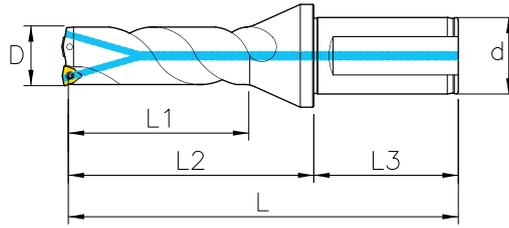


B5S-3D 드릴 U-DRILL

특허 제 10-0838176
Patent #10-0838176



초경용접
Carbide welding



• INSERTS ⇒ I.S.O

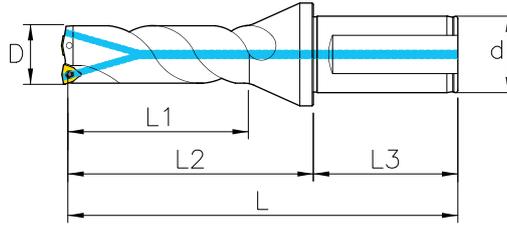
Order No. 주문형번	Dimension (mm)				Shank					Price
	D	L	L1	L2	d	L3				
B5S-3130-S20	13	106	42	56	20	50	WCGX 03T104	TSB-18045	TXL-06	124,000
B5S-3135-S20	13.5	106	42	56	20	50				124,000
B5S-3140-S20	14	110	45	60	20	50				124,000
B5S-3145-S20	14.5	110	45	60	20	50				124,000
B5S-3150-S20	15	114	48	64	20	50				124,000
B5S-3155-S20	15.5	114	48	64	20	50	WCMT 030204	TSB-22060	TXL-06	124,000
B5S-3160-S25	16	123	51	67	25	56				112,000
B5S-3165-S25	16.5	123	51	67	25	56				112,000
B5S-3170-S25	17	126	54	70	25	56				112,000
B5S-3175-S25	17.5	126	54	70	25	56				112,000
B5S-3180-S25	18	130	57	74	25	56				112,000
B5S-3185-S25	18.5	130	57	74	25	56				112,000
B5S-3190-S25	19	133	60	77	25	56				112,000
B5S-3195-S25	19.5	133	60	77	25	56				112,000
B5S-3200-S25	20	138	63	82	25	56				112,000
B5S-3205-S25	20.5	138	63	82	25	56	WCMT 040204	TSB-25065	TXL-07	112,000
B5S-3210-S25	21	141	66	85	25	56				117,000
B5S-3215-S25	21.5	141	66	85	25	56				117,000
B5S-3220-S25	22	144	69	88	25	56				117,000
B5S-3225-S25	22.5	144	69	88	25	56				117,000
B5S-3230-S25	23	149	72	93	25	56				117,000
B5S-3235-S25	23.5	149	72	93	25	56				117,000
B5S-3230-S32	23	153	72	93	32	60				117,000
B5S-3240-S25	24	152	75	96	25	56				117,000
B5S-3245-S25	24.5	152	75	96	25	56				117,000
B5S-3240-S32	24	156	75	96	32	60				117,000
B5S-3250-S25	25	156	78	100	25	56				117,000
B5S-3255-S25	25.5	156	78	100	25	56				117,000
B5S-3250-S32	25	160	78	100	32	60				117,000
B5S-3255-S32	25.5	160	78	100	32	60				117,000

