



GJT Drill

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One-Shot Cutting for Cored Hole

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



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

Point

Good Position

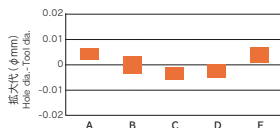
IT7 Grade

One-Shot Finish

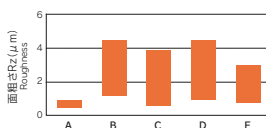
For L/D > 4 Tool overhang

IT7 Grade

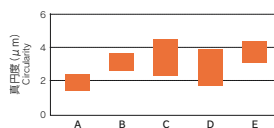
High Precision(IT7)



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

[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

Machining example

