安比特精密工具（南京）有限公司
ANBIT Precision Tools (Nanjing) Co., Ltd

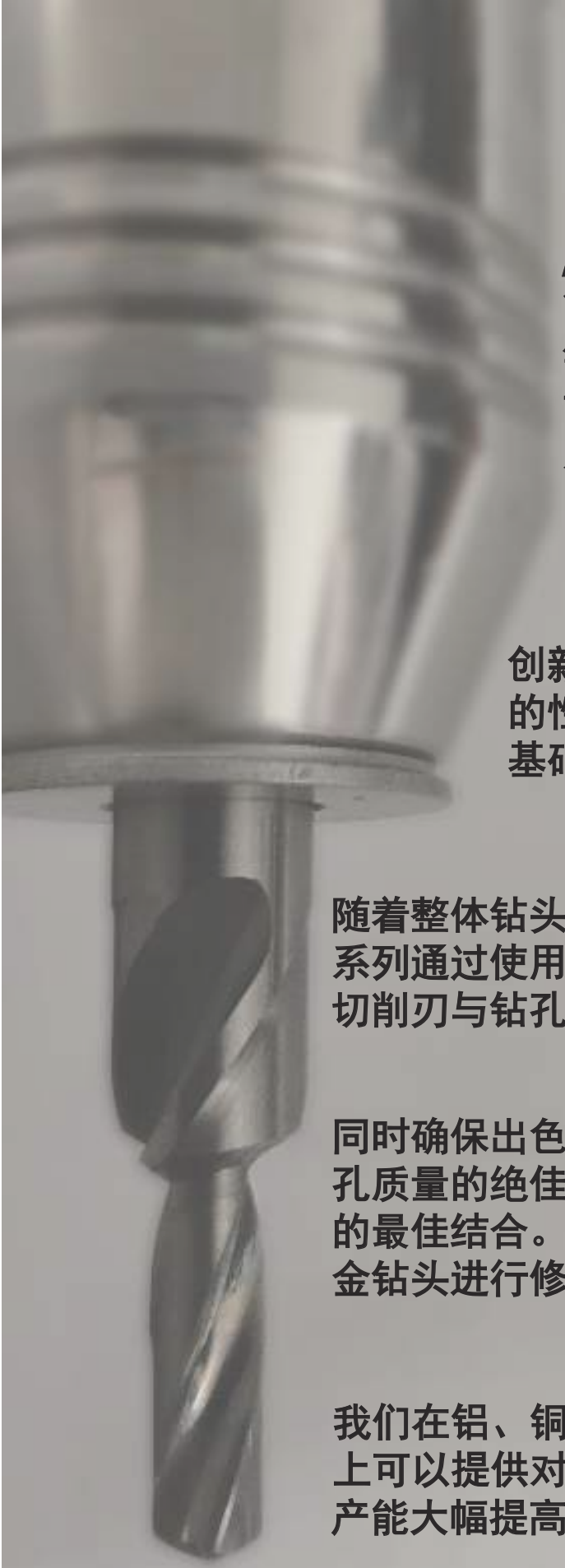
AD系列整体硬质合金钻头

整体硬质合金高性能钻头



ANBIT

解决每种材料的加工方案



公司简介

ANBIT是专业为机械加工企业提供切削工具和生产制造方案的集生产，销售，设计，服务一体的专业化公司。公司同时开设修磨中心进一步为客户降低成本，提高产品竞争力

创新的解决方案，全面的服务和高效的性能成为了我们与客户成功合作的基础

随着整体钻头的开发，AD系列整体硬质合金钻头系列通过使用新一代的高性能硬质合金和涂层，切削刃与钻孔过程始终完美匹配。

同时确保出色的加工安全性、制造经济性和良好孔质量的绝佳选择。它们实现了钻进速度与精度的最佳结合。我们还可以提供对您的整体硬质合金钻头进行修复，以实现更高的经济性。

我们在铝、铜、钢件、不锈钢、高温合金等材料上可以提供对应高效能刀具，进一步能实现客户产能大幅提高，效益明显提升的共同愿望。

ISO材料代码

P	钢和高合金钢
M	不锈钢
K	灰铸铁 可锻铸铁和球墨铸铁
N	铝合金及其他有色金属
S	特殊合金 镍基合金以及钛合金
H	硬化钢及硬化铸铁

图标说明

刀具材料	表面处理	加工深度	顶尖角	φ-公差	切削方向	柄部形式	内冷
VHM 整体硬质合金	DM	3xD	120 °	h7	R 顺时针	HA DIN6535 标准	不带内冷
	GM	4xD	130 °	m7			带内冷
	AN	5xD	135 °				
	AD	7xD	140 °				
		10xD					
		12xD					
		15xD					
		20xD					
		25xD					

产品系列

AD 10 U
AD 10 INOX
AD10R/AD15G
AD10ALU/AD15G
AD 10 H
AD 10 T

AD10U
▼钢与高合金钢，通用型 04

AD10INOX
▼不锈钢、耐酸和耐热钢
钛以及钛合金，特殊合金 18

AD10R\AD15G
▼灰口铸铁、可锻铸铁和球墨
铸铁GGV/ADI/CDI 24/31

AD10ALU\AD15G
▼铝合金、铜合金、黄铜合
金和青铜合金、塑料 36/41

AD10H
▼合金和非合金高强度钢、硬
化钢、特殊合金和钛合金 44

AD10T
▼普通钢加工最高可达1200N/mm²
通用型 53

AD 10 U

P	M	K	N	S	H	产品代号	刀具材料	表面处理	柄部形式	切削方向	钻深	d1/mm	内冷	页码
●	○	●	○	○	○	10587	VHM	DM	HA	R	3xD	3.000~20.000		06
●	○	●	○	○	○	10586	VHM	DM	HA	R	5xD	3.000~20.000		08
●	○	●	○	○	○	10590	VHM	DM	HA	R	3xD	3.000~20.000		10
●	○	●	○	○	○	10589	VHM	DM	HA	R	5xD	3.000~20.000		12
●	○	●	○	○	○	10588	VHM	DM	HA	R	7xD	3.000~20.000		14
●	○	●	○	○	○	10582	VHM	DM	HA	R	12xD	3.000~20.000		16

AD 10 INOX

P	M	K	N	S	H	产品代号	刀具材料	表面处理	柄部形式	切削方向	钻深	d1/mm	内冷	页码
○	●			○		10550	VHM	AN	HA	R	3xD	3.000~20.000		20
○	●			○		10549	VHM	AN	HA	R	5xD	3.000~20.000		22

AD10R/AD15G

P	M	K	N	S	H	产品代号	刀具材料	表面处理	柄部形式	切削方向	钻深	d1/mm	内冷	页码
●						10580	VHM	DM	HA	R	5xD	3.000~20.000		26
●						10579	VHM	DM	HA	R	7xD	4.000~20.000		29
●						10708	VHM	DM	HA	R	4xD	3.000~20.000		33
●						10706	VHM	DM	HA	R	7xD	3.000~20.000		34
●						10707	VHM	DM	HA	R	10xD	3.000~20.000		35

AD10ALU/AD15G

P	M	K	N	S	H	产品代号	刀具材料	表面处理	柄部形式	切削方向	钻深	d1/mm	内冷	页码
●						10440	VHM	无	HA	R	5xD	3.000~20.000		36
					●	10705	VHM	无	HA	R	10xD	3.000~19.500		38

AD 10 H

P	M	K	N	S	H	产品代号	刀具材料	表面处理	柄部形式	切削方向	钻深	d1/mm	内冷	页码
●				●	○	10578	VHM	DM	HA	R	3xD	3.000~20.000		46
●				●	○	10577	VHM	DM	HA	R	3xD	3.000~20.000		48
●				●	○	10575	VHM	DM	HA	R	5xD	3.000~20.000		50
●				●	○	10573	VHM	DM	HA	R	7xD	3.000~16.000		52

AD 10 T

P	M	K	N	S	H	产品代号	刀具材料	表面处理	柄部形式	切削方向	钻深	d1/mm	内冷	页码
●	●	●		○	○	13491	VHM	DM	HA	R	15xD	3.000~16.000		55
●	●	●		○	○	13489	VHM	DM	HA	R	20xD	3.000~16.000		56
●	●	●		○	○	13488	VHM	DM	HA	R	25xD	3.000~16.000		57

P

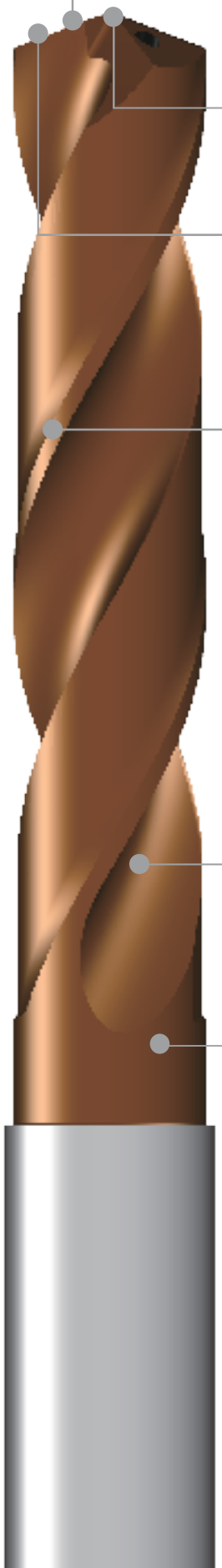
AD10U

优势和特性

- 同心度高，孔径公差小，表面粗糙度低
- 借助经优化的刀刃几何形状（带双面磨削和芯厚减薄设计）
- 在长与短切屑钢（强度高达约1200N/mm²）碳素钢、青铜、铸件和高合金ALSi合金中具有最高的切削值和出色的加工效果

钢与高合金钢

通用型



特殊几何形状可通用于几乎所有材料

芯厚减薄实现精确钻孔

钻尖倒角，即使是恶劣工况也能实现长久的使用寿命。

在钻孔深度7xD和12xD时，两个额外的导向倒角确保钻孔平直度和圆度

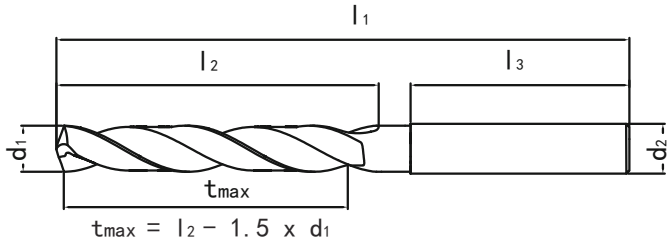
开放式切槽轮廓确保短切屑和安全排屑

DM涂层确保高切割值下的长使用时间

10587
AD10U

P	M	K	N	S	H
•	○	•	○	○	○

VHM | DM | 3xD | 140° | R | HA



芯厚≥ φ3.000 · 双后刀面 · 精密磨削过的主切削刃 · 优化了的切削几何参数

适合加工：结构钢和淬硬钢 · 易切削钢和热处理钢 · 钢（合金/非合金），强度小于1200N/mm²

- 铸件材料 · 青铜、黄铜 · 高硅铝合金

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	62,000	20,000	36,000
3,100	6,000	62,000	20,000	36,000
3,170	6,000	62,000	20,000	36,000
3,200	6,000	62,000	20,000	36,000
3,250	6,000	62,000	20,000	36,000
3,300	6,000	62,000	20,000	36,000
3,400	6,000	62,000	20,000	36,000
3,500	6,000	62,000	20,000	36,000
3,570	6,000	62,000	20,000	36,000
3,600	6,000	62,000	20,000	36,000
3,700	6,000	62,000	20,000	36,000
3,800	6,000	66,000	24,000	36,000
3,900	6,000	66,000	24,000	36,000
3,970	6,000	66,000	24,000	36,000
4,000	6,000	66,000	24,000	36,000
4,100	6,000	66,000	24,000	36,000
4,200	6,000	66,000	24,000	36,000
4,300	6,000	66,000	24,000	36,000
4,370	6,000	66,000	24,000	36,000
4,400	6,000	66,000	24,000	36,000
4,500	6,000	66,000	24,000	36,000
4,600	6,000	66,000	24,000	36,000
4,650	6,000	66,000	24,000	36,000
4,700	6,000	66,000	24,000	36,000
4,760	6,000	66,000	28,000	36,000
4,800	6,000	66,000	28,000	36,000
4,900	6,000	66,000	28,000	36,000
5,000	6,000	66,000	28,000	36,000
5,100	6,000	66,000	28,000	36,000
5,160	6,000	66,000	28,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
5,200	6,000	66,000	28,000	36,000
5,300	6,000	66,000	28,000	36,000
5,400	6,000	66,000	28,000	36,000
5,500	6,000	66,000	28,000	36,000
5,550	6,000	66,000	28,000	36,000
5,560	6,000	66,000	28,000	36,000
5,600	6,000	66,000	28,000	36,000
5,700	6,000	66,000	28,000	36,000
5,800	6,000	66,000	28,000	36,000
5,900	6,000	66,000	28,000	36,000
5,950	6,000	66,000	28,000	36,000
6,000	6,000	66,000	28,000	36,000
6,100	8,000	79,000	34,000	36,000
6,200	8,000	79,000	34,000	36,000
6,300	8,000	79,000	34,000	36,000
6,350	8,000	79,000	34,000	36,000
6,400	8,000	79,000	34,000	36,000
6,500	8,000	79,000	34,000	36,000
6,600	8,000	79,000	34,000	36,000
6,700	8,000	79,000	34,000	36,000
6,750	8,000	79,000	34,000	36,000
6,800	8,000	79,000	34,000	36,000
6,900	8,000	79,000	34,000	36,000
7,000	8,000	79,000	34,000	36,000
7,100	8,000	79,000	41,000	36,000
7,140	8,000	79,000	41,000	36,000
7,200	8,000	79,000	41,000	36,000
7,300	8,000	79,000	41,000	36,000
7,400	8,000	79,000	41,000	36,000
7,500	8,000	79,000	41,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,540	8,000	79,000	41,000	36,000
7,600	8,000	79,000	41,000	36,000
7,700	8,000	79,000	41,000	36,000
7,800	8,000	79,000	41,000	36,000
7,900	8,000	79,000	41,000	36,000
7,940	8,000	79,000	41,000	36,000
8,000	8,000	79,000	41,000	36,000
8,100	10,000	89,000	47,000	40,000
8,200	10,000	89,000	47,000	40,000
8,300	10,000	89,000	47,000	40,000
8,330	10,000	89,000	47,000	40,000
8,400	10,000	89,000	47,000	40,000
8,500	10,000	89,000	47,000	40,000
8,600	10,000	89,000	47,000	40,000
8,700	10,000	89,000	47,000	40,000
8,730	10,000	89,000	47,000	40,000
8,800	10,000	89,000	47,000	40,000
8,900	10,000	89,000	47,000	40,000
9,000	10,000	89,000	47,000	40,000
9,100	10,000	89,000	47,000	40,000
9,130	10,000	89,000	47,000	40,000
9,200	10,000	89,000	47,000	40,000
9,250	10,000	89,000	47,000	40,000
9,300	10,000	89,000	47,000	40,000
9,400	10,000	89,000	47,000	40,000
9,500	10,000	89,000	47,000	40,000
9,520	10,000	89,000	47,000	40,000
9,600	10,000	89,000	47,000	40,000
9,700	10,000	89,000	47,000	40,000
9,800	10,000	89,000	47,000	40,000
9,900	10,000	89,000	47,000	40,000
9,920	10,000	89,000	47,000	40,000
10,000	10,000	89,000	47,000	40,000
10,100	12,000	102,000	55,000	45,000
10,200	12,000	102,000	55,000	45,000
10,300	12,000	102,000	55,000	45,000
10,320	12,000	102,000	55,000	45,000
10,400	12,000	102,000	55,000	45,000
10,500	12,000	102,000	55,000	45,000
10,600	12,000	102,000	55,000	45,000
10,700	12,000	102,000	55,000	45,000
10,800	12,000	102,000	55,000	45,000
10,900	12,000	102,000	55,000	45,000
11,000	12,000	102,000	55,000	45,000
11,100	12,000	102,000	55,000	45,000
11,110	12,000	102,000	55,000	45,000
11,200	12,000	102,000	55,000	45,000
11,300	12,000	102,000	55,000	45,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
11,400	12,000	102,000	55,000	45,000
11,500	12,000	102,000	55,000	45,000
11,600	12,000	102,000	55,000	45,000
11,700	12,000	102,000	55,000	45,000
11,800	12,000	102,000	55,000	45,000
11,900	12,000	102,000	55,000	45,000
11,910	12,000	102,000	55,000	45,000
12,000	12,000	102,000	55,000	45,000
12,100	14,000	107,000	60,000	45,000
12,200	14,000	107,000	60,000	45,000
12,300	14,000	107,000	60,000	45,000
12,400	14,000	107,000	60,000	45,000
12,500	14,000	107,000	60,000	45,000
12,600	14,000	107,000	60,000	45,000
12,700	14,000	107,000	60,000	45,000
12,800	14,000	107,000	60,000	45,000
13,000	14,000	107,000	60,000	45,000
13,100	14,000	107,000	60,000	45,000
13,200	14,000	107,000	60,000	45,000
13,300	14,000	107,000	60,000	45,000
13,500	14,000	107,000	60,000	45,000
13,700	14,000	107,000	60,000	45,000
13,800	14,000	107,000	60,000	45,000
14,000	14,000	107,000	60,000	45,000
14,100	16,000	115,000	65,000	48,000
14,200	16,000	115,000	65,000	48,000
14,290	16,000	115,000	65,000	48,000
14,500	16,000	115,000	65,000	48,000
14,700	16,000	115,000	65,000	48,000
15,000	16,000	115,000	65,000	48,000
15,100	16,000	115,000	65,000	48,000
15,200	16,000	115,000	65,000	48,000
15,500	16,000	115,000	65,000	48,000
15,700	16,000	115,000	65,000	48,000
15,800	16,000	115,000	65,000	48,000
16,000	16,000	115,000	65,000	48,000
16,200	18,000	123,000	73,000	48,000
16,500	18,000	123,000	73,000	48,000
17,000	18,000	123,000	73,000	48,000
17,500	18,000	123,000	73,000	48,000
18,000	18,000	123,000	73,000	48,000
18,500	20,000	131,000	79,000	50,000
19,000	20,000	131,000	79,000	50,000
19,500	20,000	131,000	79,000	50,000
20,000	20,000	131,000	79,000	50,000

10586
AD10U

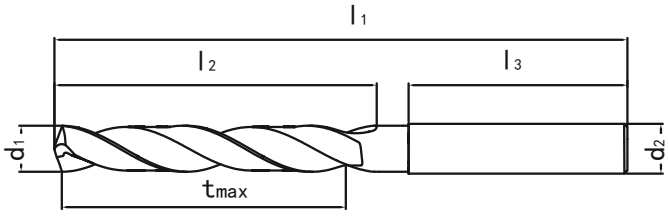
P	M	K	N	S	H
•	○	•	○	○	○

VHM | DM | 5xD | 140° | R | HA

芯厚≥ φ3.000 · 双后刀面 · 精密磨削过的主切削刃 · 优化了的切削几何参数

适合加工：结构钢和淬硬钢 · 易切削钢和热处理钢 · 钢（合金/非合金），强度小于1200N/mm²

- 铸件材料 · 青铜、黄铜 · 高硅铝合金



$t_{max} = l_2 - 1.5 \times d_1$

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	66,000	28,000	36,000
3,100	6,000	66,000	28,000	36,000
3,170	6,000	66,000	28,000	36,000
3,200	6,000	66,000	28,000	36,000
3,250	6,000	66,000	28,000	36,000
3,300	6,000	66,000	28,000	36,000
3,400	6,000	66,000	28,000	36,000
3,500	6,000	66,000	28,000	36,000
3,570	6,000	66,000	28,000	36,000
3,600	6,000	66,000	28,000	36,000
3,700	6,000	66,000	28,000	36,000
3,800	6,000	74,000	36,000	36,000
3,900	6,000	74,000	36,000	36,000
3,970	6,000	74,000	36,000	36,000
4,000	6,000	74,000	36,000	36,000
4,100	6,000	74,000	36,000	36,000
4,200	6,000	74,000	36,000	36,000
4,300	6,000	74,000	36,000	36,000
4,370	6,000	74,000	36,000	36,000
4,400	6,000	74,000	36,000	36,000
4,500	6,000	74,000	36,000	36,000
4,600	6,000	74,000	36,000	36,000
4,650	6,000	74,000	36,000	36,000
4,700	6,000	74,000	36,000	36,000
4,760	6,000	82,000	44,000	36,000
4,800	6,000	82,000	44,000	36,000
4,900	6,000	82,000	44,000	36,000
5,000	6,000	82,000	44,000	36,000
5,100	6,000	82,000	44,000	36,000
5,160	6,000	82,000	44,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
5,200	6,000	82,000	44,000	36,000
5,300	6,000	82,000	44,000	36,000
5,400	6,000	82,000	44,000	36,000
5,500	6,000	82,000	44,000	36,000
5,550	6,000	82,000	44,000	36,000
5,560	6,000	82,000	44,000	36,000
5,600	6,000	82,000	44,000	36,000
5,700	6,000	82,000	44,000	36,000
5,800	6,000	82,000	44,000	36,000
5,900	6,000	82,000	44,000	36,000
5,950	6,000	82,000	44,000	36,000
6,000	6,000	82,000	44,000	36,000
6,100	8,000	91,000	53,000	36,000
6,200	8,000	91,000	53,000	36,000
6,300	8,000	91,000	53,000	36,000
6,350	8,000	91,000	53,000	36,000
6,400	8,000	91,000	53,000	36,000
6,500	8,000	91,000	53,000	36,000
6,600	8,000	91,000	53,000	36,000
6,700	8,000	91,000	53,000	36,000
6,750	8,000	91,000	53,000	36,000
6,800	8,000	91,000	53,000	36,000
6,900	8,000	91,000	53,000	36,000
7,000	8,000	91,000	53,000	36,000
7,100	8,000	91,000	53,000	36,000
7,140	8,000	91,000	53,000	36,000
7,200	8,000	91,000	53,000	36,000
7,300	8,000	91,000	53,000	36,000
7,400	8,000	91,000	53,000	36,000
7,500	8,000	91,000	53,000	36,000

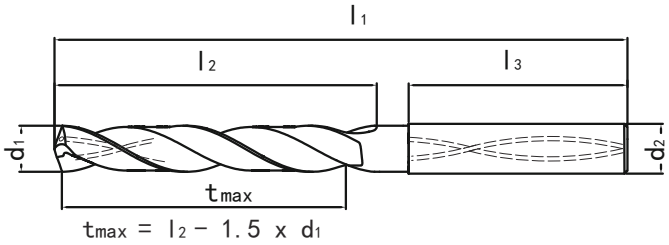
d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,540	8,000	91,000	53,000	36,000
7,600	8,000	91,000	53,000	36,000
7,700	8,000	91,000	53,000	36,000
7,800	8,000	91,000	53,000	36,000
7,900	8,000	91,000	53,000	36,000
7,940	8,000	91,000	53,000	36,000
8,000	8,000	91,000	53,000	36,000
8,100	10,000	103,000	61,000	40,000
8,200	10,000	103,000	61,000	40,000
8,300	10,000	103,000	61,000	40,000
8,330	10,000	103,000	61,000	40,000
8,400	10,000	103,000	61,000	40,000
8,500	10,000	103,000	61,000	40,000
8,600	10,000	103,000	61,000	40,000
8,700	10,000	103,000	61,000	40,000
8,730	10,000	103,000	61,000	40,000
8,800	10,000	103,000	61,000	40,000
8,900	10,000	103,000	61,000	40,000
9,000	10,000	103,000	61,000	40,000
9,100	10,000	103,000	61,000	40,000
9,130	10,000	103,000	61,000	40,000
9,200	10,000	103,000	61,000	40,000
9,250	10,000	103,000	61,000	40,000
9,300	10,000	103,000	61,000	40,000
9,400	10,000	103,000	61,000	40,000
9,500	10,000	103,000	61,000	40,000
9,520	10,000	103,000	61,000	40,000
9,600	10,000	103,000	61,000	40,000
9,700	10,000	103,000	61,000	40,000
9,800	10,000	103,000	61,000	40,000
9,900	10,000	103,000	61,000	40,000
9,920	10,000	103,000	61,000	40,000
10,000	10,000	103,000	61,000	40,000
10,100	12,000	118,000	71,000	45,000
10,200	12,000	118,000	71,000	45,000
10,300	12,000	118,000	71,000	45,000
10,320	12,000	118,000	71,000	45,000
10,400	12,000	118,000	71,000	45,000
10,500	12,000	118,000	71,000	45,000
10,600	12,000	118,000	71,000	45,000
10,700	12,000	118,000	71,000	45,000
10,800	12,000	118,000	71,000	45,000
10,900	12,000	118,000	71,000	45,000
11,000	12,000	118,000	71,000	45,000
11,100	12,000	118,000	71,000	45,000
11,110	12,000	118,000	71,000	45,000
11,200	12,000	118,000	71,000	45,000
11,300	12,000	118,000	71,000	45,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
11,400	12,000	118,000	71,000	45,000
11,500	12,000	118,000	71,000	45,000
11,600	12,000	118,000	71,000	45,000
11,700	12,000	118,000	71,000	45,000
11,800	12,000	118,000	71,000	45,000
11,900	12,000	118,000	71,000	45,000
11,910	12,000	118,000	71,000	45,000
12,000	12,000	118,000	71,000	45,000
12,100	14,000	124,000	77,000	45,000
12,200	14,000	124,000	77,000	45,000
12,500	14,000	124,000	77,000	45,000
12,700	14,000	124,000	77,000	45,000
13,000	14,000	124,000	77,000	45,000
13,100	14,000	124,000	77,000	45,000
13,500	14,000	124,000	77,000	45,000
13,700	14,000	124,000	77,000	45,000
13,800	14,000	124,000	77,000	45,000
14,000	14,000	124,000	77,000	45,000
14,100	16,000	133,000	83,000	48,000
14,200	16,000	133,000	83,000	48,000
14,290	16,000	133,000	83,000	48,000
14,500	16,000	133,000	83,000	48,000
14,700	16,000	133,000	83,000	48,000
15,000	16,000	133,000	83,000	48,000
15,100	16,000	133,000	83,000	48,000
15,200	16,000	133,000	83,000	48,000
15,500	16,000	133,000	83,000	48,000
15,700	16,000	133,000	83,000	48,000
16,000	16,000	133,000	83,000	48,000
16,500	18,000	143,000	93,000	48,000
17,000	18,000	143,000	93,000	48,000
17,500	18,000	143,000	93,000	48,000
18,000	18,000	143,000	93,000	48,000
18,500	20,000	153,000	101,000	50,000
19,000	20,000	153,000	101,000	50,000
19,500	20,000	153,000	101,000	50,000
20,000	20,000	153,000	101,000	50,000

