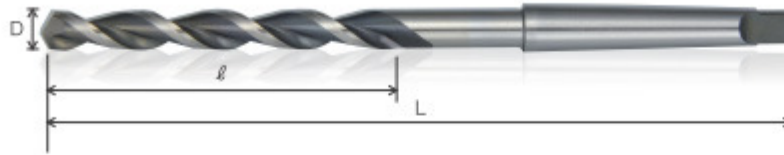




強力錐丸テーパシャンクドリル

KIRI-MARU Taper Shank Parabolick Flute-Drills



ドリルシリーズ

特長 Feature

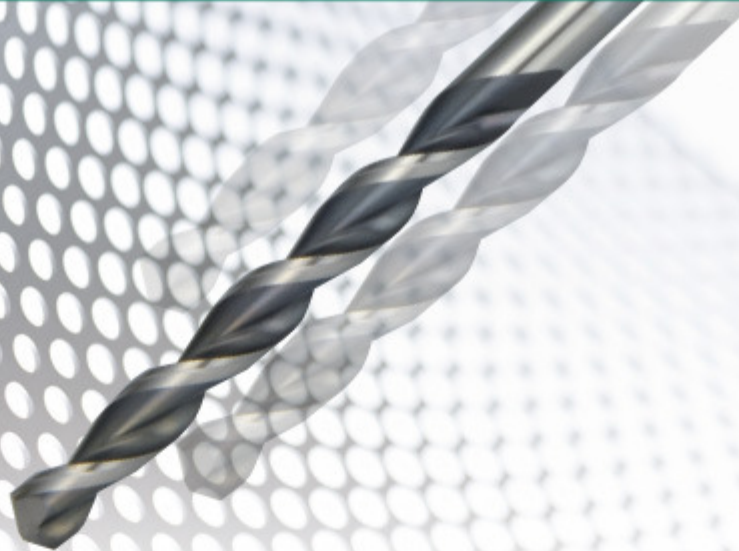
- 刃先の剛性が高い
- 切りくずの排出が良い
- 切削抵抗が少ない
- 直径の8倍までの深穴をノーステップ加工ができます
- 35°以上の強捻じれ
- Edge is high-rigidity.
- Cutting swarf removal is excellent.
- Low cutting resistance.
- Non-step machining for deep hole up to 8 times of diameter is possible.
- Minimum 35 degrees strong twist.

単位：mm

商品コード Item Code	D	ℓ	L	M.T.No.
TC-STD(YKT)5.0	5.0	65	145	1
TC-STD(YKT)5.1	5.1	65	145	1
TC-STD(YKT)5.2	5.2	65	145	1
TC-STD(YKT)5.3	5.3	65	145	1
TC-STD(YKT)5.4	5.4	65	145	1
TC-STD(YKT)5.5	5.5	65	145	1
TC-STD(YKT)5.6	5.6	75	155	1
TC-STD(YKT)5.7	5.7	75	155	1
TC-STD(YKT)5.8	5.8	75	155	1
TC-STD(YKT)5.9	5.9	75	155	1
TC-STD(YKT)6.0	6.0	75	155	1
TC-STD(YKT)6.1	6.1	75	155	1
TC-STD(YKT)6.2	6.2	75	155	1
TC-STD(YKT)6.3	6.3	75	155	1
TC-STD(YKT)6.4	6.4	75	155	1
TC-STD(YKT)6.5	6.5	75	155	1
TC-STD(YKT)6.6	6.6	80	160	1
TC-STD(YKT)6.7	6.7	80	160	1
TC-STD(YKT)6.8	6.8	80	160	1
TC-STD(YKT)6.9	6.9	80	160	1
TC-STD(YKT)7.0	7.0	80	160	1
TC-STD(YKT)7.1	7.1	80	160	1
TC-STD(YKT)7.2	7.2	80	160	1
TC-STD(YKT)7.3	7.3	80	160	1
TC-STD(YKT)7.4	7.4	80	160	1
TC-STD(YKT)7.5	7.5	80	160	1
TC-STD(YKT)7.6	7.6	85	170	1
TC-STD(YKT)7.7	7.7	85	170	1
TC-STD(YKT)7.8	7.8	85	170	1
TC-STD(YKT)7.9	7.9	85	170	1
TC-STD(YKT)8.0	8.0	85	170	1
TC-STD(YKT)8.1	8.1	85	170	1
TC-STD(YKT)8.2	8.2	85	170	1
TC-STD(YKT)8.3	8.3	85	170	1
TC-STD(YKT)8.4	8.4	85	170	1
TC-STD(YKT)8.5	8.5	85	170	1
TC-STD(YKT)8.6	8.6	85	175	1
TC-STD(YKT)8.7	8.7	85	175	1
TC-STD(YKT)8.8	8.8	90	175	1
TC-STD(YKT)8.9	8.9	90	175	1
TC-STD(YKT)9.0	9.0	90	175	1

