

HSS



Being the best through innovation



NC-SPOTTING DRILLS

- 含钴8%的高速钢
定中心和倒角

HSS(8% COBALT)
Centering and Chamfering of Holes

SELECTION GUIDE

含钴量8%的高速钢定心钻头
孔的定中心和倒角

项目	型号	规格	尺寸		页
			最小	最大	
ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
D2306 D2307		HSSCo8, 定心钻头 HSSCo8, NC-SPOTTING DRILLS	D3.0	D20.0	230
		推荐的切削条件 RECOMMENDED CUTTING CONDITIONS			231

HSS NC-SPOTTING DRILLS

HSS(8% Cobalt) NC-SPOTTING DRILLS

Centering and Chamfering of Holes

◎ : 优(Excellent)
○ : 良(Good)

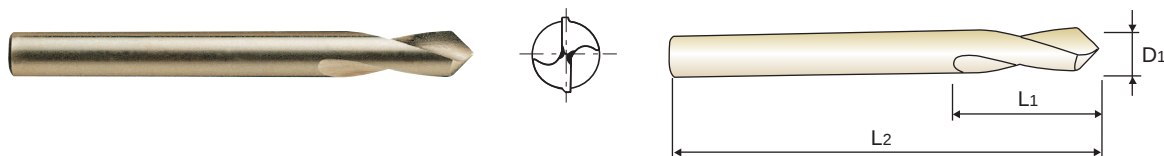
碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎					○	○		○		○


HSSCo8, 定心钻头
HSSCo8, NC-SPOTTING DRILLS

► 应用：用于NC/CNC机床上的高精度中心孔加工，大的产品直径允许在中心孔加工后继续进行倒角工作。

► Application: For more precise centering work on NC/CNC Machines.

The large diameter of the tool permits chamfering work after centering continuously.


NC
**HSS
Co8**
h6
h6
90°
120°

P.207

定心钻头 90°
NC-Spotting Drills 90°

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D1	L1	L2
D2306030	3.0	12	46
D2306040	4.0	12	55
D2306050	5.0	15	60
D2306060	6.0	20	66
D2306080	8.0	25	79
D2306100	10.0	25	89
D2306120	12.0	30	102
D2306160	16.0	35	115
D2306200	20.0	40	131

定心钻头 120°
NC-Spotting Drills 120°

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D1	L1	L2
D2307030	3.0	12	46
D2307040	4.0	12	55
D2307050	5.0	15	60
D2307060	6.0	20	66
D2307080	8.0	25	79
D2307100	10.0	25	89
D2307120	12.0	30	102
D2307160	16.0	35	115
D2307200	20.0	40	131

► TiN (D4306, D4307), TiCN (D7306, D7307), TiAlN (DQ306, DQ307) 可根据客户需求进行加工。

TiN(D4306, D4307), TiCN(D7306, D7307) and TiAlN(DQ306, DQ307) are available on your request.

◎ : 优(Excellent) ○ : 良(Good)

碳钢 Carbon Steels	合金钢 Alloy Steels	预硬钢 Prehardened Steels	硬化钢 Hardened Steels		铸铁 Cast Iron	铝 Aluminum	不锈钢 Stainless Steels	钛 Titanium	低碳钢 Mild Steels	铜 Copper	青铜 Bronze
~HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎					○	○		○		○



