

VCHSM

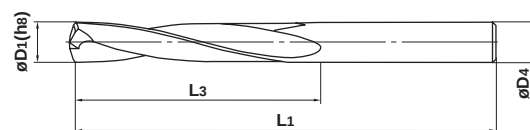
Medium, For hardened material



CARBIDE

Carbon Steel Alloy Steel	Hardened Steel	Stainless Steel	Cast Iron	Light Alloy	Heat Resistant Alloy
	◎				○

	D ₁ ≤ 3	3 < D ₁ ≤ 6	6 < D ₁ ≤ 10	10 < D ₁ ≤ 16
	$\begin{matrix} 0 \\ -0.014 \end{matrix}$	$\begin{matrix} 0 \\ -0.018 \end{matrix}$	$\begin{matrix} 0 \\ -0.022 \end{matrix}$	$\begin{matrix} 0 \\ -0.027 \end{matrix}$
	$\begin{matrix} 0 \\ -0.009 \end{matrix}$	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	$\begin{matrix} 0 \\ -0.015 \end{matrix}$	$\begin{matrix} 0 \\ -0.018 \end{matrix}$



● A suitable geometry for high hardness (60 HRC) material drilling.

Drill Dia. D ₁ (mm)	Hole Depth (l/d)	Coolant (Int./Ext.)	Stock VP15TF	Order Number	Dimensions (mm)		
					L ₃	L ₁	D ₄
2.5	3	Ext.	★	VCHSMD0250	20	55	2.5
2.6	3	Ext.	★	D0260	20	55	2.6
2.7	3	Ext.	★	D0270	20	55	2.7
2.8	3	Ext.	★	D0280	21	60	2.8
2.9	3	Ext.	★	D0290	21	60	2.9
3.0	3	Ext.	★	D0300	21	60	3
3.1	3	Ext.	★	D0310	24	60	3.1
3.2	3	Ext.	★	D0320	24	60	3.2
3.3	3	Ext.	★	D0330	24	60	3.3
3.4	3	Ext.	★	D0340	24	60	3.4
3.5	3	Ext.	★	D0350	24	60	3.5
3.6	3	Ext.	★	D0360	27	60	3.6
3.7	3	Ext.	★	D0370	27	60	3.7
3.8	3	Ext.	★	D0380	27	60	3.8
3.9	3	Ext.	★	D0390	27	60	3.9
4.0	3	Ext.	★	D0400	27	60	4
4.1	3	Ext.	★	D0410	29	63	4.1
4.2	3	Ext.	★	D0420	29	63	4.2
4.3	3	Ext.	★	D0430	29	63	4.3
4.4	3	Ext.	★	D0440	29	63	4.4
4.5	3	Ext.	★	D0450	29	63	4.5
4.6	3	Ext.	★	D0460	32	68	4.6
4.7	3	Ext.	★	D0470	32	68	4.7
4.8	3	Ext.	★	D0480	32	68	4.8
4.9	3	Ext.	★	D0490	32	68	4.9
5.0	3	Ext.	★	D0500	32	68	5
5.1	3	Ext.	★	D0510	34	72	5.1
5.2	3	Ext.	★	D0520	34	72	5.2
5.3	3	Ext.	★	D0530	34	72	5.3
5.4	3	Ext.	★	D0540	34	72	5.4

Drill Dia. D ₁ (mm)	Hole Depth (l/d)	Coolant (Int./Ext.)	Stock VP15TF	Order Number	Dimensions (mm)		
					L ₃	L ₁	D ₄
5.5	3	Ext.	★	VCHSMD0550	34	72	5.5
5.6	3	Ext.	★	D0560	36	74	5.6
5.7	3	Ext.	★	D0570	36	74	5.7
5.8	3	Ext.	★	D0580	36	74	5.8
5.9	3	Ext.	★	D0590	36	74	5.9
6.0	3	Ext.	★	D0600	41	81	6
6.5	3	Ext.	★	D0650	41	81	6.5
6.9	3	Ext.	★	D0690	43	83	6.9
7.0	3	Ext.	★	D0700	43	83	7
7.5	3	Ext.	★	D0750	45	87	7.5
8.0	3	Ext.	★	D0800	48	90	8
8.5	3	Ext.	★	D0850	53	96	8.5
8.6	3	Ext.	★	D0860	55	98	8.6
9.0	3	Ext.	★	D0900	55	98	9
9.5	3	Ext.	★	D0950	58	102	9.5
10.0	3	Ext.	★	D1000	60	105	10
10.4	3	Ext.	★	D1040	66	112	10.4
10.5	3	Ext.	★	D1050	66	112	10.5
11.0	3	Ext.	★	D1100	68	114	11
11.5	3	Ext.	★	D1150	71	118	11.5
12.0	3	Ext.	★	D1200	73	121	12
12.5	3	Ext.	★	D1250	76	135	12.5
13.0	3	Ext.	★	D1300	78	137	13
13.5	3	Ext.	★	D1350	84	144	13.5
14.0	3	Ext.	★	D1400	86	147	14
14.5	3	Ext.	★	D1450	89	151	14.5
15.0	3	Ext.	★	D1500	91	153	15
15.5	3	Ext.	★	D1550	94	157	15.5
16.0	3	Ext.	★	D1600	96	160	16

DRILLING

★ : Inventory maintained in Japan.

 CUTTING CONDITIONS > L114
 TECHNICAL DATA > N001