

非铁金属加工用极光涂层钻头
Aurora-Coat Drills for Non-Ferrous Metal

多用途钻头 **MDA**型

MULTIDRILL MDA Series 第2版

迈向铝合金加工的新领域！



覆盖从高精度加工到高效率加工的广泛使用领域

新DLC涂层 **极光涂层X** *New*

内冷式 $\phi 1.0 \sim \phi 12.0 \text{mm}$

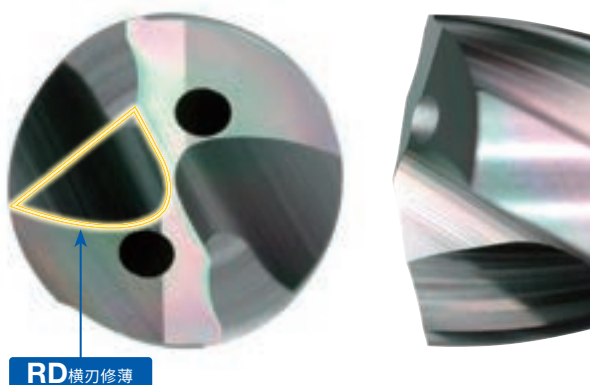
$\phi 1.0 \sim \phi 3.0 \text{mm}$ 3D 5D 10D 15D 20D

$\phi 3.1 \sim \phi 12.0 \text{mm}$ 3D 5D 10D

实现高精度·高效钻孔！

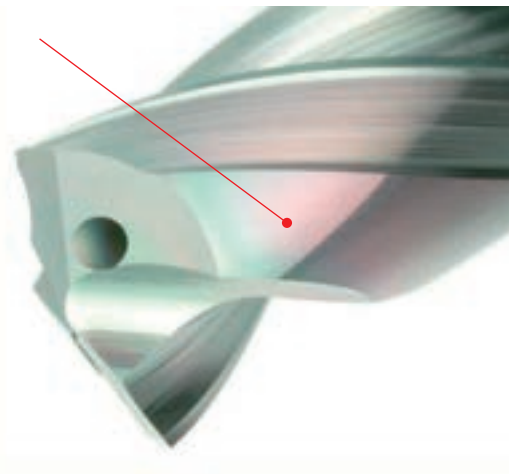
RD横刃修薄

凭借特殊横刃修薄效果, 定心性出众！



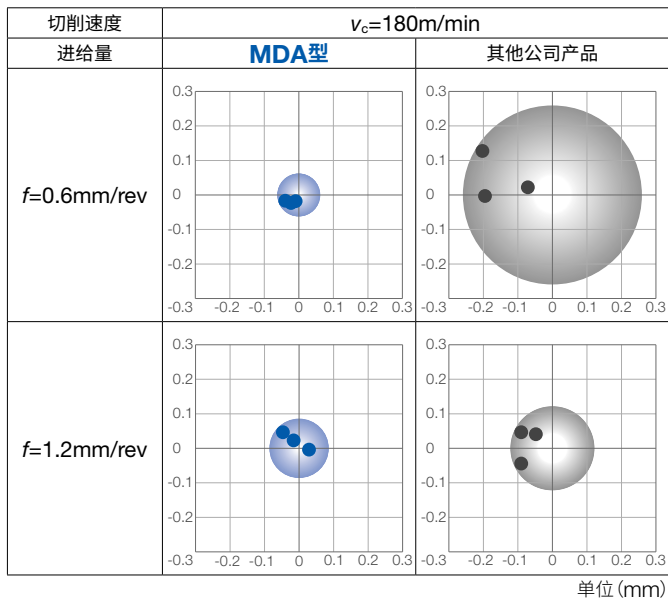
宽大的双刃带 *刃径:3.1mm~

采用高导向性的宽大双刃带, 孔精度更高！



■ 孔位置精度

无底孔加工

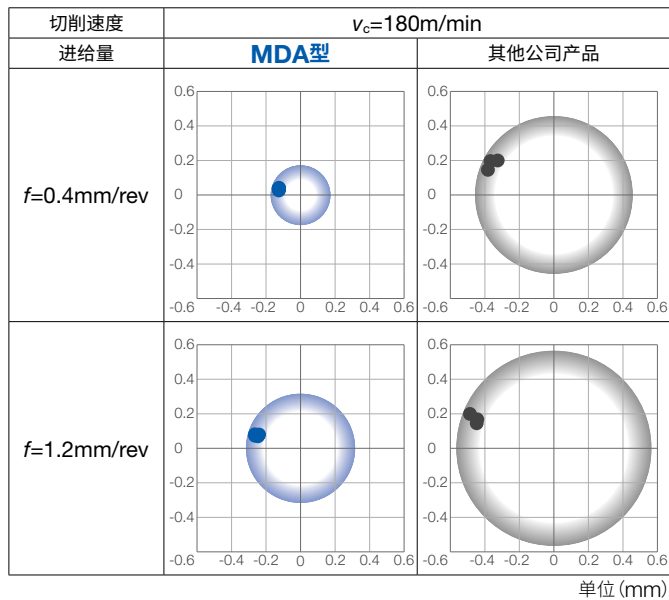
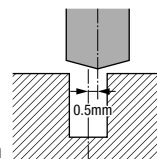


被削材: ADC12 使用刀具: MDA0600S06H05 ($\phi 6\text{mm} \times 5\text{D}$) Wet

在高效率条件下仍可保持稳定的孔位置度

有预铸孔加工

有预铸孔偏移: 0.5mm



被削材: ADC12 使用刀具: MDA0600S06H05 ($\phi 6\text{mm} \times 5\text{D}$) Wet

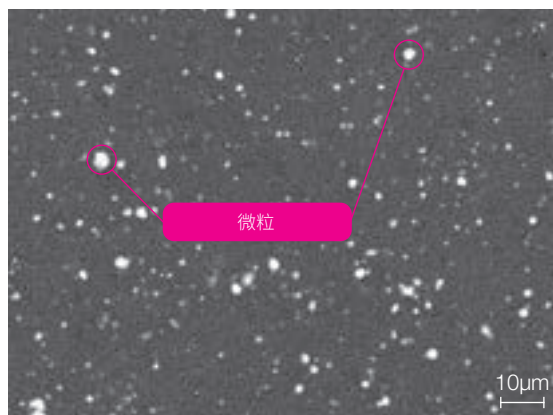
大幅降低了预铸孔位置偏移的影响

极光涂层X DLC涂层

● 涂层表面性状 (SEM图像)



