

DORMER PRAMET

天龙钻

高性能可换刀头

2020



 **DORMER**



我们在现有的天龙钻的基础上，增加了12×D的钻头刀体长度，用于深孔钻，1.5×D用于提高浅孔和平板钻孔的刚性。

新增的刀体支持整个系列的硬质合金刀头用于钢，不锈钢和铸铁加工。

特点与优点

- 稳定的高性能，即使更换各种刀头后也仍不逊色。
- 降低库存成本 – 一支刀杆上可安装多个不同尺寸的硬质合金可换刀头。
- 通用性 – 带有平面的圆柱形柄部，适合多用途的刀柄系。
- 刀头更换迅速、便捷，确保尽量减少生产过程的中断。更换刀头时无需将钻体从设备上取下。
- 刀头与钻体配合精确，优化了刀具刚度，从而带来最佳的钻孔精度和精密的公差。

材料

优质微晶硬质合金（可换刀头）

- 微晶硬质合金的硬度和韧性俱佳，因而具有高耐磨性和更长的使用寿命。

淬硬钢（钻头刀体）

- 高光亮度的镀镍淬硬钢刀体，耐磨损、耐腐蚀。

涂层

钛铝氮化物基底涂层可提供：

- 高韧度和高抗氧化性。
- 在加工铸铁等研磨性材料时具有出色的抗磨性。
- 在铸铁钻孔形成高温时可保持刀具的高硬度。
- 更长的使用寿命和更高的生产率。

刀头类型



R950

钢



R960

不锈钢



R970

铸铁

几何形状

刀尖设计

- 坚固的刀尖设计提升了钻孔作业的稳定性，并且降低钻通出口表面时的钻头受力。
- 提高了出口表面的加工质量，并且在粒状材料钻孔时有助于防止“出口崩裂”。

钻尖几何形状

- 140度钻尖角设计为大多数材料的钻孔作业提供了良好的定心能力并降低了推力。

完整的产品系列

- 1.5×D (倍径)、3×D、5×D、8×D、和12×D (倍径) 长度内冷却钻头，可提升切削效率和排屑效果，从而带来更高的生产率。
- 公制: 12.00 mm至42.00 mm。
- 英制: 15/32 inch至1.5/8 inch。
- 使用液压刀柄可获得最佳夹持效果。也可以放在ER和侧固型刀柄中。



钻头刀体长度

1,5×D



NEW

3×D



5×D



8×D



12×D



NEW

工件材料分组 (WMG)

ISO 用于选择切削等级和槽形
针对范围广泛的工件材料

一般定义
即钢、不锈钢...

P **M** **K** **S** **H**

子分组 用于更加详细的工件材料分类来导航和选择刀具

定义
根据结构/成分
即普通碳钢、合金钢...

P **M** **K** **N** **S** **H**

P1

P2

P3

P4

WMG 用于选择并提供切削工况
在±10%范围内

定义
根据硬度/极限抗拉强度
即160 < 220HB、620 < 900 n/mm² ...

P

P1

P1.1

P1.2

P1.3

P2

P2.1

P2.2

P2.3

P3

P3.1

P3.2

P3.3

P4

P4.1

P4.2

P4.3

关于DORMER PRAMET的工件材料分类

工件材料分组 (WMG) 用于支持简单和可靠地选择正确的切削刀具以及适合特定应用加工工况的初始值。

Dormer Pramet将工件材料分为六个不同的颜色组；

- 蓝色：钢和铸钢 (P组)
- 黄色：不锈钢 (M组)
- 红色：铸铁 (K组)
- 绿色：有色金属 (N组)
- 橙色：高温合金 (S组)
- 灰色：硬化材料 (H组)

