

Vドリルシリーズに

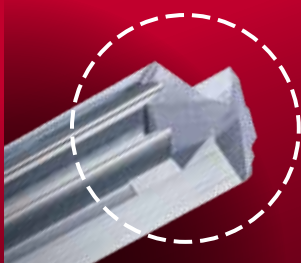
転造タツプ<sup>®</sup>下穴径  
バリエーション追加!

穴精度

**H7**

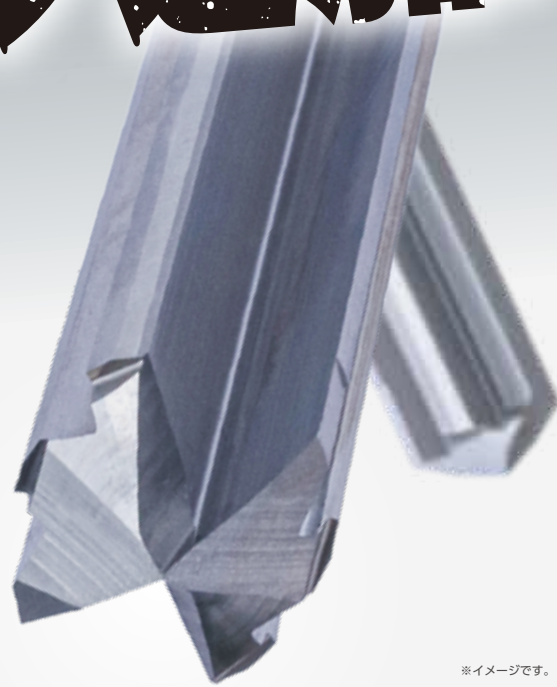
表面粗さ

**3S**



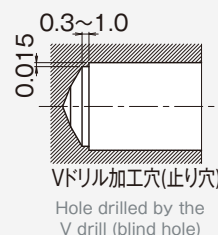
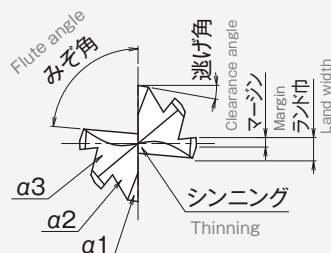
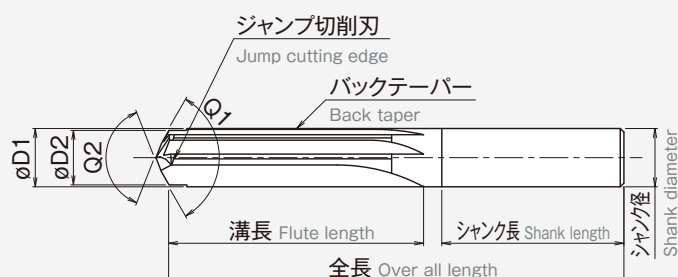
下穴不要でリーマ仕上げが可能

