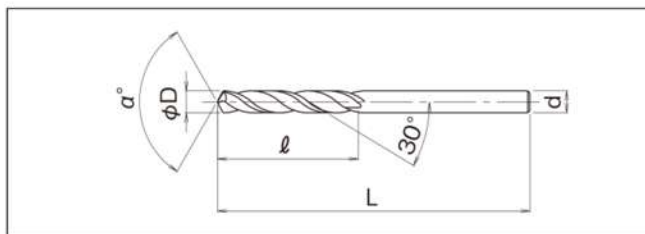


標準ソリッドドリル 〈ストレートシャンク〉

Solid Drill Standard, Straight Shank

ADS



- 鋼材・非鉄、樹脂にいたるまで幅広い対応が可能な高品位汎用ドリルです。
High quality general purpose drill applicable for steels, non-ferrous materials and for plastics.
- 高速切削はもちろん、低速切削でも高性能が得られる万能タイプです。
An excellent cutting performance is obtained at comparatively low speed.

刃径公差：φD Tolerance
φD0.1とび +0~-0.01
φD0.01とび+0~-0.005

φD≥2.1

超硬 CARBIDE 118° 135° ネジレ 30° D=d

単位 Unit : mm

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0030	0.3	4	30	
ADS-0031	0.31	4	30	
ADS-0032	0.32	4	30	
ADS-0033	0.33	4	30	
ADS-0034	0.34	4	30	
ADS-0035	0.35	4	30	
ADS-0036	0.36	4	30	
ADS-0037	0.37	4	30	
ADS-0038	0.38	4	30	
ADS-0039	0.39	4	30	
ADS-0040	0.4	5	30	
ADS-0041	0.41	5	30	
ADS-0042	0.42	5	30	
ADS-0043	0.43	5	30	
ADS-0044	0.44	5	30	
ADS-0045	0.45	5	30	
ADS-0046	0.46	5	30	
ADS-0047	0.47	5	30	
ADS-0048	0.48	5	30	
ADS-0049	0.49	5	30	
ADS-0050	0.5	6	30	
ADS-0051	0.51	6	30	
ADS-0052	0.52	6	30	
ADS-0053	0.53	6	30	
ADS-0054	0.54	6	30	
ADS-0055	0.55	6	30	

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0056	0.56	6	30	
ADS-0057	0.57	6	30	
ADS-0058	0.58	6	30	
ADS-0059	0.59	6	30	
ADS-0060	0.6	6	30	
ADS-0061	0.61	6	30	
ADS-0062	0.62	6	30	
ADS-0063	0.63	6	30	
ADS-0064	0.64	6	30	
ADS-0065	0.65	6	30	
ADS-0066	0.66	6	30	
ADS-0067	0.67	6	30	
ADS-0068	0.68	6	30	
ADS-0069	0.69	6	30	
ADS-0070	0.7	12	40	
ADS-0071	0.71	12	40	
ADS-0072	0.72	12	40	
ADS-0073	0.73	12	40	
ADS-0074	0.74	12	40	
ADS-0075	0.75	12	40	
ADS-0076	0.76	12	40	
ADS-0077	0.77	12	40	
ADS-0078	0.78	12	40	
ADS-0079	0.79	12	40	
ADS-0080	0.8	12	40	
ADS-0081	0.81	12	40	

ストレートシャンクドリル

単位 Unit : mm

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0082	0.82	12	40	
ADS-0083	0.83	12	40	
ADS-0084	0.84	12	40	
ADS-0085	0.85	12	40	
ADS-0086	0.86	12	40	
ADS-0087	0.87	12	40	
ADS-0088	0.88	12	40	
ADS-0089	0.89	12	40	
ADS-0090	0.9	12	40	
ADS-0091	0.91	12	40	
ADS-0092	0.92	12	40	
ADS-0093	0.93	12	40	
ADS-0094	0.94	12	40	
ADS-0095	0.95	12	40	
ADS-0096	0.96	12	40	
ADS-0097	0.97	12	40	
ADS-0098	0.98	12	40	
ADS-0099	0.99	12	40	
ADS-0100	1	15	40	
ADS-0101	1.01	15	40	
ADS-0102	1.02	15	40	
ADS-0103	1.03	15	40	
ADS-0104	1.04	15	40	
ADS-0105	1.05	15	40	
ADS-0106	1.06	15	40	
ADS-0107	1.07	15	40	
ADS-0108	1.08	15	40	
ADS-0109	1.09	15	40	
ADS-0110	1.1	15	40	
ADS-0111	1.11	15	40	
ADS-0112	1.12	15	40	
ADS-0113	1.13	15	40	
ADS-0114	1.14	15	40	
ADS-0115	1.15	15	40	
ADS-0116	1.16	15	40	
ADS-0117	1.17	15	40	
ADS-0118	1.18	15	40	
ADS-0119	1.19	15	40	
ADS-0120	1.2	15	40	
ADS-0121	1.21	15	40	
ADS-0122	1.22	15	40	
ADS-0123	1.23	15	40	
ADS-0124	1.24	15	40	
ADS-0125	1.25	15	40	

