ 0.2
6	5,300	0.12 ~ 0.24	5,300	0.12 ~ 0.24	5,300	0.12 ~ 0.24	3,700	0.12 ~ 0.24
7	4,500	0.14 ~ 0.26	4,500	0.14 ~ 0.26	4,500	0.14 ~ 0.26	3,200	0.14 ~ 0.26
8	4,000	0.16 ~ 0.28	4,000	0.16 ~ 0.28	4,000	0.16 ~ 0.28	2,800	0.16 ~ 0.28
9	3,500	0.18 ~ 0.3	3,500	0.18 ~ 0.3	3,500	0.18 ~ 0.3	2,500	0.18 ~ 0.3
10	3,200	0.2 ~ 0.3	3,200	0.2 ~ 0.3	3,200	0.2 ~ 0.3	2,200	0.2 ~ 0.3
11	2,900	0.2 ~ 0.3	2,900	0.2 ~ 0.3	2,900	0.2 ~ 0.3	2,000	0.2 ~ 0.3
12	2,700	0.21 ~ 0.3	2,700	0.21 ~ 0.3	2,700	0.21 ~ 0.3	1,900	0.21 ~ 0.3
14	2,300	0.22 ~ 0.35	2,300	0.22 ~ 0.35	2,300	0.22 ~ 0.35	1,600	0.22 ~ 0.35
16	2,000	0.25 ~ 0.36	2,000	0.25 ~ 0.36	2,000	0.25 ~ 0.36	1,400	0.25 ~ 0.36
18	1,800	0.28 ~ 0.38	1,800	0.28 ~ 0.38	1,800	0.28 ~ 0.38	1,200	0.28 ~ 0.38
20	1,600	0.3 ~ 0.4	1,600	0.3 ~ 0.4	1,600	0.3 ~ 0.4	1,100	0.3 ~ 0.4

加工材料 Work Material	铸铁 Cast Iron FC250 ~ 350N/mm ²		球墨铸铁 Ductile Cast Iron FCD450 FCD600 400 ~ 600N/mm ²		不锈钢 Stainless Steel SUS300系 SUS400系 480 ~ 800N/mm ²		特殊钢·调质钢·预硬钢 Special Alloy Steel · Hardened Steel · Prehardened Steel SKD61(非调质)(unquenched) 34 ~ 40HRC 1,060 ~ 1,250N/mm ²	
	80~120m/min		60~100m/min		40~80m/min		30~60m/min	
	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)	转速 Speed (min ⁻¹)	进给量 Feed Rate (mm/rev)
直径 Drill Dia. (mm)								
2	12,700	0.04 ~ 0.08	12,700	0.04 ~ 0.08	9,500	0.04 ~ 0.08	7,200	0.04 ~ 0.06
3	10,600	0.06 ~ 0.12	8,500	0.06 ~ 0.12	6,400	0.06 ~ 0.12	4,800	0.06 ~ 0.09
4	8,000	0.08 ~ 0.16	6,400	0.08 ~ 0.16	4,800	0.08 ~ 0.16	3,600	0.08 ~ 0.12
5	6,400	0.1 ~ 0.2	5,100	0.1 ~ 0.2	3,800	0.1 ~ 0.2	2,900	0.1 ~ 0.15
6	5,300	0.12 ~ 0.24	4,200	0.12 ~ 0.24	3,200	0.12 ~ 0.24	2,400	0.12 ~ 0.18
7	4,500	0.14 ~ 0.26	3,600	0.14 ~ 0.26	2,700	0.14 ~ 0.26	2,000	0.14 ~ 0.21
8	4,000	0.16 ~ 0.28	3,200	0.16 ~ 0.28	2,400	0.16 ~ 0.28	1,800	0.16 ~ 0.24
9	3,500	0.18 ~ 0.3	2,800	0.18 ~ 0.3	2,100	0.18 ~ 0.3	1,600	0.18 ~ 0.27
10	3,200	0.2 ~ 0.3	2,500	0.2 ~ 0.3	1,900	0.2 ~ 0.3	1,400	0.2 ~ 0.3
11	2,900	0.2 ~ 0.3	2,300	0.2 ~ 0.3	1,700	0.2 ~ 0.3	1,300	0.2 ~ 0.3
12	2,700	0.21 ~ 0.3	2,100	0.21 ~ 0.3	1,600	0.21 ~ 0.3	1,200	0.21 ~ 0.3
14	2,300	0.22 ~ 0.35	1,800	0.22 ~ 0.35	1,400	0.22 ~ 0.35	1,000	0.22 ~ 0.35
16	2,000	0.25 ~ 0.36	1,600	0.25 ~ 0.36	1,200	0.25 ~ 0.36	900	0.25 ~ 0.36
18	1,800	0.28 ~ 0.38	1,400	0.28 ~ 0.38	1,100	0.28 ~ 0.38	800	0.28 ~ 0.38
20	1,600	0.3 ~ 0.4	1,300	0.3 ~ 0.4	1,000	0.3 ~ 0.4	700	0.3 ~ 0.4

