



厦门鸿鹭联创工具有限公司
XIAMEN EGRET TOOL CO.,LTD.



地址:中国福建省厦门市同安区二环南路455-2号
Add: No.455-2 Er huan South Road Tong an Xiamen Fujian China
电话/Tel: 0592-6091331 网站/Web: www.egretool.com

硬质合金孔加工刀具
Solid Carbide Drill Bits

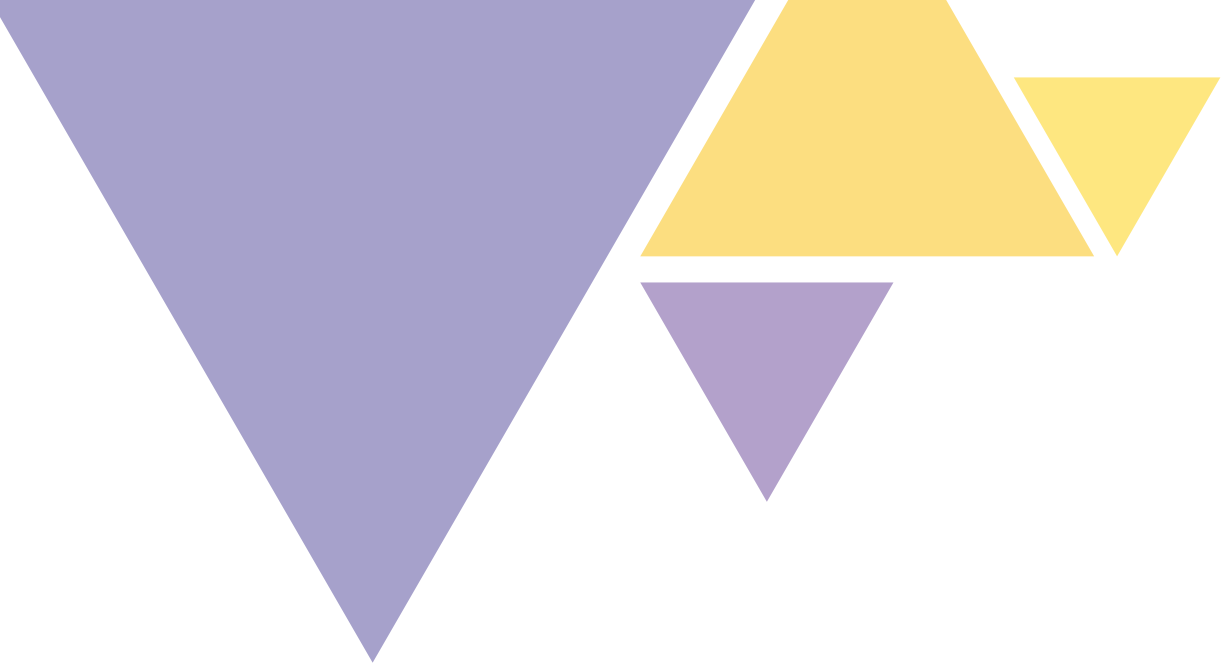


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Solid Carbide Drill Bits



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目录 CONTENTS

基本信息 BASIC INFORMATION

> > > > >

- 01 孔加工刀具订货号表示规则
Product code (Order Number) instruction of solid carbide drill bits
- 02 孔加工刀具加工材料应用一览表
Application summary of solid carbide drills
- 03 产品选择目录表
Drills guideline

GTD系列通用加工麻花钻

> > > > >

- 05 GTD-03NA通用加工3D外冷麻花钻
3D external cooling twist drills for general machining
- 12 GTD-03CA通用加工3D内冷麻花钻
3D inner cooling twist drills for general machining
- 18 GTD-05NA通用加工5D外冷麻花钻
5D external cooling twist drills for general machining
- 24 GTD-05CA通用加工5D内冷麻花钻
5D inner cooling twist drills for general machining
- 32 GTD-08CA通用加工8D内冷麻花钻
8D inner cooling twist drills for general machining
- 37 GTD-12CA通用加工12D内冷麻花钻
12D inner cooling twist drills for general machining

GXD系列通用加工麻花钻

> > > > >

- 40 GXD-03NA通用加工3D外冷麻花钻
3D external cooling twist drills for general machining
- 47 GXD-05NA通用加工5D外冷麻花钻
5D external cooling twist drills for general machining

附表

> > > > >

- 53 推荐参数表
Recommended cutting data
- 57 柄部标准
Shank standard - DIN Standard
- 58 切削定义及计算
Cutting definitions and calculations
- 59 刀具修磨服务
Tool regrinding service



孔加工刀具订货号表示规则

Product Code (Order Number) Instruction
Of Solid Carbide Drill Bits

GTD

0600

03

C

A

钻头系列号 Drill series	刃部直径 Flute diameter	钻孔深度 Drilling depth	冷却方式 Coolant type	柄部类型Shank type
GTD：通用加工麻花钻 GTD: Twist drills for general machining	0600：Φ6.00 1200：Φ12.00	03：钻深≤3D 03: Drilling Depth≤3D 05：钻深≤5D 05: Drilling Depth≤5D 08：钻深≤8D 08: Drilling Depth≤8D 12：钻深≤12D 12: Drilling Depth≤12D	C：内冷Inner coolin N：外冷External cooling	A：圆柱直柄 Cylindrical straight shank B：削平柄 Flattened handle E：斜削柄 Bevel shank Y：普通圆柱直柄 Continuous parallel shank M：莫氏锥柄 Mose shank



孔加工刀具加工材料应用一览表

Application summary of solid carbide drills

材料组 Material		内冷 Inner cooling				外冷 External cooling	
		3D	5D	8D	12D	3D	5D
	碳钢、合金钢(<35HRC) Carbon steel, alloy steel (<35 HRC)	GTD				GTD\GXD	
	合金钢(35-48HRC) Alloy steel (35-48 HRC)	GTD					
	PH与铁素体/马氏体钢(<35HRC) PH,ferritic, martensitic steel	GTD				GTD\GXD	
	不绣钢 Stainless steel	GTD				GTD GXD	
	灰铸铁、球墨铸铁(<32HRC) Grey cast iron, nodular cast iron (<32HRC)	GTD				GTD\GXD	
	高合金铸铁(35-45HRC) High-alloy cast iron (35-45HRC)					GTD	
	锻造铝合金 Wrought aluminium alloys,						
	铸造铝合金 Cast aluminium alloys (Si≤12%)						
	铜合金 Copper alloys (<200HB)						
	复合材料 Composite						
	高温合金 Heat resistant alloys (< 450HB)						
	钛合金 Titanium alloys (< 400HB)						
	淬硬钢 Hardened steel(45-55HRC)						
	淬硬钢 Hardened steel(55-60HRC)						



GTD系列

通用加工麻花钻
GTD series twist drills for general machining



全新的基体材质,成熟的前后处理工艺,超光滑的涂层表面,更大的容屑槽设计,主要适用于钢的钻削加工,也可用于铸铁和不锈钢等材料的加工。

New substrate material, mature pre-treatment and post-treatment process, super smooth coating surface and larger chip holding groove design;Mainly suitable for drilling of steel, as well as cast iron, stainless steel and other materials.

高性能的基体材质-定制刀具基体,采用亚微细碳化钨牌号,兼具良好的耐磨性与韧性,适于通用加工。
High performance substrate: Customized tool substrate, using submicron tungsten carbide grade, with good wear resistance and toughness, suitable for general machining.

成熟的刃口处理工艺-刃口采用成熟的钝化工艺,兼顾刃口强度及切削锋利性。
Mature edge treatment technology: Mature passivation technic is applied to cutting edge, maintaining both the edge strength and cutting sharpness.

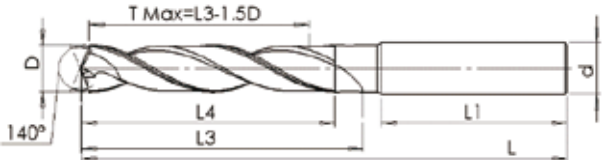
先进涂层及后处理技术-采用巴尔查斯先进的TiAlCrSiN纳米涂层工艺,保证刀具极强的耐磨性;搭配先进的槽底后处理技术,有效降低刀槽的表面粗糙度,提升刀具排屑性能。
Advanced coating and post treatment technology:The advanced TiAlCrSiN nano coating process from Balzers is applied to ensure extremely strong wear resistance of the cutting tool. The advanced groove bottom post-treatment technology is used to effectively increase surface finish of the groove and improve chip removal performance of the cutting tool.

全新槽型设计-独特的槽形设计,保证良好的断屑性能,有效降低切削力。
New groove design: Unique groove design ensures good chip breaking performance and effectively reduces cutting force.



GTD-03NA

通用加工3D外冷麻花钻
3D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0300-03NA	3.00	62	36	20	6
GTD-0310-03NA	3.10	62	36	20	6
GTD-0320-03NA	3.20	62	36	20	6
GTD-0330-03NA	3.30	62	36	20	6
GTD-0340-03NA	3.40	62	36	20	6
GTD-0350-03NA	3.50	62	36	20	6
GTD-0360-03NA	3.60	62	36	20	6
GTD-0370-03NA	3.70	62	36	20	6
GTD-0380-03NA	3.80	66	36	24	6
GTD-0390-03NA	3.90	66	36	24	6
GTD-0400-03NA	4.00	66	36	24	6
GTD-0410-03NA	4.10	66	36	24	6
GTD-0420-03NA	4.20	66	36	24	6
GTD-0430-03NA	4.30	66	36	24	6
GTD-0440-03NA	4.40	66	36	24	6
GTD-0450-03NA	4.50	66	36	24	6
GTD-0460-03NA	4.60	66	36	24	6
GTD-0470-03NA	4.70	66	36	24	6
GTD-0480-03NA	4.80	66	36	28	6
GTD-0490-03NA	4.90	66	36	28	6
GTD-0500-03NA	5.00	66	36	28	6
GTD-0510-03NA	5.10	66	36	28	6
GTD-0520-03NA	5.20	66	36	28	6
GTD-0530-03NA	5.30	66	36	28	6
GTD-0540-03NA	5.40	66	36	28	6
GTD-0550-03NA	5.50	66	36	28	6
GTD-0560-03NA	5.60	66	36	28	6
GTD-0570-03NA	5.70	66	36	28	6
GTD-0580-03NA	5.80	66	36	28	6
GTD-0590-03NA	5.90	66	36	28	6



GTD-03NA

通用加工3D外冷麻花钻

3D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0600-03NA	6.00	66	36	28	6
GTD-0610-03NA	6.10	79	36	34	8
GTD-0620-03NA	6.20	79	36	34	8
GTD-0630-03NA	6.30	79	36	34	8
GTD-0640-03NA	6.40	79	36	34	8
GTD-0650-03NA	6.50	79	36	34	8
GTD-0660-03NA	6.60	79	36	34	8
GTD-0670-03NA	6.70	79	36	34	8
GTD-0680-03NA	6.80	79	36	34	8
GTD-0690-03NA	6.90	79	36	34	8
GTD-0700-03NA	7.00	79	36	34	8
GTD-0710-03NA	7.10	79	36	41	8
GTD-0720-03NA	7.20	79	36	41	8
GTD-0730-03NA	7.30	79	36	41	8
GTD-0740-03NA	7.40	79	36	41	8
GTD-0750-03NA	7.50	79	36	41	8
GTD-0760-03NA	7.60	79	36	41	8
GTD-0770-03NA	7.70	79	36	41	8
GTD-0780-03NA	7.80	79	36	41	8
GTD-0790-03NA	7.90	79	36	41	8
GTD-0800-03NA	8.00	79	36	41	8
GTD-0810-03NA	8.10	89	40	47	10
GTD-0820-03NA	8.20	89	40	47	10
GTD-0830-03NA	8.30	89	40	47	10
GTD-0840-03NA	8.40	89	40	47	10
GTD-0850-03NA	8.50	89	40	47	10
GTD-0860-03NA	8.60	89	40	47	10
GTD-0870-03NA	8.70	89	40	47	10
GTD-0880-03NA	8.80	89	40	47	10
GTD-0890-03NA	8.90	89	40	47	10



GTD-03NA

通用加工3D外冷麻花钻

3D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0900-03NA	9.00	89	40	47	10
GTD-0910-03NA	9.10	89	40	47	10
GTD-0920-03NA	9.20	89	40	47	10
GTD-0930-03NA	9.30	89	40	47	10
GTD-0940-03NA	9.40	89	40	47	10
GTD-0950-03NA	9.50	89	40	47	10
GTD-0960-03NA	9.60	89	40	47	10
GTD-0970-03NA	9.70	89	40	47	10
GTD-0980-03NA	9.80	89	40	47	10
GTD-0990-03NA	9.90	89	40	47	10
GTD-1000-03NA	10.00	89	40	47	10
GTD-1010-03NA	10.10	102	45	55	12
GTD-1020-03NA	10.20	102	45	55	12
GTD-1030-03NA	10.30	102	45	55	12
GTD-1040-03NA	10.40	102	45	55	12
GTD-1050-03NA	10.50	102	45	55	12
GTD-1060-03NA	10.60	102	45	55	12
GTD-1070-03NA	10.70	102	45	55	12
GTD-1080-03NA	10.80	102	45	55	12
GTD-1090-03NA	10.90	102	45	55	12
GTD-1100-03NA	11.00	102	45	55	12
GTD-1110-03NA	11.10	102	45	55	12
GTD-1120-03NA	11.20	102	45	55	12
GTD-1130-03NA	11.30	102	45	55	12
GTD-1140-03NA	11.40	102	45	55	12
GTD-1150-03NA	11.50	102	45	55	12
GTD-1160-03NA	11.60	102	45	55	12
GTD-1170-03NA	11.70	102	45	55	12
GTD-1180-03NA	11.80	102	45	55	12
GTD-1190-03NA	11.90	102	45	55	12