10590
AD10U

P	M	K	N	S	H
•	○	•	○	○	○

VHM | DM | 3xD | 140° | R | HA



$t_{max} = l_2 - 1.5 \times d_1$

芯厚≥ φ3.000 · 双后刀面 · 精密磨削过的主切削刃 · 优化了的切削几何参数

适合加工：结构钢和淬硬钢 · 易切削钢和热处理钢 · 钢（合金/非合金），强度小于1200N/mm²

- 铸件材料 · 青铜、黄铜 · 高硅铝合金

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	62,000	20,000	36,000
3,100	6,000	62,000	20,000	36,000
3,170	6,000	62,000	20,000	36,000
3,200	6,000	62,000	20,000	36,000
3,250	6,000	62,000	20,000	36,000
3,300	6,000	62,000	20,000	36,000
3,400	6,000	62,000	20,000	36,000
3,500	6,000	62,000	20,000	36,000
3,570	6,000	62,000	20,000	36,000
3,600	6,000	62,000	20,000	36,000
3,700	6,000	62,000	20,000	36,000
3,800	6,000	66,000	24,000	36,000
3,900	6,000	66,000	24,000	36,000
3,970	6,000	66,000	24,000	36,000
4,000	6,000	66,000	24,000	36,000
4,100	6,000	66,000	24,000	36,000
4,200	6,000	66,000	24,000	36,000
4,300	6,000	66,000	24,000	36,000
4,370	6,000	66,000	24,000	36,000
4,400	6,000	66,000	24,000	36,000
4,500	6,000	66,000	24,000	36,000
4,600	6,000	66,000	24,000	36,000
4,650	6,000	66,000	24,000	36,000
4,700	6,000	66,000	24,000	36,000
4,760	6,000	66,000	28,000	36,000
4,800	6,000	66,000	28,000	36,000
4,900	6,000	66,000	28,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
5,000	6,000	66,000	28,000	36,000
5,100	6,000	66,000	28,000	36,000
5,160	6,000	66,000	28,000	36,000
5,200	6,000	66,000	28,000	36,000
5,300	6,000	66,000	28,000	36,000
5,400	6,000	66,000	28,000	36,000
5,500	6,000	66,000	28,000	36,000
5,550	6,000	66,000	28,000	36,000
5,560	6,000	66,000	28,000	36,000
5,600	6,000	66,000	28,000	36,000
5,700	6,000	66,000	28,000	36,000
5,800	6,000	66,000	28,000	36,000
5,900	6,000	66,000	28,000	36,000
5,950	6,000	66,000	28,000	36,000
6,000	6,000	66,000	28,000	36,000
6,100	8,000	79,000	34,000	36,000
6,200	8,000	79,000	34,000	36,000
6,300	8,000	79,000	34,000	36,000
6,350	8,000	79,000	34,000	36,000
6,400	8,000	79,000	34,000	36,000
6,500	8,000	79,000	34,000	36,000
6,600	8,000	79,000	34,000	36,000
6,700	8,000	79,000	34,000	36,000
6,750	8,000	79,000	34,000	36,000
6,800	8,000	79,000	34,000	36,000
6,900	8,000	79,000	34,000	36,000
7,000	8,000	79,000	34,000	36,000
7,100	8,000	79,000	41,000	36,000
7,140	8,000	79,000	41,000	36,000
7,200	8,000	79,000	41,000	36,000

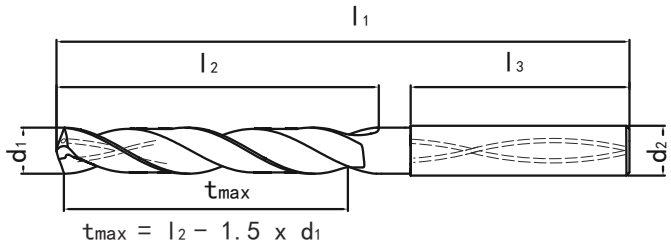
d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,300	8,000	79,000	41,000	36,000
7,400	8,000	79,000	41,000	36,000
7,500	8,000	79,000	41,000	36,000
7,540	8,000	79,000	41,000	36,000
7,600	8,000	79,000	41,000	36,000
7,700	8,000	79,000	41,000	36,000
7,800	8,000	79,000	41,000	36,000
7,900	8,000	79,000	41,000	36,000
7,940	8,000	79,000	41,000	36,000
8,000	8,000	79,000	41,000	36,000
8,100	10,000	89,000	47,000	40,000
8,200	10,000	89,000	47,000	40,000
8,300	10,000	89,000	47,000	40,000
8,330	10,000	89,000	47,000	40,000
8,400	10,000	89,000	47,000	40,000
8,500	10,000	89,000	47,000	40,000
8,600	10,000	89,000	47,000	40,000
8,700	10,000	89,000	47,000	40,000
8,730	10,000	89,000	47,000	40,000
8,800	10,000	89,000	47,000	40,000
8,900	10,000	89,000	47,000	40,000
9,000	10,000	89,000	47,000	40,000
9,100	10,000	89,000	47,000	40,000
9,130	10,000	89,000	47,000	40,000
9,200	10,000	89,000	47,000	40,000
9,250	10,000	89,000	47,000	40,000
9,300	10,000	89,000	47,000	40,000
9,400	10,000	89,000	47,000	40,000
9,500	10,000	89,000	47,000	40,000
9,520	10,000	89,000	47,000	40,000
9,600	10,000	89,000	47,000	40,000
9,700	10,000	89,000	47,000	40,000
9,800	10,000	89,000	47,000	40,000
9,900	10,000	89,000	47,000	40,000
9,920	10,000	89,000	47,000	40,000
10,000	10,000	89,000	47,000	40,000
10,100	12,000	102,000	55,000	45,000
10,200	12,000	102,000	55,000	45,000
10,300	12,000	102,000	55,000	45,000
10,320	12,000	102,000	55,000	45,000
10,400	12,000	102,000	55,000	45,000
10,500	12,000	102,000	55,000	45,000
10,600	12,000	102,000	55,000	45,000
10,700	12,000	102,000	55,000	45,000
10,800	12,000	102,000	55,000	45,000
10,900	12,000	102,000	55,000	45,000
11,000	12,000	102,000	55,000	45,000
11,100	12,000	102,000	55,000	45,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
11,110	12,000	102,000	55,000	45,000
11,200	12,000	102,000	55,000	45,000
11,300	12,000	102,000	55,000	45,000
11,400	12,000	102,000	55,000	45,000
11,500	12,000	102,000	55,000	45,000
11,600	12,000	102,000	55,000	45,000
11,700	12,000	102,000	55,000	45,000
11,800	12,000	102,000	55,000	45,000
11,900	12,000	102,000	55,000	45,000
11,910	12,000	102,000	55,000	45,000
12,000	12,000	102,000	55,000	45,000
12,100	14,000	107,000	60,000	45,000
12,200	14,000	107,000	60,000	45,000
12,300	14,000	107,000	60,000	45,000
12,500	14,000	107,000	60,000	45,000
12,700	14,000	107,000	60,000	45,000
13,000	14,000	107,000	60,000	45,000
13,200	14,000	107,000	60,000	45,000
13,300	14,000	107,000	60,000	45,000
13,500	14,000	107,000	60,000	45,000
13,700	14,000	107,000	60,000	45,000
14,000	14,000	107,000	60,000	45,000
14,200	16,000	115,000	65,000	48,000
14,290	16,000	115,000	65,000	48,000
14,400	16,000	115,000	65,000	48,000
14,500	16,000	115,000	65,000	48,000
14,600	16,000	115,000	65,000	48,000
14,700	16,000	115,000	65,000	48,000
15,000	16,000	115,000	65,000	48,000
15,200	16,000	115,000	65,000	48,000
15,500	16,000	115,000	65,000	48,000
15,700	16,000	115,000	65,000	48,000
16,000	16,000	115,000	65,000	48,000
16,100	18,000	123,000	73,000	48,000
16,500	18,000	123,000	73,000	48,000
16,900	18,000	123,000	73,000	48,000
17,000	18,000	123,000	73,000	48,000
17,300	18,000	123,000	73,000	48,000
17,500	18,000	123,000	73,000	48,000
18,000	18,000	123,000	73,000	48,000
18,500	20,000	131,000	79,000	50,000
18,900	20,000	131,000	79,000	50,000
19,000	20,000	131,000	79,000	50,000
19,500	20,000	131,000	79,000	50,000
20,000	20,000	131,000	79,000	50,000

10589
AD10U

P	M	K	N	S	H
•	○	•	○	○	○

VHM | DM | 5xD | 140° | R | HA



芯厚≥ φ3.000 · 双后刀面 · 精密磨削过的主切削刃 · 优化了的切削几何参数

适合加工：结构钢和淬硬钢 · 易切削钢和热处理钢 · 钢（合金/非合金），强度小于1200N/mm²

- 铸件材料 · 青铜、黄铜 · 高硅铝合金

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	66,000	28,000	36,000
3,100	6,000	66,000	28,000	36,000
3,170	6,000	66,000	28,000	36,000
3,200	6,000	66,000	28,000	36,000
3,250	6,000	66,000	28,000	36,000
3,300	6,000	66,000	28,000	36,000
3,400	6,000	66,000	28,000	36,000
3,500	6,000	66,000	28,000	36,000
3,570	6,000	66,000	28,000	36,000
3,600	6,000	66,000	28,000	36,000
3,700	6,000	66,000	28,000	36,000
3,800	6,000	74,000	36,000	36,000
3,900	6,000	74,000	36,000	36,000
3,970	6,000	74,000	36,000	36,000
4,000	6,000	74,000	36,000	36,000
4,100	6,000	74,000	36,000	36,000
4,200	6,000	74,000	36,000	36,000
4,300	6,000	74,000	36,000	36,000
4,370	6,000	74,000	36,000	36,000
4,400	6,000	74,000	36,000	36,000
4,500	6,000	74,000	36,000	36,000
4,600	6,000	74,000	36,000	36,000
4,650	6,000	74,000	36,000	36,000
4,700	6,000	74,000	36,000	36,000
4,760	6,000	82,000	44,000	36,000
4,800	6,000	82,000	44,000	36,000
4,900	6,000	82,000	44,000	36,000
5,000	6,000	82,000	44,000	36,000
5,100	6,000	82,000	44,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
5,160	6,000	82,000	44,000	36,000
5,200	6,000	82,000	44,000	36,000
5,300	6,000	82,000	44,000	36,000
5,400	6,000	82,000	44,000	36,000
5,500	6,000	82,000	44,000	36,000
5,550	6,000	82,000	44,000	36,000
5,560	6,000	82,000	44,000	36,000
5,600	6,000	82,000	44,000	36,000
5,700	6,000	82,000	44,000	36,000
5,800	6,000	82,000	44,000	36,000
5,900	6,000	82,000	44,000	36,000
5,950	6,000	82,000	44,000	36,000
6,000	6,000	82,000	44,000	36,000
6,100	8,000	91,000	53,000	36,000
6,200	8,000	91,000	53,000	36,000
6,300	8,000	91,000	53,000	36,000
6,350	8,000	91,000	53,000	36,000
6,400	8,000	91,000	53,000	36,000
6,500	8,000	91,000	53,000	36,000
6,600	8,000	91,000	53,000	36,000
6,700	8,000	91,000	53,000	36,000
6,750	8,000	91,000	53,000	36,000
6,800	8,000	91,000	53,000	36,000
6,900	8,000	91,000	53,000	36,000
7,000	8,000	91,000	53,000	36,000
7,100	8,000	91,000	53,000	36,000
7,140	8,000	91,000	53,000	36,000
7,200	8,000	91,000	53,000	36,000
7,300	8,000	91,000	53,000	36,000
7,400	8,000	91,000	53,000	36,000

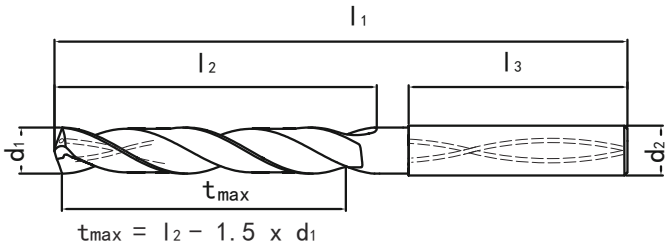
d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,500	8,000	91,000	53,000	36,000
7,540	8,000	91,000	53,000	36,000
7,600	8,000	91,000	53,000	36,000
7,700	8,000	91,000	53,000	36,000
7,800	8,000	91,000	53,000	36,000
7,900	8,000	91,000	53,000	36,000
7,940	8,000	91,000	53,000	36,000
8,000	8,000	91,000	53,000	36,000
8,100	10,000	103,000	61,000	40,000
8,200	10,000	103,000	61,000	40,000
8,300	10,000	103,000	61,000	40,000
8,330	10,000	103,000	61,000	40,000
8,400	10,000	103,000	61,000	40,000
8,500	10,000	103,000	61,000	40,000
8,600	10,000	103,000	61,000	40,000
8,700	10,000	103,000	61,000	40,000
8,730	10,000	103,000	61,000	40,000
8,800	10,000	103,000	61,000	40,000
8,900	10,000	103,000	61,000	40,000
9,000	10,000	103,000	61,000	40,000
9,100	10,000	103,000	61,000	40,000
9,130	10,000	103,000	61,000	40,000
9,200	10,000	103,000	61,000	40,000
9,250	10,000	103,000	61,000	40,000
9,300	10,000	103,000	61,000	40,000
9,400	10,000	103,000	61,000	40,000
9,500	10,000	103,000	61,000	40,000
9,520	10,000	103,000	61,000	40,000
9,600	10,000	103,000	61,000	40,000
9,700	10,000	103,000	61,000	40,000
9,800	10,000	103,000	61,000	40,000
9,900	10,000	103,000	61,000	40,000
9,920	10,000	103,000	61,000	40,000
10,000	10,000	103,000	61,000	40,000
10,100	12,000	118,000	71,000	45,000
10,200	12,000	118,000	71,000	45,000
10,300	12,000	118,000	71,000	45,000
10,320	12,000	118,000	71,000	45,000
10,400	12,000	118,000	71,000	45,000
10,500	12,000	118,000	71,000	45,000
10,600	12,000	118,000	71,000	45,000
10,700	12,000	118,000	71,000	45,000
10,800	12,000	118,000	71,000	45,000
10,900	12,000	118,000	71,000	45,000
11,000	12,000	118,000	71,000	45,000
11,100	12,000	118,000	71,000	45,000
11,110	12,000	118,000	71,000	45,000
11,200	12,000	118,000	71,000	45,000
11,300	12,000	118,000	71,000	45,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
11,400	12,000	118,000	71,000	45,000
11,500	12,000	118,000	71,000	45,000
11,600	12,000	118,000	71,000	45,000
11,700	12,000	118,000	71,000	45,000
11,800	12,000	118,000	71,000	45,000
11,900	12,000	118,000	71,000	45,000
11,910	12,000	118,000	71,000	45,000
12,000	12,000	118,000	71,000	45,000
12,100	14,000	124,000	77,000	45,000
12,200	14,000	124,000	77,000	45,000
12,300	14,000	124,000	77,000	45,000
12,400	14,000	124,000	77,000	45,000
12,500	14,000	124,000	77,000	45,000
12,600	14,000	124,000	77,000	45,000
12,700	14,000	124,000	77,000	45,000
12,800	14,000	124,000	77,000	45,000
13,000	14,000	124,000	77,000	45,000
13,100	14,000	124,000	77,000	45,000
13,300	14,000	124,000	77,000	45,000
13,500	14,000	124,000	77,000	45,000
13,700	14,000	124,000	77,000	45,000
13,800	14,000	124,000	77,000	45,000
14,000	14,000	124,000	77,000	45,000
14,100	16,000	133,000	83,000	48,000
14,200	16,000	133,000	83,000	48,000
14,290	16,000	133,000	83,000	48,000
14,500	16,000	133,000	83,000	48,000
14,700	16,000	133,000	83,000	48,000
14,800	16,000	133,000	83,000	48,000
15,000	16,000	133,000	83,000	48,000
15,100	16,000	133,000	83,000	48,000
15,200	16,000	133,000	83,000	48,000
15,300	16,000	133,000	83,000	48,000
15,500	16,000	133,000	83,000	48,000
15,700	16,000	133,000	83,000	48,000
15,800	16,000	133,000	83,000	48,000
16,000	16,000	133,000	83,000	48,000
16,500	18,000	143,000	93,000	48,000
16,900	18,000	143,000	93,000	48,000
17,000	18,000	143,000	93,000	48,000
17,500	18,000	143,000	93,000	48,000
18,000	18,000	143,000	93,000	48,000
18,500	20,000	153,000	101,000	50,000
18,900	20,000	153,000	101,000	50,000
19,000	20,000	153,000	101,000	50,000
19,050	20,000	153,000	101,000	50,000
19,500	20,000	153,000	101,000	50,000
20,000	20,000	153,000	101,000	50,000

10588
AD10U

P	M	K	N	S	H
•	○	•	○	○	○

VHM | DM | 7xD | 140° | R | HA



$t_{max} = l_2 - 1.5 \times d_1$

芯厚≥ φ3.000 · 双后刀面 · 精密磨削过的主切削刃 · 优化了的切削几何参数

适合加工：结构钢和淬硬钢 · 易切削钢和热处理钢 · 钢（合金/非合金），强度小于1200N/mm²

- 铸件材料 · 青铜、黄铜 · 高硅铝合金

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	70,000	30,000	36,000
3,100	6,000	70,000	30,000	36,000
3,170	6,000	70,000	30,000	36,000
3,200	6,000	70,000	30,000	36,000
3,250	6,000	70,000	30,000	36,000
3,300	6,000	70,000	30,000	36,000
3,400	6,000	75,000	35,500	36,000
3,500	6,000	75,000	35,500	36,000
3,570	6,000	75,000	35,500	36,000
3,600	6,000	75,000	35,500	36,000
3,700	6,000	75,000	35,500	36,000
3,800	6,000	75,000	37,500	36,000
3,900	6,000	75,000	37,500	36,000
3,970	6,000	75,000	37,500	36,000
4,000	6,000	75,000	37,500	36,000
4,100	6,000	75,000	37,500	36,000
4,200	6,000	75,000	37,500	36,000
4,300	6,000	85,000	45,000	36,000
4,370	6,000	85,000	45,000	36,000
4,400	6,000	85,000	45,000	36,000
4,500	6,000	85,000	45,000	36,000
4,600	6,000	85,000	45,000	36,000
4,650	6,000	85,000	45,000	36,000
4,700	6,000	85,000	45,000	36,000
4,760	6,000	90,000	50,000	36,000
4,800	6,000	90,000	50,000	36,000
4,900	6,000	90,000	50,000	36,000
5,000	6,000	90,000	50,000	36,000
5,100	6,000	90,000	50,000	36,000
5,160	6,000	90,000	50,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
5,200	6,000	90,000	50,000	36,000
5,300	6,000	90,000	50,000	36,000
5,400	6,000	97,000	57,000	36,000
5,500	6,000	97,000	57,000	36,000
5,700	6,000	97,000	57,000	36,000
5,800	6,000	97,000	57,000	36,000
5,900	6,000	97,000	57,000	36,000
5,950	6,000	97,000	57,000	36,000
6,000	6,000	97,000	57,000	36,000
6,200	8,000	106,000	66,000	36,000
6,300	8,000	106,000	66,000	36,000
6,350	8,000	106,000	66,000	36,000
6,500	8,000	106,000	66,000	36,000
6,600	8,000	106,000	66,000	36,000
6,700	8,000	106,000	66,000	36,000
6,800	8,000	106,000	66,000	36,000
6,900	8,000	116,000	76,000	36,000
7,000	8,000	116,000	76,000	36,000
7,100	8,000	116,000	76,000	36,000
7,200	8,000	116,000	76,000	36,000
7,500	8,000	116,000	76,000	36,000
7,600	8,000	116,000	76,000	36,000
7,700	8,000	116,000	76,000	36,000
7,800	8,000	116,000	76,000	36,000
8,000	8,000	116,000	76,000	36,000
8,100	10,000	131,000	87,000	40,000
8,200	10,000	131,000	87,000	40,000
8,400	10,000	131,000	87,000	40,000
8,500	10,000	131,000	87,000	40,000
8,600	10,000	131,000	87,000	40,000

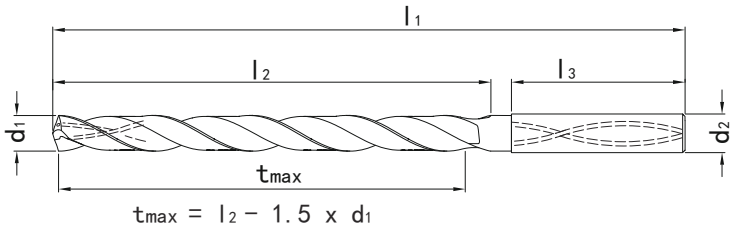
d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
8,700	10,000	131,000	87,000	40,000
8,800	10,000	131,000	87,000	40,000
9,000	10,000	131,000	87,000	40,000
9,100	10,000	139,000	95,000	40,000
9,200	10,000	139,000	95,000	40,000
9,250	10,000	139,000	95,000	40,000
9,300	10,000	139,000	95,000	40,000
9,400	10,000	139,000	95,000	40,000
9,500	10,000	139,000	95,000	40,000
9,520	10,000	139,000	95,000	40,000
9,700	10,000	139,000	95,000	40,000
9,800	10,000	139,000	95,000	40,000
9,900	10,000	139,000	95,000	40,000
10,000	10,000	139,000	95,000	40,000
10,200	12,000	155,000	106,000	45,000
10,300	12,000	155,000	106,000	45,000
10,500	12,000	155,000	106,000	45,000
10,800	12,000	155,000	106,000	45,000
11,000	12,000	155,000	106,000	45,000
11,200	12,000	163,000	114,000	45,000
11,500	12,000	163,000	114,000	45,000
11,800	12,000	163,000	114,000	45,000
12,000	12,000	163,000	114,000	45,000
12,100	14,000	182,000	133,000	45,000
12,200	14,000	182,000	133,000	45,000
12,500	14,000	182,000	133,000	45,000
12,700	14,000	182,000	133,000	45,000
13,000	14,000	182,000	133,000	45,000
13,100	14,000	182,000	133,000	45,000
13,500	14,000	182,000	133,000	45,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
14,000	14,000	182,000	133,000	45,000
14,100	16,000	204,000	152,000	48,000
14,200	16,000	204,000	152,000	48,000
14,500	16,000	204,000	152,000	48,000
15,000	16,000	204,000	152,000	48,000
15,100	16,000	204,000	152,000	48,000
15,500	16,000	204,000	152,000	48,000
16,000	16,000	204,000	152,000	48,000
16,500	18,000	223,000	171,000	48,000
16,900	18,000	223,000	171,000	48,000
17,000	18,000	223,000	171,000	48,000
17,500	18,000	223,000	171,000	48,000
18,000	18,000	223,000	171,000	48,000
18,500	20,000	244,000	190,000	50,000
18,900	20,000	244,000	190,000	50,000
19,000	20,000	244,000	190,000	50,000
19,050	20,000	244,000	190,000	50,000
19,500	20,000	244,000	190,000	50,000
20,000	20,000	244,000	190,000	50,000