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0126	1.26	15	40	
ADS-0127	1.27	15	40	
ADS-0128	1.28	15	40	
ADS-0129	1.29	15	40	
ADS-0130	1.3	16	40	
ADS-0131	1.31	16	40	
ADS-0132	1.32	16	40	
ADS-0133	1.33	16	40	
ADS-0134	1.34	16	40	
ADS-0135	1.35	16	40	
ADS-0136	1.36	16	40	
ADS-0137	1.37	16	40	
ADS-0138	1.38	16	40	
ADS-0139	1.39	16	40	
ADS-0140	1.4	16	40	
ADS-0141	1.41	16	40	
ADS-0142	1.42	16	40	
ADS-0143	1.43	16	40	
ADS-0144	1.44	16	40	
ADS-0145	1.45	16	40	
ADS-0146	1.46	16	40	
ADS-0147	1.47	16	40	
ADS-0148	1.48	16	40	
ADS-0149	1.49	16	40	
ADS-0150	1.5	16	40	
ADS-0151	1.51	16	40	
ADS-0152	1.52	16	40	
ADS-0153	1.53	16	40	
ADS-0154	1.54	16	40	
ADS-0155	1.55	16	40	
ADS-0156	1.56	16	40	
ADS-0157	1.57	16	40	
ADS-0158	1.58	16	40	
ADS-0159	1.59	16	40	
ADS-0160	1.6	18	40	
ADS-0161	1.61	18	40	
ADS-0162	1.62	18	40	
ADS-0163	1.63	18	40	
ADS-0164	1.64	18	40	
ADS-0165	1.65	18	40	
ADS-0166	1.66	18	40	
ADS-0167	1.67	18	40	
ADS-0168	1.68	18	40	
ADS-0169	1.69	18	40	

ストリートシャンクドリル
Straight Shank Drill

Next Page ▶

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0170	1.7	18	40	
ADS-0171	1.71	18	40	
ADS-0172	1.72	18	40	
ADS-0173	1.73	18	40	
ADS-0174	1.74	18	40	
ADS-0175	1.75	18	40	
ADS-0176	1.76	18	40	
ADS-0177	1.77	18	40	
ADS-0178	1.78	18	40	
ADS-0179	1.79	18	40	
ADS-0180	1.8	18	40	
ADS-0181	1.81	18	40	
ADS-0182	1.82	18	40	
ADS-0183	1.83	18	40	
ADS-0184	1.84	18	40	
ADS-0185	1.85	18	40	
ADS-0186	1.86	18	40	
ADS-0187	1.87	18	40	
ADS-0188	1.88	18	40	
ADS-0189	1.89	18	40	
ADS-0190	1.9	18	40	
ADS-0191	1.91	18	40	
ADS-0192	1.92	18	40	
ADS-0193	1.93	18	40	
ADS-0194	1.94	18	40	
ADS-0195	1.95	18	40	
ADS-0196	1.96	18	40	
ADS-0197	1.97	18	40	
ADS-0198	1.98	18	40	
ADS-0199	1.99	18	40	
ADS-0200	2	18	40	
ADS-0201	2.01	18	40	
ADS-0202	2.02	18	40	
ADS-0203	2.03	18	40	
ADS-0204	2.04	18	40	
ADS-0205	2.05	18	40	
ADS-0206	2.06	18	40	
ADS-0207	2.07	18	40	
ADS-0208	2.08	18	40	
ADS-0209	2.09	18	40	
ADS-0210	2.1	20	40 (45)	
ADS-0211	2.11	20	40 (45)	
ADS-0212	2.12	20	40 (45)	
ADS-0213	2.13	20	40 (45)	

