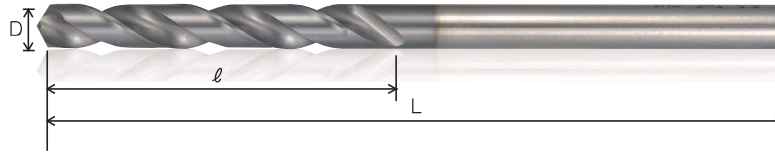


ステンレス・アルミ・スチールなどの材質に対応
Best for Stainless Steel・Aluminum and Steel

ハイス ストレートシャンクドリル 強力錐丸(キリマル)PLUS

STRONG KIRIMARU PLUS Coated HSS Straight Shank Drills



ドリルシリーズ

特長 Feature

- 先端角130°(D≤1.9 125°)、高剛性で食い付き性抜群
- 130 degrees provide high rigidity and chamfering property.
- ハンドボール盤での使用で、位置決め良好!さらに軽い
- Mark very easy when use with handball machine!Light.

単位: mm

商品コード Item Code	D	ℓ	L
TC-SSD-V 0.8	0.8	10	34
TC-SSD-V 0.9	0.9	10	36
TC-SSD-V 1.0	1.0	12	40
TC-SSD-V 1.1	1.1	14	42
TC-SSD-V 1.2	1.2	14	42
TC-SSD-V 1.3	1.3	15	45
TC-SSD-V 1.4	1.4	16	48
TC-SSD-V 1.5	1.5	17	48
TC-SSD-V 1.6	1.6	17	50
TC-SSD-V 1.7	1.7	18	50
TC-SSD-V 1.8	1.8	19	52
TC-SSD-V 1.9	1.9	19	52
TC-SSD-V 2.0	2.0	20	55
TC-SSD-V 2.1	2.1	20	55
TC-SSD-V 2.2	2.2	23	58
TC-SSD-V 2.3	2.3	23	58
TC-SSD-V 2.4	2.4	24	61
TC-SSD-V 2.5	2.5	24	61
TC-SSD-V 2.6	2.6	26	64
TC-SSD-V 2.7	2.7	26	64
TC-SSD-V 2.8	2.8	27	67
TC-SSD-V 2.9	2.9	30	71
TC-SSD-V 3.0	3.0	30	71
TC-SSD-V 3.1	3.1	30	71
TC-SSD-V 3.2	3.2	30	71
TC-SSD-V 3.3	3.3	32	73
TC-SSD-V 3.4	3.4	32	73
TC-SSD-V 3.5	3.5	32	73
TC-SSD-V 3.6	3.6	34	76
TC-SSD-V 3.7	3.7	34	76
TC-SSD-V 3.8	3.8	34	76
TC-SSD-V 3.9	3.9	36	79
TC-SSD-V 4.0	4.0	38	83
TC-SSD-V 4.1	4.1	38	83
TC-SSD-V 4.2	4.2	38	83
TC-SSD-V 4.3	4.3	38	83
TC-SSD-V 4.4	4.4	39	86
TC-SSD-V 4.5	4.5	39	86
TC-SSD-V 4.6	4.6	39	86
TC-SSD-V 4.7	4.7	41	89
TC-SSD-V 4.8	4.8	41	89
TC-SSD-V 4.9	4.9	43	92
TC-SSD-V 5.0	5.0	43	92

商品コード Item Code	D	ℓ	L
TC-SSD-V 5.1	5.1	43	92
TC-SSD-V 5.2	5.2	45	95
TC-SSD-V 5.3	5.3	45	95
TC-SSD-V 5.4	5.4	45	95
TC-SSD-V 5.5	5.5	45	95
TC-SSD-V 5.6	5.6	47	98
TC-SSD-V 5.7	5.7	47	98
TC-SSD-V 5.8	5.8	47	98
TC-SSD-V 5.9	5.9	47	98
TC-SSD-V 6.0	6.0	49	102
TC-SSD-V 6.1	6.1	49	102
TC-SSD-V 6.2	6.2	49	102
TC-SSD-V 6.3	6.3	49	102
TC-SSD-V 6.4	6.4	51	105
TC-SSD-V 6.5	6.5	51	105
TC-SSD-V 6.6	6.6	51	105
TC-SSD-V 6.7	6.7	51	105
TC-SSD-V 6.8	6.8	51	105
TC-SSD-V 6.9	6.9	51	105
TC-SSD-V 7.0	7.0	51	105
TC-SSD-V 7.1	7.1	53	108
TC-SSD-V 7.2	7.2	53	108
TC-SSD-V 7.3	7.3	53	108
TC-SSD-V 7.4	7.4	55	111
TC-SSD-V 7.5	7.5	55	111
TC-SSD-V 7.6	7.6	55	111
TC-SSD-V 7.7	7.7	57	114
TC-SSD-V 7.8	7.8	57	114
TC-SSD-V 7.9	7.9	57	114
TC-SSD-V 8.0	8.0	57	114
TC-SSD-V 8.1	8.1	59	117
TC-SSD-V 8.2	8.2	59	117
TC-SSD-V 8.3	8.3	59	117
TC-SSD-V 8.4	8.4	61	121
TC-SSD-V 8.5	8.5	61	121
TC-SSD-V 8.6	8.6	61	121
TC-SSD-V 8.7	8.7	61	121
TC-SSD-V 8.8	8.8	63	124
TC-SSD-V 8.9	8.9	63	124
TC-SSD-V 9.0	9.0	63	124
TC-SSD-V 9.1	9.1	63	124
TC-SSD-V 9.2	9.2	65	127
TC-SSD-V 9.3	9.3	65	127