10582
AD10U

P	M	K	N	S	H
•	○	•	○	○	○

VHM | DM | 12xD | 135° | R | HA



$t_{max} = l_2 - 1.5 \times d_1$

芯厚≥ φ3.000 · 双后刀面 · 刀尖涂层 · 精密磨削过的主切削刃 · 优化了的切削几何参数

适合加工：结构钢和淬硬钢 · 易切削钢和热处理钢 · 钢（合金/非合金），强度小于1200N/mm²

- 铸件材料 · 青铜、黄铜 · 高硅铝合金

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	90,000	50,000	36,000
3,100	6,000	90,000	50,000	36,000
3,170	6,000	90,000	50,000	36,000
3,200	6,000	90,000	50,000	36,000
3,300	6,000	90,000	50,000	36,000
3,400	6,000	90,000	50,000	36,000
3,500	6,000	90,000	50,000	36,000
3,600	6,000	90,000	50,000	36,000
3,700	6,000	90,000	50,000	36,000
3,800	6,000	102,000	64,000	36,000
3,900	6,000	102,000	64,000	36,000
4,000	6,000	102,000	64,000	36,000
4,100	6,000	102,000	64,000	36,000
4,200	6,000	102,000	64,000	36,000
4,300	6,000	102,000	64,000	36,000
4,400	6,000	102,000	64,000	36,000
4,500	6,000	102,000	64,000	36,000
4,600	6,000	102,000	64,000	36,000
4,700	6,000	102,000	64,000	36,000
4,800	6,000	116,000	78,000	36,000
4,900	6,000	116,000	78,000	36,000
5,000	6,000	116,000	78,000	36,000
5,100	6,000	116,000	78,000	36,000
5,200	6,000	116,000	78,000	36,000
5,300	6,000	116,000	78,000	36,000
5,400	6,000	116,000	78,000	36,000
5,500	6,000	116,000	78,000	36,000
5,600	6,000	116,000	78,000	36,000
5,700	6,000	116,000	78,000	36,000
5,800	6,000	116,000	78,000	36,000
5,900	6,000	116,000	78,000	36,000
6,000	6,000	116,000	78,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
6,100	8,000	146,000	108,000	36,000
6,200	8,000	146,000	108,000	36,000
6,300	8,000	146,000	108,000	36,000
6,350	8,000	146,000	108,000	36,000
6,400	8,000	146,000	108,000	36,000
6,500	8,000	146,000	108,000	36,000
6,600	8,000	146,000	108,000	36,000
6,700	8,000	146,000	108,000	36,000
6,800	8,000	146,000	108,000	36,000
6,900	8,000	146,000	108,000	36,000
7,000	8,000	146,000	108,000	36,000
7,100	8,000	146,000	108,000	36,000
7,200	8,000	146,000	108,000	36,000
7,300	8,000	146,000	108,000	36,000
7,400	8,000	146,000	108,000	36,000
7,500	8,000	146,000	108,000	36,000
7,600	8,000	146,000	108,000	36,000
7,700	8,000	146,000	108,000	36,000
7,800	8,000	146,000	108,000	36,000
7,900	8,000	146,000	108,000	36,000
8,000	8,000	146,000	108,000	36,000
8,100	10,000	162,000	120,000	40,000
8,200	10,000	162,000	120,000	40,000
8,300	10,000	162,000	120,000	40,000
8,400	10,000	162,000	120,000	40,000
8,500	10,000	162,000	120,000	40,000
8,600	10,000	162,000	120,000	40,000
8,700	10,000	162,000	120,000	40,000
8,800	10,000	162,000	120,000	40,000
8,900	10,000	162,000	120,000	40,000
9,000	10,000	162,000	120,000	40,000
9,100	10,000	162,000	120,000	40,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
9,200	10,000	162,000	120,000	40,000
9,300	10,000	162,000	120,000	40,000
9,400	10,000	162,000	120,000	40,000
9,500	10,000	162,000	120,000	40,000
9,520	10,000	162,000	120,000	40,000
9,600	10,000	162,000	120,000	40,000
9,700	10,000	162,000	120,000	40,000
9,800	10,000	162,000	120,000	40,000
9,900	10,000	162,000	120,000	40,000
10,000	10,000	162,000	120,000	40,000
10,200	12,000	204,000	156,000	45,000
10,500	12,000	204,000	156,000	45,000
11,000	12,000	204,000	156,000	45,000
11,500	12,000	204,000	156,000	45,000
12,000	12,000	204,000	156,000	45,000
12,500	14,000	230,000	182,000	45,000
12,700	14,000	230,000	182,000	45,000
13,000	14,000	230,000	182,000	45,000
13,500	14,000	230,000	182,000	45,000
14,000	14,000	230,000	182,000	45,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
14,500	16,000	260,000	208,000	48,000
15,000	16,000	260,000	208,000	48,000
15,500	16,000	260,000	208,000	48,000
16,000	16,000	260,000	208,000	48,000
16,500	18,000	285,000	234,000	48,000
17,000	18,000	285,000	234,000	48,000
17,500	18,000	285,000	234,000	48,000
18,000	18,000	285,000	234,000	48,000
18,500	20,000	310,000	258,000	50,000
19,000	20,000	310,000	258,000	50,000
19,050	20,000	310,000	258,000	50,000
19,500	20,000	310,000	258,000	50,000
20,000	20,000	310,000	258,000	50,000

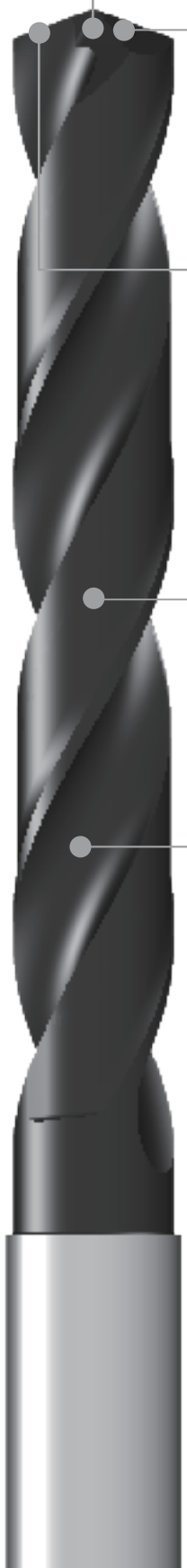
优势和特性

- 在不锈钢、耐酸和耐热钢、因科镍合金、哈氏合金、镍铬合金、钛和钛合金中实现准确钻孔也是长使用寿命的专家

- 使用AD10 INOX可实现高进给速度--可快速排屑并防止产生切屑瘤

AD10INOX

不锈钢、耐酸和耐热钢、钛和钛合金、特殊合金



特殊尖点打薄实现精确钻孔

最大的冷却通道横截面确保完美的冷却润滑

专为高合金材料切削加工设计的锋利几何形状和刃口缘预加工

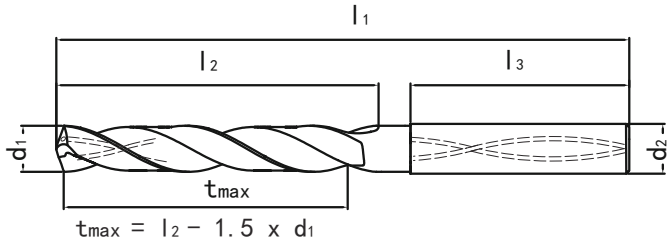
极为平滑的耐磨AN涂层确保在不锈钢和耐酸钢中有良好的效果

开放式排屑槽设计，即使长屑材料也可以实现完美排屑

10550
AD10INOX

P	M	K	N	S	H
○	•			○	

VHM | AN | 3xD | 140° | R | HA



芯厚≥ φ3.000・双后刀面・精密磨削过的主切削刃・优化了的切削几何参数

适合加工：不锈钢/耐酸/耐热钢・钛以及钛合金・镍合金，哈氏合金，锰合金

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	62,000	20,000	36,000
3,100	6,000	62,000	20,000	36,000
3,170	6,000	62,000	20,000	36,000
3,200	6,000	62,000	20,000	36,000
3,250	6,000	62,000	20,000	36,000
3,300	6,000	62,000	20,000	36,000
3,400	6,000	62,000	20,000	36,000
3,500	6,000	62,000	20,000	36,000
3,570	6,000	62,000	20,000	36,000
3,600	6,000	62,000	20,000	36,000
3,700	6,000	62,000	20,000	36,000
3,800	6,000	66,000	24,000	36,000
3,900	6,000	66,000	24,000	36,000
3,970	6,000	66,000	24,000	36,000
4,000	6,000	66,000	24,000	36,000
4,100	6,000	66,000	24,000	36,000
4,200	6,000	66,000	24,000	36,000
4,300	6,000	66,000	24,000	36,000
4,370	6,000	66,000	24,000	36,000
4,400	6,000	66,000	24,000	36,000
4,500	6,000	66,000	24,000	36,000
4,600	6,000	66,000	24,000	36,000
4,650	6,000	66,000	24,000	36,000
4,700	6,000	66,000	24,000	36,000
4,760	6,000	66,000	28,000	36,000
4,800	6,000	66,000	28,000	36,000
4,900	6,000	66,000	28,000	36,000
5,000	6,000	66,000	28,000	36,000
5,100	6,000	66,000	28,000	36,000
5,160	6,000	66,000	28,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
5,200	6,000	66,000	28,000	36,000
5,300	6,000	66,000	28,000	36,000
5,400	6,000	66,000	28,000	36,000
5,500	6,000	66,000	28,000	36,000
5,550	6,000	66,000	28,000	36,000
5,560	6,000	66,000	28,000	36,000
5,600	6,000	66,000	28,000	36,000
5,700	6,000	66,000	28,000	36,000
5,800	6,000	66,000	28,000	36,000
5,900	6,000	66,000	28,000	36,000
5,950	6,000	66,000	28,000	36,000
6,000	6,000	66,000	28,000	36,000
6,100	8,000	79,000	34,000	36,000
6,200	8,000	79,000	34,000	36,000
6,300	8,000	79,000	34,000	36,000
6,350	8,000	79,000	34,000	36,000
6,400	8,000	79,000	34,000	36,000
6,500	8,000	79,000	34,000	36,000
6,600	8,000	79,000	34,000	36,000
6,700	8,000	79,000	34,000	36,000
6,750	8,000	79,000	34,000	36,000
6,800	8,000	79,000	34,000	36,000
6,900	8,000	79,000	34,000	36,000
7,000	8,000	79,000	34,000	36,000
7,100	8,000	79,000	41,000	36,000
7,140	8,000	79,000	41,000	36,000
7,200	8,000	79,000	41,000	36,000
7,300	8,000	79,000	41,000	36,000
7,400	8,000	79,000	41,000	36,000
7,500	8,000	79,000	41,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,540	8,000	79,000	41,000	36,000
7,600	8,000	79,000	41,000	36,000
7,700	8,000	79,000	41,000	36,000
7,800	8,000	79,000	41,000	36,000
7,900	8,000	79,000	41,000	36,000
7,940	8,000	79,000	41,000	36,000
8,000	8,000	79,000	41,000	36,000
8,100	10,000	89,000	47,000	40,000
8,200	10,000	89,000	47,000	40,000
8,300	10,000	89,000	47,000	40,000
8,330	10,000	89,000	47,000	40,000
8,400	10,000	89,000	47,000	40,000
8,500	10,000	89,000	47,000	40,000
8,600	10,000	89,000	47,000	40,000
8,700	10,000	89,000	47,000	40,000
8,730	10,000	89,000	47,000	40,000
8,800	10,000	89,000	47,000	40,000
8,900	10,000	89,000	47,000	40,000
9,000	10,000	89,000	47,000	40,000
9,100	10,000	89,000	47,000	40,000
9,130	10,000	89,000	47,000	40,000
9,200	10,000	89,000	47,000	40,000
9,250	10,000	89,000	47,000	40,000
9,300	10,000	89,000	47,000	40,000
9,400	10,000	89,000	47,000	40,000
9,500	10,000	89,000	47,000	40,000
9,520	10,000	89,000	47,000	40,000
9,600	10,000	89,000	47,000	40,000
9,700	10,000	89,000	47,000	40,000
9,800	10,000	89,000	47,000	40,000
9,900	10,000	89,000	47,000	40,000
9,920	10,000	89,000	47,000	40,000
10,000	10,000	89,000	47,000	40,000
10,100	12,000	102,000	55,000	45,000
10,200	12,000	102,000	55,000	45,000
10,300	12,000	102,000	55,000	45,000
10,320	12,000	102,000	55,000	45,000
10,400	12,000	102,000	55,000	45,000
10,500	12,000	102,000	55,000	45,000
10,600	12,000	102,000	55,000	45,000
10,700	12,000	102,000	55,000	45,000
10,800	12,000	102,000	55,000	45,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
10,900	12,000	102,000	55,000	45,000
11,000	12,000	102,000	55,000	45,000
11,100	12,000	102,000	55,000	45,000
11,110	12,000	102,000	55,000	45,000
11,200	12,000	102,000	55,000	45,000
11,300	12,000	102,000	55,000	45,000
11,400	12,000	102,000	55,000	45,000
11,500	12,000	102,000	55,000	45,000
11,600	12,000	102,000	55,000	45,000
11,700	12,000	102,000	55,000	45,000
11,800	12,000	102,000	55,000	45,000
11,900	12,000	102,000	55,000	45,000
11,910	12,000	102,000	55,000	45,000
12,000	12,000	102,000	55,000	45,000
12,200	14,000	107,000	60,000	45,000
12,500	14,000	107,000	60,000	45,000
12,700	14,000	107,000	60,000	45,000
13,000	14,000	107,000	60,000	45,000
13,500	14,000	107,000	60,000	45,000
13,700	14,000	107,000	60,000	45,000
14,000	14,000	107,000	60,000	45,000
14,200	16,000	115,000	65,000	48,000
14,290	16,000	115,000	65,000	48,000
14,500	16,000	115,000	65,000	48,000
14,700	16,000	115,000	65,000	48,000
15,000	16,000	115,000	65,000	48,000
15,200	16,000	115,000	65,000	48,000
15,500	16,000	115,000	65,000	48,000
15,700	16,000	115,000	65,000	48,000
16,000	16,000	115,000	65,000	48,000
16,500	18,000	123,000	73,000	48,000
17,000	18,000	123,000	73,000	48,000
17,500	18,000	123,000	73,000	48,000
18,000	18,000	123,000	73,000	48,000
18,500	20,000	131,000	79,000	50,000
19,000	20,000	131,000	79,000	50,000
19,500	20,000	131,000	79,000	50,000
20,000	20,000	131,000	79,000	50,000

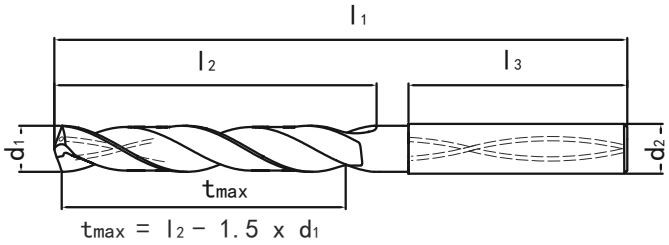
10549
AD10INOX

P	M	K	N	S	H
○	•			○	

VHM | AN | 5xD | 140° | R | HA

芯厚≥ φ3.000 · 双后刀面 · 精密磨削过的主切削刃 · 优化了的切削几何参数

适合加工：不锈钢/耐酸/耐热钢 · 钛以及钛合金 · 镍合金，哈氏合金，锰合金



$t_{max} = l_2 - 1.5 \times d_1$

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	66,000	28,000	36,000
3,100	6,000	66,000	28,000	36,000
3,170	6,000	66,000	28,000	36,000
3,200	6,000	66,000	28,000	36,000
3,250	6,000	66,000	28,000	36,000
3,300	6,000	66,000	28,000	36,000
3,400	6,000	66,000	28,000	36,000
3,500	6,000	66,000	28,000	36,000
3,570	6,000	66,000	28,000	36,000
3,600	6,000	66,000	28,000	36,000
3,700	6,000	66,000	28,000	36,000
3,800	6,000	74,000	36,000	36,000
3,900	6,000	74,000	36,000	36,000
3,970	6,000	74,000	36,000	36,000
4,000	6,000	74,000	36,000	36,000
4,100	6,000	74,000	36,000	36,000
4,200	6,000	74,000	36,000	36,000
4,300	6,000	74,000	36,000	36,000
4,370	6,000	74,000	36,000	36,000
4,400	6,000	74,000	36,000	36,000
4,500	6,000	74,000	36,000	36,000
4,600	6,000	74,000	36,000	36,000
4,650	6,000	74,000	36,000	36,000
4,700	6,000	74,000	36,000	36,000
4,760	6,000	82,000	44,000	36,000
4,800	6,000	82,000	44,000	36,000
4,900	6,000	82,000	44,000	36,000
5,000	6,000	82,000	44,000	36,000
5,100	6,000	82,000	44,000	36,000
5,160	6,000	82,000	44,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
5,200	6,000	82,000	44,000	36,000
5,300	6,000	82,000	44,000	36,000
5,400	6,000	82,000	44,000	36,000
5,500	6,000	82,000	44,000	36,000
5,550	6,000	82,000	44,000	36,000
5,560	6,000	82,000	44,000	36,000
5,600	6,000	82,000	44,000	36,000
5,700	6,000	82,000	44,000	36,000
5,800	6,000	82,000	44,000	36,000
5,900	6,000	82,000	44,000	36,000
5,950	6,000	82,000	44,000	36,000
6,000	6,000	82,000	44,000	36,000
6,100	8,000	91,000	53,000	36,000
6,200	8,000	91,000	53,000	36,000
6,300	8,000	91,000	53,000	36,000
6,350	8,000	91,000	53,000	36,000
6,400	8,000	91,000	53,000	36,000
6,500	8,000	91,000	53,000	36,000
6,600	8,000	91,000	53,000	36,000
6,700	8,000	91,000	53,000	36,000
6,750	8,000	91,000	53,000	36,000
6,800	8,000	91,000	53,000	36,000
6,900	8,000	91,000	53,000	36,000
7,000	8,000	91,000	53,000	36,000
7,100	8,000	91,000	53,000	36,000
7,140	8,000	91,000	53,000	36,000
7,200	8,000	91,000	53,000	36,000
7,300	8,000	91,000	53,000	36,000
7,400	8,000	91,000	53,000	36,000
7,500	8,000	91,000	53,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,540	8,000	91,000	53,000	36,000
7,600	8,000	91,000	53,000	36,000
7,700	8,000	91,000	53,000	36,000
7,800	8,000	91,000	53,000	36,000
7,900	8,000	91,000	53,000	36,000
7,940	8,000	91,000	53,000	36,000
8,000	8,000	91,000	53,000	36,000
8,100	10,000	103,000	61,000	40,000
8,200	10,000	103,000	61,000	40,000
8,300	10,000	103,000	61,000	40,000
8,330	10,000	103,000	61,000	40,000
8,400	10,000	103,000	61,000	40,000
8,500	10,000	103,000	61,000	40,000
8,600	10,000	103,000	61,000	40,000
8,700	10,000	103,000	61,000	40,000
8,730	10,000	103,000	61,000	40,000
8,800	10,000	103,000	61,000	40,000
8,900	10,000	103,000	61,000	40,000
9,000	10,000	103,000	61,000	40,000
9,100	10,000	103,000	61,000	40,000
9,130	10,000	103,000	61,000	40,000
9,200	10,000	103,000	61,000	40,000
9,250	10,000	103,000	61,000	40,000
9,300	10,000	103,000	61,000	40,000
9,400	10,000	103,000	61,000	40,000
9,500	10,000	103,000	61,000	40,000
9,520	10,000	103,000	61,000	40,000
9,600	10,000	103,000	61,000	40,000
9,700	10,000	103,000	61,000	40,000
9,800	10,000	103,000	61,000	40,000
9,900	10,000	103,000	61,000	40,000
9,920	10,000	103,000	61,000	40,000
10,000	10,000	103,000	61,000	40,000
10,100	12,000	118,000	71,000	45,000
10,200	12,000	118,000	71,000	45,000
10,300	12,000	118,000	71,000	45,000
10,320	12,000	118,000	71,000	45,000
10,400	12,000	118,000	71,000	45,000
10,500	12,000	118,000	71,000	45,000
10,600	12,000	118,000	71,000	45,000
10,700	12,000	118,000	71,000	45,000
10,800	12,000	118,000	71,000	45,000

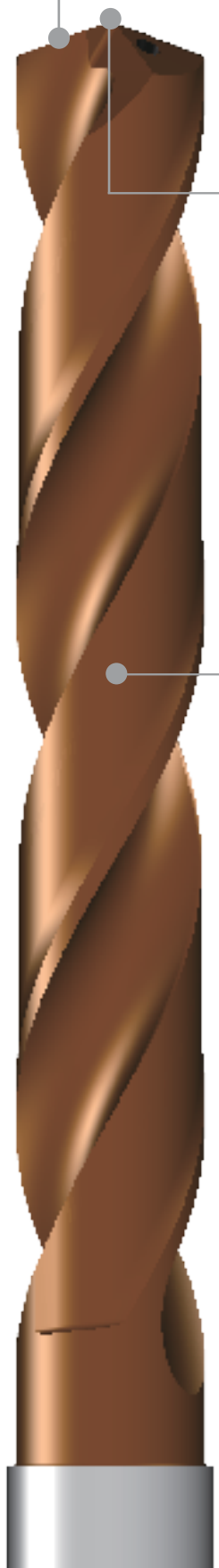
d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
10,900	12,000	118,000	71,000	45,000
11,000	12,000	118,000	71,000	45,000
11,100	12,000	118,000	71,000	45,000
11,110	12,000	118,000	71,000	45,000
11,200	12,000	118,000	71,000	45,000
11,300	12,000	118,000	71,000	45,000
11,400	12,000	118,000	71,000	45,000
11,500	12,000	118,000	71,000	45,000
11,600	12,000	118,000	71,000	45,000
11,700	12,000	118,000	71,000	45,000
11,800	12,000	118,000	71,000	45,000
11,900	12,000	118,000	71,000	45,000
11,910	12,000	118,000	71,000	45,000
12,000	12,000	118,000	71,000	45,000
12,200	14,000	124,000	77,000	45,000
12,500	14,000	124,000	77,000	45,000
12,700	14,000	124,000	77,000	45,000
13,000	14,000	124,000	77,000	45,000
13,500	14,000	124,000	77,000	45,000
13,700	14,000	124,000	77,000	45,000
14,000	14,000	124,000	77,000	45,000
14,200	16,000	133,000	83,000	48,000
14,290	16,000	133,000	83,000	48,000
14,500	16,000	133,000	83,000	48,000
14,700	16,000	133,000	83,000	48,000
15,000	16,000	133,000	83,000	48,000
15,200	16,000	133,000	83,000	48,000
15,500	16,000	133,000	83,000	48,000
15,700	16,000	133,000	83,000	48,000
16,000	16,000	133,000	83,000	48,000
16,500	18,000	143,000	93,000	48,000
17,000	18,000	143,000	93,000	48,000
17,500	18,000	143,000	93,000	48,000
18,000	18,000	143,000	93,000	48,000
18,500	20,000	153,000	101,000	50,000
19,000	20,000	153,000	101,000	50,000
19,500	20,000	153,000	101,000	50,000
20,000	20,000	153,000	101,000	50,000

优势和特性

- 特殊几何形状和弧形钻尖确保在加工GGV（蠕墨铸铁）、ADI（等温淬火球墨铸铁）以及所有传统铸造材料时，实现最高性能和经济效益
- 通过独特协调正面轮廓和槽轮廓，AD10R可极其稳定、且尺寸精确的进行安全的工艺加工
- 适合钻孔深度≤7xD