▶ 対象被削材は裏面の切削条件をご参照ください。



※イメージです。

各部の名称 Terminology



**D 1** : 第 1 直径 (仕上げ径)  
First diameter (finishing diameter)

**D 2** : 第 2 直径 (荒仕上げ径)  
Second diameter (roughing diameter)

**Q 1** : 第 1 先端角  
Primary point angle

**Q 2** : 第 2 先端角  
Secondary point angle

**$\alpha 1$**  : 第 1 逃げ角  
Primary relief angle

**$\alpha 2$**  : 第 2 逃げ角  
Secondary relief angle

**$\alpha 3$**  : 第 3 逃げ角  
Third relief angle

■ サイズ一覧表

| 対象タップ    | 型式          | 先端径  | 先端公差          | 対象タップ    | 型式          | 先端径   | 先端公差          |
|----------|-------------|------|---------------|----------|-------------|-------|---------------|
| M2x0.4   | OVDS-0017-8 | 1.78 | +0.006~+0.003 | M10x1.5  | OVDS-0092-3 | 9.23  | +0.010~+0.007 |
|          | OVDS-0017-9 | 1.79 | +0.006~+0.003 |          | OVDS-0092-4 | 9.24  | +0.010~+0.007 |
|          | OVDS-0018   | 1.8  | +0.006~+0.003 |          | OVDS-0092-5 | 9.25  | +0.010~+0.007 |
|          | OVDS-0018-1 | 1.81 | +0.006~+0.003 |          | OVDS-0092-6 | 9.26  | +0.010~+0.007 |
|          | OVDS-0018-2 | 1.82 | +0.006~+0.003 |          | OVDS-0092-7 | 9.27  | +0.010~+0.007 |
| M3x0.5   | OVDS-0027-3 | 2.73 | +0.006~+0.003 | M12x1.5  | OVDS-0112-3 | 11.23 | +0.013~+0.010 |
|          | OVDS-0027-4 | 2.74 | +0.006~+0.003 |          | OVDS-0112-4 | 11.24 | +0.013~+0.010 |
|          | OVDS-0027-5 | 2.75 | +0.006~+0.003 |          | OVDS-0112-5 | 11.25 | +0.013~+0.010 |
|          | OVDS-0027-6 | 2.76 | +0.006~+0.003 |          | OVDS-0112-6 | 11.26 | +0.013~+0.010 |
|          | OVDS-0027-7 | 2.77 | +0.006~+0.003 |          | OVDS-0112-7 | 11.27 | +0.013~+0.010 |
| M4x0.7   | OVDS-0036-3 | 3.63 | +0.007~+0.004 | M12x1.75 | OVDS-0111-1 | 11.11 | +0.013~+0.010 |
|          | OVDS-0036-4 | 3.64 | +0.007~+0.004 |          | OVDS-0111-2 | 11.12 | +0.013~+0.010 |
|          | OVDS-0036-5 | 3.65 | +0.007~+0.004 |          | OVDS-0111-3 | 11.13 | +0.013~+0.010 |
|          | OVDS-0036-6 | 3.66 | +0.007~+0.004 |          | OVDS-0111-4 | 11.14 | +0.013~+0.010 |
|          | OVDS-0036-7 | 3.67 | +0.007~+0.004 |          | OVDS-0111-5 | 11.15 | +0.013~+0.010 |
| M5x0.8   | OVDS-0045-8 | 4.58 | +0.007~+0.004 | M14x1.5  | OVDS-0132-3 | 13.23 | +0.013~+0.010 |
|          | OVDS-0045-9 | 4.59 | +0.007~+0.004 |          | OVDS-0132-4 | 13.24 | +0.013~+0.010 |
|          | OVDS-0046   | 4.6  | +0.007~+0.004 |          | OVDS-0132-5 | 13.25 | +0.013~+0.010 |
|          | OVDS-0046-1 | 4.61 | +0.007~+0.004 |          | OVDS-0132-6 | 13.26 | +0.013~+0.010 |
|          | OVDS-0046-2 | 4.62 | +0.007~+0.004 |          | OVDS-0132-7 | 13.27 | +0.013~+0.010 |
| M6x1.0   | OVDS-0054-8 | 5.48 | +0.007~+0.004 | M14x2.0  | OVDS-0129-8 | 12.98 | +0.013~+0.010 |
|          | OVDS-0054-9 | 5.49 | +0.007~+0.004 |          | OVDS-0129-9 | 12.99 | +0.013~+0.010 |
|          | OVDS-0055   | 5.5  | +0.007~+0.004 |          | OVDS-0130   | 13    | +0.013~+0.010 |
|          | OVDS-0055-1 | 5.51 | +0.007~+0.004 |          | OVDS-0130-1 | 13.01 | +0.013~+0.010 |
|          | OVDS-0055-2 | 5.52 | +0.007~+0.004 |          | OVDS-0130-2 | 13.02 | +0.013~+0.010 |
| M8x1.0   | OVDS-0074-8 | 7.48 | +0.010~+0.007 | M16x1.5  | OVDS-0152-3 | 15.23 | +0.013~+0.010 |
|          | OVDS-0074-9 | 7.49 | +0.010~+0.007 |          | OVDS-0152-4 | 15.24 | +0.013~+0.010 |
|          | OVDS-0075   | 7.5  | +0.010~+0.007 |          | OVDS-0152-5 | 15.25 | +0.013~+0.010 |
|          | OVDS-0075-1 | 7.51 | +0.010~+0.007 |          | OVDS-0152-6 | 15.26 | +0.013~+0.010 |
|          | OVDS-0075-2 | 7.52 | +0.010~+0.007 |          | OVDS-0152-7 | 15.27 | +0.013~+0.010 |
| M8x1.25  | OVDS-0073-6 | 7.36 | +0.010~+0.007 | M16x2.0  | OVDS-0149-8 | 14.98 | +0.013~+0.010 |
|          | OVDS-0073-7 | 7.37 | +0.010~+0.007 |          | OVDS-0149-9 | 14.99 | +0.013~+0.010 |
|          | OVDS-0073-8 | 7.38 | +0.010~+0.007 |          | OVDS-0150   | 15    | +0.013~+0.010 |
|          | OVDS-0073-9 | 7.39 | +0.010~+0.007 |          | OVDS-0150-1 | 15.01 | +0.013~+0.010 |
|          | OVDS-0074   | 7.4  | +0.010~+0.007 |          | OVDS-0150-2 | 15.02 | +0.013~+0.010 |
| M10x1.25 | OVDS-0093-6 | 9.36 | +0.010~+0.007 |          |             |       |               |
|          | OVDS-0093-7 | 9.37 | +0.010~+0.007 |          |             |       |               |
|          | OVDS-0093-8 | 9.38 | +0.010~+0.007 |          |             |       |               |
|          | OVDS-0093-9 | 9.39 | +0.010~+0.007 |          |             |       |               |
|          | OVDS-0094   | 9.4  | +0.010~+0.007 |          |             |       |               |

