

高性能  
新平頭鑽

# KDZ

獨家研發新鍍層  
創新款的平頭鑽  
實現「長壽命」「高精度」「安定加工」



**MEGACOAT**  
**NANO EX** | Solid |

可解決鉸孔加工等多種課題  
性能佳且兼具成本考量  
K-series 的新成員

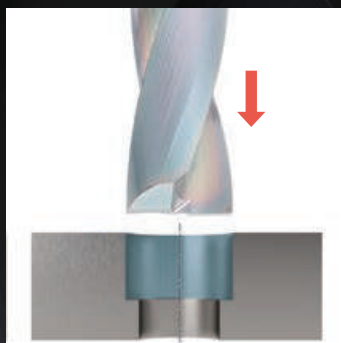


# KDZ

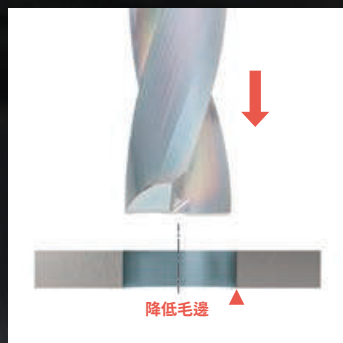
Re: Innovation 創新設計

## 如極光般閃耀的 高性能 新平頭鑽

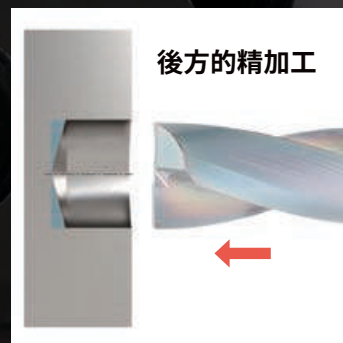
### 1 可對應多種加工需求



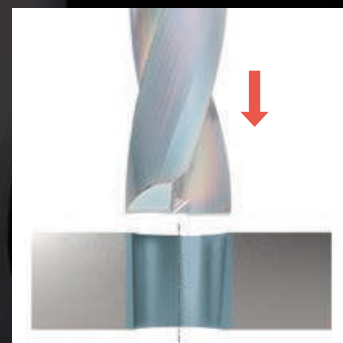
鉋孔加工



薄板的突出處加工



自動車床加工



孔精度校正

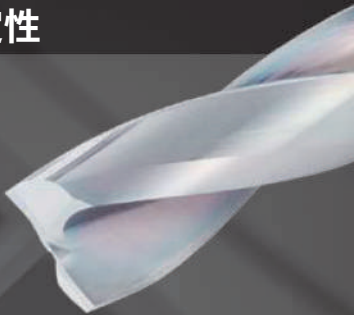
## 提供兩種選擇對應不同加工需求

重視加工安定性

# KDZ

標準型

刀尖強化



短款

標準款

計111型番  
加工徑  $\phi 1.0 \sim \phi 12.0$

計91型番  
加工徑  $\phi 3.0 \sim \phi 12.0$

可對應多種加工需求並實現安定加工  
標準型

- 刀尖角採水平設計
- 切屑排出順暢
- 鍍層延長工具壽命

進行圓面、曲面的開孔加工時，有先端角設計的鑽頭在對應較困難的加工件時仍能實現高精度加工  
推薦使用 KDZ-HP 款式

重視刀刃鋒利度

# KDZ-HP

高精度加工

低切削阻力



NEW

短款

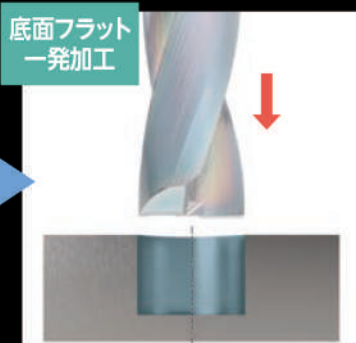
標準款

計127型番  
加工徑  $\phi 1.0 \sim \phi 20.0$

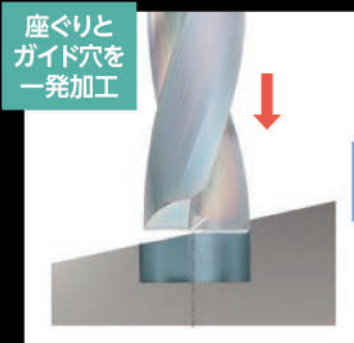
計91型番  
加工徑  $\phi 3.0 \sim \phi 12.0$

特殊螺旋設計，實現高精度的安定加工

- 順暢的進刀，改善加工精度
- スムーズな食付きで加工精度向上
- MEGACOAT NANO EX で長寿命  
鍍層延長工具壽命



加工後の底部精修



傾斜面の鉋孔加工及先導孔加工



具備客戶追求的性能表現  
獨家研發的表面鍍層



## 2 耐磨耗性及耐崩損性兼備

特殊Nano積層×多層積層

Nano 積層化

AICrN 系鍍層

高潤滑性、溶着性



Nano 積層化

TiAlN 系鍍層

優異的耐摩耗性



Point

1. 修正鍍層積層週期，韌性更佳
2. 增加潤滑度高的Cr比例，達到抑制振刀及提高耐摩耗的目的

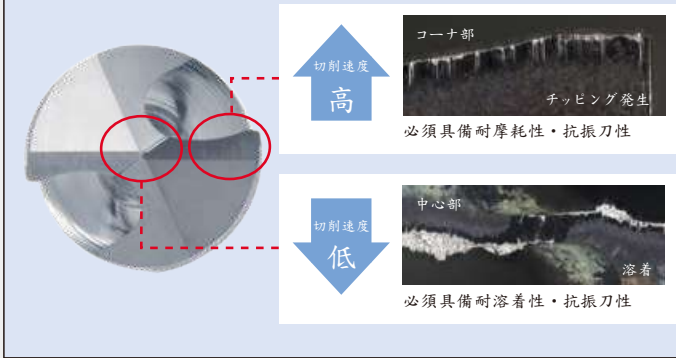
膜

3

母材

## 一般鑽頭會遇到的課題

因外圓側與靠近中心側的速度不同  
為了延長工具壽命，必須分別進行設計



## Solution

孔加工時刀刃狀態比較 (当社比較)



切削条件: Vc=80m/min, f=0.06mm/rev  
加工径φ3, 加工深さ: 6mm Wet(外部給油) 被削材: S50C

KDZ 使用 MEGACOAT® NANO EX，以下三種性能皆被提升，進一步實現高精度孔加工

耐摩耗性

耐溶着性

抗振刀

## 3 獨家的設計帶來強大的性能

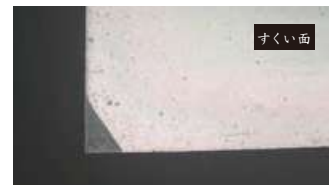
### KDZ

安定性重視

大容屑槽  
切屑排出性能卓越



提升耐欠損性的水平設計



すくい面

### KDZ-HP

鋒利度重視

特殊弧度設計  
幫助切屑分段  
改善切屑排出效率  
減輕刀刃中心的負荷



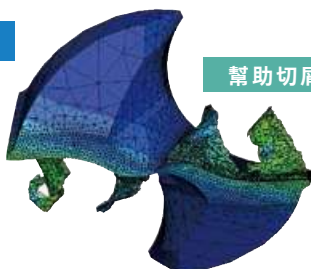
無水平設計，從刀尖開始便有角度  
進刀量提升，達到高精度、安定加工的目標 (~φ12.0)



すくい面

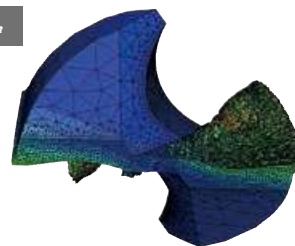
切屑生成的模擬比較圖 (電腦模擬)