B5S-3D 드릴 U-DRILL

특허 제 10-0838176
Patent #10-0838176



초경용접
Carbide welding



• INSERTS ⇒ I.S.O

Order No. 주문형번	Dimension (mm)				Shank		Insert	Screw	Flute	Price
	D	L	L1	L2	d	L3				
B5S-3260-S32	26	163	81	103	32	60	WCMT 050308	TSB-0307	TXL-09	132,000
B5S-3265-S32	26.5	163	81	103	32	60				132,000
B5S-3270-S32	27	167	84	107	32	60				132,000
B5S-3275-S32	27.5	167	84	107	32	60				132,000
B5S-3280-S32	28	171	87	111	32	60				132,000
B5S-3285-S32	28.5	171	87	111	32	60				132,000
B5S-3290-S32	29	174	90	114	32	60				132,000
B5S-3295-S32	29.5	174	90	114	32	60				132,000
B5S-3300-S32	30	179	93	119	32	60				132,000
B5S-3310-S32	31	182	96	122	32	60				141,000
B5S-3320-S32	32	185	99	125	32	60	141,000			
B5S-3330-S32	33	191	103	131	32	60	141,000			
B5S-3330-S40	33	201	103	131	40	70	141,000			
B5S-3340-S32	34	194	106	134	32	60	141,000			
B5S-3340-S40	34	204	106	134	40	70	141,000			
B5S-3350-S32	35	197	109	137	32	60	141,000			
B5S-3350-S40	35	207	109	137	40	70	141,000			
B5S-3360-S32	36	201	112	141	32	60	154,000			
B5S-3360-S40	36	211	112	141	40	70	154,000			
B5S-3370-S32	37	204	115	144	32	60	154,000			
B5S-3370-S40	37	214	115	144	40	70	154,000			
B5S-3380-S32	38	208	118	148	32	60	154,000			
B5S-3380-S40	38	218	118	148	40	70	154,000			
B5S-3390-S32	39	211	121	151	32	60	154,000			
B5S-3390-S40	39	221	121	151	40	70	154,000			
B5S-3400-S32	40	215	124	155	32	60	154,000			
B5S-3400-S40	40	225	124	155	40	70	154,000			
B5S-3410-S32	41	220	128	160	32	60	154,000			
B5S-3410-S40	41	230	128	160	40	70	154,000			
B5S-3420-S40	42	234	131	164	40	70	168,000			
B5S-3430-S40	43	237	134	167	40	70	168,000			
B5S-3440-S40	44	240	137	170	40	70	168,000			
B5S-3450-S40	45	244	140	174	40	70	168,000			
B5S-3460-S40	46	247	143	177	40	70	178,000			
B5S-3470-S40	47	251	146	181	40	70	178,000			
B5S-3480-S40	48	256	149	186	40	70	178,000			
B5S-3490-S40	49	259	152	189	40	70	178,000			
B5S-3500-S40	50	263	156	193	40	70	178,000			
B5S-3510-S40	51	269	159	199	40	70	186,000			
B5S-3520-S40	52	272	162	202	40	70	186,000			
B5S-3530-S40	53	275	165	205	40	70	186,000			
B5S-3540-S40	54	278	168	208	40	70	186,000			
B5S-3550-S40	55	281	171	211	40	70	186,000			
B5S-3560-S40	56	286	174	216	40	70	199,000			
B5S-3570-S40	57	290	178	220	40	70	199,000			
B5S-3580-S40	58	294	182	224	40	70	199,000			

B5S 드릴 절삭 데이터 B5S Drill Cutting Data

Material 피삭재		Speed 속도 (m/min)	Feed 이송 (mm/rev)						
			φ13~φ15.5	φ16~φ20	φ20.5~φ25	φ25.5~φ30	φ31~φ41	φ42~φ58	φ59~φ80
P 강 Steel	저탄소강 (-0.25%) (Unalloyed steel)	180 ~ 260	0.05 ~ 0.08	0.06 ~ 0.10	0.07 ~ 0.12	0.09 ~ 0.15	0.11 ~ 0.18	0.15 ~ 0.28	0.11 ~ 0.18
	고탄소강 (0.25% -) (Low - alloy steel)	150 ~ 240	0.05 ~ 0.08	0.06 ~ 0.10	0.07 ~ 0.12	0.09 ~ 0.15	0.11 ~ 0.18	0.15 ~ 0.28	0.11 ~ 0.18
	경합금강 (- HB300) (Low - alloy steel)	120 ~ 240	0.05 ~ 0.08	0.06 ~ 0.10	0.07 ~ 0.12	0.09 ~ 0.15	0.11 ~ 0.18	0.15 ~ 0.28	0.11 ~ 0.18
	고합금강 (HB300 -) (High - alloy steel)	130 ~ 220	0.05 ~ 0.08	0.06 ~ 0.10	0.07 ~ 0.12	0.09 ~ 0.15	0.11 ~ 0.18	0.15 ~ 0.28	0.11 ~ 0.18
M 스테인레스강 Stainless steel	스테인레스강 Stainless steel	150 ~ 220	0.04 ~ 0.08	0.05 ~ 0.09	0.06 ~ 0.12	0.07 ~ 0.13	0.08 ~ 0.16	0.10 ~ 0.20	0.08 ~ 0.16
K 주철 Cast iron	회주철 Grey cast iron	150 ~ 250	0.05 ~ 0.11	0.07 ~ 0.13	0.08 ~ 0.12	0.10 ~ 0.18	0.14 ~ 0.26	0.18 ~ 0.35	0.14 ~ 0.26
	구상흑연주철 Cast iron with nodular cast	120 ~ 200	0.05 ~ 0.11	0.06 ~ 0.13	0.07 ~ 0.12	0.08 ~ 0.18	0.14 ~ 0.26	0.18 ~ 0.35	0.14 ~ 0.26
N 비철금속 Nonferrous metals	알루미늄 단조강 Aluminium forging alloys	300 ~ 380	0.04 ~ 0.06	0.05 ~ 0.07	0.16 ~ 0.08	0.07 ~ 0.09	0.10 ~ 0.14	0.12 ~ 0.17	0.10 ~ 0.14
	알루미늄 주물강 Aluminium cast alloys	260 ~ 330	0.04 ~ 0.06	0.05 ~ 0.07	0.06 ~ 0.08	0.07 ~ 0.09	0.10 ~ 0.14	0.12 ~ 0.17	0.10 ~ 0.14
S 내열합금 Super-alloys and titanium	고경도 합금강 Super-alloys and titanium	40 ~ 80	0.03 ~ 0.05	0.04 ~ 0.06	0.04 ~ 0.07	0.05 ~ 0.08	0.06 ~ 0.10	0.07 ~ 0.13	0.06 ~ 0.10