商品コード Item Code	D	ℓ	L	M.T.No.
TC-STD(YKT)9.1	9.1	95	180	1
TC-STD(YKT)9.2	9.2	95	180	1
TC-STD(YKT)9.3	9.3	95	180	1
TC-STD(YKT)9.4	9.4	95	180	1
TC-STD(YKT)9.5	9.5	95	180	1
TC-STD(YKT)9.6	9.6	95	180	1
TC-STD(YKT)9.7	9.7	95	180	1
TC-STD(YKT)9.8	9.8	95	180	1
TC-STD(YKT)9.9	9.9	95	180	1
TC-STD(YKT)10.0	10.0	95	180	1
TC-STD(YKT)10.1	10.1	100	185	1
TC-STD(YKT)10.2	10.2	100	185	1
TC-STD(YKT)10.3	10.3	100	185	1
TC-STD(YKT)10.4	10.4	100	185	1
TC-STD(YKT)10.5	10.5	100	185	1
TC-STD(YKT)10.6	10.6	100	185	1
TC-STD(YKT)10.7	10.7	100	185	1
TC-STD(YKT)10.8	10.8	100	185	1
TC-STD(YKT)10.9	10.9	100	185	1
TC-STD(YKT)11.0	11.0	100	185	1
TC-STD(YKT)11.1	11.1	110	195	1
TC-STD(YKT)11.2	11.2	110	195	1
TC-STD(YKT)11.3	11.3	110	195	1
TC-STD(YKT)11.4	11.4	110	195	1
TC-STD(YKT)11.5	11.5	110	195	1
TC-STD(YKT)11.6	11.6	110	195	1
TC-STD(YKT)11.7	11.7	110	195	1
TC-STD(YKT)11.8	11.8	110	195	1
TC-STD(YKT)11.9	11.9	110	195	1
TC-STD(YKT)12.0	12.0	110	195	1
TC-STD(YKT)12.1	12.1	115	200	1
TC-STD(YKT)12.2	12.2	115	200	1
TC-STD(YKT)12.3	12.3	115	200	1
TC-STD(YKT)12.4	12.4	115	200	1
TC-STD(YKT)12.5	12.5	115	200	1
TC-STD(YKT)12.6	12.6	115	200	1
TC-STD(YKT)12.7	12.7	115	200	1
TC-STD(YKT)12.8	12.8	115	200	1
TC-STD(YKT)12.9	12.9	115	200	1
TC-STD(YKT)13.0	13.0	115	200	1
TC-STD(YKT)13.1	13.1	120	205	1

商品コード Item Code	D	ℓ	L	M.T.No.
TC-STD(YKT)13.2	13.2	120	205	1
TC-STD(YKT)13.3	13.3	120	205	1
TC-STD(YKT)13.4	13.4	120	205	1
TC-STD(YKT)13.5	13.5	120	205	1
TC-STD(YKT)13.6	13.6	120	205	1
TC-STD(YKT)13.7	13.7	120	205	1
TC-STD(YKT)13.8	13.8	120	205	1
TC-STD(YKT)13.9	13.9	120	205	1
TC-STD(YKT)14.0	14.0	120	205	1
TC-STD(YKT)14.1	14.1	125	225	2
TC-STD(YKT)14.2	14.2	125	225	2
TC-STD(YKT)14.3	14.3	125	225	2
TC-STD(YKT)14.4	14.4	125	225	2
TC-STD(YKT)14.5	14.5	125	225	2
TC-STD(YKT)14.6	14.6	125	225	2
TC-STD(YKT)14.7	14.7	125	225	2
TC-STD(YKT)14.8	14.8	125	225	2
TC-STD(YKT)14.9	14.9	125	225	2
TC-STD(YKT)15.0	15.0	125	225	2
TC-STD(YKT)15.1	15.1	130	230	2
TC-STD(YKT)15.2	15.2	130	230	2
TC-STD(YKT)15.3	15.3	130	230	2
TC-STD(YKT)15.4	15.4	130	230	2
TC-STD(YKT)15.5	15.5	130	230	2
TC-STD(YKT)15.6	15.6	130	230	2
TC-STD(YKT)15.7	15.7	130	230	2
TC-STD(YKT)15.8	15.8	130	230	2
TC-STD(YKT)15.9	15.9	130	230	2
TC-STD(YKT)16.0	16.0	130	230	2
TC-STD(YKT)16.1	16.1	135	235	2
TC-STD(YKT)16.2	16.2	135	235	2
TC-STD(YKT)16.3	16.3	135	235	2
TC-STD(YKT)16.4	16.4	135	235	2
TC-STD(YKT)16.5	16.5	135	235	2
TC-STD(YKT)16.6	16.6	135	235	2
TC-STD(YKT)16.7	16.7	135	235	2
TC-STD(YKT)16.8	16.8	135	235	2
TC-STD(YKT)16.9	16.9	135	235	2
TC-STD(YKT)17.0	17.0	135	235	2
TC-STD(YKT)17.1	17.1	140	240	2
TC-STD(YKT)17.2	17.2	140	240	2



