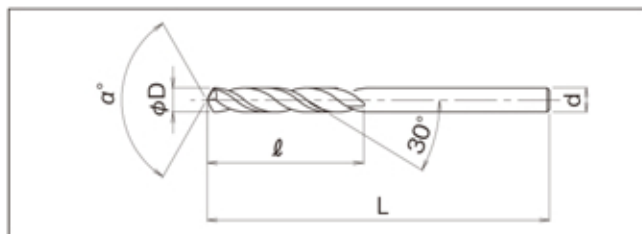


コーティング付き標準ソリッドドリル 〈ストレートシャンク〉

Solid Coated Drill, standard Straight Shank

TiAlN コーティング

V-ADS



■ ADS標準タイプにTiAlNコーティングを施し更に長寿命と安定加工を実現。

TiAlN coating on standard drill (ADS) assures longer tool life and stable drilling operation.

■ ノンコート標準品では加工困難であった50HRCまでの焼入鋼の穴あけも可能です。

V-ADS can drill quenched and tempered steels up to 50HRC.

刃径公差：+0~-0.01
φD Tolerance



φD ≥ 2.1



単位 Unit : mm

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

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

単位 Unit : mm

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

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

ストレートシャンクドリル
Straight Shank Drill

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V-ADS コーティング付き標準ソリッドドリル (ストレートシャンク) TiAlN コーティング

単位 Unit : mm

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

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

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 ¥
V-ADS-0258	2.58	20	40 (45)	
V-ADS-0259	2.59	20	40 (45)	
V-ADS-0260	2.6	20	45	
V-ADS-0261	2.61	20	45	
V-ADS-0262	2.62	20	45	
V-ADS-0263	2.63	20	45	
V-ADS-0264	2.64	20	45	
V-ADS-0265	2.65	20	45	
V-ADS-0266	2.66	20	45	
V-ADS-0267	2.67	20	45	
V-ADS-0268	2.68	20	45	
V-ADS-0269	2.69	20	45	
V-ADS-0270	2.7	20	45	
V-ADS-0271	2.71	20	45	
V-ADS-0272	2.72	20	45	
V-ADS-0273	2.73	20	45	
V-ADS-0274	2.74	20	45	
V-ADS-0275	2.75	20	45	
V-ADS-0276	2.76	20	45	
V-ADS-0277	2.77	20	45	
V-ADS-0278	2.78	20	45	
V-ADS-0279	2.79	20	45	
V-ADS-0280	2.8	20	45	
V-ADS-0281	2.81	20	45	
V-ADS-0282	2.82	20	45	
V-ADS-0283	2.83	20	45	
V-ADS-0284	2.84	20	45	
V-ADS-0285	2.85	20	45	
V-ADS-0286	2.86	20	45	
V-ADS-0287	2.87	20	45	
V-ADS-0288	2.88	20	45	
V-ADS-0289	2.89	20	45	
V-ADS-0290	2.9	20	45	
V-ADS-0291	2.91	20	45	
V-ADS-0292	2.92	20	45	
V-ADS-0293	2.93	20	45	
V-ADS-0294	2.94	20	45	
V-ADS-0295	2.95	20	45	
V-ADS-0296	2.96	20	45	
V-ADS-0297	2.97	20	45	
V-ADS-0298	2.98	20	45	
V-ADS-0299	2.99	20	45	
V-ADS-0300	3	20	45	
V-ADS-0305	3.05	20	45	

型番 CODE NUMBER	径 φD	刃長 ℓ	全長 L	定価 ¥
V-ADS-0310	3.1	25	50	
V-ADS-0315	3.15	25	50	
V-ADS-0320	3.2	25	50	
V-ADS-0325	3.25	25	50	
V-ADS-0330	3.3	25	50	
V-ADS-0335	3.35	25	50	
V-ADS-0340	3.4	25	50	
V-ADS-0345	3.45	25	50	
V-ADS-0350	3.5	25	50	
V-ADS-0355	3.55	25	50	
V-ADS-0360	3.6	27	55	
V-ADS-0365	3.65	27	55	
V-ADS-0370	3.7	27	55	
V-ADS-0375	3.75	27	55	
V-ADS-0380	3.8	27	55	
V-ADS-0385	3.85	27	55	
V-ADS-0390	3.9	27	55	
V-ADS-0395	3.95	27	55	
V-ADS-0400	4	27	55	
V-ADS-0405	4.05	27	55	
V-ADS-0410	4.1	30	60	
V-ADS-0415	4.15	30	60	
V-ADS-0420	4.2	30	60	
V-ADS-0425	4.25	30	60	
V-ADS-0430	4.3	30	60	
V-ADS-0435	4.35	30	60	
V-ADS-0440	4.4	30	60	
V-ADS-0445	4.45	30	60	
V-ADS-0450	4.5	30	60	
V-ADS-0455	4.55	30	60	
V-ADS-0460	4.6	30	60	
V-ADS-0465	4.65	30	60	
V-ADS-0470	4.7	30	60	
V-ADS-0475	4.75	30	60	
V-ADS-0480	4.8	30	60	
V-ADS-0485	4.85	30	60	
V-ADS-0490	4.9	30	60	
V-ADS-0495	4.95	30	60	
V-ADS-0500	5	30	60	
V-ADS-0505	5.05	30	60	
V-ADS-0510	5.1	40	80	
V-ADS-0515	5.15	40	80	
V-ADS-0520	5.2	40	80	
V-ADS-0525	5.25	40	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 ().

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切削条件 Cutting Condition P.177

V-ADS コーティング付き標準ドリル

Solid Coated Drill, Standard 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	14,000~	0.006~	14,000~ 12,500	0.004~	11,000~ 9,500	0.002~ 0.008	14,000~ 12,500	0.012~ 0.025	6,600	0.0005~ 0.001
	12,500	0.012		0.012						
φ0.6~ 1.0	11,000~	0.012~	10,000~ 8,000	0.008~	8,000~ 6,400	0.003~ 0.01	12,000	0.012~ 0.05	6,600~ 6,200	0.001~ 0.005
	9,500	0.025		0.02						
φ1.1~ 2.0	8,700~	0.025~	7,200~ 6,400	0.012~	5,800~ 4,000	0.01~ 0.015	11,000~ 8,000	0.07~ 0.2	5,600~ 4,200	0.005~ 0.02
	8,000	0.07		0.025						
φ2.1~ 2.9	7,600~	0.07~	6,000~ 4,400	0.025~	4,000~ 3,300	0.015~ 0.02	7,600~ 5,500	0.07~ 0.2	3,900~ 2,900	0.02~ 0.03
	5,500	0.1		0.05						
φ3.0~ 6.0	5,300~	0.1~	4,200~ 2,500	0.05~	3,200~ 1,900	0.02~ 0.04	5,300~ 3,900	0.12~ 0.25	2,800~ 1,700	0.03~ 0.05
	3,200	0.12		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	
	ドリル径 Drill Dia. (mm)	送り量 Feed (mm/rev)
φ0.3~ 0.5	10,000~	0.0005~
	8,000	0.001
φ0.6~ 1.0	8,000~	0.001~
	6,900	0.005
φ1.1~ 2.0	6,900~	0.005~
	6,200	0.02
φ2.1~ 2.9	5,900~	0.02~
	4,300	0.03
φ3.0~ 6.0	4,200~	0.03~
	2,500	0.05

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.