今回 青枠 が新サイズラインナップとなります。

※ 通常サイズに関しては弊社または販売店様にお問合せください。

■ 切削条件

| 被削材             | アルミニウム合金鋳物<br>Si ~13% | アルミニウム合金鋳物<br>Si 13~20 | アルミニウム合金展伸材<br>A7075・A2024 | 銅合金           | 鋳鉄<br>FC250~350 | ダクタイル鋳鉄<br>FCD400~500 |
|-----------------|-----------------------|------------------------|----------------------------|---------------|-----------------|-----------------------|
| 切削速度：Vc [m/min] | 50~80                 | 30~70                  | 50~80                      | 50~80         | 20~35           | 15~25                 |
| ドリル径 [mm]       | 送り速度 [mm/min]         | 送り速度 [mm/min]          | 送り速度 [mm/min]              | 送り速度 [mm/min] | 送り速度 [mm/min]   | 送り速度 [mm/min]         |
| 3               | 160~850               | 95~740                 | 160~850                    | 160~850       | 60~370          | 50~270                |
| 4               | 160~955               | 95~840                 | 160~960                    | 160~960       | 60~420          | 50~300                |
| 5               | 160~770               | 95~670                 | 160~770                    | 160~770       | 60~330          | 50~240                |
| 6               | 160~850               | 95~740                 | 160~850                    | 160~850       | 60~370          | 50~200                |
| 8               | 120~640               | 70~560                 | 120~640                    | 120~640       | 50~280          | 40~150                |
| 10              | 100~510               | 60~450                 | 100~510                    | 100~510       | 40~220          | 30~120                |
| 12              | 80~420                | 50~370                 | 80~420                     | 80~420        | 30~190          | 25~100                |
| 14              | 70~360                | 40~320                 | 70~360                     | 70~360        | 30~160          | 20~85                 |
| 16              | 60~480                | 50~420                 | 60~480                     | 60~480        | 30~140          | 24~75                 |
| 18              | 70~430                | 40~370                 | 70~430                     | 70~430        | 30~120          | 20~65                 |
| 20              | 60~380                | 40~340                 | 60~380                     | 60~380        | 25~110          | 20~60                 |

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