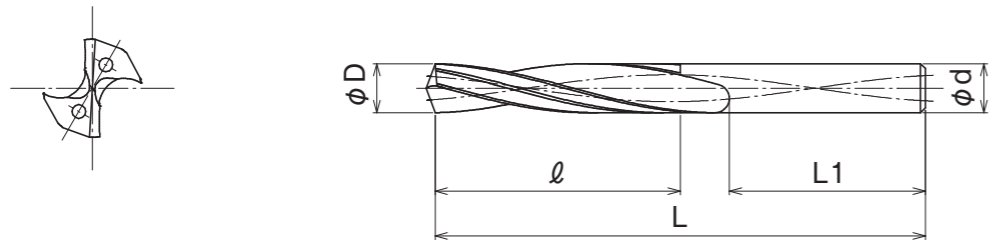


NEW **ヘキサゴンドリル** Hexagon Drill

**OHHD-0030 ▶ 0120-OH-DC**

超微粒子超硬 DCコート 右ネジレ 15° 先端角 140° 2枚刃 オイルホール 製品特長 P.14 切削条件 P.16



寸法単位 [mm] All dimensions specified in units of mm

型番 Model No.	ドリル径 Drill diameter φD	公差 Tolerance	全長 Overall length L	溝長 Flute length ℓ	シャンク長 Shank length L1	シャンク径 Shank diameter φd	シャンク公差 Shank tolerance h6	在庫 In stock
OHHD-0000-OH-DC								
OHHD-0030-OH-DC	3.0	+0.007 ~ +0.003	50	20	30	3.0	0 ~ -0.006	●
OHHD-0031-OH-DC	3.1	+0.008 ~ +0.004	50	20	30	4.0	0 ~ -0.008	□
OHHD-0032-OH-DC	3.2	+0.008 ~ +0.004	50	20	30	4.0	0 ~ -0.008	□
OHHD-0033-OH-DC	3.3	+0.008 ~ +0.004	50	20	30	4.0	0 ~ -0.008	□
OHHD-0034-OH-DC	3.4	+0.008 ~ +0.004	60	20	40	4.0	0 ~ -0.008	□
OHHD-0035-OH-DC	3.5	+0.008 ~ +0.004	60	20	40	4.0	0 ~ -0.008	●
OHHD-0036-OH-DC	3.6	+0.008 ~ +0.004	60	20	40	4.0	0 ~ -0.008	□
OHHD-0037-OH-DC	3.7	+0.008 ~ +0.004	60	20	40	4.0	0 ~ -0.008	□
OHHD-0038-OH-DC	3.8	+0.008 ~ +0.004	60	20	40	4.0	0 ~ -0.008	□
OHHD-0039-OH-DC	3.9	+0.008 ~ +0.004	60	20	40	4.0	0 ~ -0.008	□
OHHD-0040-OH-DC	4.0	+0.008 ~ +0.004	70	30	40	4.0	0 ~ -0.008	●
OHHD-0041-OH-DC	4.1	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0042-OH-DC	4.2	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0043-OH-DC	4.3	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0044-OH-DC	4.4	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0045-OH-DC	4.5	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	●
OHHD-0046-OH-DC	4.6	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0047-OH-DC	4.7	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0048-OH-DC	4.8	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0049-OH-DC	4.9	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0050-OH-DC	5.0	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	●
OHHD-0051-OH-DC	5.1	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0052-OH-DC	5.2	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□

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●: Standard stock item ○: Item stocked by particular distributors □: Made-to-order item  
Note: Stock items may be out of stock in some cases.

