



GJT Drill

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One-Shot Cutting for Cored Hole



GD Drill & Ream

GD Drill

One-Shot Cutting for Material W/O Prehole

6 Guides & 3 PCD cutting edges for superior Circularity & deep hole finishing



Drill and Ream in one shot with a Superior finish



標準条件 Standard Cutting Condition

切削速度 (m/min) Cutting Speed	50~300
送り (mm/rev) Feed Rate	0.02~0.05D



標準条件 Standard Cutting Condition

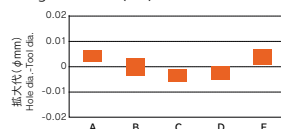
切削速度 (m/min) Cutting Speed	100~200
送り (mm/rev) Feed Rate	0.05~0.2

Point Good Position

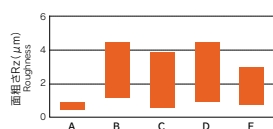
IT7 Grade One-Shot Finish For L/D > 4 Tool overhang

Point IT7 Grade One-Shot Finish Special shape available as requested

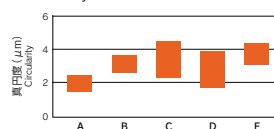
IT7 Grade High Precision(IT7)



Superior Roughness

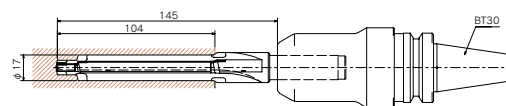


Circularity



テストNo. Test No.	A	B	C	D	E
ツール径 Tool Diameter (mm)	φ12	φ13	φ15	φ17	φ17

Machining example



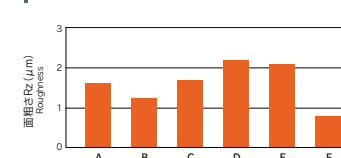
[切削条件]

切削速度 Cutting Speed	150~300m/min
送り Feed Rate	0.12~0.6(Aのみ0.48)
工具径 Tool Dia.	図中参照 See Figure
被削材 Work Material	ADC12

IT7 Grade High Precision(IT7)



Superior Roughness



テストNo. Test No.	A	B	C	D	E	F
ツール径 Tool Diameter (mm)	φ10	φ10	φ10	φ10	φ10	φ16
被削材 Work Material	AC2B	AC2B	AC2B	AC2B	AC2B	AC4M-T6
切削速度 Cutting Speed (m/min)	100	100	200	200	200	150
送り Feed Rate (mm/rev)	0.1	0.2	0.05	0.1	0.2	0.12

[切削条件]

切削速度 Cutting Speed	図中参照 See Figure
送り Feed Rate	図中参照 See Figure
工具径 Tool Dia.	図中参照 See Figure
被削材 Work Material	図中参照 See Figure