KDZ-HP

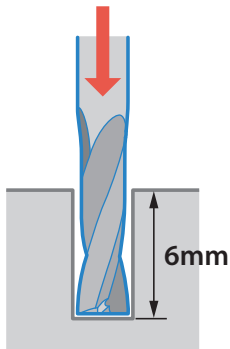
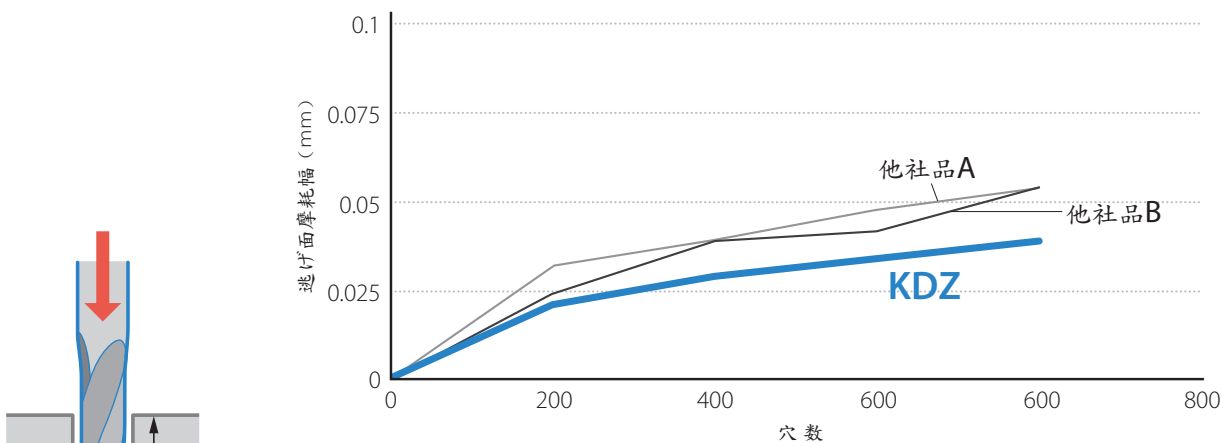


幫助切屑分段

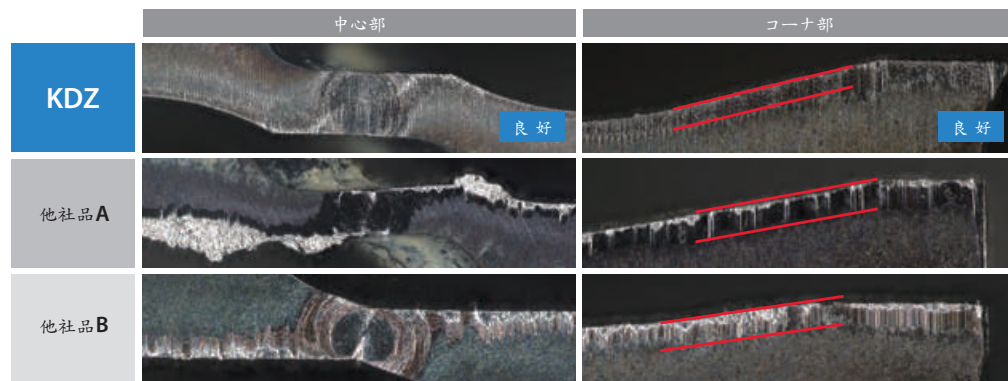
舊產品



耐摩耗性比較



刀尖狀態



切削条件: Vc=80m/min, f=0.06mm/rev, 加工径φ3, 加工深さ: 6mm Wet(外部給油) 被削材: S50C

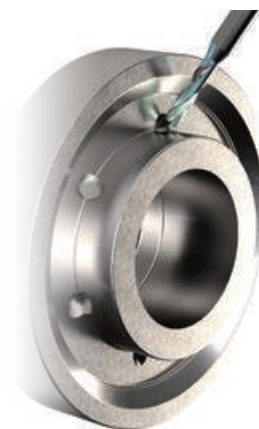
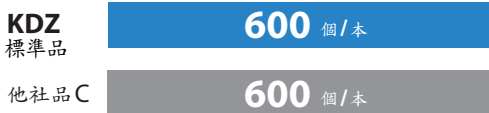
**KDZ 有效抑制摩耗量。溶着以及振刀發生頻率也很低  
完全體現三種性能：耐摩耗性・耐溶着性・抗振刀**

加工實例

自動車部品 S25C

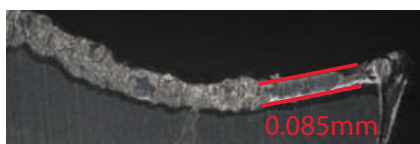
n = 6,000 min<sup>-1</sup> (Vc = 55 m/min)  
Vf = 115 mm/min (f = 0.02 mm/rev)  
加工深さ 3 mm Wet(外部給油) KDZ0300X3.0S060N

加工個数

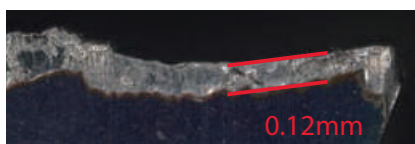


刀尖狀態

**KDZ**



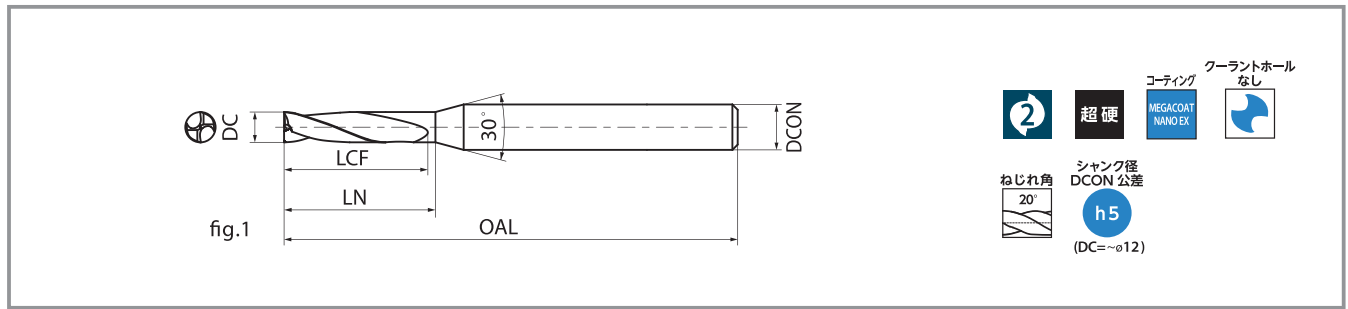
他社品C



KDZ 有良好的耐摩耗性，能實現安定加工

(ユーザー様の評価による)

# KDZ 短版



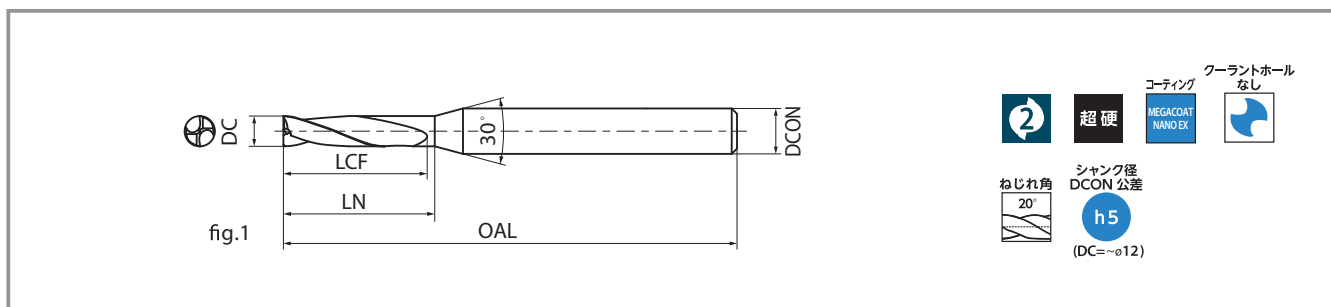
型番	在庫	寸法(mm)					形状	
		DC	外径公差	LCF	LN	DCON		OAL
KDZ0100X1.5S040N	●	1.0	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	3	4	4	50	fig.1
KDZ0110X1.5S040N	●	1.1	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	3.5	4.5	4	50	fig.1
KDZ0120X1.5S040N	●	1.2	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	4	5	4	50	fig.1
KDZ0130X1.5S040N	●	1.3	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	4.5	5.5	4	50	fig.1
KDZ0140X1.5S040N	●	1.4	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	5	6	4	50	fig.1
KDZ0150X1.5S040N	●	1.5	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	5.5	6.5	4	50	fig.1
KDZ0160X1.5S040N	●	1.6	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	6	7	4	50	fig.1
KDZ0170X1.5S040N	●	1.7	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	6.5	7.5	4	50	fig.1
KDZ0180X1.5S040N	●	1.8	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	7	8	4	50	fig.1
KDZ0190X1.5S040N	●	1.9	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	7.5	8.5	4	50	fig.1
KDZ0200X1.5S040N	●	2.0	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	8	9	4	50	fig.1
KDZ0210X1.5S040N	●	2.1	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	8.5	9.5	4	50	fig.1
KDZ0220X1.5S040N	●	2.2	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	9	10	4	50	fig.1
KDZ0230X1.5S040N	●	2.3	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	9.5	10.5	4	50	fig.1
KDZ0240X1.5S040N	●	2.4	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	10	11	4	50	fig.1
KDZ0250X1.5S040N	●	2.5	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	10.5	11.5	4	50	fig.1
KDZ0260X1.5S040N	●	2.6	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	11	12	4	50	fig.1
KDZ0270X1.5S040N	●	2.7	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	11.5	12.5	4	50	fig.1
KDZ0280X1.5S040N	●	2.8	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	12	13	4	50	fig.1
KDZ0290X1.5S040N	●	2.9	$\begin{matrix} 0 \\ -0.010 \end{matrix}$	12.5	13.5	4	50	fig.1
KDZ0300X1.5S060N	●	3.0	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	13	14	6	60	fig.1
KDZ0310X1.5S060N	●	3.1	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	13.5	14.5	6	60	fig.1
KDZ0320X1.5S060N	●	3.2	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	14	15	6	60	fig.1
KDZ0330X1.5S060N	●	3.3	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	14.5	15.5	6	60	fig.1
KDZ0340X1.5S060N	●	3.4	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	15	16	6	60	fig.1
KDZ0350X1.5S060N	●	3.5	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	15.5	16.5	6	60	fig.1
KDZ0360X1.5S060N	●	3.6	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	16	17	6	60	fig.1