GTD-03NA

通用加工3D外冷麻花钻

3D external cooling twist drills for general machining



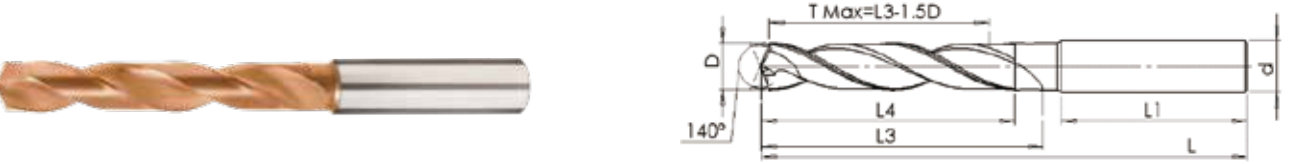
订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1200-03NA	12.00	102	45	55	12
GTD-1210-03NA	12.10	107	45	60	14
GTD-1220-03NA	12.20	107	45	60	14
GTD-1230-03NA	12.30	107	45	60	14
GTD-1240-03NA	12.40	107	45	60	14
GTD-1250-03NA	12.50	107	45	60	14
GTD-1260-03NA	12.60	107	45	60	14
GTD-1270-03NA	12.70	107	45	60	14
GTD-1280-03NA	12.80	107	45	60	14
GTD-1290-03NA	12.90	107	45	60	14
GTD-1300-03NA	13.00	107	45	60	14
GTD-1310-03NA	13.10	107	45	60	14
GTD-1320-03NA	13.20	107	45	60	14
GTD-1330-03NA	13.30	107	45	60	14
GTD-1340-03NA	13.40	107	45	60	14
GTD-1350-03NA	13.50	107	45	60	14
GTD-1360-03NA	13.60	107	45	60	14
GTD-1370-03NA	13.70	107	45	60	14
GTD-1380-03NA	13.80	107	45	60	14
GTD-1390-03NA	13.90	107	45	60	14
GTD-1400-03NA	14.00	107	45	60	14
GTD-1410-03NA	14.10	115	48	65	16
GTD-1420-03NA	14.20	115	48	65	16
GTD-1430-03NA	14.30	115	48	65	16
GTD-1440-03NA	14.40	115	48	65	16
GTD-1450-03NA	14.50	115	48	65	16
GTD-1460-03NA	14.60	115	48	65	16
GTD-1470-03NA	14.70	115	48	65	16
GTD-1480-03NA	14.80	115	48	65	16
GTD-1490-03NA	14.90	115	48	65	16



GTD-03NA

通用加工3D外冷麻花钻

3D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1500-03NA	15.00	115	48	65	16
GTD-1510-03NA	15.10	115	48	65	16
GTD-1520-03NA	15.20	115	48	65	16
GTD-1530-03NA	15.30	115	48	65	16
GTD-1540-03NA	15.40	115	48	65	16
GTD-1550-03NA	15.50	115	48	65	16
GTD-1560-03NA	15.60	115	48	65	16
GTD-1570-03NA	15.70	115	48	65	16
GTD-1580-03NA	15.80	115	48	65	16
GTD-1590-03NA	15.90	115	48	65	16
GTD-1600-03NA	16.00	115	48	65	16
GTD-1610-03NA	16.10	123	48	73	18
GTD-1620-03NA	16.20	123	48	73	18
GTD-1630-03NA	16.30	123	48	73	18
GTD-1640-03NA	16.40	123	48	73	18
GTD-1650-03NA	16.50	123	48	73	18
GTD-1660-03NA	16.60	123	48	73	18
GTD-1670-03NA	16.70	123	48	73	18
GTD-1680-03NA	16.80	123	48	73	18
GTD-1690-03NA	16.90	123	48	73	18
GTD-1700-03NA	17.00	123	48	73	18
GTD-1710-03NA	17.10	123	48	73	18
GTD-1720-03NA	17.20	123	48	73	18
GTD-1730-03NA	17.30	123	48	73	18
GTD-1740-03NA	17.40	123	48	73	18
GTD-1750-03NA	17.50	123	48	73	18
GTD-1760-03NA	17.60	123	48	73	18
GTD-1770-03NA	17.70	123	48	73	18
GTD-1780-03NA	17.80	123	48	73	18
GTD-1790-03NA	17.90	123	48	73	18



GTD-03NA

通用加工3D外冷麻花钻

3D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1800-03NA	18.00	123	48	73	18
GTD-1810-03NA	18.10	131	50	79	20
GTD-1820-03NA	18.20	131	50	79	20
GTD-1830-03NA	18.30	131	50	79	20
GTD-1840-03NA	18.40	131	50	79	20
GTD-1850-03NA	18.50	131	50	79	20
GTD-1860-03NA	18.60	131	50	79	20
GTD-1870-03NA	18.70	131	50	79	20
GTD-1880-03NA	18.80	131	50	79	20
GTD-1890-03NA	18.90	131	50	79	20
GTD-1900-03NA	19.00	131	50	79	20
GTD-1910-03NA	19.10	131	50	79	20
GTD-1920-03NA	19.20	131	50	79	20
GTD-1930-03NA	19.30	131	50	79	20
GTD-1940-03NA	19.40	131	50	79	20
GTD-1950-03NA	19.50	131	50	79	20
GTD-1960-03NA	19.60	131	50	79	20
GTD-1970-03NA	19.70	131	50	79	20
GTD-1980-03NA	19.80	131	50	79	20
GTD-1990-03NA	19.90	131	50	79	20
GTD-2000-03NA	20.00	131	50	79	20

备注：D3-D20刀具接受非标订制
Note: accept non-standard customization from D3 to D20.

尺寸范围 Nominal size range	D(m7)	d(h6)
> 3—6	+0.004/+0.016	0.000/−0.008
> 6—10	+0.006/+0.021	0.000/−0.009
> 10—18	+0.007/+0.025	0.000/−0.011
> 18—20	+0.008/+0.029	0.000/−0.013

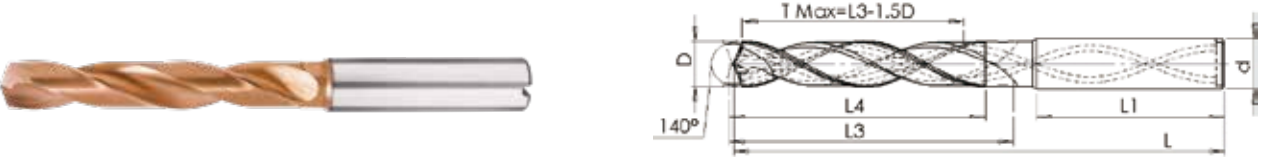
单位unit(mm)



GTD-03CA

通用加工3D内冷麻花钻

3D inner cooling twist drills for general machining



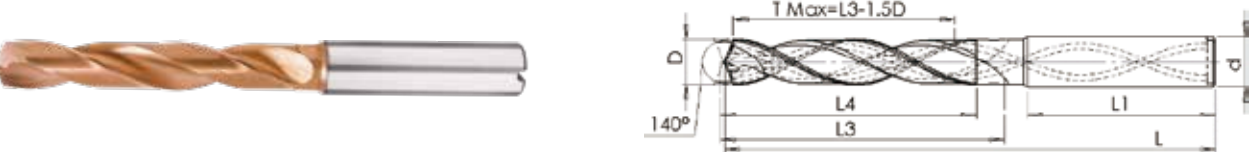
订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0300-03CA	3.00	62	36	20	6
GTD-0310-03CA	3.10	62	36	20	6
GTD-0320-03CA	3.20	62	36	20	6
GTD-0330-03CA	3.30	62	36	20	6
GTD-0340-03CA	3.40	62	36	20	6
GTD-0350-03CA	3.50	62	36	20	6
GTD-0360-03CA	3.60	62	36	20	6
GTD-0370-03CA	3.70	62	36	20	6
GTD-0380-03CA	3.80	66	36	24	6
GTD-0390-03CA	3.90	66	36	24	6
GTD-0400-03CA	4.00	66	36	24	6
GTD-0410-03CA	4.10	66	36	24	6
GTD-0420-03CA	4.20	66	36	24	6
GTD-0430-03CA	4.30	66	36	24	6
GTD-0440-03CA	4.40	66	36	24	6
GTD-0450-03CA	4.50	66	36	24	6
GTD-0460-03CA	4.60	66	36	24	6
GTD-0470-03CA	4.70	66	36	24	6
GTD-0480-03CA	4.80	66	36	28	6
GTD-0490-03CA	4.90	66	36	28	6
GTD-0500-03CA	5.00	66	36	28	6
GTD-0510-03CA	5.10	66	36	28	6
GTD-0520-03CA	5.20	66	36	28	6
GTD-0530-03CA	5.30	66	36	28	6
GTD-0540-03CA	5.40	66	36	28	6
GTD-0550-03CA	5.50	66	36	28	6
GTD-0560-03CA	5.60	66	36	28	6
GTD-0570-03CA	5.70	66	36	28	6
GTD-0580-03CA	5.80	66	36	28	6
GTD-0590-03CA	5.90	66	36	28	6



GTD-03CA

通用加工3D内冷麻花钻

3D inner cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0600-03CA	6.00	66	36	28	6
GTD-0610-03CA	6.10	79	36	34	8
GTD-0620-03CA	6.20	79	36	34	8
GTD-0630-03CA	6.30	79	36	34	8
GTD-0640-03CA	6.40	79	36	34	8
GTD-0650-03CA	6.50	79	36	34	8
GTD-0660-03CA	6.60	79	36	34	8
GTD-0670-03CA	6.70	79	36	34	8
GTD-0680-03CA	6.80	79	36	34	8
GTD-0690-03CA	6.90	79	36	34	8
GTD-0700-03CA	7.00	79	36	34	8
GTD-0710-03CA	7.10	79	36	41	8
GTD-0720-03CA	7.20	79	36	41	8
GTD-0730-03CA	7.30	79	36	41	8
GTD-0740-03CA	7.40	79	36	41	8
GTD-0750-03CA	7.50	79	36	41	8
GTD-0760-03CA	7.60	79	36	41	8
GTD-0770-03CA	7.70	79	36	41	8
GTD-0780-03CA	7.80	79	36	41	8
GTD-0790-03CA	7.90	79	36	41	8
GTD-0800-03CA	8.00	79	36	41	8
GTD-0810-03CA	8.10	89	40	47	10
GTD-0820-03CA	8.20	89	40	47	10
GTD-0830-03CA	8.30	89	40	47	10
GTD-0840-03CA	8.40	89	40	47	10
GTD-0850-03CA	8.50	89	40	47	10
GTD-0860-03CA	8.60	89	40	47	10
GTD-0870-03CA	8.70	89	40	47	10
GTD-0880-03CA	8.80	89	40	47	10
GTD-0890-03CA	8.90	89	40	47	10



GTD-03CA

通用加工3D内冷麻花钻

3D inner cooling twist drills for general machining



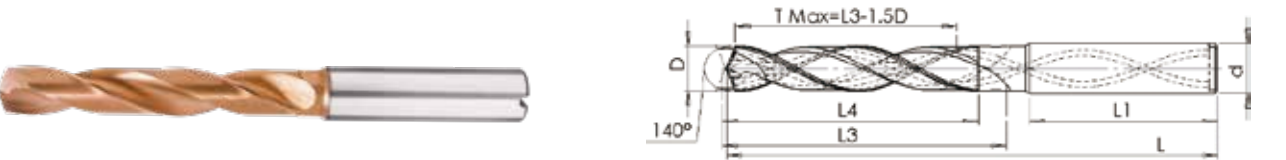
订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0900-03CA	9.00	89	40	47	10
GTD-0910-03CA	9.10	89	40	47	10
GTD-0920-03CA	9.20	89	40	47	10
GTD-0930-03CA	9.30	89	40	47	10
GTD-0940-03CA	9.40	89	40	47	10
GTD-0950-03CA	9.50	89	40	47	10
GTD-0960-03CA	9.60	89	40	47	10
GTD-0970-03CA	9.70	89	40	47	10
GTD-0980-03CA	9.80	89	40	47	10
GTD-0990-03CA	9.90	89	40	47	10
GTD-1000-03CA	10.00	89	40	47	10
GTD-1010-03CA	10.10	102	45	55	12
GTD-1020-03CA	10.20	102	45	55	12
GTD-1030-03CA	10.30	102	45	55	12
GTD-1040-03CA	10.40	102	45	55	12
GTD-1050-03CA	10.50	102	45	55	12
GTD-1060-03CA	10.60	102	45	55	12
GTD-1070-03CA	10.70	102	45	55	12
GTD-1080-03CA	10.80	102	45	55	12
GTD-1090-03CA	10.90	102	45	55	12
GTD-1100-03CA	11.00	102	45	55	12
GTD-1110-03CA	11.10	102	45	55	12
GTD-1120-03CA	11.20	102	45	55	12
GTD-1130-03CA	11.30	102	45	55	12
GTD-1140-03CA	11.40	102	45	55	12
GTD-1150-03CA	11.50	102	45	55	12
GTD-1160-03CA	11.60	102	45	55	12
GTD-1170-03CA	11.70	102	45	55	12
GTD-1180-03CA	11.80	102	45	55	12
GTD-1190-03CA	11.90	102	45	55	12



GTD-03CA

通用加工3D内冷麻花钻

3D inner cooling twist drills for general machining



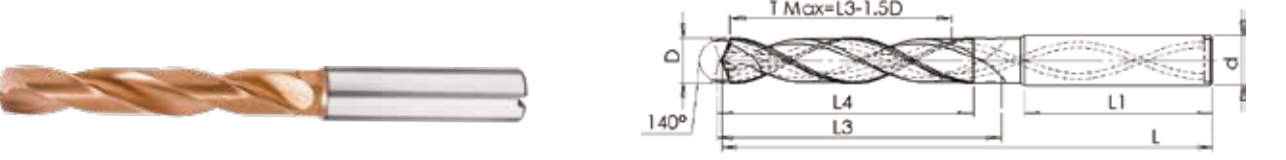
订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1200-03CA	12.00	102	45	55	12
GTD-1210-03CA	12.10	107	45	60	14
GTD-1220-03CA	12.20	107	45	60	14
GTD-1230-03CA	12.30	107	45	60	14
GTD-1240-03CA	12.40	107	45	60	14
GTD-1250-03CA	12.50	107	45	60	14
GTD-1260-03CA	12.60	107	45	60	14
GTD-1270-03CA	12.70	107	45	60	14
GTD-1280-03CA	12.80	107	45	60	14
GTD-1290-03CA	12.90	107	45	60	14
GTD-1300-03CA	13.00	107	45	60	14
GTD-1310-03CA	13.10	107	45	60	14
GTD-1320-03CA	13.20	107	45	60	14
GTD-1330-03CA	13.30	107	45	60	14
GTD-1340-03CA	13.40	107	45	60	14
GTD-1350-03CA	13.50	107	45	60	14
GTD-1360-03CA	13.60	107	45	60	14
GTD-1370-03CA	13.70	107	45	60	14
GTD-1380-03CA	13.80	107	45	60	14
GTD-1390-03CA	13.90	107	45	60	14
GTD-1400-03CA	14.00	107	45	60	14
GTD-1410-03CA	14.10	115	48	65	16
GTD-1420-03CA	14.20	115	48	65	16
GTD-1430-03CA	14.30	115	48	65	16
GTD-1440-03CA	14.40	115	48	65	16
GTD-1450-03CA	14.50	115	48	65	16
GTD-1460-03CA	14.60	115	48	65	16
GTD-1470-03CA	14.70	115	48	65	16
GTD-1480-03CA	14.80	115	48	65	16
GTD-1490-03CA	14.90	115	48	65	16