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0214	2.14	20	40 (45)	
ADS-0215	2.15	20	40 (45)	
ADS-0216	2.16	20	40 (45)	
ADS-0217	2.17	20	40 (45)	
ADS-0218	2.18	20	40 (45)	
ADS-0219	2.19	20	40 (45)	
ADS-0220	2.2	20	40 (45)	
ADS-0221	2.21	20	40 (45)	
ADS-0222	2.22	20	40 (45)	
ADS-0223	2.23	20	40 (45)	
ADS-0224	2.24	20	40 (45)	
ADS-0225	2.25	20	40 (45)	
ADS-0226	2.26	20	40 (45)	
ADS-0227	2.27	20	40 (45)	
ADS-0228	2.28	20	40 (45)	
ADS-0229	2.29	20	40 (45)	
ADS-0230	2.3	20	40 (45)	
ADS-0231	2.31	20	40 (45)	
ADS-0232	2.32	20	40 (45)	
ADS-0233	2.33	20	40 (45)	
ADS-0234	2.34	20	40 (45)	
ADS-0235	2.35	20	40 (45)	
ADS-0236	2.36	20	40 (45)	
ADS-0237	2.37	20	40 (45)	
ADS-0238	2.38	20	40 (45)	
ADS-0239	2.39	20	40 (45)	
ADS-0240	2.4	20	40 (45)	
ADS-0241	2.41	20	40 (45)	
ADS-0242	2.42	20	40 (45)	
ADS-0243	2.43	20	40 (45)	
ADS-0244	2.44	20	40 (45)	
ADS-0245	2.45	20	40 (45)	
ADS-0246	2.46	20	40 (45)	
ADS-0247	2.47	20	40 (45)	
ADS-0248	2.48	20	40 (45)	
ADS-0249	2.49	20	40 (45)	
ADS-0250	2.5	20	40 (45)	
ADS-0251	2.51	20	40 (45)	
ADS-0252	2.52	20	40 (45)	
ADS-0253	2.53	20	40 (45)	
ADS-0254	2.54	20	40 (45)	
ADS-0255	2.55	20	40 (45)	
ADS-0256	2.56	20	40 (45)	
ADS-0257	2.57	20	40 (45)	

ストレートシャンクドリル
Straight Shank Drill

*全長は () 内表示寸法に順次変更します。

The O.A.L will be changed to the O.A.L in ().

単位 Unit : mm

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0258	2.58	20	40 (45)	
ADS-0259	2.59	20	40 (45)	
ADS-0260	2.6	20	45	
ADS-0261	2.61	20	45	
ADS-0262	2.62	20	45	
ADS-0263	2.63	20	45	
ADS-0264	2.64	20	45	
ADS-0265	2.65	20	45	
ADS-0266	2.66	20	45	
ADS-0267	2.67	20	45	
ADS-0268	2.68	20	45	
ADS-0269	2.69	20	45	
ADS-0270	2.7	20	45	
ADS-0271	2.71	20	45	
ADS-0272	2.72	20	45	
ADS-0273	2.73	20	45	
ADS-0274	2.74	20	45	
ADS-0275	2.75	20	45	
ADS-0276	2.76	20	45	
ADS-0277	2.77	20	45	
ADS-0278	2.78	20	45	
ADS-0279	2.79	20	45	
ADS-0280	2.8	20	45	
ADS-0281	2.81	20	45	
ADS-0282	2.82	20	45	
ADS-0283	2.83	20	45	
ADS-0284	2.84	20	45	
ADS-0285	2.85	20	45	
ADS-0286	2.86	20	45	
ADS-0287	2.87	20	45	
ADS-0288	2.88	20	45	
ADS-0289	2.89	20	45	
ADS-0290	2.9	20	45	
ADS-0291	2.91	20	45	
ADS-0292	2.92	20	45	
ADS-0293	2.93	20	45	
ADS-0294	2.94	20	45	
ADS-0295	2.95	20	45	
ADS-0296	2.96	20	45	
ADS-0297	2.97	20	45	
ADS-0298	2.98	20	45	
ADS-0299	2.99	20	45	
ADS-0300	3	20	45	
ADS-0301	3.01	20	45	