型番	在庫	寸法(mm)					形状	
		DC	外径公差	LCF	LN	DCON		OAL
KDZ0370X1.5S060N	●	3.7	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	16.5	17.5	6	60	fig.1
KDZ0380X1.5S060N	●	3.8	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	17	18	6	60	fig.1
KDZ0390X1.5S060N	●	3.9	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	17.5	18.5	6	60	fig.1
KDZ0400X1.5S060N	●	4.0	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	18	19	6	60	fig.1
KDZ0410X1.5S060N	●	4.1	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	18.5	19.5	6	60	fig.1
KDZ0420X1.5S060N	●	4.2	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	19	20	6	60	fig.1
KDZ0430X1.5S060N	●	4.3	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	19.5	20.5	6	60	fig.1
KDZ0440X1.5S060N	●	4.4	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	20	21	6	60	fig.1
KDZ0450X1.5S060N	●	4.5	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	20.5	21.5	6	60	fig.1
KDZ0460X1.5S060N	●	4.6	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	21	22	6	60	fig.1
KDZ0470X1.5S060N	●	4.7	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	21.5	22.5	6	60	fig.1
KDZ0480X1.5S060N	●	4.8	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	22	23	6	60	fig.1
KDZ0490X1.5S060N	●	4.9	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	22.5	23.5	6	60	fig.1
KDZ0500X1.5S060N	●	5.0	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	23	24	6	60	fig.1
KDZ0510X1.5S060N	●	5.1	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	23.5	24.5	6	60	fig.1
KDZ0520X1.5S060N	●	5.2	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	24	25	6	60	fig.1
KDZ0530X1.5S060N	●	5.3	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	24.5	25.5	6	60	fig.1
KDZ0540X1.5S060N	●	5.4	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	25	26	6	60	fig.1
KDZ0550X1.5S060N	●	5.5	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	25.5	26.5	6	60	fig.1
KDZ0560X1.5S060N	●	5.6	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	26	27	6	60	fig.1
KDZ0570X1.5S060N	●	5.7	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	26.5	27.5	6	60	fig.1
KDZ0580X1.5S060N	●	5.8	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	27	28	6	60	fig.1
KDZ0590X1.5S060N	●	5.9	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	27.5	28.5	6	60	fig.1

●: 標準在庫

加工深度請設定為 1.5 D (1.5xDC)

# KDZ 短版



型番	在庫	寸法(mm)					形状	
		DC	外径公差	LCF	LN	DCON		
KDZ0600X1.5S060N	●	6.0	$0_{-0.012}$			6	60	fig.1
KDZ0610X1.5S080N	●	6.1	$0_{-0.015}$	19	21	8	70	
KDZ0620X1.5S080N	●	6.2						
KDZ0630X1.5S080N	●	6.3	$0_{-0.015}$	20	22	8	70	fig.1
KDZ0640X1.5S080N	●	6.4						
KDZ0650X1.5S080N	●	6.5						
KDZ0660X1.5S080N	●	6.6						
KDZ0670X1.5S080N	●	6.7	$0_{-0.015}$	21	23	8	70	fig.1
KDZ0680X1.5S080N	●	6.8						
KDZ0690X1.5S080N	●	6.9						
KDZ0700X1.5S080N	●	7.0	$0_{-0.015}$	22	24	8	70	fig.1
KDZ0710X1.5S080N	●	7.1						
KDZ0720X1.5S080N	●	7.2						
KDZ0730X1.5S080N	●	7.3						
KDZ0740X1.5S080N	●	7.4	$0_{-0.015}$	23	25	8	70	fig.1
KDZ0750X1.5S080N	●	7.5						
KDZ0760X1.5S080N	●	7.6	$0_{-0.015}$	24	25	8	70	fig.1
KDZ0770X1.5S080N	●	7.7						
KDZ0780X1.5S080N	●	7.8						
KDZ0790X1.5S080N	●	7.9						
KDZ0800X1.5S080N	●	8.0	$0_{-0.015}$	25	27	8	70	fig.1
KDZ0810X1.5S100N	●	8.1				10	80	
KDZ0820X1.5S100N	●	8.2						
KDZ0830X1.5S100N	●	8.3	$0_{-0.015}$	26	28	10	80	fig.1
KDZ0840X1.5S100N	●	8.4						
KDZ0850X1.5S100N	●	8.5						
KDZ0860X1.5S100N	●	8.6	$0_{-0.015}$	27	29	10	80	fig.1
KDZ0870X1.5S100N	●	8.7						
KDZ0880X1.5S100N	●	8.8						
KDZ0890X1.5S100N	●	8.9						
KDZ0900X1.5S100N	●	9.0	$0_{-0.015}$	28	30	10	80	fig.1
KDZ0910X1.5S100N	●	9.1						

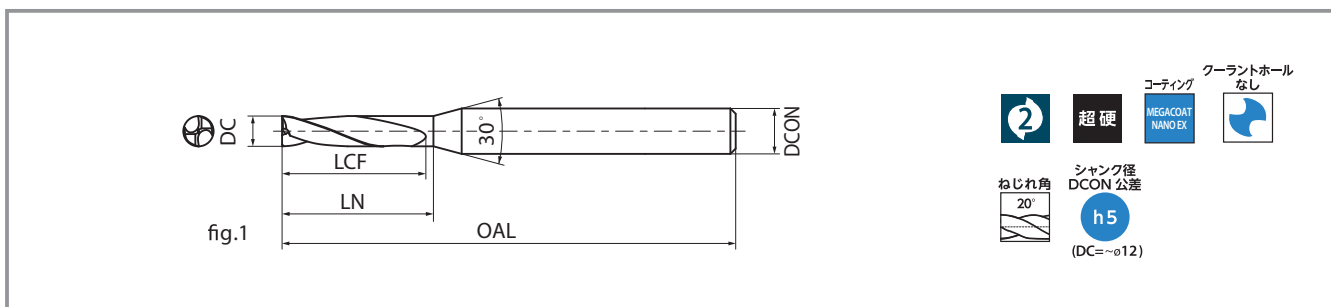
型番	在庫	寸法(mm)					形状	
		DC	外径公差	LCF	LN	DCON		
KDZ0920X1.5S100N	●	9.2	$0_{-0.015}$	29	31	10	80	fig.1
KDZ0930X1.5S100N	●	9.3						
KDZ0940X1.5S100N	●	9.4						
KDZ0950X1.5S100N	●	9.5						
KDZ0960X1.5S100N	●	9.6	$0_{-0.015}$	30	32	10	80	fig.1
KDZ0970X1.5S100N	●	9.7						
KDZ0980X1.5S100N	●	9.8						
KDZ0990X1.5S100N	●	9.9						
KDZ1000X1.5S100N	●	10.0	$0_{-0.015}$	31	33	10	80	fig.1
KDZ1010X1.5S120N	●	10.1				12	100	
KDZ1020X1.5S120N	●	10.2	$0_{-0.018}$	32	34	12	100	fig.1
KDZ1030X1.5S120N	●	10.3						
KDZ1040X1.5S120N	●	10.4						
KDZ1050X1.5S120N	●	10.5						
KDZ1060X1.5S120N	●	10.6	$0_{-0.018}$	33	35	12	100	fig.1
KDZ1070X1.5S120N	●	10.7						
KDZ1080X1.5S120N	●	10.8						
KDZ1090X1.5S120N	●	10.9	$0_{-0.018}$	34	36	12	100	fig.1
KDZ1100X1.5S120N	●	11.0						
KDZ1110X1.5S120N	●	11.1						
KDZ1120X1.5S120N	●	11.2						
KDZ1130X1.5S120N	●	11.3	$0_{-0.018}$	35	37	12	100	fig.1
KDZ1140X1.5S120N	●	11.4						
KDZ1150X1.5S120N	●	11.5						
KDZ1160X1.5S120N	●	11.6	$0_{-0.018}$	36	38	12	100	fig.1
KDZ1170X1.5S120N	●	11.7						
KDZ1180X1.5S120N	●	11.8						
KDZ1190X1.5S120N	●	11.9						
KDZ1200X1.5S120N	●	12.0	$0_{-0.018}$	37	39	12	100	fig.1