1. 此切削条件基准表适用于水溶性切削油剂或油雾式冷却加工。

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. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。还有，处理切屑时请注意，以免造成火灾。
1. The indicated speeds and feeds are for drilling with water-soluble coolant or MQL.

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. Please always use the appropriate cutting fluid recommended by the cutting fluid manufacturer in the machining of magnesium alloys. Be cautious with the cutting chips as they are highly flammable and may pose a serious fire risk if not properly handled.



Cutting Conditions

切削条件推荐表

ADO-10D/15D-DIN

加工材料 Work Material	软钢・低碳素钢 Mild Steel・Low Carbon Steel (C<0.3%) SS400・S10C ~18HRC ~220HB		碳素钢・合金钢 Carbon Steel・Alloy Steel S50C・SCM-40CrMo ~28HRC ~270HB		合金钢 Alloy Steel SCM-40CrMo ~35HRC ~330HB		铸铁 Cast Iron FC250		球墨铸铁 Ductile Cast Iron FCD450	
	60~100m/min		60~100m/min		60~100m/min		70~120m/min		50~80m/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)	转速 Speed (min ⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min ⁻¹)	进给量 Feed Rate (mm/rev)
3	8,400	0.04~0.08	8,400	0.04~0.08	8,400	0.04~0.07	10,500	0.04~0.08	6,300	0.04~0.08
4	6,300	0.08~0.16	6,300	0.08~0.16	6,300	0.08~0.14	7,900	0.08~0.16	4,700	0.08~0.16
6	4,200	0.12~0.24	4,200	0.12~0.24	4,200	0.12~0.22	5,200	0.12~0.24	3,100	0.12~0.24
8	3,100	0.16~0.28	3,100	0.16~0.28	3,100	0.16~0.28	3,900	0.16~0.28	2,400	0.16~0.28
10	2,500	0.2~0.3	2,500	0.2~0.3	2,500	0.2~0.3	3,100	0.2~0.3	1,900	0.2~0.3
12	2,100	0.21~0.3	2,100	0.21~0.3	2,100	0.21~0.3	2,600	0.21~0.3	1,600	0.21~0.3
14	1,800	0.22~0.35	1,800	0.22~0.35	1,800	0.22~0.35	2,200	0.22~0.35	1,300	0.22~0.35
16	1,600	0.25~0.36	1,600	0.25~0.36	1,600	0.25~0.36	2,000	0.25~0.36	1,200	0.25~0.36

加工材料 Work Material	不锈钢 Stainless Steel		特殊钢・调质钢・预硬钢 Special Alloy Steel・Hardened Steel・Prehardened Steel(unquenched)			
			35~45HRC		45~50HRC	
切削速度 Cutting Speed	40~80m/min		60~100m/min		60~100m/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)
3	6,300	0.04~0.08	4,200	0.02~0.05	2,600	0.02~0.04
4	4,700	0.08~0.16	3,100	0.04~0.1	2,000	0.04~0.08
6	3,100	0.12~0.24	2,100	0.06~0.15	1,300	0.06~0.12
8	2,400	0.16~0.28	1,600	0.08~0.2	1,000	0.08~0.14
10	1,900	0.2~0.3	1,300	0.1~0.22	800	0.1~0.15
12	1,600	0.21~0.3	1,000	0.12~0.24	700	0.12~0.18
14	1,300	0.22~0.35	900	0.14~0.28	600	0.14~0.21
16	1,200	0.25~0.36	800	0.16~0.32	500	0.16~0.24