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0302	3.02	20	45	
ADS-0303	3.03	20	45	
ADS-0304	3.04	20	45	
ADS-0305	3.05	20	45	
ADS-0306	3.06	20	45	
ADS-0307	3.07	20	45	
ADS-0308	3.08	20	45	
ADS-0309	3.09	20	45	
ADS-0310	3.1	25	50	
ADS-0311	3.11	25	50	
ADS-0312	3.12	25	50	
ADS-0313	3.13	25	50	
ADS-0314	3.14	25	50	
ADS-0315	3.15	25	50	
ADS-0316	3.16	25	50	
ADS-0317	3.17	25	50	
ADS-0318	3.18	25	50	
ADS-0319	3.19	25	50	
ADS-0320	3.2	25	50	
ADS-0321	3.21	25	50	
ADS-0322	3.22	25	50	
ADS-0323	3.23	25	50	
ADS-0324	3.24	25	50	
ADS-0325	3.25	25	50	
ADS-0326	3.26	25	50	
ADS-0327	3.27	25	50	
ADS-0328	3.28	25	50	
ADS-0329	3.29	25	50	
ADS-0330	3.3	25	50	
ADS-0331	3.31	25	50	
ADS-0332	3.32	25	50	
ADS-0333	3.33	25	50	
ADS-0334	3.34	25	50	
ADS-0335	3.35	25	50	
ADS-0336	3.36	25	50	
ADS-0337	3.37	25	50	
ADS-0338	3.38	25	50	
ADS-0339	3.39	25	50	
ADS-0340	3.4	25	50	
ADS-0341	3.41	25	50	
ADS-0342	3.42	25	50	
ADS-0343	3.43	25	50	
ADS-0344	3.44	25	50	
ADS-0345	3.45	25	50	

※全長は () 内表示寸法に順次変更します。

The O.A.L will be changed to the O.A.L in ().

Next Page ▶

切削条件 Cutting Condition P.175

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0346	3.46	25	50	
ADS-0347	3.47	25	50	
ADS-0348	3.48	25	50	
ADS-0349	3.49	25	50	
ADS-0350	3.5	25	50	
ADS-0351	3.51	25	50	
ADS-0352	3.52	25	50	
ADS-0353	3.53	25	50	
ADS-0354	3.54	25	50	
ADS-0355	3.55	25	50	
ADS-0356	3.56	25	50	
ADS-0357	3.57	25	50	
ADS-0358	3.58	25	50	
ADS-0359	3.59	25	50	
ADS-0360	3.6	27	55	
ADS-0361	3.61	27	55	
ADS-0362	3.62	27	55	
ADS-0363	3.63	27	55	
ADS-0364	3.64	27	55	
ADS-0365	3.65	27	55	
ADS-0366	3.66	27	55	
ADS-0367	3.67	27	55	
ADS-0368	3.68	27	55	
ADS-0369	3.69	27	55	
ADS-0370	3.7	27	55	
ADS-0371	3.71	27	55	
ADS-0372	3.72	27	55	
ADS-0373	3.73	27	55	
ADS-0374	3.74	27	55	
ADS-0375	3.75	27	55	
ADS-0376	3.76	27	55	
ADS-0377	3.77	27	55	
ADS-0378	3.78	27	55	
ADS-0379	3.79	27	55	
ADS-0380	3.8	27	55	
ADS-0381	3.81	27	55	
ADS-0382	3.82	27	55	
ADS-0383	3.83	27	55	
ADS-0384	3.84	27	55	
ADS-0385	3.85	27	55	
ADS-0386	3.86	27	55	
ADS-0387	3.87	27	55	
ADS-0388	3.88	27	55	
ADS-0389	3.89	27	55	

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0390	3.9	27	55	
ADS-0391	3.91	27	55	
ADS-0392	3.92	27	55	
ADS-0393	3.93	27	55	
ADS-0394	3.94	27	55	
ADS-0395	3.95	27	55	
ADS-0396	3.96	27	55	
ADS-0397	3.97	27	55	
ADS-0398	3.98	27	55	
ADS-0399	3.99	27	55	
ADS-0400	4	27	55	
ADS-0401	4.01	27	55	
ADS-0402	4.02	27	55	
ADS-0403	4.03	27	55	
ADS-0404	4.04	27	55	
ADS-0405	4.05	27	55	
ADS-0406	4.06	27	55	
ADS-0407	4.07	27	55	
ADS-0408	4.08	27	55	
ADS-0409	4.09	27	55	
ADS-0410	4.1	30	60	
ADS-0411	4.11	30	60	
ADS-0412	4.12	30	60	
ADS-0413	4.13	30	60	
ADS-0414	4.14	30	60	
ADS-0415	4.15	30	60	
ADS-0416	4.16	30	60	
ADS-0417	4.17	30	60	
ADS-0418	4.18	30	60	
ADS-0419	4.19	30	60	
ADS-0420	4.2	30	60	
ADS-0421	4.21	30	60	
ADS-0422	4.22	30	60	
ADS-0423	4.23	30	60	
ADS-0424	4.24	30	60	
ADS-0425	4.25	30	60	
ADS-0426	4.26	30	60	
ADS-0427	4.27	30	60	
ADS-0428	4.28	30	60	
ADS-0429	4.29	30	60	
ADS-0430	4.3	30	60	
ADS-0431	4.31	30	60	
ADS-0432	4.32	30	60	
ADS-0433	4.33	30	60	

