

**CARBIDE**



Being the best through innovation



# NC-SPOTTING DRILLS



- 定中心和倒角

CENTERING and CHAMFERING

# SELECTION GUIDE

## 整体硬质合金定心钻头

用于加工普通材料, 铸钢, 铸铁, 有色金属材料

项目	型号	规格	尺寸		页
			最小	最大	
ITEM	MODEL	DESCRIPTION	SIZE		PAGE
			MIN	MAX	
<b>D5306</b> <b>D5307</b>		硬质合金定心钻头 CARBIDE, NC-SPOTTING DRILLS	D6.0	D20.0	<b>110</b>
<b>D5315</b> <b>D5318</b>		硬质合金定心钻头 CARBIDE, NC-SPOTTING DRILLS	D3.0	D20.0	<b>111</b>
		推荐的切削条件 RECOMMENDED CUTTING CONDITIONS			<b>112</b>

# SOLID CARBIDE NC-SPOTTING DRILLS

## SOLID CARBIDE NC-SPOTTING DRILLS

For General materials, Cast steels, Cast iron, Non-ferrous materials

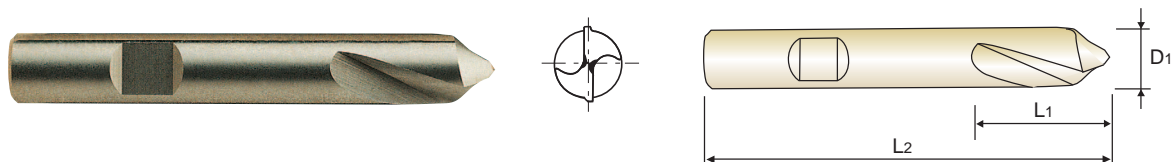
◎ : 优(Excellent)  
○ : 良(Good)

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~							
◎	◎	◎			○	○	○	○	○		
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**硬质合金定心钻头**  
**CARBIDE, 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-Spotting drills 90°**

**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
D5306060	6.0	13	50
D5306080	8.0	23	60
D5306100	10.0	24	70
D5306120	12.0	24	70
D5306160	16.0	29	75
D5306200	20.0	35	100

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D1	L1	L2
D5307060	6.0	13	50
D5307080	8.0	23	60
D5307100	10.0	24	70
D5307120	12.0	24	70
D5307160	16.0	29	75
D5307200	20.0	35	100

▶ TiN (D6306,D6307), TiCN (DG306,DG307), TiAlN (DH306,DH307) 可根据客户需求进行加工  
TiN(D6306,D6307), TiCN(DG306,DG307) and TiAlN(DH306,DH307) are available on your request.

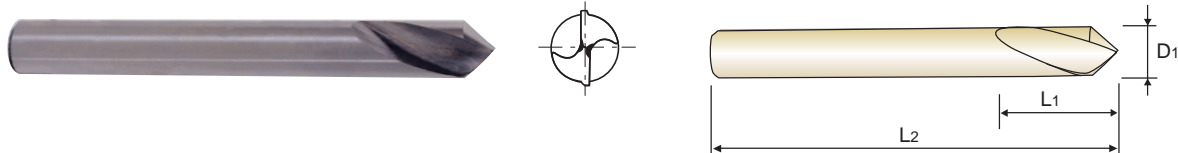
◎ : 优(Excellent) ○ : 良(Good)

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~							
◎	◎	◎			○	○	○	○	○		

**硬质合金定心钻头**  
**CARBIDE, 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-Spotting drills 90°**

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D1	L1	L2
D5315030	3.0	10	50
D5315040	4.0	10	50
D5315050	5.0	10	60
D5315060	6.0	13	70
D5315080	8.0	23	80
D5315100	10.0	24	90
D5315120	12.0	24	90
D5315160	16.0	29	90
D5315200	20.0	35	100

**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
D5318030	3.0	10	50
D5318040	4.0	10	50
D5318050	5.0	10	60
D5318060	6.0	13	70
D5318080	8.0	23	80
D5318100	10.0	24	90
D5318120	12.0	24	90
D5318160	16.0	29	90
D5318200	20.0	35	100

▶ TiN (D6315,D6318), TiCN (DG315,DG318), TiAlN (DH315,318)可根据客户需求进行加工  
TiN(D6315,D6318), TiCN(DG315,DG318) and TiAlN(DH315,DH318) are available on your request.

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~							
◎	◎	◎			○	○	○	○	○		

I-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA



推荐的切削条件  
RECOMMENDED CUTTING CONDITIONS

硬质合金定心钻头 90° ; 120°  
CARBIDE NC - SPOTTING DRILLS 90°, 120°

**D5306, D5307, D5315, D5318** SERIES

单位(Unit) : mm

被加工材料	普通钢		合金钢		软灰铸铁		硬灰铸铁		不锈钢		铝硅合金 Si < 10%		铝硅合金 Si > 10%		钛, 镍合金钢	
WORK MATERIAL	NON-ALLOY STEELS		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON		STAINLESS STEELS		Al-Si ALLOYS, Si < 10%		Al-Si ALLOYS, Si > 10%		Ti, Ni ALLOY STEELS	
STRENGTH	< 700 N/mm <sup>2</sup>		< 1000 N/mm <sup>2</sup>		< HB240, GG25		< HB300, GG40									
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S	N	S	N	S
6.0	3900	0.08	2850	0.08	5200	0.09	3800	0.09	2000	0.07	8800	0.11	7100	0.11	1950	0.07
8.0	2900	0.10	2150	0.10	3900	0.12	2850	0.12	1500	0.09	6600	0.15	5350	0.15	1450	0.09
10.0	2350	0.12	1700	0.12	3100	0.16	2300	0.16	1200	0.11	5300	0.19	4250	0.19	1200	0.11
12.0	1950	0.14	1450	0.14	2600	0.20	1900	0.20	1000	0.13	4450	0.23	3550	0.23	980	0.13
16.0	1450	0.17	1100	0.17	1950	0.24	1450	0.24	755	0.17	3300	0.27	2650	0.27	735	0.17
20.0	1150	0.19	850	0.19	1550	0.28	1150	0.28	590	0.20	2650	0.31	2150	0.31	590	0.20

N = R.P.M  
S = Feed per Revolution (mm/rev.)

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