●：標準在庫

加工深度請設定為 1.5 D (1.5xDC)



# KDZ 標準長度

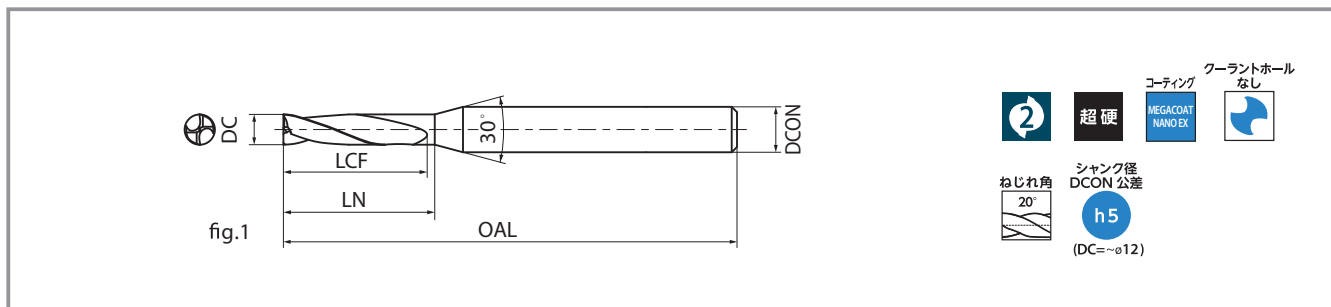


型番	在庫	寸法(mm)					形状	
		DC	外径公差	LCF	LN	DCON		OAL
KDZ0300X3.0S060N	●	3.0	$\begin{matrix} 0 \\ -0.010 \end{matrix}$					
KDZ0310X3.0S060N	●	3.1	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	14	15	6	60	fig.1
KDZ0320X3.0S060N	●	3.2	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0330X3.0S060N	●	3.3	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	15	16	6	60	fig.1
KDZ0340X3.0S060N	●	3.4	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0350X3.0S060N	●	3.5	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0360X3.0S060N	●	3.6	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0370X3.0S060N	●	3.7	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	17	18	6	60	fig.1
KDZ0380X3.0S060N	●	3.8	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0390X3.0S060N	●	3.9	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0400X3.0S060N	●	4.0	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	19	20	6	60	fig.1
KDZ0410X3.0S060N	●	4.1	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0420X3.0S060N	●	4.2	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0430X3.0S060N	●	4.3	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	20	21	6	60	fig.1
KDZ0440X3.0S060N	●	4.4	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0450X3.0S060N	●	4.5	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0460X3.0S060N	●	4.6	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	21	22	6	60	fig.1
KDZ0470X3.0S060N	●	4.7	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					

型番	在庫	寸法(mm)					形状	
		DC	外径公差	LCF	LN	DCON		OAL
KDZ0480X3.0S060N	●	4.8	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	21	22	6	60	fig.1
KDZ0490X3.0S060N	●	4.9	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0500X3.0S060N	●	5.0	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0510X3.0S060N	●	5.1	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	23	24	6	60	fig.1
KDZ0520X3.0S060N	●	5.2	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0530X3.0S060N	●	5.3	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	24	25	6	60	fig.1
KDZ0540X3.0S060N	●	5.4	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0550X3.0S060N	●	5.5	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	25	26	6	60	fig.1
KDZ0560X3.0S060N	●	5.6	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0570X3.0S060N	●	5.7	$\begin{matrix} 0 \\ -0.012 \end{matrix}$	26	27	6	60	fig.1
KDZ0580X3.0S060N	●	5.8	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0590X3.0S060N	●	5.9	$\begin{matrix} 0 \\ -0.012 \end{matrix}$					
KDZ0600X3.0S060N	●	6.0	$\begin{matrix} 0 \\ -0.012 \end{matrix}$		28	6	60	
KDZ0610X3.0S080N	●	6.1	$\begin{matrix} 0 \\ -0.015 \end{matrix}$					
KDZ0620X3.0S080N	●	6.2	$\begin{matrix} 0 \\ -0.015 \end{matrix}$	28				fig.1
KDZ0630X3.0S080N	●	6.3	$\begin{matrix} 0 \\ -0.015 \end{matrix}$		29	8	70	
KDZ0640X3.0S080N	●	6.4	$\begin{matrix} 0 \\ -0.015 \end{matrix}$					
KDZ0650X3.0S080N	●	6.5	$\begin{matrix} 0 \\ -0.015 \end{matrix}$	30	31	8	70	fig.1

加工深度請設定為 2.0 D (2.0xDC)  
 深度超過2.0D時，推薦使用階梯式加工

# KDZ 標準長度



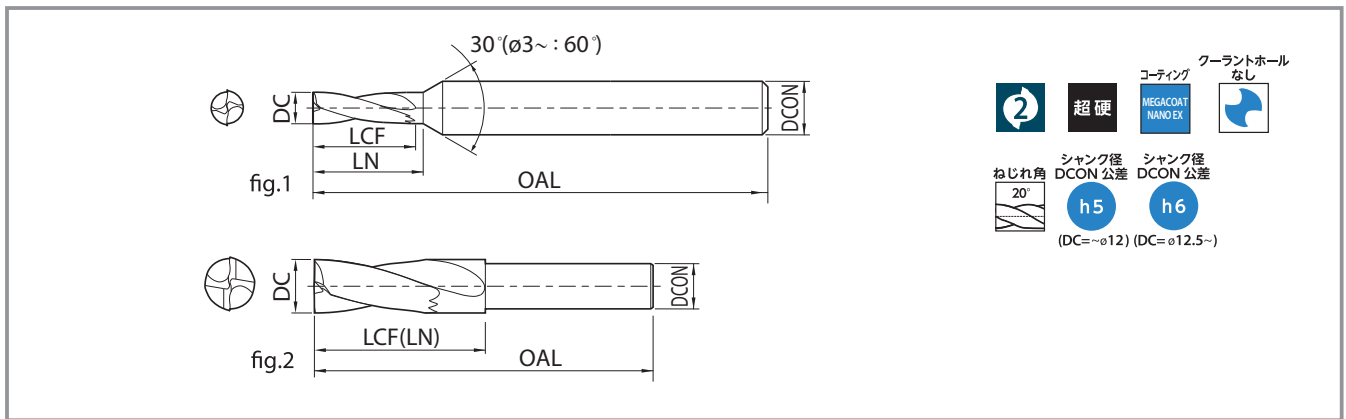
型番	在庫	寸法(mm)						形状
		DC	外径公差	LCF	LN	DCON	OAL	
KDZ0660X3.0S080N	●	6.6	0 -0.015	30	31	8	70	fig.1
KDZ0670X3.0S080N	●	6.7						
KDZ0680X3.0S080N	●	6.8	0 -0.015	31	32	8	70	fig.1
KDZ0690X3.0S080N	●	6.9						
KDZ0700X3.0S080N	●	7.0	0 -0.015	32	33	8	70	fig.1
KDZ0710X3.0S080N	●	7.1						
KDZ0720X3.0S080N	●	7.2						
KDZ0730X3.0S080N	●	7.3						
KDZ0740X3.0S080N	●	7.4						
KDZ0750X3.0S080N	●	7.5						
KDZ0760X3.0S080N	●	7.6						
KDZ0770X3.0S080N	●	7.7						
KDZ0780X3.0S080N	●	7.8	0 -0.015	34	35	8	70	fig.1
KDZ0790X3.0S080N	●	7.9						
KDZ0800X3.0S080N	●	8.0	0 -0.015	36	36	8	70	fig.1
KDZ0810X3.0S100N	●	8.1						
KDZ0820X3.0S100N	●	8.2			37	10	80	
KDZ0830X3.0S100N	●	8.3						
KDZ0840X3.0S100N	●	8.4						
KDZ0850X3.0S100N	●	8.5						
KDZ0860X3.0S100N	●	8.6	0 -0.015	38	39	10	80	fig.1
KDZ0870X3.0S100N	●	8.7						
KDZ0880X3.0S100N	●	8.8	0 -0.015	39	40	10	80	fig.1
KDZ0890X3.0S100N	●	8.9						
KDZ0900X3.0S100N	●	9.0	0 -0.015	40	41	10	80	fig.1
KDZ0910X3.0S100N	●	9.1						
KDZ0920X3.0S100N	●	9.2						
KDZ0930X3.0S100N	●	9.3						
KDZ0940X3.0S100N	●	9.4						