GTD-03CA

通用加工3D内冷麻花钻

3D inner cooling twist drills for general machining



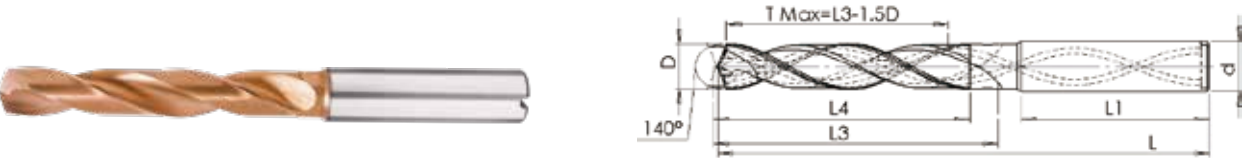
订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1500-03CA	15.00	115	48	65	16
GTD-1510-03CA	15.10	115	48	65	16
GTD-1520-03CA	15.20	115	48	65	16
GTD-1530-03CA	15.30	115	48	65	16
GTD-1540-03CA	15.40	115	48	65	16
GTD-1550-03CA	15.50	115	48	65	16
GTD-1560-03CA	15.60	115	48	65	16
GTD-1570-03CA	15.70	115	48	65	16
GTD-1580-03CA	15.80	115	48	65	16
GTD-1590-03CA	15.90	115	48	65	16
GTD-1600-03CA	16.00	115	48	65	16
GTD-1610-03CA	16.10	123	48	73	18
GTD-1620-03CA	16.20	123	48	73	18
GTD-1630-03CA	16.30	123	48	73	18
GTD-1640-03CA	16.40	123	48	73	18
GTD-1650-03CA	16.50	123	48	73	18
GTD-1660-03CA	16.60	123	48	73	18
GTD-1670-03CA	16.70	123	48	73	18
GTD-1680-03CA	16.80	123	48	73	18
GTD-1690-03CA	16.90	123	48	73	18
GTD-1700-03CA	17.00	123	48	73	18
GTD-1710-03CA	17.10	123	48	73	18
GTD-1720-03CA	17.20	123	48	73	18
GTD-1730-03CA	17.30	123	48	73	18
GTD-1740-03CA	17.40	123	48	73	18
GTD-1750-03CA	17.50	123	48	73	18
GTD-1760-03CA	17.60	123	48	73	18
GTD-1770-03CA	17.70	123	48	73	18
GTD-1780-03CA	17.80	123	48	73	18
GTD-1790-03CA	17.90	123	48	73	18



GTD-03CA

通用加工3D内冷麻花钻

3D inner cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1800-03CA	18.00	123	48	73	18
GTD-1810-03CA	18.10	131	50	79	20
GTD-1820-03CA	18.20	131	50	79	20
GTD-1830-03CA	18.30	131	50	79	20
GTD-1840-03CA	18.40	131	50	79	20
GTD-1850-03CA	18.50	131	50	79	20
GTD-1860-03CA	18.60	131	50	79	20
GTD-1870-03CA	18.70	131	50	79	20
GTD-1880-03CA	18.80	131	50	79	20
GTD-1890-03CA	18.90	131	50	79	20
GTD-1900-03CA	19.00	131	50	79	20
GTD-1910-03CA	19.10	131	50	79	20
GTD-1920-03CA	19.20	131	50	79	20
GTD-1930-03CA	19.30	131	50	79	20
GTD-1940-03CA	19.40	131	50	79	20
GTD-1950-03CA	19.50	131	50	79	20
GTD-1960-03CA	19.60	131	50	79	20
GTD-1970-03CA	19.70	131	50	79	20
GTD-1980-03CA	19.80	131	50	79	20
GTD-1990-03CA	19.90	131	50	79	20
GTD-2000-03CA	20.00	131	50	79	20

备注：D3–D20刀具接受非标订制
Note: accept non-standard customization from D3 to D20.

尺寸范围 Nominal size range	D(m7)	d(h6)
> 3—6	+0.004/+0.016	0.000/–0.008
> 6—10	+0.006/+0.021	0.000/–0.009
> 10—18	+0.007/+0.025	0.000/–0.011
> 18—20	+0.008/+0.029	0.000/–0.013

单位unit(mm)



GTD-05NA

通用加工5D外冷麻花钻

5D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0300-05NA	3.00	66	36	28	6
GTD-0310-05NA	3.10	66	36	28	6
GTD-0320-05NA	3.20	66	36	28	6
GTD-0330-05NA	3.30	66	36	28	6
GTD-0340-05NA	3.40	66	36	28	6
GTD-0350-05NA	3.50	66	36	28	6
GTD-0360-05NA	3.60	66	36	28	6
GTD-0370-05NA	3.70	66	36	28	6
GTD-0380-05NA	3.80	74	36	36	6
GTD-0390-05NA	3.90	74	36	36	6
GTD-0400-05NA	4.00	74	36	36	6
GTD-0410-05NA	4.10	74	36	36	6
GTD-0420-05NA	4.20	74	36	36	6
GTD-0430-05NA	4.30	74	36	36	6
GTD-0440-05NA	4.40	74	36	36	6
GTD-0450-05NA	4.50	74	36	36	6
GTD-0460-05NA	4.60	74	36	36	6
GTD-0470-05NA	4.70	74	36	36	6
GTD-0480-05NA	4.80	82	36	44	6
GTD-0490-05NA	4.90	82	36	44	6
GTD-0500-05NA	5.00	82	36	44	6
GTD-0510-05NA	5.10	82	36	44	6
GTD-0520-05NA	5.20	82	36	44	6
GTD-0530-05NA	5.30	82	36	44	6
GTD-0540-05NA	5.40	82	36	44	6
GTD-0550-05NA	5.50	82	36	44	6
GTD-0560-05NA	5.60	82	36	44	6
GTD-0570-05NA	5.70	82	36	44	6
GTD-0580-05NA	5.80	82	36	44	6
GTD-0590-05NA	5.90	82	36	44	6



GTD-05NA

通用加工5D外冷麻花钻

5D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0600-05NA	6.00	82	36	44	6
GTD-0610-05NA	6.10	91	36	53	8
GTD-0620-05NA	6.20	91	36	53	8
GTD-0630-05NA	6.30	91	36	53	8
GTD-0640-05NA	6.40	91	36	53	8
GTD-0650-05NA	6.50	91	36	53	8
GTD-0660-05NA	6.60	91	36	53	8
GTD-0670-05NA	6.70	91	36	53	8
GTD-0680-05NA	6.80	91	36	53	8
GTD-0690-05NA	6.90	91	36	53	8
GTD-0700-05NA	7.00	91	36	53	8
GTD-0710-05NA	7.10	91	36	53	8
GTD-0720-05NA	7.20	91	36	53	8
GTD-0730-05NA	7.30	91	36	53	8
GTD-0740-05NA	7.40	91	36	53	8
GTD-0750-05NA	7.50	91	36	53	8
GTD-0760-05NA	7.60	91	36	53	8
GTD-0770-05NA	7.70	91	36	53	8
GTD-0780-05NA	7.80	91	36	53	8
GTD-0790-05NA	7.90	91	36	53	8
GTD-0800-05NA	8.00	91	36	53	8
GTD-0810-05NA	8.10	103	40	61	10
GTD-0820-05NA	8.20	103	40	61	10
GTD-0830-05NA	8.30	103	40	61	10
GTD-0840-05NA	8.40	103	40	61	10
GTD-0850-05NA	8.50	103	40	61	10
GTD-0860-05NA	8.60	103	40	61	10
GTD-0870-05NA	8.70	103	40	61	10
GTD-0880-05NA	8.80	103	40	61	10
GTD-0890-05NA	8.90	103	40	61	10



GTD-05NA

通用加工5D外冷麻花钻

5D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0900-05NA	9.00	103	40	61	10
GTD-0910-05NA	9.10	103	40	61	10
GTD-0920-05NA	9.20	103	40	61	10
GTD-0930-05NA	9.30	103	40	61	10
GTD-0940-05NA	9.40	103	40	61	10
GTD-0950-05NA	9.50	103	40	61	10
GTD-0960-05NA	9.60	103	40	61	10
GTD-0970-05NA	9.70	103	40	61	10
GTD-0980-05NA	9.80	103	40	61	10
GTD-0990-05NA	9.90	103	40	61	10
GTD-1000-05NA	10.00	103	40	61	10
GTD-1010-05NA	10.10	118	45	71	12
GTD-1020-05NA	10.20	118	45	71	12
GTD-1030-05NA	10.30	118	45	71	12
GTD-1040-05NA	10.40	118	45	71	12
GTD-1050-05NA	10.50	118	45	71	12
GTD-1060-05NA	10.60	118	45	71	12
GTD-1070-05NA	10.70	118	45	71	12
GTD-1080-05NA	10.80	118	45	71	12
GTD-1090-05NA	10.90	118	45	71	12
GTD-1100-05NA	11.00	118	45	71	12
GTD-1110-05NA	11.10	118	45	71	12
GTD-1120-05NA	11.20	118	45	71	12
GTD-1130-05NA	11.30	118	45	71	12
GTD-1140-05NA	11.40	118	45	71	12
GTD-1150-05NA	11.50	118	45	71	12
GTD-1160-05NA	11.60	118	45	71	12
GTD-1170-05NA	11.70	118	45	71	12
GTD-1180-05NA	11.80	118	45	71	12
GTD-1190-05NA	11.90	118	45	71	12



GTD-05NA

通用加工5D外冷麻花钻

5D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1200-05NA	12.00	118	45	71	12
GTD-1210-05NA	12.10	124	45	77	14
GTD-1220-05NA	12.20	124	45	77	14
GTD-1230-05NA	12.30	124	45	77	14
GTD-1240-05NA	12.40	124	45	77	14
GTD-1250-05NA	12.50	124	45	77	14
GTD-1260-05NA	12.60	124	45	77	14
GTD-1270-05NA	12.70	124	45	77	14
GTD-1280-05NA	12.80	124	45	77	14
GTD-1290-05NA	12.90	124	45	77	14
GTD-1300-05NA	13.00	124	45	77	14
GTD-1310-05NA	13.10	124	45	77	14
GTD-1320-05NA	13.20	124	45	77	14
GTD-1330-05NA	13.30	124	45	77	14
GTD-1340-05NA	13.40	124	45	77	14
GTD-1350-05NA	13.50	124	45	77	14
GTD-1360-05NA	13.60	124	45	77	14
GTD-1370-05NA	13.70	124	45	77	14
GTD-1380-05NA	13.80	124	45	77	14
GTD-1390-05NA	13.90	124	45	77	14
GTD-1400-05NA	14.00	124	45	77	14
GTD-1410-05NA	14.10	133	48	83	16
GTD-1420-05NA	14.20	133	48	83	16
GTD-1430-05NA	14.30	133	48	83	16
GTD-1440-05NA	14.40	133	48	83	16
GTD-1450-05NA	14.50	133	48	83	16
GTD-1460-05NA	14.60	133	48	83	16
GTD-1470-05NA	14.70	133	48	83	16
GTD-1480-05NA	14.80	133	48	83	16
GTD-1490-05NA	14.90	133	48	83	16



GTD-05NA

通用加工5D外冷麻花钻

5D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1500-05NA	15.00	133	48	83	16
GTD-1510-05NA	15.10	133	48	83	16
GTD-1520-05NA	15.20	133	48	83	16
GTD-1530-05NA	15.30	133	48	83	16
GTD-1540-05NA	15.40	133	48	83	16
GTD-1550-05NA	15.50	133	48	83	16
GTD-1560-05NA	15.60	133	48	83	16
GTD-1570-05NA	15.70	133	48	83	16
GTD-1580-05NA	15.80	133	48	83	16
GTD-1590-05NA	15.90	133	48	83	16
GTD-1600-05NA	16.00	133	48	83	16
GTD-1610-05NA	16.10	143	48	93	18
GTD-1620-05NA	16.20	143	48	93	18
GTD-1630-05NA	16.30	143	48	93	18
GTD-1640-05NA	16.40	143	48	93	18
GTD-1650-05NA	16.50	143	48	93	18
GTD-1660-05NA	16.60	143	48	93	18
GTD-1670-05NA	16.70	143	48	93	18
GTD-1680-05NA	16.80	143	48	93	18
GTD-1690-05NA	16.90	143	48	93	18
GTD-1700-05NA	17.00	143	48	93	18
GTD-1710-05NA	17.10	143	48	93	18
GTD-1720-05NA	17.20	143	48	93	18
GTD-1730-05NA	17.30	143	48	93	18
GTD-1740-05NA	17.40	143	48	93	18
GTD-1750-05NA	17.50	143	48	93	18
GTD-1760-05NA	17.60	143	48	93	18
GTD-1770-05NA	17.70	143	48	93	18
GTD-1780-05NA	17.80	143	48	93	18
GTD-1790-05NA	17.90	143	48	93	18



GTD-05NA

通用加工5D外冷麻花钻

5D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1800-05NA	18.00	143	48	93	18
GTD-1810-05NA	18.10	153	50	101	20
GTD-1820-05NA	18.20	153	50	101	20
GTD-1830-05NA	18.30	153	50	101	20
GTD-1840-05NA	18.40	153	50	101	20
GTD-1850-05NA	18.50	153	50	101	20
GTD-1860-05NA	18.60	153	50	101	20
GTD-1870-05NA	18.70	153	50	101	20
GTD-1880-05NA	18.80	153	50	101	20
GTD-1890-05NA	18.90	153	50	101	20
GTD-1900-05NA	19.00	153	50	101	20
GTD-1910-05NA	19.10	153	50	101	20
GTD-1920-05NA	19.20	153	50	101	20
GTD-1930-05NA	19.30	153	50	101	20
GTD-1940-05NA	19.40	153	50	101	20
GTD-1950-05NA	19.50	153	50	101	20
GTD-1960-05NA	19.60	153	50	101	20
GTD-1970-05NA	19.70	153	50	101	20
GTD-1980-05NA	19.80	153	50	101	20
GTD-1990-05NA	19.90	153	50	101	20
GTD-2000-05NA	20.00	153	50	101	20

备注：D3–D20刀具接受非标订制
Note: accept non-standard customization from D3 to D20.

