

PRODUCT NEWS

No. 545

シリーズ拡張
SERIES EXPANSION

 **DIJET**[®]

NEW

超硬コーティングドリル

EZシリーズ

ストライクドリル

EZ series

Coated carbide drill "STRIKE DRILL"

EZN形 EZN type

■クーラント穴無し: 2Dタイプ(φ1~φ14)・4Dタイプ(φ3~φ14)

■クーラント穴付き: 3Dタイプ(φ3~φ16)・5Dタイプ(φ3~φ16)・8Dタイプ(φ3~φ14)

EZT形 EZT type

■クーラント穴無し: 3Dタイプ(φ2.78~φ5.55)

■クーラント穴付き: 4Dタイプ(φ3.68~φ5.55)



ダイジェット工業株式会社

特長

Feature of product



多様な被削材にど真ん中ストレートの穴をあける ストライクドリル

STRIKE DRILL make a straight hole in the middle of various materials

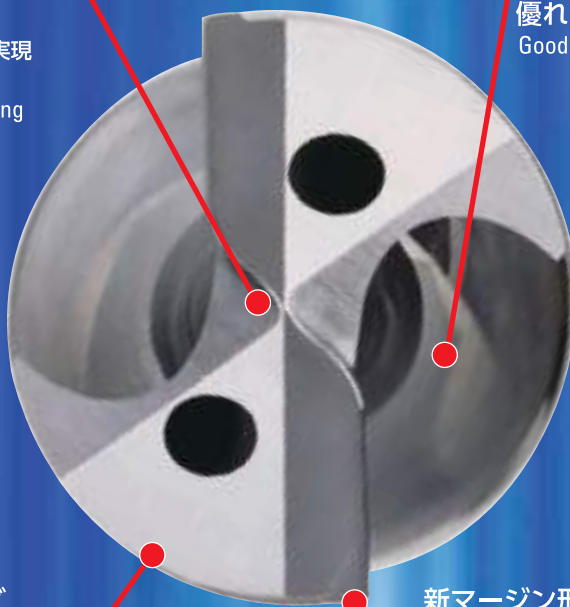


新シンニング形状 (特許出願中)
NEW Thinning shape (Patent pending)

低スラスト力で
良好な食いつきを実現
Because of low thrust,
achieved excellent biting
property

溝平滑処理
Smoothing process for flute

優れた切りくず排出性
Good chip discharge performance



DV コーティング
DV coating

微粒子超硬母材と
耐酸化性に優れたバリューコート採用
Adopted micro-grain carbide
and DV coating which is
good for oxidation resistant

新マージン形状
New margin shape

切削熱・切削抵抗の低減により
摩耗の抑制、加工面精度の向上
By reducing cutting force and cutting heat,
attaining excellent surface roughness

ラインナップ

Line up

クーラント穴無し Without coolant hole



2Dタイプ 2D type
4Dタイプ 4D type

クーラント穴付き With coolant hole



3Dタイプ 3D type
5Dタイプ 5D type
8Dタイプ 8D type

※5D・8Dは剛性重視のダブルマージン仕様
5D・8D type improved drill rigidity because of
adopted double margin

VIDEO



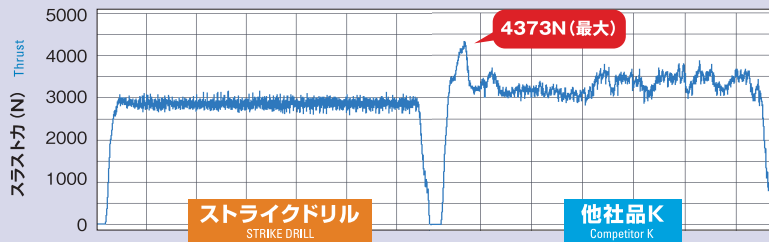
切削性能

Cutting performance

ステンレス鋼に対する切削性能比較 (φ10) Cutting performance comparison (Stainless steel)

- 低スラスト力で食いつきから加工穴底部まで安定した穴あけ加工が可能
Because of low thrust, it achieved excellent biting property and stable drilling

被削材: **SUS304** Material
 ● 工具形番: EZN3DCH1000S10 Cat.No.
 ● 工具径: φ10 Tool dia.
 ● 切削条件: $V_c=60\text{m/min}$, $f=0.30\text{mm/rev}$ Cutting conditions
 ● 穴あけ深さ: 30mm (止まり穴) Drilling depth (Blind hole)
 ● 突き出し量: 60mm Over hung length
 ● 水溶性切削油 (内部) Wet (internal)



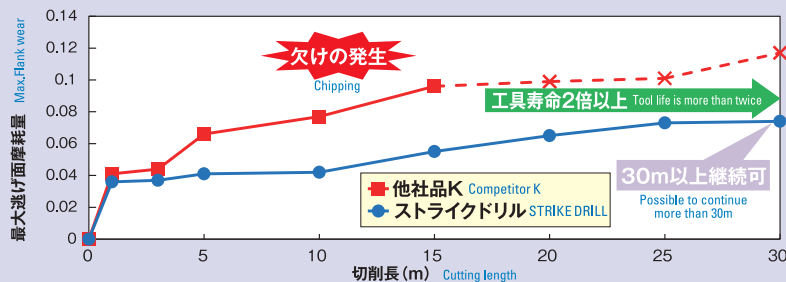
- 新マージン形状により、切削抵抗と切削熱を抑制し、優れた加工面精度を実現
By reducing cutting force and cutting heat, attaining excellent surface roughness



ステンレス鋼加工での工具寿命 (φ10) Tool life comparison (Stainless steel)

- ストライクドリルは、他社品に対し、2倍以上の寿命を達成
STRIKE DRILL achieved more than 2 times longer tool life compared with competitor K

被削材: **SUS316L** Material
 ● 工具形番: EZN3DCH1000S10 Cat.No.
 ● 工具径: φ10 Tool dia.
 ● 切削条件: $V_c=60\text{m/min}$, $f=0.28\text{mm/rev}$ Cutting conditions
 ● 穴あけ深さ: 22mm (貫通穴) Drilling depth (Through hole)
 ● 突き出し量: 60mm Over hung length
 ● 水溶性切削油 (内部) Wet (internal)



- 低速から高速加工領域まで良好な切りくずが排出できる
Favorable chip shape from high speed machining to low speed machining



製品概要

Line up

ストライクドリル EZN2D形(2Dタイプ) EZN2D type



- 高精度ソリッドドリル High accuracy solid drill
- 有効加工穴深さ2×Dc Drilling depth 2×Dc
- ねじれ角30° Helix angle :30°
- クーラント穴無し Without coolant hole



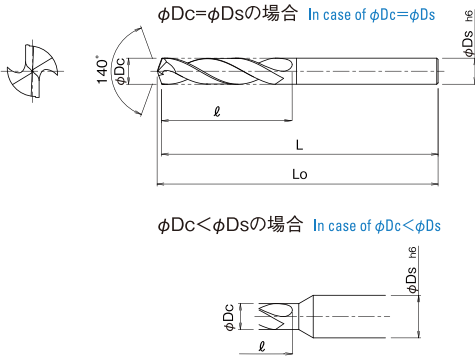
| 形番 Cat. No. | 在庫 Stock | 寸法(mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------|-------------|-------------------|----|----|------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN2D0100S03 | ● | 1.0 | 4 | 49 | 49.2 | 3 | 4,610 |
| EZN2D0110S03 | ● | 1.1 | 5 | 49 | 49.2 | 3 | 4,610 |
| EZN2D0120S03 | ● | 1.2 | 5 | 49 | 49.2 | 3 | 4,610 |
| EZN2D0130S03 | ● | 1.3 | 6 | 49 | 49.2 | 3 | 4,610 |
| EZN2D0140S03 | ● | 1.4 | 6 | 49 | 49.3 | 3 | 4,610 |
| EZN2D0150S03 | ● | 1.5 | 6 | 49 | 49.3 | 3 | 4,610 |
| EZN2D0160S03 | ● | 1.6 | 7 | 49 | 49.3 | 3 | 4,610 |
| EZN2D0170S03 | ● | 1.7 | 7 | 49 | 49.3 | 3 | 4,610 |
| EZN2D0180S03 | ● | 1.8 | 8 | 49 | 49.3 | 3 | 4,610 |
| EZN2D0190S03 | ● | 1.9 | 8 | 49 | 49.3 | 3 | 4,610 |
| EZN2D0200S03 | ● | 2.0 | 8 | 49 | 49.4 | 3 | 4,610 |
| EZN2D0210S03 | ● | 2.1 | 9 | 49 | 49.4 | 3 | 4,610 |
| EZN2D0220S03 | ● | 2.2 | 9 | 49 | 49.4 | 3 | 4,610 |
| EZN2D0230S03 | ● | 2.3 | 10 | 49 | 49.4 | 3 | 4,610 |
| EZN2D0240S03 | ● | 2.4 | 10 | 49 | 49.4 | 3 | 4,610 |
| EZN2D0250S03 | ● | 2.5 | 10 | 49 | 49.5 | 3 | 4,610 |
| EZN2D0260S03 | ● | 2.6 | 11 | 49 | 49.5 | 3 | 4,610 |
| EZN2D0270S03 | ● | 2.7 | 11 | 49 | 49.5 | 3 | 4,610 |
| EZN2D0280S03 | ● | 2.8 | 12 | 49 | 49.5 | 3 | 4,610 |
| EZN2D0290S03 | ● | 2.9 | 12 | 49 | 49.5 | 3 | 4,610 |
| EZN2D0300S04 | ● | 3.0 | 13 | 49 | 49.5 | 4 | 4,610 |
| EZN2D0310S04 | ● | 3.1 | 15 | 49 | 49.6 | 4 | 4,980 |
| EZN2D0320S04 | ● | 3.2 | 15 | 49 | 49.6 | 4 | 4,980 |
| EZN2D0330S04 | ● | 3.3 | 15 | 49 | 49.6 | 4 | 4,980 |
| EZN2D0340S04 | ● | 3.4 | 15 | 49 | 49.6 | 4 | 4,980 |
| EZN2D0350S04 | ● | 3.5 | 15 | 49 | 49.6 | 4 | 4,980 |
| EZN2D0360S04 | ● | 3.6 | 17 | 49 | 49.7 | 4 | 5,190 |
| EZN2D0370S04 | ● | 3.7 | 17 | 49 | 49.7 | 4 | 5,190 |
| EZN2D0380S04 | ● | 3.8 | 17 | 49 | 49.7 | 4 | 5,190 |
| EZN2D0390S04 | ● | 3.9 | 17 | 49 | 49.7 | 4 | 5,190 |
| EZN2D0400S04 | ● | 4.0 | 17 | 49 | 49.7 | 4 | 5,190 |
| EZN2D0410S06 | ● | 4.1 | 19 | 64 | 64.7 | 6 | 5,610 |
| EZN2D0420S06 | ● | 4.2 | 19 | 64 | 64.8 | 6 | 5,610 |

| 形番 Cat. No. | 在庫 Stock | 寸法(mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------|-------------|-------------------|----|----|------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN2D0430S06 | ● | 4.3 | 19 | 64 | 64.8 | 6 | 5,610 |
| EZN2D0440S06 | ● | 4.4 | 19 | 64 | 64.8 | 6 | 5,610 |
| EZN2D0450S06 | ● | 4.5 | 19 | 64 | 64.8 | 6 | 5,610 |
| EZN2D0460S06 | ● | 4.6 | 21 | 64 | 64.8 | 6 | 5,990 |
| EZN2D0470S06 | ● | 4.7 | 21 | 64 | 64.9 | 6 | 5,990 |
| EZN2D0480S06 | ● | 4.8 | 21 | 64 | 64.9 | 6 | 5,990 |
| EZN2D0490S06 | ● | 4.9 | 21 | 64 | 64.9 | 6 | 5,990 |
| EZN2D0500S06 | ● | 5.0 | 21 | 64 | 64.9 | 6 | 5,990 |
| EZN2D0510S06 | ● | 5.1 | 23 | 68 | 68.9 | 6 | 6,340 |
| EZN2D0520S06 | ● | 5.2 | 23 | 68 | 68.9 | 6 | 6,340 |
| EZN2D0530S06 | ● | 5.3 | 23 | 68 | 69.0 | 6 | 6,340 |
| EZN2D0540S06 | ● | 5.4 | 23 | 68 | 69.0 | 6 | 6,340 |
| EZN2D0550S06 | ● | 5.5 | 23 | 68 | 69.0 | 6 | 6,340 |
| EZN2D0560S06 | ● | 5.6 | 25 | 68 | 69.0 | 6 | 6,640 |
| EZN2D0570S06 | ● | 5.7 | 25 | 68 | 69.0 | 6 | 6,640 |
| EZN2D0580S06 | ● | 5.8 | 25 | 68 | 69.1 | 6 | 6,640 |
| EZN2D0590S06 | ● | 5.9 | 25 | 68 | 69.1 | 6 | 6,640 |
| EZN2D0600S06 | ● | 6.0 | 25 | 68 | 69.1 | 6 | 6,640 |
| EZN2D0610S08 | ● | 6.1 | 27 | 73 | 74.1 | 8 | 6,640 |
| EZN2D0620S08 | ● | 6.2 | 27 | 73 | 74.1 | 8 | 6,640 |
| EZN2D0630S08 | ● | 6.3 | 27 | 73 | 74.1 | 8 | 6,640 |
| EZN2D0640S08 | ● | 6.4 | 27 | 73 | 74.2 | 8 | 6,640 |
| EZN2D0650S08 | ● | 6.5 | 27 | 73 | 74.2 | 8 | 6,640 |
| EZN2D0660S08 | ● | 6.6 | 28 | 73 | 74.2 | 8 | 7,040 |
| EZN2D0670S08 | ● | 6.7 | 28 | 73 | 74.2 | 8 | 7,040 |
| EZN2D0680S08 | ● | 6.8 | 28 | 73 | 74.2 | 8 | 7,040 |
| EZN2D0690S08 | ● | 6.9 | 28 | 73 | 74.3 | 8 | 7,040 |
| EZN2D0700S08 | ● | 7.0 | 28 | 73 | 74.3 | 8 | 7,040 |
| EZN2D0710S08 | ● | 7.1 | 30 | 73 | 74.3 | 8 | 7,460 |
| EZN2D0720S08 | ● | 7.2 | 30 | 73 | 74.3 | 8 | 7,460 |
| EZN2D0730S08 | ● | 7.3 | 30 | 73 | 74.3 | 8 | 7,460 |
| EZN2D0740S08 | ● | 7.4 | 30 | 73 | 74.3 | 8 | 7,460 |
| EZN2D0750S08 | ● | 7.5 | 30 | 73 | 74.4 | 8 | 7,460 |

●：メーカー在庫品 Standard stock items

◎：近日在庫品(2023年1月発売予定) Soon be stocked (Scheduled to released in January 2023)