寸法単位 [mm] All dimensions specified in units of mm

型番 Model No.	ドリル径 Drill diameter φD	公差 Tolerance	全長 Overall length L	溝長 Flute length ℓ	シャンク長 Shank length L1	シャンク径 Shank diameter φd	シャンク公差 Shank tolerance h6	在庫 In stock
OHHD-0000-OH-DC								
OHHD-0053-OH-DC	5.3	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0054-OH-DC	5.4	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0055-OH-DC	5.5	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	●
OHHD-0056-OH-DC	5.6	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0057-OH-DC	5.7	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0058-OH-DC	5.8	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0059-OH-DC	5.9	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0060-OH-DC	6.0	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	●
OHHD-0061-OH-DC	6.1	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0062-OH-DC	6.2	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0063-OH-DC	6.3	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0064-OH-DC	6.4	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0065-OH-DC	6.5	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	●
OHHD-0066-OH-DC	6.6	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0067-OH-DC	6.7	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0068-OH-DC	6.8	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0069-OH-DC	6.9	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0070-OH-DC	7.0	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	●
OHHD-0071-OH-DC	7.1	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0072-OH-DC	7.2	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0073-OH-DC	7.3	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0074-OH-DC	7.4	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0075-OH-DC	7.5	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	●
OHHD-0076-OH-DC	7.6	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0077-OH-DC	7.7	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0078-OH-DC	7.8	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0079-OH-DC	7.9	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0080-OH-DC	8.0	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	●
OHHD-0081-OH-DC	8.1	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0082-OH-DC	8.2	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0083-OH-DC	8.3	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0084-OH-DC	8.4	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0085-OH-DC	8.5	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	●
OHHD-0086-OH-DC	8.6	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□

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寸法単位 [mm]  
All dimensions specified in units of mm

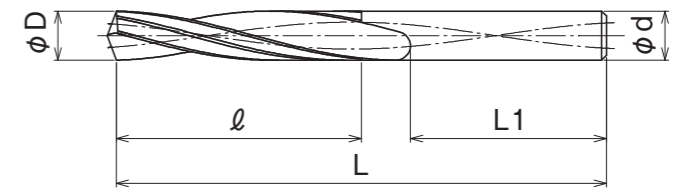
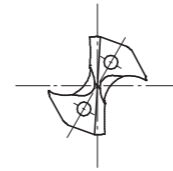
型番 Model No.	ドリル径 Drill diameter φD	公差 Tolerance	全長 Overall length L	溝長 Flute length ℓ	シャンク長 Shank length L1	シャンク径 Shank diameter φd	シャンク公差 Shank tolerance h6	在庫 In stock
OHHD-0000-OH-DC								
OHHD-0087-OH-DC	8.7	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0088-OH-DC	8.8	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0089-OH-DC	8.9	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0090-OH-DC	9.0	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	●
OHHD-0091-OH-DC	9.1	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0092-OH-DC	9.2	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0093-OH-DC	9.3	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0094-OH-DC	9.4	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0095-OH-DC	9.5	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	●
OHHD-0096-OH-DC	9.6	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0097-OH-DC	9.7	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0098-OH-DC	9.8	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0099-OH-DC	9.9	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0100-OH-DC	10.0	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	●
OHHD-0101-OH-DC	10.1	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0102-OH-DC	10.2	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0103-OH-DC	10.3	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0104-OH-DC	10.4	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0105-OH-DC	10.5	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	●
OHHD-0106-OH-DC	10.6	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0107-OH-DC	10.7	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0108-OH-DC	10.8	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0109-OH-DC	10.9	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0110-OH-DC	11.0	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	●
OHHD-0111-OH-DC	11.1	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0112-OH-DC	11.2	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0113-OH-DC	11.3	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0114-OH-DC	11.4	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0115-OH-DC	11.5	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	●
OHHD-0116-OH-DC	11.6	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0117-OH-DC	11.7	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0118-OH-DC	11.8	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0119-OH-DC	11.9	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0120-OH-DC	12.0	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	●

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NEW ヘキサゴンドリル Hexagon Drill

OHHD-0030 ▶ 0120-OH

超微粒子 超硬 右ネジ 15° 先端角 140° 2枚刃 オイルホール 製品特長 P.14 切削条件 P.16  
Product features Machining conditions



