DMP, DMC, DMF ヘッドに AH9130 材種と径拡充
ドリルヘッド

DMP 汎用ヘッド

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a20 - ø25.9 = -1 ケース1個入り

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a6 - ø19.9 = 1 ケース2個入り
a20 - ø25.9 = 1 ケース1個入り

*: 第一選択

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# DMP 汎用ヘッド

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※：第一選択

形状 DC LPR PL ボディ

- P：鋼
- M：ステンレス
- K：鉄
- N：非鉄金属
- S：耐熱合金
- H：高硬度材

ø6 - ø19.9 =1 ø20 - ø25.9 =1

- ●：設定アイテム

差し替え
### DMC 高精度加工ヘッド

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### 工具径
- ヘッド径寸法:
  - ø4 - ø17.9: ±0.018 / 0
  - ø18 - ø25.9: ±0.021 / 0

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### DMC 高精度加工ヘッド

![Image of DMC Drill Heads]

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**工具径**

| ヘッド径公差 | a4 - a17.9 | +0.018 / 0 | a18 - a25.9 | +0.021 / 0 |

*☆: 第一選択  ‖: 第二選択

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新製品
設定アイテム

*4 - *19.9 = 1ケース2個入り
*20 - *25.9 = 1ケース1個入り
DMF 座縫り穴加工用ヘッド

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a6 - ø19.9 =1 ケース2個入り
a20 - ø25.9 =1 ケース1個入り

工具径       ヘッド径公差
ø6 - ø17.9  +0.018 / 0
ø18 - ø25.9  +0.021 / 0

新製品

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<td>21.8</td>
<td>9.54</td>
<td>0.7</td>
<td>1.79</td>
<td>6.92</td>
<td>TID*210...</td>
</tr>
<tr>
<td>DMF220</td>
<td>22</td>
<td>9.86</td>
<td>0.7</td>
<td>1.81</td>
<td>7.13</td>
<td>TID*220...</td>
</tr>
<tr>
<td>DMF225</td>
<td>22.5</td>
<td>9.86</td>
<td>0.7</td>
<td>1.81</td>
<td>7.13</td>
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</tr>
<tr>
<td>DMF230</td>
<td>23</td>
<td>10.28</td>
<td>0.7</td>
<td>1.83</td>
<td>7.42</td>
<td>TID*230...</td>
</tr>
<tr>
<td>DMF235</td>
<td>23.5</td>
<td>10.28</td>
<td>0.7</td>
<td>1.83</td>
<td>7.42</td>
<td>TID*230...</td>
</tr>
<tr>
<td>DMF240</td>
<td>24</td>
<td>10.71</td>
<td>0.7</td>
<td>1.86</td>
<td>7.45</td>
<td>TID*240...</td>
</tr>
<tr>
<td>DMF245</td>
<td>24.5</td>
<td>10.71</td>
<td>0.7</td>
<td>1.86</td>
<td>7.45</td>
<td>TID*240...</td>
</tr>
<tr>
<td>DMF250</td>
<td>25</td>
<td>11.15</td>
<td>0.7</td>
<td>1.9</td>
<td>7.54</td>
<td>TID*250...</td>
</tr>
<tr>
<td>DMF254</td>
<td>25.4</td>
<td>11.15</td>
<td>0.7</td>
<td>1.9</td>
<td>7.54</td>
<td>TID*250...</td>
</tr>
<tr>
<td>DMF255</td>
<td>25.5</td>
<td>11.15</td>
<td>0.7</td>
<td>1.9</td>
<td>7.54</td>
<td>TID*250...</td>
</tr>
<tr>
<td>DMF259</td>
<td>25.9</td>
<td>11.15</td>
<td>0.7</td>
<td>1.9</td>
<td>7.54</td>
<td>TID*250...</td>
</tr>
</tbody>
</table>

a6 - ø19.9 =1ケース2個入り
a20 - ø25.9 =1ケース1個入り
●：設定アイテム
☆：第一選択
★：第二選択
道具メイスターデリル

### 材種

ドリル加工に最適化された新コーティング材種により長寿命を実現

**AH9130**

- 3種類の機能を持つNano積層膜を融合した「トリプルNanoテクノロジー」コーティングを採用
- 「耐摩耗性」「耐欠損性」「耐酸化性」「耐溶着性」「耐皮膜剥離性」を高次元で共存