上述各组再根据其结构和/或成分分为几个子组。例如，P组钢和铸钢分成四个子组，即：

- P1 – 易切削钢
- P2 – 普通碳钢
- P3 – 合金钢
- P4 – 工具钢

最后，根据材料属性（例如硬度和极限抗拉强度）进行进一步分类。通过这种分类方式，可以为我们的客户提供一套完整的刀具推荐方案，包括切削速度和进给量等初始值。

下页的表格中包含对每个工件材料分组的描述，以及适用于该分组的常用名称示例。

ISO		WMG (工件材料分组)		极限 抗拉 强度 Mpa [N/mm²]	原Dormer AMG	原Pramet ISO
P	P1	P1.1	易切削的硫化碳钢, 硬度< 220HB	≤ 760	1.1	P1
		P1.2	易切削的硫化和磷化碳钢, 硬度< 180HB	≤ 620	1.1	P1
		P1.3	易切削的硫化/磷化和含铅碳钢, 硬度< 160HB	≤ 550	1.1	P1
	P2	P2.1	普通低碳钢, 含< 0.25%C, 硬度< 180HB	≤ 620	1.2	P2
		P2.2	普通中碳钢, 含< 0.55%C, 硬度< 240HB	≤ 830	1.3	P2
		P2.3	普通高碳钢, 含> 0.55%C, 硬度< 300HB	≤ 1030	1.5	P3
	P3	P3.1	合金钢, 硬度< 180HB	≤ 620	1.4	P3
		P3.2	合金钢, 硬度180–260HB	> 620 ≤ 900	1.4	P3
		P3.3	合金钢, 硬度260–360HB	> 900 ≤ 1240	1.5	P4
	P4	P4.1	工具钢, 硬度< 26HRC	≤ 900	1.4	P3
P4.2		工具钢, 硬度26–39HRC	> 900 ≤ 1240	1.5	P4	
P4.3		工具钢, 硬度39–45HRC	> 1250 ≤ 1450	1.6	H1	
M	M1	M1.1	铁素体不锈钢, 硬度< 160HB	≤ 520	2.1	M1
		M1.2	铁素体不锈钢, 硬度160–220HB	> 520 ≤ 700	2.1	M1
	M2	M2.1	马氏体不锈钢, 硬度< 200HB	≤ 670	2.3	M2
		M2.2	马氏体不锈钢, 硬度200–280HB	> 670 ≤ 950	2.3	M2
	M3	M2.3	马氏体不锈钢, 硬度280–380HB	> 950 ≤ 1300	2.4	M2
		M3.1	奥氏体不锈钢, 硬度< 200HB	≤ 750	2.2	M3
		M3.2	奥氏体不锈钢, 硬度200–260HB	>750 ≤ 870	2.2	M3
	M4	M3.3	奥氏体不锈钢, 硬度260–300HB	> 870 ≤ 1040	2.2	M3
		M4.1	奥氏体-铁素体或超奥氏体不锈钢, 硬度< 300HB	≤ 990	2.3	M4
		M4.2	沉淀硬化奥氏体不锈钢, 硬度300–380HB	≤ 1320	2.4	M4
K	K1	K1.1	铁素体或铁素体-珠光体灰口铸铁, 硬度< 180HB	≤ 190	3.1	K1
		K1.2	铁素体-珠光体或珠光体灰口铸铁, 硬度< 180–240HB	> 190 ≤ 310	3.2	K1
		K1.3	珠光体灰口铸铁, 硬度240–280HB	>310 ≤ 390	3.2	K1
	K2	K2.1	铁素体可锻铸铁, 硬度< 160HB	≤ 400	3.3	K2
		K2.2	铁素体或珠光体可锻铸铁, 硬度160–200HB	> 400 ≤ 550	3.3	K2
		K2.3	珠光体可锻铸铁, 硬度200–240HB	> 550 ≤ 660	3.4	K2
	K3	K3.1	铁素体球墨铸铁, 硬度< 180HB	≤ 560	3.3	K3
		K3.2	铁素体或珠光体延性球墨铸铁, 硬度180–220HB	> 560 ≤ 680	3.3	K4
		K3.3	珠光体延性球墨铸铁, 硬度220–260HB	> 680 ≤ 800	3.4	K4
	K4	K4.1	奥氏体铸铁, 硬度< 180HB	≤ 610		
		K4.2	奥氏体铸铁, 硬度180–240HB	> 610 ≤ 840		