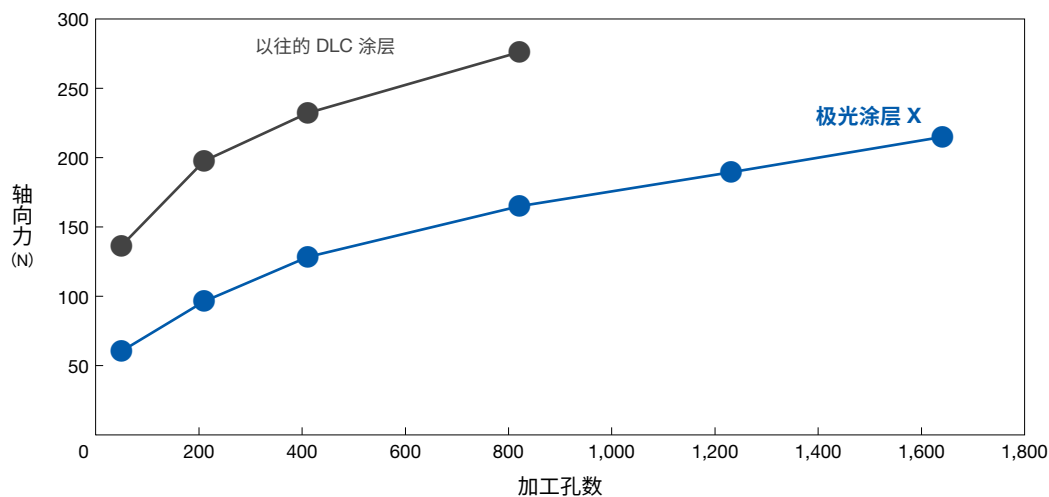
极光涂层X



以往的DLC涂层

新技术大幅提高了平滑性

● 切削阻力



被削材: ADC12 设备: 立式M/C BT30
使用刀具: MDA0600S06H05 (ø6mm×5D)
切削条件: $v_c=180\text{m/min}$ $f=0.2\text{mm/rev}$ 内冷式(水溶性)

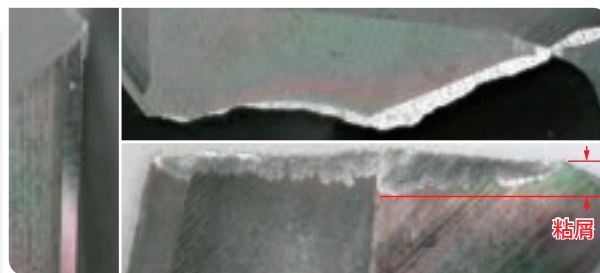
由于涂层表面的平滑性提高,因此从初期开始阻力就低且阻力上升缓慢,使用寿命长

● 耐溶着性

极光涂层X



以往的DLC涂层



被削材: ADC12 设备: 立式M/C BT30
使用刀具: MDA0600S06H05 (ø6mm×5D)
切削条件: $v_c=180\text{m/min}$ $f=0.2\text{mm/rev}$ 内冷式(水溶性)

平滑性优异,粘屑大幅减少

配合尺寸公差请参见综合产品目录[N章 一般资料篇]。

Fig 1 L/D=3~5D 单刃带

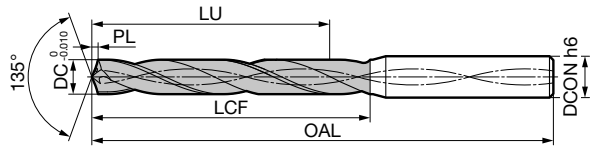
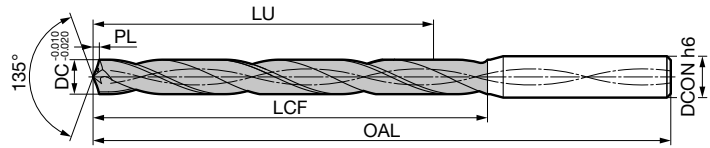


Fig 2 L/D=10~15·20D 单刃带

■刀体 刃径 $\phi 1.0 \sim 2.0\text{mm}$

尺寸 (mm)

刃径 DC (mm)	孔深 L	库存	型号	有效长度 LU	排屑槽长度 LCF	全长 OAL	前端 PL	柄径 DCON	Fig
1.0	3	●	MDA0100S03H03	4.5	6.0	45.0	0.2	3.0	1
	5	●	MDA0100S03H05	8.5	10.0	50.0	0.2	3.0	1
	10	●	MDA0100S03H10	12.5	14.0	55.0	0.2	3.0	2
	15	●	MDA0100S03H15	17.5	19.0	60.0	0.2	3.0	2
1.1	3	●	MDA0110S03H03	6.4	8.0	45.0	0.2	3.0	1
	5	●	MDA0110S03H05	10.4	12.0	50.0	0.2	3.0	1
	10	●	MDA0110S03H10	16.4	18.0	55.0	0.2	3.0	2
	15	●	MDA0110S03H15	19.4	21.0	65.0	0.2	3.0	2
1.2	3	●	MDA0120S03H03	6.2	8.0	48.0	0.2	3.0	1
	5	●	MDA0120S03H05	10.2	12.0	55.0	0.2	3.0	1
	10	●	MDA0120S03H10	16.2	18.0	60.0	0.2	3.0	2
	15	●	MDA0120S03H15	21.2	23.0	65.0	0.2	3.0	2
1.3	3	●	MDA0130S03H03	6.1	8.0	48.0	0.3	3.0	1
	5	●	MDA0130S03H05	12.1	14.0	55.0	0.3	3.0	1
	10	●	MDA0130S03H10	18.1	20.0	60.0	0.3	3.0	2
	15	●	MDA0130S03H15	23.1	25.0	65.0	0.3	3.0	2
1.4	3	●	MDA0140S03H03	5.9	8.0	48.0	0.3	3.0	1
	5	●	MDA0140S03H05	11.9	14.0	55.0	0.3	3.0	1
	10	●	MDA0140S03H10	17.9	20.0	60.0	0.3	3.0	2
	15	●	MDA0140S03H15	25.9	28.0	70.0	0.3	3.0	2
1.5	3	●	MDA0150S03H03	5.8	8.0	48.0	0.3	3.0	1
	5	●	MDA0150S03H05	13.8	16.0	55.0	0.3	3.0	1
	10	●	MDA0150S03H10	20.8	23.0	65.0	0.3	3.0	2
	15	●	MDA0150S03H15	25.8	28.0	70.0	0.3	3.0	2
1.6	3	●	MDA0160S03H03	7.6	10.0	50.0	0.3	3.0	1
	5	●	MDA0160S03H05	13.6	16.0	55.0	0.3	3.0	1
	10	●	MDA0160S03H10	22.6	25.0	65.0	0.3	3.0	2
	15	●	MDA0160S03H15	29.6	32.0	75.0	0.3	3.0	2
1.7	3	●	MDA0170S03H03	7.5	10.0	50.0	0.4	3.0	1
	5	●	MDA0170S03H05	15.5	18.0	60.0	0.4	3.0	1
	10	●	MDA0170S03H10	22.5	25.0	65.0	0.4	3.0	2
	15	●	MDA0170S03H15	29.5	32.0	75.0	0.4	3.0	2
1.8	3	●	MDA0180S03H03	7.3	10.0	50.0	0.4	3.0	1
	5	●	MDA0180S03H05	15.3	18.0	60.0	0.4	3.0	1
	10	●	MDA0180S03H10	25.3	28.0	70.0	0.4	3.0	2
	15	●	MDA0180S03H15	32.3	35.0	75.0	0.4	3.0	2
1.9	3	●	MDA0190S03H03	7.2	10.0	50.0	0.4	3.0	1
	5	●	MDA0190S03H05	17.2	20.0	60.0	0.4	3.0	1
	10	●	MDA0190S03H10	25.2	28.0	70.0	0.4	3.0	2
	15	●	MDA0190S03H15	32.2	35.0	75.0	0.4	3.0	2
2.0	3	●	MDA0200S03H03	7.0	10.0	50.0	0.4	3.0	1
	5	●	MDA0200S03H05	17.0	20.0	60.0	0.4	3.0	1
	10	●	MDA0200S03H10	27.0	30.0	70.0	0.4	3.0	2
	15	●	MDA0200S03H15	37.0	40.0	80.0	0.4	3.0	2