型番	在庫	寸法(mm)						形状
		DC	外径公差	LCF	LN	DCON	OAL	
KDZ0950X3.0S100N	●	9.5	0 -0.015	42	43	10	80	fig.1
KDZ0960X3.0S100N	●	9.6						
KDZ0970X3.0S100N	●	9.7						
KDZ0980X3.0S100N	●	9.8						
KDZ0990X3.0S100N	●	9.9						
KDZ1000X3.0S100N	●	10.0						
KDZ1010X3.0S120N	●	10.1	0 -0.018	45	46	12	100	fig.1
KDZ1020X3.0S120N	●	10.2						
KDZ1030X3.0S120N	●	10.3	0 -0.018	46	47	12	100	fig.1
KDZ1040X3.0S120N	●	10.4						
KDZ1050X3.0S120N	●	10.5	0 -0.018	47	48	12	100	fig.1
KDZ1060X3.0S120N	●	10.6						
KDZ1070X3.0S120N	●	10.7						
KDZ1080X3.0S120N	●	10.8						
KDZ1090X3.0S120N	●	10.9						
KDZ1100X3.0S120N	●	11.0						
KDZ1110X3.0S120N	●	11.1	0 -0.018	51	52	12	100	fig.1
KDZ1120X3.0S120N	●	11.2						
KDZ1130X3.0S120N	●	11.3						
KDZ1140X3.0S120N	●	11.4						
KDZ1150X3.0S120N	●	11.5	0 -0.018	53	54	12	100	fig.1
KDZ1160X3.0S120N	●	11.6						
KDZ1170X3.0S120N	●	11.7						
KDZ1180X3.0S120N	●	11.8						
KDZ1190X3.0S120N	●	11.9						
KDZ1200X3.0S120N	●	12.0						

●: 標準在庫

加工深度請設定為 2.0 D (2.0xDC)  
深度超過2.0D時，推薦使用階梯式加工

# KDZ-HP 短版



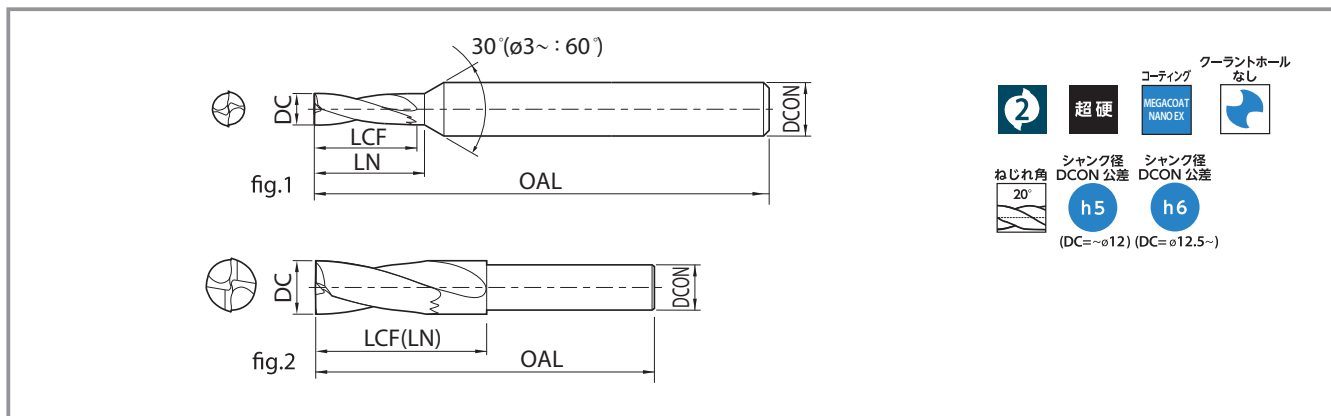
型番	在庫	寸法 (mm)					形状	
		DC	外径公差	LCF	LN	DCON		OAL
KDZ0100X1.5S040N-HP	●	1.0	$0_{-0.010}$	3.5	4.3	4	50	fig.1
KDZ0110X1.5S040N-HP	●	1.1	$0_{-0.010}$	3.9	4.7	4	50	fig.1
KDZ0120X1.5S040N-HP	●	1.2	$0_{-0.010}$	4.3	5.1	4	50	fig.1
KDZ0130X1.5S040N-HP	●	1.3	$0_{-0.010}$	4.7	5.5	4	50	fig.1
KDZ0140X1.5S040N-HP	●	1.4	$0_{-0.010}$	5.1	5.9	4	50	fig.1
KDZ0150X1.5S040N-HP	●	1.5	$0_{-0.010}$	5.5	6.3	4	50	fig.1
KDZ0160X1.5S040N-HP	●	1.6	$0_{-0.010}$	5.7	6.5	4	50	fig.1
KDZ0170X1.5S040N-HP	●	1.7	$0_{-0.010}$	5.9	6.7	4	50	fig.1
KDZ0180X1.5S040N-HP	●	1.8	$0_{-0.010}$	6.1	6.9	4	50	fig.1
KDZ0190X1.5S040N-HP	●	1.9	$0_{-0.010}$	6.3	7.1	4	50	fig.1
KDZ0200X1.5S040N-HP	●	2.0	$0_{-0.010}$	6.5	7.3	4	50	fig.1
KDZ0210X1.5S040N-HP	●	2.1	$0_{-0.010}$	6.9	7.7	4	50	fig.1
KDZ0220X1.5S040N-HP	●	2.2	$0_{-0.010}$	7.3	8.1	4	50	fig.1
KDZ0230X1.5S040N-HP	●	2.3	$0_{-0.010}$	7.7	8.5	4	50	fig.1
KDZ0240X1.5S040N-HP	●	2.4	$0_{-0.010}$	8.1	8.9	4	50	fig.1
KDZ0250X1.5S040N-HP	●	2.5	$0_{-0.010}$	8.5	9.3	4	50	fig.1
KDZ0260X1.5S040N-HP	●	2.6	$0_{-0.010}$	8.8	9.5	4	50	fig.1
KDZ0270X1.5S040N-HP	●	2.7	$0_{-0.010}$	9.1	9.8	4	50	fig.1
KDZ0280X1.5S040N-HP	●	2.8	$0_{-0.010}$	9.3	10.0	4	50	fig.1
KDZ0290X1.5S040N-HP	●	2.9	$0_{-0.010}$	9.5	10.3	4	50	fig.1
KDZ0300X1.5S060N-HP	●	3.0	$0_{-0.010}$	9	10	6	60	fig.1
KDZ0310X1.5S060N-HP	●	3.1						
KDZ0320X1.5S060N-HP	●	3.2	$0_{-0.012}$	10	11	6	60	fig.1
KDZ0330X1.5S060N-HP	●	3.3						
KDZ0340X1.5S060N-HP	●	3.4						
KDZ0350X1.5S060N-HP	●	3.5	$0_{-0.012}$	11	12	6	60	fig.1
KDZ0360X1.5S060N-HP	●	3.6						
KDZ0370X1.5S060N-HP	●	3.7						
KDZ0380X1.5S060N-HP	●	3.8						
KDZ0390X1.5S060N-HP	●	3.9	$0_{-0.012}$	12	13	6	60	fig.1
KDZ0400X1.5S060N-HP	●	4.0						
KDZ0410X1.5S060N-HP	●	4.1						
KDZ0420X1.5S060N-HP	●	4.2	$0_{-0.012}$	13	14	6	60	fig.1
KDZ0430X1.5S060N-HP	●	4.3						

加工深度請設定為 1.5 D (1.5xDC)