ストレートシャンクドリル
 Straight Shank Drill

単位 Unit : mm

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0434	4.34	30	60	
ADS-0435	4.35	30	60	
ADS-0436	4.36	30	60	
ADS-0437	4.37	30	60	
ADS-0438	4.38	30	60	
ADS-0439	4.39	30	60	
ADS-0440	4.4	30	60	
ADS-0441	4.41	30	60	
ADS-0442	4.42	30	60	
ADS-0443	4.43	30	60	
ADS-0444	4.44	30	60	
ADS-0445	4.45	30	60	
ADS-0446	4.46	30	60	
ADS-0447	4.47	30	60	
ADS-0448	4.48	30	60	
ADS-0449	4.49	30	60	
ADS-0450	4.5	30	60	
ADS-0451	4.51	30	60	
ADS-0452	4.52	30	60	
ADS-0453	4.53	30	60	
ADS-0454	4.54	30	60	
ADS-0455	4.55	30	60	
ADS-0456	4.56	30	60	
ADS-0457	4.57	30	60	
ADS-0458	4.58	30	60	
ADS-0459	4.59	30	60	
ADS-0460	4.6	30	60	
ADS-0461	4.61	30	60	
ADS-0462	4.62	30	60	
ADS-0463	4.63	30	60	
ADS-0464	4.64	30	60	
ADS-0465	4.65	30	60	
ADS-0466	4.66	30	60	
ADS-0467	4.67	30	60	
ADS-0468	4.68	30	60	
ADS-0469	4.69	30	60	
ADS-0470	4.7	30	60	
ADS-0471	4.71	30	60	
ADS-0472	4.72	30	60	
ADS-0473	4.73	30	60	
ADS-0474	4.74	30	60	
ADS-0475	4.75	30	60	
ADS-0476	4.76	30	60	
ADS-0477	4.77	30	60	

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0478	4.78	30	60	
ADS-0479	4.79	30	60	
ADS-0480	4.8	30	60	
ADS-0481	4.81	30	60	
ADS-0482	4.82	30	60	
ADS-0483	4.83	30	60	
ADS-0484	4.84	30	60	
ADS-0485	4.85	30	60	
ADS-0486	4.86	30	60	
ADS-0487	4.87	30	60	
ADS-0488	4.88	30	60	
ADS-0489	4.89	30	60	
ADS-0490	4.9	30	60	
ADS-0491	4.91	30	60	
ADS-0492	4.92	30	60	
ADS-0493	4.93	30	60	
ADS-0494	4.94	30	60	
ADS-0495	4.95	30	60	
ADS-0496	4.96	30	60	
ADS-0497	4.97	30	60	
ADS-0498	4.98	30	60	
ADS-0499	4.99	30	60	
ADS-0500	5	30	60	
ADS-0501	5.01	30	60	
ADS-0502	5.02	30	60	
ADS-0503	5.03	30	60	
ADS-0504	5.04	30	60	
ADS-0505	5.05	30	60	
ADS-0506	5.06	30	60	
ADS-0507	5.07	30	60	
ADS-0508	5.08	30	60	
ADS-0509	5.09	30	60	
ADS-0510	5.1	40	65 (80)	
ADS-0511	5.11	40	65 (80)	
ADS-0512	5.12	40	65 (80)	
ADS-0513	5.13	40	65 (80)	
ADS-0514	5.14	40	65 (80)	
ADS-0515	5.15	40	65 (80)	
ADS-0516	5.16	40	65 (80)	
ADS-0517	5.17	40	65 (80)	
ADS-0518	5.18	40	65 (80)	
ADS-0519	5.19	40	65 (80)	
ADS-0520	5.2	40	65 (80)	
ADS-0521	5.21	40	65 (80)	

※全長は () 内表示寸法に順次変更します。
The O.A.L will be changed to the O.A.L in () .

