

樹脂用半月ドリル

ショート：φ0.5～φ6(0.1mmトビ)
ロング：φ2～φ8(0.5mmトビ)



特長

- ①独自の油溝付ネジレ1枚刃形状の樹脂専用ドリル
- ②穴面粗度が良く、穴拡大代が小さい
- ③抜けバリが小さい1/10以下 (対通常超硬ドリル)

特許No.2014-79810
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樹脂用半月ドリル

- ・真円度 ⇒ 10μm以下
- ・粗さ ⇒ Ra 3.2以下

| | | |
|---------------|---------------|-----------------|
| 真円度(入口) 2.7μm | 内径(入口) φ3.985 | 粗さ(入口) Ra 0.164 |
| 真円度(奥) 3.1μm | 内径(奥) φ4.007 | 粗さ(奥) Ra 2.440 |

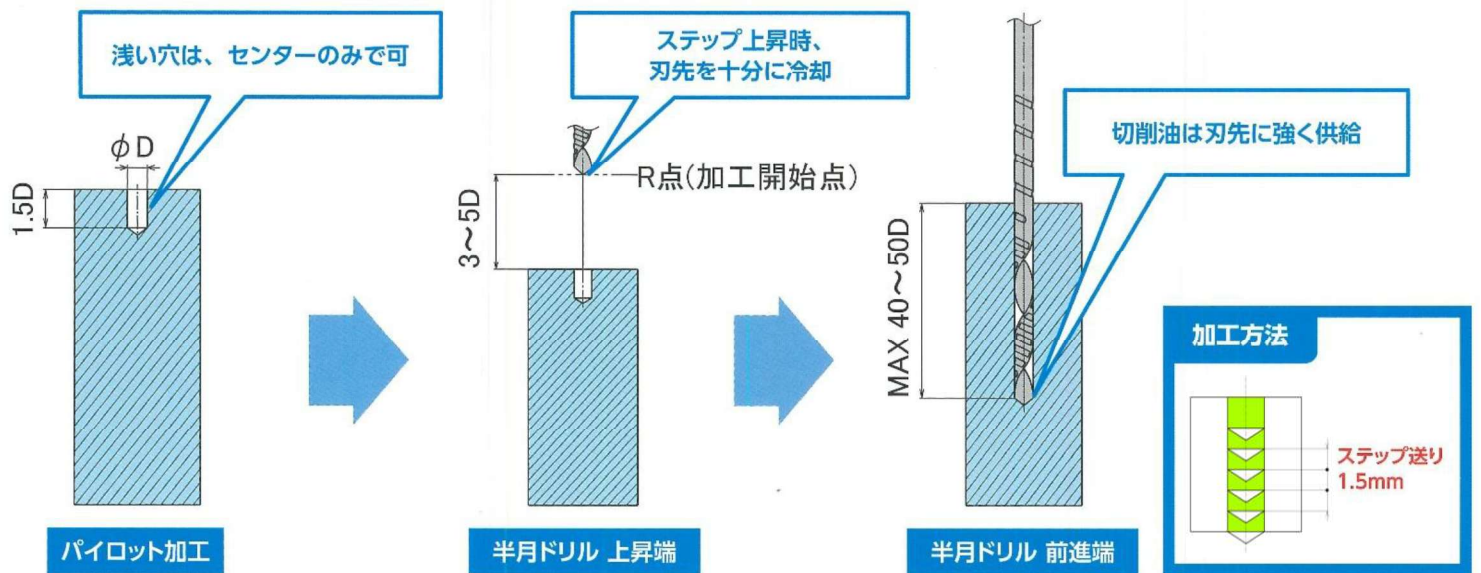
DLC付

- ・真円度 ⇒ 10μm以下
- ・粗さ ⇒ Ra0.4以下

| | | |
|---------------|---------------|-----------------|
| 真円度(入口) 1.8μm | 内径(入口) φ3.995 | 粗さ(入口) Ra 0.156 |
| 真円度(奥) 2.1μm | 内径(奥) φ4.005 | 粗さ(奥) Ra 0.327 |

