切 削 條件表 P467
Cutting Condition

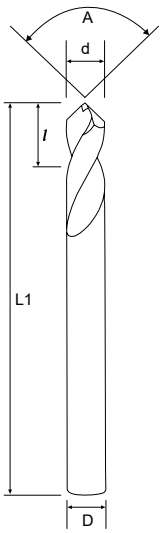
Position Drill
■ 定位鑽

600 Nano　HRC ▶45

- Micro Grain Carbide
- WC=90 Co=10 HV30=1571 Rupture=3750N/mm^2 Grain Size=0.6μm







MODE	Diameter	Flute Length	Full Length	Shank Diameter	Tip Angle
型號	d 刃徑	l 刃長	L 全長	D 柄徑	A 前端角
PDST030900	3	10	50	3	90°
PDST030120	3	10	50	3	120°
PDST040900	4	12	50	4	90°
PDST040120	4	12	50	4	120°
PDST050900	5	15	50	5	90°
PDST050120	5	15	50	5	120°
PDST060900	6	20	60	6	90°
PDST060120	6	20	60	6	120°
PDST080900	8	25	60	8	90°
PDST080120	8	25	60	8	120°
PDST100900	10	25	75	10	90°
PDST100120	10	25	75	10	120°
PDST120900	12	30	75	12	90°
PDST120120	12	30	75	12	120°
PDST160900	16	35	100	16	90°
PDST160120	16	35	100	16	120°
PDST200900	20	40	100	20	90°
PDST200120	20	40	100	20	120°

Application 適用材質：

★ Perfect 最推薦　◎ Excellent 適合　○ Good 佳

carbon steel, Alloy steel 炭素鋼 ,合金鋼	Pre-harden steel 預硬鋼	High-hardened 高硬度鋼				Stainless steel 不鏽鋼	Titanium ally 鈦合金	Nickel/Inconel ally 鎳基合金	Copper alloy 銅合金,銅	Aluminum alloy 鋁合金
	~45HRC	~50HRC	~55HRC	~60HRC	~65HRC					
○	◎	○							○	○

Unit/單位: mm

切削條件表 P467
Cutting Condition

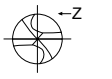
Position Drill
■ 定位鑽

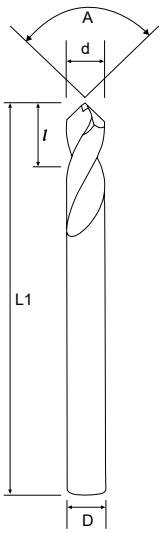
600 Nano | HRC ▶50 | ZrN-A

- Micro Grain Carbide
- WC=90 Co=10 HV30=1571 Rupture=3750N/mm^2 Grain Size=0.6μm



MODE	Diameter	Flute Length	Full Length	Shank Diameter	Tip Angle
型號	d 刃徑	l 刃長	L 全長	D 柄徑	A 前端角
PDST030900T	3	10	50	3	90°
PDST030120T	3	10	50	3	120°
PDST040900T	4	12	50	4	90°
PDST040120T	4	12	50	4	120°
PDST050900T	5	15	50	5	90°
PDST050120T	5	15	50	5	120°
PDST060900T	6	20	60	6	90°
PDST060120T	6	20	60	6	120°
PDST080900T	8	25	60	8	90°
PDST080120T	8	25	60	8	120°
PDST100900T	10	25	75	10	90°
PDST100120T	10	25	75	10	120°
PDST120900T	12	30	75	12	90°
PDST120120T	12	30	75	12	120°
PDST160900T	16	35	100	16	90°
PDST160120T	16	35	100	16	120°
PDST200900T	20	40	100	20	90°
PDST200120T	20	40	100	20	120°





Application 適用材質：

★ Perfect 最推薦　◎ Excellent 適合　○ Good 佳

carbon steel, Alloy steel 炭素鋼 ,合金鋼	Pre-harden steel 預硬鋼	High-hardened 高硬度鋼				Stainless steel 不鏽鋼	Titanium ally 鈦合金	Nickel/Inconel ally 鎳基合金	Copper alloy 銅合金,銅	Aluminum alloy 鋁合金
	~45HRC	~50HRC	~55HRC	~60HRC	~65HRC					
○	◎	◎	○			○	○	○	○	○