寸法単位 [mm]  
All dimensions specified in units of mm

型番 Model No.	ドリル径 Drill diameter φD	公差 Tolerance	全長 Overall length L	溝長 Flute length ℓ	シャンク長 Shank length L1	シャンク径 Shank diameter φd	シャンク公差 Shank tolerance h6	在庫 In stock
OHHD-0000-OH								
OHHD-0030-OH	3.0	+0.007 ~ +0.003	50	20	30	3.0	0 ~ -0.006	●
OHHD-0031-OH	3.1	+0.008 ~ +0.004	50	20	30	4.0	0 ~ -0.008	□
OHHD-0032-OH	3.2	+0.008 ~ +0.004	50	20	30	4.0	0 ~ -0.008	□
OHHD-0033-OH	3.3	+0.008 ~ +0.004	50	20	30	4.0	0 ~ -0.008	□
OHHD-0034-OH	3.4	+0.008 ~ +0.004	60	20	40	4.0	0 ~ -0.008	□
OHHD-0035-OH	3.5	+0.008 ~ +0.004	60	20	40	4.0	0 ~ -0.008	●
OHHD-0036-OH	3.6	+0.008 ~ +0.004	60	20	40	4.0	0 ~ -0.008	□
OHHD-0037-OH	3.7	+0.008 ~ +0.004	60	20	40	4.0	0 ~ -0.008	□
OHHD-0038-OH	3.8	+0.008 ~ +0.004	60	20	40	4.0	0 ~ -0.008	□
OHHD-0039-OH	3.9	+0.008 ~ +0.004	60	20	40	4.0	0 ~ -0.008	□
OHHD-0040-OH	4.0	+0.008 ~ +0.004	70	30	40	4.0	0 ~ -0.008	●
OHHD-0041-OH	4.1	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0042-OH	4.2	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0043-OH	4.3	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0044-OH	4.4	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0045-OH	4.5	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	●
OHHD-0046-OH	4.6	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0047-OH	4.7	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0048-OH	4.8	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0049-OH	4.9	+0.008 ~ +0.004	70	30	40	6.0	0 ~ -0.008	□
OHHD-0050-OH	5.0	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	●
OHHD-0051-OH	5.1	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0052-OH	5.2	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□

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非鉄 [N] Tools for non-ferrous metals  
 鋳鉄 [K] Tools for cast iron  
 炭素鋼 [P] Tools for carbon steels  
 高硬度鋼 [H] Tools for hard steels  
 ステンレス [M] Tools for stainless steels  
 耐熱合金 [S] Tools for heat-resistant alloys

非鉄 [N] Tools for non-ferrous metals  
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 耐熱合金 [S] Tools for heat-resistant alloys

寸法単位 [mm]

All dimensions specified in units of mm

型番 Model No.	ドリル径 Drill diameter φD	公差 Tolerance	全長 Overall length L	溝長 Flute length ℓ	シャンク長 Shank length L1	シャンク径 Shank diameter φd	シャンク公差 Shank tolerance h6	在庫 In stock
OHHD-0000-OH								
OHHD-0053-OH	5.3	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0054-OH	5.4	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0055-OH	5.5	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	●
OHHD-0056-OH	5.6	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0057-OH	5.7	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0058-OH	5.8	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0059-OH	5.9	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	□
OHHD-0060-OH	6.0	+0.008 ~ +0.004	80	40	40	6.0	0 ~ -0.008	●
OHHD-0061-OH	6.1	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0062-OH	6.2	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0063-OH	6.3	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0064-OH	6.4	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0065-OH	6.5	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	●
OHHD-0066-OH	6.6	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0067-OH	6.7	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0068-OH	6.8	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0069-OH	6.9	+0.010 ~ +0.006	80	40	40	8.0	0 ~ -0.009	□
OHHD-0070-OH	7.0	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	●
OHHD-0071-OH	7.1	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0072-OH	7.2	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0073-OH	7.3	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0074-OH	7.4	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0075-OH	7.5	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	●
OHHD-0076-OH	7.6	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0077-OH	7.7	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0078-OH	7.8	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0079-OH	7.9	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	□
OHHD-0080-OH	8.0	+0.010 ~ +0.006	90	50	40	8.0	0 ~ -0.009	●
OHHD-0081-OH	8.1	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0082-OH	8.2	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0083-OH	8.3	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0084-OH	8.4	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0085-OH	8.5	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	●
OHHD-0086-OH	8.6	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□