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■刀体 刃径 $\phi 2.1 \sim 3.0\text{mm}$

尺寸 (mm)

刃径 DC (mm)	孔深 L	库存	型号	有效长度 LU	排屑槽长度 LCF	全长 OAL	前端 PL	柄径 DCON	Fig
2.1	3	●	MDA0210S03H03	9.9	13.0	55.0	0.4	3.0	1
	5	●	MDA0210S03H05	18.9	22.0	65.0	0.4	3.0	1
	10	●	MDA0210S03H10	26.9	30.0	70.0	0.4	3.0	2
	15	●	MDA0210S03H15	36.9	40.0	80.0	0.4	3.0	2
2.2	3	●	MDA0220S03H03	9.7	13.0	55.0	0.5	3.0	1
	5	●	MDA0220S03H05	18.7	22.0	65.0	0.5	3.0	1
	10	●	MDA0220S03H10	28.7	32.0	75.0	0.5	3.0	2
	15	●	MDA0220S03H15	38.7	42.0	85.0	0.5	3.0	2
2.3	3	●	MDA0230S03H03	9.6	13.0	55.0	0.5	3.0	1
	5	●	MDA0230S03H05	20.6	24.0	65.0	0.5	3.0	1
	10	●	MDA0230S03H10	28.6	32.0	75.0	0.5	3.0	2
	15	●	MDA0230S03H15	41.6	45.0	85.0	0.5	3.0	2
2.4	3	●	MDA0240S03H03	9.4	13.0	55.0	0.5	3.0	1
	5	●	MDA0240S03H05	20.4	24.0	65.0	0.5	3.0	1
	10	●	MDA0240S03H10	31.4	35.0	75.0	0.5	3.0	2
	15	●	MDA0240S03H15	41.4	45.0	85.0	0.5	3.0	2
2.5	3	●	MDA0250S03H03	9.3	13.0	55.0	0.5	3.0	1
	5	●	MDA0250S03H05	22.3	26.0	65.0	0.5	3.0	1
	10	●	MDA0250S03H10	31.3	35.0	75.0	0.5	3.0	2
	15	●	MDA0250S03H15	41.3	45.0	85.0	0.5	3.0	2
2.6	3	●	MDA0260S03H03	11.1	15.0	60.0	0.5	3.0	1
	5	●	MDA0260S03H05	22.1	26.0	70.0	0.5	3.0	1
	10	●	MDA0260S03H10	34.1	38.0	80.0	0.5	3.0	2
	15	●	MDA0260S03H15	46.1	50.0	90.0	0.5	3.0	2
2.7	3	●	MDA0270S03H03	11.0	15.0	60.0	0.6	3.0	1
	5	●	MDA0270S03H05	24.0	28.0	70.0	0.6	3.0	1
	10	●	MDA0270S03H10	34.0	38.0	80.0	0.6	3.0	2
	15	●	MDA0270S03H15	46.0	50.0	90.0	0.6	3.0	2
2.8	3	●	MDA0280S03H03	10.8	15.0	60.0	0.6	3.0	1
	5	●	MDA0280S03H05	23.8	28.0	70.0	0.6	3.0	1
	10	●	MDA0280S03H10	35.8	40.0	80.0	0.6	3.0	2
	15	●	MDA0280S03H15	50.8	55.0	95.0	0.6	3.0	2
2.9	3	●	MDA0290S03H03	10.7	15.0	60.0	0.6	3.0	1
	5	●	MDA0290S03H05	25.7	30.0	70.0	0.6	3.0	1
	10	●	MDA0290S03H10	35.7	40.0	80.0	0.6	3.0	2
	15	●	MDA0290S03H15	50.7	55.0	95.0	0.6	3.0	2
3.0	3	●	MDA0300S03H03	10.5	15.0	60.0	0.6	3.0	1
	5	●	MDA0300S03H05	25.5	30.0	70.0	0.6	3.0	1
	10	●	MDA0300S03H10	37.5	42.0	82.0	0.6	3.0	2
	15	●	MDA0300S03H15	53.5	58.0	98.0	0.6	3.0	2

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Fig 1 L/D=3~5D 双刃带

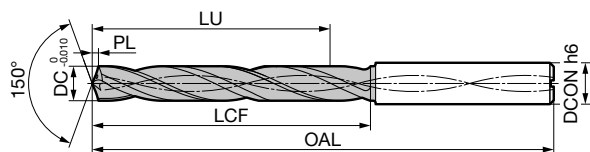
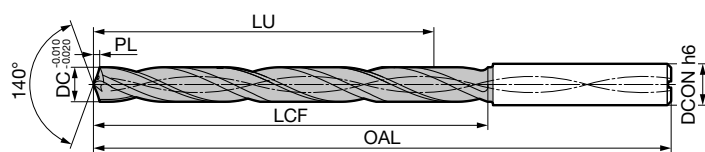


Fig 2 L/D=10D 双刃带

■刀体 刃径 $\phi 3.1 \sim 4.5\text{mm}$

尺寸(mm)

