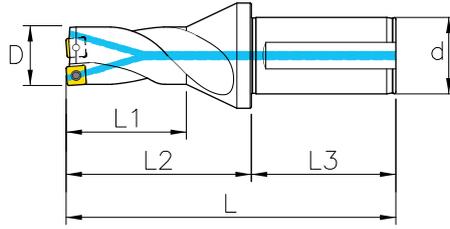


B6-2D 드릴 T-DRILL

특허 제 10-0838176
Patent #10-0838176



초경용접
Carbide welding



• INSERTS ⇒ **BPK, TAEGU-TEC**

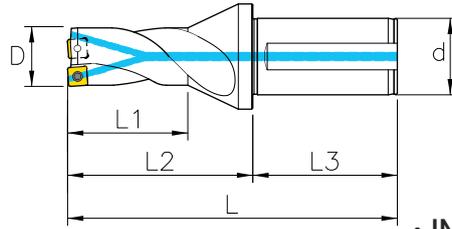
Order No. 주문형번	Dimension (mm)				Shank					Price
	D	L	L1	L2	d	L3				
B6-2125-S20	12.5	94	26	44	20	50	SPMG 050204	TSB-0204	TXL-06	121,000
B6-2130-S20	13	94	26	44	20	50				121,000
B6-2135-S20	13.5	96	28	46	20	50				121,000
B6-2140-S20	14	96	28	46	20	50				121,000
B6-2145-S20	14.5	99	30	49	20	50				121,000
B6-2150-S20	15	99	30	49	20	50				121,000
B6-2155-S25	15.5	108	32	52	25	56	SPMG 060204	TSB-22060	TXL-06	121,000
B6-2160-S25	16	108	32	52	25	56				121,000
B6-2165-S25	16.5	110	34	54	25	56				121,000
B6-2170-S25	17	110	34	54	25	56				121,000
B6-2175-S25	17.5	113	36	57	25	56				121,000
B6-2180-S25	18	113	36	57	25	56				121,000
B6-2185-S25	18.5	115	38	59	25	56				121,000
B6-2190-S25	19	115	38	59	25	56				121,000
B6-2195-S25	19.5	119	40	63	25	56				121,000
B6-2200-S25	20	119	40	63	25	56				121,000
B6-2205-S25	20.5	121	42	65	25	56				121,000
B6-2210-S25	21	121	42	65	25	56				121,000
B6-2215-S25	21.5	123	44	67	25	56				123,000
B6-2220-S25	22	123	44	67	25	56				SPMG 07T308
B6-2225-S32	22.5	131	46	71	32	60	123,000			
B6-2230-S25	23	127	46	71	25	56	123,000			
B6-2230-S32	23	131	46	71	32	60	123,000			
B6-2235-S32	23.5	134	48	74	32	60	123,000			
B6-2240-S25	24	130	48	74	25	56	123,000			
B6-2240-S32	24	134	48	74	32	60	123,000			
B6-2245-S32	24.5	137	50	77	32	60	123,000			
B6-2250-S25	25	133	50	77	25	56	123,000			
B6-2250-S32	25	137	50	77	32	60	123,000			
B6-2255-S32	25.5	139	52	79	32	60	132,000			
B6-2260-S25	26	135	52	79	25	56	132,000			
B6-2260-S32	26	139	52	79	32	60	132,000			
B6-2265-S32	26.5	141	54	81	32	60	132,000			
B6-2270-S25	27	137	54	81	25	56	132,000			
B6-2270-S32	27	141	54	81	32	60	132,000			
B6-2275-S32	27.5	144	56	84	32	60	132,000			

B6-2D 드릴 T-DRILL

특허 제 10-0838176
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초경용접
Carbide welding



• INSERTS ⇒ **BPK, TAEGU-TEC**

Order No. 주문형번	Dimension (mm)				Shank					Price
	D	L	L1	L2	d	L3				
B6-2280-S25	28	140	56	84	25	56	SPMG 090408	TSB-3508	TXL-15	132,000
B6-2280-S32	28	144	56	84	32	60				132,000
B6-2285-S32	28.5	146	58	86	32	60				132,000
B6-2290-S25	29	142	58	86	25	56				132,000
B6-2290-S32	29	146	58	86	32	60				132,000
B6-2295-S32	29.5	151	60	91	32	60				132,000
B6-2300-S32	30	151	60	91	32	60				132,000
B6-2305-S32	30.5	154	62	94	32	60				149,000
B6-2310-S32	31	154	62	94	32	60				149,000
B6-2320-S32	32	156	64	96	32	60				149,000
B6-2330-S32	33	159	66	99	32	60				149,000
B6-2340-S32	34	161	68	101	32	60				149,000
B6-2340-S40	34	171	68	101	40	70	149,000			
B6-2350-S32	35	164	70	104	32	60	149,000			
B6-2350-S40	35	174	70	104	40	70	149,000			
B6-2360-S32	36	167	72	107	32	60	149,000			
B6-2360-S40	36	177	72	107	40	70	149,000			
B6-2370-S32	37	170	74	110	32	60	156,000			
B6-2370-S40	37	180	74	110	40	70	156,000			
B6-2380-S32	38	173	76	113	32	60	156,000			
B6-2380-S40	38	183	76	113	40	70	156,000			
B6-2390-S32	39	175	78	115	32	60	156,000			
B6-2390-S40	39	185	78	115	40	70	156,000			
B6-2400-S32	40	178	80	118	32	60	156,000			
B6-2400-S40	40	188	80	118	40	70	156,000			
B6-2410-S32	41	181	82	121	32	60	172,000			
B6-2410-S40	41	191	82	121	40	70	172,000			
B6-2420-S32	42	183	84	123	32	60	172,000			
B6-2420-S40	42	193	84	123	40	70	172,000			
B6-2430-S32	43	186	86	126	32	60	172,000			
B6-2430-S40	43	196	86	126	40	70	172,000			
B6-2440-S32	44	188	88	128	32	60	172,000			
B6-2440-S40	44	198	88	128	40	70	172,000			
B6-2450-S32	45	192	90	132	32	60	172,000			
B6-2450-S40	45	202	90	132	40	70	172,000			
B6-2460-S32	46	195	92	135	32	60	181,000			
B6-2460-S40	46	205	92	135	40	70	181,000			
B6-2470-S32	47	197	94	137	32	60	181,000			
B6-2470-S40	47	207	94	137	40	70	181,000			
B6-2480-S32	48	200	96	140	32	60	181,000			
B6-2480-S40	48	210	96	140	40	70	181,000			
B6-2490-S32	49	202	98	142	32	60	181,000			
B6-2490-S40	49	212	98	142	40	70	181,000			
B6-2500-S32	50	205	100	145	32	60	181,000			
B6-2500-S40	50	215	100	145	40	70	181,000			

