MULTI-1 DRILLS

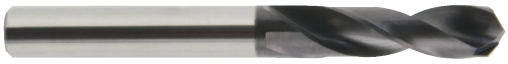
CDRA03 SERIES

粉末高速钢 MULTI-1钻头
PREMIUM HSS-PM MULTI-1 DRILLS

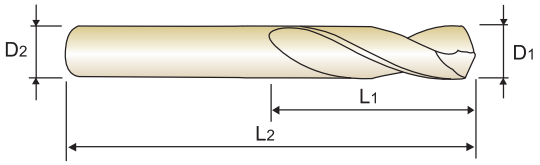
超短
STUB

▶应用：适用于结构钢，碳素钢，合金，预硬化钢，模具钢，不锈钢，淬火钢(HRc30~45)，铸铁，铝合金，非铁金属合金
▶优点：钻顶的形状使产品具有极佳的自定心能力.
沟槽的设计使产品的排削性能更高.
使用粉末高速钢制作是产品具有更优良的韧性.

▶**Application** : Structural steels, Carbon steels, Alloy steels, Pre-hardened steels, Mold steels, stainless steels, Hardened steels(HRc30~45), Cast iron, Aluminum alloys, Nonferrous alloys.
▶**Advantage** : Point shape to maximize self-centering.
Flute design for the best chip evacuation.
Premium powder materials with excellent toughness.



up to 1.4mm over 1.4mm



PREMIUM HSS-PM | N 30° | h6 | h7 | 118° | 135°

up to 1.9mm over 1.9mm

단위(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	柄径 Shank Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D1	D2	L1	L2
CDRA03010	1.0	3	6	38
CDRA03011	1.1	3	7	39
CDRA03012	1.2	3	8	40
CDRA03013	1.3	3	8	40
CDRA03014	1.4	3	9	41
CDRA03015	1.5	3	9	41
CDRA03016	1.6	3	10	42
CDRA03017	1.7	3	10	42
CDRA03018	1.8	3	11	43
CDRA03019	1.9	3	11	43
CDRA03020	2.0	3	12	44
CDRA03021	2.1	3	12	44
CDRA03022	2.2	3	13	45
CDRA03023	2.3	3	13	45
CDRA03024	2.4	3	14	46
CDRA03025	2.5	3	14	46
CDRA03026	2.6	3	14	46
CDRA03027	2.7	3	16	48
CDRA03028	2.8	3	16	48
CDRA03029	2.9	3	16	48
CDRA03030	3.0	3	16	48
CDRA03031	3.1	4	18	50
CDRA03032	3.2	4	18	50
CDRA03033	3.3	4	18	50
CDRA03034	3.4	4	20	52
CDRA03035	3.5	4	20	52
CDRA03036	3.6	4	20	52
CDRA03037	3.7	4	20	52
CDRA03038	3.8	4	22	54
CDRA03039	3.9	4	22	54
CDRA03040	4.0	4	22	54

型号 EDP No.	刃径 Drill Diameter	柄径 Shank Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D1	D2	L1	L2
CDRA03041	4.1	6	22	66
CDRA03042	4.2	6	22	66
CDRA03043	4.3	6	24	68
CDRA03044	4.4	6	24	68
CDRA03045	4.5	6	24	68
CDRA03046	4.6	6	24	68
CDRA03047	4.7	6	24	68
CDRA03048	4.8	6	26	70
CDRA03049	4.9	6	26	70
CDRA03050	5.0	6	26	70
CDRA03051	5.1	6	26	70
CDRA03052	5.2	6	26	70
CDRA03053	5.3	6	26	70
CDRA03054	5.4	6	28	72
CDRA03055	5.5	6	28	72
CDRA03056	5.6	6	28	72
CDRA03057	5.7	6	28	72
CDRA03058	5.8	6	28	72
CDRA03059	5.9	6	28	72
CDRA03060	6.0	6	28	72
CDRA03061	6.1	8	31	75
CDRA03062	6.2	8	31	75
CDRA03063	6.3	8	31	75
CDRA03064	6.4	8	31	75
CDRA03065	6.5	8	31	75
CDRA03066	6.6	8	31	75
CDRA03067	6.7	8	31	75
CDRA03068	6.8	8	34	78
CDRA03069	6.9	8	34	78
CDRA03070	7.0	8	34	78
CDRA03071	7.1	8	34	78

◎ : 优(Excellent) ○ : 良(Good)

碳钢 Carbon Steels	合金钢 Alloy Steels	预硬钢 Prehardened Steels	硬化钢 Hardened Steels		铸铁 Cast Iron	铝 Aluminum	不锈钢 Stainless Steels	钛 Titanium	模具钢 Mild Steels	铜 Copper	青铜 Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○			○	○	○		◎		

MULTI-1 DRILLS

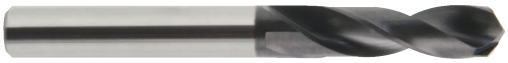
CDRA03 SERIES

粉末高速钢 MULTI-1钻头
PREMIUM HSS-PM MULTI-1 DRILLS

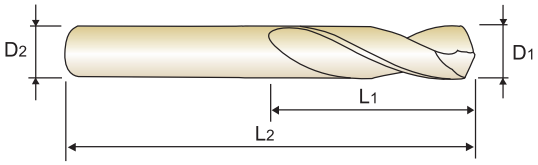
超短
STUB

▶应用：适用于结构钢，碳素钢，合金，预硬化钢，模具钢，不锈钢，淬火钢(HRc30~45)，铸铁，铝合金，非铁金属合金
▶优点：钻顶的形状使产品具有极佳的自定心能力.
沟槽的设计使产品的排削性能更高.
使用粉末高速钢制作是产品具有更优良的韧性.