標準価格は2022年11月時点の価格となります。
標準切削条件は17~18ページをご参照ください。



●直径寸法許容差(mm)
Tolerance for φDc

| 直径φDc Tool dia. | 許容差 Tolerance |
|----------------------------|------------------|
| 3以下 Up to 3 | 0 -0.014 |
| 3をこえ6以下 Over 3 Up to 6 | 0 -0.018 |
| 6をこえ10以下 Over 6 Up to 10 | 0 -0.022 |
| 10をこえ14以下 Over 10 Up to 14 | 0 -0.027 |

| 形番 Cat. No. | 在庫 Stock | 寸法(mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------|-------------|-------------------|----|----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN2D0760S08 | ● | 7.6 | 32 | 73 | 74.4 | 8 | 7,850 |
| EZN2D0770S08 | ● | 7.7 | 32 | 73 | 74.4 | 8 | 7,850 |
| EZN2D0780S08 | ● | 7.8 | 32 | 73 | 74.4 | 8 | 7,850 |
| EZN2D0790S08 | ● | 7.9 | 32 | 73 | 74.4 | 8 | 7,850 |
| EZN2D0800S08 | ● | 8.0 | 32 | 73 | 74.5 | 8 | 7,850 |
| EZN2D0810S10 | ● | 8.1 | 34 | 78 | 79.5 | 10 | 8,310 |
| EZN2D0820S10 | ● | 8.2 | 34 | 78 | 79.5 | 10 | 8,310 |
| EZN2D0830S10 | ● | 8.3 | 34 | 78 | 79.5 | 10 | 8,310 |
| EZN2D0840S10 | ● | 8.4 | 34 | 78 | 79.5 | 10 | 8,310 |
| EZN2D0850S10 | ● | 8.5 | 34 | 78 | 79.5 | 10 | 8,310 |
| EZN2D0860S10 | ● | 8.6 | 36 | 78 | 79.6 | 10 | 8,690 |
| EZN2D0870S10 | ● | 8.7 | 36 | 78 | 79.6 | 10 | 8,690 |
| EZN2D0880S10 | ● | 8.8 | 36 | 78 | 79.6 | 10 | 8,690 |
| EZN2D0890S10 | ● | 8.9 | 36 | 78 | 79.6 | 10 | 8,690 |
| EZN2D0900S10 | ● | 9.0 | 36 | 78 | 79.6 | 10 | 8,690 |
| EZN2D0910S10 | ● | 9.1 | 38 | 88 | 89.7 | 10 | 9,150 |
| EZN2D0920S10 | ● | 9.2 | 38 | 88 | 89.7 | 10 | 9,150 |
| EZN2D0930S10 | ● | 9.3 | 38 | 88 | 89.7 | 10 | 9,150 |
| EZN2D0940S10 | ● | 9.4 | 38 | 88 | 89.7 | 10 | 9,150 |
| EZN2D0950S10 | ● | 9.5 | 38 | 88 | 89.7 | 10 | 9,150 |
| EZN2D0960S10 | ● | 9.6 | 40 | 88 | 89.7 | 10 | 9,530 |
| EZN2D0970S10 | ● | 9.7 | 40 | 88 | 89.8 | 10 | 9,530 |
| EZN2D0980S10 | ● | 9.8 | 40 | 88 | 89.8 | 10 | 9,530 |
| EZN2D0990S10 | ● | 9.9 | 40 | 88 | 89.8 | 10 | 9,530 |
| EZN2D1000S10 | ● | 10.0 | 40 | 88 | 89.8 | 10 | 9,530 |
| EZN2D1010S12 | ● | 10.1 | 42 | 98 | 99.8 | 12 | 10,000 |
| EZN2D1020S12 | ● | 10.2 | 42 | 98 | 99.9 | 12 | 10,000 |
| EZN2D1030S12 | ● | 10.3 | 42 | 98 | 99.9 | 12 | 10,000 |
| EZN2D1040S12 | ● | 10.4 | 42 | 98 | 99.9 | 12 | 10,000 |
| EZN2D1050S12 | ● | 10.5 | 42 | 98 | 99.9 | 12 | 10,000 |
| EZN2D1060S12 | ● | 10.6 | 44 | 98 | 99.9 | 12 | 10,400 |
| EZN2D1070S12 | ● | 10.7 | 44 | 98 | 99.9 | 12 | 10,400 |
| EZN2D1080S12 | ● | 10.8 | 44 | 98 | 100.0 | 12 | 10,400 |

| 形番 Cat. No. | 在庫 Stock | 寸法(mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|------------------|-------------|-------------------|----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN2D1090S12 | ● | 10.9 | 44 | 98 | 100.0 | 12 | 10,400 |
| EZN2D1100S12 | ● | 11.0 | 44 | 98 | 100.0 | 12 | 10,400 |
| NEW EZN2D1110S12 | ◎ | 11.1 | 46 | 98 | 100.0 | 12 | 10,800 |
| NEW EZN2D1120S12 | ◎ | 11.2 | 46 | 98 | 100.0 | 12 | 10,800 |
| NEW EZN2D1130S12 | ◎ | 11.3 | 46 | 98 | 100.1 | 12 | 10,800 |
| NEW EZN2D1140S12 | ◎ | 11.4 | 46 | 98 | 100.1 | 12 | 10,800 |
| EZN2D1150S12 | ● | 11.5 | 46 | 98 | 100.1 | 12 | 10,800 |
| NEW EZN2D1160S12 | ◎ | 11.6 | 48 | 98 | 100.1 | 12 | 11,110 |
| NEW EZN2D1170S12 | ◎ | 11.7 | 48 | 98 | 100.1 | 12 | 11,110 |
| NEW EZN2D1180S12 | ◎ | 11.8 | 48 | 98 | 100.1 | 12 | 11,110 |
| NEW EZN2D1190S12 | ◎ | 11.9 | 48 | 98 | 100.2 | 12 | 11,110 |
| EZN2D1200S12 | ● | 12.0 | 48 | 98 | 100.2 | 12 | 11,110 |
| NEW EZN2D1210S14 | ◎ | 12.1 | 52 | 110 | 112.2 | 14 | 11,660 |
| NEW EZN2D1220S14 | ◎ | 12.2 | 52 | 110 | 112.2 | 14 | 11,660 |
| NEW EZN2D1230S14 | ◎ | 12.3 | 52 | 110 | 112.2 | 14 | 11,660 |
| NEW EZN2D1240S14 | ◎ | 12.4 | 52 | 110 | 112.3 | 14 | 11,660 |
| EZN2D1250S14 | ● | 12.5 | 52 | 110 | 112.3 | 14 | 11,660 |
| NEW EZN2D1260S14 | ◎ | 12.6 | 52 | 110 | 112.3 | 14 | 11,880 |
| NEW EZN2D1270S14 | ◎ | 12.7 | 52 | 110 | 112.3 | 14 | 11,880 |
| NEW EZN2D1280S14 | ◎ | 12.8 | 52 | 110 | 112.3 | 14 | 11,880 |
| NEW EZN2D1290S14 | ◎ | 12.9 | 52 | 110 | 112.3 | 14 | 11,880 |
| EZN2D1300S14 | ● | 13.0 | 52 | 110 | 112.4 | 14 | 11,880 |
| NEW EZN2D1310S14 | ◎ | 13.1 | 56 | 115 | 117.4 | 14 | 12,540 |
| NEW EZN2D1320S14 | ◎ | 13.2 | 56 | 115 | 117.4 | 14 | 12,540 |
| NEW EZN2D1330S14 | ◎ | 13.3 | 56 | 115 | 117.4 | 14 | 12,540 |
| NEW EZN2D1340S14 | ◎ | 13.4 | 56 | 115 | 117.4 | 14 | 12,540 |
| EZN2D1350S14 | ● | 13.5 | 56 | 115 | 117.5 | 14 | 12,540 |
| NEW EZN2D1360S14 | ◎ | 13.6 | 56 | 115 | 117.5 | 14 | 12,870 |
| NEW EZN2D1370S14 | ◎ | 13.7 | 56 | 115 | 117.5 | 14 | 12,870 |
| NEW EZN2D1380S14 | ◎ | 13.8 | 56 | 115 | 117.5 | 14 | 12,870 |
| NEW EZN2D1390S14 | ◎ | 13.9 | 56 | 115 | 117.5 | 14 | 12,870 |
| EZN2D1400S14 | ● | 14.0 | 56 | 115 | 117.5 | 14 | 12,870 |

特殊品対応及び、再研削再コート対応致します。
詳細は弊社営業所までお問い合わせください。



製品概要

Line up

ストライクドリル EZN4D形(4Dタイプ) EZN4D type



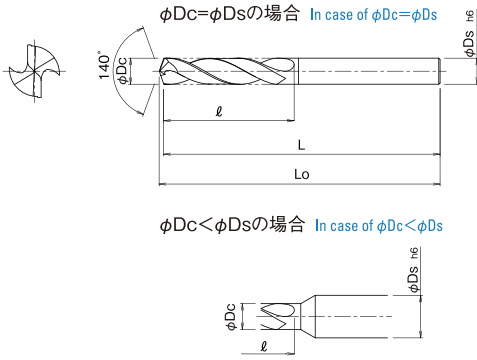
- 高精度ソリッドドリル High accuracy solid drill
- 有効加工穴深さ4×Dc Drilling depth 4×Dc
- ねじれ角30° Helix angle :30°
- クーラント穴無し Without coolant hole



| 形番 Cat. No. | 在庫 Stock | 寸法(mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------|-------------|-------------------|----|----|------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN4D0300S04 | ● | 3.0 | 19 | 59 | 59.5 | 4 | 5,450 |
| EZN4D0310S04 | ● | 3.1 | 22 | 59 | 59.6 | 4 | 5,830 |
| EZN4D0320S04 | ● | 3.2 | 22 | 59 | 59.6 | 4 | 5,830 |
| EZN4D0330S04 | ● | 3.3 | 22 | 59 | 59.6 | 4 | 5,830 |
| EZN4D0340S04 | ● | 3.4 | 22 | 59 | 59.6 | 4 | 5,830 |
| EZN4D0350S04 | ● | 3.5 | 22 | 59 | 59.6 | 4 | 5,830 |
| EZN4D0360S04 | ● | 3.6 | 25 | 59 | 59.7 | 4 | 6,160 |
| EZN4D0370S04 | ● | 3.7 | 25 | 59 | 59.7 | 4 | 6,160 |
| EZN4D0380S04 | ● | 3.8 | 25 | 59 | 59.7 | 4 | 6,160 |
| EZN4D0390S04 | ● | 3.9 | 25 | 59 | 59.7 | 4 | 6,160 |
| EZN4D0400S04 | ● | 4.0 | 25 | 59 | 59.7 | 4 | 6,160 |
| EZN4D0410S06 | ● | 4.1 | 28 | 74 | 74.7 | 6 | 6,600 |
| EZN4D0420S06 | ● | 4.2 | 28 | 74 | 74.8 | 6 | 6,600 |
| EZN4D0430S06 | ● | 4.3 | 28 | 74 | 74.8 | 6 | 6,600 |
| EZN4D0440S06 | ● | 4.4 | 28 | 74 | 74.8 | 6 | 6,600 |
| EZN4D0450S06 | ● | 4.5 | 28 | 74 | 74.8 | 6 | 6,600 |
| EZN4D0460S06 | ● | 4.6 | 31 | 74 | 74.8 | 6 | 7,040 |
| EZN4D0470S06 | ● | 4.7 | 31 | 74 | 74.9 | 6 | 7,040 |
| EZN4D0480S06 | ● | 4.8 | 31 | 74 | 74.9 | 6 | 7,040 |
| EZN4D0490S06 | ● | 4.9 | 31 | 74 | 74.9 | 6 | 7,040 |
| EZN4D0500S06 | ● | 5.0 | 31 | 74 | 74.9 | 6 | 7,040 |
| EZN4D0510S06 | ● | 5.1 | 34 | 79 | 79.9 | 6 | 7,430 |
| EZN4D0520S06 | ● | 5.2 | 34 | 79 | 79.9 | 6 | 7,430 |
| EZN4D0530S06 | ● | 5.3 | 34 | 79 | 80.0 | 6 | 7,430 |
| EZN4D0540S06 | ● | 5.4 | 34 | 79 | 80.0 | 6 | 7,430 |
| EZN4D0550S06 | ● | 5.5 | 34 | 79 | 80.0 | 6 | 7,430 |
| EZN4D0560S06 | ● | 5.6 | 37 | 79 | 80.0 | 6 | 7,810 |
| EZN4D0570S06 | ● | 5.7 | 37 | 79 | 80.0 | 6 | 7,810 |
| EZN4D0580S06 | ● | 5.8 | 37 | 79 | 80.1 | 6 | 7,810 |
| EZN4D0590S06 | ● | 5.9 | 37 | 79 | 80.1 | 6 | 7,810 |
| EZN4D0600S06 | ● | 6.0 | 37 | 79 | 80.1 | 6 | 7,810 |
| EZN4D0610S08 | ● | 6.1 | 40 | 88 | 89.1 | 8 | 7,810 |
| EZN4D0620S08 | ● | 6.2 | 40 | 88 | 89.1 | 8 | 7,810 |

| 形番 Cat. No. | 在庫 Stock | 寸法(mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------|-------------|-------------------|----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN4D0630S08 | ● | 6.3 | 40 | 88 | 89.1 | 8 | 7,810 |
| EZN4D0640S08 | ● | 6.4 | 40 | 88 | 89.2 | 8 | 7,810 |
| EZN4D0650S08 | ● | 6.5 | 40 | 88 | 89.2 | 8 | 7,810 |
| EZN4D0660S08 | ● | 6.6 | 42 | 88 | 89.2 | 8 | 8,310 |
| EZN4D0670S08 | ● | 6.7 | 42 | 88 | 89.2 | 8 | 8,310 |
| EZN4D0680S08 | ● | 6.8 | 42 | 88 | 89.2 | 8 | 8,310 |
| EZN4D0690S08 | ● | 6.9 | 42 | 88 | 89.3 | 8 | 8,310 |
| EZN4D0700S08 | ● | 7.0 | 42 | 88 | 89.3 | 8 | 8,310 |
| EZN4D0710S08 | ● | 7.1 | 45 | 93 | 94.3 | 8 | 8,800 |
| EZN4D0720S08 | ● | 7.2 | 45 | 93 | 94.3 | 8 | 8,800 |
| EZN4D0730S08 | ● | 7.3 | 45 | 93 | 94.3 | 8 | 8,800 |
| EZN4D0740S08 | ● | 7.4 | 45 | 93 | 94.3 | 8 | 8,800 |
| EZN4D0750S08 | ● | 7.5 | 45 | 93 | 94.4 | 8 | 8,800 |
| EZN4D0760S08 | ● | 7.6 | 48 | 93 | 94.4 | 8 | 9,300 |
| EZN4D0770S08 | ● | 7.7 | 48 | 93 | 94.4 | 8 | 9,300 |
| EZN4D0780S08 | ● | 7.8 | 48 | 93 | 94.4 | 8 | 9,300 |
| EZN4D0790S08 | ● | 7.9 | 48 | 93 | 94.4 | 8 | 9,300 |
| EZN4D0800S08 | ● | 8.0 | 48 | 93 | 94.5 | 8 | 9,300 |
| EZN4D0810S10 | ● | 8.1 | 51 | 98 | 99.5 | 10 | 9,790 |
| EZN4D0820S10 | ● | 8.2 | 51 | 98 | 99.5 | 10 | 9,790 |
| EZN4D0830S10 | ● | 8.3 | 51 | 98 | 99.5 | 10 | 9,790 |
| EZN4D0840S10 | ● | 8.4 | 51 | 98 | 99.5 | 10 | 9,790 |
| EZN4D0850S10 | ● | 8.5 | 51 | 98 | 99.5 | 10 | 9,790 |
| EZN4D0860S10 | ● | 8.6 | 54 | 98 | 99.6 | 10 | 10,180 |
| EZN4D0870S10 | ● | 8.7 | 54 | 98 | 99.6 | 10 | 10,180 |
| EZN4D0880S10 | ● | 8.8 | 54 | 98 | 99.6 | 10 | 10,180 |
| EZN4D0890S10 | ● | 8.9 | 54 | 98 | 99.6 | 10 | 10,180 |
| EZN4D0900S10 | ● | 9.0 | 54 | 98 | 99.6 | 10 | 10,180 |
| EZN4D0910S10 | ● | 9.1 | 57 | 108 | 109.7 | 10 | 10,780 |
| EZN4D0920S10 | ● | 9.2 | 57 | 108 | 109.7 | 10 | 10,780 |
| EZN4D0930S10 | ● | 9.3 | 57 | 108 | 109.7 | 10 | 10,780 |
| EZN4D0940S10 | ● | 9.4 | 57 | 108 | 109.7 | 10 | 10,780 |
| EZN4D0950S10 | ● | 9.5 | 57 | 108 | 109.7 | 10 | 10,780 |

●：メーカー在庫品 Standard stock items
 ◎：近日在庫品(2023年1月発売予定) Soon be stocked (Scheduled to released in January 2023)
 標準価格は2022年11月時点の価格となります。
 標準切削条件は17~18ページをご参照ください。