Next Page ▶

切削条件 Cutting Condition P.175

ADS 標準ソリッドドリル (ストレートシャンク)

単位 Unit : mm

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0522	5.22	40	65 (80)	
ADS-0523	5.23	40	65 (80)	
ADS-0524	5.24	40	65 (80)	
ADS-0525	5.25	40	65 (80)	
ADS-0526	5.26	40	65 (80)	
ADS-0527	5.27	40	65 (80)	
ADS-0528	5.28	40	65 (80)	
ADS-0529	5.29	40	65 (80)	
ADS-0530	5.3	40	65 (80)	
ADS-0531	5.31	40	65 (80)	
ADS-0532	5.32	40	65 (80)	
ADS-0533	5.33	40	65 (80)	
ADS-0534	5.34	40	65 (80)	
ADS-0535	5.35	40	65 (80)	
ADS-0536	5.36	40	65 (80)	
ADS-0537	5.37	40	65 (80)	
ADS-0538	5.38	40	65 (80)	
ADS-0539	5.39	40	65 (80)	
ADS-0540	5.4	40	65 (80)	
ADS-0541	5.41	40	65 (80)	
ADS-0542	5.42	40	65 (80)	
ADS-0543	5.43	40	65 (80)	
ADS-0544	5.44	40	65 (80)	
ADS-0545	5.45	40	65 (80)	
ADS-0546	5.46	40	65 (80)	
ADS-0547	5.47	40	65 (80)	
ADS-0548	5.48	40	65 (80)	
ADS-0549	5.49	40	65 (80)	
ADS-0550	5.5	40	65 (80)	
ADS-0551	5.51	40	65 (80)	
ADS-0552	5.52	40	65 (80)	
ADS-0553	5.53	40	65 (80)	
ADS-0554	5.54	40	65 (80)	
ADS-0555	5.55	40	65 (80)	
ADS-0556	5.56	40	65 (80)	
ADS-0557	5.57	40	65 (80)	
ADS-0558	5.58	40	65 (80)	
ADS-0559	5.59	40	65 (80)	
ADS-0560	5.6	40	65 (80)	
ADS-0561	5.61	40	65 (80)	
ADS-0562	5.62	40	65 (80)	
ADS-0563	5.63	40	65 (80)	
ADS-0564	5.64	40	65 (80)	
ADS-0565	5.65	40	65 (80)	

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0566	5.66	40	65 (80)	
ADS-0567	5.67	40	65 (80)	
ADS-0568	5.68	40	65 (80)	
ADS-0569	5.69	40	65 (80)	
ADS-0570	5.7	40	65 (80)	
ADS-0571	5.71	40	65 (80)	
ADS-0572	5.72	40	65 (80)	
ADS-0573	5.73	40	65 (80)	
ADS-0574	5.74	40	65 (80)	
ADS-0575	5.75	40	65 (80)	
ADS-0576	5.76	40	65 (80)	
ADS-0577	5.77	40	65 (80)	
ADS-0578	5.78	40	65 (80)	
ADS-0579	5.79	40	65 (80)	
ADS-0580	5.8	40	65 (80)	
ADS-0581	5.81	40	65 (80)	
ADS-0582	5.82	40	65 (80)	
ADS-0583	5.83	40	65 (80)	
ADS-0584	5.84	40	65 (80)	
ADS-0585	5.85	40	65 (80)	
ADS-0586	5.86	40	65 (80)	
ADS-0587	5.87	40	65 (80)	
ADS-0588	5.88	40	65 (80)	
ADS-0589	5.89	40	65 (80)	
ADS-0590	5.9	40	65 (80)	
ADS-0591	5.91	40	65 (80)	
ADS-0592	5.92	40	65 (80)	
ADS-0593	5.93	40	65 (80)	
ADS-0594	5.94	40	65 (80)	
ADS-0595	5.95	40	65 (80)	
ADS-0596	5.96	40	65 (80)	
ADS-0597	5.97	40	65 (80)	
ADS-0598	5.98	40	65 (80)	
ADS-0599	5.99	40	65 (80)	
ADS-0600	6	40	65 (80)	
ADS-0601	6.01	40	65 (80)	
ADS-0602	6.02	40	65 (80)	
ADS-0603	6.03	40	65 (80)	
ADS-0604	6.04	40	65 (80)	
ADS-0605	6.05	40	65 (80)	
ADS-0606	6.06	40	65 (80)	
ADS-0607	6.07	40	65 (80)	
ADS-0608	6.08	40	65 (80)	
ADS-0609	6.09	40	65 (80)	

ストレートシャンクドリル
Straight Shank Drill

※全長は () 内表示寸法に順次変更します。

The O.A.L will be changed to the O.A.L in ().