刃径 DC (mm)	孔深 L	库存	型号	有效长度 LU	排屑槽长度 LCF	全长 OAL	前端 PL	柄径 DCON	Fig
3.1	3	●	MDA0310S04H03	15.8	20.4	72.4	0.4	4.0	1
	5	●	MDA0310S04H05	27.8	32.4	86.4	0.4	4.0	1
	10	●	MDA0310S04H10	44.9	49.6	106.6	0.6	4.0	2
3.2	3	●	MDA0320S04H03	15.6	20.4	72.4	0.4	4.0	1
	5	●	MDA0320S04H05	27.6	32.4	86.4	0.4	4.0	1
	10	●	MDA0320S04H10	44.8	49.6	106.6	0.6	4.0	2
3.3	3	●	MDA0330S04H03	15.5	20.4	72.4	0.4	4.0	1
	5	●	MDA0330S04H05	27.5	32.4	86.4	0.4	4.0	1
	10	●	MDA0330S04H10	44.7	49.6	106.6	0.6	4.0	2
3.4	3	●	MDA0340S04H03	15.4	20.5	72.5	0.5	4.0	1
	5	●	MDA0340S04H05	27.4	32.5	86.5	0.5	4.0	1
	10	●	MDA0340S04H10	44.5	49.6	106.6	0.6	4.0	2
3.5	3	●	MDA0350S04H03	15.2	20.5	72.5	0.5	4.0	1
	5	●	MDA0350S04H05	27.2	32.5	86.5	0.5	4.0	1
	10	●	MDA0350S04H10	44.4	49.6	106.6	0.6	4.0	2
3.6	3	●	MDA0360S04H03	17.6	23.0	72.5	0.5	4.0	1
	5	●	MDA0360S04H05	31.1	36.5	86.5	0.5	4.0	1
	10	●	MDA0360S04H10	51.3	56.7	106.7	0.7	4.0	2
3.65	3	●	MDA0365S04H03	17.4	23.0	72.5	0.5	4.0	1
	5	●	MDA0365S04H05	30.9	36.5	86.5	0.5	4.0	1
3.66	5	●	MDA0366S04H05	30.9	36.5	86.5	0.5	4.0	1
3.7	3	●	MDA0370S04H03	17.4	23.0	72.5	0.5	4.0	1
	5	●	MDA0370S04H05	30.9	36.5	86.5	0.5	4.0	1
	10	●	MDA0370S04H10	51.1	56.7	106.7	0.7	4.0	2
3.8	3	●	MDA0380S04H03	17.3	23.0	72.5	0.5	4.0	1
	5	●	MDA0380S04H05	30.8	36.5	86.5	0.5	4.0	1
	10	●	MDA0380S04H10	51.0	56.7	106.7	0.7	4.0	2
3.9	3	●	MDA0390S04H03	17.2	23.0	72.5	0.5	4.0	1
	5	●	MDA0390S04H05	30.7	36.5	86.5	0.5	4.0	1
	10	●	MDA0390S04H10	50.9	56.7	106.7	0.7	4.0	2
4.0	3	●	MDA0400S04H03	17.0	23.0	72.5	0.5	4.0	1
	5	●	MDA0400S04H05	30.5	36.5	86.5	0.5	4.0	1
	10	●	MDA0400S04H10	50.7	56.7	106.7	0.7	4.0	2
4.1	3	●	MDA0410S06H03	19.4	25.5	80.5	0.5	6.0	1
	5	●	MDA0410S06H05	34.4	40.5	98.5	0.5	6.0	1
	10	●	MDA0410S06H10	57.6	63.7	121.7	0.7	6.0	2
4.2	3	●	MDA0420S06H03	19.3	25.6	80.6	0.6	6.0	1
	5	●	MDA0420S06H05	34.3	40.6	98.6	0.6	6.0	1
	10	●	MDA0420S06H10	57.5	63.8	121.8	0.8	6.0	2
4.3	3	●	MDA0430S06H03	19.1	25.6	80.6	0.6	6.0	1
	5	●	MDA0430S06H05	34.1	40.6	98.6	0.6	6.0	1
	10	●	MDA0430S06H10	57.3	63.8	121.8	0.8	6.0	2
4.4	3	●	MDA0440S06H03	19.0	25.6	80.6	0.6	6.0	1
	5	●	MDA0440S06H05	34.0	40.6	98.6	0.6	6.0	1
	10	●	MDA0440S06H10	57.2	63.8	121.8	0.8	6.0	2
4.5	3	●	MDA0450S06H03	18.9	25.6	80.6	0.6	6.0	1
	5	●	MDA0450S06H05	33.9	40.6	98.6	0.6	6.0	1
	10	●	MDA0450S06H10	57.1	63.8	121.8	0.8	6.0	2

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■刀体 刃径 $\phi 4.6 \sim 6.0\text{mm}$

尺寸(mm)

刃径 DC (mm)	孔深 L	库存	型号	有效长度 LU	排屑槽长度 LCF	全长 OAL	前端 PL	柄径 DCON	Fig
4.6	3	●	MDA0460S06H03	20.7	27.6	80.6	0.6	6.0	1
	5	●	MDA0460S06H05	37.7	44.6	98.6	0.6	6.0	1
	10	●	MDA0460S06H10	61.9	68.8	121.8	0.8	6.0	2
4.7	3	●	MDA0470S06H03	20.6	27.6	80.6	0.6	6.0	1
	5	●	MDA0470S06H05	37.6	44.6	98.6	0.6	6.0	1
	10	●	MDA0470S06H10	61.8	68.9	121.9	0.9	6.0	2
4.8	3	●	MDA0480S06H03	20.4	27.6	80.6	0.6	6.0	1
	5	●	MDA0480S06H05	37.4	44.6	98.6	0.6	6.0	1
	10	●	MDA0480S06H10	61.7	68.9	121.9	0.9	6.0	2
4.9	3	●	MDA0490S06H03	20.5	27.7	80.7	0.7	6.0	1
	5	●	MDA0490S06H05	37.5	44.7	98.7	0.7	6.0	1
	10	●	MDA0490S06H10	61.7	68.9	121.9	0.9	6.0	2
5.0	3	●	MDA0500S06H03	20.2	27.7	80.7	0.7	6.0	1
	5	●	MDA0500S06H05	37.2	44.7	98.7	0.7	6.0	1
	10	●	MDA0500S06H10	61.4	68.9	121.9	0.9	6.0	2
5.1	3	●	MDA0510S06H03	20.5	28.2	82.7	0.7	6.0	1
	5	●	MDA0510S06H05	37.0	44.7	100.7	0.7	6.0	1
	10	●	MDA0510S06H10	70.3	77.9	136.9	0.9	6.0	2
5.2	3	●	MDA0520S06H03	20.4	28.2	82.7	0.7	6.0	1
	5	●	MDA0520S06H05	36.9	44.7	100.7	0.7	6.0	1
	10	●	MDA0520S06H10	70.1	77.9	136.9	0.9	6.0	2
5.3	3	●	MDA0530S06H03	20.3	28.2	82.7	0.7	6.0	1
	5	●	MDA0530S06H05	36.8	44.7	100.7	0.7	6.0	1
	10	●	MDA0530S06H10	70.0	78.0	137.0	1.0	6.0	2
5.4	3	●	MDA0540S06H03	20.1	28.2	82.7	0.7	6.0	1
	5	●	MDA0540S06H05	36.6	44.7	100.7	0.7	6.0	1
	10	●	MDA0540S06H10	69.9	78.0	137.0	1.0	6.0	2
5.5	3	●	MDA0550S06H03	20.0	28.2	82.7	0.7	6.0	1
	5	●	MDA0550S06H05	36.5	44.7	100.7	0.7	6.0	1
	10	●	MDA0550S06H10	69.8	78.0	137.0	1.0	6.0	2
5.6	3	●	MDA0560S06H03	22.3	30.7	82.7	0.8	6.0	1
	5	●	MDA0560S06H05	40.3	48.7	100.7	0.8	6.0	1
	10	●	MDA0560S06H10	76.6	85.0	137.0	1.0	6.0	2
5.7	3	●	MDA0570S06H03	22.2	30.8	82.8	0.8	6.0	1
	5	●	MDA0570S06H05	40.2	48.8	100.8	0.8	6.0	1
	10	●	MDA0570S06H10	76.5	85.0	137.0	1.0	6.0	2
5.8	3	●	MDA0580S06H03	22.1	30.8	82.8	0.8	6.0	1
	5	●	MDA0580S06H05	40.1	48.8	100.8	0.8	6.0	1
	10	●	MDA0580S06H10	76.4	85.1	137.1	1.1	6.0	2
5.9	3	●	MDA0590S06H03	21.9	30.8	82.8	0.8	6.0	1
	5	●	MDA0590S06H05	39.9	48.8	100.8	0.8	6.0	1
	10	●	MDA0590S06H10	76.2	85.1	137.1	1.1	6.0	2
6.0	3	●	MDA0600S06H03	21.8	30.8	82.8	0.8	6.0	1
	5	●	MDA0600S06H05	39.8	48.8	100.8	0.8	6.0	1
	10	●	MDA0600S06H10	76.1	85.1	137.1	1.1	6.0	2