型番	在庫	寸法 (mm)					形状	
		DC	外径公差	LCF	LN	DCON		OAL
KDZ0440X1.5S060N-HP	●	4.4						
KDZ0450X1.5S060N-HP	●	4.5	$0_{-0.012}$	14	15	6	60	fig.1
KDZ0460X1.5S060N-HP	●	4.6						
KDZ0470X1.5S060N-HP	●	4.7						
KDZ0480X1.5S060N-HP	●	4.8	$0_{-0.012}$	15	16	6	60	fig.1
KDZ0490X1.5S060N-HP	●	4.9						
KDZ0500X1.5S060N-HP	●	5.0						
KDZ0510X1.5S060N-HP	●	5.1	$0_{-0.012}$	16	17	6	60	fig.1
KDZ0520X1.5S060N-HP	●	5.2						
KDZ0530X1.5S060N-HP	●	5.3						
KDZ0540X1.5S060N-HP	●	5.4						
KDZ0550X1.5S060N-HP	●	5.5	$0_{-0.012}$	17	18	6	60	fig.1
KDZ0560X1.5S060N-HP	●	5.6						
KDZ0570X1.5S060N-HP	●	5.7						
KDZ0580X1.5S060N-HP	●	5.8	$0_{-0.012}$	18	19	6	60	fig.1
KDZ0590X1.5S060N-HP	●	5.9						
KDZ0600X1.5S060N-HP	●	6.0	$0_{-0.012}$	19	21	6	60	fig.1
KDZ0610X1.5S080N-HP	●	6.1						
KDZ0620X1.5S080N-HP	●	6.2	$0_{-0.015}$	19	21	8	70	fig.1
KDZ0630X1.5S080N-HP	●	6.3						
KDZ0640X1.5S080N-HP	●	6.4	$0_{-0.015}$	20	22	8	70	fig.1
KDZ0650X1.5S080N-HP	●	6.5						
KDZ0660X1.5S080N-HP	●	6.6						
KDZ0670X1.5S080N-HP	●	6.7						
KDZ0680X1.5S080N-HP	●	6.8	$0_{-0.015}$	21	23	8	70	fig.1
KDZ0690X1.5S080N-HP	●	6.9						
KDZ0700X1.5S080N-HP	●	7.0						
KDZ0710X1.5S080N-HP	●	7.1	$0_{-0.015}$	22	24	8	70	fig.1
KDZ0720X1.5S080N-HP	●	7.2						
KDZ0730X1.5S080N-HP	●	7.3						
KDZ0740X1.5S080N-HP	●	7.4	$0_{-0.015}$	23	25	8	70	fig.1
KDZ0750X1.5S080N-HP	●	7.5						

●: 標準在庫

# KDZ-HP 短版



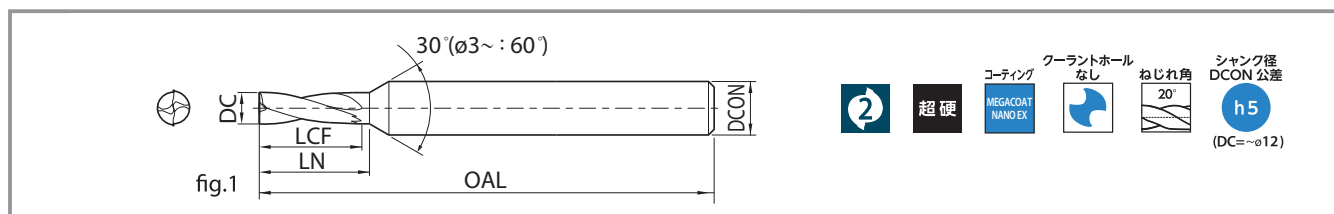
型番	在庫	寸法(mm)					形状	
		DC	外径公差	LCF	LN	DCON		OAL
KDZ0760X1.5S080N-HP	●	7.6						
KDZ0770X1.5S080N-HP	●	7.7						
KDZ0780X1.5S080N-HP	●	7.8	<sup>0</sup> <sub>-0.015</sub>	24	25	8	70	fig.1
KDZ0790X1.5S080N-HP	●	7.9						
KDZ0800X1.5S080N-HP	●	8.0	<sup>0</sup> <sub>-0.015</sub>	25	27	8	70	fig.1
KDZ0810X1.5S100N-HP	●	8.1						
KDZ0820X1.5S100N-HP	●	8.2	<sup>0</sup> <sub>-0.015</sub>	25	27	10	80	fig.1
KDZ0830X1.5S100N-HP	●	8.3						
KDZ0840X1.5S100N-HP	●	8.4	<sup>0</sup> <sub>-0.015</sub>	26	28	10	80	fig.1
KDZ0850X1.5S100N-HP	●	8.5						
KDZ0860X1.5S100N-HP	●	8.6						
KDZ0870X1.5S100N-HP	●	8.7	<sup>0</sup> <sub>-0.015</sub>	27	29	10	80	fig.1
KDZ0880X1.5S100N-HP	●	8.8						
KDZ0890X1.5S100N-HP	●	8.9						
KDZ0900X1.5S100N-HP	●	9.0	<sup>0</sup> <sub>-0.015</sub>	28	30	10	80	fig.1
KDZ0910X1.5S100N-HP	●	9.1						
KDZ0920X1.5S100N-HP	●	9.2						
KDZ0930X1.5S100N-HP	●	9.3						
KDZ0940X1.5S100N-HP	●	9.4	<sup>0</sup> <sub>-0.015</sub>	29	31	10	80	fig.1
KDZ0950X1.5S100N-HP	●	9.5						
KDZ0960X1.5S100N-HP	●	9.6						
KDZ0970X1.5S100N-HP	●	9.7	<sup>0</sup> <sub>-0.015</sub>	30	32	10	80	fig.1
KDZ0980X1.5S100N-HP	●	9.8						
KDZ0990X1.5S100N-HP	●	9.9	<sup>0</sup> <sub>-0.015</sub>	31	33	10	80	fig.1
KDZ1000X1.5S100N-HP	●	10.0						
KDZ1010X1.5S120N-HP	●	10.1	<sup>0</sup> <sub>-0.018</sub>	31	33	12	100	fig.1
KDZ1020X1.5S120N-HP	●	10.2						
KDZ1030X1.5S120N-HP	●	10.3	<sup>0</sup> <sub>-0.018</sub>	32	34	12	100	fig.1
KDZ1040X1.5S120N-HP	●	10.4						
KDZ1050X1.5S120N-HP	●	10.5						
KDZ1060X1.5S120N-HP	●	10.6						
KDZ1070X1.5S120N-HP	●	10.7	<sup>0</sup> <sub>-0.018</sub>	33	35	12	100	fig.1
KDZ1080X1.5S120N-HP	●	10.8						

加工深度請設定為 1.5 D (1.5xDC)

型番	在庫	寸法(mm)					形状	
		DC	外径公差	LCF	LN	DCON		OAL
KDZ1090X1.5S120N-HP	●	10.9						
KDZ1100X1.5S120N-HP	●	11.0	<sup>0</sup> <sub>-0.018</sub>	34	36	12	100	fig.1
KDZ1110X1.5S120N-HP	●	11.1						
KDZ1120X1.5S120N-HP	●	11.2						
KDZ1130X1.5S120N-HP	●	11.3	<sup>0</sup> <sub>-0.018</sub>	35	37	12	100	fig.1
KDZ1140X1.5S120N-HP	●	11.4						
KDZ1150X1.5S120N-HP	●	11.5						
KDZ1160X1.5S120N-HP	●	11.6						
KDZ1170X1.5S120N-HP	●	11.7	<sup>0</sup> <sub>-0.018</sub>	36	38	12	100	fig.1
KDZ1180X1.5S120N-HP	●	11.8						
KDZ1190X1.5S120N-HP	●	11.9						
KDZ1200X1.5S120N-HP	●	12.0	<sup>0</sup> <sub>-0.018</sub>	37	39	12	100	fig.1
KDZ1250X1.5S120N-HP	●	12.5						
KDZ1300X1.5S120N-HP	●	13.0						
KDZ1350X1.5S120N-HP	●	13.5	<sup>0</sup> <sub>-0.018</sub>			12	100	fig.2
KDZ1400X1.5S120N-HP	●	14.0						
KDZ1450X1.5S120N-HP	●	14.5						
KDZ1500X1.5S120N-HP	●	15.0	<sup>0</sup> <sub>-0.018</sub>			12	115	fig.2
KDZ1550X1.5S120N-HP	●	15.5						
KDZ1600X1.5S160N-HP	●	16.0	<sup>0</sup> <sub>-0.018</sub>	52	52	16	115	fig.1
KDZ1650X1.5S160N-HP	●	16.5						
KDZ1700X1.5S160N-HP	●	17.0						
KDZ1750X1.5S160N-HP	●	17.5	<sup>0</sup> <sub>-0.018</sub>			16	115	fig.2
KDZ1800X1.5S160N-HP	●	18.0						
KDZ1850X1.5S160N-HP	●	18.5						
KDZ1900X1.5S160N-HP	●	19.0	<sup>0</sup> <sub>-0.021</sub>			16	125	fig.2
KDZ1950X1.5S160N-HP	●	19.5						
KDZ2000X1.5S200N-HP	●	20.0	<sup>0</sup> <sub>-0.021</sub>	63	63	20	125	fig.1