単位 Unit : mm

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0610	6.1	40	65 (80)	
ADS-0615	6.15	40	65 (80)	
ADS-0620	6.2	40	65 (80)	
ADS-0625	6.25	40	65 (80)	
ADS-0630	6.3	40	65 (80)	
ADS-0635	6.35	40	65 (80)	
ADS-0640	6.4	40	65 (80)	
ADS-0645	6.45	40	65 (80)	
ADS-0650	6.5	40	65 (80)	
ADS-0655	6.55	40	65 (80)	
ADS-0660	6.6	40	65 (80)	
ADS-0665	6.65	40	65 (80)	
ADS-0670	6.7	40	65 (80)	
ADS-0675	6.75	40	65 (80)	
ADS-0680	6.8	40	65 (80)	
ADS-0685	6.85	40	65 (80)	
ADS-0690	6.9	40	65 (80)	
ADS-0695	6.95	40	65 (80)	
ADS-0700	7	40	65 (80)	
ADS-0701	7.01	40	65 (80)	
ADS-0702	7.02	40	65 (80)	
ADS-0703	7.03	40	65 (80)	
ADS-0704	7.04	40	65 (80)	
ADS-0705	7.05	40	65 (80)	
ADS-0706	7.06	40	65 (80)	
ADS-0707	7.07	40	65 (80)	
ADS-0708	7.08	40	65 (80)	
ADS-0709	7.09	40	65 (80)	
ADS-0710	7.1	40	80	
ADS-0720	7.2	40	80	
ADS-0730	7.3	40	80	
ADS-0740	7.4	40	80	
ADS-0750	7.5	40	80	
ADS-0760	7.6	40	80	
ADS-0770	7.7	40	80	
ADS-0780	7.8	40	80	
ADS-0790	7.9	40	80	
ADS-0800	8	40	80	
ADS-0801	8.01	40	80	
ADS-0802	8.02	40	80	
ADS-0803	8.03	40	80	
ADS-0804	8.04	40	80	
ADS-0805	8.05	40	80	
ADS-0806	8.06	40	80	

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
ADS-0807	8.07	40	80	
ADS-0808	8.08	40	80	
ADS-0809	8.09	40	80	
ADS-0810	8.1	40	80	
ADS-0820	8.2	40	80	
ADS-0830	8.3	40	80	
ADS-0840	8.4	40	80	
ADS-0850	8.5	40	80	
ADS-0860	8.6	40	80	
ADS-0870	8.7	40	80	
ADS-0880	8.8	40	80	
ADS-0890	8.9	40	80	
ADS-0900	9	40	80	
ADS-0901	9.01	40	80	
ADS-0902	9.02	40	80	
ADS-0903	9.03	40	80	
ADS-0904	9.04	40	80	
ADS-0905	9.05	40	80	
ADS-0906	9.06	40	80	
ADS-0907	9.07	40	80	
ADS-0908	9.08	40	80	
ADS-0909	9.09	40	80	
ADS-0910	9.1	40	80	
ADS-0920	9.2	40	80	
ADS-0930	9.3	40	80	
ADS-0940	9.4	40	80	
ADS-0950	9.5	40	80	
ADS-0960	9.6	50	100	
ADS-0970	9.7	50	100	
ADS-0980	9.8	50	100	
ADS-0990	9.9	50	100	
ADS-1000	10	50	100	
ADS-1001	10.01	50	100	
ADS-1002	10.02	50	100	
ADS-1003	10.03	50	100	
ADS-1004	10.04	50	100	
ADS-1005	10.05	50	100	
ADS-1006	10.06	50	100	
ADS-1007	10.07	50	100	
ADS-1008	10.08	50	100	
ADS-1009	10.09	50	100	
ADS-1010	10.1	50	100	
ADS-1020	10.2	50	100	
ADS-1030	10.3	50	100	

※全長は () 内表示寸法に順次変更します。
The O.A.L will be changed to the O.A.L in () .