●直径寸法許容差 (mm)
Tolerance for φDc

| 直径φDc Tool dia. | 許容差 Tolerance |
|----------------------------|------------------|
| 3以下 Up to 3 | 0 -0.014 |
| 3をこえ6以下 Over 3 Up to 6 | 0 -0.018 |
| 6をこえ10以下 Over 6 Up to 10 | 0 -0.022 |
| 10をこえ16以下 Over 10 Up to 16 | 0 -0.027 |

| 形番 Cat. No. | 在庫 Stock | 寸法 (mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|------------------|-------------|--------------------|----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN4D0960S10 | ● | 9.6 | 60 | 108 | 109.7 | 10 | 11,110 |
| EZN4D0970S10 | ● | 9.7 | 60 | 108 | 109.8 | 10 | 11,110 |
| EZN4D0980S10 | ● | 9.8 | 60 | 108 | 109.8 | 10 | 11,110 |
| EZN4D0990S10 | ● | 9.9 | 60 | 108 | 109.8 | 10 | 11,110 |
| EZN4D1000S10 | ● | 10.0 | 60 | 108 | 109.8 | 10 | 11,110 |
| EZN4D1010S12 | ● | 10.1 | 63 | 118 | 119.8 | 12 | 11,770 |
| EZN4D1020S12 | ● | 10.2 | 63 | 118 | 119.9 | 12 | 11,770 |
| EZN4D1030S12 | ● | 10.3 | 63 | 118 | 119.9 | 12 | 11,770 |
| EZN4D1040S12 | ● | 10.4 | 63 | 118 | 119.9 | 12 | 11,770 |
| EZN4D1050S12 | ● | 10.5 | 63 | 118 | 119.9 | 12 | 11,770 |
| EZN4D1060S12 | ● | 10.6 | 66 | 118 | 119.9 | 12 | 12,100 |
| EZN4D1070S12 | ● | 10.7 | 66 | 118 | 119.9 | 12 | 12,100 |
| EZN4D1080S12 | ● | 10.8 | 66 | 118 | 120.0 | 12 | 12,100 |
| EZN4D1090S12 | ● | 10.9 | 66 | 118 | 120.0 | 12 | 12,100 |
| EZN4D1100S12 | ● | 11.0 | 66 | 118 | 120.0 | 12 | 12,100 |
| NEW EZN4D1110S12 | ◎ | 11.1 | 69 | 118 | 120.0 | 12 | 12,650 |
| NEW EZN4D1120S12 | ◎ | 11.2 | 69 | 118 | 120.0 | 12 | 12,650 |
| NEW EZN4D1130S12 | ◎ | 11.3 | 69 | 118 | 120.1 | 12 | 12,650 |
| NEW EZN4D1140S12 | ◎ | 11.4 | 69 | 118 | 120.1 | 12 | 12,650 |
| EZN4D1150S12 | ● | 11.5 | 69 | 118 | 120.1 | 12 | 12,650 |
| NEW EZN4D1160S12 | ◎ | 11.6 | 72 | 118 | 120.1 | 12 | 13,090 |
| NEW EZN4D1170S12 | ◎ | 11.7 | 72 | 118 | 120.1 | 12 | 13,090 |
| NEW EZN4D1180S12 | ◎ | 11.8 | 72 | 118 | 120.1 | 12 | 13,090 |
| NEW EZN4D1190S12 | ◎ | 11.9 | 72 | 118 | 120.2 | 12 | 13,090 |
| EZN4D1200S12 | ● | 12.0 | 72 | 118 | 120.2 | 12 | 13,090 |
| NEW EZN4D1210S14 | ◎ | 12.1 | 78 | 137 | 139.2 | 14 | 13,420 |
| NEW EZN4D1220S14 | ◎ | 12.2 | 78 | 137 | 139.2 | 14 | 13,420 |
| NEW EZN4D1230S14 | ◎ | 12.3 | 78 | 137 | 139.2 | 14 | 13,420 |
| NEW EZN4D1240S14 | ◎ | 12.4 | 78 | 137 | 139.3 | 14 | 13,420 |
| EZN4D1250S14 | ● | 12.5 | 78 | 137 | 139.3 | 14 | 13,420 |
| NEW EZN4D1260S14 | ◎ | 12.6 | 78 | 137 | 139.3 | 14 | 13,970 |
| NEW EZN4D1270S14 | ◎ | 12.7 | 78 | 137 | 139.3 | 14 | 13,970 |
| NEW EZN4D1280S14 | ◎ | 12.8 | 78 | 137 | 139.3 | 14 | 13,970 |

| 形番 Cat. No. | 在庫 Stock | 寸法 (mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|------------------|-------------|--------------------|----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| NEW EZN4D1290S14 | ◎ | 12.9 | 78 | 137 | 139.3 | 14 | 13,970 |
| EZN4D1300S14 | ● | 13.0 | 78 | 137 | 139.4 | 14 | 13,970 |
| NEW EZN4D1310S14 | ◎ | 13.1 | 84 | 147 | 149.4 | 14 | 14,410 |
| NEW EZN4D1320S14 | ◎ | 13.2 | 84 | 147 | 149.4 | 14 | 14,410 |
| NEW EZN4D1330S14 | ◎ | 13.3 | 84 | 147 | 149.4 | 14 | 14,410 |
| NEW EZN4D1340S14 | ◎ | 13.4 | 84 | 147 | 149.4 | 14 | 14,410 |
| EZN4D1350S14 | ● | 13.5 | 84 | 147 | 149.5 | 14 | 14,410 |
| NEW EZN4D1360S14 | ◎ | 13.6 | 84 | 147 | 149.5 | 14 | 14,960 |
| NEW EZN4D1370S14 | ◎ | 13.7 | 84 | 147 | 149.5 | 14 | 14,960 |
| NEW EZN4D1380S14 | ◎ | 13.8 | 84 | 147 | 149.5 | 14 | 14,960 |
| NEW EZN4D1390S14 | ◎ | 13.9 | 84 | 147 | 149.5 | 14 | 14,960 |
| EZN4D1400S14 | ● | 14.0 | 84 | 147 | 149.5 | 14 | 14,960 |

特殊品対応及び、再研削再コート対応致します。
詳細は弊社営業所までお問い合わせください。



製品概要

Line up

ストライクドリル EZN3D形(3Dタイプ) EZN3D type



- 高精度ソリッドドリル High accuracy solid drill
- 有効加工穴深さ3×Dc Drilling depth 3×Dc
- ねじれ角30° Helix angle :30°
- クーラント穴つき Through coolant hole



| 形番 Cat. No. | 在庫 Stock | 寸法(mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------|-------------|-------------------|----|----|------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN3DCH0300S03 | ● | 3.0 | 15 | 68 | 68.5 | 3 | 8,100 |
| EZN3DCH0310S04 | ● | 3.1 | 18 | 71 | 71.6 | 4 | 8,620 |
| EZN3DCH0320S04 | ● | 3.2 | 18 | 71 | 71.6 | 4 | 8,620 |
| EZN3DCH0330S04 | ● | 3.3 | 18 | 71 | 71.6 | 4 | 8,620 |
| EZN3DCH0340S04 | ● | 3.4 | 18 | 71 | 71.6 | 4 | 8,620 |
| EZN3DCH0350S04 | ● | 3.5 | 18 | 71 | 71.6 | 4 | 8,620 |
| EZN3DCH0360S04 | ● | 3.6 | 20 | 73 | 73.7 | 4 | 9,010 |
| EZN3DCH0370S04 | ● | 3.7 | 20 | 73 | 73.7 | 4 | 9,010 |
| EZN3DCH0380S04 | ● | 3.8 | 20 | 73 | 73.7 | 4 | 9,010 |
| EZN3DCH0390S04 | ● | 3.9 | 20 | 73 | 73.7 | 4 | 9,010 |
| EZN3DCH0400S04 | ● | 4.0 | 20 | 73 | 73.7 | 4 | 9,010 |
| EZN3DCH0410S05 | ● | 4.1 | 23 | 78 | 78.7 | 5 | 9,710 |
| EZN3DCH0420S05 | ● | 4.2 | 23 | 78 | 78.8 | 5 | 9,710 |
| EZN3DCH0430S05 | ● | 4.3 | 23 | 78 | 78.8 | 5 | 9,710 |
| EZN3DCH0440S05 | ● | 4.4 | 23 | 78 | 78.8 | 5 | 9,710 |
| EZN3DCH0450S05 | ● | 4.5 | 23 | 78 | 78.8 | 5 | 9,710 |
| EZN3DCH0460S05 | ● | 4.6 | 25 | 80 | 80.8 | 5 | 10,500 |
| EZN3DCH0470S05 | ● | 4.7 | 25 | 80 | 80.9 | 5 | 10,500 |
| EZN3DCH0480S05 | ● | 4.8 | 25 | 80 | 80.9 | 5 | 10,500 |
| EZN3DCH0490S05 | ● | 4.9 | 25 | 80 | 80.9 | 5 | 10,500 |
| EZN3DCH0500S05 | ● | 5.0 | 25 | 80 | 80.9 | 5 | 10,500 |
| EZN3DCH0510S06 | ● | 5.1 | 28 | 82 | 82.9 | 6 | 11,220 |
| EZN3DCH0520S06 | ● | 5.2 | 28 | 82 | 82.9 | 6 | 11,220 |
| EZN3DCH0530S06 | ● | 5.3 | 28 | 82 | 83.0 | 6 | 11,220 |
| EZN3DCH0540S06 | ● | 5.4 | 28 | 82 | 83.0 | 6 | 11,220 |
| EZN3DCH0550S06 | ● | 5.5 | 28 | 82 | 83.0 | 6 | 11,220 |
| EZN3DCH0560S06 | ● | 5.6 | 30 | 82 | 83.0 | 6 | 11,770 |
| EZN3DCH0570S06 | ● | 5.7 | 30 | 82 | 83.0 | 6 | 11,770 |
| EZN3DCH0580S06 | ● | 5.8 | 30 | 82 | 83.1 | 6 | 11,770 |
| EZN3DCH0590S06 | ● | 5.9 | 30 | 82 | 83.1 | 6 | 11,770 |
| EZN3DCH0600S06 | ● | 6.0 | 30 | 82 | 83.1 | 6 | 11,770 |
| EZN3DCH0610S07 | ● | 6.1 | 33 | 86 | 87.1 | 7 | 11,880 |
| EZN3DCH0620S07 | ● | 6.2 | 33 | 86 | 87.1 | 7 | 11,880 |

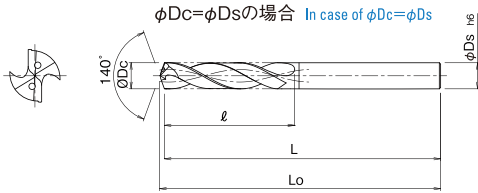
| 形番 Cat. No. | 在庫 Stock | 寸法(mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------|-------------|-------------------|----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN3DCH0630S07 | ● | 6.3 | 33 | 86 | 87.1 | 7 | 11,880 |
| EZN3DCH0640S07 | ● | 6.4 | 33 | 86 | 87.2 | 7 | 11,880 |
| EZN3DCH0650S07 | ● | 6.5 | 33 | 86 | 87.2 | 7 | 11,880 |
| EZN3DCH0660S07 | ● | 6.6 | 35 | 88 | 89.2 | 7 | 12,650 |
| EZN3DCH0670S07 | ● | 6.7 | 35 | 88 | 89.2 | 7 | 12,650 |
| EZN3DCH0680S07 | ● | 6.8 | 35 | 88 | 89.2 | 7 | 12,650 |
| EZN3DCH0690S07 | ● | 6.9 | 35 | 88 | 89.3 | 7 | 12,650 |
| EZN3DCH0700S07 | ● | 7.0 | 35 | 88 | 89.3 | 7 | 12,650 |
| EZN3DCH0710S08 | ● | 7.1 | 38 | 92 | 93.3 | 8 | 13,530 |
| EZN3DCH0720S08 | ● | 7.2 | 38 | 92 | 93.3 | 8 | 13,530 |
| EZN3DCH0730S08 | ● | 7.3 | 38 | 92 | 93.3 | 8 | 13,530 |
| EZN3DCH0740S08 | ● | 7.4 | 38 | 92 | 93.3 | 8 | 13,530 |
| EZN3DCH0750S08 | ● | 7.5 | 38 | 92 | 93.4 | 8 | 13,530 |
| EZN3DCH0760S08 | ● | 7.6 | 40 | 94 | 95.4 | 8 | 14,300 |
| EZN3DCH0770S08 | ● | 7.7 | 40 | 94 | 95.4 | 8 | 14,300 |
| EZN3DCH0780S08 | ● | 7.8 | 40 | 94 | 95.4 | 8 | 14,300 |
| EZN3DCH0790S08 | ● | 7.9 | 40 | 94 | 95.4 | 8 | 14,300 |
| EZN3DCH0800S08 | ● | 8.0 | 40 | 94 | 95.5 | 8 | 14,300 |
| EZN3DCH0810S09 | ● | 8.1 | 43 | 100 | 101.5 | 9 | 15,620 |
| EZN3DCH0820S09 | ● | 8.2 | 43 | 100 | 101.5 | 9 | 15,620 |
| EZN3DCH0830S09 | ● | 8.3 | 43 | 100 | 101.5 | 9 | 15,620 |
| EZN3DCH0840S09 | ● | 8.4 | 43 | 100 | 101.5 | 9 | 15,620 |
| EZN3DCH0850S09 | ● | 8.5 | 43 | 100 | 101.5 | 9 | 15,620 |
| EZN3DCH0860S09 | ● | 8.6 | 45 | 100 | 101.6 | 9 | 16,280 |
| EZN3DCH0870S09 | ● | 8.7 | 45 | 100 | 101.6 | 9 | 16,280 |
| EZN3DCH0880S09 | ● | 8.8 | 45 | 100 | 101.6 | 9 | 16,280 |
| EZN3DCH0890S09 | ● | 8.9 | 45 | 100 | 101.6 | 9 | 16,280 |
| EZN3DCH0900S09 | ● | 9.0 | 45 | 100 | 101.6 | 9 | 16,280 |
| EZN3DCH0910S10 | ● | 9.1 | 48 | 106 | 107.7 | 10 | 17,160 |
| EZN3DCH0920S10 | ● | 9.2 | 48 | 106 | 107.7 | 10 | 17,160 |
| EZN3DCH0930S10 | ● | 9.3 | 48 | 106 | 107.7 | 10 | 17,160 |
| EZN3DCH0940S10 | ● | 9.4 | 48 | 106 | 107.7 | 10 | 17,160 |
| EZN3DCH0950S10 | ● | 9.5 | 48 | 106 | 107.7 | 10 | 17,160 |

●：メーカー在庫品 Standard stock items

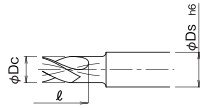
◎：近日在庫品(2023年1月発売予定) Soon be stocked (Scheduled to released in January 2023)