●: 標準在庫

# KDZ-HP 標準長度



型番	在庫	寸法(mm)					形状	
		DC	外径公差	LCF	LN	DCON		OAL
KDZ0300X3.0S060N-HP	●	3.0	<sup>0</sup> / <sub>-0.010</sub>	14	15	6	60	fig.1
KDZ0310X3.0S060N-HP	●	3.1	<sup>0</sup> / <sub>-0.012</sub>	14	15	6	60	fig.1
KDZ0320X3.0S060N-HP	●	3.2	<sup>0</sup> / <sub>-0.012</sub>	15	16	6	60	fig.1
KDZ0330X3.0S060N-HP	●	3.3	<sup>0</sup> / <sub>-0.012</sub>	17	18	6	60	fig.1
KDZ0340X3.0S060N-HP	●	3.4	<sup>0</sup> / <sub>-0.012</sub>	19	20	6	60	fig.1
KDZ0350X3.0S060N-HP	●	3.5	<sup>0</sup> / <sub>-0.012</sub>	20	21	6	60	fig.1
KDZ0360X3.0S060N-HP	●	3.6	<sup>0</sup> / <sub>-0.012</sub>	21	22	6	60	fig.1
KDZ0370X3.0S060N-HP	●	3.7	<sup>0</sup> / <sub>-0.012</sub>	23	24	6	60	fig.1
KDZ0380X3.0S060N-HP	●	3.8	<sup>0</sup> / <sub>-0.012</sub>	24	25	6	60	fig.1
KDZ0390X3.0S060N-HP	●	3.9	<sup>0</sup> / <sub>-0.012</sub>	25	26	6	60	fig.1
KDZ0400X3.0S060N-HP	●	4.0	<sup>0</sup> / <sub>-0.012</sub>	26	27	6	60	fig.1
KDZ0410X3.0S060N-HP	●	4.1	<sup>0</sup> / <sub>-0.012</sub>	28	(28)	6	60	fig.1
KDZ0420X3.0S060N-HP	●	4.2	<sup>0</sup> / <sub>-0.012</sub>	28	29	8	70	fig.1
KDZ0430X3.0S060N-HP	●	4.3	<sup>0</sup> / <sub>-0.012</sub>	28	29	8	70	fig.1
KDZ0440X3.0S060N-HP	●	4.4	<sup>0</sup> / <sub>-0.012</sub>	30	31	8	70	fig.1
KDZ0450X3.0S060N-HP	●	4.5	<sup>0</sup> / <sub>-0.012</sub>	31	32	8	70	fig.1
KDZ0460X3.0S060N-HP	●	4.6	<sup>0</sup> / <sub>-0.012</sub>	31	32	8	70	fig.1
KDZ0470X3.0S060N-HP	●	4.7	<sup>0</sup> / <sub>-0.012</sub>	32	33	8	70	fig.1
KDZ0480X3.0S060N-HP	●	4.8	<sup>0</sup> / <sub>-0.012</sub>	34	35	8	70	fig.1
KDZ0490X3.0S060N-HP	●	4.9	<sup>0</sup> / <sub>-0.012</sub>	34	35	8	70	fig.1
KDZ0500X3.0S060N-HP	●	5.0	<sup>0</sup> / <sub>-0.012</sub>	34	35	8	70	fig.1
KDZ0510X3.0S060N-HP	●	5.1	<sup>0</sup> / <sub>-0.012</sub>	34	35	8	70	fig.1
KDZ0520X3.0S060N-HP	●	5.2	<sup>0</sup> / <sub>-0.012</sub>	34	35	8	70	fig.1
KDZ0530X3.0S060N-HP	●	5.3	<sup>0</sup> / <sub>-0.012</sub>	34	35	8	70	fig.1
KDZ0540X3.0S060N-HP	●	5.4	<sup>0</sup> / <sub>-0.012</sub>	34	35	8	70	fig.1
KDZ0550X3.0S060N-HP	●	5.5	<sup>0</sup> / <sub>-0.012</sub>	34	35	8	70	fig.1
KDZ0560X3.0S060N-HP	●	5.6	<sup>0</sup> / <sub>-0.012</sub>	34	35	8	70	fig.1
KDZ0570X3.0S060N-HP	●	5.7	<sup>0</sup> / <sub>-0.012</sub>	34	35	8	70	fig.1
KDZ0580X3.0S060N-HP	●	5.8	<sup>0</sup> / <sub>-0.012</sub>	34	35	8	70	fig.1
KDZ0590X3.0S060N-HP	●	5.9	<sup>0</sup> / <sub>-0.012</sub>	34	35	8	70	fig.1
KDZ0600X3.0S060N-HP	●	6.0	<sup>0</sup> / <sub>-0.012</sub>	34	35	8	70	fig.1
KDZ0610X3.0S080N-HP	●	6.1	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0620X3.0S080N-HP	●	6.2	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0630X3.0S080N-HP	●	6.3	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0640X3.0S080N-HP	●	6.4	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0650X3.0S080N-HP	●	6.5	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0660X3.0S080N-HP	●	6.6	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0670X3.0S080N-HP	●	6.7	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0680X3.0S080N-HP	●	6.8	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0690X3.0S080N-HP	●	6.9	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0700X3.0S080N-HP	●	7.0	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0710X3.0S080N-HP	●	7.1	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0720X3.0S080N-HP	●	7.2	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0730X3.0S080N-HP	●	7.3	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0740X3.0S080N-HP	●	7.4	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1
KDZ0750X3.0S080N-HP	●	7.5	<sup>0</sup> / <sub>-0.015</sub>	32	33	8	70	fig.1

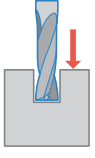
型番	在庫	寸法(mm)					形状	
		DC	外径公差	LCF	LN	DCON		OAL
KDZ0760X3.0S080N-HP	●	7.6	<sup>0</sup> / <sub>-0.015</sub>	34	35	8	70	fig.1
KDZ0770X3.0S080N-HP	●	7.7						
KDZ0780X3.0S080N-HP	●	7.8						
KDZ0790X3.0S080N-HP	●	7.9	<sup>0</sup> / <sub>-0.015</sub>	36	(36)	8	70	fig.1
KDZ0800X3.0S080N-HP	●	8.0						
KDZ0810X3.0S100N-HP	●	8.1						
KDZ0820X3.0S100N-HP	●	8.2	<sup>0</sup> / <sub>-0.015</sub>	36	37	10	80	fig.1
KDZ0830X3.0S100N-HP	●	8.3						
KDZ0840X3.0S100N-HP	●	8.4						
KDZ0850X3.0S100N-HP	●	8.5	<sup>0</sup> / <sub>-0.015</sub>	38	39	10	80	fig.1
KDZ0860X3.0S100N-HP	●	8.6						
KDZ0870X3.0S100N-HP	●	8.7						
KDZ0880X3.0S100N-HP	●	8.8	<sup>0</sup> / <sub>-0.015</sub>	39	40	10	80	fig.1
KDZ0890X3.0S100N-HP	●	8.9						
KDZ0900X3.0S100N-HP	●	9.0						
KDZ0910X3.0S100N-HP	●	9.1	<sup>0</sup> / <sub>-0.015</sub>	40	41	10	80	fig.1
KDZ0920X3.0S100N-HP	●	9.2						
KDZ0930X3.0S100N-HP	●	9.3						
KDZ0940X3.0S100N-HP	●	9.4	<sup>0</sup> / <sub>-0.015</sub>	42	43	10	80	fig.1
KDZ0950X3.0S100N-HP	●	9.5						
KDZ0960X3.0S100N-HP	●	9.6						
KDZ0970X3.0S100N-HP	●	9.7	<sup>0</sup> / <sub>-0.015</sub>	45	(45)	10	80	fig.1
KDZ0980X3.0S100N-HP	●	9.8						
KDZ0990X3.0S100N-HP	●	9.9						
KDZ1000X3.0S100N-HP	●	10.0	<sup>0</sup> / <sub>-0.018</sub>	45	46	12	100	fig.1
KDZ1010X3.0S120N-HP	●	10.1						
KDZ1020X3.0S120N-HP	●	10.2						
KDZ1030X3.0S120N-HP	●	10.3	<sup>0</sup> / <sub>-0.018</sub>	46	47	12	100	fig.1
KDZ1040X3.0S120N-HP	●	10.4						
KDZ1050X3.0S120N-HP	●	10.5						
KDZ1060X3.0S120N-HP	●	10.6	<sup>0</sup> / <sub>-0.018</sub>	47	48	12	100	fig.1
KDZ1070X3.0S120N-HP	●	10.7						
KDZ1080X3.0S120N-HP	●	10.8						
KDZ1090X3.0S120N-HP	●	10.9	<sup>0</sup> / <sub>-0.018</sub>	51	52	12	100	fig.1
KDZ1100X3.0S120N-HP	●	11.0						
KDZ1110X3.0S120N-HP	●	11.1						
KDZ1120X3.0S120N-HP	●	11.2	<sup>0</sup> / <sub>-0.018</sub>	53	54	12	100	fig.1
KDZ1130X3.0S120N-HP	●	11.3						
KDZ1140X3.0S120N-HP	●	11.4						
KDZ1150X3.0S120N-HP	●	11.5	<sup>0</sup> / <sub>-0.018</sub>	54	(54)	12	100	fig.1
KDZ1160X3.0S120N-HP	●	11.6						
KDZ1170X3.0S120N-HP	●	11.7						
KDZ1180X3.0S120N-HP	●	11.8	<sup>0</sup> / <sub>-0.018</sub>	54	(54)	12	100	fig.1
KDZ1190X3.0S120N-HP	●	11.9						
KDZ1200X3.0S120N-HP	●	12.0	<sup>0</sup> / <sub>-0.018</sub>	54	(54)	12	100	fig.1