Next Page ▶

切削条件 Cutting Condition P.175

ADS 標準ソリッドドリル

ADS Solid Drill, Standard Straight Shank

ADSL ソリッドセミロングドリル

ADSL Semi Long Drill, Straight Shank

被削材 Work Materials	炭素鋼 Carbon steel SS S50C		合金鋼 Alloy Steel SCM SKS		調質鋼 Hardened Steel NAK SKD (HRC30~38)		鋳鉄 Cast Iron FC25		オーステナイト系 SUS304/316 Austenitic	
	ドリル径 Drill Dia. (mm)	回転数 Rotation (min ⁻¹)	送り量 Feed (mm/rev)	回転数 Rotation (min ⁻¹)	送り量 Feed (mm/rev)	回転数 Rotation (min ⁻¹)	送り量 Feed (mm/rev)	回転数 Rotation (min ⁻¹)	送り量 Feed (mm/rev)	回転数 Rotation (min ⁻¹)
φ0.3~ 0.5	12,000~ 10,000	0.005~ 0.01	10,000~ 9500	0.003~ 0.01	8,500~ 7,600	0.002~ 0.008	12,000~ 10,000	0.01~ 0.02	5,300	0.0005~ 0.001
φ0.6~ 1.0	10,000~ 9,500	0.01~ 0.02	8,000~ 6,400	0.007~ 0.015	6,400~ 4,800	0.003~ 0.01	10,000~ 9,500	0.01~ 0.04	5,300~ 4,800	0.001~ 0.005
φ1.1~ 2.0	7,200~ 6,400	0.02~ 0.06	5,800~ 3,200	0.01~ 0.02	4,400~ 3,200	0.01~ 0.015	8,700~ 7,200	0.06~ 0.15	4,300~ 3,200	0.005~ 0.02
φ2.1~ 2.9	6,100~ 4,400	0.06~ 0.08	3,000~ 2800	0.02~ 0.04	3,000~ 2,800	0.015~ 0.02	6,800~ 4,900	0.06~ 0.15	3,000~ 2,200	0.02~ 0.03
φ3.0~ 5.0	4,300~ 2,600	0.08~ 0.1	2,700~ 2,000	0.04~ 0.08	2,700~ 1,900	0.02~ 0.04	4,800~ 3,200	0.1~0.2	2,100~ 1,300	0.03~ 0.05
φ6.0~ 8.0	2,200~ 1,900	0.1~ 0.12	1,600~ 1,400	0.05~ 0.1	1,600~ 1,400	0.02~ 0.06	2,600~ 2,000	0.15~ 0.25	1,100~ 800	0.05~ 0.1
φ9.0~ 13.0	1,600~ 1,200	0.1~ 0.12	1,300~ 1,000	0.05~ 0.1	1,200~ 900	0.04~ 0.08	1,800~ 1,500	0.2~ 0.4	700~ 500	0.05~ 0.1

被削材 Work Materials	マルテンサイト・ フェライト系 SUS303/420/430 Martensitic & Ferritic		アルミ・銅合金 Aluminium Copper Alloy	
	ドリル径 Drill Dia. (mm)	回転数 Rotation (min ⁻¹)	送り量 Feed (mm/rev)	回転数 Rotation (min ⁻¹)
φ0.3~ 0.5	8,000~ 6,300	0.0005~ 0.001	20,000~ 16,000	0.02~ 0.05
φ0.6~ 1.0	6,300~ 5,300	0.001~ 0.005	20,000~ 16,000	0.06~ 0.15
φ1.1~ 2.0	5,300~ 4,700	0.005~ 0.02	16,000~ 13,000	0.1~ 0.2
φ2.1~ 2.9	4,500~ 3,300	0.02~ 0.03	13,000~ 10,000	0.1~ 0.2
φ3.0~ 5.0	3,200~ 1,900	0.03~ 0.05	8,500~ 6,400	0.1~ 0.2
φ6.0~ 8.0	1,600~ 1,200	0.05~ 0.1	5,300~ 4,000	0.2~ 0.3
φ9.0~ 13.0	1,100~ 750	0.05~ 0.1	3,000~ 2,500	0.4~ 0.5

備考

- 1) 切削条件は当初上記条件表の低い値より選定し、徐々に高い値にして最適条件でご使用下さい。
- 2) 工具の突き出し長さはできるだけ短くしてご使用下さい。
- 3) ご使用の機械の最高回転数が上記切削条件に達しない場合は、なるべく安定領域での高い回転数で使用し、送り速度を調整して下さい。

Remarks:

- 1) It is generally recommended to start with the lowest speed and feed shown in the table.
They may be gradually increased to higher points to obtain the fittest condition.
- 2) Overhanging length of the tool from the chuck should be minimized.
- 3) When machines can not achieve a recommended rotation speed, use the maximum speed but in stable rotation range and adjust the feed rate.