標準価格は2022年11月時点の価格となります。

標準切削条件は19~20ページをご参照ください。



φDc<φDsの場合 In case of φDc<φDs



●直径寸法許容差 (mm)
Tolerance for φDc

| 直径φDc Tool dia. | 許容差 Tolerance |
|----------------------------|------------------|
| 3以下 Up to 3 | 0 -0.014 |
| 3をこえ6以下 Over 3 Up to 6 | 0 -0.018 |
| 6をこえ10以下 Over 6 Up to 10 | 0 -0.022 |
| 10をこえ16以下 Over 10 Up to 16 | 0 -0.027 |

| 形番 Cat. No. | 在庫 Stock | 寸法 (mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|--------------------|-------------|--------------------|----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN3DCH0960S10 | ● | 9.6 | 50 | 106 | 107.7 | 10 | 17,820 |
| EZN3DCH0970S10 | ● | 9.7 | 50 | 106 | 107.8 | 10 | 17,820 |
| EZN3DCH0980S10 | ● | 9.8 | 50 | 106 | 107.8 | 10 | 17,820 |
| EZN3DCH0990S10 | ● | 9.9 | 50 | 106 | 107.8 | 10 | 17,820 |
| EZN3DCH1000S10 | ● | 10.0 | 50 | 106 | 107.8 | 10 | 17,820 |
| EZN3DCH1010S11 | ● | 10.1 | 53 | 116 | 117.8 | 11 | 18,810 |
| EZN3DCH1020S11 | ● | 10.2 | 53 | 116 | 117.9 | 11 | 18,810 |
| EZN3DCH1030S11 | ● | 10.3 | 53 | 116 | 117.9 | 11 | 18,810 |
| EZN3DCH1040S11 | ● | 10.4 | 53 | 116 | 117.9 | 11 | 18,810 |
| EZN3DCH1050S11 | ● | 10.5 | 53 | 116 | 117.9 | 11 | 18,810 |
| EZN3DCH1060S11 | ● | 10.6 | 55 | 116 | 117.9 | 11 | 19,360 |
| EZN3DCH1070S11 | ● | 10.7 | 55 | 116 | 117.9 | 11 | 19,360 |
| EZN3DCH1080S11 | ● | 10.8 | 55 | 116 | 118.0 | 11 | 19,360 |
| EZN3DCH1090S11 | ● | 10.9 | 55 | 116 | 118.0 | 11 | 19,360 |
| EZN3DCH1100S11 | ● | 11.0 | 55 | 116 | 118.0 | 11 | 19,800 |
| NEW EZN3DCH1110S12 | ◎ | 11.1 | 58 | 122 | 124.0 | 12 | 20,570 |
| NEW EZN3DCH1120S12 | ◎ | 11.2 | 58 | 122 | 124.0 | 12 | 20,570 |
| NEW EZN3DCH1130S12 | ◎ | 11.3 | 58 | 122 | 124.1 | 12 | 20,570 |
| NEW EZN3DCH1140S12 | ◎ | 11.4 | 58 | 122 | 124.1 | 12 | 20,570 |
| EZN3DCH1150S12 | ● | 11.5 | 58 | 122 | 124.1 | 12 | 20,570 |
| NEW EZN3DCH1160S12 | ◎ | 11.6 | 60 | 122 | 124.1 | 12 | 21,450 |
| NEW EZN3DCH1170S12 | ◎ | 11.7 | 60 | 122 | 124.1 | 12 | 21,450 |
| NEW EZN3DCH1180S12 | ◎ | 11.8 | 60 | 122 | 124.1 | 12 | 21,450 |
| NEW EZN3DCH1190S12 | ◎ | 11.9 | 60 | 122 | 124.2 | 12 | 21,450 |
| EZN3DCH1200S12 | ● | 12.0 | 60 | 122 | 124.2 | 12 | 21,450 |
| NEW EZN3DCH1210S13 | ◎ | 12.1 | 65 | 128 | 130.2 | 13 | 22,110 |
| NEW EZN3DCH1220S13 | ◎ | 12.2 | 65 | 128 | 130.2 | 13 | 22,110 |
| NEW EZN3DCH1230S13 | ◎ | 12.3 | 65 | 128 | 130.2 | 13 | 22,110 |
| NEW EZN3DCH1240S13 | ◎ | 12.4 | 65 | 128 | 130.3 | 13 | 22,110 |
| EZN3DCH1250S13 | ● | 12.5 | 65 | 128 | 130.3 | 13 | 22,110 |
| NEW EZN3DCH1260S13 | ◎ | 12.6 | 65 | 128 | 130.3 | 13 | 22,880 |
| NEW EZN3DCH1270S13 | ◎ | 12.7 | 65 | 128 | 130.3 | 13 | 22,880 |
| NEW EZN3DCH1280S13 | ◎ | 12.8 | 65 | 128 | 130.3 | 13 | 22,880 |

| 形番 Cat. No. | 在庫 Stock | 寸法 (mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|--------------------|-------------|--------------------|----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| NEW EZN3DCH1290S13 | ◎ | 12.9 | 65 | 128 | 130.3 | 13 | 22,880 |
| EZN3DCH1300S13 | ● | 13.0 | 65 | 128 | 130.4 | 13 | 22,880 |
| NEW EZN3DCH1310S14 | ◎ | 13.1 | 70 | 134 | 136.4 | 14 | 23,760 |
| NEW EZN3DCH1320S14 | ◎ | 13.2 | 70 | 134 | 136.4 | 14 | 23,760 |
| NEW EZN3DCH1330S14 | ◎ | 13.3 | 70 | 134 | 136.4 | 14 | 23,760 |
| NEW EZN3DCH1340S14 | ◎ | 13.4 | 70 | 134 | 136.4 | 14 | 23,760 |
| EZN3DCH1350S14 | ● | 13.5 | 70 | 134 | 136.5 | 14 | 23,760 |
| NEW EZN3DCH1360S14 | ◎ | 13.6 | 70 | 134 | 136.5 | 14 | 24,530 |
| NEW EZN3DCH1370S14 | ◎ | 13.7 | 70 | 134 | 136.5 | 14 | 24,530 |
| NEW EZN3DCH1380S14 | ◎ | 13.8 | 70 | 134 | 136.5 | 14 | 24,530 |
| NEW EZN3DCH1390S14 | ◎ | 13.9 | 70 | 134 | 136.5 | 14 | 24,530 |
| EZN3DCH1400S14 | ● | 14.0 | 70 | 134 | 136.5 | 14 | 24,530 |
| EZN3DCH1450S15 | ● | 14.5 | 75 | 140 | 142.6 | 15 | 25,080 |
| EZN3DCH1500S15 | ● | 15.0 | 75 | 140 | 142.7 | 15 | 25,960 |
| EZN3DCH1550S16 | ● | 15.5 | 80 | 146 | 148.8 | 16 | 26,730 |
| EZN3DCH1600S16 | ● | 16.0 | 80 | 146 | 148.9 | 16 | 27,500 |

特殊品対応及び、再研削再コート対応致します。
詳細は弊社営業所までお問い合わせください。

再研削の手引きは
↓コチラ↓



製品概要

Line up

● ストライクドリル EZN5D形(5Dタイプ)

EZN5D type



- 高精度ソリッドドリル High accuracy solid drill
- 有効加工穴深さ5×Dc Drilling depth 5×Dc
- ねじれ角30° Helix angle :30°
- クーラント穴つき Through coolant hole
- ダブルマージン Double margin



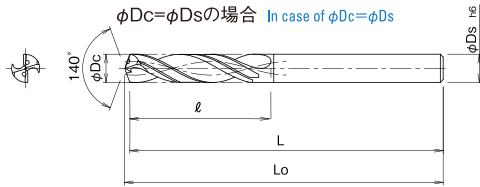
| 形番 Cat. No. | 在庫 Stock | 寸法 (mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------|-------------|--------------------|----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN5DCH0300S03 | ● | 3.0 | 24 | 77 | 77.5 | 3 | 10,440 |
| EZN5DCH0310S04 | ● | 3.1 | 28 | 81 | 81.6 | 4 | 10,770 |
| EZN5DCH0320S04 | ● | 3.2 | 28 | 81 | 81.6 | 4 | 10,770 |
| EZN5DCH0330S04 | ● | 3.3 | 28 | 81 | 81.6 | 4 | 10,770 |
| EZN5DCH0340S04 | ● | 3.4 | 28 | 81 | 81.6 | 4 | 10,770 |
| EZN5DCH0350S04 | ● | 3.5 | 28 | 81 | 81.6 | 4 | 10,770 |
| EZN5DCH0360S04 | ● | 3.6 | 32 | 85 | 85.7 | 4 | 11,110 |
| EZN5DCH0370S04 | ● | 3.7 | 32 | 85 | 85.7 | 4 | 11,110 |
| EZN5DCH0380S04 | ● | 3.8 | 32 | 85 | 85.7 | 4 | 11,110 |
| EZN5DCH0390S04 | ● | 3.9 | 32 | 85 | 85.7 | 4 | 11,110 |
| EZN5DCH0400S04 | ● | 4.0 | 32 | 85 | 85.7 | 4 | 11,110 |
| EZN5DCH0410S05 | ● | 4.1 | 36 | 91 | 91.7 | 5 | 11,880 |
| EZN5DCH0420S05 | ● | 4.2 | 36 | 91 | 91.8 | 5 | 11,880 |
| EZN5DCH0430S05 | ● | 4.3 | 36 | 91 | 91.8 | 5 | 11,880 |
| EZN5DCH0440S05 | ● | 4.4 | 36 | 91 | 91.8 | 5 | 11,880 |
| EZN5DCH0450S05 | ● | 4.5 | 36 | 91 | 91.8 | 5 | 11,880 |
| EZN5DCH0460S05 | ● | 4.6 | 40 | 94 | 94.8 | 5 | 12,100 |
| EZN5DCH0470S05 | ● | 4.7 | 40 | 94 | 94.9 | 5 | 12,100 |
| EZN5DCH0480S05 | ● | 4.8 | 40 | 94 | 94.9 | 5 | 12,100 |
| EZN5DCH0490S05 | ● | 4.9 | 40 | 94 | 94.9 | 5 | 12,100 |
| EZN5DCH0500S05 | ● | 5.0 | 40 | 94 | 94.9 | 5 | 12,100 |
| EZN5DCH0510S06 | ● | 5.1 | 44 | 96 | 96.9 | 6 | 13,420 |
| EZN5DCH0520S06 | ● | 5.2 | 44 | 96 | 96.9 | 6 | 13,420 |
| EZN5DCH0530S06 | ● | 5.3 | 44 | 96 | 97.0 | 6 | 13,420 |
| EZN5DCH0540S06 | ● | 5.4 | 44 | 96 | 97.0 | 6 | 13,420 |
| EZN5DCH0550S06 | ● | 5.5 | 44 | 96 | 97.0 | 6 | 13,420 |
| EZN5DCH0560S06 | ● | 5.6 | 48 | 100 | 101.0 | 6 | 13,750 |
| EZN5DCH0570S06 | ● | 5.7 | 48 | 100 | 101.0 | 6 | 13,750 |
| EZN5DCH0580S06 | ● | 5.8 | 48 | 100 | 101.1 | 6 | 13,750 |
| EZN5DCH0590S06 | ● | 5.9 | 48 | 100 | 101.1 | 6 | 13,750 |
| EZN5DCH0600S06 | ● | 6.0 | 48 | 100 | 101.1 | 6 | 13,750 |
| EZN5DCH0610S07 | ● | 6.1 | 52 | 105 | 106.1 | 7 | 14,410 |
| EZN5DCH0620S07 | ● | 6.2 | 52 | 105 | 106.1 | 7 | 14,410 |

| 形番 Cat. No. | 在庫 Stock | 寸法 (mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------|-------------|--------------------|----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN5DCH0630S07 | ● | 6.3 | 52 | 105 | 106.1 | 7 | 14,410 |
| EZN5DCH0640S07 | ● | 6.4 | 52 | 105 | 106.2 | 7 | 14,410 |
| EZN5DCH0650S07 | ● | 6.5 | 52 | 105 | 106.2 | 7 | 14,410 |
| EZN5DCH0660S07 | ● | 6.6 | 56 | 109 | 110.2 | 7 | 14,850 |
| EZN5DCH0670S07 | ● | 6.7 | 56 | 109 | 110.2 | 7 | 14,850 |
| EZN5DCH0680S07 | ● | 6.8 | 56 | 109 | 110.2 | 7 | 14,850 |
| EZN5DCH0690S07 | ● | 6.9 | 56 | 109 | 110.3 | 7 | 14,850 |
| EZN5DCH0700S07 | ● | 7.0 | 56 | 109 | 110.3 | 7 | 14,850 |
| EZN5DCH0710S08 | ● | 7.1 | 60 | 114 | 115.3 | 8 | 16,060 |
| EZN5DCH0720S08 | ● | 7.2 | 60 | 114 | 115.3 | 8 | 16,060 |
| EZN5DCH0730S08 | ● | 7.3 | 60 | 114 | 115.3 | 8 | 16,060 |
| EZN5DCH0740S08 | ● | 7.4 | 60 | 114 | 115.3 | 8 | 16,060 |
| EZN5DCH0750S08 | ● | 7.5 | 60 | 114 | 115.4 | 8 | 16,060 |
| EZN5DCH0760S08 | ● | 7.6 | 64 | 118 | 119.4 | 8 | 16,390 |
| EZN5DCH0770S08 | ● | 7.7 | 64 | 118 | 119.4 | 8 | 16,390 |
| EZN5DCH0780S08 | ● | 7.8 | 64 | 118 | 119.4 | 8 | 16,390 |
| EZN5DCH0790S08 | ● | 7.9 | 64 | 118 | 119.4 | 8 | 16,390 |
| EZN5DCH0800S08 | ● | 8.0 | 64 | 118 | 119.5 | 8 | 16,390 |
| EZN5DCH0810S09 | ● | 8.1 | 68 | 127 | 128.5 | 9 | 17,600 |
| EZN5DCH0820S09 | ● | 8.2 | 68 | 127 | 128.5 | 9 | 17,600 |
| EZN5DCH0830S09 | ● | 8.3 | 68 | 127 | 128.5 | 9 | 17,600 |
| EZN5DCH0840S09 | ● | 8.4 | 68 | 127 | 128.5 | 9 | 17,600 |
| EZN5DCH0850S09 | ● | 8.5 | 68 | 127 | 128.5 | 9 | 17,600 |
| EZN5DCH0860S09 | ● | 8.6 | 72 | 127 | 128.6 | 9 | 18,040 |
| EZN5DCH0870S09 | ● | 8.7 | 72 | 127 | 128.6 | 9 | 18,040 |
| EZN5DCH0880S09 | ● | 8.8 | 72 | 127 | 128.6 | 9 | 18,040 |
| EZN5DCH0890S09 | ● | 8.9 | 72 | 127 | 128.6 | 9 | 18,040 |
| EZN5DCH0900S09 | ● | 9.0 | 72 | 127 | 128.6 | 9 | 18,040 |
| EZN5DCH0910S10 | ● | 9.1 | 76 | 136 | 137.7 | 10 | 19,250 |
| EZN5DCH0920S10 | ● | 9.2 | 76 | 136 | 137.7 | 10 | 19,250 |
| EZN5DCH0930S10 | ● | 9.3 | 76 | 136 | 137.7 | 10 | 19,250 |
| EZN5DCH0940S10 | ● | 9.4 | 76 | 136 | 137.7 | 10 | 19,250 |
| EZN5DCH0950S10 | ● | 9.5 | 76 | 136 | 137.7 | 10 | 19,250 |

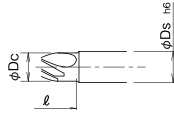
●:メーカー在庫品 Standard stock items

◎:近日在庫品(2023年1月発売予定) Soon be stocked (Scheduled to released in January 2023)