| | | | |
|---------------|-------------|------------|-----------|
| 刃具型番 | S-HGD040075 | 切込み(mm) | 0.05 |
| 被削材 | アクリル樹脂 | ステップ加工(mm) | 1 |
| 加工設備 | 縦型M/C(BC40) | 切削油 | 水溶性エマルジョン |
| 回転数S(min-1) | 600 | 穴深さ(mm) | 60 |
| 切削速度V(m/min) | 10 | 工具径(mm) | φ4 |
| 送り速度f(mm/rev) | 0.05 | | |

| | | | |
|---------------|-----------------|------------|-----------|
| 刃具型番 | S-HGD040250-DLC | 切込み(mm) | 0.05 |
| 被削材 | アクリル樹脂 | ステップ加工(mm) | 1 |
| 加工設備 | 縦型M/C(BT30) | 切削油 | 水溶性エマルジョン |
| 回転数S(min-1) | 2,000 | 穴深さ(mm) | 50 |
| 切削速度V(m/min) | 25 | 工具径(mm) | φ4 |
| 送り速度f(mm/rev) | 0.01 | | |



S-HGD
LS-HGD
LS-HGD-DLC

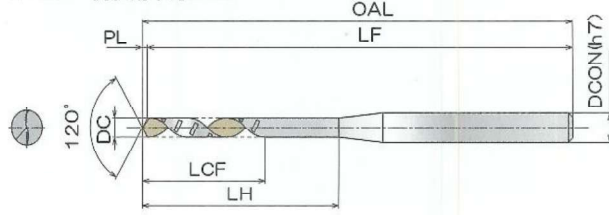
樹脂用半月ドリル
樹脂用ロング半月ドリル
コーティング付樹脂用ロング半月ドリル

| | | |
|---------|----------|-----|
| 炭素鋼・合金鋼 | アルミニウム合金 | 銅合金 |
| 鋳鉄 | 樹脂 | 真鍮 |
| ダクタイル鋳鉄 | ステンレス | |

推奨条件

| 被削材 | 切削速度 V (m/min) | 送り f (mm/rev) |
|-----------|----------------|---------------|
| アクリル樹脂 | 10 ~ 50 | 0.01 ~ 0.1 |
| ポリアセタール樹脂 | 10 ~ 50 | 0.01 ~ 0.1 |