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寸法単位 [mm]

All dimensions specified in units of mm

型番 Model No.	ドリル径 Drill diameter φD	公差 Tolerance	全長 Overall length L	溝長 Flute length ℓ	シャンク長 Shank length L1	シャンク径 Shank diameter φd	シャンク公差 Shank tolerance h6	在庫 In stock
OHHD-0000-OH								
OHHD-0087-OH	8.7	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0088-OH	8.8	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0089-OH	8.9	+0.010 ~ +0.006	90	50	40	10.0	0 ~ -0.009	□
OHHD-0090-OH	9.0	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	●
OHHD-0091-OH	9.1	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0092-OH	9.2	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0093-OH	9.3	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0094-OH	9.4	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0095-OH	9.5	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	●
OHHD-0096-OH	9.6	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0097-OH	9.7	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0098-OH	9.8	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0099-OH	9.9	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	□
OHHD-0100-OH	10.0	+0.010 ~ +0.006	100	60	40	10.0	0 ~ -0.009	●
OHHD-0101-OH	10.1	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0102-OH	10.2	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0103-OH	10.3	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0104-OH	10.4	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0105-OH	10.5	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	●
OHHD-0106-OH	10.6	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0107-OH	10.7	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0108-OH	10.8	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0109-OH	10.9	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	□
OHHD-0110-OH	11.0	+0.011 ~ +0.007	110	70	40	12.0	0 ~ -0.011	●
OHHD-0111-OH	11.1	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0112-OH	11.2	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0113-OH	11.3	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0114-OH	11.4	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0115-OH	11.5	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	●
OHHD-0116-OH	11.6	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0117-OH	11.7	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0118-OH	11.8	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0119-OH	11.9	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	□
OHHD-0120-OH	12.0	+0.011 ~ +0.007	120	70	50	12.0	0 ~ -0.011	●

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# 切削条件表 Drill selection table

## ドリル Drills

### ヘキサゴンドリル Hexagon Drill OHHD-OH-DC

被削材 Material	純アルミニウム Pure Aluminum A1017	アルミニウム合金 Aluminum Alloy Si, Mg-Si系 A4032 A6061	アルミニウム合金 Aluminum Alloy Mg系 A5052	アルミニウム合金 Aluminum Alloy Zn-Mg系 A7075	アルミニウム合金鋳物 Aluminum Alloy Casting AC ADC	銅合金 Copper Alloy C1100
切削速度: Vc Cutting Speed [m/min]	140	140	170	170	176	120
ドリル径 Drill Diameter [mm]	n: 22,300, Vf: 1,350, fr: 0.061	n: 22,300, Vf: 1,350, fr: 0.061	n: 27,000, Vf: 1,800, fr: 0.067	n: 27,000, Vf: 1,800, fr: 0.067	n: 28,000, Vf: 1,850, fr: 0.066	n: 19,000, Vf: 950, fr: 0.050
2	22,300, 1,350, 0.061	22,300, 1,350, 0.061	27,000, 1,800, 0.067	27,000, 1,800, 0.067	28,000, 1,850, 0.066	19,000, 950, 0.050
3	14,900, 1,350, 0.091	14,900, 1,350, 0.091	18,000, 1,800, 0.100	18,000, 1,800, 0.100	18,600, 1,850, 0.099	12,500, 950, 0.076
4	11,200, 1,350, 0.121	11,200, 1,350, 0.121	13,500, 1,800, 0.133	13,500, 1,800, 0.133	14,000, 1,850, 0.132	9,500, 950, 0.100
5	8,900, 1,350, 0.152	8,900, 1,350, 0.152	10,800, 1,800, 0.167	10,800, 1,800, 0.167	11,200, 1,850, 0.165	7,500, 950, 0.127
6	7,500, 1,350, 0.180	7,500, 1,350, 0.180	9,000, 1,800, 0.200	9,000, 1,800, 0.200	9,300, 1,850, 0.199	6,300, 950, 0.151
8	5,600, 1,350, 0.241	5,600, 1,350, 0.241	6,800, 1,800, 0.265	6,800, 1,800, 0.265	7,000, 1,850, 0.264	4,700, 950, 0.202
10	4,500, 1,350, 0.300	4,500, 1,350, 0.300	5,400, 1,800, 0.333	5,400, 1,800, 0.333	5,600, 1,850, 0.330	3,800, 950, 0.250
12	3,700, 1,350, 0.365	3,700, 1,350, 0.365	4,500, 1,800, 0.400	4,500, 1,800, 0.400	4,700, 1,850, 0.394	3,200, 950, 0.297