標準価格は2022年11月時点の価格となります。
標準切削条件は19~20ページをご参照ください。



φDc<φDsの場合 In case of φDc<φDs



●直径寸法許容差(mm)
Tolerance for φDc

| 直径φDc Tool dia. | 許容差 Tolerance |
|----------------------------|------------------|
| 3以下 Up to 3 | 0 -0.014 |
| 3をこえ6以下 Over 3 Up to 6 | 0 -0.018 |
| 6をこえ10以下 Over 6 Up to 10 | 0 -0.022 |
| 10をこえ16以下 Over 10 Up to 16 | 0 -0.027 |

| 形番 Cat. No. | 在庫 Stock | 寸法(mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|--------------------|-------------|-------------------|-----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN5DCH0960S10 | ● | 9.6 | 80 | 136 | 137.7 | 10 | 19,470 |
| EZN5DCH0970S10 | ● | 9.7 | 80 | 136 | 137.8 | 10 | 19,470 |
| EZN5DCH0980S10 | ● | 9.8 | 80 | 136 | 137.8 | 10 | 19,470 |
| EZN5DCH0990S10 | ● | 9.9 | 80 | 136 | 137.8 | 10 | 19,470 |
| EZN5DCH1000S10 | ● | 10.0 | 80 | 136 | 137.8 | 10 | 19,470 |
| EZN5DCH1010S11 | ● | 10.1 | 84 | 149 | 150.8 | 11 | 20,680 |
| EZN5DCH1020S11 | ● | 10.2 | 84 | 149 | 150.9 | 11 | 20,680 |
| EZN5DCH1030S11 | ● | 10.3 | 84 | 149 | 150.9 | 11 | 20,680 |
| EZN5DCH1040S11 | ● | 10.4 | 84 | 149 | 150.9 | 11 | 20,680 |
| EZN5DCH1050S11 | ● | 10.5 | 84 | 149 | 150.9 | 11 | 20,680 |
| EZN5DCH1060S11 | ● | 10.6 | 88 | 149 | 150.9 | 11 | 21,340 |
| EZN5DCH1070S11 | ● | 10.7 | 88 | 149 | 150.9 | 11 | 21,340 |
| EZN5DCH1080S11 | ● | 10.8 | 88 | 149 | 151.0 | 11 | 21,340 |
| EZN5DCH1090S11 | ● | 10.9 | 88 | 149 | 151.0 | 11 | 21,340 |
| EZN5DCH1100S11 | ● | 11.0 | 88 | 149 | 151.0 | 11 | 21,340 |
| NEW EZN5DCH1110S12 | ◎ | 11.1 | 92 | 158 | 160.0 | 12 | 22,550 |
| NEW EZN5DCH1120S12 | ◎ | 11.2 | 92 | 158 | 160.0 | 12 | 22,550 |
| NEW EZN5DCH1130S12 | ◎ | 11.3 | 92 | 158 | 160.1 | 12 | 22,550 |
| NEW EZN5DCH1140S12 | ◎ | 11.4 | 92 | 158 | 160.1 | 12 | 22,550 |
| EZN5DCH1150S12 | ● | 11.5 | 92 | 158 | 160.1 | 12 | 22,550 |
| NEW EZN5DCH1160S12 | ◎ | 11.6 | 96 | 158 | 160.1 | 12 | 22,990 |
| NEW EZN5DCH1170S12 | ◎ | 11.7 | 96 | 158 | 160.1 | 12 | 22,990 |
| NEW EZN5DCH1180S12 | ◎ | 11.8 | 96 | 158 | 160.1 | 12 | 22,990 |
| NEW EZN5DCH1190S12 | ◎ | 11.9 | 96 | 158 | 160.2 | 12 | 22,990 |
| EZN5DCH1200S12 | ● | 12.0 | 96 | 158 | 160.2 | 12 | 22,990 |
| NEW EZN5DCH1210S13 | ◎ | 12.1 | 104 | 167 | 169.2 | 13 | 24,200 |
| NEW EZN5DCH1220S13 | ◎ | 12.2 | 104 | 167 | 169.2 | 13 | 24,200 |
| NEW EZN5DCH1230S13 | ◎ | 12.3 | 104 | 167 | 169.2 | 13 | 24,200 |
| NEW EZN5DCH1240S13 | ◎ | 12.4 | 104 | 167 | 169.3 | 13 | 24,200 |
| EZN5DCH1250S13 | ● | 12.5 | 104 | 167 | 169.3 | 13 | 24,200 |
| NEW EZN5DCH1260S13 | ◎ | 12.6 | 104 | 167 | 169.3 | 13 | 24,640 |
| NEW EZN5DCH1270S13 | ◎ | 12.7 | 104 | 167 | 169.3 | 13 | 24,640 |
| NEW EZN5DCH1280S13 | ◎ | 12.8 | 104 | 167 | 169.3 | 13 | 24,640 |

| 形番 Cat. No. | 在庫 Stock | 寸法(mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|--------------------|-------------|-------------------|-----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| NEW EZN5DCH1290S13 | ◎ | 12.9 | 104 | 167 | 169.3 | 13 | 24,640 |
| EZN5DCH1300S13 | ● | 13.0 | 104 | 167 | 169.4 | 13 | 24,640 |
| NEW EZN5DCH1310S14 | ◎ | 13.1 | 112 | 176 | 178.4 | 14 | 25,960 |
| NEW EZN5DCH1320S14 | ◎ | 13.2 | 112 | 176 | 178.4 | 14 | 25,960 |
| NEW EZN5DCH1330S14 | ◎ | 13.3 | 112 | 176 | 178.4 | 14 | 25,960 |
| NEW EZN5DCH1340S14 | ◎ | 13.4 | 112 | 176 | 178.4 | 14 | 25,960 |
| EZN5DCH1350S14 | ● | 13.5 | 112 | 176 | 178.5 | 14 | 25,960 |
| NEW EZN5DCH1360S14 | ◎ | 13.6 | 112 | 176 | 178.5 | 14 | 26,290 |
| NEW EZN5DCH1370S14 | ◎ | 13.7 | 112 | 176 | 178.5 | 14 | 26,290 |
| NEW EZN5DCH1380S14 | ◎ | 13.8 | 112 | 176 | 178.5 | 14 | 26,290 |
| NEW EZN5DCH1390S14 | ◎ | 13.9 | 112 | 176 | 178.5 | 14 | 26,290 |
| EZN5DCH1400S14 | ● | 14.0 | 112 | 176 | 178.5 | 14 | 26,290 |
| EZN5DCH1450S15 | ● | 14.5 | 120 | 185 | 187.6 | 15 | 29,260 |
| EZN5DCH1500S15 | ● | 15.0 | 120 | 185 | 187.7 | 15 | 29,590 |
| EZN5DCH1550S16 | ● | 15.5 | 128 | 194 | 196.8 | 16 | 31,130 |
| EZN5DCH1600S16 | ● | 16.0 | 128 | 194 | 196.9 | 16 | 31,240 |

特殊品対応及び、再研削再コート対応致します。
詳細は弊社営業所までお問い合わせください。

再研削の手引きは
↓こちら↓



製品概要

Line up

ストライクドリル EZN8D形(8Dタイプ) EZN 8D type



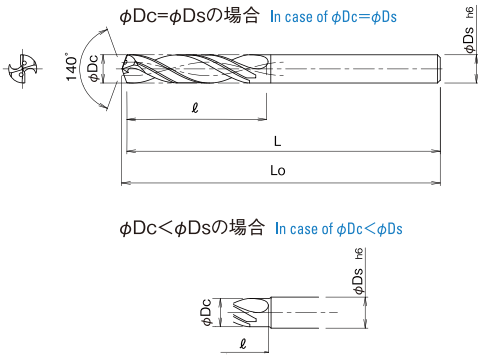
- 高精度ソリッドドリル High accuracy solid drill
- 有効加工穴深さ8×Dc Drilling depth 8×Dc
- ねじれ角30° Helix angle :30°
- クーラント穴つき Through coolant hole
- ダブルマージン Double margin



| 形番 Cat. No. | 在庫 Stock | 寸法 (mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------|-------------|--------------------|----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN8DCH0300S03 | ● | 3.0 | 33 | 81 | 81.5 | 3 | 15,070 |
| EZN8DCH0310S04 | ● | 3.1 | 39 | 87 | 87.6 | 4 | 15,400 |
| EZN8DCH0320S04 | ● | 3.2 | 39 | 87 | 87.6 | 4 | 15,400 |
| EZN8DCH0330S04 | ● | 3.3 | 39 | 87 | 87.6 | 4 | 15,400 |
| EZN8DCH0340S04 | ● | 3.4 | 39 | 87 | 87.6 | 4 | 15,400 |
| EZN8DCH0350S04 | ● | 3.5 | 39 | 87 | 87.6 | 4 | 15,400 |
| EZN8DCH0360S04 | ● | 3.6 | 44 | 92 | 92.7 | 4 | 15,400 |
| EZN8DCH0370S04 | ● | 3.7 | 44 | 92 | 92.7 | 4 | 15,400 |
| EZN8DCH0380S04 | ● | 3.8 | 44 | 92 | 92.7 | 4 | 15,400 |
| EZN8DCH0390S04 | ● | 3.9 | 44 | 92 | 92.7 | 4 | 15,400 |
| EZN8DCH0400S04 | ● | 4.0 | 44 | 92 | 92.7 | 4 | 15,400 |
| EZN8DCH0410S05 | ● | 4.1 | 50 | 100 | 100.7 | 5 | 16,060 |
| EZN8DCH0420S05 | ● | 4.2 | 50 | 100 | 100.8 | 5 | 16,060 |
| EZN8DCH0430S05 | ● | 4.3 | 50 | 100 | 100.8 | 5 | 16,060 |
| EZN8DCH0440S05 | ● | 4.4 | 50 | 100 | 100.8 | 5 | 16,060 |
| EZN8DCH0450S05 | ● | 4.5 | 50 | 100 | 100.8 | 5 | 16,060 |
| EZN8DCH0460S05 | ● | 4.6 | 55 | 105 | 105.8 | 5 | 16,280 |
| EZN8DCH0470S05 | ● | 4.7 | 55 | 105 | 105.9 | 5 | 16,280 |
| EZN8DCH0480S05 | ● | 4.8 | 55 | 105 | 105.9 | 5 | 16,280 |
| EZN8DCH0490S05 | ● | 4.9 | 55 | 105 | 105.9 | 5 | 16,280 |
| EZN8DCH0500S05 | ● | 5.0 | 55 | 105 | 105.9 | 5 | 16,280 |
| EZN8DCH0510S06 | ● | 5.1 | 61 | 114 | 114.9 | 6 | 16,940 |
| EZN8DCH0520S06 | ● | 5.2 | 61 | 114 | 114.9 | 6 | 16,940 |
| EZN8DCH0530S06 | ● | 5.3 | 61 | 114 | 115.0 | 6 | 16,940 |
| EZN8DCH0540S06 | ● | 5.4 | 61 | 114 | 115.0 | 6 | 16,940 |
| EZN8DCH0550S06 | ● | 5.5 | 61 | 114 | 115.0 | 6 | 16,940 |
| EZN8DCH0560S06 | ● | 5.6 | 66 | 118 | 119.0 | 6 | 17,380 |
| EZN8DCH0570S06 | ● | 5.7 | 66 | 118 | 119.0 | 6 | 17,380 |
| EZN8DCH0580S06 | ● | 5.8 | 66 | 118 | 119.1 | 6 | 17,380 |

| 形番 Cat. No. | 在庫 Stock | 寸法 (mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------|-------------|--------------------|----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN8DCH0590S06 | ● | 5.9 | 66 | 118 | 119.1 | 6 | 17,380 |
| EZN8DCH0600S06 | ● | 6.0 | 66 | 118 | 119.1 | 6 | 17,380 |
| EZN8DCH0610S07 | ● | 6.1 | 71 | 125 | 126.1 | 7 | 18,370 |
| EZN8DCH0620S07 | ● | 6.2 | 71 | 125 | 126.1 | 7 | 18,370 |
| EZN8DCH0630S07 | ● | 6.3 | 71 | 125 | 126.1 | 7 | 18,370 |
| EZN8DCH0640S07 | ● | 6.4 | 71 | 125 | 126.2 | 7 | 18,370 |
| EZN8DCH0650S07 | ● | 6.5 | 71 | 125 | 126.2 | 7 | 18,370 |
| EZN8DCH0660S07 | ● | 6.6 | 77 | 130 | 131.2 | 7 | 18,590 |
| EZN8DCH0670S07 | ● | 6.7 | 77 | 130 | 131.2 | 7 | 18,590 |
| EZN8DCH0680S07 | ● | 6.8 | 77 | 130 | 131.2 | 7 | 18,590 |
| EZN8DCH0690S07 | ● | 6.9 | 77 | 130 | 131.3 | 7 | 18,590 |
| EZN8DCH0700S07 | ● | 7.0 | 77 | 130 | 131.3 | 7 | 18,590 |
| EZN8DCH0710S08 | ● | 7.1 | 82 | 136 | 137.3 | 8 | 19,910 |
| EZN8DCH0720S08 | ● | 7.2 | 82 | 136 | 137.3 | 8 | 19,910 |
| EZN8DCH0730S08 | ● | 7.3 | 82 | 136 | 137.3 | 8 | 19,910 |
| EZN8DCH0740S08 | ● | 7.4 | 82 | 136 | 137.3 | 8 | 19,910 |
| EZN8DCH0750S08 | ● | 7.5 | 82 | 136 | 137.4 | 8 | 19,910 |
| EZN8DCH0760S08 | ● | 7.6 | 88 | 142 | 143.4 | 8 | 20,240 |
| EZN8DCH0770S08 | ● | 7.7 | 88 | 142 | 143.4 | 8 | 20,240 |
| EZN8DCH0780S08 | ● | 7.8 | 88 | 142 | 143.4 | 8 | 20,240 |
| EZN8DCH0790S08 | ● | 7.9 | 88 | 142 | 143.4 | 8 | 20,240 |
| EZN8DCH0800S08 | ● | 8.0 | 88 | 142 | 143.5 | 8 | 20,240 |
| EZN8DCH0810S09 | ● | 8.1 | 93 | 154 | 155.5 | 9 | 21,230 |
| EZN8DCH0820S09 | ● | 8.2 | 93 | 154 | 155.5 | 9 | 21,230 |
| EZN8DCH0830S09 | ● | 8.3 | 93 | 154 | 155.5 | 9 | 21,230 |
| EZN8DCH0840S09 | ● | 8.4 | 93 | 154 | 155.5 | 9 | 21,230 |
| EZN8DCH0850S09 | ● | 8.5 | 93 | 154 | 155.5 | 9 | 21,230 |
| EZN8DCH0860S09 | ● | 8.6 | 99 | 154 | 155.6 | 9 | 21,450 |
| EZN8DCH0870S09 | ● | 8.7 | 99 | 154 | 155.6 | 9 | 21,450 |

●：メーカー在庫品 Standard stock items
標準価格は2022年11月時点の価格となります。
標準切削条件は19~20ページをご参照ください。



●直径寸法許容差(mm)
Tolerance for φDc

| 直径φDc Tool dia. | 許容差 Tolerance |
|----------------------------|------------------|
| 3以下 3 Up to | 0 -0.014 |
| 3をこえ6以下 3 Over 6 Up to | 0 -0.018 |
| 6をこえ10以下 6 Over 10 Up to | 0 -0.022 |
| 10をこえ16以下 10 Over 16 Up to | 0 -0.027 |

| 形番 Cat. No. | 在庫 Stock | 寸法(mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------|-------------|-------------------|-----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN8DCH0880S09 | ● | 8.8 | 99 | 154 | 155.6 | 9 | 21,450 |
| EZN8DCH0890S09 | ● | 8.9 | 99 | 154 | 155.6 | 9 | 21,450 |
| EZN8DCH0900S09 | ● | 9.0 | 99 | 154 | 155.6 | 9 | 21,450 |
| EZN8DCH0910S10 | ● | 9.1 | 104 | 166 | 167.7 | 10 | 24,420 |
| EZN8DCH0920S10 | ● | 9.2 | 104 | 166 | 167.7 | 10 | 24,420 |
| EZN8DCH0930S10 | ● | 9.3 | 104 | 166 | 167.7 | 10 | 24,420 |
| EZN8DCH0940S10 | ● | 9.4 | 104 | 166 | 167.7 | 10 | 24,420 |
| EZN8DCH0950S10 | ● | 9.5 | 104 | 166 | 167.7 | 10 | 24,420 |
| EZN8DCH0960S10 | ● | 9.6 | 110 | 166 | 167.7 | 10 | 24,970 |
| EZN8DCH0970S10 | ● | 9.7 | 110 | 166 | 167.8 | 10 | 24,970 |
| EZN8DCH0980S10 | ● | 9.8 | 110 | 166 | 167.8 | 10 | 24,970 |
| EZN8DCH0990S10 | ● | 9.9 | 110 | 166 | 167.8 | 10 | 24,970 |
| EZN8DCH1000S10 | ● | 10.0 | 110 | 166 | 167.8 | 10 | 24,970 |
| EZN8DCH1010S11 | ● | 10.1 | 115 | 182 | 183.8 | 11 | 27,500 |
| EZN8DCH1020S11 | ● | 10.2 | 115 | 182 | 183.9 | 11 | 27,500 |
| EZN8DCH1030S11 | ● | 10.3 | 115 | 182 | 183.9 | 11 | 27,500 |
| EZN8DCH1040S11 | ● | 10.4 | 115 | 182 | 183.9 | 11 | 27,500 |
| EZN8DCH1050S11 | ● | 10.5 | 115 | 182 | 183.9 | 11 | 27,500 |
| EZN8DCH1060S11 | ● | 10.6 | 121 | 182 | 183.9 | 11 | 28,160 |
| EZN8DCH1070S11 | ● | 10.7 | 121 | 182 | 183.9 | 11 | 28,160 |
| EZN8DCH1080S11 | ● | 10.8 | 121 | 182 | 184.0 | 11 | 28,160 |
| EZN8DCH1090S11 | ● | 10.9 | 121 | 182 | 184.0 | 11 | 28,160 |
| EZN8DCH1100S11 | ● | 11.0 | 121 | 182 | 184.0 | 11 | 28,160 |
| EZN8DCH1110S12 | ● | 11.1 | 126 | 194 | 196.0 | 12 | 31,020 |
| EZN8DCH1120S12 | ● | 11.2 | 126 | 194 | 196.0 | 12 | 31,020 |
| EZN8DCH1130S12 | ● | 11.3 | 126 | 194 | 196.1 | 12 | 31,020 |
| EZN8DCH1140S12 | ● | 11.4 | 126 | 194 | 196.1 | 12 | 31,020 |