AD 10 R

灰口铸铁、可锻铸铁和球墨铸铁、GGA/ADI/CDI



特殊的弧形钻尖显著降低磨损

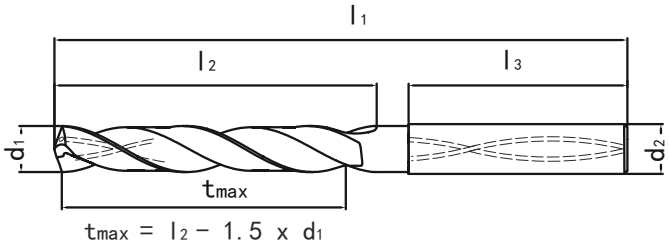
采用特殊尖点打薄的坚固尖端磨削保证准确钻孔和尺寸精确的孔洞

DM涂层在研磨铸造材料中实现最高耐磨强度

10580
AD10R

P	M	K	N	S	H
		•			

VHM | DM | 5xD | R | HA



芯厚≥φ3.000・双后刀面・弧形钻尖・直型切削刃（通过刃修正）

适合加工：蠕墨铸铁GGV和ADI、CDI・灰铸铁，可锻铸铁和球墨铸铁

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	66,000	28,000	36,000
3,100	6,000	66,000	28,000	36,000
3,170	6,000	66,000	28,000	36,000
3,200	6,000	66,000	28,000	36,000
3,250	6,000	66,000	28,000	36,000
3,300	6,000	66,000	28,000	36,000
3,400	6,000	66,000	28,000	36,000
3,500	6,000	66,000	28,000	36,000
3,570	6,000	66,000	28,000	36,000
3,600	6,000	66,000	28,000	36,000
3,700	6,000	66,000	28,000	36,000
3,800	6,000	74,000	36,000	36,000
3,900	6,000	74,000	36,000	36,000
3,970	6,000	74,000	36,000	36,000
4,000	6,000	74,000	36,000	36,000
4,100	6,000	74,000	36,000	36,000
4,200	6,000	74,000	36,000	36,000
4,300	6,000	74,000	36,000	36,000
4,370	6,000	74,000	36,000	36,000
4,400	6,000	74,000	36,000	36,000
4,500	6,000	74,000	36,000	36,000
4,600	6,000	74,000	36,000	36,000
4,650	6,000	74,000	36,000	36,000
4,700	6,000	74,000	36,000	36,000
4,760	6,000	82,000	44,000	36,000
4,800	6,000	82,000	44,000	36,000
4,900	6,000	82,000	44,000	36,000
5,000	6,000	82,000	44,000	36,000
5,100	6,000	82,000	44,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
5,160	6,000	82,000	44,000	36,000
5,200	6,000	82,000	44,000	36,000
5,300	6,000	82,000	44,000	36,000
5,400	6,000	82,000	44,000	36,000
5,500	6,000	82,000	44,000	36,000
5,550	6,000	82,000	44,000	36,000
5,560	6,000	82,000	44,000	36,000
5,600	6,000	82,000	44,000	36,000
5,700	6,000	82,000	44,000	36,000
5,800	6,000	82,000	44,000	36,000
5,900	6,000	82,000	44,000	36,000
5,950	6,000	82,000	44,000	36,000
6,000	6,000	82,000	44,000	36,000
6,100	8,000	91,000	53,000	36,000
6,200	8,000	91,000	53,000	36,000
6,300	8,000	91,000	53,000	36,000
6,350	8,000	91,000	53,000	36,000
6,400	8,000	91,000	53,000	36,000
6,500	8,000	91,000	53,000	36,000
6,600	8,000	91,000	53,000	36,000
6,700	8,000	91,000	53,000	36,000
6,750	8,000	91,000	53,000	36,000
6,800	8,000	91,000	53,000	36,000
6,900	8,000	91,000	53,000	36,000
7,000	8,000	91,000	53,000	36,000
7,100	8,000	91,000	53,000	36,000
7,140	8,000	91,000	53,000	36,000
7,200	8,000	91,000	53,000	36,000
7,300	8,000	91,000	53,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,400	8,000	91,000	53,000	36,000
7,500	8,000	91,000	53,000	36,000
7,540	8,000	91,000	53,000	36,000
7,600	8,000	91,000	53,000	36,000
7,700	8,000	91,000	53,000	36,000
7,800	8,000	91,000	53,000	36,000
7,900	8,000	91,000	53,000	36,000
7,940	8,000	91,000	53,000	36,000
8,000	8,000	91,000	53,000	36,000
8,100	10,000	103,000	61,000	40,000
8,200	10,000	103,000	61,000	40,000
8,300	10,000	103,000	61,000	40,000
8,330	10,000	103,000	61,000	40,000
8,400	10,000	103,000	61,000	40,000
8,500	10,000	103,000	61,000	40,000
8,600	10,000	103,000	61,000	40,000
8,700	10,000	103,000	61,000	40,000
8,730	10,000	103,000	61,000	40,000
8,800	10,000	103,000	61,000	40,000
8,900	10,000	103,000	61,000	40,000
9,000	10,000	103,000	61,000	40,000
9,100	10,000	103,000	61,000	40,000
9,130	10,000	103,000	61,000	40,000
9,200	10,000	103,000	61,000	40,000
9,250	10,000	103,000	61,000	40,000
9,300	10,000	103,000	61,000	40,000
9,400	10,000	103,000	61,000	40,000
9,500	10,000	103,000	61,000	40,000
9,520	10,000	103,000	61,000	40,000
9,600	10,000	103,000	61,000	40,000
9,700	10,000	103,000	61,000	40,000
9,800	10,000	103,000	61,000	40,000
9,900	10,000	103,000	61,000	40,000
9,920	10,000	103,000	61,000	40,000
10,000	10,000	103,000	61,000	40,000
10,100	12,000	118,000	71,000	45,000
10,200	12,000	118,000	71,000	45,000
10,300	12,000	118,000	71,000	45,000
10,320	12,000	118,000	71,000	45,000
10,400	12,000	118,000	71,000	45,000
10,500	12,000	118,000	71,000	45,000
10,600	12,000	118,000	71,000	45,000
10,700	12,000	118,000	71,000	45,000
10,720	12,000	118,000	71,000	45,000
10,800	12,000	118,000	71,000	45,000
10,900	12,000	118,000	71,000	45,000
11,000	12,000	118,000	71,000	45,000
11,100	12,000	118,000	71,000	45,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
11,110	12,000	118,000	71,000	45,000
11,200	12,000	118,000	71,000	45,000
11,300	12,000	118,000	71,000	45,000
11,400	12,000	118,000	71,000	45,000
11,500	12,000	118,000	71,000	45,000
11,600	12,000	118,000	71,000	45,000
11,700	12,000	118,000	71,000	45,000
11,800	12,000	118,000	71,000	45,000
11,900	12,000	118,000	71,000	45,000
11,910	12,000	118,000	71,000	45,000
12,000	12,000	118,000	71,000	45,000
12,100	14,000	124,000	77,000	45,000
12,200	14,000	124,000	77,000	45,000
12,300	14,000	124,000	77,000	45,000
12,400	14,000	124,000	77,000	45,000
12,500	14,000	124,000	77,000	45,000
12,600	14,000	124,000	77,000	45,000
12,700	14,000	124,000	77,000	45,000
12,800	14,000	124,000	77,000	45,000
12,900	14,000	124,000	77,000	45,000
13,000	14,000	124,000	77,000	45,000
13,100	14,000	124,000	77,000	45,000
13,300	14,000	124,000	77,000	45,000
13,400	14,000	124,000	77,000	45,000
13,500	14,000	124,000	77,000	45,000
13,700	14,000	124,000	77,000	45,000
13,800	14,000	124,000	77,000	45,000
13,900	14,000	124,000	77,000	45,000
14,000	14,000	124,000	77,000	45,000
14,100	16,000	133,000	83,000	48,000
14,200	16,000	133,000	83,000	48,000
14,290	16,000	133,000	83,000	48,000
14,300	16,000	133,000	83,000	48,000
14,400	16,000	133,000	83,000	48,000
14,500	16,000	133,000	83,000	48,000
14,600	16,000	133,000	83,000	48,000
14,700	16,000	133,000	83,000	48,000
14,900	16,000	133,000	83,000	48,000
15,000	16,000	133,000	83,000	48,000
15,100	16,000	133,000	83,000	48,000
15,200	16,000	133,000	83,000	48,000
15,300	16,000	133,000	83,000	48,000
15,400	16,000	133,000	83,000	48,000
15,500	16,000	133,000	83,000	48,000
15,600	16,000	133,000	83,000	48,000
15,700	16,000	133,000	83,000	48,000
15,800	16,000	133,000	83,000	48,000
15,870	16,000	133,000	83,000	48,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
15,900	16,000	133,000	83,000	48,000
16,000	16,000	133,000	83,000	48,000
16,500	18,000	143,000	93,000	48,000
16,670	18,000	143,000	93,000	48,000
17,000	18,000	143,000	93,000	48,000
17,500	18,000	143,000	93,000	48,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
18,000	18,000	143,000	93,000	48,000
18,500	20,000	153,000	101,000	50,000
19,000	20,000	153,000	101,000	50,000
19,500	20,000	153,000	101,000	50,000
20,000	20,000	153,000	101,000	50,000

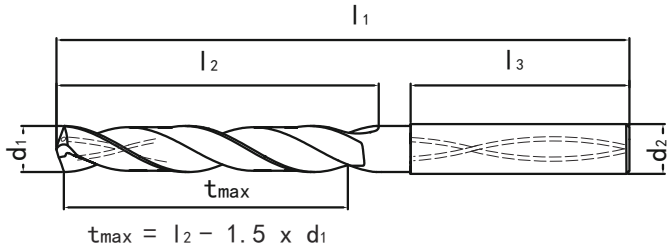
10579
AD10R

P	M	K	N	S	H
		•			

VHM | DM | 7xD | R | HA

芯厚≥ φ3.000 · 双后刀面 · 弧形钻尖 · 直型切削刃（通过刃修正）

适合加工：蠕墨铸铁GGV和ADI、CDI · 灰铸铁，可锻铸铁和球墨铸铁



$t_{max} = l_2 - 1.5 \times d_1$

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
4,000	6,000	75,000	37,500	36,000
4,100	6,000	75,000	37,500	36,000
4,200	6,000	75,000	37,500	36,000
4,300	6,000	85,000	45,000	36,000
4,370	6,000	85,000	45,000	36,000
4,400	6,000	85,000	45,000	36,000
4,500	6,000	85,000	45,000	36,000
4,600	6,000	85,000	45,000	36,000
4,650	6,000	85,000	45,000	36,000
4,700	6,000	85,000	45,000	36,000
4,760	6,000	90,000	50,000	36,000
4,800	6,000	90,000	50,000	36,000
4,900	6,000	90,000	50,000	36,000
5,000	6,000	90,000	50,000	36,000
5,100	6,000	90,000	50,000	36,000
5,160	6,000	90,000	50,000	36,000
5,200	6,000	90,000	50,000	36,000
5,300	6,000	90,000	50,000	36,000
5,400	6,000	97,000	57,000	36,000
5,500	6,000	97,000	57,000	36,000
5,550	6,000	97,000	57,000	36,000
5,560	6,000	97,000	57,000	36,000
5,600	6,000	97,000	57,000	36,000
5,700	6,000	97,000	57,000	36,000
5,800	6,000	97,000	57,000	36,000
5,900	6,000	97,000	57,000	36,000
5,950	6,000	97,000	57,000	36,000
6,000	6,000	97,000	57,000	36,000
6,100	8,000	106,000	66,000	36,000
6,200	8,000	106,000	66,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
6,300	8,000	106,000	66,000	36,000
6,350	8,000	106,000	66,000	36,000
6,400	8,000	106,000	66,000	36,000
6,500	8,000	106,000	66,000	36,000
6,600	8,000	106,000	66,000	36,000
6,700	8,000	106,000	66,000	36,000
6,750	8,000	106,000	66,000	36,000
6,800	8,000	106,000	66,000	36,000
6,900	8,000	116,000	76,000	36,000
7,000	8,000	116,000	76,000	36,000
7,100	8,000	116,000	76,000	36,000
7,140	8,000	116,000	76,000	36,000
7,200	8,000	116,000	76,000	36,000
7,300	8,000	116,000	76,000	36,000
7,400	8,000	116,000	76,000	36,000
7,500	8,000	116,000	76,000	36,000
7,540	8,000	116,000	76,000	36,000
7,600	8,000	116,000	76,000	36,000
7,700	8,000	116,000	76,000	36,000
7,800	8,000	116,000	76,000	36,000
7,900	8,000	116,000	76,000	36,000
7,940	8,000	116,000	76,000	36,000
8,000	8,000	116,000	76,000	36,000
8,100	10,000	131,000	87,000	40,000
8,200	10,000	131,000	87,000	40,000
8,300	10,000	131,000	87,000	40,000
8,330	10,000	131,000	87,000	40,000
8,400	10,000	131,000	87,000	40,000
8,500	10,000	131,000	87,000	40,000
8,600	10,000	131,000	87,000	40,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
8,700	10,000	131,000	87,000	40,000
8,730	10,000	131,000	87,000	40,000
8,800	10,000	131,000	87,000	40,000
8,900	10,000	131,000	87,000	40,000
9,000	10,000	131,000	87,000	40,000
9,100	10,000	139,000	95,000	40,000
9,130	10,000	139,000	95,000	40,000
9,200	10,000	139,000	95,000	40,000
9,250	10,000	139,000	95,000	40,000
9,300	10,000	139,000	95,000	40,000
9,400	10,000	139,000	95,000	40,000
9,500	10,000	139,000	95,000	40,000
9,520	10,000	139,000	95,000	40,000
9,600	10,000	139,000	95,000	40,000
9,700	10,000	139,000	95,000	40,000
9,800	10,000	139,000	95,000	40,000
9,900	10,000	139,000	95,000	40,000
9,920	10,000	139,000	95,000	40,000
10,000	10,000	139,000	95,000	40,000
10,100	12,000	155,000	106,000	45,000
10,200	12,000	155,000	106,000	45,000
10,300	12,000	155,000	106,000	45,000
10,320	12,000	155,000	106,000	45,000
10,400	12,000	155,000	106,000	45,000
10,500	12,000	155,000	106,000	45,000
10,600	12,000	155,000	106,000	45,000
10,700	12,000	155,000	106,000	45,000
10,720	12,000	155,000	106,000	45,000
10,800	12,000	155,000	106,000	45,000
10,900	12,000	155,000	106,000	45,000
11,000	12,000	155,000	106,000	45,000
11,100	12,000	163,000	114,000	45,000
11,110	12,000	163,000	114,000	45,000
11,200	12,000	163,000	114,000	45,000
11,300	12,000	163,000	114,000	45,000
11,400	12,000	163,000	114,000	45,000
11,500	12,000	163,000	114,000	45,000
11,600	12,000	163,000	114,000	45,000
11,700	12,000	163,000	114,000	45,000
11,800	12,000	163,000	114,000	45,000
11,900	12,000	163,000	114,000	45,000
11,910	12,000	163,000	114,000	45,000
12,000	12,000	163,000	114,000	45,000
12,100	14,000	182,000	133,000	45,000
12,200	14,000	182,000	133,000	45,000
12,300	14,000	182,000	133,000	45,000
12,400	14,000	182,000	133,000	45,000
12,500	14,000	182,000	133,000	45,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
12,600	14,000	182,000	133,000	45,000
12,700	14,000	182,000	133,000	45,000
12,800	14,000	182,000	133,000	45,000
12,900	14,000	182,000	133,000	45,000
13,000	14,000	182,000	133,000	45,000
13,100	14,000	182,000	133,000	45,000
13,300	14,000	182,000	133,000	45,000
13,400	14,000	182,000	133,000	45,000
13,500	14,000	182,000	133,000	45,000
13,700	14,000	182,000	133,000	45,000
13,800	14,000	182,000	133,000	45,000
13,900	14,000	182,000	133,000	45,000
14,000	14,000	182,000	133,000	45,000
14,100	16,000	204,000	152,000	48,000
14,200	16,000	204,000	152,000	48,000
14,290	16,000	204,000	152,000	48,000
14,300	16,000	204,000	152,000	48,000
14,400	16,000	204,000	152,000	48,000
14,500	16,000	204,000	152,000	48,000
14,600	16,000	204,000	152,000	48,000
14,700	16,000	204,000	152,000	48,000
14,900	16,000	204,000	152,000	48,000
15,000	16,000	204,000	152,000	48,000
15,100	16,000	204,000	152,000	48,000
15,200	16,000	204,000	152,000	48,000
15,300	16,000	204,000	152,000	48,000
15,400	16,000	204,000	152,000	48,000
15,500	16,000	204,000	152,000	48,000
15,600	16,000	204,000	152,000	48,000
15,700	16,000	204,000	152,000	48,000
15,800	16,000	204,000	152,000	48,000
15,870	16,000	204,000	152,000	48,000
15,900	16,000	204,000	152,000	48,000
16,000	16,000	204,000	152,000	48,000
16,500	18,000	223,000	171,000	48,000
16,670	18,000	223,000	171,000	48,000
17,000	18,000	223,000	171,000	48,000
17,500	18,000	223,000	171,000	48,000
18,000	18,000	223,000	171,000	48,000
18,500	20,000	244,000	190,000	50,000
19,000	20,000	244,000	190,000	50,000
19,500	20,000	244,000	190,000	50,000
20,000	20,000	244,000	190,000	50,000

优势和特性

- 高性能硬质合金钻头用于加工短切屑材料，例如铸铁、灰口铸铁、可锻铸铁和球墨铸铁
- 用于同心度、直线度高的孔加工
- 根据要求也可以提供涂层

AD 15 G

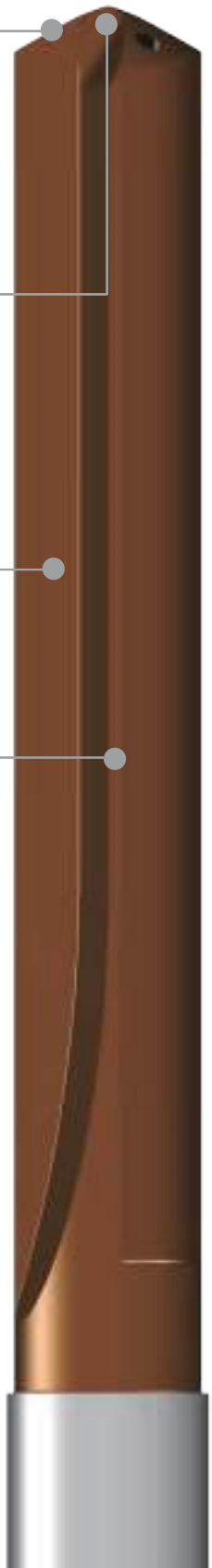
灰口铸铁、可锻铸铁和球墨铸铁

特殊调整的刀刃几何形状几乎可实现经济加工所有铸造材料

特殊芯厚减薄处理实现高精度的孔径及直线度

抛光规格确保最佳排屑

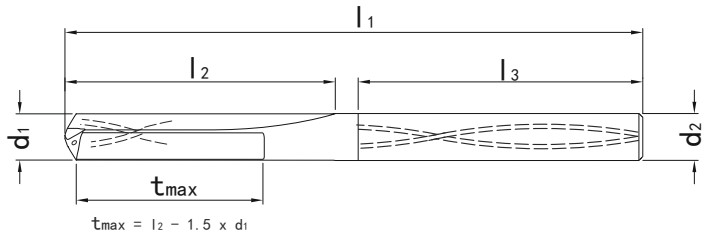
四个导向倒角确保孔洞平直度和圆度



10708
AD15G

P	M	K	N	S	H
		•	○		

VHM | DM | 4xD | 120° | R | HA



芯厚≥ϕ3.000・双后刀面・紧直径公差・很好的孔表面质量・注意冷却压力

适合加工：铝和铝合金・铝材料含硅量

AD10R/AD15G

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	66,000	24,000	36,000
3,100	6,000	66,000	24,000	36,000
3,200	6,000	66,000	24,000	36,000
3,300	6,000	66,000	24,000	36,000
3,400	6,000	66,000	24,000	36,000
3,500	6,000	66,000	24,000	36,000
3,600	6,000	66,000	24,000	36,000
3,700	6,000	66,000	24,000	36,000
3,800	6,000	74,000	30,000	36,000
3,900	6,000	74,000	30,000	36,000
4,000	6,000	74,000	30,000	36,000
4,200	6,000	74,000	30,000	36,000
5,000	6,000	74,000	36,000	36,000
5,100	6,000	74,000	36,000	36,000
5,300	6,000	74,000	36,000	36,000
5,400	6,000	74,000	36,000	36,000
5,900	6,000	74,000	36,000	36,000
6,000	6,000	74,000	36,000	36,000
6,200	8,000	91,000	53,000	36,000
6,300	8,000	91,000	53,000	36,000
6,400	8,000	91,000	53,000	36,000
6,600	8,000	91,000	53,000	36,000
6,700	8,000	91,000	53,000	36,000
6,800	8,000	91,000	53,000	36,000
7,000	8,000	91,000	53,000	36,000
7,400	8,000	91,000	53,000	36,000
7,500	8,000	91,000	53,000	36,000
8,000	8,000	91,000	53,000	36,000
8,100	10,000	103,000	61,000	40,000
8,200	10,000	103,000	61,000	40,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
8,300	10,000	103,000	61,000	40,000
8,400	10,000	103,000	61,000	40,000
8,500	10,000	103,000	61,000	40,000
8,700	10,000	103,000	61,000	40,000
9,000	10,000	103,000	61,000	40,000
9,400	10,000	103,000	61,000	40,000
10,000	10,000	103,000	61,000	40,000
10,200	12,000	118,000	71,000	45,000
10,500	12,000	118,000	71,000	45,000
11,000	12,000	118,000	71,000	45,000
11,500	12,000	118,000	71,000	45,000
12,000	12,000	118,000	71,000	45,000
12,300	14,000	124,000	74,000	45,000
12,500	14,000	124,000	74,000	45,000
12,700	14,000	124,000	74,000	45,000
13,000	14,000	124,000	74,000	45,000
14,000	14,000	124,000	74,000	45,000
15,000	16,000	133,000	83,000	48,000
16,000	16,000	133,000	83,000	48,000
16,500	18,000	143,000	93,000	48,000
17,000	18,000	143,000	93,000	48,000
17,500	18,000	143,000	93,000	48,000
18,000	18,000	143,000	93,000	48,000
19,000	20,000	153,000	101,000	50,000
20,000	20,000	153,000	101,000	50,000

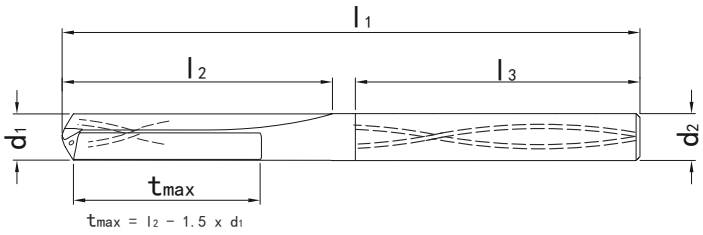
10706
AD15G

P	M	K	N	S	H
		•	○		

VHM | DM | 7xD | 120° | R | HA

芯厚≥ φ3.000 · 圆弧后刀面 · 紧直径公差 · 很好的孔表面质量 · 注意冷却压力

适合加工：铝和铝合金 · 铝材料含硅量



d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	74,000	32,000	36,000
3,100	6,000	74,000	32,000	36,000
3,200	6,000	74,000	32,000	36,000
3,300	6,000	74,000	32,000	36,000
3,400	6,000	74,000	34,000	36,000
3,500	6,000	74,000	34,000	36,000
3,600	6,000	74,000	34,000	36,000
3,700	6,000	74,000	34,000	36,000
3,800	6,000	97,000	45,000	36,000
3,900	6,000	97,000	45,000	36,000
4,000	6,000	97,000	45,000	36,000
4,100	6,000	97,000	45,000	36,000
4,200	6,000	97,000	45,000	36,000
4,300	6,000	97,000	45,000	36,000
4,400	6,000	97,000	45,000	36,000
4,500	6,000	97,000	45,000	36,000
4,700	6,000	97,000	45,000	36,000
4,800	6,000	97,000	57,000	36,000
4,900	6,000	97,000	57,000	36,000
5,000	6,000	97,000	57,000	36,000
5,500	6,000	97,000	57,000	36,000
6,000	6,000	97,000	57,000	36,000
6,500	8,000	116,000	76,000	36,000
6,800	8,000	116,000	76,000	36,000
7,000	8,000	116,000	76,000	36,000
7,500	8,000	116,000	76,000	36,000
7,800	8,000	116,000	76,000	36,000
8,000	8,000	116,000	76,000	36,000
8,500	10,000	139,000	95,000	40,000
9,000	10,000	139,000	95,000	40,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
9,500	10,000	139,000	95,000	40,000
10,000	10,000	139,000	95,000	40,000
10,200	12,000	163,000	114,000	45,000
10,500	12,000	163,000	114,000	45,000
11,000	12,000	163,000	114,000	45,000
11,500	12,000	163,000	114,000	45,000
12,000	12,000	163,000	114,000	45,000
12,300	14,000	182,000	133,000	45,000
12,500	14,000	182,000	133,000	45,000
12,700	14,000	182,000	133,000	45,000
13,000	14,000	182,000	133,000	45,000
13,500	14,000	182,000	133,000	45,000
14,000	14,000	182,000	133,000	45,000
14,500	16,000	204,000	152,000	48,000
15,000	16,000	204,000	152,000	48,000
15,500	16,000	204,000	152,000	48,000
16,000	16,000	204,000	152,000	48,000
16,500	18,000	223,000	171,000	48,000
17,000	18,000	223,000	171,000	48,000
17,500	18,000	223,000	171,000	48,000
18,000	18,000	223,000	171,000	48,000
18,500	20,000	244,000	190,000	50,000
19,000	20,000	244,000	190,000	50,000
19,500	20,000	244,000	190,000	50,000
20,000	20,000	244,000	190,000	50,000