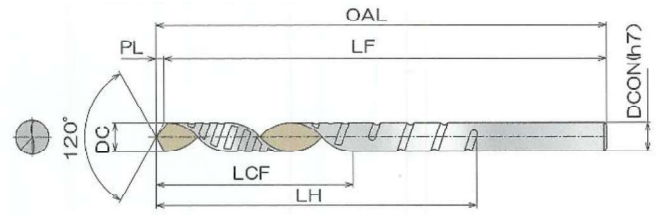
S-HGD 樹脂用半月ドリル



S-HGD ●: 在庫品 ★: 特定代理店在庫品 ○: 受注生産品 単位: mm

| 在庫 | 型番 | DC | DC0 | LCF | LH | LF | OAL | PL | DCON |
|----|-------------|-----|--------|------|------|----|------|-----|------|
| ★ | S-HGD005065 | 0.5 | -0.015 | 5.1 | 30.1 | | 65.1 | 0.1 | |
| ★ | S-HGD006065 | 0.6 | | 5.2 | | | 65.2 | 0.2 | |
| ★ | S-HGD007065 | 0.7 | | 5.3 | 30.2 | | | | |
| ★ | S-HGD008065 | 0.8 | | 5.4 | | | 65.3 | 0.3 | |
| ★ | S-HGD009065 | 0.9 | | 5.5 | | | | | |
| ★ | S-HGD010065 | 1.0 | | 5.6 | 30.3 | | | | |
| ★ | S-HGD011065 | 1.1 | | 5.7 | | | 65.4 | 0.4 | |
| ★ | S-HGD012065 | 1.2 | | 5.8 | | | | | |
| ★ | S-HGD013065 | 1.3 | | 5.9 | 30.4 | 65 | | | 2 |
| ★ | S-HGD014065 | 1.4 | | 6.0 | | | | | |
| ★ | S-HGD015065 | 1.5 | | 6.1 | | | 65.5 | 0.5 | |
| ★ | S-HGD016065 | 1.6 | | 6.2 | | | | | |
| ★ | S-HGD017065 | 1.7 | | 6.3 | 30.5 | | | | |
| ★ | S-HGD018065 | 1.8 | | 6.4 | | | 65.6 | 0.6 | |
| ★ | S-HGD019065 | 1.9 | | 6.5 | 30.6 | | | | |
| ★ | S-HGD020065 | 2.0 | | 6.6 | | | | | |
| ★ | S-HGD021075 | 2.1 | | 6.7 | | | 75.6 | | |
| ★ | S-HGD022075 | 2.2 | | 6.8 | 40.6 | | | | |
| ★ | S-HGD023075 | 2.3 | | 6.9 | | | 75.7 | 0.7 | |
| ★ | S-HGD024075 | 2.4 | | 7.0 | 40.7 | | | | |
| ★ | S-HGD025075 | 2.5 | | 7.1 | | | 75.8 | 0.8 | |
| ★ | S-HGD026075 | 2.6 | | 7.2 | | | | | |
| ★ | S-HGD027075 | 2.7 | | 7.3 | 40.8 | 75 | | | |
| ★ | S-HGD028075 | 2.8 | | 7.4 | | | 75.9 | 0.9 | |
| ★ | S-HGD029075 | 2.9 | | 7.5 | | | | | |
| ★ | S-HGD030075 | 3.0 | | 7.6 | 40.9 | | | | |
| ★ | S-HGD031075 | 3.1 | | 7.7 | | | | | |
| ★ | S-HGD032075 | 3.2 | | 7.8 | | | | | |
| ★ | S-HGD033075 | 3.3 | | 7.9 | 41.1 | | 76.1 | 1.1 | |
| ★ | S-HGD034075 | 3.4 | | 8.0 | | | | | |
| ★ | S-HGD035075 | 3.5 | | 8.1 | | | 76.2 | 1.2 | |
| ★ | S-HGD036075 | 3.6 | | 8.2 | | | | | |
| ★ | S-HGD037075 | 3.7 | | 8.3 | 41.2 | | 86.2 | 1.3 | |
| ★ | S-HGD038075 | 3.8 | | 8.4 | | | | | |
| ★ | S-HGD039075 | 3.9 | | 8.5 | | | | | |
| ★ | S-HGD040075 | 4.0 | | 8.6 | 51.2 | | | | |
| ★ | S-HGD041085 | 4.1 | | 8.7 | | | 86.3 | 1.4 | |
| ★ | S-HGD042085 | 4.2 | | 8.8 | | | | | |
| ★ | S-HGD043085 | 4.3 | | 8.9 | 51.3 | 85 | | | 5 |
| ★ | S-HGD044085 | 4.4 | | 9.0 | | | | | |
| ★ | S-HGD045085 | 4.5 | | 9.1 | | | 86.4 | 1.5 | |
| ★ | S-HGD046085 | 4.6 | | 9.2 | 51.4 | | | | |
| ★ | S-HGD047085 | 4.7 | | 9.3 | | | | | |
| ★ | S-HGD048085 | 4.8 | | 9.4 | | | 86.5 | 1.6 | |
| ★ | S-HGD049085 | 4.9 | | 9.5 | 51.5 | | | | |
| ★ | S-HGD050085 | 5.0 | | 9.6 | | | | | |
| ★ | S-HGD051095 | 5.1 | | 9.7 | | | 96.5 | 1.7 | |
| ★ | S-HGD052095 | 5.2 | | 9.8 | 51.6 | 95 | | | 6 |
| ★ | S-HGD053095 | 5.3 | | 9.9 | | | | | |
| ★ | S-HGD054095 | 5.4 | | 10.0 | | | 96.6 | 1.8 | |
| ★ | S-HGD055095 | 5.5 | | 10.1 | 51.7 | | | | |
| ★ | S-HGD056095 | 5.6 | | 10.2 | | | | | |
| ★ | S-HGD057095 | 5.7 | | 10.3 | | | 96.7 | 1.9 | |
| ★ | S-HGD058095 | 5.8 | | 10.4 | 51.8 | | | | |
| ★ | S-HGD059095 | 5.9 | | 10.5 | | | | | |
| ★ | S-HGD060095 | 6.0 | | 10.6 | 51.9 | | | | |