### ヘキサゴンドリル Hexagon Drill OHHD-OH

被削材 Material	純アルミニウム Pure Aluminum A1017	アルミニウム合金 Aluminum Alloy Si, Mg-Si系 A4032 A6061	アルミニウム合金 Aluminum Alloy Mg系 A5052	アルミニウム合金 Aluminum Alloy Zn-Mg系 A7075	アルミニウム合金鋳物 Aluminum Alloy Casting AC ADC	銅合金 Copper Alloy C1100
切削速度: Vc Cutting Speed [m/min]	112	112	135	135	140	95
ドリル径 Drill Diameter [mm]	n: 17,840, Vf: 756, fr: 0.042	n: 17,840, Vf: 756, fr: 0.042	n: 21,600, Vf: 1,008, fr: 0.047	n: 21,600, Vf: 1,008, fr: 0.047	n: 22,400, Vf: 1,036, fr: 0.046	n: 15,200, Vf: 532, fr: 0.035
2	17,840, 756, 0.042	17,840, 756, 0.042	21,600, 1,008, 0.047	21,600, 1,008, 0.047	22,400, 1,036, 0.046	15,200, 532, 0.035
3	11,920, 756, 0.063	11,920, 756, 0.063	14,400, 1,008, 0.070	14,400, 1,008, 0.070	14,880, 1,036, 0.070	10,000, 532, 0.053
4	8,960, 756, 0.084	8,960, 756, 0.084	10,800, 1,008, 0.093	10,800, 1,008, 0.093	11,200, 1,036, 0.093	7,600, 532, 0.070
5	7,120, 756, 0.106	7,120, 756, 0.106	8,640, 1,008, 0.117	8,640, 1,008, 0.117	8,960, 1,036, 0.116	6,000, 532, 0.089
6	6,000, 756, 0.126	6,000, 756, 0.126	7,200, 1,008, 0.140	7,200, 1,008, 0.140	7,440, 1,036, 0.139	5,040, 532, 0.106
8	4,480, 756, 0.169	4,480, 756, 0.169	5,440, 1,008, 0.185	5,440, 1,008, 0.185	5,600, 1,036, 0.185	3,760, 532, 0.141
10	3,600, 756, 0.210	3,600, 756, 0.210	4,320, 1,008, 0.233	4,320, 1,008, 0.233	4,480, 1,036, 0.231	3,040, 532, 0.175
12	2,960, 756, 0.255	2,960, 756, 0.255	3,600, 1,008, 0.280	3,600, 1,008, 0.280	3,760, 1,036, 0.276	2,560, 532, 0.208