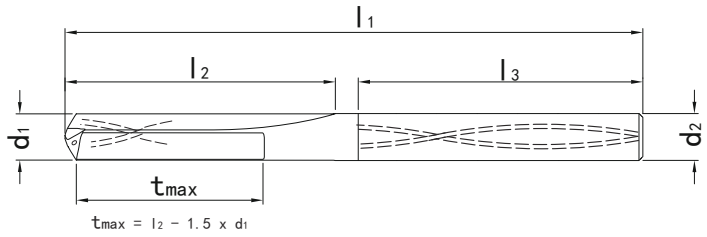
10707
AD15G

P	M	K	N	S	H
		•	○		

VHM | DM | 10xD | 120° | R | HA

芯厚≥ φ3.000 · 圆弧后刀面 · 紧直径公差 · 很好的孔表面质量 · 注意冷却压力

适合加工：铝和铝合金 · 铝材料含硅量



d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	91,000	42,000	36,000
3,100	6,000	91,000	42,000	36,000
3,170	6,000	91,000	42,000	36,000
3,200	6,000	91,000	42,000	36,000
3,250	6,000	91,000	42,000	36,000
3,300	6,000	91,000	42,000	36,000
3,500	6,000	91,000	48,000	36,000
3,570	6,000	91,000	48,000	36,000
3,600	6,000	91,000	48,000	36,000
3,700	6,000	91,000	48,000	36,000
3,800	6,000	121,000	77,000	36,000
3,900	6,000	121,000	77,000	36,000
3,970	6,000	121,000	77,000	36,000
4,000	6,000	121,000	77,000	36,000
4,200	6,000	121,000	77,000	36,000
4,400	6,000	121,000	77,000	36,000
4,500	6,000	121,000	77,000	36,000
5,000	6,000	121,000	82,000	36,000
5,500	6,000	121,000	82,000	36,000
6,000	6,000	121,000	82,000	36,000
6,350	8,000	146,000	106,000	36,000
6,500	8,000	146,000	106,000	36,000
6,800	8,000	146,000	106,000	36,000
7,000	8,000	146,000	106,000	36,000
7,140	8,000	146,000	106,000	36,000
7,500	8,000	146,000	106,000	36,000
7,800	8,000	146,000	106,000	36,000
8,000	8,000	146,000	106,000	36,000
8,500	10,000	175,000	130,000	40,000
8,730	10,000	175,000	130,000	40,000

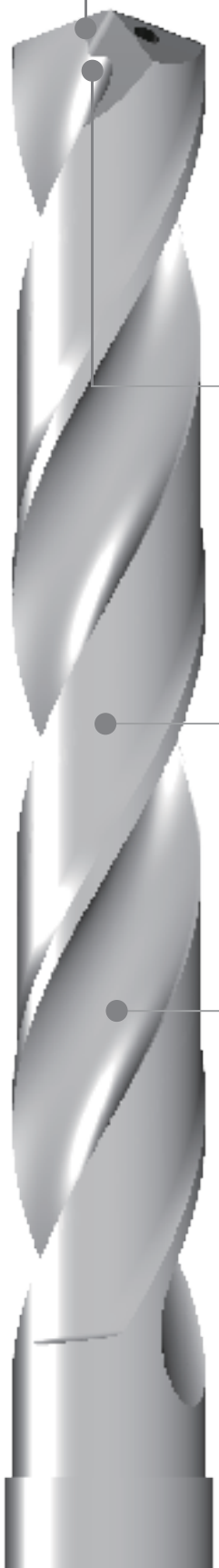
d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
9,000	10,000	175,000	130,000	40,000
9,500	10,000	175,000	130,000	40,000
9,520	10,000	175,000	130,000	40,000
10,000	10,000	175,000	130,000	40,000
10,200	12,000	209,000	159,000	45,000
10,500	12,000	209,000	159,000	45,000
10,720	12,000	209,000	159,000	45,000
11,000	12,000	209,000	159,000	45,000
11,500	12,000	209,000	159,000	45,000
12,000	12,000	209,000	159,000	45,000
12,500	14,000	233,000	183,000	45,000
12,700	14,000	233,000	183,000	45,000
13,000	14,000	233,000	183,000	45,000
13,500	14,000	233,000	183,000	45,000
14,000	14,000	233,000	183,000	45,000
14,500	16,000	260,000	207,000	48,000
15,000	16,000	260,000	207,000	48,000
15,500	16,000	260,000	207,000	48,000
16,000	16,000	260,000	207,000	48,000
17,500	18,000	284,000	231,000	48,000
18,000	18,000	284,000	231,000	48,000
20,000	20,000	308,000	255,000	50,000

AD 10 ALU

优势和特性

- 可靠的排屑和完美切削性能，特别是针对铝合金、铜合金、黄铜合金和青铜合金以及塑料
- 在整个材料范围内均可最佳形成切屑--包括软质硬质有色金属合金到脆性铸铝或黄铜合金
- 低工艺温度防止在加工有色金属合金时产生切屑瘤

铝合金、铜合金、黄铜合金和青铜合金、塑料



经过微处理的锋利刀刃缘，即使在加工热处理AlSi合金中也具有完美的切削性能

开放式尖端几何形状和凹形刀刃缘形状实现最佳切屑形成性能

尖端面、切屑面和间隙面区域的高表面质量可显著降低工艺温度

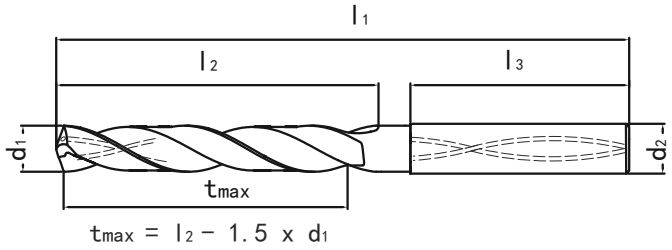
抛光处理，有利于排屑

特殊的硬质合金款式实现有色金属加工

10440
AD10ALU

P	M	K	N	S	H
			•		

VHM | 5xD | 140° | R | HA



$t_{max} = l_2 - 1.5 \times d_1$

圆弧后刀面・主切削刃轻微内凹・优化了的切削几何参数・锋利的切削性能

适合加工：铝和铝合金・铝材料含硅量

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	66,000	28,000	36,000
3,100	6,000	66,000	28,000	36,000
3,170	6,000	66,000	28,000	36,000
3,200	6,000	66,000	28,000	36,000
3,250	6,000	66,000	28,000	36,000
3,300	6,000	66,000	28,000	36,000
3,400	6,000	66,000	28,000	36,000
3,500	6,000	66,000	28,000	36,000
3,570	6,000	66,000	28,000	36,000
3,600	6,000	66,000	28,000	36,000
3,700	6,000	66,000	28,000	36,000
3,800	6,000	74,000	36,000	36,000
3,900	6,000	74,000	36,000	36,000
3,970	6,000	74,000	36,000	36,000
4,000	6,000	74,000	36,000	36,000
4,100	6,000	74,000	36,000	36,000
4,200	6,000	74,000	36,000	36,000
4,300	6,000	74,000	36,000	36,000
4,370	6,000	74,000	36,000	36,000
4,400	6,000	74,000	36,000	36,000
4,500	6,000	74,000	36,000	36,000
4,600	6,000	74,000	36,000	36,000
4,650	6,000	74,000	36,000	36,000
4,700	6,000	74,000	36,000	36,000
4,760	6,000	82,000	44,000	36,000
4,800	6,000	82,000	44,000	36,000
4,900	6,000	82,000	44,000	36,000
5,000	6,000	82,000	44,000	36,000
5,100	6,000	82,000	44,000	36,000
5,160	6,000	82,000	44,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
5,200	6,000	82,000	44,000	36,000
5,300	6,000	82,000	44,000	36,000
5,400	6,000	82,000	44,000	36,000
5,500	6,000	82,000	44,000	36,000
5,550	6,000	82,000	44,000	36,000
5,560	6,000	82,000	44,000	36,000
5,600	6,000	82,000	44,000	36,000
5,700	6,000	82,000	44,000	36,000
5,800	6,000	82,000	44,000	36,000
5,900	6,000	82,000	44,000	36,000
5,950	6,000	82,000	44,000	36,000
6,000	6,000	82,000	44,000	36,000
6,100	8,000	91,000	53,000	36,000
6,200	8,000	91,000	53,000	36,000
6,300	8,000	91,000	53,000	36,000
6,350	8,000	91,000	53,000	36,000
6,400	8,000	91,000	53,000	36,000
6,500	8,000	91,000	53,000	36,000
6,600	8,000	91,000	53,000	36,000
6,700	8,000	91,000	53,000	36,000
6,750	8,000	91,000	53,000	36,000
6,800	8,000	91,000	53,000	36,000
6,900	8,000	91,000	53,000	36,000
7,000	8,000	91,000	53,000	36,000
7,100	8,000	91,000	53,000	36,000
7,140	8,000	91,000	53,000	36,000
7,200	8,000	91,000	53,000	36,000
7,300	8,000	91,000	53,000	36,000
7,400	8,000	91,000	53,000	36,000
7,500	8,000	91,000	53,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,540	8,000	91,000	53,000	36,000
7,600	8,000	91,000	53,000	36,000
7,700	8,000	91,000	53,000	36,000
7,800	8,000	91,000	53,000	36,000
7,900	8,000	91,000	53,000	36,000
7,940	8,000	91,000	53,000	36,000
8,000	8,000	91,000	53,000	36,000
8,100	10,000	103,000	61,000	40,000
8,200	10,000	103,000	61,000	40,000
8,300	10,000	103,000	61,000	40,000
8,330	10,000	103,000	61,000	40,000
8,400	10,000	103,000	61,000	40,000
8,500	10,000	103,000	61,000	40,000
8,600	10,000	103,000	61,000	40,000
8,700	10,000	103,000	61,000	40,000
8,730	10,000	103,000	61,000	40,000
8,800	10,000	103,000	61,000	40,000
8,900	10,000	103,000	61,000	40,000
9,000	10,000	103,000	61,000	40,000
9,100	10,000	103,000	61,000	40,000
9,130	10,000	103,000	61,000	40,000
9,200	10,000	103,000	61,000	40,000
9,250	10,000	103,000	61,000	40,000
9,300	10,000	103,000	61,000	40,000
9,340	10,000	103,000	61,000	40,000
9,400	10,000	103,000	61,000	40,000
9,500	10,000	103,000	61,000	40,000
9,520	10,000	103,000	61,000	40,000
9,600	10,000	103,000	61,000	40,000
9,700	10,000	103,000	61,000	40,000
9,800	10,000	103,000	61,000	40,000
9,900	10,000	103,000	61,000	40,000
9,920	10,000	103,000	61,000	40,000
10,000	10,000	103,000	61,000	40,000
10,100	12,000	118,000	71,000	45,000
10,200	12,000	118,000	71,000	45,000
10,300	12,000	118,000	71,000	45,000
10,320	12,000	118,000	71,000	45,000
10,400	12,000	118,000	71,000	45,000
10,500	12,000	118,000	71,000	45,000
10,600	12,000	118,000	71,000	45,000
10,700	12,000	118,000	71,000	45,000
10,800	12,000	118,000	71,000	45,000
10,900	12,000	118,000	71,000	45,000
11,000	12,000	118,000	71,000	45,000
11,100	12,000	118,000	71,000	45,000
11,110	12,000	118,000	71,000	45,000
11,200	12,000	118,000	71,000	45,000
11,300	12,000	118,000	71,000	45,000
11,400	12,000	118,000	71,000	45,000
11,500	12,000	118,000	71,000	45,000
11,600	12,000	118,000	71,000	45,000
11,700	12,000	118,000	71,000	45,000
11,800	12,000	118,000	71,000	45,000
11,900	12,000	118,000	71,000	45,000
11,910	12,000	118,000	71,000	45,000
12,000	12,000	118,000	71,000	45,000
12,100	14,000	124,000	77,000	45,000
12,200	14,000	124,000	77,000	45,000
12,500	14,000	124,000	77,000	45,000
12,600	14,000	124,000	77,000	45,000
12,700	14,000	124,000	77,000	45,000
12,800	14,000	124,000	77,000	45,000
12,900	14,000	124,000	77,000	45,000
13,000	14,000	124,000	77,000	45,000
13,100	14,000	124,000	77,000	45,000
13,300	14,000	124,000	77,000	45,000
13,400	14,000	124,000	77,000	45,000
13,500	14,000	124,000	77,000	45,000
13,700	14,000	124,000	77,000	45,000
13,800	14,000	124,000	77,000	45,000
14,000	14,000	124,000	77,000	45,000
14,100	16,000	133,000	83,000	48,000
14,200	16,000	133,000	83,000	48,000
14,290	16,000	133,000	83,000	48,000
14,300	16,000	133,000	83,000	48,000
14,400	16,000	133,000	83,000	48,000
14,500	16,000	133,000	83,000	48,000
14,700	16,000	133,000	83,000	48,000
14,800	16,000	133,000	83,000	48,000
15,000	16,000	133,000	83,000	48,000
15,100	16,000	133,000	83,000	48,000
15,200	16,000	133,000	83,000	48,000
15,300	16,000	133,000	83,000	48,000
15,500	16,000	133,000	83,000	48,000
15,700	16,000	133,000	83,000	48,000
15,800	16,000	133,000	83,000	48,000
16,000	16,000	133,000	83,000	48,000
16,500	18,000	143,000	93,000	48,000
16,700	18,000	143,000	93,000	48,000
16,900	18,000	143,000	93,000	48,000
17,000	18,000	143,000	93,000	48,000
17,500	18,000	143,000	93,000	48,000
17,700	18,000	143,000	93,000	48,000
18,000	18,000	143,000	93,000	48,000
18,500	20,000	153,000	101,000	50,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
18,900	20,000	153,000	101,000	50,000
19,000	20,000	153,000	101,000	50,000
19,050	20,000	153,000	101,000	50,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
19,300	20,000	153,000	101,000	50,000
19,500	20,000	153,000	101,000	50,000
20,000	20,000	153,000	101,000	50,000

AD 15 G

优势和特性

- 高性能硬质合金钻头用于加工短切屑材料例如硅含量高的铝合金
- 用于同心度、直线度高的孔加工
- 钻孔具备高单位时间金属切削率
- 根据要求也可提供涂层

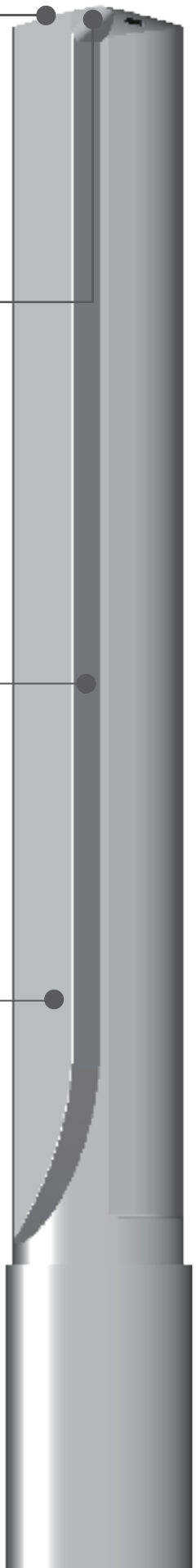
铝合金、铜合金、黄铜合金和青铜合金、塑料

特殊芯厚减薄处理实现高精度的孔径及直线度

特殊调整的刀刃几何形状实现经济加工几乎所有铝合金和铝铸造合金

四个导向倒角确保孔洞平直度和圆度

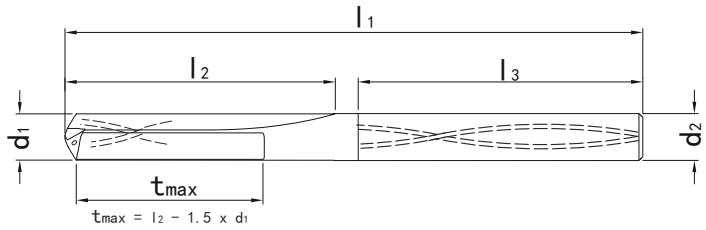
抛光处理，有利于排屑



10705
AD15G

P	M	K	N	S	H
		○	•		

VHM | 10xD | 130° | R | HA



芯厚≥ϕ3.000・双后刀面・紧直径公差・很好的孔表面质量・注意最佳冷却压力

适合加工：灰铸铁，可锻铸铁和球墨铸铁

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	91,000	42,000	36,000
3,100	6,000	91,000	42,000	36,000
3,300	6,000	91,000	42,000	36,000
3,500	6,000	91,000	48,000	36,000
3,600	6,000	91,000	48,000	36,000
3,800	6,000	121,000	77,000	36,000
4,000	6,000	121,000	77,000	36,000
4,400	6,000	121,000	77,000	36,000
4,700	6,000	121,000	77,000	36,000
4,800	6,000	121,000	82,000	36,000
4,900	6,000	121,000	82,000	36,000
5,000	6,000	121,000	82,000	36,000
5,500	6,000	121,000	82,000	36,000
6,000	6,000	121,000	82,000	36,000
6,350	8,000	146,000	106,000	36,000
6,500	8,000	146,000	106,000	36,000
6,800	8,000	146,000	106,000	36,000
7,000	8,000	146,000	106,000	36,000
7,140	8,000	146,000	106,000	36,000
7,500	8,000	146,000	106,000	36,000
7,800	8,000	146,000	106,000	36,000
7,940	8,000	146,000	106,000	36,000
8,000	8,000	146,000	106,000	36,000
8,330	10,000	175,000	130,000	40,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
8,500	10,000	175,000	130,000	40,000
8,730	10,000	175,000	130,000	40,000
9,000	10,000	175,000	130,000	40,000
9,130	10,000	175,000	130,000	40,000
9,500	10,000	175,000	130,000	40,000
9,520	10,000	175,000	130,000	40,000
10,000	10,000	175,000	130,000	40,000
10,320	12,000	209,000	159,000	45,000
10,500	12,000	209,000	159,000	45,000
11,000	12,000	209,000	159,000	45,000
11,110	12,000	209,000	159,000	45,000
11,510	12,000	209,000	159,000	45,000
12,000	12,000	209,000	159,000	45,000
12,300	14,000	233,000	183,000	45,000
12,700	14,000	233,000	183,000	45,000
13,000	14,000	233,000	183,000	45,000
14,000	14,000	233,000	183,000	45,000
15,000	16,000	260,000	207,000	48,000
15,500	16,000	260,000	207,000	48,000
16,000	16,000	260,000	207,000	48,000
17,500	18,000	284,000	231,000	48,000
18,000	18,000	284,000	231,000	48,000
18,500	20,000	308,000	255,000	50,000
19,500	20,000	308,000	255,000	50,000

优势和特性

- 借助特殊的刀刃几何形状和极硬的DM涂层可精确高效的加工高强度材料和特殊金属
- 适用于汽车工业、航空航天业、能源设施制造和化学工业的理想解决方案

AD 10 H

合金、非合金高强度钢、硬化钢、特殊合金和钛合金



通过带凹形刀刃和特殊尖端几何形状的锥体磨削，实现可靠的切割和最佳切屑的形成

负倒棱设计可保护刀尖拐角，确保部件出色的表面质量

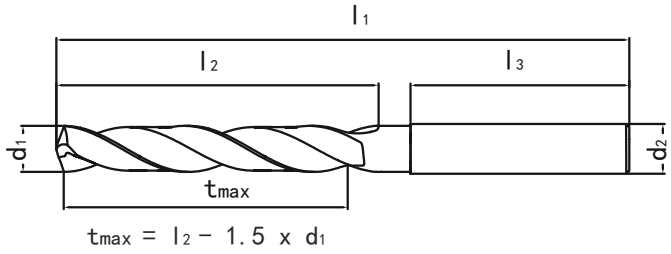
四个导向倒角确保最佳钻孔质量并尽可能的减少刀刃角磨损

特殊槽轮廓在长切屑材料中也能实现完美排屑

10578
AD10H

P	M	K	N	S	H
•				•	○

VHM | DM | 3xD | 140° | R | HA



$t_{max} = l_2 - 1.5 \times d_1$

芯厚≥φ3.000・圆弧后刀面・主切削刃轻微内凹・优化了的切削几何参数

适合加工：强度小于1400N/mm²的合金和高强度钢・镍合金，哈氏合金，锰合金・钛及钛合金

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	62,000	20,000	36,000
3,100	6,000	62,000	20,000	36,000
3,170	6,000	62,000	20,000	36,000
3,200	6,000	62,000	20,000	36,000
3,250	6,000	62,000	20,000	36,000
3,300	6,000	62,000	20,000	36,000
3,400	6,000	62,000	20,000	36,000
3,500	6,000	62,000	20,000	36,000
3,570	6,000	62,000	20,000	36,000
3,600	6,000	62,000	20,000	36,000
3,700	6,000	62,000	20,000	36,000
3,800	6,000	66,000	24,000	36,000
3,900	6,000	66,000	24,000	36,000
3,970	6,000	66,000	24,000	36,000
4,000	6,000	66,000	24,000	36,000
4,100	6,000	66,000	24,000	36,000
4,200	6,000	66,000	24,000	36,000
4,300	6,000	66,000	24,000	36,000
4,370	6,000	66,000	24,000	36,000
4,400	6,000	66,000	24,000	36,000
4,500	6,000	66,000	24,000	36,000
4,600	6,000	66,000	24,000	36,000
4,650	6,000	66,000	24,000	36,000
4,700	6,000	66,000	24,000	36,000
4,760	6,000	66,000	28,000	36,000
4,800	6,000	66,000	28,000	36,000
4,900	6,000	66,000	28,000	36,000
5,000	6,000	66,000	28,000	36,000
5,100	6,000	66,000	28,000	36,000
5,160	6,000	66,000	28,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
5,200	6,000	66,000	28,000	36,000
5,300	6,000	66,000	28,000	36,000
5,400	6,000	66,000	28,000	36,000
5,500	6,000	66,000	28,000	36,000
5,550	6,000	66,000	28,000	36,000
5,560	6,000	66,000	28,000	36,000
5,600	6,000	66,000	28,000	36,000
5,700	6,000	66,000	28,000	36,000
5,800	6,000	66,000	28,000	36,000
5,900	6,000	66,000	28,000	36,000
5,950	6,000	66,000	28,000	36,000
6,000	6,000	66,000	28,000	36,000
6,100	8,000	79,000	34,000	36,000
6,200	8,000	79,000	34,000	36,000
6,300	8,000	79,000	34,000	36,000
6,350	8,000	79,000	34,000	36,000
6,400	8,000	79,000	34,000	36,000
6,500	8,000	79,000	34,000	36,000
6,600	8,000	79,000	34,000	36,000
6,700	8,000	79,000	34,000	36,000
6,750	8,000	79,000	34,000	36,000
6,800	8,000	79,000	34,000	36,000
6,900	8,000	79,000	34,000	36,000
7,000	8,000	79,000	34,000	36,000
7,100	8,000	79,000	41,000	36,000
7,140	8,000	79,000	41,000	36,000
7,200	8,000	79,000	41,000	36,000
7,300	8,000	79,000	41,000	36,000
7,400	8,000	79,000	41,000	36,000
7,500	8,000	79,000	41,000	36,000