▶**Application** : Structural steels, Carbon steels, Alloy steels, Pre-hardened steels, Mold steels, stainless steels, Hardened steels(HRc30~45), Cast iron, Aluminum alloys, Nonferrous alloys.
▶**Advantage** : Point shape to maximize self-centering.
Flute design for the best chip evacuation.
Premium powder materials with excellent toughness.



up to 1.4mm over 1.4mm



up to 1.9mm over 1.9mm

단위(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	柄径 Shank Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D1	D2	L1	L2
CDRA03072	7.2	8	34	78
CDRA03073	7.3	8	34	78
CDRA03074	7.4	8	34	78
CDRA03075	7.5	8	34	78
CDRA03076	7.6	8	37	81
CDRA03077	7.7	8	37	81
CDRA03078	7.8	8	37	81
CDRA03079	7.9	8	37	81
CDRA03080	8.0	8	37	81
CDRA03081	8.1	10	37	87
CDRA03082	8.2	10	37	87
CDRA03083	8.3	10	37	87
CDRA03084	8.4	10	37	87
CDRA03085	8.5	10	37	87
CDRA03086	8.6	10	40	90
CDRA03087	8.7	10	40	90
CDRA03088	8.8	10	40	90
CDRA03089	8.9	10	40	90
CDRA03090	9.0	10	40	90
CDRA03091	9.1	10	40	90
CDRA03092	9.2	10	40	90
CDRA03093	9.3	10	40	90
CDRA03094	9.4	10	40	90
CDRA03095	9.5	10	40	90
CDRA03096	9.6	10	43	93
CDRA03097	9.7	10	43	93
CDRA03098	9.8	10	43	93
CDRA03099	9.9	10	43	93
CDRA03100	10.0	10	43	93
CDRA03101	10.1	12	43	100

型号 EDP No.	刃径 Drill Diameter	柄径 Shank Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D1	D2	L1	L2
CDRA03102	10.2	12	43	100
CDRA03103	10.3	12	43	100
CDRA03104	10.4	12	43	100
CDRA03105	10.5	12	43	100
CDRA03106	10.6	12	43	100
CDRA03107	10.7	12	47	104
CDRA03108	10.8	12	47	104
CDRA03109	10.9	12	47	104
CDRA03110	11.0	12	47	104
CDRA03111	11.1	12	47	104
CDRA03112	11.2	12	47	104
CDRA03113	11.3	12	47	104
CDRA03114	11.4	12	47	104
CDRA03115	11.5	12	47	104
CDRA03116	11.6	12	47	104
CDRA03117	11.7	12	47	104
CDRA03118	11.8	12	47	104
CDRA03119	11.9	12	51	108
CDRA03120	12.0	12	51	108
CDRA03121	12.1	12	51	108
CDRA03122	12.2	12	51	108
CDRA03123	12.3	12	51	108
CDRA03124	12.4	12	51	108
CDRA03125	12.5	12	51	108
CDRA03126	12.6	12	51	108
CDRA03127	12.7	12	51	108
CDRA03128	12.8	12	51	108
CDRA03129	12.9	12	51	108
CDRA03130	13.0	12	51	108

◎ : 优(Excellent) ○ : 良(Good)

碳钢 Carbon Steels	合金钢 Alloy Steels	预硬钢 Prehardened Steels	硬化钢 Hardened Steels		铸铁 Cast Iron	铝 Aluminum	不锈钢 Stainless Steels	钛 Titanium	模具钢 Mild Steels	铜 Copper	青铜 Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎	○			○	○	○		◎		

粉末高速钢 MULTI-1钻头, TiAlN涂层
PREMIUM HSS-PM MULTI-1 DRILLS, TiAlN COATED

CDRA03 SERIES

单位(Unit) : mm

被加工材料	碳钢		合金钢 预硬钢		铸铁		铝合金 有色金属合金		型模钢, 硬化钢 (HRc30~45) 不锈钢 (SUS304, 200)		不锈钢 (SUS420, 440)	
WORK MATERIAL	CARBON STEELS		ALLOY STEELS PRE-HARDENED STEELS		CAST IRON		ALUMINUM ALLOYS NONFRERROUS ALLOYS		MOLD STEELS, HARDENED STEELS (HRc30~45) STAINLESS STEELS (SUS304, 200)		STAINLESS STEELS (SUS420, 440)	
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S
2.0	5800	0.06	4700	0.05	6500	0.08	10500	0.17	2600	0.04	3100	0.08
3.0	4300	0.12	3500	0.09	4900	0.14	10500	0.27	1800	0.05	2100	0.09
4.0	3200	0.15	2600	0.13	3600	0.18	8000	0.33	1300	0.07	1600	0.11
5.0	2600	0.18	2100	0.16	2900	0.21	6500	0.39	1050	0.09	1250	0.17
6.0	2100	0.20	1700	0.18	2400	0.25	5200	0.46	900	0.10	1050	0.19
8.0	1600	0.24	1300	0.20	1800	0.29	4200	0.51	650	0.14	800	0.26
10.0	1300	0.27	1000	0.24	1500	0.32	3400	0.61	550	0.17	630	0.33
12.0	1100	0.29	850	0.26	1200	0.36	2700	0.73	450	0.20	530	0.39

N = R.P.M
S = Feed per Revolution (mm/rev.)