1. 此切削条件基准表适用于**水溶性切削油剂或油雾冷却加工**。
(不锈钢加工不推荐 MQL)
2. 请使用稀释20倍~30倍的优质水溶性切削油剂。
3. 使用油性切削油剂时，切削速度请设定在最低值的70%左右。
4. 此切削条件基准表请按照右图深孔钻推荐加工方法进行**导向孔加工**。
5. 油孔堵塞是造成折损问题的原因，请务必安装共有装置的过滤器。
6. 加工高硬度材料时，请进行1D~2D的阶梯加工。

1. The indicated speeds and feeds are for drilling with **water-soluble coolant or MQL** (mist drilling in stainless steels is not recommended)
2. Water-soluble high density coolant (20~20 times dilution) is recommended.
3. When using non-water-soluble, reduce set the cutting speed between 70~100% of the lowest limit.
4. Make a pilot hole before using in accordance with recommended operation.
5. A clogged oil hole can lead to a breakage. Make sure that a filter is attached to the oil feeder.
6. Peck drilling of 1D~2D is strongly recommended.



切削条件推荐表

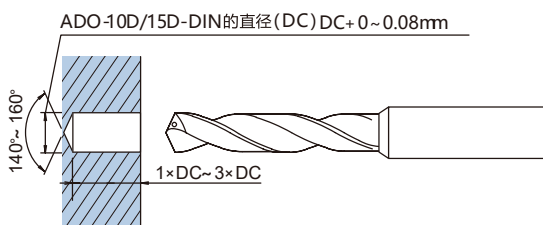
ADO-10D/15D-DIN 推荐加工方法

①使用ADO-3D/5D-DIN 进行导向孔加工

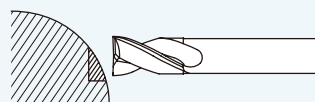
Make a pilot hole with the ADO-3D/5D-DIN

导向孔加工用工具请选择比 ADO-10D/15D-DIN 的直径 (DC) + 0~0.08mm 的钻头，推荐在加工时将导向孔尽量加深。

For the pilot hole, select 0 - 0.08mm larger size drill than ADO-10D/15D-DIN.

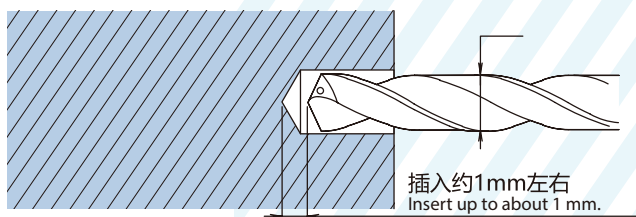


* 弯曲部加工时，在导向孔加工前请先用 FX-ZDS 沉孔加工铣刀或 ADF 硬质合金平头钻进行如图所示的沉孔加工。
When working on a curved surface, use the FX-ZDS (end mill for counterboring) or the ADF (carbide flat drill) to counterbore a surface before drilling a pilot hole.



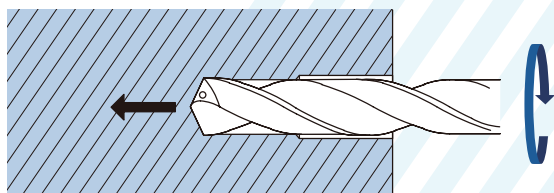
②深孔钻以转速 (n) = 300~500min⁻¹ 左右, 进给速度 (Vf) = 300~500mm/min 插入

Insert the long drill at a speed of (n) = 300 to 500 min⁻¹ and a feed rate of (Vf) = 300 to 500 mm/min.



③加速至规定转速后开始加工

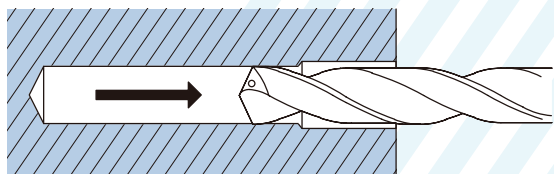
Increase the revolution to the designated speed and start drilling.



加工通孔时，请在拔出时降低进给量至 (f) = 0.05 ~ 0.1mm/rev.
When drilling through holes, reduce the feed rate to (f) 0.05 to 0.1 mm/rev.