LS-HGD 樹脂用ロング半月ドリル
LS-HGD-DLC コーティング付樹脂用ロング半月ドリル



LS-HGD ●: 在庫品 ★: 特定代理店在庫品 ○: 受注生産品 単位: mm

| 在庫 | 型番 | DC | DC0 | LCF | LH | LF | OAL | PL | DCON |
|----|--------------|-----|--------|------|-------|-----|-------|-----|------|
| ★ | LS-HGD020200 | 2 | 0 | 14.6 | 100.6 | 200 | 200.6 | 0.6 | 2 |
| ★ | LS-HGD025200 | 2.5 | -0.010 | 18.7 | 100.7 | 200 | 200.7 | 0.7 | 2.5 |
| ★ | LS-HGD030250 | 3 | | 21.9 | 100.9 | 250 | 250.9 | 0.9 | 3 |
| ★ | LS-HGD035250 | 3.5 | | 26 | 101 | 250 | 251 | 1 | 3.5 |
| ★ | LS-HGD040250 | 4 | | 29.2 | 101.2 | 250 | 251.2 | 1.2 | 4 |
| ★ | LS-HGD045280 | 4.5 | 0 | 33.3 | 101.3 | 280 | 281.3 | 1.3 | 4.5 |
| ★ | LS-HGD050280 | 5 | -0.012 | 36.4 | 101.4 | 280 | 281.4 | 1.4 | 5 |
| ★ | LS-HGD055280 | 5.5 | | 40.6 | 101.6 | 280 | 281.6 | 1.6 | 5.5 |
| ★ | LS-HGD060300 | 6 | | 43.7 | 101.7 | 300 | 301.7 | 1.7 | 6 |
| ★ | LS-HGD065300 | 6.5 | 0 | 47.9 | 101.9 | 300 | 301.9 | 1.9 | 6.5 |
| ★ | LS-HGD070300 | 7 | -0.015 | 51 | 102 | 300 | 302 | 2 | 7 |
| ★ | LS-HGD080300 | 8 | | 58.3 | 102.3 | 300 | 302.3 | 2.3 | 8 |

LS-HGD-DLC ●: 在庫品 ★: 特定代理店在庫品 ○: 受注生産品 単位: mm

| 在庫 | 型番 | DC | DC0 | LCF | LH | LF | OAL | PL | DCON |
|----|------------------|-----|--------|------|-------|-----|-------|-----|------|
| ★ | LS-HGD020200-DLC | 2 | 0 | 14.6 | 100.6 | 200 | 200.6 | 0.6 | 2 |
| ★ | LS-HGD025200-DLC | 2.5 | -0.010 | 18.7 | 100.7 | 200 | 200.7 | 0.7 | 2.5 |
| ★ | LS-HGD030250-DLC | 3 | | 21.9 | 100.9 | 250 | 250.9 | 0.9 | 3 |
| ★ | LS-HGD035250-DLC | 3.5 | | 26 | 101 | 250 | 251 | 1 | 3.5 |
| ★ | LS-HGD040250-DLC | 4 | | 29.2 | 101.2 | 250 | 251.2 | 1.2 | 4 |
| ★ | LS-HGD045280-DLC | 4.5 | 0 | 33.3 | 101.3 | 280 | 281.3 | 1.3 | 4.5 |
| ★ | LS-HGD050280-DLC | 5 | -0.012 | 36.4 | 101.4 | 280 | 281.4 | 1.4 | 5 |
| ★ | LS-HGD055280-DLC | 5.5 | | 40.6 | 101.6 | 280 | 281.6 | 1.6 | 5.5 |
| ★ | LS-HGD060300-DLC | 6 | | 43.7 | 101.7 | 300 | 301.7 | 1.7 | 6 |
| ★ | LS-HGD065300-DLC | 6.5 | 0 | 47.9 | 101.9 | 300 | 301.9 | 1.9 | 6.5 |
| ★ | LS-HGD070300-DLC | 7 | -0.015 | 51 | 102 | 300 | 302 | 2 | 7 |
| ★ | LS-HGD080300-DLC | 8 | | 58.3 | 102.3 | 300 | 302.3 | 2.3 | 8 |



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