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Fig 1 L/D=3·5D 双刃带

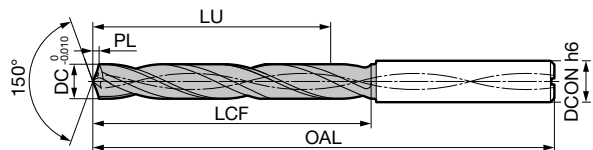
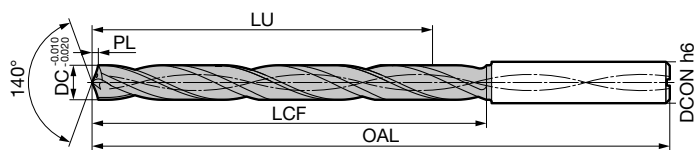


Fig 2 L/D=10D 双刃带

■刀体 刃径 $\phi 6.1 \sim 7.5\text{mm}$

尺寸 (mm)

刃径 DC (mm)	孔深 L	库存	型号	有效长度 LU	排屑槽长度 LCF	全长 OAL	前端 PL	柄径 DCON	Fig
6.1	3	●	MDA0610S08H03	24.2	33.3	88.8	0.8	8.0	1
	5	●	MDA0610S08H05	43.7	52.8	109.8	0.8	8.0	1
	10	●	MDA0610S08H10	83.0	92.1	152.1	1.1	8.0	2
6.2	3	●	MDA0620S08H03	24.0	33.3	88.8	0.8	8.0	1
	5	●	MDA0620S08H05	43.5	52.8	109.8	0.8	8.0	1
	10	●	MDA0620S08H10	82.8	92.1	152.1	1.1	8.0	2
6.3	3	●	MDA0630S08H03	23.9	33.3	88.8	0.8	8.0	1
	5	●	MDA0630S08H05	43.4	52.8	109.8	0.8	8.0	1
	10	●	MDA0630S08H10	82.7	92.1	152.1	1.1	8.0	2
6.4	3	●	MDA0640S08H03	23.8	33.4	88.9	0.9	8.0	1
	5	●	MDA0640S08H05	43.3	52.9	109.9	0.9	8.0	1
	10	●	MDA0640S08H10	82.6	92.2	152.2	1.2	8.0	2
6.5	3	●	MDA0650S08H03	23.6	33.4	88.9	0.9	8.0	1
	5	●	MDA0650S08H05	43.1	52.9	109.9	0.9	8.0	1
	10	●	MDA0650S08H10	82.4	92.2	152.2	1.2	8.0	2
6.6	3	●	MDA0660S08H03	24.0	33.9	88.9	0.9	8.0	1
	5	●	MDA0660S08H05	45.0	54.9	109.9	0.9	8.0	1
	10	●	MDA0660S08H10	87.3	97.2	152.2	1.2	8.0	2
6.7	3	●	MDA0670S08H03	24.0	33.9	88.9	0.9	8.0	1
	5	●	MDA0670S08H05	45.0	54.9	109.9	0.9	8.0	1
	10	●	MDA0670S08H10	87.3	97.2	152.2	1.2	8.0	2
6.8	3	●	MDA0680S08H03	23.7	33.9	88.9	0.9	8.0	1
	5	●	MDA0680S08H05	44.7	54.9	109.9	0.9	8.0	1
	10	●	MDA0680S08H10	87.0	97.2	152.2	1.2	8.0	2
6.9	3	●	MDA0690S08H03	23.6	33.9	88.9	0.9	8.0	1
	5	●	MDA0690S08H05	44.6	54.9	109.9	0.9	8.0	1
	10	●	MDA0690S08H10	86.9	97.3	152.3	1.3	8.0	2
7.0	3	●	MDA0700S08H03	23.4	33.9	88.9	0.9	8.0	1
	5	●	MDA0700S08H05	44.4	54.9	109.9	0.9	8.0	1
	10	●	MDA0700S08H10	86.8	97.3	152.3	1.3	8.0	2
7.1	3	●	MDA0710S08H03	27.8	38.4	94.9	1.0	8.0	1
	5	●	MDA0710S08H05	50.3	60.9	118.9	1.0	8.0	1
	10	●	MDA0710S08H10	95.6	106.3	167.3	1.3	8.0	2
7.2	3	●	MDA0720S08H03	27.7	38.5	95.0	1.0	8.0	1
	5	●	MDA0720S08H05	50.2	61.0	119.0	1.0	8.0	1
	10	●	MDA0720S08H10	95.5	106.3	167.3	1.3	8.0	2
7.3	3	●	MDA0730S08H03	27.5	38.5	95.0	1.0	8.0	1
	5	●	MDA0730S08H05	50.0	61.0	119.0	1.0	8.0	1
	10	●	MDA0730S08H10	95.4	106.3	167.3	1.3	8.0	2
7.35	3	●	MDA0735S08H03	27.4	38.5	95.0	1.0	8.0	1
	5	●	MDA0735S08H05	49.9	61.0	119.0	1.0	8.0	1
	10	●	MDA0735S08H10	95.2	106.3	167.3	1.3	8.0	2
7.4	3	●	MDA0740S08H03	27.4	38.5	95.0	1.0	8.0	1
	5	●	MDA0740S08H05	49.9	61.0	119.0	1.0	8.0	1
	10	●	MDA0740S08H10	95.2	106.3	167.3	1.3	8.0	2
7.5	3	●	MDA0750S08H03	27.3	38.5	95.0	1.0	8.0	1
	5	●	MDA0750S08H05	49.8	61.0	119.0	1.0	8.0	1
	10	●	MDA0750S08H10	95.1	106.4	167.4	1.4	8.0	2