B6-2D, 3D, 4D / B6K - 5D 드릴 절삭 데이터 B6-2D, 3D, 4D / B6K - 5D Drill Cutting Data

Material 피삭재		Speed 속도 (m/min)	Feed 이송 (mm/rev)					
			ø12.5 ~ ø15	ø15.5 ~ ø21.5	ø22 ~ ø27.5	ø28 ~ ø33	ø34 ~ ø41	ø42 ~ ø50
P 강 Steel	저탄소강 (-0.25%) (Unalloyed steel)	180 ~ 250	0.05 ~ 0.08	0.06 ~ 0.10	0.06 ~ 0.12	0.07 ~ 0.13	0.08 ~ 0.15	0.08 ~ 0.16
	고탄소강 (0.25% -) (Low - alloy steel)	160 ~ 220	0.06 ~ 0.12	0.08 ~ 0.15	0.10 ~ 0.18	0.12 ~ 0.22	0.12 ~ 0.24	0.13 ~ 0.25
	경합금강 (- HB300) (Low - alloy steel)	150 ~ 220	0.06 ~ 0.12	0.08 ~ 0.14	0.10 ~ 0.18	0.12 ~ 0.22	0.12 ~ 0.23	0.13 ~ 0.24
	고합금강 (HB300 -) (High - alloy steel)	130 ~ 180	0.06 ~ 0.10	0.06 ~ 0.12	0.08 ~ 0.15	0.09 ~ 0.16	0.10 ~ 0.17	0.11 ~ 0.19
M 스테인레스강 Stainless steel	스테인레스강 Stainless steel	170 ~ 240	0.05 ~ 0.10	0.06 ~ 0.12	0.08 ~ 0.15	0.09 ~ 0.16	0.10 ~ 0.17	0.11 ~ 0.19
K 주철 Cast iron	회주철 Grey cast iron	180 ~ 250	0.06 ~ 0.12	0.08 ~ 0.16	0.12 ~ 0.20	0.15 ~ 0.25	0.16 ~ 0.28	0.18 ~ 0.30
	구상흑연주철 Cast iron with nodular cast	130 ~ 200	0.06 ~ 0.10	0.08 ~ 0.15	0.10 ~ 0.18	0.12 ~ 0.20	0.15 ~ 0.23	0.16 ~ 0.25
N 비철금속 Nonferrous metals	알루미늄 Aluminium	330 ~ 380	0.06 ~ 0.14	0.08 ~ 0.15	0.10 ~ 0.20	0.12 ~ 0.22	0.14 ~ 0.23	0.15 ~ 0.26
S 내열합금 Super-alloys and titanium	고경도 합금강 Super-alloys and titanium	30 ~ 60	0.05 ~ 0.15	0.06 ~ 0.14	0.08 ~ 0.18	0.10 ~ 0.22	0.12 ~ 0.22	0.14 ~ 0.24

B6T - 6D, 9D 드릴 절삭 데이터 B6T-6D, 9D Drill Cutting Data

Material 피삭재		Speed 속도 (m/min)	Feed 이송 (mm/rev)	
			ø 18 ~ ø 25	ø 26 ~ ø 30
P 강 Steel	저탄소강 (-0.25%) Unalloyed steel	130 ~ 190	0.06 ~ 0.10	0.07 ~ 0.11
	고탄소강 (0.25% -) Low - alloy steel	130 ~ 190	0.06 ~ 0.10	0.07 ~ 0.11
	경합금강 (- HB300) Low - alloy steel	100 ~ 140	0.06 ~ 0.10	0.07 ~ 0.11
	고합금강 (HB300 -) High - alloy steel	60 ~ 100	0.05 ~ 0.07	0.05 ~ 0.07
M 스테인레스강 Stainless steel	스테인레스강 Stainless steel	60 ~ 110	0.04 ~ 0.07	0.04 ~ 0.11
K 주철 Cast iron	회주철 Grey cast iron	130 ~ 190	0.07 ~ 0.13	0.07 ~ 0.15
	구상흑연주철 Cast iron with nodular cast	110 ~ 190	0.04 ~ 0.13	0.07 ~ 0.15
N 비철금속 Nonferrous metals	알루미늄 단조강 Aluminium forging alloys	200 ~ 300	0.04 ~ 0.06	0.07 ~ 0.12
	알루미늄 주물강 Aluminium cast alloys	140 ~ 300	0.04 ~ 0.06	0.06 ~ 0.12