| 形番 Cat. No. | 在庫 Stock | 寸法(mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------|-------------|-------------------|-----|-----|-------|-----|------------------------------------|
| | | φDc | ℓ | L | Lo | φDs | |
| EZN8DCH1150S12 | ● | 11.5 | 126 | 194 | 196.1 | 12 | 31,020 |
| EZN8DCH1160S12 | ● | 11.6 | 132 | 194 | 196.1 | 12 | 31,680 |
| EZN8DCH1170S12 | ● | 11.7 | 132 | 194 | 196.1 | 12 | 31,680 |
| EZN8DCH1180S12 | ● | 11.8 | 132 | 194 | 196.1 | 12 | 31,680 |
| EZN8DCH1190S12 | ● | 11.9 | 132 | 194 | 196.2 | 12 | 31,680 |
| EZN8DCH1200S12 | ● | 12.0 | 132 | 194 | 196.2 | 12 | 31,680 |
| EZN8DCH1210S13 | ● | 12.1 | 137 | 206 | 208.2 | 13 | 35,200 |
| EZN8DCH1220S13 | ● | 12.2 | 137 | 206 | 208.2 | 13 | 35,200 |
| EZN8DCH1230S13 | ● | 12.3 | 137 | 206 | 208.2 | 13 | 35,200 |
| EZN8DCH1240S13 | ● | 12.4 | 137 | 206 | 208.3 | 13 | 35,200 |
| EZN8DCH1250S13 | ● | 12.5 | 137 | 206 | 208.3 | 13 | 35,200 |
| EZN8DCH1260S13 | ● | 12.6 | 143 | 206 | 208.3 | 13 | 35,640 |
| EZN8DCH1270S13 | ● | 12.7 | 143 | 206 | 208.3 | 13 | 35,640 |
| EZN8DCH1280S13 | ● | 12.8 | 143 | 206 | 208.3 | 13 | 35,640 |
| EZN8DCH1290S13 | ● | 12.9 | 143 | 206 | 208.3 | 13 | 35,640 |
| EZN8DCH1300S13 | ● | 13.0 | 143 | 206 | 208.4 | 13 | 35,640 |
| EZN8DCH1310S14 | ● | 13.1 | 148 | 218 | 220.4 | 14 | 39,930 |
| EZN8DCH1320S14 | ● | 13.2 | 148 | 218 | 220.4 | 14 | 39,930 |
| EZN8DCH1330S14 | ● | 13.3 | 148 | 218 | 220.4 | 14 | 39,930 |
| EZN8DCH1340S14 | ● | 13.4 | 148 | 218 | 220.4 | 14 | 39,930 |
| EZN8DCH1350S14 | ● | 13.5 | 148 | 218 | 220.5 | 14 | 39,930 |
| EZN8DCH1360S14 | ● | 13.6 | 154 | 218 | 220.5 | 14 | 40,480 |
| EZN8DCH1370S14 | ● | 13.7 | 154 | 218 | 220.5 | 14 | 40,480 |
| EZN8DCH1380S14 | ● | 13.8 | 154 | 218 | 220.5 | 14 | 40,480 |
| EZN8DCH1390S14 | ● | 13.9 | 154 | 218 | 220.5 | 14 | 40,480 |
| EZN8DCH1400S14 | ● | 14.0 | 154 | 218 | 220.5 | 14 | 40,480 |

特殊品対応及び、再研削再コート対応致します。
詳細は弊社営業所までお問い合わせください。

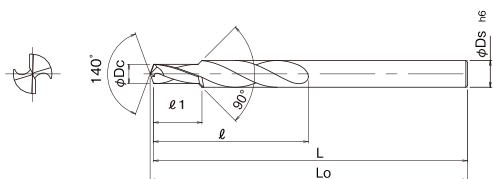
再研削の手引きは
↓コチラ↓



製品概要

● 面取り刃付き ストライクドリル 外部給油タイプ

- 高精度ソリッドドリル
- クーラント穴無し



2Dタイプ

| 形番 | 在庫 | 寸法 (mm) | | | | | |
|------------------|--------------------------|---------|----|----|-----|-------|-----|
| | | φDc | ℓ1 | ℓ | L | Lo | φDs |
| EZN2D0340S06-M4 | <input type="checkbox"/> | 3.4 | 8 | 25 | 78 | 78.6 | 6 |
| EZN2D0430S07-M5 | <input type="checkbox"/> | 4.3 | 10 | 30 | 82 | 82.8 | 7 |
| EZN2D0510S08-M6 | <input type="checkbox"/> | 5.1 | 12 | 35 | 88 | 88.9 | 8 |
| EZN2D0680S10-M8 | <input type="checkbox"/> | 6.8 | 16 | 45 | 108 | 109.2 | 10 |
| EZN2D0850S12-M10 | <input type="checkbox"/> | 8.5 | 20 | 50 | 118 | 119.5 | 12 |
| EZN2D1030S14-M12 | <input type="checkbox"/> | 10.3 | 24 | 60 | 137 | 138.9 | 14 |

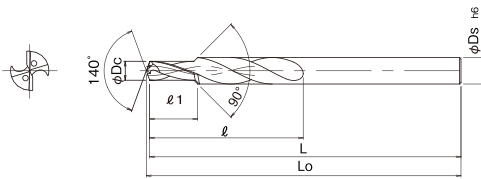
特定代理店在庫品
標準切削条件は21~22ページをご参照ください。

3Dタイプ

| 形番 | 在庫 | 寸法 (mm) | | | | | |
|------------------|--------------------------|---------|----|----|-----|-------|-----|
| | | φDc | ℓ1 | ℓ | L | Lo | φDs |
| EZN3D0340S06-M4 | <input type="checkbox"/> | 3.4 | 12 | 30 | 78 | 78.6 | 6 |
| EZN3D0430S07-M5 | <input type="checkbox"/> | 4.3 | 15 | 35 | 82 | 82.8 | 7 |
| EZN3D0510S08-M6 | <input type="checkbox"/> | 5.1 | 18 | 40 | 88 | 88.9 | 8 |
| EZN3D0680S10-M8 | <input type="checkbox"/> | 6.8 | 24 | 50 | 108 | 109.2 | 10 |
| EZN3D0850S12-M10 | <input type="checkbox"/> | 8.5 | 30 | 60 | 118 | 119.5 | 12 |
| EZN3D1030S14-M12 | <input type="checkbox"/> | 10.3 | 36 | 70 | 137 | 138.9 | 14 |

● 面取り刃付き ストライクドリル 内部給油タイプ

- 高精度ソリッドドリル
- クーラント穴つき



● 直径寸法許容差 (mm)

| 直径φDc | 許容差 |
|-----------|-------------|
| 3をこえ6以下 | 0 -0.018 |
| 6をこえ10以下 | 0 -0.022 |
| 10をこえ16以下 | 0 -0.027 |

2Dタイプ

| 形番 | 在庫 | 寸法 (mm) | | | | | |
|--------------------|--------------------------|---------|----|----|-----|-------|-----|
| | | φDc | ℓ1 | ℓ | L | Lo | φDs |
| EZN2DCH0340S06-M4 | <input type="checkbox"/> | 3.4 | 8 | 25 | 78 | 78.6 | 6 |
| EZN2DCH0430S07-M5 | <input type="checkbox"/> | 4.3 | 10 | 30 | 82 | 82.8 | 7 |
| EZN2DCH0510S08-M6 | <input type="checkbox"/> | 5.1 | 12 | 35 | 88 | 88.9 | 8 |
| EZN2DCH0680S10-M8 | <input type="checkbox"/> | 6.8 | 16 | 45 | 108 | 109.2 | 10 |
| EZN2DCH0850S12-M10 | <input type="checkbox"/> | 8.5 | 20 | 50 | 118 | 119.5 | 12 |
| EZN2DCH1030S14-M12 | <input type="checkbox"/> | 10.3 | 24 | 60 | 137 | 138.9 | 14 |

特定代理店在庫品
標準切削条件は21~22ページをご参照ください。

3Dタイプ

| 形番 | 在庫 | 寸法 (mm) | | | | | |
|--------------------|--------------------------|---------|----|----|-----|-------|-----|
| | | φDc | ℓ1 | ℓ | L | Lo | φDs |
| EZN3DCH0340S06-M4 | <input type="checkbox"/> | 3.4 | 12 | 30 | 78 | 78.6 | 6 |
| EZN3DCH0430S07-M5 | <input type="checkbox"/> | 4.3 | 15 | 35 | 82 | 82.8 | 7 |
| EZN3DCH0510S08-M6 | <input type="checkbox"/> | 5.1 | 18 | 40 | 88 | 88.9 | 8 |
| EZN3DCH0680S10-M8 | <input type="checkbox"/> | 6.8 | 24 | 50 | 108 | 109.2 | 10 |
| EZN3DCH0850S12-M10 | <input type="checkbox"/> | 8.5 | 30 | 60 | 118 | 119.5 | 12 |
| EZN3DCH1030S14-M12 | <input type="checkbox"/> | 10.3 | 36 | 70 | 137 | 138.9 | 14 |

特殊品対応及び、再研削再コート対応致します。
詳細は弊社営業所までお問い合わせください。

再研削の手引きは
↓コチラ↓



シリーズ拡張 Series Expansion

● ロールタップ下穴用ストライクドリル EZT形

STRIKE DRILL for Forming Tap

ロールタップとは What is Forming Tap

- ・ 切削タップに比べ寿命が約3倍。3 times longer tool life compared with cutting tap.
- ・ 切削せずにめねじを成形するため切りくずが出ず、止まり穴のねじ立てに最適。
No chips are produced as the internal thread are formed without cutting, making it ideal for setting threads in stop holes.

クーラント穴無し Without coolant hole

クーラント穴付き With coolant hole

3Dタイプ 3D type

4Dタイプ 4D type

特長

Feature of product

下穴管理が重要なロールタップ加工において

Forming Tap, Which pre-hole control is critical

狙い通りの高精度な穴あけが可能!
High-accuracy drilling is possible!

外径精度-0.01~0を実現!
Outer diameter accuracy of -0.01 to 0 is realized!

溝長最適設定

Optimal groove length setting

精度重視の為再研磨代を設けていません
No regrinding fee due to our emphasis on precision.

外径精度重視!

Focus on diameter accuracy


全サイズダブルマージンを採用!

All size adopted double margine

切削性能

Cutting performance

SS400

| ロールタップ下穴用ストライクドリル STRIKE DRILL for Forming Tap EZT4DCH0463S05 (φ4.63) | | | |
|---|---------------|----------|---|
| 穴径 | 入口 Entry | 4.633 mm |  |
| | 中間 Middle | 4.632 mm | |
| | 抜け側 Exit | 4.633 mm | |
| | 平均 Average | 4.633 mm | |


回転速度 Spindle speed: 4,460min⁻¹ (切削速度 Cutting speed: 65m/min)

送り速度 Feed speed: 67mm/min (送り量 Feed: 0.15mm/rev)

切削油材 Coolant: 水溶切削油 (内部) Water soluble

使用機械: 立型MC Vertical MC

SUS304

| ロールタップ下穴用ストライクドリル STRIKE DRILL for Forming Tap EZT4DCH0463S05 (φ4.63) | | | |
|---|---------------|----------|---|
| 穴径 | 入口 Entry | 4.631 mm |  |
| | 中間 Middle | 4.631 mm | |
| | 抜け側 Exit | 4.630 mm | |
| | 平均 Average | 4.631 mm | |

回転速度 Spindle speed: 660min⁻¹ (切削速度 Cutting speed: 10m/min)

送り速度 Feed speed: 50mm/min (送り量 Feed: 0.075mm/rev)

切削油材 Coolant: 水溶切削油 (内部) Water soluble

使用機械: 立型MC Vertical MC

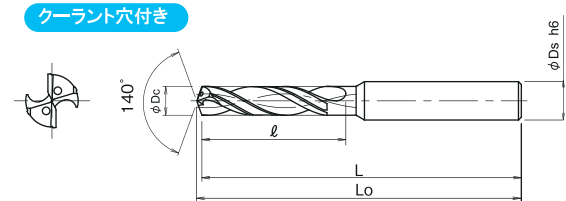
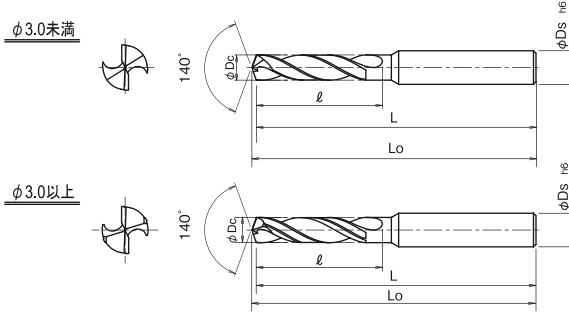
➡ 穴の拡大代が少なくタップ下穴などの高品質な穴あけ加工に最適!

Suitable for high quality drilling such as tapped holes with a small hole enlargement allowance!