尺寸范围 Nominal size range	D(m7)	d(h6)
> 3—6	+0.004/+0.016	0.000/–0.008
> 6—10	+0.006/+0.021	0.000/–0.009
> 10—18	+0.007/+0.025	0.000/–0.011
> 18—20	+0.008/+0.029	0.000/–0.013

单位unit(mm)



GTD-05CA

通用加工5D内冷麻花钻

5D inner cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0300-05CA	3.00	66	36	28	6
GTD-0310-05CA	3.10	66	36	28	6
GTD-0320-05CA	3.20	66	36	28	6
GTD-0330-05CA	3.30	66	36	28	6
GTD-0340-05CA	3.40	66	36	28	6
GTD-0350-05CA	3.50	66	36	28	6
GTD-0360-05CA	3.60	66	36	28	6
GTD-0370-05CA	3.70	66	36	28	6
GTD-0380-05CA	3.80	74	36	36	6
GTD-0390-05CA	3.90	74	36	36	6
GTD-0400-05CA	4.00	74	36	36	6
GTD-0410-05CA	4.10	74	36	36	6
GTD-0420-05CA	4.20	74	36	36	6
GTD-0430-05CA	4.30	74	36	36	6
GTD-0440-05CA	4.40	74	36	36	6
GTD-0450-05CA	4.50	74	36	36	6
GTD-0460-05CA	4.60	74	36	36	6
GTD-0470-05CA	4.70	74	36	36	6
GTD-0480-05CA	4.80	82	36	44	6
GTD-0490-05CA	4.90	82	36	44	6
GTD-0500-05CA	5.00	82	36	44	6
GTD-0510-05CA	5.10	82	36	44	6
GTD-0520-05CA	5.20	82	36	44	6
GTD-0530-05CA	5.30	82	36	44	6
GTD-0540-05CA	5.40	82	36	44	6
GTD-0550-05CA	5.50	82	36	44	6
GTD-0560-05CA	5.60	82	36	44	6
GTD-0570-05CA	5.70	82	36	44	6
GTD-0580-05CA	5.80	82	36	44	6
GTD-0590-05CA	5.90	82	36	44	6



GTD-05CA

通用加工5D内冷麻花钻

5D inner cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0600-05CA	6.00	82	36	44	6
GTD-0610-05CA	6.10	91	36	53	8
GTD-0620-05CA	6.20	91	36	53	8
GTD-0630-05CA	6.30	91	36	53	8
GTD-0640-05CA	6.40	91	36	53	8
GTD-0650-05CA	6.50	91	36	53	8
GTD-0660-05CA	6.60	91	36	53	8
GTD-0670-05CA	6.70	91	36	53	8
GTD-0680-05CA	6.80	91	36	53	8
GTD-0690-05CA	6.90	91	36	53	8
GTD-0700-05CA	7.00	91	36	53	8
GTD-0710-05CA	7.10	91	36	53	8
GTD-0720-05CA	7.20	91	36	53	8
GTD-0730-05CA	7.30	91	36	53	8
GTD-0740-05CA	7.40	91	36	53	8
GTD-0750-05CA	7.50	91	36	53	8
GTD-0760-05CA	7.60	91	36	53	8
GTD-0770-05CA	7.70	91	36	53	8
GTD-0780-05CA	7.80	91	36	53	8
GTD-0790-05CA	7.90	91	36	53	8
GTD-0800-05CA	8.00	91	36	53	8
GTD-0810-05CA	8.10	103	40	61	10
GTD-0820-05CA	8.20	103	40	61	10
GTD-0830-05CA	8.30	103	40	61	10
GTD-0840-05CA	8.40	103	40	61	10
GTD-0850-05CA	8.50	103	40	61	10
GTD-0860-05CA	8.60	103	40	61	10
GTD-0870-05CA	8.70	103	40	61	10
GTD-0880-05CA	8.80	103	40	61	10
GTD-0890-05CA	8.90	103	40	61	10



GTD-05CA

通用加工5D内冷麻花钻

5D inner cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0900-05CA	9.00	103	40	61	10
GTD-0910-05CA	9.10	103	40	61	10
GTD-0920-05CA	9.20	103	40	61	10
GTD-0930-05CA	9.30	103	40	61	10
GTD-0940-05CA	9.40	103	40	61	10
GTD-0950-05CA	9.50	103	40	61	10
GTD-0960-05CA	9.60	103	40	61	10
GTD-0970-05CA	9.70	103	40	61	10
GTD-0980-05CA	9.80	103	40	61	10
GTD-0990-05CA	9.90	103	40	61	10
GTD-1000-05CA	10.00	103	40	61	10
GTD-1010-05CA	10.10	118	45	71	12
GTD-1020-05CA	10.20	118	45	71	12
GTD-1030-05CA	10.30	118	45	71	12
GTD-1040-05CA	10.40	118	45	71	12
GTD-1050-05CA	10.50	118	45	71	12
GTD-1060-05CA	10.60	118	45	71	12
GTD-1070-05CA	10.70	118	45	71	12
GTD-1080-05CA	10.80	118	45	71	12
GTD-1090-05CA	10.90	118	45	71	12
GTD-1100-05CA	11.00	118	45	71	12
GTD-1110-05CA	11.10	118	45	71	12
GTD-1120-05CA	11.20	118	45	71	12
GTD-1130-05CA	11.30	118	45	71	12
GTD-1140-05CA	11.40	118	45	71	12
GTD-1150-05CA	11.50	118	45	71	12
GTD-1160-05CA	11.60	118	45	71	12
GTD-1170-05CA	11.70	118	45	71	12
GTD-1180-05CA	11.80	118	45	71	12
GTD-1190-05CA	11.90	118	45	71	12



GTD-05CA

通用加工5D内冷麻花钻

5D inner cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1200-05CA	12.00	118	45	71	12
GTD-1210-05CA	12.10	124	45	77	14
GTD-1220-05CA	12.20	124	45	77	14
GTD-1230-05CA	12.30	124	45	77	14
GTD-1240-05CA	12.40	124	45	77	14
GTD-1250-05CA	12.50	124	45	77	14
GTD-1260-05CA	12.60	124	45	77	14
GTD-1270-05CA	12.70	124	45	77	14
GTD-1280-05CA	12.80	124	45	77	14
GTD-1290-05CA	12.90	124	45	77	14
GTD-1300-05CA	13.00	124	45	77	14
GTD-1310-05CA	13.10	124	45	77	14
GTD-1320-05CA	13.20	124	45	77	14
GTD-1330-05CA	13.30	124	45	77	14
GTD-1340-05CA	13.40	124	45	77	14
GTD-1350-05CA	13.50	124	45	77	14
GTD-1360-05CA	13.60	124	45	77	14
GTD-1370-05CA	13.70	124	45	77	14
GTD-1380-05CA	13.80	124	45	77	14
GTD-1390-05CA	13.90	124	45	77	14
GTD-1400-05CA	14.00	124	45	77	14
GTD-1410-05CA	14.10	133	48	83	16
GTD-1420-05CA	14.20	133	48	83	16
GTD-1430-05CA	14.30	133	48	83	16
GTD-1440-05CA	14.40	133	48	83	16
GTD-1450-05CA	14.50	133	48	83	16
GTD-1460-05CA	14.60	133	48	83	16
GTD-1470-05CA	14.70	133	48	83	16
GTD-1480-05CA	14.80	133	48	83	16
GTD-1490-05CA	14.90	133	48	83	16



GTD-05CA

通用加工5D内冷麻花钻

5D inner cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0900-05CA	9.00	103	40	61	10
GTD-0910-05CA	9.10	103	40	61	10
GTD-0920-05CA	9.20	103	40	61	10
GTD-0930-05CA	9.30	103	40	61	10
GTD-0940-05CA	9.40	103	40	61	10
GTD-0950-05CA	9.50	103	40	61	10
GTD-0960-05CA	9.60	103	40	61	10
GTD-0970-05CA	9.70	103	40	61	10
GTD-0980-05CA	9.80	103	40	61	10
GTD-0990-05CA	9.90	103	40	61	10
GTD-1000-05CA	10.00	103	40	61	10
GTD-1010-05CA	10.10	118	45	71	12
GTD-1020-05CA	10.20	118	45	71	12
GTD-1030-05CA	10.30	118	45	71	12
GTD-1040-05CA	10.40	118	45	71	12
GTD-1050-05CA	10.50	118	45	71	12
GTD-1060-05CA	10.60	118	45	71	12
GTD-1070-05CA	10.70	118	45	71	12
GTD-1080-05CA	10.80	118	45	71	12
GTD-1090-05CA	10.90	118	45	71	12
GTD-1100-05CA	11.00	118	45	71	12
GTD-1110-05CA	11.10	118	45	71	12
GTD-1120-05CA	11.20	118	45	71	12
GTD-1130-05CA	11.30	118	45	71	12
GTD-1140-05CA	11.40	118	45	71	12
GTD-1150-05CA	11.50	118	45	71	12
GTD-1160-05CA	11.60	118	45	71	12
GTD-1170-05CA	11.70	118	45	71	12
GTD-1180-05CA	11.80	118	45	71	12
GTD-1190-05CA	11.90	118	45	71	12



GTD-05CA

通用加工5D内冷麻花钻

5D inner cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1200-05CA	12.00	118	45	71	12
GTD-1210-05CA	12.10	124	45	77	14
GTD-1220-05CA	12.20	124	45	77	14
GTD-1230-05CA	12.30	124	45	77	14
GTD-1240-05CA	12.40	124	45	77	14
GTD-1250-05CA	12.50	124	45	77	14
GTD-1260-05CA	12.60	124	45	77	14
GTD-1270-05CA	12.70	124	45	77	14
GTD-1280-05CA	12.80	124	45	77	14
GTD-1290-05CA	12.90	124	45	77	14
GTD-1300-05CA	13.00	124	45	77	14
GTD-1310-05CA	13.10	124	45	77	14
GTD-1320-05CA	13.20	124	45	77	14
GTD-1330-05CA	13.30	124	45	77	14
GTD-1340-05CA	13.40	124	45	77	14
GTD-1350-05CA	13.50	124	45	77	14
GTD-1360-05CA	13.60	124	45	77	14
GTD-1370-05CA	13.70	124	45	77	14
GTD-1380-05CA	13.80	124	45	77	14
GTD-1390-05CA	13.90	124	45	77	14
GTD-1400-05CA	14.00	124	45	77	14
GTD-1410-05CA	14.10	133	48	83	16
GTD-1420-05CA	14.20	133	48	83	16
GTD-1430-05CA	14.30	133	48	83	16
GTD-1440-05CA	14.40	133	48	83	16
GTD-1450-05CA	14.50	133	48	83	16
GTD-1460-05CA	14.60	133	48	83	16
GTD-1470-05CA	14.70	133	48	83	16
GTD-1480-05CA	14.80	133	48	83	16
GTD-1490-05CA	14.90	133	48	83	16



GTD-05CA

通用加工5D内冷麻花钻

5D inner cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1500-05CA	15.00	133	48	83	16
GTD-1510-05CA	15.10	133	48	83	16
GTD-1520-05CA	15.20	133	48	83	16
GTD-1530-05CA	15.30	133	48	83	16
GTD-1540-05CA	15.40	133	48	83	16
GTD-1550-05CA	15.50	133	48	83	16
GTD-1560-05CA	15.60	133	48	83	16
GTD-1570-05CA	15.70	133	48	83	16
GTD-1580-05CA	15.80	133	48	83	16
GTD-1590-05CA	15.90	133	48	83	16
GTD-1600-05CA	16.00	133	48	83	16
GTD-1610-05CA	16.10	143	48	93	18
GTD-1620-05CA	16.20	143	48	93	18
GTD-1630-05CA	16.30	143	48	93	18
GTD-1640-05CA	16.40	143	48	93	18
GTD-1650-05CA	16.50	143	48	93	18
GTD-1660-05CA	16.60	143	48	93	18
GTD-1670-05CA	16.70	143	48	93	18
GTD-1680-05CA	16.80	143	48	93	18
GTD-1690-05CA	16.90	143	48	93	18
GTD-1700-05CA	17.00	143	48	93	18
GTD-1710-05CA	17.10	143	48	93	18
GTD-1720-05CA	17.20	143	48	93	18
GTD-1730-05CA	17.30	143	48	93	18
GTD-1740-05CA	17.40	143	48	93	18
GTD-1750-05CA	17.50	143	48	93	18
GTD-1760-05CA	17.60	143	48	93	18
GTD-1770-05CA	17.70	143	48	93	18
GTD-1780-05CA	17.80	143	48	93	18
GTD-1790-05CA	17.90	143	48	93	18



GTD-05CA

通用加工5D内冷麻花钻

5D inner cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1800-05CA	18.00	143	48	93	18
GTD-1810-05CA	18.10	153	50	101	20
GTD-1820-05CA	18.20	153	50	101	20
GTD-1830-05CA	18.30	153	50	101	20
GTD-1840-05CA	18.40	153	50	101	20
GTD-1850-05CA	18.50	153	50	101	20
GTD-1860-05CA	18.60	153	50	101	20
GTD-1870-05CA	18.70	153	50	101	20
GTD-1880-05CA	18.80	153	50	101	20
GTD-1890-05CA	18.90	153	50	101	20
GTD-1900-05CA	19.00	153	50	101	20
GTD-1910-05CA	19.10	153	50	101	20
GTD-1920-05CA	19.20	153	50	101	20
GTD-1930-05CA	19.30	153	50	101	20
GTD-1940-05CA	19.40	153	50	101	20
GTD-1950-05CA	19.50	153	50	101	20
GTD-1960-05CA	19.60	153	50	101	20
GTD-1970-05CA	19.70	153	50	101	20
GTD-1980-05CA	19.80	153	50	101	20
GTD-1990-05CA	19.90	153	50	101	20
GTD-2000-05CA	20.00	153	50	101	20

备注：D3–D20刀具接受非标订制
Note: accept non-standard customization from D3 to D20.