単位：mm

商品コード Item Code	D	φ	L	M.T.No.
TC-STD(YKT)17.3	17.3	140	240	2
TC-STD(YKT)17.4	17.4	140	240	2
TC-STD(YKT)17.5	17.5	140	240	2
TC-STD(YKT)17.6	17.6	140	240	2
TC-STD(YKT)17.7	17.7	140	240	2
TC-STD(YKT)17.8	17.8	140	240	2
TC-STD(YKT)17.9	17.9	140	240	2
TC-STD(YKT)18.0	18.0	140	240	2
TC-STD(YKT)18.1	18.1	145	245	2
TC-STD(YKT)18.2	18.2	145	245	2
TC-STD(YKT)18.3	18.3	145	245	2
TC-STD(YKT)18.4	18.4	145	245	2
TC-STD(YKT)18.5	18.5	145	245	2
TC-STD(YKT)18.6	18.6	145	245	2
TC-STD(YKT)18.7	18.7	145	245	2
TC-STD(YKT)18.8	18.8	145	245	2
TC-STD(YKT)18.9	18.9	145	245	2
TC-STD(YKT)19.0	19.0	145	245	2
TC-STD(YKT)19.1	19.1	150	250	2
TC-STD(YKT)19.2	19.2	150	250	2
TC-STD(YKT)19.3	19.3	150	250	2
TC-STD(YKT)19.4	19.4	150	250	2
TC-STD(YKT)19.5	19.5	150	250	2
TC-STD(YKT)19.6	19.6	150	250	2
TC-STD(YKT)19.7	19.7	150	250	2
TC-STD(YKT)19.8	19.8	150	250	2

商品コード Item Code	D	φ	L	M.T.No.
TC-STD(YKT)19.9	19.9	150	250	2
TC-STD(YKT)20.0	20.0	150	250	2
TC-STD(YKT)20.1	20.1	155	255	2
TC-STD(YKT)20.2	20.2	155	255	2
TC-STD(YKT)20.3	20.3	155	255	2
TC-STD(YKT)20.4	20.4	155	255	2
TC-STD(YKT)20.5	20.5	155	255	2
TC-STD(YKT)20.6	20.6	155	255	2
TC-STD(YKT)20.7	20.7	155	255	2
TC-STD(YKT)20.8	20.8	155	255	2
TC-STD(YKT)20.9	20.9	155	255	2
TC-STD(YKT)21.0	21.0	155	255	2
TC-STD(YKT)21.1	21.1	160	260	2
TC-STD(YKT)21.2	21.2	160	260	2
TC-STD(YKT)21.3	21.3	160	260	2
TC-STD(YKT)21.4	21.4	160	260	2
TC-STD(YKT)21.5	21.5	160	260	2
TC-STD(YKT)21.6	21.6	160	260	2
TC-STD(YKT)21.7	21.7	160	260	2
TC-STD(YKT)21.8	21.8	160	260	2
TC-STD(YKT)21.9	21.9	160	260	2
TC-STD(YKT)22.0	22.0	160	260	2
TC-STD(YKT)22.1	22.1	165	265	2
TC-STD(YKT)22.2	22.2	165	265	2
TC-STD(YKT)22.3	22.3	165	265	2
TC-STD(YKT)22.4	22.4	165	265	2