### 超硬 Vドリル Tungsten Carbide V Drill OVDS, OVDSJ, OVDL, OVDLJ

被削材 Material	アルミニウム合金鋳物 Aluminum Alloy Casting ~13wt%Si·AC1~8·ADC	アルミニウム合金鋳物 Aluminum Alloy Casting 13~20wt%Si·AC9B	アルミニウム合金展伸材 Aluminum Alloy Expanded Material A7075·A2024	銅合金 Copper Alloy	铸铁 Cast Iron FC250~350	ダクタイル铸铁 Ductile Cast Iron FCD400~500
切削速度: Vc Cutting Speed [m/min]	20-35	12-30	20-35	20-35	10-25	6-10
ドリル径 Drill Diameter [mm]	n: 6,370, Vf: 191, fr: 0.030	n: 3,820, Vf: 114, fr: 0.030	n: 6,370, Vf: 191, fr: 0.030	n: 6,370, Vf: 191, fr: 0.030	n: 3,190, Vf: 95, fr: 0.030	n: 1,910, Vf: 57, fr: 0.030
1.0	6,370, 191, 0.030	3,820, 114, 0.030	6,370, 191, 0.030	6,370, 191, 0.030	3,190, 95, 0.030	1,910, 57, 0.030
2.0	3,980, 119, 0.030	2,390, 71, 0.030	3,980, 119, 0.030	3,980, 119, 0.030	1,590, 47, 0.030	1,270, 38, 0.030
3.0	5,300, 159, 0.030	3,190, 95, 0.030	5,300, 159, 0.030	5,300, 159, 0.030	2,120, 63, 0.030	1,590, 47, 0.030
4.0	3,980, 159, 0.040	2,390, 95, 0.040	3,980, 159, 0.040	3,980, 159, 0.040	1,590, 63, 0.040	1,190, 47, 0.040
5.0	3,190, 159, 0.050	1,910, 95, 0.050	3,190, 159, 0.050	3,190, 159, 0.050	1,270, 63, 0.050	960, 48, 0.050
6.0	2,650, 159, 0.060	1,590, 95, 0.060	2,650, 159, 0.060	2,650, 159, 0.060	1,060, 63, 0.060	800, 48, 0.060
7.0	2,280, 136, 0.060	1,370, 82, 0.060	2,280, 136, 0.060	2,280, 136, 0.060	910, 54, 0.060	680, 40, 0.060
8.0	1,990, 119, 0.060	1,190, 71, 0.060	1,990, 119, 0.060	1,990, 119, 0.060	800, 48, 0.060	600, 36, 0.060
9.0	1,770, 106, 0.060	1,060, 63, 0.060	1,770, 106, 0.060	1,770, 106, 0.060	710, 42, 0.060	530, 31, 0.060
10.0	1,590, 95, 0.060	960, 57, 0.060	1,590, 95, 0.060	1,590, 95, 0.060	640, 38, 0.060	480, 28, 0.060
11.0	1,450, 87, 0.060	870, 52, 0.060	1,450, 87, 0.060	1,450, 87, 0.060	580, 34, 0.060	430, 25, 0.060
12.0	1,330, 79, 0.060	800, 48, 0.060	1,330, 79, 0.060	1,330, 79, 0.060	530, 31, 0.060	400, 24, 0.060
14.0	1,140, 68, 0.060	680, 40, 0.060	1,140, 68, 0.060	1,140, 68, 0.060	460, 27, 0.060	340, 20, 0.060
16.0	1,000, 60, 0.060	600, 48, 0.060	1,000, 60, 0.060	1,000, 60, 0.060	400, 32, 0.060	300, 24, 0.060
18.0	890, 71, 0.080	530, 42, 0.080	890, 71, 0.080	890, 71, 0.080	350, 28, 0.080	270, 21, 0.080
20.0	800, 64, 0.080	480, 38, 0.080	800, 64, 0.080	800, 64, 0.080	320, 25, 0.080	240, 19, 0.080

非鉄 [N] Tools for non-ferrous metals

鋳鉄 [K] Tools for cast iron

炭素鋼 [P] Tools for carbon steels

高硬度鋼 [H] Tools for hard steels

ステンレス [M] Tools for stainless steels

耐熱合金 [S] Tools for heat-resistant alloys

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