尺寸范围 Nominal size range	D(m7)	d(h6)
≥2—3	+0.002/+0.012	0.000/–0.006
> 3—6	+0.004/+0.016	0.000/–0.008
> 6—10	+0.006/+0.021	0.000/–0.009
> 10—18	+0.007/+0.025	0.000/–0.011
> 18—20	+0.008/+0.029	0.000/–0.013

单位unit(mm)



GTD-08CA

通用加工8D内冷麻花钻

8D inner cooling twist drills for general machinin



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0300-08CA	3.00	72	36	34	6
GTD-0310-08CA	3.10	72	36	34	6
GTD-0320-08CA	3.20	72	36	34	6
GTD-0330-08CA	3.30	72	36	34	6
GTD-0340-08CA	3.40	72	36	34	6
GTD-0350-08CA	3.50	72	36	34	6
GTD-0360-08CA	3.60	72	36	34	6
GTD-0370-08CA	3.70	72	36	34	6
GTD-0380-08CA	3.80	81	36	43	6
GTD-0390-08CA	3.90	81	36	43	6
GTD-0400-08CA	4.00	81	36	43	6
GTD-0410-08CA	4.10	81	36	43	6
GTD-0420-08CA	4.20	81	36	43	6
GTD-0430-08CA	4.30	81	36	43	6
GTD-0440-08CA	4.40	81	36	43	6
GTD-0450-08CA	4.50	81	36	43	6
GTD-0460-08CA	4.60	81	36	43	6
GTD-0470-08CA	4.70	81	36	43	6
GTD-0480-08CA	4.80	95	36	57	6
GTD-0490-08CA	4.90	95	36	57	6
GTD-0500-08CA	5.00	95	36	57	6
GTD-0510-08CA	5.10	95	36	57	6
GTD-0520-08CA	5.20	95	36	57	6
GTD-0530-08CA	5.30	95	36	57	6
GTD-0540-08CA	5.40	95	36	57	6
GTD-0550-08CA	5.50	95	36	57	6
GTD-0560-08CA	5.60	95	36	57	6
GTD-0570-08CA	5.70	95	36	57	6
GTD-0580-08CA	5.80	95	36	57	6
GTD-0590-08CA	5.90	95	36	57	6



GTD-08CA

通用加工8D内冷麻花钻

8D inner cooling twist drills for general machinin



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0600-08CA	6.00	95	36	57	6
GTD-0610-08CA	6.10	114	36	76	8
GTD-0620-08CA	6.20	114	36	76	8
GTD-0630-08CA	6.30	114	36	76	8
GTD-0640-08CA	6.40	114	36	76	8
GTD-0650-08CA	6.50	114	36	76	8
GTD-0660-08CA	6.60	114	36	76	8
GTD-0670-08CA	6.70	114	36	76	8
GTD-0680-08CA	6.80	114	36	76	8
GTD-0690-08CA	6.90	114	36	76	8
GTD-0700-08CA	7.00	114	36	76	8
GTD-0710-08CA	7.10	114	36	76	8
GTD-0720-08CA	7.20	114	36	76	8
GTD-0730-08CA	7.30	114	36	76	8
GTD-0740-08CA	7.40	114	36	76	8
GTD-0750-08CA	7.50	114	36	76	8
GTD-0760-08CA	7.60	114	36	76	8
GTD-0770-08CA	7.70	114	36	76	8
GTD-0780-08CA	7.80	114	36	76	8
GTD-0790-08CA	7.90	114	36	76	8
GTD-0800-08CA	8.00	114	36	76	8
GTD-0810-08CA	8.10	142	40	95	10
GTD-0820-08CA	8.20	142	40	95	10
GTD-0830-08CA	8.30	142	40	95	10
GTD-0840-08CA	8.40	142	40	95	10
GTD-0850-08CA	8.50	142	40	95	10
GTD-0860-08CA	8.60	142	40	95	10
GTD-0870-08CA	8.70	142	40	95	10
GTD-0880-08CA	8.80	142	40	95	10
GTD-0890-08CA	8.90	142	40	95	10



GTD-08CA

通用加工8D内冷麻花钻

8D inner cooling twist drills for general machinin



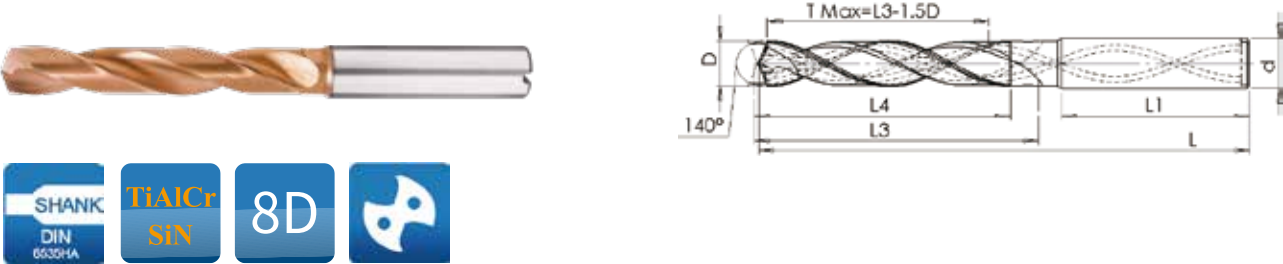
订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0900-08CA	9.00	142	40	95	10
GTD-0910-08CA	9.10	142	40	95	10
GTD-0920-08CA	9.20	142	40	95	10
GTD-0930-08CA	9.30	142	40	95	10
GTD-0940-08CA	9.40	142	40	95	10
GTD-0950-08CA	9.50	142	40	95	10
GTD-0960-08CA	9.60	142	40	95	10
GTD-0970-08CA	9.70	142	40	95	10
GTD-0980-08CA	9.80	142	40	95	10
GTD-0990-08CA	9.90	142	40	95	10
GTD-1000-08CA	10.00	142	40	95	10
GTD-1010-08CA	10.10	162	45	114	12
GTD-1020-08CA	10.20	162	45	114	12
GTD-1030-08CA	10.30	162	45	114	12
GTD-1040-08CA	10.40	162	45	114	12
GTD-1050-08CA	10.50	162	45	114	12
GTD-1060-08CA	10.60	162	45	114	12
GTD-1070-08CA	10.70	162	45	114	12
GTD-1080-08CA	10.80	162	45	114	12
GTD-1090-08CA	10.90	162	45	114	12
GTD-1100-08CA	11.00	162	45	114	12
GTD-1110-08CA	11.10	162	45	114	12
GTD-1120-08CA	11.20	162	45	114	12
GTD-1130-08CA	11.30	162	45	114	12
GTD-1140-08CA	11.40	162	45	114	12
GTD-1150-08CA	11.50	162	45	114	12
GTD-1160-08CA	11.60	162	45	114	12
GTD-1170-08CA	11.70	162	45	114	12
GTD-1180-08CA	11.80	162	45	114	12
GTD-1190-08CA	11.90	162	45	114	12



GTD-08CA

通用加工8D内冷麻花钻

8D inner cooling twist drills for general machinin



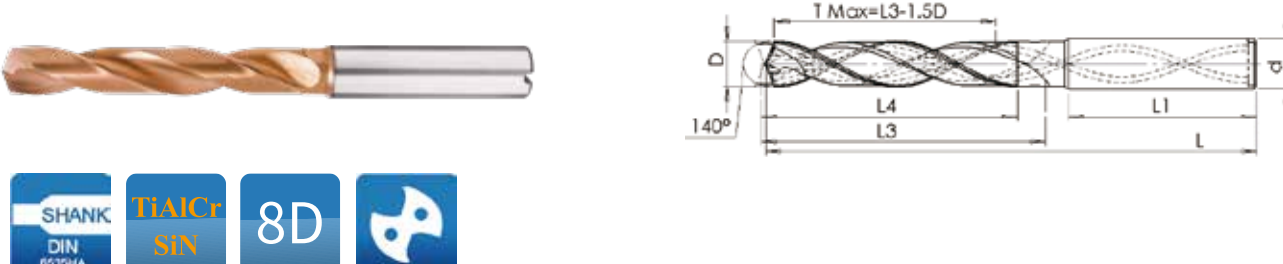
订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1200-08CA	12.00	162	45	114	12
GTD-1210-08CA	12.10	182	45	133	14
GTD-1220-08CA	12.20	182	45	133	14
GTD-1230-08CA	12.30	182	45	133	14
GTD-1240-08CA	12.40	182	45	133	14
GTD-1250-08CA	12.50	182	45	133	14
GTD-1260-08CA	12.60	182	45	133	14
GTD-1270-08CA	12.70	182	45	133	14
GTD-1280-08CA	12.80	182	45	133	14
GTD-1290-08CA	12.90	182	45	133	14
GTD-1300-08CA	13.00	182	45	133	14
GTD-1310-08CA	13.10	182	45	133	14
GTD-1320-08CA	13.20	182	45	133	14
GTD-1330-08CA	13.30	182	45	133	14
GTD-1340-08CA	13.40	182	45	133	14
GTD-1350-08CA	13.50	182	45	133	14
GTD-1360-08CA	13.60	182	45	133	14
GTD-1370-08CA	13.70	182	45	133	14
GTD-1380-08CA	13.80	182	45	133	14
GTD-1390-08CA	13.90	182	45	133	14
GTD-1400-08CA	14.00	182	45	133	14
GTD-1410-08CA	14.10	203	48	152	16
GTD-1420-08CA	14.20	203	48	152	16
GTD-1430-08CA	14.30	203	48	152	16
GTD-1440-08CA	14.40	203	48	152	16
GTD-1450-08CA	14.50	203	48	152	16
GTD-1460-08CA	14.60	203	48	152	16
GTD-1470-08CA	14.70	203	48	152	16
GTD-1480-08CA	14.80	203	48	152	16
GTD-1490-08CA	14.90	203	48	152	16



GTD-08CA

通用加工8D内冷麻花钻

8D inner cooling twist drills for general machinin



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-1500-08CA	15.00	203	48	152	16
GTD-1510-08CA	15.10	203	48	152	16
GTD-1520-08CA	15.20	203	48	152	16
GTD-1530-08CA	15.30	203	48	152	16
GTD-1540-08CA	15.40	203	48	152	16
GTD-1550-08CA	15.50	203	48	152	16
GTD-1560-08CA	15.60	203	48	152	16
GTD-1570-08CA	15.70	203	48	152	16
GTD-1580-08CA	15.80	203	48	152	16
GTD-1590-08CA	15.90	203	48	152	16
GTD-1600-08CA	16.00	203	48	152	16

备注：D3-D16刀具接受非标订制
Note: accept non-standard customization from D3 to D16.

尺寸范围 Nominal size range	D(m7)	d(h6)
> 3—6	+0.004/+0.016	0.000/−0.008
> 6—10	+0.006/+0.021	0.000/−0.009
> 10—16	+0.007/+0.025	0.000/−0.011

单位unit(mm)



GTD-12CA

通用加工12D内冷麻花钻

12D inner cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0300-12CA	3.00	92	36	54	6
GTD-0310-12CA	3.10	92	36	54	6
GTD-0320-12CA	3.20	92	36	54	6
GTD-0330-12CA	3.30	92	36	54	6
GTD-0340-12CA	3.40	92	36	54	6
GTD-0350-12CA	3.50	92	36	54	6
GTD-0360-12CA	3.60	92	36	54	6
GTD-0370-12CA	3.70	92	36	54	6
GTD-0380-12CA	3.80	102	36	64	6
GTD-0390-12CA	3.90	102	36	64	6
GTD-0400-12CA	4.00	102	36	64	6
GTD-0410-12CA	4.10	102	36	64	6
GTD-0420-12CA	4.20	102	36	64	6
GTD-0430-12CA	4.30	102	36	64	6
GTD-0440-12CA	4.40	102	36	64	6
GTD-0450-12CA	4.50	102	36	64	6
GTD-0460-12CA	4.60	102	36	64	6
GTD-0470-12CA	4.70	102	36	64	6
GTD-0480-12CA	4.80	121	36	83	6
GTD-0490-12CA	4.90	121	36	83	6
GTD-0500-12CA	5.00	121	36	83	6
GTD-0510-12CA	5.10	121	36	83	6
GTD-0520-12CA	5.20	121	36	83	6
GTD-0530-12CA	5.30	121	36	83	6
GTD-0540-12CA	5.40	121	36	83	6
GTD-0550-12CA	5.50	121	36	83	6
GTD-0560-12CA	5.60	121	36	83	6
GTD-0570-12CA	5.70	121	36	83	6
GTD-0580-12CA	5.80	121	36	83	6
GTD-0590-12CA	5.90	121	36	83	6