● ロールタップ下穴用ストライクドリル

- 高精度ソリッドドリル High accuracy solid drill
- ねじれ角30° Helix angle :30°
- 外径許容差 -0.01mm~0mm Accuracy -0.01mm~0mm

再研磨不可



EZT3D形 (3Dタイプ) 外部給油式

| ねじサイズ Thread size | 形番 Cat. No. | 在庫 Stock | 寸法 (mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------------|----------------|-------------|--------------------|--------|----|-------|------------|------------------------------------|
| | | | ϕD_c | ℓ | L | L_o | ϕD_s | |
| M3X0.5 | EZT3D0278S03 | ● | 2.78 | 13 | 49 | 49.5 | 3 | 5,450 |
| M3X0.5 | EZT3D0279S03 | ● | 2.79 | 13 | 49 | 49.5 | 3 | 5,450 |
| M3X0.5 | EZT3D0280S03 | ● | 2.80 | 13 | 49 | 49.5 | 3 | 5,450 |
| M4X0.7 | EZT3D0368S04 | ● | 3.68 | 18 | 49 | 49.7 | 4 | 6,130 |
| M4X0.7 | EZT3D0369S04 | ● | 3.69 | 18 | 49 | 49.7 | 4 | 6,130 |
| M4X0.7 | EZT3D0370S04 | ● | 3.70 | 18 | 49 | 49.7 | 4 | 6,130 |
| M5X0.8 | EZT3D0463S06 | ● | 4.63 | 22 | 64 | 64.8 | 6 | 7,080 |
| M5X0.8 | EZT3D0464S06 | ● | 4.64 | 22 | 64 | 64.8 | 6 | 7,080 |
| M5X0.8 | EZT3D0465S06 | ● | 4.65 | 22 | 64 | 64.8 | 6 | 7,080 |
| M6X1.0 | EZT3D0553S06 | ● | 5.53 | 24 | 68 | 69.0 | 6 | 7,490 |
| M6X1.0 | EZT3D0554S06 | ● | 5.54 | 24 | 68 | 69.0 | 6 | 7,490 |
| M6X1.0 | EZT3D0555S06 | ● | 5.55 | 24 | 68 | 69.0 | 6 | 7,490 |

●:メーカー在庫品 Standard stock items

EZT4D形 (4Dタイプ) 内部給油式

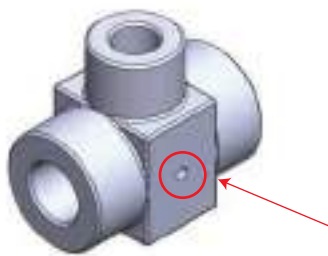
| ねじサイズ Thread size | 形番 Cat. No. | 在庫 Stock | 寸法 (mm) Dimensions | | | | | 標準価格 (円) List Price (JPY) |
|----------------------|----------------|-------------|--------------------|--------|----|-------|------------|------------------------------------|
| | | | ϕD_c | ℓ | L | L_o | ϕD_s | |
| M4X0.7 | EZT4DCH0368S04 | ● | 3.68 | 21 | 73 | 73.7 | 4 | 10,650 |
| M4X0.7 | EZT4DCH0369S04 | ● | 3.69 | 21 | 73 | 73.7 | 4 | 10,650 |
| M4X0.7 | EZT4DCH0370S04 | ● | 3.70 | 21 | 73 | 73.7 | 4 | 10,650 |
| M5X0.8 | EZT4DCH0463S05 | ● | 4.63 | 26 | 80 | 80.8 | 5 | 12,400 |
| M5X0.8 | EZT4DCH0464S05 | ● | 4.64 | 26 | 80 | 80.8 | 5 | 12,400 |
| M5X0.8 | EZT4DCH0465S05 | ● | 4.65 | 26 | 80 | 80.8 | 5 | 12,400 |
| M6X1.0 | EZT4DCH0553S06 | ● | 5.53 | 29 | 82 | 83.0 | 6 | 13,910 |
| M6X1.0 | EZT4DCH0554S06 | ● | 5.54 | 29 | 82 | 83.0 | 6 | 13,910 |
| M6X1.0 | EZT4DCH0555S06 | ● | 5.55 | 29 | 82 | 83.0 | 6 | 13,910 |

●:メーカー在庫品 Standard stock items

加工事例

Cutting data

ステンレス鋼の下穴加工 Pre-hole drilling of stainless steel



結果 Result

4,000個加工後も穴位置精度が良好で、継続加工可能。
安定した穴あけ加工ができ後工程のタップも長寿命化を実現！

Excellent hole position accuracy even after 4,000 pieces are machined,
enabling continuous machining.
Stable drilling and long tool life of tapping in the subsequent process are realized!

| | | |
|-------------------------------|---|--|
| 被加工材料 Work Material | 名称 Part name | バルブ部品 Valve parts |
| | 被削材 Material | ステンレス鋼 (SUS316L) |
| | 硬さ Hardness | — |
| 使用工具 Tool | 形番 Tool No. | EZT4DCH0464S05 |
| | 材種 Grade | バリュースコート DV coat |
| 加工条件 Cutting Conditions | 回転速度、切削速度 Spindle speed Cutting speed | $n=3,000\text{min}^{-1}$ $V_c=43\text{m/min}$ |
| | 送り速度、送り量 Feed speed Feed | $V_f=360\text{mm/min}$ $f=0.12\text{mm/rev}$ |
| | 穴あけ深さ Drilling depth | 10mm |
| | クーラント Coolant | 水溶性切削油 (内部) Water coolant(internal) |
| | 使用機械 Machine | 立形MC Vertical MC |

標準切削条件 Recommended cutting conditions

● ストライクドリル EZN2D・EZN4D形(2D・4Dタイプ)
 ロールタップ下穴用ストライクドリル EZT3D形(3Dタイプ)

EZN2D/EZN4D type
 EZT3Dtype

| 被削材 Work materials | 構造用鋼(SS400)硬さ180HB以下 Steel for structure Below 180HB | 炭素鋼(S50C)硬さ280HB以下 Carbon steel (C50) Below 280HB | 合金鋼(SCM440) 硬さ280~350HB Alloy steel (1.7223) 280~350HB | ブリアードン鋼(NAK80)硬さ38~43HRC Mold Steel (P21) 38~43HRC | | | | |
|-------------------------------------|--|--|--|--|---|-----------------------------------|---|-----------------------------------|
| 切削速度 Cutting speed Vc (m/min) | 15~ 45(φ1 ~φ 1.9) 40~100(φ2 ~φ 7) 60~120(φ7.1~φ14) | 15~ 45(φ1 ~φ 1.9) 40~100(φ2 ~φ 7) 60~120(φ7.1~φ14) | 15~45(φ1~φ 1.9) 40~80(φ2~φ14) | 15~45(φ1~φ 1.9) 30~60(φ2~φ14) | | | | |
| 送り量 feed f (mm/rev) | 0.02~0.06(φ 1 ~φ 2.9) 0.08~0.18(φ 3 ~φ 5) 0.08~0.22(φ 5.1~φ 7) 0.15~0.28(φ 7.1~φ12) 0.20~0.33(φ12.1~φ14) | 0.02~0.06(φ 1 ~φ 2.9) 0.08~0.18(φ 3 ~φ 5) 0.08~0.22(φ 5.1~φ 7) 0.15~0.28(φ 7.1~φ12) 0.20~0.33(φ12.1~φ14) | 0.02~0.06(φ 1 ~φ 2.9) 0.08~0.18(φ 3 ~φ 5) 0.08~0.22(φ 5.1~φ 7) 0.15~0.28(φ 7.1~φ12) 0.18~0.33(φ12.1~φ14) | 0.02~0.05(φ 1 ~φ 2.9) 0.08~0.18(φ 3 ~φ 5) 0.08~0.22(φ 5.1~φ 7) 0.10~0.28(φ 7.1~φ12) 0.13~0.30(φ12.1~φ14) | | | | |
| ドリル直径 Drill dia. (mm) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) |
| 1 | 9,550 | 390 | 9,550 | 390 | 9,550 | 390 | 9,550 | 290 |
| 2 | 8,760 | 360 | 8,760 | 360 | 8,760 | 360 | 7,170 | 220 |
| 3 | 7,430 | 970 | 7,430 | 970 | 6,370 | 830 | 4,780 | 630 |
| 4 | 5,580 | 790 | 5,580 | 790 | 4,780 | 670 | 3,590 | 510 |
| 5 | 4,460 | 670 | 4,460 | 670 | 3,820 | 580 | 2,870 | 440 |
| 6 | 3,720 | 620 | 3,720 | 620 | 3,190 | 530 | 2,390 | 400 |
| 7 | 3,530 | 610 | 3,530 | 610 | 2,730 | 470 | 2,050 | 340 |
| 8 | 3,190 | 580 | 3,190 | 580 | 2,390 | 440 | 1,800 | 300 |
| 9 | 3,010 | 560 | 3,010 | 560 | 2,130 | 400 | 1,600 | 270 |
| 10 | 2,710 | 560 | 2,710 | 560 | 1,910 | 400 | 1,440 | 240 |
| 11 | 2,460 | 560 | 2,460 | 560 | 1,740 | 400 | 1,310 | 220 |
| 12 | 2,390 | 540 | 2,260 | 510 | 1,600 | 360 | 1,200 | 200 |
| 13 | 2,330 | 540 | 2,210 | 510 | 1,470 | 340 | 1,110 | 200 |
| 14 | 2,160 | 520 | 2,050 | 500 | 1,370 | 330 | 1,030 | 190 |

使用上の注意事項

- *1. 上記の標準切削条件は平坦面加工における目安の条件を示しています。
機械剛性やワーククランプ、加工部形状などにより必要に応じて切削条件を調整してください。
 - *2. 上記の標準切削条件は切れ刃先端部に水溶性切削油を外部給油にて充分な量を供給している場合を想定しています。
 - *3. 穴深さは2Dタイプの場合は2D以下、4Dタイプの場合は4D以下での使用を想定しています。
 - *4. 被削材の性質やワーク形状などにより、切りくずが長く伸びる場合があります。
それにより、『穴径が拡大する』『壁面に傷がつく』『切りくず詰まりによる工具破損』などの可能性があるので、『送り上げる』『ステップ加工』などを行い、切りくずを分断してください。
 - *5. 横型マシニングセンタ等、切削油剤が届きにくい場合はEZ3D形・EZ5D形の内部給油での加工を推奨いたします。
 - *6. オーステナイト系ステンレス鋼を加工する際はEZ3D形・EZ5D形の内部給油での加工を推奨いたします。外部給油で加工する際は、下記注意事項をお守りください。
 - *7. ロールタップ下穴用ストライクドリルを使用の場合は、通常の条件から80%落としてください。
- <オーステナイト系ステンレス鋼を外部給油で加工する際の注意事項>
- ・外部給油で加工する際は油性切削油の使用を推奨いたします。
 - ・φ10以上の工具で加工する際や4Dタイプでの2D以上の加工の際は、穴の上面まで戻すステップ加工を推奨します。

Attention

- *1. Above cutting conditions are for drilling flat surface.
Please adjust cutting conditions according to machine rigidity, work clamping and shape of machining part.
- *2. Above cutting conditions are for drilling with water soluble (internal coolant)
- *3. We expect 2D type's depth of hole is less than 2D, 4D type is less than 4D.
- *4. In case of long chips evacuated, adjust above conditions by increasing Feed speed or using step feed for breaking chips.
- *5. When it is difficult to reach the cutting fluid such as using horizontal machining centers, EZ3D and EZ5D type with internal coolant is recommended.
- *6. When machining austenitic stainless steel, EZ3D and EZ5D types with internal coolant is recommended.
When machining with external lubrication, please be sure to follow the following precautions.
- *7. When using Forming Tap Strike Drill, reduce 80% of the above data.

<Precautions for machining austenitic stainless steel with external lubrication>

- ・When machining with external lubrication, using an oil-based cutting oil is recommended.
- ・When machining with φ10 or more, or machining more than 2D with 4D type, step machining back to the top of the hole is recommended.

| 被削材 Work materials | ねずみ鋳鉄(FC250)引張り強さ350MPa以下 Grey cast iron (GG25) Below 350MPa | | ダクタイル鋳鉄(FCD400) 引張り強さ450MPa以下 Nodular cast iron (GGG40) Below 450MPa | | オーステナイト系ステンレス鋼 (SUS304, SUS316L) 硬さ280HB以下 Austenitic stainless steel (AISI304,316L) Below 280HB | | フェライト系ステンレス鋼(SUS430) マルテンサイト系ステンレス鋼(SUS440C) 硬さ220HB以下 Ferritic stainless steel(AISI430) Martensitic stainless steel(AISI440C) Below 220HB | |
|-------------------------------------|--|-----------------------------------|--|-----------------------------------|---|-----------------------------------|---|-----------------------------------|
| 切削速度 Cutting speed Vc (m/min) | 15~ 45(φ1 ~φ 1.9) 40~100(φ2 ~φ 7) 80~120(φ7.1~φ14) | | 15~ 45(φ1 ~φ 1.9) 40~ 80(φ2 ~φ 7) 50~100(φ7.1~φ14) | | 10 ~ 15(φ 1 ~φ 14) | | 10~ 30 (φ 1 ~φ 2.9) 20~ 40 (φ 3 ~φ 7) 20~ 45 (φ 7.1~φ14) | |
| 送り量 feed f (mm/rev) | 0.02~0.06(φ 1 ~φ 2.9) 0.10~0.18(φ 3 ~φ 5) 0.12~0.22(φ 5.1~φ 7) 0.15~0.28(φ 7.1~φ12) 0.20~0.33(φ12.1~φ14) | | 0.02~0.06(φ 1 ~φ 2.9) 0.10~0.18(φ 3 ~φ 5) 0.12~0.22(φ 5.1~φ 7) 0.15~0.28(φ 7.1~φ12) 0.20~0.30(φ12.1~φ14) | | 0.02~0.05 (φ 1 ~φ 2.9) 0.05~0.08 (φ 3 ~φ 5) 0.06~0.12 (φ 5.1~φ 7) 0.10~0.20 (φ 7.1~φ12) 0.15~0.23 (φ12.1~φ14) | | 0.02~0.05(φ 1 ~φ 2.9) 0.05~0.18(φ 3 ~φ 5) 0.06~0.23(φ 5.1~φ 7) 0.08~0.25(φ 7.1~φ12) 0.10~0.25(φ12.1~φ14) | |
| ドリル直径 Drill dia. (mm) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) |
| 1 | 9,550 | 390 | 9,550 | 390 | 3,180 | 95 | 4,780 | 140 |
| 2 | 8,760 | 360 | 8,760 | 360 | 1,590 | 65 | 3,180 | 130 |
| 3 | 9,020 | 1,220 | 6,370 | 860 | 1,060 | 65 | 2,650 | 210 |
| 4 | 6,770 | 990 | 4,780 | 700 | 810 | 50 | 2,150 | 260 |
| 5 | 5,420 | 850 | 3,820 | 600 | 660 | 50 | 1,780 | 250 |
| 6 | 4,510 | 770 | 3,190 | 550 | 550 | 50 | 1,490 | 240 |
| 7 | 3,870 | 660 | 2,730 | 470 | 465 | 50 | 1,370 | 230 |
| 8 | 3,590 | 650 | 2,590 | 470 | 405 | 50 | 1,200 | 215 |
| 9 | 3,540 | 640 | 2,300 | 420 | 355 | 50 | 1,170 | 210 |
| 10 | 3,190 | 640 | 2,070 | 420 | 335 | 50 | 1,050 | 210 |
| 11 | 2,900 | 630 | 1,890 | 410 | 320 | 55 | 1,010 | 205 |
| 12 | 2,660 | 600 | 1,860 | 420 | 305 | 55 | 960 | 200 |
| 13 | 2,450 | 570 | 1,720 | 400 | 305 | 55 | 910 | 200 |
| 14 | 2,280 | 550 | 1,600 | 390 | 295 | 55 | 865 | 190 |

高硬度材の穴あけ加工には

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標準切削条件 Recommended cutting conditions

● ストライクドリル EZN3D・EZN5D・EZN8D形(3D・5D・8Dタイプ) EZN3D/EZN5D/EZN8Dtype
 ロールタップ下穴用ストライクドリル EZT4D形(4Dタイプ) EZT4Dtype

| 被削材 Work materials | 構造用鋼(SS400)硬さ180HB以下 Steel for structure Below 180HB | | 炭素鋼(S50C)硬さ280HB以下 Carbon steel (C50) Below 280HB | | 合金鋼(SCM440)280~350HB Alloy steel (1.7223) 280~350HB | | プリアードン鋼(NAK80)硬さ38~43HRC Mold Steel (P21) 38~43HRC | |
|-------------------------------------|--|-----------------------------------|--|-----------------------------------|--|-----------------------------------|--|-----------------------------------|
| 切削速度 Cutting speed Vc (m/min) | 50~120(φ3 ~φ7) 80~160(φ7.1~φ16) | | 50~120(φ3 ~φ7) 80~140(φ7.1~φ16) | | 40~80(φ3 ~φ7) 50~100(φ7.1~φ16) | | 30~60(φ3 ~φ7) 40~70(φ7.1~φ16) | |
| 送り量 feed f (mm/rev) | 0.10~0.20(φ3 ~φ5) 0.13~0.25(φ5.1~φ7) 0.15~0.32(φ7.1~φ12) 0.20~0.35(φ12.1~φ16) | | 0.10~0.20(φ3 ~φ5) 0.13~0.25(φ5.1~φ7) 0.15~0.32(φ7.1~φ12) 0.20~0.35(φ12.1~φ16) | | 0.10~0.20(φ3 ~φ5) 0.12~0.23(φ5.1~φ7) 0.15~0.32(φ7.1~φ12) 0.20~0.35(φ12.1~φ16) | | 0.10~0.18(φ3 ~φ5) 0.12~0.23(φ5.1~φ7) 0.15~0.28(φ7.1~φ12) 0.15~0.30(φ12.1~φ16) | |
| ドリル直径 Drill dia. (mm) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) |
| 3 | 9,020 | 1,360 | 9,020 | 1,360 | 6,370 | 960 | 4,780 | 670 |
| 4 | 6,770 | 1,020 | 6,770 | 1,020 | 4,780 | 720 | 3,590 | 530 |
| 5 | 5,420 | 950 | 5,420 | 950 | 3,820 | 640 | 2,870 | 460 |
| 6 | 4,780 | 910 | 4,780 | 910 | 3,450 | 610 | 2,390 | 420 |
| 7 | 4,550 | 870 | 4,550 | 870 | 3,190 | 600 | 2,280 | 400 |
| 8 | 4,380 | 880 | 4,380 | 880 | 2,990 | 600 | 1,990 | 360 |
| 9 | 3,900 | 820 | 3,900 | 820 | 2,660 | 580 | 1,770 | 340 |
| 10 | 3,510 | 780 | 3,510 | 780 | 2,390 | 550 | 1,680 | 340 |
| 11 | 3,190 | 750 | 3,190 | 750 | 2,180 | 520 | 1,520 | 330 |
| 12 | 3,060 | 750 | 3,060 | 750 | 1,990 | 500 | 1,460 | 320 |
| 13 | 2,940 | 740 | 2,700 | 680 | 1,960 | 500 | 1,350 | 310 |
| 14 | 2,730 | 690 | 2,510 | 630 | 1,820 | 470 | 1,260 | 290 |
| 15 | 2,550 | 670 | 2,340 | 610 | 1,700 | 450 | 1,170 | 270 |
| 16 | 2,390 | 660 | 2,190 | 610 | 1,600 | 450 | 1,100 | 250 |