推荐的切削条件 RECOMMENDED CUTTING CONDITIONS

HSSCo8, 定心钻头 90° ; 120° HSSCo8, NC-SPOTTING DRILLS 90°, 120°

D2306, D2307 SERIES

单位(Unit) : mm

被加工材料 WORK MATERIAL	碳钢 CARBON STEELS		合金钢 ALLOY STEELS		合金钢, 工具钢, 硬化钢 ALLOY STEELS, TOOL STEELS, HARDENED STEELS		不锈钢 STAINLESS STEELS		铝, 铝合金 ALUMINUM, ALUMINUM ALLOYS	
DIAMETER	N	S	N	S	N	S	N	S	N	S
3.0	2460	0.06	2110	0.06	1080	0.06	940	0.06	7040	0.14
4.0	1850	0.07	1580	0.07	800	0.07	700	0.07	5280	0.15
5.0	1510	0.08	1300	0.08	670	0.08	580	0.08	4400	0.17
6.0	1170	0.09	1030	0.09	540	0.09	460	0.09	3520	0.19
8.0	880	0.11	790	0.11	400	0.11	350	0.11	2640	0.22
10.0	700	0.12	630	0.12	320	0.12	290	0.12	2110	0.25
12.0	590	0.14	530	0.14	260	0.14	240	0.14	1760	0.28
16.0	460	0.20	400	0.20	200	0.20	180	0.20	1320	0.33
20.0	350	0.24	320	0.24	150	0.24	140	0.24	1060	0.45

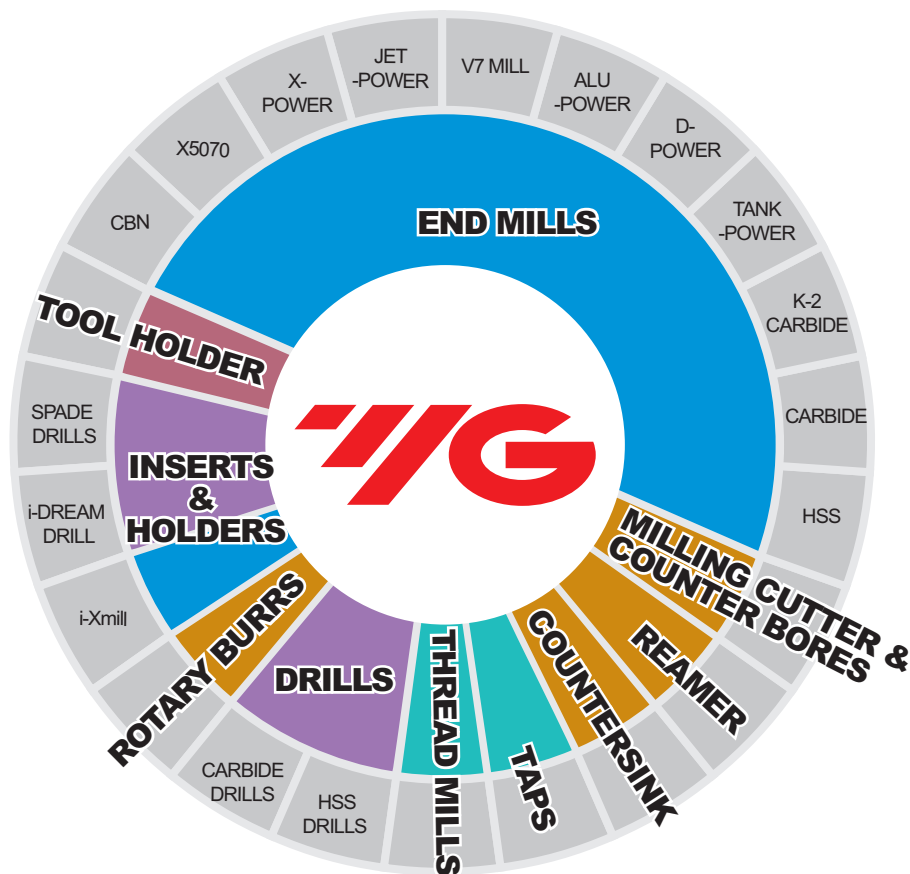
N = R.P.M

S = Feed per Revolution (mm/rev.)

I-DREAM
DRILLSDREAM
DRILLS
-GENERALDREAM
DRILLS
-SOFTDREAM
DRILLS
-INOXDREAM
DRILLS
-MQL TYPEDREAM
DRILLS
for HARDENED
STEELSGENERAL
CARBIDE
DRILLSNC-SPOTTING
DRILLSMULTI-1
DRILLS

HPD DRILLS

GOLD-P
DRILLSWORM
PATTERN
DRILLSSTRAIGHT
SHANK
DRILLSTAPER
SHANK
DRILLSNC-SPOTTING
DRILLSCENTER
DRILLSSPADE
DRILLSTECHNICAL
DATA



Challenge toward a Global Leader-

YG-1 Leads the World Market.