GTD-12CA

通用加工12D内冷麻花钻

12D inner cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0600-12CA	6.00	121	36	83	6
GTD-0610-12CA	6.10	148	36	110	8
GTD-0620-12CA	6.20	148	36	110	8
GTD-0630-12CA	6.30	148	36	110	8
GTD-0640-12CA	6.40	148	36	110	8
GTD-0650-12CA	6.50	148	36	110	8
GTD-0660-12CA	6.60	148	36	110	8
GTD-0670-12CA	6.70	148	36	110	8
GTD-0680-12CA	6.80	148	36	110	8
GTD-0690-12CA	6.90	148	36	110	8
GTD-0700-12CA	7.00	148	36	110	8
GTD-0710-12CA	7.10	148	36	110	8
GTD-0720-12CA	7.20	148	36	110	8
GTD-0730-12CA	7.30	148	36	110	8
GTD-0740-12CA	7.40	148	36	110	8
GTD-0750-12CA	7.50	148	36	110	8
GTD-0760-12CA	7.60	148	36	110	8
GTD-0770-12CA	7.70	148	36	110	8
GTD-0780-12CA	7.80	148	36	110	8
GTD-0790-12CA	7.90	148	36	110	8
GTD-0800-12CA	8.00	148	36	110	8
GTD-0810-12CA	8.10	180	40	138	10
GTD-0820-12CA	8.20	180	40	138	10
GTD-0830-12CA	8.30	180	40	138	10
GTD-0840-12CA	8.40	180	40	138	10
GTD-0850-12CA	8.50	180	40	138	10
GTD-0860-12CA	8.60	180	40	138	10
GTD-0870-12CA	8.70	180	40	138	10
GTD-0880-12CA	8.80	180	40	138	10
GTD-0890-12CA	8.90	180	40	138	10
GTD-0900-12CA	9.00	180	40	138	10
GTD-0910-12CA	9.10	180	40	138	10
GTD-0920-12CA	9.20	180	40	138	10
GTD-0930-12CA	9.30	180	40	138	10



GTD-12CA

通用加工12D内冷麻花钻

12D inner cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GTD-0940-12CA	9.40	180	40	138	10
GTD-0950-12CA	9.50	180	40	138	10
GTD-0960-12CA	9.60	180	40	138	10
GTD-0970-12CA	9.70	180	40	138	10
GTD-0980-12CA	9.80	180	40	138	10
GTD-0990-12CA	9.90	180	40	138	10
GTD-1000-12CA	10.00	180	40	138	10
GTD-1010-12CA	10.10	206	45	158	12
GTD-1020-12CA	10.20	206	45	158	12
GTD-1030-12CA	10.30	206	45	158	12
GTD-1040-12CA	10.40	206	45	158	12
GTD-1050-12CA	10.50	206	45	158	12
GTD-1060-12CA	10.60	206	45	158	12
GTD-1070-12CA	10.70	206	45	158	12
GTD-1080-12CA	10.80	206	45	158	12
GTD-1090-12CA	10.90	206	45	158	12
GTD-1100-12CA	11.00	206	45	158	12
GTD-1110-12CA	11.10	206	45	158	12
GTD-1120-12CA	11.20	206	45	158	12
GTD-1130-12CA	11.30	206	45	158	12
GTD-1140-12CA	11.40	206	45	158	12
GTD-1150-12CA	11.50	206	45	158	12
GTD-1160-12CA	11.60	206	45	158	12
GTD-1170-12CA	11.70	206	45	158	12
GTD-1180-12CA	11.80	206	45	158	12
GTD-1190-12CA	11.90	206	45	158	12
GTD-1200-12CA	12.00	206	45	158	12

备注：D3-D12刀具接受非标订制
Note: accept non-standard customization from D3 to D12.

尺寸范围 Nominal size range	D(m7)	d(h6)
> 3—6	+0.004/+0.016	0.000/−0.008
> 6—10	+0.006/+0.021	0.000/−0.009
> 10—12	+0.007/+0.025	0.000/−0.011

单位unit(mm)



GXD系列

通用加工麻花钻

GTD series twist drills for general machining



超级多用途钻头采用新型沟槽形状,降低切削阻力和提高钻头强度,可进行优异的切削处理和排屑的整体硬质合金钻头。

Super multi-purpose drill bit adopts new groove shape to reduce cutting resistance and improve drill strength, which can perform excellent cuttingIntegral carbide bit for cutting and chip removal.

通用性强,能实现对钢件、铸铁、不锈钢等多种材料的高效长寿稳定加工。
It has strong versatility and can realize efficient, long-life and stable processing of steel, cast iron, stainless steel and other materials.

J型槽设计,提高机体刚性同时兼具良好的排屑效果。
J-shaped groove design improves the rigidity of the machine body and has good chip removal effect.

圆弧形刃口形状具有良好的切削效果。
The circular edge shape has good cutting effect.

小横刃设计,具有良好的定心与断屑效果。
Small cross blade design, with good centering and chip breaking effect.



GXD-03NA

通用加工3D外冷麻花钻

3D external cooling twist drills for general machining



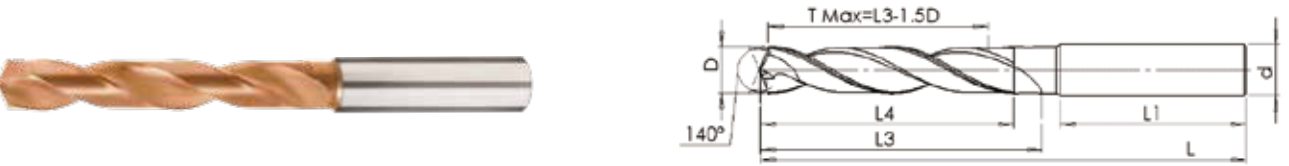
订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GXD-0300-03NA	3.00	62	36	20	6
GXD-0310-03NA	3.10	62	36	20	6
GXD-0320-03NA	3.20	62	36	20	6
GXD-0330-03NA	3.30	62	36	20	6
GXD-0340-03NA	3.40	62	36	20	6
GXD-0350-03NA	3.50	62	36	20	6
GXD-0360-03NA	3.60	62	36	20	6
GXD-0370-03NA	3.70	62	36	20	6
GXD-0380-03NA	3.80	66	36	24	6
GXD-0390-03NA	3.90	66	36	24	6
GXD-0400-03NA	4.00	66	36	24	6
GXD-0410-03NA	4.10	66	36	24	6
GXD-0420-03NA	4.20	66	36	24	6
GXD-0430-03NA	4.30	66	36	24	6
GXD-0440-03NA	4.40	66	36	24	6
GXD-0450-03NA	4.50	66	36	24	6
GXD-0460-03NA	4.60	66	36	24	6
GXD-0470-03NA	4.70	66	36	24	6
GXD-0480-03NA	4.80	66	36	28	6
GXD-0490-03NA	4.90	66	36	28	6
GXD-0500-03NA	5.00	66	36	28	6
GXD-0510-03NA	5.10	66	36	28	6
GXD-0520-03NA	5.20	66	36	28	6
GXD-0530-03NA	5.30	66	36	28	6
GXD-0540-03NA	5.40	66	36	28	6
GXD-0550-03NA	5.50	66	36	28	6
GXD-0560-03NA	5.60	66	36	28	6
GXD-0570-03NA	5.70	66	36	28	6
GXD-0580-03NA	5.80	66	36	28	6
GXD-0590-03NA	5.90	66	36	28	6



GXD-03NA

通用加工3D外冷麻花钻

3D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GXD-0600-03NA	6.00	66	36	28	6
GXD-0610-03NA	6.10	79	36	34	8
GXD-0620-03NA	6.20	79	36	34	8
GXD-0630-03NA	6.30	79	36	34	8
GXD-0640-03NA	6.40	79	36	34	8
GXD-0650-03NA	6.50	79	36	34	8
GXD-0660-03NA	6.60	79	36	34	8
GXD-0670-03NA	6.70	79	36	34	8
GXD-0680-03NA	6.80	79	36	34	8
GXD-0690-03NA	6.90	79	36	34	8
GXD-0700-03NA	7.00	79	36	34	8
GXD-0710-03NA	7.10	79	36	41	8
GXD-0720-03NA	7.20	79	36	41	8
GXD-0730-03NA	7.30	79	36	41	8
GXD-0740-03NA	7.40	79	36	41	8
GXD-0750-03NA	7.50	79	36	41	8
GXD-0760-03NA	7.60	79	36	41	8
GXD-0770-03NA	7.70	79	36	41	8
GXD-0780-03NA	7.80	79	36	41	8
GXD-0790-03NA	7.90	79	36	41	8
GXD-0800-03NA	8.00	79	36	41	8
GXD-0810-03NA	8.10	89	40	47	10
GXD-0820-03NA	8.20	89	40	47	10
GXD-0830-03NA	8.30	89	40	47	10
GXD-0840-03NA	8.40	89	40	47	10
GXD-0850-03NA	8.50	89	40	47	10
GXD-0860-03NA	8.60	89	40	47	10
GXD-0870-03NA	8.70	89	40	47	10
GXD-0880-03NA	8.80	89	40	47	10
GXD-0890-03NA	8.90	89	40	47	10



GXD-03NA

通用加工3D外冷麻花钻

3D external cooling twist drills for general machining



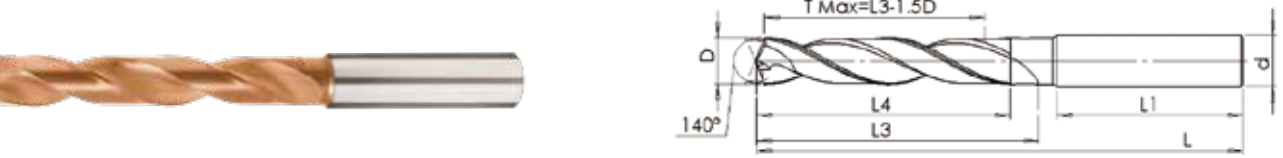
订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GXD-1200-03NA	9.00	89	40	47	10
GXD-1210-03NA	9.10	89	40	47	10
GXD-1220-03NA	9.20	89	40	47	10
GXD-1230-03NA	9.30	89	40	47	10
GXD-1240-03NA	9.40	89	40	47	10
GXD-1250-03NA	9.50	89	40	47	10
GXD-1260-03NA	9.60	89	40	47	10
GXD-1270-03NA	9.70	89	40	47	10
GXD-1280-03NA	9.80	89	40	47	10
GXD-1290-03NA	9.90	89	40	47	10
GXD-1300-03NA	10.00	89	40	47	10
GXD-1310-03NA	10.10	102	45	55	12
GXD-1320-03NA	10.20	102	45	55	12
GXD-1330-03NA	10.30	102	45	55	12
GXD-1340-03NA	10.40	102	45	55	12
GXD-1350-03NA	10.50	102	45	55	12
GXD-1360-03NA	10.60	102	45	55	12
GXD-1370-03NA	10.70	102	45	55	12
GXD-1380-03NA	10.80	102	45	55	12
GXD-1390-03NA	10.90	102	45	55	12
GXD-1400-03NA	11.00	102	45	55	12
GXD-1410-03NA	11.10	102	45	55	12
GXD-1420-03NA	11.20	102	45	55	12
GXD-1430-03NA	11.30	102	45	55	12
GXD-1440-03NA	11.40	102	45	55	12
GXD-1450-03NA	11.50	102	45	55	12
GXD-1460-03NA	11.60	102	45	55	12
GXD-1470-03NA	11.70	102	45	55	12
GXD-1480-03NA	11.80	102	45	55	12
GXD-1490-03NA	11.90	102	45	55	12



GXD-03NA

通用加工3D外冷麻花钻

3D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GXD-1200-03NA	12.00	102	45	55	12
GXD-1210-03NA	12.10	107	45	60	14
GXD-1220-03NA	12.20	107	45	60	14
GXD-1230-03NA	12.30	107	45	60	14
GXD-1240-03NA	12.40	107	45	60	14
GXD-1250-03NA	12.50	107	45	60	14
GXD-1260-03NA	12.60	107	45	60	14
GXD-1270-03NA	12.70	107	45	60	14
GXD-1280-03NA	12.80	107	45	60	14
GXD-1290-03NA	12.90	107	45	60	14
GXD-1300-03NA	13.00	107	45	60	14
GXD-1310-03NA	13.10	107	45	60	14
GXD-1320-03NA	13.20	107	45	60	14
GXD-1330-03NA	13.30	107	45	60	14
GXD-1340-03NA	13.40	107	45	60	14
GXD-1350-03NA	13.50	107	45	60	14
GXD-1360-03NA	13.60	107	45	60	14
GXD-1370-03NA	13.70	107	45	60	14
GXD-1380-03NA	13.80	107	45	60	14
GXD-1390-03NA	13.90	107	45	60	14
GXD-1400-03NA	14.00	107	45	60	14
GXD-1410-03NA	14.10	115	48	65	16
GXD-1420-03NA	14.20	115	48	65	16
GXD-1430-03NA	14.30	115	48	65	16
GXD-1440-03NA	14.40	115	48	65	16
GXD-1450-03NA	14.50	115	48	65	16
GXD-1460-03NA	14.60	115	48	65	16
GXD-1470-03NA	14.70	115	48	65	16
GXD-1480-03NA	14.80	115	48	65	16
GXD-1490-03NA	14.90	115	48	65	16



GXD-03NA

通用加工3D外冷麻花钻

3D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GXD-1500-03NA	15.00	115	48	65	16
GXD-1510-03NA	15.10	115	48	65	16
GXD-1520-03NA	15.20	115	48	65	16
GXD-1530-03NA	15.30	115	48	65	16
GXD-1540-03NA	15.40	115	48	65	16
GXD-1550-03NA	15.50	115	48	65	16
GXD-1560-03NA	15.60	115	48	65	16
GXD-1570-03NA	15.70	115	48	65	16
GXD-1580-03NA	15.80	115	48	65	16
GXD-1590-03NA	15.90	115	48	65	16
GXD-1600-03NA	16.00	115	48	65	16
GXD-1610-03NA	16.10	123	48	73	18
GXD-1620-03NA	16.20	123	48	73	18
GXD-1630-03NA	16.30	123	48	73	18
GXD-1640-03NA	16.40	123	48	73	18
GXD-1650-03NA	16.50	123	48	73	18
GXD-1660-03NA	16.60	123	48	73	18
GXD-1670-03NA	16.70	123	48	73	18
GXD-1680-03NA	16.80	123	48	73	18
GXD-1690-03NA	16.90	123	48	73	18
GXD-1700-03NA	17.00	123	48	73	18
GXD-1710-03NA	17.10	123	48	73	18
GXD-1720-03NA	17.20	123	48	73	18
GXD-1730-03NA	17.30	123	48	73	18
GXD-1740-03NA	17.40	123	48	73	18
GXD-1750-03NA	17.50	123	48	73	18
GXD-1760-03NA	17.60	123	48	73	18
GXD-1770-03NA	17.70	123	48	73	18
GXD-1780-03NA	17.80	123	48	73	18
GXD-1790-03NA	17.90	123	48	73	18



GXD-03NA

通用加工3D外冷麻花钻

3D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GXD-1800-03NA	18.00	123	48	73	18
GXD-1810-03NA	18.10	131	50	79	20
GXD-1820-03NA	18.20	131	50	79	20
GXD-1830-03NA	18.30	131	50	79	20
GXD-1840-03NA	18.40	131	50	79	20
GXD-1850-03NA	18.50	131	50	79	20
GXD-1860-03NA	18.60	131	50	79	20
GXD-1870-03NA	18.70	131	50	79	20
GXD-1880-03NA	18.80	131	50	79	20
GXD-1890-03NA	18.90	131	50	79	20
GXD-1900-03NA	19.00	131	50	79	20
GXD-1910-03NA	19.10	131	50	79	20
GXD-1920-03NA	19.20	131	50	79	20
GXD-1930-03NA	19.30	131	50	79	20
GXD-1940-03NA	19.40	131	50	79	20
GXD-1950-03NA	19.50	131	50	79	20
GXD-1960-03NA	19.60	131	50	79	20
GXD-1970-03NA	19.70	131	50	79	20
GXD-1980-03NA	19.80	131	50	79	20
GXD-1990-03NA	19.90	131	50	79	20
GXD-2000-03NA	20.00	131	50	79	20

备注：D3-D20刀具接受非标订制
Note: accept non-standard customization from D3 to D20.