Unit/單位: mm

切削條件表 P467
Cutting Condition

Position Drill - Long Shank

■ 長柄定位鑽

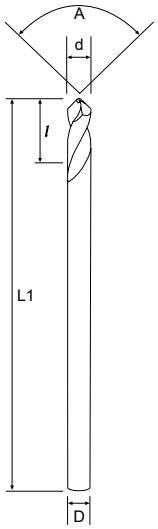
600 Nano HRC ▶45

- Micro Grain Carbide
- WC=90 Co=10 HV30=1571 Rupture=3750N/mm^2 Grain Size=0.6μm



MODE	Diameter	Flute Length	Full Length	Shank Diameter	Tip Angle
型號	d 刃徑	l 刃長	L 全長	D 柄徑	A 前端角
PDST040901	4	12	100	4	90°
PDST040121	4	12	100	4	120°
PDST060901	6	20	100	6	90°
PDST060121	6	20	100	6	120°
PDST080901	8	25	100	8	90°
PDST080121	8	25	100	8	120°
PDST100901	10	25	150	10	90°
PDST100121	10	25	150	10	120°
PDST120901	12	30	150	12	90°
PDST120121	12	30	150	12	120°
PDST160901	16	35	150	16	90°
PDST160121	16	35	150	16	120°
PDST200901	20	40	150	20	90°
PDST200121	20	40	150	20	120°





Application 適用材質：

★ Perfect 最推薦　◎ Excellent 適合　○ Good 佳

carbon steel, Alloy steel 炭素鋼 ,合金鋼	Pre-harden steel 預硬鋼	High-hardened 高硬度鋼				Stainless steel 不鏽鋼	Titanium ally 鈦合金	Nickel/Inconel ally 鎳基合金	Copper alloy 銅合金,銅	Aluminum alloy 鋁合金
	~45HRC	~50HRC	~55HRC	~60HRC	~65HRC					
○	◎	○							○	○

Unit/單位: mm

切削條件表 P467
Cutting Condition

Position Drill - Long Shank

■ 長柄定位鑽

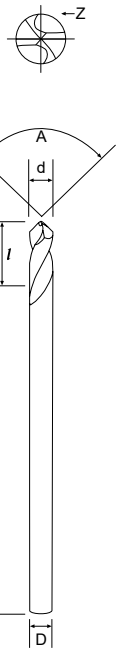
600 Nano | HRC ▶50 | ZrN-A

● Micro Grain Carbide

● WC=90 Co=10 HV30=1571 Rupture=3750N/mm^2 Grain Size=0.6μm



MODE 型號	Diameter d 刃徑	Flute Length l 刃長	Full Length L 全長	Shank Diameter D 柄徑	Tip Angle A 前端角
PDST040901T	4	12	100	4	90°
PDST040121T	4	12	100	4	120°
PDST060901T	6	20	100	6	90°
PDST060121T	6	20	100	6	120°
PDST080901T	8	25	100	8	90°
PDST080121T	8	25	100	8	120°
PDST100901T	10	25	150	10	90°
PDST100121T	10	25	150	10	120°
PDST120901T	12	30	150	12	90°
PDST120121T	12	30	150	12	120°
PDST160901T	16	35	150	16	90°
PDST160121T	16	35	150	16	120°
PDST200901T	20	40	150	20	90°
PDST200121T	20	40	150	20	120°



Application 適用材質：

★ Perfect 最推薦　◎ Excellent 適合　○ Good 佳

carbon steel, Alloy steel 炭素鋼 ,合金鋼	Pre-harden steel 預硬鋼	High-hardened 高硬度鋼				Stainless steel 不鏽鋼	Titanium ally 鈦合金	Nickel/Inconel ally 鎳基合金	Copper alloy 銅合金,銅	Aluminum alloy 鋁合金
	~45HRC	~50HRC	~55HRC	~60HRC	~65HRC					
○	◎	◎	○			○	○	○	○	○

Unit/單位: mm