●：標準在庫

加工深度請設定為 2.0 D (2.0xDC)  
 深度超過2.0D時，推薦使用階梯式加工

切削条件表

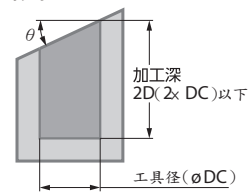
KDZ

被削材	区分	外径 DC (mm)	φ1	φ2	φ3	φ4	φ5	φ6	φ8	φ10	φ12
一般構造用鋼・炭素鋼 S5400, S45C	 突き加工	回転数 (min <sup>-1</sup> )	19,500	11,200	8,300	6,200	5,000	4,200	3,200	2,500	2,100
		送り (mm/min)	300	380	520	520	520	520	520	520	450
合金鋼 SCM, SNCM		回転数 (min <sup>-1</sup> )	19,000	10,000	7,200	5,400	4,400	3,600	2,700	2,200	1,800
		送り (mm/min)	300	320	450	450	450	450	450	400	400
プリハードン鋼 (30~45HRC)		回転数 (min <sup>-1</sup> )	16,000	8,000	3,900	2,900	2,300	1,900	1,500	1,200	1,000
		送り (mm/min)	210	210	210	210	210	210	210	190	190
ダクタイル鋳鉄 FCD400		回転数 (min <sup>-1</sup> )	16,000	10,000	7,200	5,400	4,400	3,600	2,700	2,200	1,800
		送り (mm/min)	200	300	390	390	390	390	390	340	340
アルミニウム合金 A7075		回転数 (min <sup>-1</sup> )	20,000	20,000	17,800	13,100	10,500	8,900	6,700	5,400	4,500
		送り (mm/min)	500	850	1,270	1,270	1,270	1,270	1,270	1,270	1,270
アルミニウム合金鋳物 AC, ADC		回転数 (min <sup>-1</sup> )	20,000	20,000	13,100	10,000	8,000	6,700	5,000	4,000	3,400
		送り (mm/min)	450	750	820	820	820	820	820	820	820

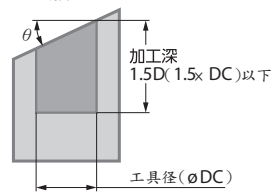
注意

- ・本工具為切斷加工專用，橫向加工請勿使用
- ・建議使用切削油
- ・請根據工具剛性、加工件凸出量調整切削條件
- ・2D 以上的深度進行加工時，推薦使用階梯式加工
- ・機台以及刀座建議使用高剛性產品
- ・不推薦用於加工不鏽鋼 SUS304・SUS316
- ・傾斜面加工時，請依加工件的傾斜角度調整加工條件 (如右圖所示)  
 傾斜角 (θ) ≤ 30° 進給量請調整至 50% 以下  
 傾斜角 (θ) > 30° 回轉數請調整至 70% 以下，進給量則為 30% 以下

標準型

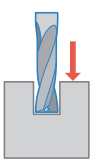


短版



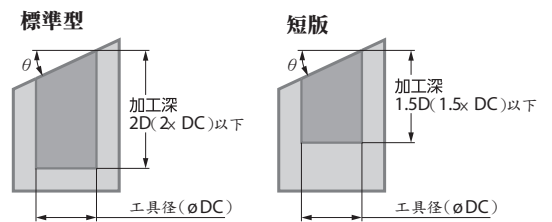
切削条件表

KDZ-HP

被削材	区分	外径DC (mm)	φ1	φ1.5	φ2	φ2.5	φ3	φ3.5	φ4	φ4.5	φ5	φ6	φ8	φ10	φ12	φ14	φ16	φ18	φ20
一般構造用鋼・炭素鋼 S5400, S45C	 <p>切斷加工</p>	回転数 (min <sup>-1</sup> )	20,700	13,800	11,150	9,200	9,100	7,800	6,800	6,100	5,500	4,600	3,500	2,800	2,300	1,800	1,600	1,400	1,300
		送り (mm/min)	350	350	430	430	520	520	520	520	520	520	520	520	520	520	480	480	480
合金鋼 SCM, SNCM		回転数 (min <sup>-1</sup> )	17,500	11,700	9,600	7,650	7,200	6,200	5,400	4,800	4,400	3,600	2,700	2,200	1,800	1,500	1,350	1,200	1,100
		送り (mm/min)	290	290	380	380	450	450	450	450	450	450	450	450	450	450	420	420	420
プリハードン鋼 (30~45HRC)		回転数 (min <sup>-1</sup> )	9,600	6,400	5,570	4,460	3,900	3,400	2,900	2,600	2,300	1,900	1,500	1,200	1,000	850	750	650	600
		送り (mm/min)	120	120	170	170	210	210	210	210	210	210	210	210	210	210	200	200	200
ダクタイル鋳鉄 FCD400		回転数 (min <sup>-1</sup> )	15,900	10,600	10,360	8,290	7,200	6,200	5,400	4,800	4,400	3,600	2,700	2,200	1,800	1,550	1,350	1,200	1,100
		送り (mm/min)	220	250	390	390	390	390	390	390	390	390	390	390	390	390	360	360	360
アルミニウム合金 A7075		回転数 (min <sup>-1</sup> )	39,800	26,600	23,000	18,500	17,800	15,200	13,100	11,800	10,500	8,900	6,700	5,400	4,500	3,800	3,400	3,000	2,700
		送り (mm/min)	900	1,000	1,270	1,270	1,270	1,270	1,270	1,270	1,270	1,270	1,270	1,270	1,270	1,270	1,270	1,270	1,270
アルミニウム合金鋳物 AC, ADC	回転数 (min <sup>-1</sup> )	29,000	19,200	17,500	14,000	13,100	11,500	10,000	8,800	8,000	6,700	5,000	4,000	3,400	2,900	2,500	2,200	2,000	
	送り (mm/min)	550	550	820	820	820	820	820	820	820	820	820	820	820	820	820	820	820	

注意

- ・ 本工具為切斷加工專用，橫向加工請勿使用
- ・ 建議使用切削油
- ・ 請根據工具剛性、加工件凸出量調整切削條件
- ・ 2D 以上的深度進行加工時，推薦使用階梯式加工
- ・ 機台以及刀座建議使用高剛性產品
- ・ 不推薦用於加工不鏽鋼 SUS304・SUS316
- ・ 傾斜面加工時，請依加工件的傾斜角度調整加工條件 (如右圖所示)  
 傾斜角 (θ) ≤ 30° 進給量請調整至 50% 以下  
 傾斜角 (θ) > 30° 回轉數請調整至 70% 以下，進給量則為 30% 以下





對應多種加工皆力求發揮最佳效能

以達成整體配刀的目標

鎢鋼刀具的最新系列，K-series 誕生！

京瓷集團會持續挑戰並開發對社會有意義的新科技

K-series 的加入讓產品線更加齊全！

創新所帶來的感動將持續下去！



京瓷株式會社  
產業工具部門  
官方影片網站



京瓷亞太有限公司  
台北分公司  
官方網站

更多產品  
請掃描



新加坡商京瓷亞太有限公司  
產業工具部門  
台北市中山區市民大道三段209號3樓  
TEL:02-2567-2008 FAX:02-2567-2700  
<https://www.kyocera.co.jp/prdct/tool/>