尺寸范围 Nominal size range	D(m7)	d(h6)
> 3—6	+0.004/+0.016	0.000/−0.008
> 6—10	+0.006/+0.021	0.000/−0.009
> 10—18	+0.007/+0.025	0.000/−0.011
> 18—20	+0.008/+0.029	0.000/−0.013

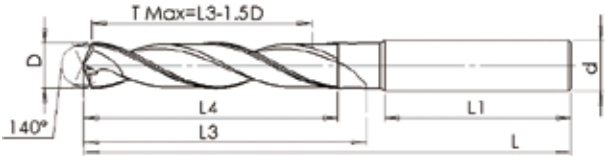
单位unit(mm)



GXD-05NA

通用加工5D外冷麻花钻

5D external cooling twist drills for general machining



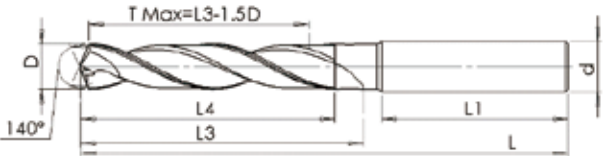
订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GXD-0300-05NA	3.00	66	36	28	6
GXD-0310-05NA	3.10	66	36	28	6
GXD-0320-05NA	3.20	66	36	28	6
GXD-0330-05NA	3.30	66	36	28	6
GXD-0340-05NA	3.40	66	36	28	6
GXD-0350-05NA	3.50	66	36	28	6
GXD-0360-05NA	3.60	66	36	28	6
GXD-0370-05NA	3.70	66	36	28	6
GXD-0380-05NA	3.80	74	36	36	6
GXD-0390-05NA	3.90	74	36	36	6
GXD-0400-05NA	4.00	74	36	36	6
GXD-0410-05NA	4.10	74	36	36	6
GXD-0420-05NA	4.20	74	36	36	6
GXD-0430-05NA	4.30	74	36	36	6
GXD-0440-05NA	4.40	74	36	36	6
GXD-0450-05NA	4.50	74	36	36	6
GXD-0460-05NA	4.60	74	36	36	6
GXD-0470-05NA	4.70	74	36	36	6
GXD-0480-05NA	4.80	82	36	44	6
GXD-0490-05NA	4.90	82	36	44	6
GXD-0500-05NA	5.00	82	36	44	6
GXD-0510-05NA	5.10	82	36	44	6
GXD-0520-05NA	5.20	82	36	44	6
GXD-0530-05NA	5.30	82	36	44	6
GXD-0540-05NA	5.40	82	36	44	6
GXD-0550-05NA	5.50	82	36	44	6
GXD-0560-05NA	5.60	82	36	44	6
GXD-0570-05NA	5.70	82	36	44	6
GXD-0580-05NA	5.80	82	36	44	6
GXD-0590-05NA	5.90	82	36	44	6



GXD-05NA

通用加工5D外冷麻花钻

5D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GXD-0600-05NA	6.00	82	36	44	6
GXD-0610-05NA	6.10	91	36	53	8
GXD-0620-05NA	6.20	91	36	53	8
GXD-0630-05NA	6.30	91	36	53	8
GXD-0640-05NA	6.40	91	36	53	8
GXD-0650-05NA	6.50	91	36	53	8
GXD-0660-05NA	6.60	91	36	53	8
GXD-0670-05NA	6.70	91	36	53	8
GXD-0680-05NA	6.80	91	36	53	8
GXD-0690-05NA	6.90	91	36	53	8
GXD-0700-05NA	7.00	91	36	53	8
GXD-0710-05NA	7.10	91	36	53	8
GXD-0720-05NA	7.20	91	36	53	8
GXD-0730-05NA	7.30	91	36	53	8
GXD-0740-05NA	7.40	91	36	53	8
GXD-0750-05NA	7.50	91	36	53	8
GXD-0760-05NA	7.60	91	36	53	8
GXD-0770-05NA	7.70	91	36	53	8
GXD-0780-05NA	7.80	91	36	53	8
GXD-0790-05NA	7.90	91	36	53	8
GXD-0800-05NA	8.00	91	36	53	8
GXD-0810-05NA	8.10	103	40	61	10
GXD-0820-05NA	8.20	103	40	61	10
GXD-0830-05NA	8.30	103	40	61	10
GXD-0840-05NA	8.40	103	40	61	10
GXD-0850-05NA	8.50	103	40	61	10
GXD-0860-05NA	8.60	103	40	61	10
GXD-0870-05NA	8.70	103	40	61	10
GXD-0880-05NA	8.80	103	40	61	10
GXD-0890-05NA	8.90	103	40	61	10



GXD-05NA

通用加工5D外冷麻花钻

5D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GXD-0900-05NA	9.00	103	40	61	10
GXD-0910-05NA	9.10	103	40	61	10
GXD-0920-05NA	9.20	103	40	61	10
GXD-0930-05NA	9.30	103	40	61	10
GXD-0940-05NA	9.40	103	40	61	10
GXD-0950-05NA	9.50	103	40	61	10
GXD-0960-05NA	9.60	103	40	61	10
GXD-0970-05NA	9.70	103	40	61	10
GXD-0980-05NA	9.80	103	40	61	10
GXD-0990-05NA	9.90	103	40	61	10
GXD-1000-05NA	10.00	103	40	61	10
GXD-1010-05NA	10.10	118	45	71	12
GXD-1020-05NA	10.20	118	45	71	12
GXD-1030-05NA	10.30	118	45	71	12
GXD-1040-05NA	10.40	118	45	71	12
GXD-1050-05NA	10.50	118	45	71	12
GXD-1060-05NA	10.60	118	45	71	12
GXD-1070-05NA	10.70	118	45	71	12
GXD-1080-05NA	10.80	118	45	71	12
GXD-1090-05NA	10.90	118	45	71	12
GXD-1100-05NA	11.00	118	45	71	12
GXD-1110-05NA	11.10	118	45	71	12
GXD-1120-05NA	11.20	118	45	71	12
GXD-1130-05NA	11.30	118	45	71	12
GXD-1140-05NA	11.40	118	45	71	12
GXD-1150-05NA	11.50	118	45	71	12
GXD-1160-05NA	11.60	118	45	71	12
GXD-1170-05NA	11.70	118	45	71	12
GXD-1180-05NA	11.80	118	45	71	12
GXD-1190-05NA	11.90	118	45	71	12



GXD-05NA

通用加工5D外冷麻花钻

5D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GXD-1200-05NA	12.00	118	45	71	12
GXD-1210-05NA	12.10	124	45	77	14
GXD-1220-05NA	12.20	124	45	77	14
GXD-1230-05NA	12.30	124	45	77	14
GXD-1240-05NA	12.40	124	45	77	14
GXD-1250-05NA	12.50	124	45	77	14
GXD-1260-05NA	12.60	124	45	77	14
GXD-1270-05NA	12.70	124	45	77	14
GXD-1280-05NA	12.80	124	45	77	14
GXD-1290-05NA	12.90	124	45	77	14
GXD-1300-05NA	13.00	124	45	77	14
GXD-1310-05NA	13.10	124	45	77	14
GXD-1320-05NA	13.20	124	45	77	14
GXD-1330-05NA	13.30	124	45	77	14
GXD-1340-05NA	13.40	124	45	77	14
GXD-1350-05NA	13.50	124	45	77	14
GXD-1360-05NA	13.60	124	45	77	14
GXD-1370-05NA	13.70	124	45	77	14
GXD-1380-05NA	13.80	124	45	77	14
GXD-1390-05NA	13.90	124	45	77	14
GXD-1400-05NA	14.00	124	45	77	14
GXD-1410-05NA	14.10	133	48	83	16
GXD-1420-05NA	14.20	133	48	83	16
GXD-1430-05NA	14.30	133	48	83	16
GXD-1440-05NA	14.40	133	48	83	16
GXD-1450-05NA	14.50	133	48	83	16
GXD-1460-05NA	14.60	133	48	83	16
GXD-1470-05NA	14.70	133	48	83	16
GXD-1480-05NA	14.80	133	48	83	16
GXD-1490-05NA	14.90	133	48	83	16



GXD-05NA

通用加工5D外冷麻花钻

5D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GXD-1500-05NA	15.00	133	48	83	16
GXD-1510-05NA	15.10	133	48	83	16
GXD-1520-05NA	15.20	133	48	83	16
GXD-1530-05NA	15.30	133	48	83	16
GXD-1540-05NA	15.40	133	48	83	16
GXD-1550-05NA	15.50	133	48	83	16
GXD-1560-05NA	15.60	133	48	83	16
GXD-1570-05NA	15.70	133	48	83	16
GXD-1580-05NA	15.80	133	48	83	16
GXD-1590-05NA	15.90	133	48	83	16
GXD-1600-05NA	16.00	133	48	83	16
GXD-1610-05NA	16.10	143	48	93	18
GXD-1620-05NA	16.20	143	48	93	18
GXD-1630-05NA	16.30	143	48	93	18
GXD-1640-05NA	16.40	143	48	93	18
GXD-1650-05NA	16.50	143	48	93	18
GXD-1660-05NA	16.60	143	48	93	18
GXD-1670-05NA	16.70	143	48	93	18
GXD-1680-05NA	16.80	143	48	93	18
GXD-1690-05NA	16.90	143	48	93	18
GXD-1700-05NA	17.00	143	48	93	18
GXD-1710-05NA	17.10	143	48	93	18
GXD-1720-05NA	17.20	143	48	93	18
GXD-1730-05NA	17.30	143	48	93	18
GXD-1740-05NA	17.40	143	48	93	18
GXD-1750-05NA	17.50	143	48	93	18
GXD-1760-05NA	17.60	143	48	93	18
GXD-1770-05NA	17.70	143	48	93	18
GXD-1780-05NA	17.80	143	48	93	18
GXD-1790-05NA	17.90	143	48	93	18



GXD-05NA

通用加工5D外冷麻花钻

5D external cooling twist drills for general machining



订货号 Ordering Code	直径(D) Dia.(D)	全长(L) Total length (L)	柄长(L1) Shank length (L1)	槽长(L3) Groove length (L3)	柄径(h6) Shank dia. (h6)
GXD-1800-05NA	18.00	143	48	93	18
GXD-1810-05NA	18.10	153	50	101	20
GXD-1820-05NA	18.20	153	50	101	20
GXD-1830-05NA	18.30	153	50	101	20
GXD-1840-05NA	18.40	153	50	101	20
GXD-1850-05NA	18.50	153	50	101	20
GXD-1860-05NA	18.60	153	50	101	20
GXD-1870-05NA	18.70	153	50	101	20
GXD-1880-05NA	18.80	153	50	101	20
GXD-1890-05NA	18.90	153	50	101	20
GXD-1900-05NA	19.00	153	50	101	20
GXD-1910-05NA	19.10	153	50	101	20
GXD-1920-05NA	19.20	153	50	101	20
GXD-1930-05NA	19.30	153	50	101	20
GXD-1940-05NA	19.40	153	50	101	20
GXD-1950-05NA	19.50	153	50	101	20
GXD-1960-05NA	19.60	153	50	101	20
GXD-1970-05NA	19.70	153	50	101	20
GXD-1980-05NA	19.80	153	50	101	20
GXD-1990-05NA	19.90	153	50	101	20
GXD-2000-05NA	20.00	153	50	101	20

备注：D3–D20刀具接受非标订制
Note: accept non–standard customization from D3 to D20.