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■刀体 刃径 $\phi 7.6 \sim 9.0\text{mm}$

尺寸 (mm)

刃径 DC (mm)	孔深 L	库存	型号	有效长度 LU	排屑槽长度 LCF	全长 OAL	前端 PL	柄径 DCON	Fig
7.6	3	●	MDA0760S08H03	29.6	41.0	95.0	1.0	8.0	1
	5	●	MDA0760S08H05	53.6	65.0	119.0	1.0	8.0	1
	10	●	MDA0760S08H10	102.0	113.4	167.4	1.4	8.0	2
7.7	3	●	MDA0770S08H03	29.5	41.0	95.0	1.0	8.0	1
	5	●	MDA0770S08H05	53.5	65.0	119.0	1.0	8.0	1
	10	●	MDA0770S08H10	101.9	113.4	167.4	1.4	8.0	2
7.8	3	●	MDA0780S08H03	29.3	41.0	95.0	1.0	8.0	1
	5	●	MDA0780S08H05	53.3	65.0	119.0	1.0	8.0	1
	10	●	MDA0780S08H10	101.7	113.4	167.4	1.4	8.0	2
7.9	3	●	MDA0790S08H03	29.2	41.1	95.1	1.1	8.0	1
	5	●	MDA0790S08H05	53.2	65.1	119.1	1.1	8.0	1
	10	●	MDA0790S08H10	101.6	113.4	167.4	1.4	8.0	2
8.0	3	●	MDA0800S08H03	29.1	41.1	95.1	1.1	8.0	1
	5	●	MDA0800S08H05	53.1	65.1	119.1	1.1	8.0	1
	10	●	MDA0800S08H10	101.5	113.5	167.5	1.5	8.0	2
8.1	3	●	MDA0810S10H03	31.4	43.6	101.1	1.1	10.0	1
	5	●	MDA0810S10H05	56.9	69.1	128.1	1.1	10.0	1
	10	●	MDA0810S10H10	108.3	120.5	182.5	1.5	10.0	2
8.2	3	●	MDA0820S10H03	31.3	43.6	101.1	1.1	10.0	1
	5	●	MDA0820S10H05	56.8	69.1	128.1	1.1	10.0	1
	10	●	MDA0820S10H10	108.2	120.5	182.5	1.5	10.0	2
8.3	3	●	MDA0830S10H03	31.2	43.6	101.1	1.1	10.0	1
	5	●	MDA0830S10H05	56.7	69.1	128.1	1.1	10.0	1
	10	●	MDA0830S10H10	108.1	120.5	182.5	1.5	10.0	2
8.4	3	●	MDA0840S10H03	31.0	43.6	101.1	1.1	10.0	1
	5	●	MDA0840S10H05	56.5	69.1	128.1	1.1	10.0	1
	10	●	MDA0840S10H10	107.9	120.5	182.5	1.5	10.0	2
8.5	3	●	MDA0850S10H03	31.0	43.6	101.1	1.1	10.0	1
	5	●	MDA0850S10H05	56.5	69.1	128.1	1.1	10.0	1
	10	●	MDA0850S10H10	107.9	120.5	182.5	1.5	10.0	2
8.6	3	●	MDA0860S10H03	31.2	44.1	101.1	1.2	10.0	1
	5	●	MDA0860S10H05	58.2	71.1	128.1	1.2	10.0	1
	10	●	MDA0860S10H10	112.7	125.6	182.6	1.6	10.0	2
8.7	3	●	MDA0870S10H03	31.1	44.2	101.2	1.2	10.0	1
	5	●	MDA0870S10H05	58.1	71.2	128.2	1.2	10.0	1
	10	●	MDA0870S10H10	112.5	125.6	182.6	1.6	10.0	2
8.8	3	●	MDA0880S10H03	31.0	44.2	101.2	1.2	10.0	1
	5	●	MDA0880S10H05	58.0	71.2	128.2	1.2	10.0	1
	10	●	MDA0880S10H10	112.4	125.6	182.6	1.6	10.0	2
8.9	3	●	MDA0890S10H03	30.8	44.2	101.2	1.2	10.0	1
	5	●	MDA0890S10H05	57.8	71.2	128.2	1.2	10.0	1
	10	●	MDA0890S10H10	112.3	125.6	182.6	1.6	10.0	2
9.0	3	●	MDA0900S10H03	30.7	44.2	101.2	1.2	10.0	1
	5	●	MDA0900S10H05	57.7	71.2	128.2	1.2	10.0	1
	10	●	MDA0900S10H10	112.1	125.6	182.6	1.6	10.0	2

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Fig 1 L/D=3~5D 双刃带

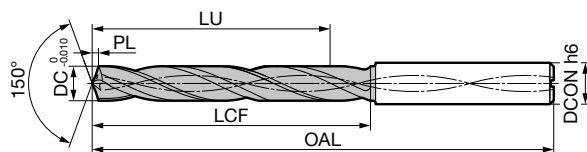
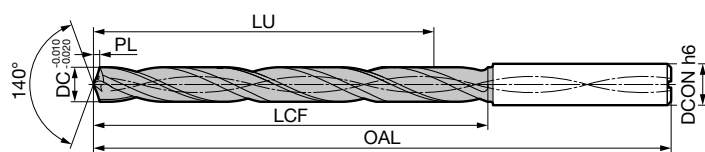


Fig 2 L/D=10D 双刃带

■刀体 刃径 $\phi 9.1 \sim 10.5\text{mm}$

尺寸(mm)