商品コード Item Code	D	φ	L	M.T.No.
TC-STD(YKT)22.5	22.5	165	265	2
TC-STD(YKT)22.6	22.6	165	265	2
TC-STD(YKT)22.7	22.7	165	265	2
TC-STD(YKT)22.8	22.8	165	265	2
TC-STD(YKT)22.9	22.9	165	265	2
TC-STD(YKT)23.0	23.0	165	265	2
TC-STD(YKT)23.5	23.5	165	285	3
TC-STD(YKT)24.0	24.0	165	285	3
TC-STD(YKT)24.5	24.5	165	285	3
TC-STD(YKT)25.0	25.0	165	285	3
TC-STD(YKT)25.5	25.5	165	285	3
TC-STD(YKT)26.0	26.0	165	285	3
TC-STD(YKT)26.5	26.5	170	290	3
TC-STD(YKT)27.0	27.0	170	290	3
TC-STD(YKT)27.5	27.5	175	295	3
TC-STD(YKT)28.0	28.0	175	295	3
TC-STD(YKT)28.5	28.5	180	300	3
TC-STD(YKT)29.0	29.0	180	300	3
TC-STD(YKT)29.5	29.5	185	305	3
TC-STD(YKT)30.0	30.0	185	305	3
TC-STD(YKT)30.5	30.5	190	310	3
TC-STD(YKT)31.0	31.0	190	310	3
TC-STD(YKT)31.5	31.5	195	315	3
TC-STD(YKT)32.0	32.0	195	315	3

注) TC-STDのφ6.9以下は在庫が切れ次第、廃盤になります。
 Note: TC-STD φ6.9 and smaller sizes are discontinued stock products

■標準切削条件表 Recommended cutting conditions

被削材 Work	普通鋼/合金鋼				ステンレス鋼				鍛造鋼 S48C (280~300H)		金型用鋼				鋳鉄 (FC200~250)					
	SS400 (40~50)	S C, 5Cr (50~60)	SNC (60~70)	SCM (80以上)	SUS400台 (180HB以下)	SUS300台 (190HB以下)			SKD61 (30HRC以上)	プリハードン鋼 (40~45HR)										
切削速度	20~50	20~30	15~25	10~20	15~20	10~20	12~18		10~15	3~5	20~40									
D	回転数 n(min ⁻¹)	送り量 mm/rev	回転数 n(min ⁻¹)	送り量 mm/rev	回転数 n(min ⁻¹)	送り量 mm/rev	回転数 n(min ⁻¹)	送り量 mm/rev	回転数 n(min ⁻¹)	送り量 mm/rev	回転数 n(min ⁻¹)	送り量 mm/rev	回転数 n(min ⁻¹)	送り量 mm/rev	回転数 n(min ⁻¹)	送り量 mm/rev				
5	2,000	0.1	1,600	0.07	1,200	0.05	950	0.05	1,100	0.07	630	0.08	1,100	0.08	950	0.06	230	0.025	1,910	0.11
6	1,700	0.12	1,300	0.09	1,000	0.06	790	0.06	900	0.09	530	0.1	950	0.1	790	0.07	200	0.03	1,590	0.15
8	1,300	0.16	1,000	0.12	790	0.08	590	0.08	680	0.12	390	0.14	710	0.12	590	0.09	140	0.04	1,195	0.2
10	1,000	0.2	800	0.15	630	0.1	470	0.1	540	0.15	310	0.17	570	0.18	470	0.12	110	0.05	950	0.22
12	850	0.24	670	0.18	530	0.12	392	0.12	450	0.18	260	0.21	470	0.2	390	0.14	95	0.06	800	0.25
15	680	0.3	530	0.22	420	0.15	320	0.15	360	0.22	210	0.26	380	0.25	310	0.18	75	0.08	630	0.3
20	500	0.4	400	0.3	310	0.2	230	0.2	270	0.3	150	0.31	280	0.3	230	0.24	55	0.11	480	0.35
25	400	0.5	320	0.37	250	0.25	190	0.25	220	0.37	120	0.37	220	0.35	190	0.3	45	0.14	380	0.4
30	350	0.62	280	0.45	210	0.31	170	0.31	190	0.45	100	0.43	190	0.41	170	0.37	40	0.18	330	0.46

※切削条件はあくまでも目安です。使用される機械、チャックの剛性や切削油等の状況によって変動致します。

These conditions are for general guidance. Therefore they are subject to change to the situation of the machine used, the tool hold rigidity, cutting oil, etc.

構造用鋼/炭素鋼 (SS, S C)	工具鋼/合金 (SKD, NAK)	合金鋼/合金 (SCM, SNC)	ステンレス (SUS)	鋳鉄 (FC, FCD)
HRC30以下	HRC30~35	HRC35~40	HRC40~45	HRC30以下
◎	○	△	△	○