④加工后，拔出钻头时，请降低转速至 (n)=300~500min⁻¹ · 进给速度 (Vf) = 1,000~3,000mm/min 左右拔出

After drilling, reduce the speed to (n) = 300 to 500 min⁻¹ and a feed rate of (Vf) = 1,000 to 3,000 mm/min and pull the drill out of the hole.



加工时请务必使用内冷方式

Make sure to use internal coolant supply when drilling.

Cutting Conditions

切削条件推荐表

AD-2D/4D-DIN Type-S

加工材料 Work Material	软钢・低碳素钢 Mild Steel・Low Carbon Steel (C<0.3%) S5400・S10C ~18HRC ~220HB		碳素钢・合金钢 Carbon Steel・Alloy Steel S50C・SCM-40CrMo ~28HRC ~270HB		合金钢 Alloy Steel SCM-40CrMo ~35HRC ~330HB		铸铁 Cast Iron FC250		球墨铸铁 Ductile Cast Iron FCD450	
	80~120m/min		60~120m/min		60~100m/min		80~120m/min		50~100m/min	
切削速度 Cutting Speed										
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)	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	0.04~0.08	10,400	0.04~0.08	10,400	0.04~0.08	12,000	0.04~0.08	9,600	0.04~0.08
4	8,000	0.08~0.16	7,200	0.08~0.16	6,300	0.08~0.16	8,000	0.08~0.16	6,000	0.08~0.16
6	5,300	0.12~0.24	4,800	0.12~0.24	4,200	0.12~0.24	5,300	0.12~0.24	4,000	0.12~0.24
8	4,000	0.16~0.28	3,600	0.16~0.28	3,100	0.16~0.28	4,000	0.16~0.28	3,000	0.16~0.28
10	3,200	0.20~0.30	2,900	0.20~0.30	2,500	0.20~0.30	3,200	0.20~0.30	2,400	0.20~0.30
12	2,700	0.21~0.32	2,400	0.21~0.32	2,100	0.21~0.32	2,700	0.21~0.32	2,000	0.21~0.32
14	2,300	0.22~0.35	2,050	0.22~0.35	1,800	0.22~0.35	2,300	0.22~0.35	1,700	0.22~0.35
16	2,000	0.25~0.36	1,800	0.25~0.36	1,600	0.25~0.36	2,000	0.25~0.36	1,500	0.25~0.36
18	1,800	0.28~0.38	1,600	0.28~0.38	1,400	0.28~0.38	1,800	0.28~0.38	1,350	0.28~0.38
20	1,600	0.30~0.40	1,450	0.30~0.40	1,300	0.30~0.40	1,600	0.30~0.40	1,200	0.30~0.40

加工材料 Work Material	不锈钢 Stainless Steel			特殊钢・调质钢・预硬钢 Special Alloy Steel・Hardened Steel・Prehardened Steel(unquenched)			
				35~45HRC		45~50HRC	
切削速度 Cutting Speed	10~30m/min			30~60m/min		20~30m/min	
直径 Drill Dia. (mm)	转速 Speed (min ⁻¹)	进给量 Feed Rate (mm/rev)	啄钻量 Step Feed (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)
2	3,180	0.04~0.07	0.5xDc~1xDc	6,300	0.02~0.05	3,100	0.02~0.04
4	1,590	0.08~0.14		3,100	0.04~0.10	1,600	0.04~0.08
6	1,060	0.12~0.21		2,100	0.06~0.15	1,000	0.06~0.12
8	800	0.16~0.26		1,600	0.08~0.20	800	0.08~0.14
10	640	0.20~0.30		1,300	0.10~0.22	600	0.10~0.15
12	530	0.21~0.32		1,000	0.12~0.24	500	0.12~0.18
14	450	0.22~0.35		900	0.14~0.28	400	0.14~0.21
16	400	0.25~0.36		800	0.16~0.32	400	0.16~0.24
18	350	0.28~0.38		700	0.18~0.36	300	0.18~0.27
20	320	0.30~0.40		600	0.20~0.40	300	0.20~0.30

1. 此切削条件基准表适用于**水溶性切削油剂或油雾冷却加工**。

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. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。还有，处理切屑时请注意，以免造成火灾。
1. The indicated speeds and feeds are for drilling with **water-soluble coolant or MQL**.