刃径 DC (mm)	孔 深 存	型号	有效长度 LU	排屑槽长度 LCF	全长 OAL	前端 PL	柄径 DCON	Fig
9.1	3	MDA0910S10H03	35.1	48.7	107.2	1.2	10.0	1
	5	MDA0910S10H05	63.6	77.2	137.2	1.2	10.0	1
	10	MDA0910S10H10	121.0	134.7	197.7	1.7	10.0	2
9.2	3	MDA0920S10H03	34.9	48.7	107.2	1.2	10.0	1
	5	MDA0920S10H05	63.4	77.2	137.2	1.2	10.0	1
	10	MDA0920S10H10	120.9	134.7	197.7	1.7	10.0	2
9.21	5	MDA0930S10H05	63.3	77.2	137.2	1.2	10.0	1
9.3	3	MDA0930S10H03	34.8	48.7	107.2	1.2	10.0	1
	5	MDA0930S10H05	63.3	77.2	137.2	1.2	10.0	1
	10	MDA0930S10H10	120.7	134.7	197.7	1.7	10.0	2
9.4	3	MDA0940S10H03	34.7	48.8	107.3	1.3	10.0	1
	5	MDA0940S10H05	63.2	77.3	137.3	1.3	10.0	1
	10	MDA0940S10H10	120.6	134.7	197.7	1.7	10.0	2
9.5	3	MDA0950S10H03	34.5	48.8	107.3	1.3	10.0	1
	5	MDA0950S10H05	63.0	77.3	137.3	1.3	10.0	1
	10	MDA0950S10H10	120.5	134.7	197.7	1.7	10.0	2
9.6	3	MDA0960S10H03	36.9	51.3	107.3	1.3	10.0	1
	5	MDA0960S10H05	66.9	81.3	137.3	1.3	10.0	1
	10	MDA0960S10H10	127.3	141.7	197.7	1.7	10.0	2
9.7	3	MDA0970S10H03	36.7	51.3	107.3	1.3	10.0	1
	5	MDA0970S10H05	66.7	81.3	137.3	1.3	10.0	1
	10	MDA0970S10H10	127.2	141.8	197.8	1.8	10.0	2
9.8	3	MDA0980S10H03	36.6	51.3	107.3	1.3	10.0	1
	5	MDA0980S10H05	66.6	81.3	137.3	1.3	10.0	1
	10	MDA0980S10H10	127.1	141.8	197.8	1.8	10.0	2
9.9	3	MDA0990S10H03	36.5	51.3	107.3	1.3	10.0	1
	5	MDA0990S10H05	66.5	81.3	137.3	1.3	10.0	1
	10	MDA0990S10H10	127.0	141.8	197.8	1.8	10.0	2
10.0	3	MDA1000S10H03	36.3	51.3	107.3	1.3	10.0	1
	5	MDA1000S10H05	66.3	81.3	137.3	1.3	10.0	1
	10	MDA1000S10H10	126.8	141.8	197.8	1.8	10.0	2
10.1	3	MDA1010S12H03	38.7	53.8	117.3	1.4	12.0	1
	5	MDA1010S12H05	70.2	85.3	150.3	1.4	12.0	1
	10	MDA1010S12H10	133.7	148.8	216.8	1.8	12.0	2
10.2	3	MDA1020S12H03	38.6	53.9	117.4	1.4	12.0	1
	5	MDA1020S12H05	70.1	85.4	150.4	1.4	12.0	1
	10	MDA1020S12H10	133.6	148.9	216.9	1.9	12.0	2
10.3	3	MDA1030S12H03	38.6	53.9	117.4	1.4	12.0	1
	5	MDA1030S12H05	70.1	85.4	150.4	1.4	12.0	1
	10	MDA1030S12H10	133.6	148.9	216.9	1.9	12.0	2
10.4	3	MDA1040S12H03	38.3	53.9	117.4	1.4	12.0	1
	5	MDA1040S12H05	69.8	85.4	150.4	1.4	12.0	1
	10	MDA1040S12H10	133.3	148.9	216.9	1.9	12.0	2
10.5	3	MDA1050S12H03	38.2	53.9	117.4	1.4	12.0	1
	5	MDA1050S12H05	69.7	85.4	150.4	1.4	12.0	1
	10	MDA1050S12H10	133.2	148.9	216.9	1.9	12.0	2

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■刀体 刃径 $\phi 10.6 \sim 12.0\text{mm}$

尺寸(mm)

刃径 DC (mm)	孔 深 存	型号	有效长度 LU	排屑槽长度 LCF	全长 OAL	前端 PL	柄径 DCON	Fig
10.6	3	MDA1060S12H03	38.5	54.4	117.4	1.4	12.0	1
	5	MDA1060S12H05	71.5	87.4	150.4	1.4	12.0	1
	10	MDA1060S12H10	138.0	153.9	216.9	1.9	12.0	2
10.7	3	MDA1070S12H03	38.4	54.4	117.4	1.4	12.0	1
	5	MDA1070S12H05	71.4	87.4	150.4	1.4	12.0	1
	10	MDA1070S12H10	137.9	153.9	216.9	1.9	12.0	2
10.8	3	MDA1080S12H03	38.2	54.4	117.4	1.4	12.0	1
	5	MDA1080S12H05	71.2	87.4	150.4	1.4	12.0	1
	10	MDA1080S12H10	137.8	154.0	217.0	2.0	12.0	2
10.9	3	MDA1090S12H03	38.1	54.5	117.5	1.5	12.0	1
	5	MDA1090S12H05	71.1	87.5	150.5	1.5	12.0	1
	10	MDA1090S12H10	137.6	154.0	217.0	2.0	12.0	2
11.0	3	MDA1100S12H03	38.0	54.5	117.5	1.5	12.0	1
	5	MDA1100S12H05	71.0	87.5	150.5	1.5	12.0	1
	10	MDA1100S12H10	137.5	154.0	217.0	2.0	12.0	2
11.1	3	MDA1110S12H03	42.3	59.0	123.5	1.5	12.0	1
	5	MDA1110S12H05	76.8	93.5	159.5	1.5	12.0	1
	10	MDA1110S12H10	146.4	163.0	232.0	2.0	12.0	2
11.2	3	MDA1120S12H03	42.2	59.0	123.5	1.5	12.0	1
	5	MDA1120S12H05	76.7	93.5	159.5	1.5	12.0	1
	10	MDA1120S12H10	146.2	163.0	232.0	2.0	12.0	2
11.3	3	MDA1130S12H03	42.1	59.0	123.5	1.5	12.0	1
	5	MDA1130S12H05	76.6	93.5	159.5	1.5	12.0	1
	10	MDA1130S12H10	146.1	163.1	232.1	2.1	12.0	2
11.4	3	MDA1140S12H03	41.9	59.0	123.5	1.5	12.0	1
	5	MDA1140S12H05	76.4	93.5	159.5	1.5	12.0	1
	10	MDA1140S12H10	146.0	163.1	232.1	2.1	12.0	2
11.5	3	MDA1150S12H03	41.8	59.0	123.5	1.5	12.0	1
	5	MDA1150S12H05	76.3	93.5	159.5	1.5	12.0	1
	10	MDA1150S12H10	145.8	163.1	232.1	2.1	12.0	2
11.6	3	MDA1160S12H03	44.1	61.5	123.5	1.6	12.0	1
	5	MDA1160S12H05	80.1	97.5	159.5	1.6	12.0	1
	10	MDA1160S12H10	152.7	170.1	232.1	2.1	12.0	2
11.7	3	MDA1170S12H03	44.0	61.6	123.6	1.6	12.0	1
	5	MDA1170S12H05	80.0	97.6	159.6	1.6	12.0	1
	10	MDA1170S12H10	152.6	170.1	232.1	2.1	12.0	2
11.8	3	MDA1180S12H03	43.9	61.6	123.6	1.6	12.0	1
	5	MDA1180S12H05	79.9	97.6	159.6	1.6	12.0	1
	10	MDA1180S12H10	152.4	170.1	232.1	2.1	12.0	2
11.9	3	MDA1190S12H03	43.7	61.6	123.6	1.6	12.0	1
	5	MDA1190S12H05	79.7	97.6	159.6	1.6	12.0	1
	10	MDA1190S12H10	152.3	170.2	232.2	2.2	12.0	2
12.0	3	MDA1200S12H03	43.6	61.6	123.6	1.6	12.0	1
	5	MDA1200S12H05	79.6	97.6	159.6	1.6	12.0	1
	10	MDA1200S12H10	152.2	170.2	232.2	2.2	12.0	2