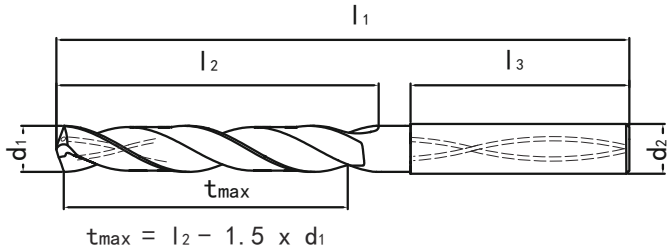
d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,540	8,000	79,000	41,000	36,000
7,600	8,000	79,000	41,000	36,000
7,700	8,000	79,000	41,000	36,000
7,800	8,000	79,000	41,000	36,000
7,900	8,000	79,000	41,000	36,000
7,940	8,000	79,000	41,000	36,000
8,000	8,000	79,000	41,000	36,000
8,100	10,000	89,000	47,000	40,000
8,200	10,000	89,000	47,000	40,000
8,300	10,000	89,000	47,000	40,000
8,330	10,000	89,000	47,000	40,000
8,400	10,000	89,000	47,000	40,000
8,500	10,000	89,000	47,000	40,000
8,600	10,000	89,000	47,000	40,000
8,700	10,000	89,000	47,000	40,000
8,730	10,000	89,000	47,000	40,000
8,800	10,000	89,000	47,000	40,000
8,900	10,000	89,000	47,000	40,000
9,000	10,000	89,000	47,000	40,000
9,100	10,000	89,000	47,000	40,000
9,130	10,000	89,000	47,000	40,000
9,200	10,000	89,000	47,000	40,000
9,250	10,000	89,000	47,000	40,000
9,300	10,000	89,000	47,000	40,000
9,400	10,000	89,000	47,000	40,000
9,500	10,000	89,000	47,000	40,000
9,520	10,000	89,000	47,000	40,000
9,600	10,000	89,000	47,000	40,000
9,700	10,000	89,000	47,000	40,000
9,800	10,000	89,000	47,000	40,000
9,900	10,000	89,000	47,000	40,000
9,920	10,000	89,000	47,000	40,000
10,000	10,000	89,000	47,000	40,000
10,100	12,000	102,000	55,000	45,000
10,200	12,000	102,000	55,000	45,000
10,300	12,000	102,000	55,000	45,000
10,320	12,000	102,000	55,000	45,000
10,400	12,000	102,000	55,000	45,000
10,500	12,000	102,000	55,000	45,000
10,600	12,000	102,000	55,000	45,000
10,700	12,000	102,000	55,000	45,000
10,800	12,000	102,000	55,000	45,000
10,900	12,000	102,000	55,000	45,000
11,000	12,000	102,000	55,000	45,000
11,100	12,000	102,000	55,000	45,000
11,110	12,000	102,000	55,000	45,000
11,200	12,000	102,000	55,000	45,000
11,300	12,000	102,000	55,000	45,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
11,400	12,000	102,000	55,000	45,000
11,500	12,000	102,000	55,000	45,000
11,600	12,000	102,000	55,000	45,000
11,700	12,000	102,000	55,000	45,000
11,800	12,000	102,000	55,000	45,000
11,900	12,000	102,000	55,000	45,000
11,910	12,000	102,000	55,000	45,000
12,000	12,000	102,000	55,000	45,000
12,200	14,000	107,000	60,000	45,000
12,500	14,000	107,000	60,000	45,000
12,700	14,000	107,000	60,000	45,000
12,800	14,000	107,000	60,000	45,000
13,000	14,000	107,000	60,000	45,000
13,300	14,000	107,000	60,000	45,000
13,500	14,000	107,000	60,000	45,000
13,700	14,000	107,000	60,000	45,000
14,000	14,000	107,000	60,000	45,000
14,200	16,000	115,000	65,000	48,000
14,290	16,000	115,000	65,000	48,000
14,300	16,000	115,000	65,000	48,000
14,500	16,000	115,000	65,000	48,000
14,700	16,000	115,000	65,000	48,000
15,000	16,000	115,000	65,000	48,000
15,200	16,000	115,000	65,000	48,000
15,300	16,000	115,000	65,000	48,000
15,500	16,000	115,000	65,000	48,000
15,700	16,000	115,000	65,000	48,000
16,000	16,000	115,000	65,000	48,000
16,300	18,000	123,000	73,000	48,000
16,500	18,000	123,000	73,000	48,000
16,900	18,000	123,000	73,000	48,000
17,000	18,000	123,000	73,000	48,000
17,300	18,000	123,000	73,000	48,000
17,500	18,000	123,000	73,000	48,000
18,000	18,000	123,000	73,000	48,000
18,500	20,000	131,000	79,000	50,000
18,900	20,000	131,000	79,000	50,000
19,000	20,000	131,000	79,000	50,000
19,050	20,000	131,000	79,000	50,000
19,300	20,000	131,000	79,000	50,000
19,500	20,000	131,000	79,000	50,000
20,000	20,000	131,000	79,000	50,000

10577
AD10H

P	M	K	N	S	H
•				•	○

VHM | DM | 3xD | 140° | R | HA



$t_{max} = l_2 - 1.5 \times d_1$

芯厚≥φ3.000・圆弧后刀面・主切削刃轻微内凹・优化了的切削几何参数

适合加工：强度小于1400N/mm²的合金和高强度钢・镍合金，哈氏合金，锰合金・钛及钛合金

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	62,000	20,000	36,000
3,100	6,000	62,000	20,000	36,000
3,170	6,000	62,000	20,000	36,000
3,200	6,000	62,000	20,000	36,000
3,250	6,000	62,000	20,000	36,000
3,300	6,000	62,000	20,000	36,000
3,400	6,000	62,000	20,000	36,000
3,500	6,000	62,000	20,000	36,000
3,570	6,000	62,000	20,000	36,000
3,600	6,000	62,000	20,000	36,000
3,700	6,000	62,000	20,000	36,000
3,800	6,000	66,000	24,000	36,000
3,900	6,000	66,000	24,000	36,000
3,970	6,000	66,000	24,000	36,000
4,000	6,000	66,000	24,000	36,000
4,100	6,000	66,000	24,000	36,000
4,200	6,000	66,000	24,000	36,000
4,300	6,000	66,000	24,000	36,000
4,370	6,000	66,000	24,000	36,000
4,400	6,000	66,000	24,000	36,000
4,500	6,000	66,000	24,000	36,000
4,600	6,000	66,000	24,000	36,000
4,650	6,000	66,000	24,000	36,000
4,700	6,000	66,000	24,000	36,000
4,760	6,000	66,000	28,000	36,000
4,800	6,000	66,000	28,000	36,000
4,900	6,000	66,000	28,000	36,000
5,000	6,000	66,000	28,000	36,000
5,100	6,000	66,000	28,000	36,000
5,160	6,000	66,000	28,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
5,200	6,000	66,000	28,000	36,000
5,300	6,000	66,000	28,000	36,000
5,400	6,000	66,000	28,000	36,000
5,500	6,000	66,000	28,000	36,000
5,550	6,000	66,000	28,000	36,000
5,560	6,000	66,000	28,000	36,000
5,600	6,000	66,000	28,000	36,000
5,700	6,000	66,000	28,000	36,000
5,800	6,000	66,000	28,000	36,000
5,900	6,000	66,000	28,000	36,000
5,950	6,000	66,000	28,000	36,000
6,000	6,000	66,000	28,000	36,000
6,100	8,000	79,000	34,000	36,000
6,200	8,000	79,000	34,000	36,000
6,300	8,000	79,000	34,000	36,000
6,350	8,000	79,000	34,000	36,000
6,400	8,000	79,000	34,000	36,000
6,500	8,000	79,000	34,000	36,000
6,600	8,000	79,000	34,000	36,000
6,700	8,000	79,000	34,000	36,000
6,750	8,000	79,000	34,000	36,000
6,800	8,000	79,000	34,000	36,000
6,900	8,000	79,000	34,000	36,000
7,000	8,000	79,000	34,000	36,000
7,100	8,000	79,000	41,000	36,000
7,140	8,000	79,000	41,000	36,000
7,200	8,000	79,000	41,000	36,000
7,300	8,000	79,000	41,000	36,000
7,400	8,000	79,000	41,000	36,000
7,500	8,000	79,000	41,000	36,000

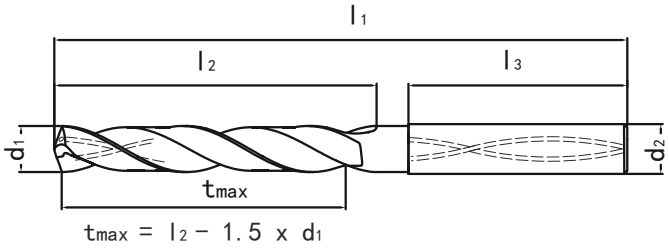
d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,540	8,000	79,000	41,000	36,000
7,600	8,000	79,000	41,000	36,000
7,700	8,000	79,000	41,000	36,000
7,800	8,000	79,000	41,000	36,000
7,900	8,000	79,000	41,000	36,000
7,940	8,000	79,000	41,000	36,000
8,000	8,000	79,000	41,000	36,000
8,100	10,000	89,000	47,000	40,000
8,200	10,000	89,000	47,000	40,000
8,300	10,000	89,000	47,000	40,000
8,330	10,000	89,000	47,000	40,000
8,400	10,000	89,000	47,000	40,000
8,500	10,000	89,000	47,000	40,000
8,600	10,000	89,000	47,000	40,000
8,700	10,000	89,000	47,000	40,000
8,730	10,000	89,000	47,000	40,000
8,800	10,000	89,000	47,000	40,000
8,900	10,000	89,000	47,000	40,000
9,000	10,000	89,000	47,000	40,000
9,100	10,000	89,000	47,000	40,000
9,130	10,000	89,000	47,000	40,000
9,200	10,000	89,000	47,000	40,000
9,250	10,000	89,000	47,000	40,000
9,300	10,000	89,000	47,000	40,000
9,400	10,000	89,000	47,000	40,000
9,500	10,000	89,000	47,000	40,000
9,520	10,000	89,000	47,000	40,000
9,600	10,000	89,000	47,000	40,000
9,700	10,000	89,000	47,000	40,000
9,800	10,000	89,000	47,000	40,000
9,900	10,000	89,000	47,000	40,000
9,920	10,000	89,000	47,000	40,000
10,000	10,000	89,000	47,000	40,000
10,100	12,000	102,000	55,000	45,000
10,200	12,000	102,000	55,000	45,000
10,300	12,000	102,000	55,000	45,000
10,320	12,000	102,000	55,000	45,000
10,400	12,000	102,000	55,000	45,000
10,500	12,000	102,000	55,000	45,000
10,600	12,000	102,000	55,000	45,000
10,700	12,000	102,000	55,000	45,000
10,800	12,000	102,000	55,000	45,000
10,900	12,000	102,000	55,000	45,000
11,000	12,000	102,000	55,000	45,000
11,100	12,000	102,000	55,000	45,000
11,110	12,000	102,000	55,000	45,000
11,200	12,000	102,000	55,000	45,000
11,300	12,000	102,000	55,000	45,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
11,400	12,000	102,000	55,000	45,000
11,500	12,000	102,000	55,000	45,000
11,600	12,000	102,000	55,000	45,000
11,700	12,000	102,000	55,000	45,000
11,800	12,000	102,000	55,000	45,000
11,900	12,000	102,000	55,000	45,000
11,910	12,000	102,000	55,000	45,000
12,000	12,000	102,000	55,000	45,000
12,200	14,000	107,000	60,000	45,000
12,500	14,000	107,000	60,000	45,000
12,700	14,000	107,000	60,000	45,000
12,800	14,000	107,000	60,000	45,000
13,000	14,000	107,000	60,000	45,000
13,300	14,000	107,000	60,000	45,000
13,500	14,000	107,000	60,000	45,000
13,700	14,000	107,000	60,000	45,000
14,000	14,000	107,000	60,000	45,000
14,200	16,000	115,000	65,000	48,000
14,290	16,000	115,000	65,000	48,000
14,300	16,000	115,000	65,000	48,000
14,500	16,000	115,000	65,000	48,000
14,700	16,000	115,000	65,000	48,000
15,000	16,000	115,000	65,000	48,000
15,200	16,000	115,000	65,000	48,000
15,300	16,000	115,000	65,000	48,000
15,500	16,000	115,000	65,000	48,000
15,700	16,000	115,000	65,000	48,000
16,000	16,000	115,000	65,000	48,000
16,300	18,000	123,000	73,000	48,000
16,500	18,000	123,000	73,000	48,000
16,900	18,000	123,000	73,000	48,000
17,000	18,000	123,000	73,000	48,000
17,300	18,000	123,000	73,000	48,000
17,500	18,000	123,000	73,000	48,000
18,000	18,000	123,000	73,000	48,000
18,500	20,000	131,000	79,000	50,000
18,900	20,000	131,000	79,000	50,000
19,000	20,000	131,000	79,000	50,000
19,050	20,000	131,000	79,000	50,000
19,300	20,000	131,000	79,000	50,000
19,500	20,000	131,000	79,000	50,000
20,000	20,000	131,000	79,000	50,000

10575
AD10H

P	M	K	N	S	H
•				•	○

VHM | DM | 5xD | 140° | R | HA



$t_{max} = l_2 - 1.5 \times d_1$

芯厚≥φ3.000・圆弧后刀面・主切削刃轻微内凹・优化了的切削几何参数

适合加工：强度小于1400N/mm²的合金和高强度钢・镍合金，哈氏合金，锰合金・钛及钛合金

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	66,000	28,000	36,000
3,100	6,000	66,000	28,000	36,000
3,170	6,000	66,000	28,000	36,000
3,200	6,000	66,000	28,000	36,000
3,250	6,000	66,000	28,000	36,000
3,300	6,000	66,000	28,000	36,000
3,400	6,000	66,000	28,000	36,000
3,500	6,000	66,000	28,000	36,000
3,570	6,000	66,000	28,000	36,000
3,600	6,000	66,000	28,000	36,000
3,700	6,000	66,000	28,000	36,000
3,800	6,000	74,000	36,000	36,000
3,900	6,000	74,000	36,000	36,000
3,970	6,000	74,000	36,000	36,000
4,000	6,000	74,000	36,000	36,000
4,100	6,000	74,000	36,000	36,000
4,200	6,000	74,000	36,000	36,000
4,300	6,000	74,000	36,000	36,000
4,370	6,000	74,000	36,000	36,000
4,400	6,000	74,000	36,000	36,000
4,500	6,000	74,000	36,000	36,000
4,600	6,000	74,000	36,000	36,000
4,650	6,000	74,000	36,000	36,000
4,700	6,000	74,000	36,000	36,000
4,760	6,000	82,000	44,000	36,000
4,800	6,000	82,000	44,000	36,000
4,900	6,000	82,000	44,000	36,000
5,000	6,000	82,000	44,000	36,000
5,100	6,000	82,000	44,000	36,000
5,160	6,000	82,000	44,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
5,200	6,000	82,000	44,000	36,000
5,300	6,000	82,000	44,000	36,000
5,400	6,000	82,000	44,000	36,000
5,500	6,000	82,000	44,000	36,000
5,550	6,000	82,000	44,000	36,000
5,560	6,000	82,000	44,000	36,000
5,600	6,000	82,000	44,000	36,000
5,700	6,000	82,000	44,000	36,000
5,800	6,000	82,000	44,000	36,000
5,900	6,000	82,000	44,000	36,000
5,950	6,000	82,000	44,000	36,000
6,000	6,000	82,000	44,000	36,000
6,100	8,000	91,000	53,000	36,000
6,200	8,000	91,000	53,000	36,000
6,300	8,000	91,000	53,000	36,000
6,350	8,000	91,000	53,000	36,000
6,400	8,000	91,000	53,000	36,000
6,500	8,000	91,000	53,000	36,000
6,600	8,000	91,000	53,000	36,000
6,700	8,000	91,000	53,000	36,000
6,750	8,000	91,000	53,000	36,000
6,800	8,000	91,000	53,000	36,000
6,900	8,000	91,000	53,000	36,000
7,000	8,000	91,000	53,000	36,000
7,100	8,000	91,000	53,000	36,000
7,140	8,000	91,000	53,000	36,000
7,200	8,000	91,000	53,000	36,000
7,300	8,000	91,000	53,000	36,000
7,400	8,000	91,000	53,000	36,000
7,500	8,000	91,000	53,000	36,000

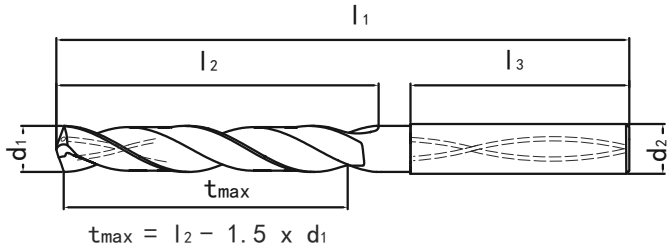
d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,540	8,000	91,000	53,000	36,000
7,600	8,000	91,000	53,000	36,000
7,700	8,000	91,000	53,000	36,000
7,800	8,000	91,000	53,000	36,000
7,900	8,000	91,000	53,000	36,000
7,940	8,000	91,000	53,000	36,000
8,000	8,000	91,000	53,000	36,000
8,100	10,000	103,000	61,000	40,000
8,200	10,000	103,000	61,000	40,000
8,300	10,000	103,000	61,000	40,000
8,330	10,000	103,000	61,000	40,000
8,400	10,000	103,000	61,000	40,000
8,500	10,000	103,000	61,000	40,000
8,600	10,000	103,000	61,000	40,000
8,700	10,000	103,000	61,000	40,000
8,730	10,000	103,000	61,000	40,000
8,800	10,000	103,000	61,000	40,000
8,900	10,000	103,000	61,000	40,000
9,000	10,000	103,000	61,000	40,000
9,100	10,000	103,000	61,000	40,000
9,130	10,000	103,000	61,000	40,000
9,200	10,000	103,000	61,000	40,000
9,250	10,000	103,000	61,000	40,000
9,300	10,000	103,000	61,000	40,000
9,400	10,000	103,000	61,000	40,000
9,500	10,000	103,000	61,000	40,000
9,520	10,000	103,000	61,000	40,000
9,600	10,000	103,000	61,000	40,000
9,700	10,000	103,000	61,000	40,000
9,800	10,000	103,000	61,000	40,000
9,900	10,000	103,000	61,000	40,000
9,920	10,000	103,000	61,000	40,000
10,000	10,000	103,000	61,000	40,000
10,100	12,000	118,000	71,000	45,000
10,200	12,000	118,000	71,000	45,000
10,300	12,000	118,000	71,000	45,000
10,320	12,000	118,000	71,000	45,000
10,400	12,000	118,000	71,000	45,000
10,500	12,000	118,000	71,000	45,000
10,600	12,000	118,000	71,000	45,000
10,700	12,000	118,000	71,000	45,000
10,800	12,000	118,000	71,000	45,000
10,900	12,000	118,000	71,000	45,000
11,000	12,000	118,000	71,000	45,000
11,100	12,000	118,000	71,000	45,000
11,110	12,000	118,000	71,000	45,000
11,200	12,000	118,000	71,000	45,000
11,300	12,000	118,000	71,000	45,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
11,400	12,000	118,000	71,000	45,000
11,500	12,000	118,000	71,000	45,000
11,600	12,000	118,000	71,000	45,000
11,700	12,000	118,000	71,000	45,000
11,800	12,000	118,000	71,000	45,000
11,900	12,000	118,000	71,000	45,000
11,910	12,000	118,000	71,000	45,000
12,000	12,000	118,000	71,000	45,000
12,200	14,000	124,000	77,000	45,000
12,500	14,000	124,000	77,000	45,000
12,700	14,000	124,000	77,000	45,000
12,800	14,000	124,000	77,000	45,000
13,000	14,000	124,000	77,000	45,000
13,300	14,000	124,000	77,000	45,000
13,500	14,000	124,000	77,000	45,000
13,700	14,000	124,000	77,000	45,000
14,000	14,000	124,000	77,000	45,000
14,200	16,000	133,000	83,000	48,000
14,290	16,000	133,000	83,000	48,000
14,300	16,000	133,000	83,000	48,000
14,500	16,000	133,000	83,000	48,000
14,700	16,000	133,000	83,000	48,000
15,000	16,000	133,000	83,000	48,000
15,200	16,000	133,000	83,000	48,000
15,300	16,000	133,000	83,000	48,000
15,500	16,000	133,000	83,000	48,000
15,700	16,000	133,000	83,000	48,000
16,000	16,000	133,000	83,000	48,000
16,300	18,000	143,000	93,000	48,000
16,500	18,000	143,000	93,000	48,000
16,900	18,000	143,000	93,000	48,000
17,000	18,000	143,000	93,000	48,000
17,300	18,000	143,000	93,000	48,000
17,500	18,000	143,000	93,000	48,000
18,000	18,000	143,000	93,000	48,000
18,500	20,000	153,000	101,000	50,000
18,900	20,000	153,000	101,000	50,000
19,000	20,000	153,000	101,000	50,000
19,050	20,000	153,000	101,000	50,000
19,300	20,000	153,000	101,000	50,000
19,500	20,000	153,000	101,000	50,000
20,000	20,000	153,000	101,000	50,000

10573
AD10H

P	M	K	N	S	H
•				•	○

VHM | DM | 7xD | 140° | R | HA



$t_{max} = l_2 - 1.5 \times d_1$

芯厚≥φ3.000・圆弧后刀面・主切削刃轻微内凹・优化了的切削几何参数

适合加工：强度小于1400N/mm²的合金和高强度钢・镍合金，哈氏合金，锰合金・钛及钛合金

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	70,000	30,000	36,000
3,250	6,000	70,000	30,000	36,000
3,300	6,000	70,000	30,000	36,000
3,400	6,000	75,000	35,500	36,000
3,500	6,000	75,000	35,500	36,000
3,700	6,000	75,000	35,500	36,000
4,000	6,000	75,000	37,500	36,000
4,200	6,000	75,000	37,500	36,000
4,300	6,000	85,000	45,000	36,000
4,500	6,000	85,000	45,000	36,000
4,650	6,000	85,000	45,000	36,000
5,000	6,000	90,000	50,000	36,000
5,100	6,000	90,000	50,000	36,000
5,200	6,000	90,000	50,000	36,000
5,500	6,000	97,000	57,000	36,000
5,550	6,000	97,000	57,000	36,000
6,000	6,000	97,000	57,000	36,000
6,500	8,000	106,000	66,000	36,000
6,750	8,000	106,000	66,000	36,000
6,800	8,000	106,000	66,000	36,000
6,900	8,000	116,000	76,000	36,000
7,000	8,000	116,000	76,000	36,000
7,400	8,000	116,000	76,000	36,000
7,500	8,000	116,000	76,000	36,000
7,800	8,000	116,000	76,000	36,000
8,000	8,000	116,000	76,000	36,000
8,500	10,000	131,000	87,000	40,000
8,600	10,000	131,000	87,000	40,000
8,800	10,000	131,000	87,000	40,000
9,000	10,000	131,000	87,000	40,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
9,250	10,000	139,000	95,000	40,000
9,400	10,000	139,000	95,000	40,000
9,500	10,000	139,000	95,000	40,000
10,000	10,000	139,000	95,000	40,000
10,200	12,000	155,000	106,000	45,000
10,400	12,000	155,000	106,000	45,000
10,500	12,000	155,000	106,000	45,000
10,800	12,000	155,000	106,000	45,000
11,000	12,000	155,000	106,000	45,000
11,300	12,000	163,000	114,000	45,000
11,400	12,000	163,000	114,000	45,000
11,500	12,000	163,000	114,000	45,000
12,000	12,000	163,000	114,000	45,000
12,500	14,000	182,000	133,000	45,000
13,000	14,000	182,000	133,000	45,000
13,100	14,000	182,000	133,000	45,000
13,500	14,000	182,000	133,000	45,000
14,000	14,000	182,000	133,000	45,000
14,500	16,000	204,000	152,000	48,000
15,000	16,000	204,000	152,000	48,000
15,100	16,000	204,000	152,000	48,000
15,500	16,000	204,000	152,000	48,000
16,000	16,000	204,000	152,000	48,000

- 用于钻孔深度最高25xD的螺旋深孔钻头适合非合金和合金钢，尤其是曲轴钢
- 经优化的槽横截面和抛光的平滑槽实现深孔的最佳排屑
- 最高进给和切削速度可显著缩短制造时间
- 可根据要求选购针对铝加工的特殊规格 N

P

M

K

AD 10 T

普通钢加工最高可达1200N/mm²▾通用型

特殊芯厚减薄处理实现高精度的
孔径及直线度

最大冷却通道横截面确保为刀刃
高效提供润滑剂以及出色排屑

刀具几何形状设计用于几乎所有材料

四个导向倒角实现最佳孔内支承

最佳槽横截面确保在刀具前部出色形
成切屑，以及在后部区域良好排屑

抛光槽实现完美排屑--即使面向极深钻孔



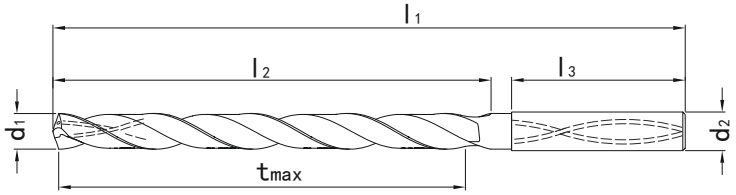
13491
AD10T

P	M	K	N	S	H
•	•	•		○	○

VHM | DM | 15xD | 135° | R | HA

芯厚≥ φ3.000・圆弧后刀面・刀尖涂层・凹形主切削刃形状・优化槽型设计

适合加工：结构钢和淬硬钢・易切削钢和热处理钢・强度小于1200N/mm²的合金钢・不锈钢・铸件材料



$t_{max} = l_2 - 1.5 \times d_1$

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	95,000	55,000	36,000
3,100	6,000	106,000	66,000	36,000
3,170	6,000	106,000	66,000	36,000
3,200	6,000	106,000	66,000	36,000
3,300	6,000	106,000	66,000	36,000
3,500	6,000	116,000	76,000	36,000
3,570	6,000	116,000	76,000	36,000
3,700	6,000	116,000	76,000	36,000
3,800	6,000	116,000	76,000	36,000
3,970	6,000	116,000	76,000	36,000
4,000	6,000	116,000	76,000	36,000
4,200	6,000	133,000	93,000	36,000
4,300	6,000	133,000	93,000	36,000
4,370	6,000	133,000	93,000	36,000
4,500	6,000	133,000	93,000	36,000
4,600	6,000	133,000	93,000	36,000
4,760	6,000	133,000	93,000	36,000
4,800	6,000	133,000	93,000	36,000
5,000	6,000	133,000	93,000	36,000
5,100	6,000	150,000	110,000	36,000
5,160	6,000	150,000	110,000	36,000
5,410	6,000	150,000	110,000	36,000
5,500	6,000	150,000	110,000	36,000
5,560	6,000	150,000	110,000	36,000
5,600	6,000	150,000	110,000	36,000
5,800	6,000	150,000	110,000	36,000
5,950	6,000	150,000	110,000	36,000
6,000	6,000	150,000	110,000	36,000
6,300	8,000	167,000	127,000	36,000
6,350	8,000	167,000	127,000	36,000
6,500	8,000	167,000	127,000	36,000
6,750	8,000	167,000	127,000	36,000
6,800	8,000	167,000	127,000	36,000
7,000	8,000	167,000	127,000	36,000
7,140	8,000	183,000	143,000	36,000
7,500	8,000	183,000	143,000	36,000