### 母材

耐摩耗性と耐欠損性のバランスに優れる超硬母材

### 耐溶着層

耐溶着性の高い被膜を採用

### 耐摩耗・耐酸化・耐欠損層

耐摩耗性被膜と耐酸化性被膜の2種を積層

### 密着層

超硬母材との密着性に優れる被膜を採用し、母材からの被膜剝離を抑制

### 標準切削条件

**ISO 被削材**

<table>
<thead>
<tr>
<th>被削材</th>
<th>切削速度 Vc (m/min)</th>
<th>送り f (mm/rev)</th>
</tr>
</thead>
<tbody>
<tr>
<td>低炭素鋼（C &lt; 0.3） SS400, SM490, S25Cなど</td>
<td>80 - 140</td>
<td>0.04 - 0.07 0.04 - 0.08 0.07 - 0.13 0.09 - 0.13 0.12 - 0.25 0.15 - 0.28 0.18 - 0.3 0.20 - 0.35 0.25 - 0.45 0.25 - 0.45</td>
</tr>
<tr>
<td>炭素鋼（C &lt; 0.3） S45C, S55Cなど</td>
<td>70 - 120</td>
<td>0.04 - 0.07 0.04 - 0.08 0.07 - 0.13 0.09 - 0.13 0.12 - 0.25 0.15 - 0.28 0.18 - 0.3 0.20 - 0.35 0.25 - 0.45 0.25 - 0.45</td>
</tr>
<tr>
<td>低合金鋼 SCM150など</td>
<td>70 - 120</td>
<td>0.04 - 0.07 0.05 - 0.08 0.07 - 0.13 0.08 - 0.13 0.11 - 0.25 0.14 - 0.28 0.16 - 0.32 0.18 - 0.35 0.23 - 0.4 0.25 - 0.45</td>
</tr>
<tr>
<td>合金鋼 SCM440, SG420など</td>
<td>40 - 90</td>
<td>0.04 - 0.07 0.05 - 0.08 0.07 - 0.13 0.08 - 0.13 0.11 - 0.25 0.14 - 0.28 0.16 - 0.32 0.18 - 0.35 0.23 - 0.4 0.25 - 0.45</td>
</tr>
<tr>
<td>ステンレス鋼 SUS304, SUS316など</td>
<td>30 - 70</td>
<td>- - 0.04 - 0.08 0.08 - 0.1 0.1 - 0.15 0.12 - 0.18 0.14 - 0.2 0.16 - 0.24 0.18 - 0.26 0.18 - 0.3</td>
</tr>
<tr>
<td>普通鋼製 FC250など</td>
<td>80 - 180</td>
<td>0.04 - 0.08 0.04 - 0.08 0.1 - 0.15 0.12 - 0.18 0.15 - 0.3 0.20 - 0.35 0.25 - 0.4 0.3 - 0.45 0.35 - 0.55 0.35 - 0.6</td>
</tr>
<tr>
<td>ダクタイル鉄製 FC0700など</td>
<td>80 - 140</td>
<td>0.04 - 0.08 0.04 - 0.08 0.1 - 0.15 0.12 - 0.18 0.15 - 0.3 0.20 - 0.35 0.25 - 0.4 0.3 - 0.45 0.35 - 0.55 0.35 - 0.6</td>
</tr>
<tr>
<td>アルミニウム合金 ADC12など</td>
<td>80 - 220</td>
<td>- - - 0.1 - 0.2 0.2 - 0.35 0.25 - 0.4 0.3 - 0.45 0.35 - 0.5 0.4 - 0.6 0.5 - 0.75</td>
</tr>
<tr>
<td>チタン合金 Ti6Al-4Vなど</td>
<td>20 - 50</td>
<td>- - - 0.05 - 0.07 0.06 - 0.12 0.08 - 0.15 0.1 - 0.28 0.12 - 0.2 0.14 - 0.22 0.18 - 0.27</td>
</tr>
<tr>
<td>焼入れ鋼</td>
<td>20 - 50</td>
<td>- - - 0.05 - 0.07 0.06 - 0.12 0.08 - 0.15 0.1 - 0.18 0.12 - 0.2 0.14 - 0.22 0.16 - 0.25</td>
</tr>
</tbody>
</table>

- 上記切削条件は一般的な加工条件の目安です
- 使用機械の馬力や特性および被削材によって変更する必要があります
- 機械剛性や切削条件などにより穴径は変動することがあります
安全上の注意点

ご使用の際には、安全カバーや保護メガネ等の保護具をご使用ください。
切れ刃が銳利なため手をできやしないでください。
切れ刃を確認してから工具を交換を行ってください。
切断中に発生する火花や破損による火災、切りくずで引火する危険があります。引火の危険があるところでは使用しないでください。
また、不溶性切削油を使用する場合は防火対策が必要です。

製品の問い合わせは

製品 動画 はこちら

tungaloy.com.jp
タンガロイ公式アカウント
facebook.com/tungaloyjapan
twitter.com/tungaloyjapan

友だち追加はこちらから。
または@tungaloy_officialでID検索してください。

資源保護のため再生紙を使用しています。 Jun. 2022 (TJ)