材质 DLX1700

●印:标准库存品 无印:接单生产品

■ 推荐切削条件 (L/D=3D,5D)

被削材	铝合金铸件/铝合金压铸件 ADC、AC(硬度≤100HB)		铝合金铸件/铝合金压铸件 ADC、AC(硬度>100HB)		铝合金 硬铝类 Al-Zn-Mg类(7075)		铝合金延展材料 Al-Mg类(5052)	
	切削速度(m/min)	进给量(mm/rev)	切削速度(m/min)	进给量(mm/rev)	切削速度(m/min)	进给量(mm/rev)	切削速度(m/min)	进给量(mm/rev)
~ ø2.00	50 - 120	0.05 - 0.40	50 - 120	0.05 - 0.15	40 - 90	0.05 - 0.20	50 - 120	0.04 - 0.08
~ ø3.00	60 - 150	0.10 - 0.60	60 - 150	0.05 - 0.20	50 - 100	0.10 - 0.30	60 - 150	0.04 - 0.08
~ ø4.00	60 - 150	0.15 - 0.80	60 - 150	0.10 - 0.25	50 - 120	0.15 - 0.40	60 - 150	0.05 - 0.12
~ ø6.00	80 - 200	0.20 - 1.20	80 - 200	0.10 - 0.40	80 - 180	0.20 - 0.60	80 - 200	0.08 - 0.18
~ ø8.00	100 - 200	0.20 - 1.20	100 - 200	0.10 - 0.40	80 - 180	0.20 - 0.80	100 - 200	0.10 - 0.20
~ ø10.00	100 - 200	0.20 - 1.20	100 - 200	0.10 - 0.40	100 - 180	0.20 - 0.80	100 - 200	0.10 - 0.25
~ ø12.00	120 - 250	0.20 - 1.20	120 - 250	0.10 - 0.40	120 - 200	0.20 - 0.80	120 - 250	0.10 - 0.30

- 上述推荐切削条件表为使用水溶性切削油剂时的值。
- 请使用内冷供油。
- 关于切削油剂的供给压力, ø3以下建议为2.0MPa以上, 超出ø3建议为1.5MPa以上。
- 钻头的跳动请控制在0.02mm以下。
- 发现有异响或异常振动时, 请根据情况变更切削条件。
- 加工铸件通孔时, 建议使用推荐条件的下限。

■ 推荐切削条件 (L/D=10D以上)

被削材	铝合金铸件/铝合金压铸件 ADC、AC(硬度≤100HB)		铝合金铸件/铝合金压铸件 ADC、AC(硬度>100HB)		铝合金 硬铝类 Al-Zn-Mg类(7075)		铝合金延展材料 Al-Mg类(5052)	
	切削速度(m/min)	进给量(mm/rev)	切削速度(m/min)	进给量(mm/rev)	切削速度(m/min)	进给量(mm/rev)	切削速度(m/min)	进给量(mm/rev)
~ ø2.00	50 - 100	0.05 - 0.20	50 - 100	0.05 - 0.10	40 - 60	0.05 - 0.15	50 - 100	0.04 - 0.08
~ ø3.00	60 - 120	0.10 - 0.30	60 - 120	0.05 - 0.15	50 - 80	0.10 - 0.20	60 - 120	0.04 - 0.08
~ ø4.00	60 - 120	0.15 - 0.40	60 - 120	0.10 - 0.20	50 - 100	0.10 - 0.25	60 - 120	0.04 - 0.10
~ ø6.00	80 - 150	0.20 - 0.60	80 - 150	0.10 - 0.30	60 - 120	0.15 - 0.30	80 - 150	0.06 - 0.12
~ ø8.00	80 - 180	0.20 - 0.60	80 - 180	0.10 - 0.30	80 - 150	0.20 - 0.40	80 - 180	0.08 - 0.15
~ ø10.00	100 - 180	0.20 - 0.60	100 - 180	0.10 - 0.30	100 - 150	0.20 - 0.40	100 - 180	0.10 - 0.20
~ ø12.00	120 - 200	0.20 - 0.60	120 - 200	0.10 - 0.30	120 - 180	0.20 - 0.40	120 - 200	0.10 - 0.25

- 上述推荐切削条件表为使用水溶性切削油剂时的值。
- 请使用内冷供油。
- 关于切削油剂的供给压力, ø3以下建议为2.0MPa以上, 超出ø3建议为1.5MPa以上。
- 钻头的跳动请控制在0.02mm以下。
- 发现有异响或异常振动时, 请根据情况变更切削条件。
- 关于预铸孔的加工, 不建议使用10D (以上) 钻头。
- 10D以上的钻孔加工可能会发生异常, 因此请先加工引导孔 (孔深1D~2D)。
- 加工引导孔可使用3D (5D) 钻头。(加工引导孔时请根据“10D以上推荐进给量”降低条件进行加工)

◆安全使用注意事项◆



- 加工时会出现高温切屑飞散、排出切屑过长等情况, 请使用安全罩壳及防护眼镜等防护具, 并务必注意防火、防火。
- Very hot or lengthy chips may be discharged while the machine is in operation. Therefore, machine guards, safety goggles or other protective covers must be used. Fire safety precautions must also be considered.

- 使用时请务必小心锋利刀尖。
- 使用错误、使用条件不当, 会造成刀具崩损、飞散, 请在推荐的范围内使用。

- Please handle with care as this product has sharp edges.
- Improper cutting conditions or mis-handling of the tool may result in breakages or projectiles. Therefore, please use the tool within its recommended conditions.

- 使用非水溶性切削油的情况, 为防止火灾意外, 请配置自动灭火装置。

- When using non-water soluble cutting oil, precautions against fire must be taken and please ensure that a fire extinguisher is placed near the machine.



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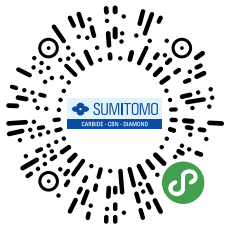
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