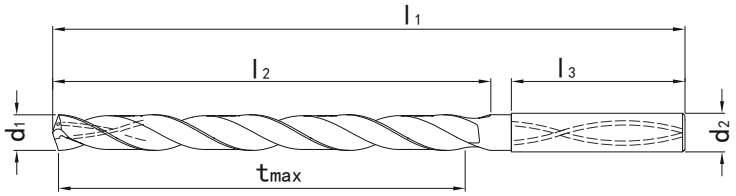
d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,540	8,000	183,000	143,000	36,000
7,800	8,000	183,000	143,000	36,000
7,940	8,000	183,000	143,000	36,000
8,000	8,000	183,000	143,000	36,000
8,330	10,000	204,000	160,000	40,000
8,500	10,000	204,000	160,000	40,000
8,730	10,000	204,000	160,000	40,000
8,800	10,000	204,000	160,000	40,000
9,000	10,000	204,000	160,000	40,000
9,130	10,000	221,000	177,000	40,000
9,500	10,000	221,000	177,000	40,000
9,520	10,000	221,000	177,000	40,000
9,800	10,000	221,000	177,000	40,000
9,920	10,000	221,000	177,000	40,000
10,000	10,000	221,000	177,000	40,000
10,320	12,000	247,000	198,000	45,000
10,500	12,000	247,000	198,000	45,000
10,720	12,000	247,000	198,000	45,000
11,000	12,000	247,000	198,000	45,000
11,110	12,000	263,000	214,000	45,000
11,510	12,000	263,000	214,000	45,000
11,800	12,000	263,000	214,000	45,000
11,910	12,000	263,000	214,000	45,000
12,000	12,000	263,000	214,000	45,000
12,300	14,000	297,000	248,000	45,000
12,500	14,000	297,000	248,000	45,000
12,700	14,000	297,000	248,000	45,000
13,000	14,000	297,000	248,000	45,000
13,100	14,000	297,000	248,000	45,000
13,490	14,000	297,000	248,000	45,000
13,890	14,000	297,000	248,000	45,000
14,000	14,000	297,000	248,000	45,000
14,290	16,000	333,000	281,000	48,000
15,000	16,000	333,000	281,000	48,000
15,870	16,000	333,000	281,000	48,000
16,000	16,000	333,000	281,000	48,000

13489

AD10T

P	M	K	N	S	H
•	•	•		○	○

VHM | DM | 20xD | 135° | R | HA



$t_{max} = l_2 - 1.5 \times d_1$

芯厚≥φ3.000・圆弧后刀面・刀尖涂层・凹形主切削刃形状・优化槽型设计

适合加工：结构钢和淬硬钢・易切削钢和热处理钢・强度小于1200N/mm²的合金钢・不锈钢・铸件材料

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	110,000	70,000	36,000
3,100	6,000	123,000	83,000	36,000
3,170	6,000	123,000	83,000	36,000
3,200	6,000	123,000	83,000	36,000
3,300	6,000	123,000	83,000	36,000
3,500	6,000	136,000	96,000	36,000
3,570	6,000	136,000	96,000	36,000
3,700	6,000	136,000	96,000	36,000
3,800	6,000	136,000	96,000	36,000
3,970	6,000	136,000	96,000	36,000
4,000	6,000	136,000	96,000	36,000
4,200	6,000	158,000	118,000	36,000
4,300	6,000	158,000	118,000	36,000
4,370	6,000	158,000	118,000	36,000
4,500	6,000	158,000	118,000	36,000
4,600	6,000	158,000	118,000	36,000
4,760	6,000	158,000	118,000	36,000
4,800	6,000	158,000	118,000	36,000
5,000	6,000	158,000	118,000	36,000
5,100	6,000	180,000	140,000	36,000
5,160	6,000	180,000	140,000	36,000
5,410	6,000	180,000	140,000	36,000
5,500	6,000	180,000	140,000	36,000
5,560	6,000	180,000	140,000	36,000
5,800	6,000	180,000	140,000	36,000
5,950	6,000	180,000	140,000	36,000
6,000	6,000	180,000	140,000	36,000
6,350	8,000	202,000	162,000	36,000
6,500	8,000	202,000	162,000	36,000
6,750	8,000	202,000	162,000	36,000
6,800	8,000	202,000	162,000	36,000
7,000	8,000	202,000	162,000	36,000
7,140	8,000	223,000	183,000	36,000
7,500	8,000	223,000	183,000	36,000
7,540	8,000	223,000	183,000	36,000
7,800	8,000	223,000	183,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,940	8,000	223,000	183,000	36,000
8,000	8,000	223,000	183,000	36,000
8,330	10,000	249,000	205,000	40,000
8,500	10,000	249,000	205,000	40,000
8,730	10,000	249,000	205,000	40,000
8,800	10,000	249,000	205,000	40,000
9,000	10,000	249,000	205,000	40,000
9,130	10,000	271,000	227,000	40,000
9,520	10,000	271,000	227,000	40,000
9,920	10,000	271,000	227,000	40,000
10,000	10,000	271,000	227,000	40,000
10,200	12,000	302,000	253,000	45,000
10,320	12,000	302,000	253,000	45,000
10,500	12,000	302,000	253,000	45,000
10,720	12,000	302,000	253,000	45,000
11,000	12,000	302,000	253,000	45,000
11,110	12,000	323,000	274,000	45,000
11,510	12,000	323,000	274,000	45,000
11,800	12,000	323,000	274,000	45,000
11,910	12,000	323,000	274,000	45,000
12,000	12,000	323,000	274,000	45,000
12,300	14,000	367,000	318,000	45,000
12,500	14,000	367,000	318,000	45,000
12,700	14,000	367,000	318,000	45,000
13,000	14,000	367,000	318,000	45,000
13,100	14,000	367,000	318,000	45,000
13,490	14,000	367,000	318,000	45,000
13,890	14,000	367,000	318,000	45,000
14,000	14,000	367,000	318,000	45,000
14,290	16,000	413,000	361,000	48,000
15,000	16,000	413,000	361,000	48,000
15,870	16,000	413,000	361,000	48,000
16,000	16,000	413,000	361,000	48,000

13488

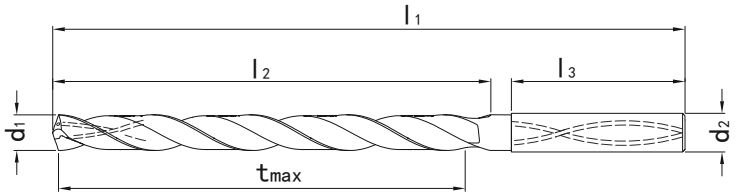
AD10T

P	M	K	N	S	H
•	•	•		○	○

VHM | DM | 25xD | 135° | R | HA

芯厚≥φ3.000・圆弧后刀面・刀尖涂层・凹形主切削刃形状・优化槽型设计

适合加工：结构钢和淬硬钢・易切削钢和热处理钢・强度小于1200N/mm²的合金钢・不锈钢・铸件材料



$t_{max} = l_2 - 1.5 \times d_1$

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
3,000	6,000	125,000	85,000	36,000
3,100	6,000	141,000	101,000	36,000
3,170	6,000	141,000	101,000	36,000
3,200	6,000	141,000	101,000	36,000
3,300	6,000	141,000	101,000	36,000
3,500	6,000	156,000	116,000	36,000
3,570	6,000	156,000	116,000	36,000
3,700	6,000	156,000	116,000	36,000
3,800	6,000	156,000	116,000	36,000
3,970	6,000	156,000	116,000	36,000
4,000	6,000	156,000	116,000	36,000
4,200	6,000	183,000	143,000	36,000
4,300	6,000	183,000	143,000	36,000
4,370	6,000	183,000	143,000	36,000
4,500	6,000	183,000	143,000	36,000
4,600	6,000	183,000	143,000	36,000
4,760	6,000	183,000	143,000	36,000
4,800	6,000	183,000	143,000	36,000
5,000	6,000	183,000	143,000	36,000
5,100	6,000	210,000	170,000	36,000
5,160	6,000	210,000	170,000	36,000
5,410	6,000	210,000	170,000	36,000
5,500	6,000	210,000	170,000	36,000
5,560	6,000	210,000	170,000	36,000
5,800	6,000	210,000	170,000	36,000
5,950	6,000	210,000	170,000	36,000
6,000	6,000	210,000	170,000	36,000
6,300	8,000	237,000	197,000	36,000
6,350	8,000	237,000	197,000	36,000
6,500	8,000	237,000	197,000	36,000
6,750	8,000	237,000	197,000	36,000
6,800	8,000	237,000	197,000	36,000
7,000	8,000	237,000	197,000	36,000

d1 mm	d2 h6 mm	l1 mm	l2 mm	l3 mm
7,140	8,000	263,000	223,000	36,000
7,500	8,000	263,000	223,000	36,000
7,540	8,000	263,000	223,000	36,000
7,940	8,000	263,000	223,000	36,000
8,000	8,000	263,000	223,000	36,000
8,330	10,000	294,000	250,000	40,000
8,500	10,000	294,000	250,000	40,000
8,730	10,000	294,000	250,000	40,000
8,800	10,000	294,000	250,000	40,000
9,000	10,000	294,000	250,000	40,000
9,130	10,000	321,000	277,000	40,000
9,520	10,000	321,000	277,000	40,000
9,920	10,000	321,000	277,000	40,000
10,000	10,000	321,000	277,000	40,000
10,320	12,000	359,000	310,000	45,000
10,720	12,000	359,000	310,000	45,000
11,000	12,000	359,000	310,000	45,000
11,110	12,000	386,000	337,000	45,000
11,510	12,000	386,000	337,000	45,000
11,910	12,000	386,000	337,000	45,000
12,000	12,000	386,000	337,000	45,000
12,300	14,000	437,000	388,000	45,000
12,700	14,000	437,000	388,000	45,000
13,000	14,000	437,000	388,000	45,000
13,100	14,000	437,000	388,000	45,000
13,490	14,000	437,000	388,000	45,000
13,890	14,000	437,000	388,000	45,000
14,000	14,000	437,000	388,000	45,000
14,290	16,000	493,000	441,000	48,000
15,000	16,000	493,000	441,000	48,000
15,870	16,000	493,000	441,000	48,000
16,000	16,000	493,000	441,000	48,000



技术信息

涂层

DM涂层



- 外观特征：古铜色
- DM涂层的成分是SiTiN，它的通用性好，一般用于加工超硬材料，同样也适合高线速度的加工工况

GM涂层



- 外观特征：黑灰色
- GM涂层的成分是AlTiN，一般用来加工高硬度的材料，比较适合低线速度的加工工况

AN涂层



- 外观特征：黑灰色
- AN涂层的成分是TiAlN，一般用来加工＜HRC45的材料

AD涂层



- 外观特征：黑灰色
- AD涂层的成分是TiAlN，一般用来加工HRC50-60的材料

技术信息

AD系列硬质合金钻头

一般提示

出于安全考虑，特别注意不得已高于n=6000rpm的转速空转钻头。否则离心力可能使长刀具在接触工件表面前断裂！

7xD、10xD和12xD钻头的使用提示

针对≥7xD的钻孔深度，统通常设有导向孔。

1. 导向孔可以通过段短硬钻头生成，其直径要比AD系列钻头的直径大0.01～0.02mm。导向孔深度1xD。
2. AD钻头也可加工导向孔。为此，切削速度和进给降低30~40%。

AD系列钻头的应用建议

货号:HA

刀具材质

表面处理

类型

内冷

页码

整体硬质合金钻头的一般提示
高性能机床，高精度刀柄，刀尖跳动偏差最大0.02mm，
高冷却压力，建议采用液压刀柄和热缩刀柄。

整体硬质合金钻头的冷却提示
我们建议使用乳化液或油进行冷却润滑。在特殊情况下可以
通过空气冷却，但并不推荐空冷。

钻头直径 Ø mm	进给代号								
	1	2	3	4	5	6	7	8	9
	f(mm/圈)								
2, 50	0, 025	0, 032	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160
3, 15	0, 032	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 160
4, 00	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 200
5, 00	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250
6, 30	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315
8, 00	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 315
10, 00	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 400
12, 50	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500
16, 00	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500	0, 630
20, 00	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500	0, 630	0, 630
25, 00	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500	0, 630	0, 800	0, 800

冷却剂:
● 乳化液
● 切削油
○ 空气

材料组	材料例举,最新牌号(括弧内为旧牌号) 粗体数字=材料代号依据DIN EN	拉伸强度_ MPa (N/mm²)	硬度	冷却方式
普通结构钢	**1.0035** S185(St33), **1.0486** P275N(StE285), **1.0345** P235GH(H1), **1.0425** P265GH(H2)	≤500		●
	1.0050 E295 (St50-2), **1.0070** E360 (St70-2), **1.8937** P500NH (WStE500)	≤1000		●
易切削钢	**1.0718** 11SMnPb30 (9SMnPb28), **1.0736** 11SMn37 (9SMn36)	≤850		●
	1.0727 46S20 (45S20), **1.0728** (60S20), **1.0757** 46SPb20 (45SPb20)	≤1000		●
非合金热处理钢	**1.0402** C22, **1.1178** C30E (Ck30)	≤700		●
	1.0503 C45, **1.1191** C45E (Ck45)	≤850		●
	1.0601 C60, **1.1221** C60E (Ck60)	≤1000		●
合金热处理钢	**1.5131** 50MnSi4, **1.7003** 38Cr2, **1.7030** 28Cr4	≤1000		●
	1.5710 36NiCr6, **1.7035** 41Cr4, **1.7225** 42CrMo4	≤1400		●
非合金表面硬化钢	**1.0301** (C10), **1.1121** C10E (Ck10)	≤850		●
合金表面硬化钢	**1.7276** 10CrMo11, **1.5125** 11MnSi6	≤1000		●
	1.5752 15NiCr13, **1.7131** 16MnCr5, **1.7264** 20CrMo5	≤1400		●
氮化钢	**1.8504** 34CrAl6	≤1000		●
	1.8519 31CrMoV9, **1.8550** 34CrAlNi7	≤1400		●
工具钢	**1.1750** C75W, **1.2067** 102Cr6, **1.2307** 29CrMoV9	≤850		●
	1.2080 X210Cr12, **1.2083** X42Cr13, **1.2419** 105WCr6, **1.2767** X45NiCrMo4	≤1400		●
高速钢	**1.3243** S 6-5-2-5, **1.3343** S 6-5-2, **1.3344** S 6-5-3	≤1400		●
弹簧钢	**1.5026** 55Si7, **1.7176** 55Cr3, **1.8159** 51CrV4 (51CrV4)		≤350 HB	●
硬化钢	-		≤48 HRC	●
			≤66 HRC	●
不锈钢,硫化	**1.4005** X12CrS13, **1.4104** X14CrMoS17, **1.4105** X6CrMoS17, **1.4305** X8CrNiS18-9	≤900		●
奥氏体	**1.4301** X5CrNi18-10 (V2A), **1.4541** X6CrNiTi18-10, **1.4571** X6CrNiMoTi 17-12-2 (V4A)	≤1100		●
马氏体	**1.4057** X20CrNi172 (X17CrNi16-2), **1.4122** X39CrMo17-1, **1.4521** X2CrMoTi18-2	≤1500		●
铸铁	**0.6010** EN-GJL-100 (GG10), **0.6020** EN-GJL-200 (GG20)		≤240 HB	● ○
	0.6025 EN-GJL-250 (GG25), **0.6035** EN-GJL-350 (GG35)		≤350 HB	● ○
球墨铁铸和	**0.7050** EN-GJS-500-7 (GGG50), **0.8035** EN-GJMW-350-4 (GTW35)		≤240 HB	●
可锻铸铁	**0.7070** EN-GJS-700-2 (GGG70), **0.8170** EN-GJMB-700-2 (GTS70)		≤350 HB	●
冷激铸铁	-		≤350 HB	●
蠕墨铸铁 GGV	**EN-GJV250** (GGV25), **EN-GJV350** (GGV35)		≤220 HB	● ○
	EN-GJV400 (GGV40), **EN-GJV500** (GGV50), SiMo 6		≤300 HB	● ○
蠕墨铸铁 ADI	**EN-GJS-800-8** (ADI800), **EN-GJS-1000-5** (ADI1000)	≤1000		● ○
	EN-GJS-1200-2 (ADI1200), **EN-GJS-1400-1** (ADI1400)	≤1400		● ○
特殊合金	Nimonic, Inconel, Monel, Hastelloy	≤2000		●
钛及钛合金	**3.7024** Ti99,5, **3.7114** TiAl5Sn2,5, **3.7124** TiCu2	≤850		●
	3.7154 TiAl6Zr5, **3.7165** TiAl6V4, **3.7184** TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤1400		●
铝及铝合金	**3.0255** Al99,5, **3.2315** AlMgSi1, **3.3515** AlMg1	≤400		●
锻铝合金	**3.0615** AlMgSiPb, **3.1325** AlCuMg1, **3.3245** AlMg3Si, **3.4365** AlZnMgCu1,5	≤650		●
铸铝 ≤ 10 % Si	**3.2131** G-AlSi5Cu1, **3.2153** G-AlSi7Cu3, **3.2573** G-AlSi9	≤600		●
≤ 24 % Si	**3.2581** G-AlSi12, **3.2583** G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		●
镁合金	**3.5200** MgMn2, **3.5812.05** G-MgAl8Zn1, **3.5612.05** G-MgAl6Zn1	≤400		○
低合金铜	**2.0070** SE-Cu, **2.1020** CuSn6, **2.1096** G-CuSn5ZnPb	≤500		●
黄铜,短屑	**2.0380** CuZn39Pb2, **2.0401** CuZn39Pb3, **2.0410** CuZn43Pb2	≤600		●
长屑	**2.0250** CuZn20, **2.0280** CuZn33, **2.0332** CuZn37Pb0,5	≤600		●
青铜,短屑	**2.1090** CuSn7ZnPb, **2.1170** CuPb5Sn5, **2.1176** CuPb10Sn	≤600		● ●
	2.0790 CuNi18Zn19Pb	≤850		●
青铜,长屑	**2.0916** CuAl5, **2.0960** CuAl9Mn, **2.1050** CuSn10	≤850		●
	2.0980 CuAl11Ni, **2.1247** CuBe2	≤1000		●
热固塑料	环氧树脂, Resopal, Pertinax, Moltopren	≤150		○
热塑塑料	Plexiglas, Hostalen, Novodur, Makralon	≤100		● ○
Kevlar 合成纤维	Kevlar	≤1000		○
玻璃/碳纤维	GFK/CFK	≤1000		○

技术信息



≤3xD	≤3xD	≤3xD	≤3xD	≤3xD	≤4xD	≤5xD	≤5xD
10587	10590	10550	10578	10577	10708	10586	10589
VHM	VHM	VHM	VHM	VHM	VHM	VHM	VHM
DM	DM	AN	DM	DM	DM	DM	DM
AD 10 U	AD 10 U	AD 10 INOX	AD 10 H	AD 10 H	AD 15 G	AD 10 U	AD 10 U
外冷	内冷	内冷	外冷	内冷	内冷	外冷	内冷
06	10	20	46	48	33	08	12

v_c m/min	进给率代号	v_c m/min	进给率代号	v_c m/min	进给率代号	v_c m/min	进给率代号	v_c m/min	进给率代号	v_c m/min	进给率代号	v_c m/min	进给率代号	v_c m/min	进给率代号
130	7	145	7			130	7	145	7			130	7	145	7
110	6	120	6			110	6	120	6			110	6	120	6
145	8	170	8			145	8	170	8			145	8	170	8
110	7	145	8			110	7	145	8			110	7	145	8
120	7	130	8			120	7	130	8			120	7	130	8
110	7	125	7			110	7	125	7			110	7	125	7
105	7	120	7			105	7	120	7			105	7	120	7
105	7	120	7			105	7	120	7			105	7	120	7
100	6	105	7			100	6	105	7			100	6	105	7
130	8	145	8			130	8	145	8			130	8	145	8
120	7	120	7			120	7	120	7			120	7	120	7
85	5	85	5			85	5	85	5			85	5	85	5
100	6	110	7			100	6	110	7			100	6	110	7
90	5	105	5			90	5	105	5			90	5	105	5
65	6	80	6			65	6	80	6			65	6	80	6
55	5	65	5			55	5	65	5			55	5	65	5
		60	4			55	4	60	4					60	5
45	3	60	3			45	3	60	3			45	3	60	3
40	1	55	3			40	1	55	3			40	1	55	2
20	1	35	2			20	1	35	2			20	1	35	2
40	2	60	5	80	5	40	2					40	2	60	5
15	1	55	2	60	2–3	15	1					15	1	55	5
35	2	45	5	80	5	35	2					35	2	45	5
210	8	210	9							120	7	210	8	210	9
155	8	160	9							100	7	155	8	160	9
155	7	140	9							90	7	155	7	140	9
125	7	130	8							80	7	125	7	130	8
35	3	40	3							40	2	35	3	40	3
25	4	35	4	30	4	25	4	35	4			25	4	35	4
15	1	45	4	45	4	15	1	45	4			15	1	45	4
15	1	40	3	40	3	15	1	40	3			15	1	40	3
260	9	310	9							410	9	260	9	310	9
260	9	310	9							410	9	260	9	310	9
220	8	260	9							380	9	220	9	260	9
180	8	220	9							330	9	180	8	220	9
260	8	280	8									260	8	280	8
105	7	125	7									105	7	125	7
270	8	325	8							280	9	270	8	325	8
180	7	220	7									180	7	220	7
105	6	125	7							110	6	105	6	125	7
85	6	105	6							80	5	85	6	105	6
80	5	90	6									80	5	90	6
60	5	80	6									60	5	80	6

AD系列钻头的应用建议

货号:HA
刀具材质
表面处理
类型
内冷
页码

整体硬质合金钻头的一般提示
高性能机床，高精度刀柄，刀尖跳动偏差最大0.02mm，
高冷却压力，建议采用液压刀柄和热缩刀柄。

整体硬质合金钻头的冷却提示
我们建议使用乳化液或油进行冷却润滑。在特殊情况下可以
通过空气冷却，但并不推荐空冷。

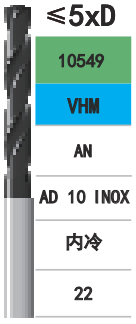
进给代号为粗体的刀具是首选项.