尺寸范围 Nominal size range	D(m7)	d(h6)
> 3—6	+0.004/+0.016	0.000/–0.008
> 6—10	+0.006/+0.021	0.000/–0.009
> 10—18	+0.007/+0.025	0.000/–0.011
> 18—20	+0.008/+0.029	0.000/–0.013

单位unit(mm)



推荐参数表

Recommended cutting data

GTD/GXD系列通用加工3D/5D麻花钻 GTD/GXD 3D/5D twist drills for general machining														
加工材料 Workpiece material		线速Vc (m/min)		进给Fn (mm/rev)			进给Fn (mm/rev)							
				D3	D4		D6	D8	D10	D12	D14	D16	D18	D20
	低碳钢≤125HB Low-carbon steels (< 125HB)	50 ~ 120	60 ~ 140	0.10 ~ 0.20	0.10 ~ 0.20		0.15 ~ 0.25	0.16 ~ 0.32	0.16 ~ 0.32	0.18 ~ 0.40	0.22 ~ 0.45	0.22 ~ 0.45	0.25 ~ 0.50	0.25 ~ 0.50
	中碳钢、高碳钢≤25HRC High-carbon steels, midium-carbon steels (< 25HRC)	45 ~ 120	60 ~ 120	0.10 ~ 0.20	0.10 ~ 0.20		0.15 ~ 0.25	0.16 ~ 0.32	0.16 ~ 0.32	0.18 ~ 0.40	0.22 ~ 0.45	0.22 ~ 0.45	0.25 ~ 0.50	0.25 ~ 0.50
	合金钢、工具钢≤35HRC Alloy steels, tool steels. (< 35HRC)	45 ~ 100	60 ~ 110	0.09 ~ 0.16	0.09 ~ 0.16		0.12 ~ 0.23	0.14 ~ 0.28	0.14 ~ 0.30	0.15 ~ 0.34	0.18 ~ 0.38	0.18 ~ 0.38	0.20 ~ 0.40	0.20 ~ 0.40
	合金钢、工具钢35~48HRC Alloy steels, tool steels. (35~48HRC)	35 ~ 80	35 ~ 90	0.08 ~ 0.14	0.08 ~ 0.14		0.08 ~ 0.20	0.09 ~ 0.25	0.09 ~ 0.28	0.11 ~ 0.30	0.12 ~ 0.32	0.12 ~ 0.32	0.14 ~ 0.34	0.14 ~ 0.34
	铁素体、马氏体钢≤35HRC PH and ferrite/martensitic steels (< 35HRC)	30 ~ 70	30 ~ 90	0.05 ~ 0.11	0.05 ~ 0.11		0.07 ~ 0.17	0.08 ~ 0.20	0.08 ~ 0.23	0.10 ~ 0.28	0.12 ~ 0.30	0.12 ~ 0.30	0.14 ~ 0.32	0.14 ~ 0.32
	铁素体、马氏体钢35~48HRC Ferrite/martensitic steels (35~48HRC)	25 ~ 70	30 ~ 80	0.04 ~ 0.08	0.04 ~ 0.08		0.06 ~ 0.14	0.08 ~ 0.18	0.08 ~ 0.20	0.10 ~ 0.28	0.12 ~ 0.30	0.12 ~ 0.30	0.14 ~ 0.32	0.14 ~ 0.32
	奥氏体不锈钢130~200HB Austenitic stainless steels(130~ 200HB)	40 ~ 60	40 ~ 60	0.04 ~ 0.08	0.04 ~ 0.08		0.06 ~ 0.12	0.06 ~ 0.12	0.08 ~ 0.16	0.10 ~ 0.24	0.10 ~ 0.24	0.10 ~ 0.20	0.12 ~ 0.20	0.12 ~ 0.20
	双相不锈钢≤30HRC Duplex stainless steels (<30HRC)	30 ~ 50	30 ~ 50	0.04 ~ 0.08	0.04 ~ 0.08		0.06 ~ 0.10	0.06 ~ 0.10	0.08 ~ 0.12	0.10 ~ 0.20	0.10 ~ 0.20	0.10 ~ 0.16	0.12 ~ 0.16	0.12 ~ 0.16
	灰铸铁≤32HRC Grey cast iron(< 32HRC)	60 ~ 140	60 ~ 160	0.13 ~ 0.20	0.13 ~ 0.20		0.17 ~ 0.30	0.20 ~ 0.35	0.23 ~ 0.40	0.25 ~ 0.45	0.28 ~ 0.48	0.30 ~ 0.50	0.32 ~ 0.52	0.35 ~ 0.55
	合金铸铁、球墨铸铁≤28HRC Alloy cast iron, nodular cast iron (< 28HRC)	60 ~ 120	60 ~ 140	0.11 ~ 0.18	0.11 ~ 0.18		0.15 ~ 0.25	0.17 ~ 0.32	0.20 ~ 0.36	0.22 ~ 0.42	0.24 ~ 0.45	0.25 ~ 0.48	0.28 ~ 0.48	0.30 ~ 0.50
	合金铸铁、球墨铸铁28~45HRC Alloy cast iron, nodular cast iron (28~45HRC)	50 ~ 100	50 ~ 100	0.06 ~ 0.11	0.06 ~ 0.11		0.10 ~ 0.16	0.12 ~ 0.20	0.14 ~ 0.26	0.16 ~ 0.28	0.18 ~ 0.30	0.20 ~ 0.32	0.22 ~ 0.34	0.25 ~ 0.35



推荐参数表

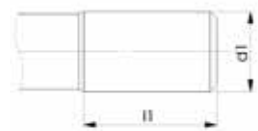
Recommended cutting data

GTD系列通用加工8D/12D麻花钻											
加工材料 Workpiece material		线速Vc (m/min)	进给Fn (mm/rev)			进给Fn (mm/rev)					
			D3	D4		D6	D8	D10	D12	D14	D16
	低碳钢≤125HB Low-carbon steels < 125HB	60 ~ 140	0.10 ~ 0.20	0.10 ~ 0.20		0.14 ~ 0.25	0.16 ~ 0.32	0.16 ~ 0.35	0.18 ~ 0.40	0.22 ~ 0.45	0.22 ~ 0.45
	中碳钢、高碳钢≤25HRC High-carbon steels, midium carbon steels < 25HRC	60 ~ 120	0.10 ~ 0.20	0.10 ~ 0.20		0.14 ~ 0.25	0.16 ~ 0.30	0.16 ~ 0.32	0.18 ~ 0.38	0.22 ~ 0.45	0.22 ~ 0.45
	合金钢、工具钢≤35HRC Alloy steels, tool steels < 35HRC	60 ~ 110	0.09 ~ 0.16	0.09 ~ 0.16		0.12 ~ 0.23	0.14 ~ 0.28	0.14 ~ 0.30	0.15 ~ 0.34	0.18 ~ 0.38	0.18 ~ 0.38
	合金钢、工具钢35~48HRC Alloy steels, tool steels 35~48HRC	35 ~ 90	0.08 ~ 0.14	0.08 ~ 0.14		0.08 ~ 0.20	0.09 ~ 0.25	0.09 ~ 0.28	0.11 ~ 0.30	0.12 ~ 0.32	0.12 ~ 0.32
	铁素体、马氏体钢≤35HRC PH and ferrite/martensitic steels < 35HRC	30 ~ 90	0.05 ~ 0.11	0.05 ~ 0.11		0.07 ~ 0.17	0.08 ~ 0.20	0.08 ~ 0.23	0.10 ~ 0.28	0.12 ~ 0.30	0.12 ~ 0.30
	铁素体、马氏体钢35~48HRC Ferrite/martensitic steels 35~48HRC	30 ~ 80	0.04 ~ 0.08	0.04 ~ 0.08		0.06 ~ 0.14	0.08 ~ 0.18	0.08 ~ 0.20	0.10 ~ 0.28	0.12 ~ 0.30	0.12 ~ 0.30
	奥氏体不锈钢130~200HB austenitic stainless steels 130~ 200HB	40 ~ 60	0.04 ~ 0.10	0.04 ~ 0.10		0.06 ~ 0.12	0.06 ~ 0.12	0.08 ~ 0.16	0.08 ~ 0.16	0.10 ~ 0.18	0.10 ~ 0.18
	双相不锈钢≤30HRC Duplex stainless steels <30HRC	30 ~ 50	0.04 ~ 0.08	0.04 ~ 0.08		0.06 ~ 0.10	0.06 ~ 0.10	0.08 ~ 0.12	0.08 ~ 0.12	0.10 ~ 0.14	0.10 ~ 0.14
	灰铸铁≤32HRC Grey cast iron < 32HRC	60 ~ 160	0.13 ~ 0.20	0.15 ~ 0.23		0.17 ~ 0.30	0.20 ~ 0.35	0.23 ~ 0.40	0.25 ~ 0.45	0.28 ~ 0.48	0.30 ~ 0.50
	合金铸铁、球墨铸铁≤28HRC Alloy cast iron, nodular cast iron < 28HRC	60 ~ 140	0.11 ~ 0.18	0.13 ~ 0.20		0.15 ~ 0.25	0.17 ~ 0.32	0.20 ~ 0.36	0.22 ~ 0.42	0.24 ~ 0.45	0.25 ~ 0.48
	合金铸铁、球墨铸铁28~45HRC Alloy cast iron, nodular cast iron 28~45HRC	50 ~ 100	0.06 ~ 0.11	0.08 ~ 0.13		0.10 ~ 0.16	0.12 ~ 0.20	0.14 ~ 0.26	0.16 ~ 0.28	0.18 ~ 0.30	0.20 ~ 0.32



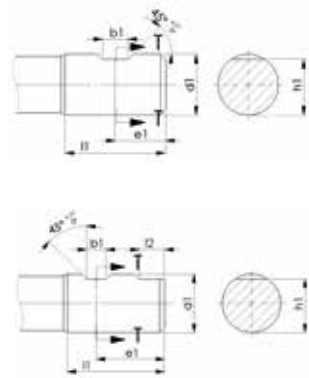
柄部标准-DIN标准
Shank standard - DIN Standard

DIN6535-HA



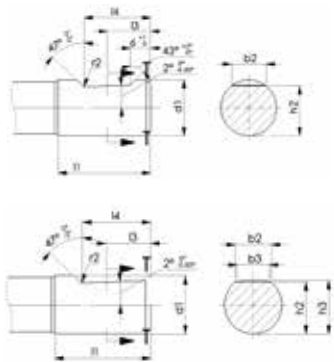
d1h6	2	3	4	5	6	8	10	12	14	16	18	20	25	32
11	⁺² ₀	28			36		40	45		48	55	56	60	

DIN6535-HB



d1h6	b1	^{+0.05} ₀	e1	⁰ ₋₁	h1h11	11	⁺² ₀	12	⁺¹ ₀
6	4.2		18		5.1	36			
8	5.5		18		6.9	36			
10	7		20		8.5	40			
12	8		22.5		10.4	45			
14	8		22.5		12.7	45			
16	10		24		14.2	48			
18	10		24		16.2	48			
20	11		25		18.2	50			
25	12		32		23	56		17	
32	14		36		30	60		19	

柄部标准 The structure of shank



d1	b2	b3	b2	h3	l1	l3	l4	r2
6	4.3		4.3		36	18	25	1.2
8	4.5		4.5		36	18	25	1.2
10	7.1		7.1		40	20	28	1.2
12	8.2		8.2		45	22.5	33	1.2
14	8.1		8.1		45	22.5	33	1.2
16	10.1		10.1		48	24	36	1.6
18	10.8		10.8		48	24	36	1.6
20	11.4		11.4		50	25	38	1.6
25	13.6	9.3	13.6	24.1	56	32	44	1.6
32	15.5	9.9	15.5	31.2	60	35	48	1.6



切削定义及计算
Cutting definitions and calculations

常用参数及其单位 Parameter and Unit			
D	钻头直径 Diameter	(mm)	Fn 每转进给量 Feed per Revolution (mm/rev)
ap	切削深度 Cutting Depth	(mm)	fz 每刃进给量 Feeding per Teeth (mm/tooth)
ae	切削宽度 Cuting Width	(mm)	Z 刀刃数 Number of Teeth
Vf	进给速度 Feed Rate	(mm/min)	n 主轴转速 Spindle Speed(rev/min)
Vc	切削速度 Cutting Speed	(m/min)	L 工作台总进给长度Length(mm)
Q	金属切削率 Rate of Metal Removal (cm³/min)		Tc 加工时间Processing Time(min)

通用计算公式 General Formula			
N	主轴转速 Spindle Speed	$n = \frac{V_c \cdot 1000}{\pi \cdot D}$	(rev/min)
Vc	切速度 Cutting Speed	$V_c = \frac{\pi \cdot D \cdot n}{1000}$	(m/min)
Vf	进给速度 Feed Rate	$V_f = f_z \cdot z \cdot n$	(mm/min)
fz	每刃进给量 Feed per Teeth	$f_z = \frac{V_f}{z \cdot n}$	(mm)
Q	金属切削率 Rate of Metal Removal	$Q = \frac{a_e \cdot a_p \cdot V_f}{1000}$	(cm³/min)
T	加工时间Processing Time	$T_c = \frac{L}{V_f}$	(min)

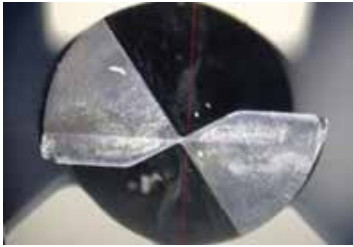
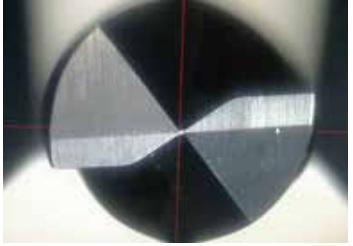


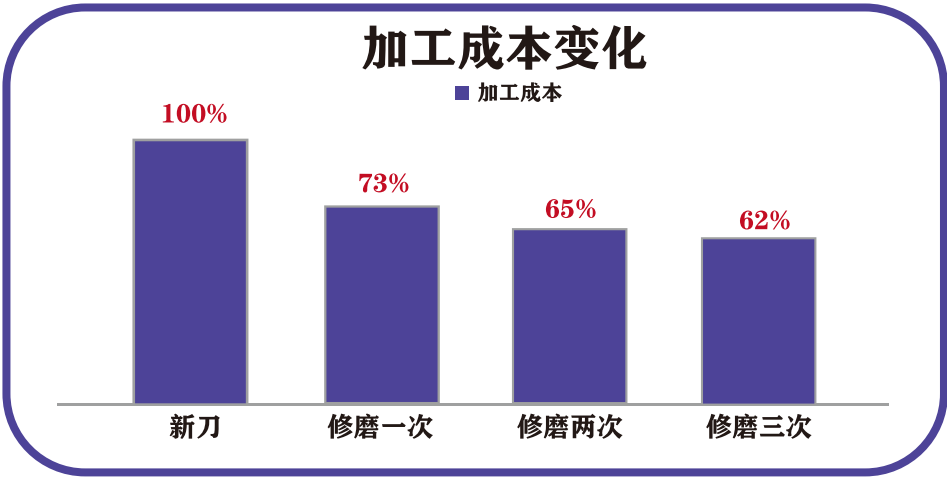
刀具修磨服务

Tool regrinding service

鸿鹭联创竭诚为您提供刀具修磨服务。我们采用先进的修磨设备、成熟的修磨工艺，制造过程严格管控产品质量。经过鸿鹭联创修磨的钻头，产品一致性好。根据终端使用情况反馈，修磨三次预计可为您节省刀具成本38%左右，刀具成本大大降低。如需修磨，请联系就近的厦门鸿鹭联创代理商。

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	周刃 Side flute	底刃 End flute
修磨前 Before regrind		
修磨后 After regrind		



MEMO