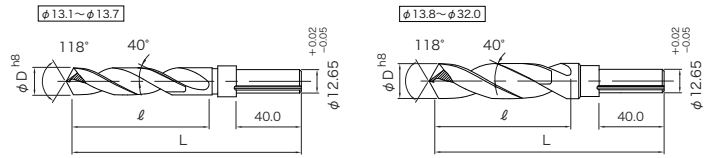




Shank : 13mm (1/2) Type

(X-THINNING TYPE)



Unit : mm

Code	Drill Dia. (Dc)	Flute Length (ℓ)	Overall Length (L)	Price (Yen)
YK07277	13.1	74	134	7,630
YK07278	13.2	74	134	7,630
YK07279	13.3	74	134	7,630
YK07280	13.4	74	134	7,630
YK07281	13.5	74	134	6,880
YK07282	13.6	74	134	7,800
YK07283	13.7	74	134	7,800
YK07284	13.8	74	134	7,800
YK07285	13.9	74	134	7,800
YK07286	14.0	74	134	6,720
YK07287	14.1	74	134	8,370
YK07288	14.2	74	134	8,370
YK07289	14.3	74	134	8,370
YK07290	14.4	74	134	8,370
YK07291	14.5	74	134	7,580
YK07292	14.6	74	134	8,670
YK07293	14.7	74	134	8,670
YK07294	14.8	74	134	8,670
YK07295	14.9	74	134	8,670
YK07296	15.0	74	134	7,670
YK07297	15.1	74	134	9,120
YK07298	15.2	74	134	9,120
YK07299	15.3	74	134	9,120
YK07300	15.4	74	134	9,120
YK07301	15.5	74	134	8,130
YK07302	15.6	74	134	9,300
YK07303	15.7	74	134	9,300
YK07304	15.8	74	134	9,300
YK07305	15.9	74	134	9,300
YK07306	16.0	74	134	8,370
YK07307	16.1	74	134	9,980
YK07308	16.2	74	134	9,980
YK07309	16.3	74	134	9,980
YK07310	16.4	74	134	9,980
YK07311	16.5	74	134	8,920
YK07312	16.6	74	134	10,470
YK07313	16.7	74	134	10,470
YK07314	16.8	74	134	10,470
YK07315	16.9	74	134	10,470
YK07316	17.0	74	134	9,500
YK07317	17.1	74	134	11,230
YK07318	17.2	74	134	11,230
YK07319	17.3	74	134	11,230
YK07320	17.4	74	134	11,230
YK07321	17.5	74	134	10,130
YK07322	17.6	74	134	11,500
YK07323	17.7	74	134	11,500

Code	Drill Dia. (Dc)	Flute Length (ℓ)	Overall Length (L)	Price (Yen)
YK07324	17.8	74	134	11,500
YK07325	17.9	74	134	11,500
YK07326	18.0	74	134	10,530
YK07327	18.1	74	134	12,220
YK07328	18.2	74	134	12,220
YK07329	18.3	74	134	12,220
YK07330	18.4	74	134	12,220
YK07331	18.5	74	134	11,030
YK07332	18.6	74	134	12,630
YK07333	18.7	74	134	12,630
YK07334	18.8	74	134	12,630
YK07335	18.9	74	134	12,630
YK07336	19.0	74	134	11,500
YK07337	19.1	74	134	13,330
YK07338	19.2	74	134	13,330
YK07339	19.3	74	134	13,330
YK07340	19.4	74	134	13,330
YK07341	19.5	74	134	11,920
YK07342	19.6	74	134	14,380
YK07343	19.7	74	134	14,380
YK07344	19.8	74	134	14,380
YK07345	19.9	74	134	14,380
YK07346	20.0	74	134	12,800
YK07347	20.5	74	134	13,900
YK07348	21.0	74	134	13,870
YK07349	21.5	74	134	16,070
YK07350	22.0	74	134	16,030
YK07351	22.5	74	134	17,000
YK07352	23.0	74	134	16,250
YK07353	23.5	74	134	17,970
YK07354	24.0	74	134	17,150
YK07355	24.5	74	134	20,870
YK07356	25.0	74	134	20,820
YK07357	25.5	74	134	22,230
YK07358	26.0	74	134	22,200
YK07359	26.5	74	134	23,550
YK07360	27.0	74	134	23,500
YK07361	27.5	74	134	26,250
YK07362	28.0	74	134	26,220
YK07363	28.5	74	134	29,030
YK07364	29.0	74	134	28,980
YK07365	29.5	74	134	30,380
YK07366	30.0	74	134	30,370
YK07367	30.5	74	134	36,220
YK07368	31.0	74	134	36,170
YK07369	31.5	74	134	45,080
YK07370	32.0	74	134	45,050

RECOMMENDED CUTTING CONDITIONS

Work Material	CARBON STEELS ~ 570 N/mm2		CARBON STEELS ~ HRC23 ~ 830 N/mm2		CARBON STEELS HRC23 ~ 28 830 ~ 950 N/mm2	
	28 ~ 34 m/min		20 ~ 25 m/min		15 ~ 20 m/min	
	RPM	Feed rate	RPM	Feed rate	RPM	Feed rate
Drill Dia. (mm)	min-1	mm/rev	min-1	mm/rev	min-1	mm/rev
13	785	0.17	575	0.17	445	0.09
14	720	0.18	530	0.18	410	0.10
16	635	0.20	475	0.20	365	0.11
18	550	0.22	420	0.22	320	0.12
20	500	0.23	380	0.23	290	0.13
22	450	0.24	340	0.24	260	0.14
24	420	0.25	320	0.25	240	0.15
26	390	0.26	300	0.26	220	0.16
28	360	0.27	275	0.27	205	0.17
30	330	0.28	250	0.28	190	0.18

Work Material	ALLOY STEELS HRC23 ~ 34 830 ~ 1110 N/mm2		ALLOY STEELS HRC34 ~ 38 1110 ~ 1260 N/mm2		STAINLESS STEELS HRC23 830 N/mm2		CAST IRON HRC21 800 N/mm2	
	20 ~ 25 m/min		10 ~ 15 m/min		28 ~ 34 m/min		28 ~ 34 m/min	
	RPM	Feed rate	RPM	Feed rate	RPM	Feed rate	RPM	Feed rate
Drill Dia. (mm)	min-1	mm/rev	min-1	mm/rev	min-1	mm/rev	min-1	mm/rev
13	540	0.20	325	0.05	785	0.17	785	0.17
14	500	0.20	300	0.05	720	0.18	720	0.18
16	445	0.22	265	0.05	635	0.20	635	0.20
18	390	0.23	230	0.05	550	0.22	550	0.22
20	355	0.23	210	0.06	500	0.23	500	0.23
22	320	0.23	190	0.06	450	0.24	450	0.24
24	295	0.23	175	0.07	420	0.25	420	0.25
26	270	0.23	160	0.07	390	0.26	390	0.26
28	250	0.23	150	0.07	360	0.27	360	0.27
30	230	0.23	140	0.08	330	0.28	330	0.28