钻头直径 Ø mm	进给代号								
	1	2	3	4	5	6	7	8	9
	f(mm/圈)								
2, 50	0, 025	0, 032	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160
3, 15	0, 032	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 160
4, 00	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 200
5, 00	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250
6, 30	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315
8, 00	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 315
10, 00	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 400
12, 50	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500
16, 00	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500	0, 630
20, 00	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500	0, 630	0, 630
25, 00	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500	0, 630	0, 800	0, 800

冷却剂:
● 乳化液
● 切削油
○ 空气

材料组	材料例举,最新牌号(括弧内为旧牌号) 粗体数字=材料代号依据DIN EN	拉伸强度_ MPa (N/mm²)	硬度	冷却方式
普通结构钢	**1.0035** S185(St33), **1.0486** P275N(StE285), **1.0345** P235GH(H1), **1.0425** P265GH(H2)	≤500		●
	1.0050 E295 (St50-2), **1.0070** E360 (St70-2), **1.8937** P500NH (WStE500)	≤1000		●
易切削钢	**1.0718** 11SMnPb30 (9SMnPb28), **1.0736** 11SMn37 (9SMn36)	≤850		●
	1.0727 46S20 (45S20), **1.0728** (60S20), **1.0757** 46SPb20 (45SPb20)	≤1000		●
非合金热处理钢	**1.0402** C22, **1.1178** C30E (Ck30)	≤700		●
	1.0503 C45, **1.1191** C45E (Ck45)	≤850		●
	1.0601 C60, **1.1221** C60E (Ck60)	≤1000		●
合金热处理钢	**1.5131** 50MnSi4, **1.7003** 38Cr2, **1.7030** 28Cr4	≤1000		●
	1.5710 36NiCr6, **1.7035** 41Cr4, **1.7225** 42CrMo4	≤1400		●
非合金表面硬化钢	**1.0301** (C10), **1.1121** C10E (Ck10)	≤850		●
合金表面硬化钢	**1.7276** 10CrMo11, **1.5125** 11MnSi6	≤1000		●
	1.5752 15NiCr13, **1.7131** 16MnCr5, **1.7264** 20CrMo5	≤1400		●
氮化钢	**1.8504** 34CrAl6	≤1000		●
	1.8519 31CrMoV9, **1.8550** 34CrAlNi7	≤1400		●
工具钢	**1.1750** C75W, **1.2067** 102Cr6, **1.2307** 29CrMoV9	≤850		●
	1.2080 X210Cr12, **1.2083** X42Cr13, **1.2419** 105WCr6, **1.2767** X45NiCrMo4	≤1400		●
高速钢	**1.3243** S 6-5-2-5, **1.3343** S 6-5-2, **1.3344** S 6-5-3	≤1400		●
弹簧钢	**1.5026** 55Si7, **1.7176** 55Cr3, **1.8159** 51CrV4 (51CrV4)		≤350 HB	●
硬化钢	-		≤48 HRC	●
			≤66 HRC	●
不锈钢,硫化	**1.4005** X12CrS13, **1.4104** X14CrMoS17, **1.4105** X6CrMoS17, **1.4305** X8CrNiS18-9	≤900		●
奥氏体	**1.4301** X5CrNi18-10 (V2A), **1.4541** X6CrNiTi18-10, **1.4571** X6CrNiMoTi 17-12-2 (V4A)	≤1100		●
马氏体	**1.4057** X20CrNi172 (X17CrNi16-2), **1.4122** X39CrMo17-1, **1.4521** X2CrMoTi18-2	≤1500		●
铸铁	**0.6010** EN-GJL-100 (GG10), **0.6020** EN-GJL-200 (GG20)		≤240 HB	● ○
	0.6025 EN-GJL-250 (GG25), **0.6035** EN-GJL-350 (GG35)		≤350 HB	● ○
球墨铁铸和	**0.7050** EN-GJS-500-7 (GGG50), **0.8035** EN-GJMW-350-4 (GTW35)		≤240 HB	●
可锻铸铁	**0.7070** EN-GJS-700-2 (GGG70), **0.8170** EN-GJMB-700-2 (GTS70)		≤350 HB	●
冷激铸铁	-		≤350 HB	●
蠕墨铸铁 GGV	**EN-GJV250** (GGV25), **EN-GJV350** (GGV35)		≤220 HB	● ○
	EN-GJV400 (GGV40), **EN-GJV500** (GGV50), SiMo 6		≤300 HB	● ○
蠕墨铸铁 ADI	**EN-GJS-800-8** (ADI800), **EN-GJS-1000-5** (ADI1000)	≤1000		● ○
	EN-GJS-1200-2 (ADI1200), **EN-GJS-1400-1** (ADI1400)	≤1400		● ○
特殊合金	Nimonic, Inconel, Monel, Hastelloy	≤2000		●
钛及钛合金	**3.7024** Ti99,5, **3.7114** TiAl5Sn2,5, **3.7124** TiCu2	≤850		●
	3.7154 TiAl6Zr5, **3.7165** TiAl6V4, **3.7184** TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤1400		●
铝及铝合金	**3.0255** Al99,5, **3.2315** AlMgSi1, **3.3515** AlMg1	≤400		●
锻铝合金	**3.0615** AlMgSiPb, **3.1325** AlCuMg1, **3.3245** AlMg3Si, **3.4365** AlZnMgCu1,5	≤650		●
铸铝 ≤ 10 % Si	**3.2131** G-AlSi5Cu1, **3.2153** G-AlSi7Cu3, **3.2573** G-AlSi9	≤600		●
≤ 24 % Si	**3.2581** G-AlSi12, **3.2583** G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		●
镁合金	**3.5200** MgMn2, **3.5812.05** G-MgAl8Zn1, **3.5612.05** G-MgAl6Zn1	≤400		○
低合金铜	**2.0070** SE-Cu, **2.1020** CuSn6, **2.1096** G-CuSn5ZnPb	≤500		●
黄铜,短屑	**2.0380** CuZn39Pb2, **2.0401** CuZn39Pb3, **2.0410** CuZn43Pb2	≤600		●
长屑	**2.0250** CuZn20, **2.0280** CuZn33, **2.0332** CuZn37Pb0,5	≤600		●
青铜,短屑	**2.1090** CuSn7ZnPb, **2.1170** CuPb5Sn5, **2.1176** CuPb10Sn	≤600		● ●
	2.0790 CuNi18Zn19Pb	≤850		●
青铜,长屑	**2.0916** CuAl5, **2.0960** CuAl9Mn, **2.1050** CuSn10	≤850		●
	2.0980 CuAl11Ni, **2.1247** CuBe2	≤1000		●
热固塑料	环氧树脂, Resopal, Pertinax, Moltopren	≤150		○
热塑塑料	Plexiglas, Hostalen, Novodur, Makralon	≤100		● ○
Kevlar 合成纤维	Kevlar	≤1000		○
玻璃/碳纤维	GFK/CFK	≤1000		○

技术信息



≤5xD

10549

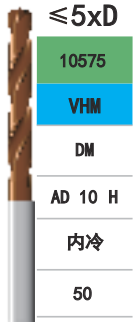
VHM

AN

AD 10 INOX

内冷

22



≤5xD

10575

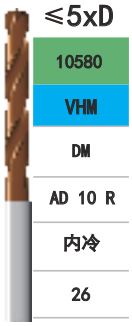
VHM

DM

AD 10 H

内冷

50



≤5xD

10580

VHM

DM

AD 10 R

内冷

26



≤5xD

10440

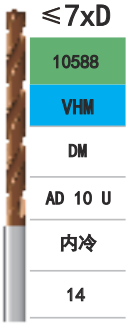
VHM

无

AD 10 ALU

内冷

38



≤7xD

10588

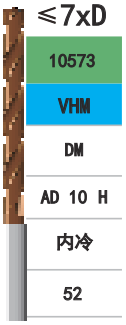
VHM

DM

AD 10 U

内冷

14



≤7xD

10573

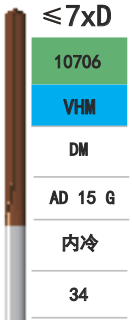
VHM

DM

AD 10 H

内冷

52



≤7xD

10706

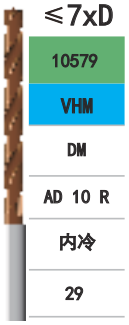
VHM

DM

AD 15 G

内冷

34



≤7xD

10579

VHM

DM

AD 10 R

内冷

29

v_c m/min	进给率代号
80	5
60	2-3
80	5
30	4
45	4
40	3

AD系列钻头的应用建议

货号:HA
刀具材质
表面处理
类型
内冷
页码

整体硬质合金钻头的一般提示
高性能机床，高精度刀柄，刀尖跳动偏差最大0.02mm，
高冷却压力，建议采用液压刀柄和热缩刀柄。

整体硬质合金钻头的冷却提示
我们建议使用乳化液或油进行冷却润滑。在特殊情况下可以
通过空气冷却，但并不推荐空冷。

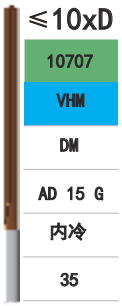
进给代号为粗体的刀具是首选项.

钻头直径 Ø mm	进给代号								
	1	2	3	4	5	6	7	8	9
	f(mm/圈)								
2, 50	0, 025	0, 032	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160
3, 15	0, 032	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 160
4, 00	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 200
5, 00	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250
6, 30	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315
8, 00	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 315
10, 00	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 400
12, 50	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500
16, 00	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500	0, 630
20, 00	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500	0, 630	0, 630
25, 00	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500	0, 630	0, 800	0, 800

冷却剂:
● 乳化液
● 切削油
○ 空气

材料组	材料例举,最新牌号(括弧内为旧牌号) 粗体数字=材料代号依据DIN EN	拉伸强度_ MPa (N/mm²)	硬度	冷却方式
普通结构钢	**1.0035** S185(St33), **1.0486** P275N(StE285), **1.0345** P235GH(H1), **1.0425** P265GH(H2)	≤500		●
	1.0050 E295 (St50-2), **1.0070** E360 (St70-2), **1.8937** P500NH (WStE500)	≤1000		●
易切削钢	**1.0718** 11SMnPb30 (9SMnPb28), **1.0736** 11SMn37 (9SMn36)	≤850		●
	1.0727 46S20 (45S20), **1.0728** (60S20), **1.0757** 46SPb20 (45SPb20)	≤1000		●
非合金热处理钢	**1.0402** C22, **1.1178** C30E (Ck30)	≤700		●
	1.0503 C45, **1.1191** C45E (Ck45)	≤850		●
	1.0601 C60, **1.1221** C60E (Ck60)	≤1000		●
合金热处理钢	**1.5131** 50MnSi4, **1.7003** 38Cr2, **1.7030** 28Cr4	≤1000		●
	1.5710 36NiCr6, **1.7035** 41Cr4, **1.7225** 42CrMo4	≤1400		●
非合金表面硬化钢	**1.0301** (C10), **1.1121** C10E (Ck10)	≤850		●
合金表面硬化钢	**1.7276** 10CrMo11, **1.5125** 11MnSi6	≤1000		●
	1.5752 15NiCr13, **1.7131** 16MnCr5, **1.7264** 20CrMo5	≤1400		●
氮化钢	**1.8504** 34CrAl6	≤1000		●
	1.8519 31CrMoV9, **1.8550** 34CrAlNi7	≤1400		●
工具钢	**1.1750** C75W, **1.2067** 102Cr6, **1.2307** 29CrMoV9	≤850		●
	1.2080 X210Cr12, **1.2083** X42Cr13, **1.2419** 105WCr6, **1.2767** X45NiCrMo4	≤1400		●
高速钢	**1.3243** S 6-5-2-5, **1.3343** S 6-5-2, **1.3344** S 6-5-3	≤1400		●
弹簧钢	**1.5026** 55Si7, **1.7176** 55Cr3, **1.8159** 51CrV4 (51CrV4)		≤350 HB	●
硬化钢	-		≤48 HRC	●
			≤66 HRC	●
不锈钢,硫化	**1.4005** X12CrS13, **1.4104** X14CrMoS17, **1.4105** X6CrMoS17, **1.4305** X8CrNiS18-9	≤900		●
奥氏体	**1.4301** X5CrNi18-10 (V2A), **1.4541** X6CrNiTi18-10, **1.4571** X6CrNiMoTi 17-12-2 (V4A)	≤1100		●
马氏体	**1.4057** X20CrNi172 (X17CrNi16-2), **1.4122** X39CrMo17-1, **1.4521** X2CrMoTi18-2	≤1500		●
铸铁	**0.6010** EN-GJL-100 (GG10), **0.6020** EN-GJL-200 (GG20)		≤240 HB	● ○
	0.6025 EN-GJL-250 (GG25), **0.6035** EN-GJL-350 (GG35)		≤350 HB	● ○
球墨铁铸和	**0.7050** EN-GJS-500-7 (GGG50), **0.8035** EN-GJMW-350-4 (GTW35)		≤240 HB	●
可锻铸铁	**0.7070** EN-GJS-700-2 (GGG70), **0.8170** EN-GJMB-700-2 (GTS70)		≤350 HB	●
冷激铸铁	-		≤350 HB	●
蠕墨铸铁 GGV	**EN-GJV250** (GGV25), **EN-GJV350** (GGV35)		≤220 HB	● ○
	EN-GJV400 (GGV40), **EN-GJV500** (GGV50), SiMo 6		≤300 HB	● ○
蠕墨铸铁 ADI	**EN-GJS-800-8** (ADI800), **EN-GJS-1000-5** (ADI1000)	≤1000		● ○
	EN-GJS-1200-2 (ADI1200), **EN-GJS-1400-1** (ADI1400)	≤1400		● ○
特殊合金	Nimonic, Inconel, Monel, Hastelloy	≤2000		●
钛及钛合金	**3.7024** Ti99, 5, **3.7114** TiAl5Sn2, 5, **3.7124** TiCu2	≤850		●
	3.7154 TiAl6Zr5, **3.7165** TiAl6V4, **3.7184** TiAl4Mo4Sn2, 5, - TiAl8Mo1V1	≤1400		●
铝及铝合金	**3.0255** Al99, 5, **3.2315** AlMgSi1, **3.3515** AlMg1	≤400		●
锻铝合金	**3.0615** AlMgSiPb, **3.1325** AlCuMg1, **3.3245** AlMg3Si, **3.4365** AlZnMgCu1, 5	≤650		●
铸铝 ≤ 10 % Si	**3.2131** G-AlSi5Cu1, **3.2153** G-AlSi7Cu3, **3.2573** G-AlSi9	≤600		●
≤ 24 % Si	**3.2581** G-AlSi12, **3.2583** G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		●
镁合金	**3.5200** MgMn2, **3.5812.05** G-MgAl8Zn1, **3.5612.05** G-MgAl6Zn1	≤400		○
低合金铜	**2.0070** SE-Cu, **2.1020** CuSn6, **2.1096** G-CuSn5ZnPb	≤500		●
黄铜,短屑	**2.0380** CuZn39Pb2, **2.0401** CuZn39Pb3, **2.0410** CuZn43Pb2	≤600		●
长屑	**2.0250** CuZn20, **2.0280** CuZn33, **2.0332** CuZn37Pb0, 5	≤600		●
青铜,短屑	**2.1090** CuSn7ZnPb, **2.1170** CuPb5Sn5, **2.1176** CuPb10Sn	≤600		● ●
	2.0790 CuNi18Zn19Pb	≤850		●
青铜,长屑	**2.0916** CuAl5, **2.0960** CuAl9Mn, **2.1050** CuSn10	≤850		●
	2.0980 CuAl11Ni, **2.1247** CuBe2	≤1000		●
热固塑料	环氧树脂, Resopal, Pertinax, Moltopren	≤150		○
热塑塑料	Plexiglas, Hostalen, Novodur, Makralon	≤100		● ○
Kevlar 合成纤维	Kevlar	≤1000		○
玻璃/碳纤维	GFK/CFK	≤1000		○

技术信息



v_c m/min	进给率代号
120	6
100	6
90	6
80	6
40	2
410	8
410	8
380	8
330	8
280	7
110	6
80	5



v_c m/min	进给率代号
120	6
100	6
90	6
80	6
40	2
410	6
410	6
380	6
330	6
280	7
110	6
80	5



v_c m/min	进给率代号
110	6
110	5
110	7
100	7
110	7
110	6
100	6
110	6
105	6
110	7
110	6
85	4
100	6
80	4
80	5
65	4
50	4
50	2
60	4
55	2
45	4
120	8
120	8
100	8
90	7
150	8
150	8
150	8
120	8
150	7
80	6
120	7
120	6
40	6
40	5

AD系列钻头的应用建议

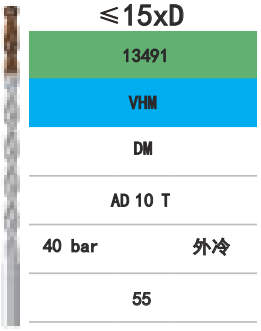
货号:HA
刀具材质
表面处理
类型
内冷
页码

步骤
- 在工件表面铣一个平面,确保正确的钻孔角度。
- 钻深1xD引导孔(公差F9)
- 以大约300转/分钟的速度和500毫米/分钟的进给进入引导孔 • 打开冷却液同时转速提到至设定值。
- 一次性加工至预定深度,不要啄钻
- 加工出口为斜面的通孔,钻穿前1mm处将进给Vf降低至40%
- 到达孔深,机床主轴停转,冷却液停供,快速退回

钻头直径 Ø mm	进给代号								
	1	2	3	4	5	6	7	8	9
	f(mm/圈)								
2, 50	0, 025	0, 032	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160
3, 15	0, 032	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 160
4, 00	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 200
5, 00	0, 040	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250
6, 30	0, 050	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315
8, 00	0, 063	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 315
10, 00	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 400
12, 50	0, 080	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500
16, 00	0, 100	0, 125	0, 160	0, 200	0, 250	0, 315	0, 400	0, 500	0, 630

冷却剂:
- ● 乳化液
- ● 切削油
- ○ 空气

材料组	材料例举,最新牌号(括弧内为旧牌号) 粗体数字=材料代号依据DIN EN	拉伸强度_ MPa (N/mm²)	硬度	冷却方式
普通结构钢	**1.0035** S185(St33), **1.0486** P275N(StE285), **1.0345** P235GH(H1), **1.0425** P265GH(H2)	≤500		●
	1.0050 E295 (St50-2), **1.0070** E360 (St70-2), **1.8937** P500NH (WStE500)	≤1000		●
易切削钢	**1.0718** 11SMnPb30 (9SMnPb28), **1.0736** 11SMn37 (9SMn36)	≤850		●
	1.0727 46S20 (45S20), **1.0728** (60S20), **1.0757** 46SPb20 (45SPb20)	≤1000		●
非合金热处理钢	**1.0402** C22, **1.1178** C30E (Ck30)	≤700		●
	1.0503 C45, **1.1191** C45E (Ck45)	≤850		●
	1.0601 C60, **1.1221** C60E (Ck60)	≤1000		●
合金热处理钢	**1.5131** 50MnSi4, **1.7003** 38Cr2, **1.7030** 28Cr4	≤1000		●
	1.5710 36NiCr6, **1.7035** 41Cr4, **1.7225** 42CrMo4	≤1400		●
非合金表面硬化钢	**1.0301** (C10), **1.1121** C10E (Ck10)	≤850		●
合金表面硬化钢	**1.7276** 10CrMo11, **1.5125** 11MnSi6	≤1000		●
	1.5752 15NiCr13, **1.7131** 16MnCr5, **1.7264** 20CrMo5	≤1400		●
氮化钢	**1.8504** 34CrAl6	≤1000		●
	1.8519 31CrMoV9, **1.8550** 34CrAlNi7	≤1400		●
工具钢	**1.1750** C75W, **1.2067** 102Cr6, **1.2307** 29CrMoV9	≤850		●
	1.2080 X210Cr12, **1.2083** X42Cr13, **1.2419** 105WCr6, **1.2767** X45NiCrMo4	≤1400		●
高速钢	**1.3243** S 6-5-2-5, **1.3343** S 6-5-2, **1.3344** S 6-5-3	≤1400		●
弹簧钢	**1.5026** 55Si7, **1.7176** 55Cr3, **1.8159** 51CrV4 (51CrV4)		≤350 HB	●
硬化钢	-		≤48 HRC	●
			≤66 HRC	●
不锈钢,硫化	**1.4005** X12CrS13, **1.4104** X14CrMoS17, **1.4105** X6CrMoS17, **1.4305** X8CrNiS18-9	≤900		●
奥氏体	**1.4301** X5CrNi18-10 (V2A), **1.4541** X6CrNiTi18-10, **1.4571** X6CrNiMoTi 17-12-2 (V4A)	≤1100		●
马氏体	**1.4057** X20CrNi172 (X17CrNi16-2), **1.4122** X39CrMo17-1, **1.4521** X2CrMoTi18-2	≤1500		●
铸铁	**0.6010** EN-GJL-100 (GG10), **0.6020** EN-GJL-200 (GG20)		≤240 HB	○ ○
	0.6025 EN-GJL-250 (GG25), **0.6035** EN-GJL-350 (GG35)		≤350 HB	○ ○
球墨铁铸和	**0.7050** EN-GJS-500-7 (GGG50), **0.8035** EN-GJMW-350-4 (GTW35)		≤240 HB	●
可锻铸铁	**0.7070** EN-GJS-700-2 (GGG70), **0.8170** EN-GJMB-700-2 (GTS70)		≤350 HB	●
冷激铸铁	-		≤350 HB	●
蠕墨铸铁 GGV	**EN-GJV250** (GGV25), **EN-GJV350** (GGV35)		≤220 HB	○ ○
	EN-GJV400 (GGV40), **EN-GJV500** (GGV50), SiMo 6		≤300 HB	○ ○
蠕墨铸铁 ADI	**EN-GJS-800-8** (ADI800), **EN-GJS-1000-5** (ADI1000)	≤1000		○ ○
	EN-GJS-1200-2 (ADI1200), **EN-GJS-1400-1** (ADI1400)	≤1400		○ ○
特殊合金	Nimonic, Inconel, Monel, Hastelloy	≤2000		●
钛及钛合金	**3.7024** Ti99,5, **3.7114** TiAl5Sn2,5, **3.7124** TiCu2	≤850		●
	3.7154 TiAl6Zr5, **3.7165** TiAl6V4, **3.7184** TiAl4Mo4Sn2,5, - TiAl8Mo1V1	≤1400		●
铝及铝合金	**3.0255** Al99,5, **3.2315** AlMgSi1, **3.3515** AlMg1	≤400		●
锻铝合金	**3.0615** AlMgSiPb, **3.1325** AlCuMg1, **3.3245** AlMg3Si, **3.4365** AlZnMgCu1,5	≤650		●
铸铝 ≤ 10 % Si	**3.2131** G-AlSi5Cu1, **3.2153** G-AlSi7Cu3, **3.2573** G-AlSi9	≤600		●
≤ 24 % Si	**3.2581** G-AlSi12, **3.2583** G-AlSi12Cu, - G-AlSi12CuNiMg	≤600		●
镁合金	**3.5200** MgMn2, **3.5812.05** G-MgAl8Zn1, **3.5612.05** G-MgAl6Zn1	≤400		○
低合金铜	**2.0070** SE-Cu, **2.1020** CuSn6, **2.1096** G-CuSn5ZnPb	≤500		●
黄铜,短屑	**2.0380** CuZn39Pb2, **2.0401** CuZn39Pb3, **2.0410** CuZn43Pb2	≤600		●
长屑	**2.0250** CuZn20, **2.0280** CuZn33, **2.0332** CuZn37Pb0,5	≤600		●
青铜,短屑	**2.1090** CuSn7ZnPb, **2.1170** CuPb5Sn5, **2.1176** CuPb10Sn	≤600		● ●
	2.0790 CuNi18Zn19Pb	≤850		●
青铜,长屑	**2.0916** CuAl5, **2.0960** CuAl9Mn, **2.1050** CuSn10	≤850		●
	2.0980 CuAl11Ni, **2.1247** CuBe2	≤1000		●
热固塑料	环氧树脂, Resopal, Pertinax, Moltopren	≤150		○
热塑塑料	Plexiglas, Hostalen, Novodur, Makralon	≤100		● ○
Kevlar 合成纤维	Kevlar	≤1000		○
玻璃/碳纤维	GFK/CFK	≤1000		○



≤15xD

13491

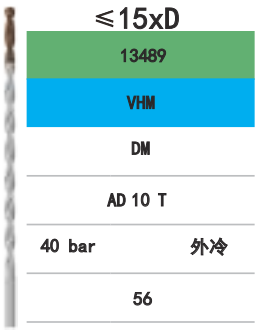
VHM

DM

AD 10 T

40 bar 外冷

55



≤15xD

13489

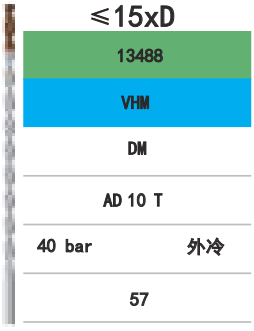
VHM

DM

AD 10 T

40 bar 外冷

56



≤15xD

13488

VHM

DM

AD 10 T

40 bar 外冷

57

v_c m/min	进给率代号	v_c m/min	进给率代号
110	8		
110	8		
120	8		
120	8		
110	6		
110	8		
100	7		
110	7	80	7
110	6	80	7
110	8		
110	7	80	6–7
110	6	80	6–7
100	5		
80	5		
100	6–7		
80	5		
50	5		
50	5		
50	4		
100	5		
70	2–3		
100	5		
140	8		
100	8		
140	8		
100	8		
100	6		
100	6		
90	8	90	8
30	2		
120	1		
120	8		

v_c m/min	进给率代号	v_c m/min	进给率代号
110	8		
110	8		
120	8		
120	8		
110	6		
110	8		
100	7		
110	7	80	7
110	6	80	7
110	8		
110	7	80	6–7
110	6	80	6–7
100	5		
80	5		
100	6		
80	5		
50	5		
50	5		
50	4		
100	5		
60	3		
100	5		
140	8		
100	8		
140	8		
100	8		
100	6		
100	6		
90	8	90	8
30	2		
120	1		
120	8		

v_c m/min	进给率代号	v_c m/min	进给率代号
100	8		
100	8		
120	8		
100	8		
110	6		
100	8		
100	7		
100	7	70	7
100	6	70	7
100	8		
100	7	70	6–7
100	6	70	6–7
80	5		
60	5		
90	6		
70	4		
50	4		
50	4		
50	4		
100	5		
60	3		
100	5		
130	8		
90	8		
130	8		
90	8		
90	6		
90	6		
80	8	80	8
30	2		
120	1		
110	8		

技术信息

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ANBIT Precision Tools (Nanjing) Co., Ltd

AD系列钻头产品



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