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. Please always use the appropriate cutting fluid recommended by the cutting fluid manufacturer in the machining of magnesium alloys. Be cautious with the cutting chips as they are highly flammable and may pose a serious fire risk if not properly handled.



切削条件推荐表

ADO-3D/5D-DIN Type-S

加工材料 Work Material	软钢・低碳素钢 Mild Steel・Low Carbon Steel (C<0.3%) S4500・S10C ~18HRC ~220HB		碳素钢・合金钢 Carbon Steel・Alloy Steel S50C・SCM・40CrMo ~28HRC ~270HB		合金钢 Alloy Steel SCM・40CrMo ~35HRC ~330HB		铸铁 Cast Iron FC250		球墨铸铁 Ductile Cast Iron FCD450	
切削速度 Cutting Speed	80~120m/min		60~120m/min		60~110m/min		80~120m/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)	转速 Speed (min ⁻¹)	进给量 Feed Rate (mm/rev)	转速 Speed (min ⁻¹)	进给量 Feed Rate (mm/rev)
3	10,500	0.04~0.08	10,500	0.04~0.08	9,400	0.04~0.07	10,500	0.04~0.08	8,500	0.04~0.08
4	7,900	0.08~0.16	7,900	0.08~0.16	7,100	0.08~0.14	7,900	0.08~0.16	6,000	0.08~0.16
6	5,200	0.12~0.24	5,200	0.12~0.24	4,700	0.12~0.22	5,200	0.12~0.24	4,000	0.12~0.24
8	3,900	0.16~0.28	3,900	0.16~0.28	3,500	0.16~0.28	3,900	0.16~0.28	3,000	0.16~0.28
10	3,100	0.2~0.3	3,100	0.2~0.3	2,800	0.2~0.3	3,100	0.2~0.3	2,400	0.2~0.3
12	2,600	0.21~0.3	2,600	0.21~0.3	2,400	0.21~0.3	2,600	0.21~0.3	2,000	0.21~0.3
14	2,200	0.22~0.35	2,200	0.22~0.35	2,000	0.22~0.35	2,200	0.22~0.35	1,700	0.22~0.35
16	2,000	0.25~0.36	2,000	0.25~0.36	1,800	0.25~0.36	2,000	0.25~0.36	1,500	0.25~0.36
18	1,700	0.28~0.38	1,700	0.28~0.38	1,600	0.28~0.38	1,700	0.28~0.38	1,350	0.28~0.38
20	1,600	0.3~0.4	1,600	0.3~0.4	1,400	0.3~0.4	1,600	0.3~0.4	1,200	0.3~0.4

加工材料 Work Material	不锈钢 Stainless Steel		特殊钢・调质钢・预硬钢 Special Alloy Steel・Hardened Steel・Prehardened Steel(unquenched)			
			35~45HRC		45~50HRC	
切削速度 Cutting Speed	40~80m/min		30~60m/min		20~30m/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)
3	6,300	0.04~0.08	4,700	0.02~0.05	2,600	0.02~0.04
4	4,700	0.08~0.16	3,500	0.04~0.1	2,000	0.04~0.08
6	3,100	0.12~0.24	2,400	0.06~0.15	1,300	0.06~0.12
8	2,400	0.16~0.28	1,800	0.08~0.2	1,000	0.08~0.14
10	1,900	0.2~0.3	1,400	0.1~0.22	800	0.1~0.15
12	1,600	0.21~0.3	1,200	0.12~0.24	700	0.12~0.18
14	1,300	0.22~0.35	1,000	0.14~0.28	600	0.14~0.21
16	1,200	0.25~0.36	900	0.16~0.32	500	0.16~0.24
18	1,000	0.28~0.38	800	0.18~0.36	400	0.18~0.27
20	900	0.3~0.4	700	0.2~0.4	400	0.2~0.3

1. 此切削条件基准表适用于水溶性切削油剂或油雾式冷却加工。
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. 加工镁合金时，请务必使用切削油剂厂家推荐的切削油剂。还有，处理切屑时请注意，以免造成火灾。

1. The indicated speeds and feeds are for drilling with water-soluble coolant or MQL.
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. Please always use the appropriate cutting fluid recommended by the cutting fluid manufacturer in the machining of magnesium alloys. Be cautious with the cutting chips as they are highly flammable and may pose a serious fire risk if not properly handled.



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