単位：mm

商品コード Item Code	D	φ	L
TC-SSD-V 9.4	9.4	65	127
TC-SSD-V 9.5	9.5	65	127
TC-SSD-V 9.6	9.6	67	130
TC-SSD-V 9.7	9.7	67	130
TC-SSD-V 9.8	9.8	67	130
TC-SSD-V 9.9	9.9	67	130
TC-SSD-V 10.0	10.0	67	130
TC-SSD-V 10.1	10.1	69	133
TC-SSD-V 10.2	10.2	69	133
TC-SSD-V 10.3	10.3	69	133
TC-SSD-V 10.4	10.4	69	133
TC-SSD-V 10.5	10.5	70	137
TC-SSD-V 10.6	10.6	70	137
TC-SSD-V 10.7	10.7	70	137
TC-SSD-V 10.8	10.8	72	140
TC-SSD-V 10.9	10.9	72	140
TC-SSD-V 11.0	11.0	72	140
TC-SSD-V 11.1	11.1	72	140
TC-SSD-V 11.2	11.2	75	143

商品コード Item Code	D	φ	L
TC-SSD-V 11.3	11.3	75	143
TC-SSD-V 11.4	11.4	75	143
TC-SSD-V 11.5	11.5	75	143
TC-SSD-V 11.6	11.6	77	146
TC-SSD-V 11.7	11.7	77	146
TC-SSD-V 11.8	11.8	77	146
TC-SSD-V 11.9	11.9	77	146
TC-SSD-V 12.0	12.0	78	149
TC-SSD-V 12.1	12.1	78	149
TC-SSD-V 12.2	12.2	78	149
TC-SSD-V 12.3	12.3	78	149
TC-SSD-V 12.4	12.4	80	152
TC-SSD-V 12.5	12.5	80	152
TC-SSD-V 12.6	12.6	80	152
TC-SSD-V 12.7	12.7	80	152
TC-SSD-V 12.8	12.8	80	152
TC-SSD-V 12.9	12.9	80	152
TC-SSD-V 13.0	13.0	80	152

販売単位

- ~1.9 (5本入り/5 pcs per case)
- φ2.0~ (1本入り/1 pc per case)

標準切削条件表 Recommended cutting conditions

被削材 Work	一般鋼/鋳鉄 (SS400,S45C/FC (~HRC25))		合金鋼 (SCM/SK (25~35HRC))		合金鋼 (SCM/SK (35~40HRC))		ステンレス SUS304/316		銅合金 Copper alloy		アルミ合金 Aluminum alloy	
	回転数 n(min ⁻¹)	送り量 F(mm/rev)	回転数 n(min ⁻¹)	送り量 F(mm/rev)	回転数 n(min ⁻¹)	送り量 F(mm/rev)	回転数 n(min ⁻¹)	送り量 F(mm/rev)	回転数 n(min ⁻¹)	送り量 F(mm/rev)	回転数 n(min ⁻¹)	送り量 F(mm/rev)
0.8	10,000	0.04	9,600	0.03	7,000	0.03	5,500	0.03	10,000	0.04	20,000	0.05
1.0	9,000	0.05	7,700	0.04	5,600	0.03	4,800	0.04	8,500	0.05	18,000	0.06
2.0	5,000	0.08	4,000	0.05	2,900	0.04	2,390	0.04	4,500	0.09	9,000	0.09
3.0	3,400	0.12	2,500	0.07	1,900	0.05	1,590	0.06	2,800	0.13	6,000	0.13
4.0	2,500	0.14	2,000	0.09	1,400	0.07	1,190	0.08	2,200	0.15	4,500	0.15
5.0	2,000	0.16	1,600	0.11	1,100	0.09	960	0.10	1,800	0.18	3,600	0.18
6.0	1,600	0.17	1,300	0.14	950	0.11	800	0.11	1,400	0.19	3,000	0.20
8.0	1,300	0.18	990	0.17	720	0.14	600	0.13	1,100	0.20	2,300	0.26
10.0	1,000	0.20	800	0.19	570	0.16	480	0.15	900	0.22	1,800	0.32
12.0	850	0.23	650	0.21	470	0.20	400	0.17	710	0.25	1,400	0.36
13.0	780	0.24	600	0.23	440	0.21	370	0.17	660	0.26	1,300	0.38

※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 (SS41,S45C)	工具鋼/ブリーハードン鋼 (SKD,NAK101)	合金鋼/ステンレス鋼 (SCM,SUS304)	熱処理鋼等 Hardened Steels	硬質材 Hard material
HRC30以下	HRC30~35	HRC35~40	HRC40~45	HRC45~55
○	○	○	△	×