使用上の注意事項

- *1. 上記の標準切削条件は平坦面加工における目安の条件を示しています。
機械剛性やワーククランプ、加工部形状などにより必要に応じて切削条件を調整してください。
- *2. 水溶性切削油を内部給油にてお使いください。
- *3. 穴深さは3Dタイプの場合は3D以下、5Dタイプの場合は5D以下、8Dタイプの場合は8D以下での使用を想定しています。
- *4. 被削材の性質やワーク形状などにより、切りくずが長く伸びる場合があります。
それにより、『穴径が拡大する』『壁面に傷がつく』『切りくず詰まりによる工具破損』
などの可能性がありますので、『送りを上げる』『ステップ加工』などを行い、切りくずを分断してください。
- *5. ロールタップ下穴用ストライクドリルを使用の場合は、通常の条件から80%落としてください。

Attention

- *1. Above cutting conditions are for drilling flat surface.
Please adjust cutting conditions according to machine rigidity, work clamping and shape of machining part.
- *2. Please use water soluble cutting oil with internal coolant.
- *3. We expect 3D type's depth of hole is less than 3D, 5D type is less than 5D, 8D type is less than 8D.
- *4. In case of long chips evacuated, adjust above conditions by increasing Feed speed or using step feed for breaking chips.
- *5. When using Forming Tap Strike Drill, reduce 80% of the above data.

| 被削材 Work materials | ステンレス鋼(SUS304)硬さ280HB以下 Stainless steel Below 280HB | | ねずみ铸铁(FC250)引張り強さ350MPa以下 Grey cast iron (GG25) Below 350MPa | | ダクタイル铸铁(FCD400)引張り強さ450MPa以下 Nodular cast iron (GGG40) Below 450MPa | |
|-------------------------------------|---|-----------------------------------|---|-----------------------------------|---|-----------------------------------|
| 切削速度 Cutting speed Vc (m/min) | 40~ 80(φ3 ~φ 7) 60~100(φ7.1~φ16) | | 70~120(φ3 ~φ 7) 80~160(φ7.1~φ16) | | 40~ 80(φ3 ~φ 7) 50~100(φ7.1~φ16) | |
| 送り量 feed f (mm/rev) | 0.10~0.20(φ 3 ~φ 5) 0.12~0.23(φ 5.1~φ 7) 0.15~0.28(φ 7.1~φ12) 0.18~0.30(φ12.1~φ16) | | 0.12~0.20(φ 3 ~φ 5) 0.15~0.25(φ 5.1~φ 7) 0.18~0.32(φ 7.1~φ12) 0.20~0.35(φ12.1~φ16) | | 0.10~0.20(φ 3 ~φ 5) 0.12~0.23(φ 5.1~φ 7) 0.15~0.30(φ 7.1~φ12) 0.20~0.33(φ12.1~φ16) | |
| ドリル直径 Drill dia. (mm) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) |
| 3 | 6,370 | 760 | 10,080 | 1,620 | 6,370 | 960 |
| 4 | 4,780 | 720 | 7,560 | 1,210 | 4,780 | 720 |
| 5 | 3,820 | 650 | 6,050 | 1,090 | 3,820 | 640 |
| 6 | 3,190 | 560 | 5,040 | 1,010 | 3,450 | 610 |
| 7 | 2,960 | 550 | 4,550 | 1,010 | 3,190 | 600 |
| 8 | 2,790 | 520 | 4,380 | 990 | 2,990 | 600 |
| 9 | 2,480 | 490 | 3,900 | 900 | 2,660 | 540 |
| 10 | 2,230 | 470 | 3,510 | 830 | 2,390 | 540 |
| 11 | 2,030 | 470 | 3,190 | 770 | 2,180 | 500 |
| 12 | 1,990 | 460 | 3,060 | 770 | 1,990 | 470 |
| 13 | 1,960 | 460 | 2,940 | 770 | 1,960 | 470 |
| 14 | 1,820 | 430 | 2,730 | 730 | 1,820 | 440 |
| 15 | 1,700 | 410 | 2,660 | 720 | 1,700 | 450 |
| 16 | 1,600 | 390 | 2,590 | 720 | 1,600 | 430 |

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標準切削条件

● 面取り刃付き ストライクドリル 外部給油タイプ

| 被削材 Work materials | 構造用鋼(SS400)硬さ180HB以下 Steel for structure Below 180HB | | 炭素鋼(S50C)硬さ280HB以下 Carbon steel (C50) Below 280HB | | 合金鋼(SCM440)硬さ280~350HB Alloy steel (1.7223) 280~350HB | |
|-------------------------------------|--|-----------------------------------|--|-----------------------------------|--|-----------------------------------|
| 切削速度 Cutting speed Vc (m/min) | 40 ~ 80 (φ 3.4~φ10.3) | | 40 ~ 80 (φ 3.4~φ10.3) | | 30 ~ 70 (φ 3.4~φ10.3) | |
| 送り量 feed f (mm/rev) | 0.05~0.15(φ 3.4、φ 4.3) 0.08~0.18(φ 5.1、φ 6.8) 0.12~0.25(φ 8.5、φ10.3) | | 0.05~0.15(φ 3.4、φ 4.3) 0.08~0.18(φ 5.1、φ 6.8) 0.12~0.25(φ 8.5、φ10.3) | | 0.05~0.15(φ 3.4、φ 4.3) 0.06~0.18(φ 5.1、φ 6.8) 0.12~0.25(φ 8.5、φ10.3) | |
| ドリル直径 Drill dia. (mm) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) |
| 3.4 | 4,690 | 310 | 4,690 | 310 | 4,690 | 290 |
| 4.3 | 3,930 | 310 | 3,930 | 310 | 3,710 | 290 |
| 5.1 | 3,440 | 420 | 3,440 | 420 | 3,130 | 380 |
| 6.8 | 2,720 | 410 | 2,720 | 410 | 2,350 | 360 |
| 8.5 | 2,180 | 410 | 2,180 | 410 | 1,880 | 320 |
| 10.3 | 1,860 | 400 | 1,860 | 400 | 1,550 | 310 |

| 被削材 Work materials | プリハードン鋼(NAK80)硬さ38~43HRC Mold Steel (P21) 38~43HRC | | ねずみ铸铁(FC250)引張り強さ350MPa以下 Grey cast iron (GG25) Below 350MPa | | ダクタイル铸铁(FCD400)引張り強さ450MPa以下 Nodular cast iron (GGG40) Below 450MPa | |
|-------------------------------------|--|-----------------------------------|--|-----------------------------------|--|-----------------------------------|
| 切削速度 Cutting speed Vc (m/min) | 20 ~ 40(φ 3.4、φ 4.3) 20 ~ 50(φ 5.1、φ 6.8) 20 ~ 60(φ 8.5、φ10.3) | | 30 ~ 80(φ 3.4~φ 6.8) 40 ~ 100(φ 8.5、φ 10.3) | | 30 ~ 70 (φ 3.4~φ10.3) | |
| 送り量 feed f (mm/rev) | 0.05~0.15(φ 3.4、φ 4.3) 0.05~0.18(φ 5.1、φ 6.8) 0.08~0.23(φ 8.5、φ10.3) | | 0.08~0.18(φ 3.4、φ 4.3) 0.10~0.20(φ 5.1、φ 6.8) 0.12~0.25(φ 8.5、φ10.3) | | 0.05~0.15(φ 3.4、φ 4.3) 0.08~0.20(φ 5.1、φ 6.8) 0.12~0.25(φ 8.5、φ10.3) | |
| ドリル直径 Drill dia. (mm) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) |
| 3.4 | 2,810 | 170 | 4,690 | 400 | 4,690 | 300 |
| 4.3 | 2,230 | 170 | 4,080 | 400 | 3,710 | 300 |
| 5.1 | 2,190 | 270 | 3,750 | 480 | 3,130 | 400 |
| 6.8 | 1,640 | 250 | 3,050 | 480 | 2,350 | 370 |
| 8.5 | 1,500 | 250 | 2,630 | 480 | 1,880 | 330 |
| 10.3 | 1,240 | 230 | 2,170 | 480 | 1,550 | 310 |

使用上の注意事項

- *1. 本工具は穴あけと口元の面取り加工を一度に行う工具です。大径部にバックテーパは無いので、大径部まで使用した段穴あけ加工（段付き加工）はできません。
- *2. 面取り幅は適応ねじサイズM4~M6用はC1.0まで、M8~M12用はC1.5までの大きさを想定しています。
- *3. 面取り加工時、切りくずが長くなり加工に支障をきたす場合があります。その場合はインチング加工などで切りくずを分断させてください。
- *4. 面取り刃が食いつくタイミングで切削抵抗が増大し、皿穴面にビバリが発生する場合があります。その場合は上記表を参考に面取り加工時の送り量を下げてください。
穴の内壁にビバリが発生した場合は穴あけ加工時から送り量を下げた条件で加工してください。
- *5. 上記の標準切削条件は切れ刃先端部に水溶性切削油を外部給油にて十分な量を供給している場合を想定しています。
- *6. ステンレス加工の場合は内部給油タイプを選定してください。
外部給油での加工は工具欠損や切りくずが長くなり加工に支障をきたす恐れがあるため推奨していません。

標準切削条件

● 面取り刃付き ストライクドリル 内部給油タイプ

| 被削材 Work materials | 構造用鋼 (SS400) 硬さ180HB以下 Steel for structure Below 180HB | | 炭素鋼 (S50C) 硬さ280HB以下 Carbon steel (C50) Below 280HB | | 合金鋼 (SCM440) 硬さ280~350HB Alloy steel (1.7223) 280~350HB | | プリハードン鋼 (NAK80) 硬さ38~43HRC Mold Steel (P21) 38~43HRC | |
|-------------------------------------|---|-----------------------------------|---|-----------------------------------|---|-----------------------------------|---|-----------------------------------|
| 切削速度 Cutting speed Vc (m/min) | 40~80(φ3.4、φ4.3) 40~100(φ5.1、φ6.8) 40~120(φ8.5、φ10.3) | | 40~80(φ3.4、φ4.3) 40~100(φ5.1、φ6.8) 40~120(φ8.5、φ10.3) | | 30~80(φ3.4~φ6.8) 40~80(φ8.5、φ10.3) | | 20~60(φ3.4~φ10.3) | |
| 送り量 feed f (mm/rev) | 0.05~0.20(φ3.4、φ4.3) 0.10~0.25(φ5.1、φ6.8) 0.12~0.30(φ8.5、φ10.3) | | 0.05~0.20(φ3.4、φ4.3) 0.10~0.25(φ5.1、φ6.8) 0.12~0.30(φ8.5、φ10.3) | | 0.05~0.18(φ3.4、φ4.3) 0.10~0.23(φ5.1、φ6.8) 0.12~0.30(φ8.5、φ10.3) | | 0.05~0.15(φ3.4、φ4.3) 0.08~0.20(φ5.1、φ6.8) 0.12~0.25(φ8.5、φ10.3) | |
| ドリル直径 Drill dia. (mm) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) |
| 3.4 | 5,620 | 450 | 5,620 | 450 | 5,150 | 370 | 3,750 | 240 |
| 4.3 | 4,450 | 450 | 4,450 | 450 | 4,080 | 370 | 2,970 | 240 |
| 5.1 | 4,370 | 660 | 4,370 | 660 | 3,440 | 450 | 2,500 | 320 |
| 6.8 | 3,280 | 600 | 3,280 | 600 | 2,580 | 420 | 1,880 | 300 |
| 8.5 | 3,000 | 570 | 3,000 | 570 | 2,250 | 410 | 1,500 | 270 |
| 10.3 | 2,480 | 550 | 2,480 | 550 | 1,860 | 400 | 1,240 | 240 |

| 被削材 Work materials | ステンレス鋼 (SUS304) 硬さ280HB以下 Stainless steel Below 280HB | | ねずみ鉄 (FC250) 引張り強さ350MPa以下 Grey cast iron (GG25) Below 350MPa | | ダクタイル鉄 (FCD400) 引張り強さ450MPa以下 Nodular cast iron (GGG40) Below 450MPa | |
|-------------------------------------|---|-----------------------------------|---|-----------------------------------|---|-----------------------------------|
| 切削速度 Cutting speed Vc (m/min) | 20~60(φ3.4~φ10.3) | | 40~80(φ3.4、φ4.3) 40~100(φ5.1、φ6.8) 50~130(φ8.5、φ10.3) | | 30~80(φ3.4~φ6.8) 40~80(φ8.5、φ10.3) | |
| 送り量 feed f (mm/rev) | 0.05~0.18(φ3.4、φ4.3) 0.08~0.20(φ5.1、φ6.8) 0.12~0.25(φ8.5、φ10.3) | | 0.08~0.23(φ3.4、φ4.3) 0.12~0.25(φ5.1、φ6.8) 0.15~0.30(φ8.5、φ10.3) | | 0.05~0.18(φ3.4、φ4.3) 0.10~0.23(φ5.1、φ6.8) 0.12~0.30(φ8.5、φ10.3) | |
| ドリル直径 Drill dia. (mm) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) | 回転速度 Spindle speed n (min ⁻¹) | 送り速度 Feed speed Vf (mm/min) |
| 3.4 | 3,750 | 250 | 5,620 | 550 | 5,150 | 340 |
| 4.3 | 2,970 | 250 | 4,450 | 550 | 4,080 | 340 |
| 5.1 | 2,500 | 320 | 4,060 | 620 | 3,440 | 450 |
| 6.8 | 1,880 | 300 | 3,280 | 620 | 2,580 | 420 |
| 8.5 | 1,500 | 270 | 3,260 | 620 | 2,250 | 410 |
| 10.3 | 1,240 | 240 | 2,790 | 620 | 1,860 | 400 |

使用上の注意事項

- *1. 本工具は穴あけと口元の面取り加工を一度に行う工具です。大径部にバックテーパは無いので、大径部まで使用した段穴あけ加工（段付き加工）はできません。
- *2. 面取り幅は適応ねじサイズM4~M6用はC1.0まで、M8~M12用はC1.5までの大きさを想定しています。
- *3. 面取り加工時、切りくずが長くなり加工に支障をきたす場合があります。その場合はインチング加工などで切りくずを分断させてください。
- *4. 面取り刃が食いつくタイミングで切削抵抗が増大し、皿穴面にビビリが発生する場合があります。その場合は上記表を参考に面取り加工時の送り量を下げてください。穴の内壁にビビリが発生した場合は穴あけ加工時から送り量を下げた条件で加工してください。



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ご使用上の注意 工具を安全にご使用いただくために

- 不適切な切削条件で使用しないでください。●大きな摩耗や欠けのある工具は使用しないでください。
- 切りくずの飛散、巻き付きによるケガにご注意ください。又、保護眼鏡や安全カバーをご使用ください。

WARNING: *Grinding produces hazardous dust. *To avoid adverse health, use adequate ventilation and read Material Safety Data Sheet first.
 *Cutting tools may fragment in use. Wear eye protection in the vicinity of their operation.

●工具仕様は、改良のため予告なく変更することがあります。 **Specification shall be changed without notice.**

販売店