		K4.3	等温淬火延性铸铁, 硬度240–280HB	> 840 ≤ 980		
		K4.4	等温淬火延性铸铁, 硬度280–320HB	> 980 ≤ 1130		
		K4.5	等温淬火延性铸铁, 硬度320–360HB	> 1130 ≤ 1280		
	K5	K5.1	蠕墨铸铁, 硬度< 180HB			
K5.2		蠕墨铸铁, 硬度180–220HB				
K5.3		蠕墨铸铁, 硬度220–260HB				
N	N1	N1.1	纯铝和锻铝合金, 硬度< 60HB	≤ 240	7.1	N1
		N1.2	铝塑合金, 硬度60–100HB	> 240 ≤ 400	7.1	N1
		N1.3	铝塑合金, 硬度100–150HB	> 400 ≤ 590	7.2	N2
	N2	N2.1	铸铝合金, 硬度< 75HB	≤ 240	7.3	N1
		N2.2	铸铝合金, 硬度75–90HB	> 240 ≤ 270	7.3	N1
		N2.3	铸铝合金, 硬度90 < 140HB	> 270 ≤ 440	7.3	N2
	N3	N3.1	易切削的铜合金材料, 具有出色机械加工性能		6.3	N3
		N3.2	短切屑铜合金, 具有良好至中等的机械加工性能		6.2	N3
		N3.3	电解铜和长切屑铜合金, 具有中等至较差的机械加工性能		6.1	N4
	N4	N4.1	热塑性塑料		8.1	
N4.2		热固性聚合物		8.2		
N4.3		增强型塑料或复合材料		8.3		
S	S1	S1.1	钛或钛合金, 硬度< 200HB	≤ 660	4.1	S1
		S1.2	钛合金, 硬度200–280HB	> 660 ≤ 950	4.2	S1
		S1.3	钛合金, 硬度280–360HB	> 950 ≤ 1200	4.3	S1
	S2	S2.1	高温铁基合金, 硬度< 200HB	≤ 690		S2
		S2.2	高温铁基合金, 硬度200-280HB	> 690 ≤ 970		S2
		S3.1	高温镍基合金, 硬度< 280HB	≤ 940	5.2	S3
	S3	S3.2	高温镍基合金, 硬度280–360HB	> 940 ≤ 1200	5.3	S3
		S4	S4.1	高温钴基合金, 硬度< 240HB	≤ 800	
S4.2	高温钴基合金, 硬度240–320HB		> 800 ≤ 1070		S4	
H	H1	H1.1	冷硬铸铁, 硬度< 400HB			
		H2.1	硬化铸铁, 硬度< 55HRC			H2
	H2	H2.2	硬化铸铁, 硬度> 55HRC			H2
		H3	H3.1	淬火钢, 硬度<51HRC		1.7
	H3.2		淬火钢, 硬度51–55HRC		1.7	H3
	H4	H4.1	淬火钢, 硬度55–59HRC		1.8	H4
H4.2		淬火钢, 硬度> 59HRC		1.8	H4	

HYDRA

$$n = \frac{V_c \times 1000}{\pi \times D}$$

$$Vf = n \times fn$$



Ø (D)	12 [mm]	15 [mm]	16 [mm]	20 [mm]	25 [mm]	30 [mm]	40 [mm]
S	0.100	0.123	0.130	0.150	0.170	0.190	0.220
T	0.130	0.160	0.170	0.190	0.210	0.230	0.260
U	0.200	0.223	0.230	0.240	0.270	0.300	0.360
V	0.280	0.310	0.320	0.340	0.400	0.440	0.510
W	0.380	0.418	0.430	0.450	0.470	0.490	0.520
mm/rev. ± 25%							

HYDRA

			
H861	H860	R950 R960 R970	H851, H853, H855, H858, H8512

R950	R960	R970	H851	H853	H855	H858	H8512	H860	H861
									
			1,5xD	3xD	5xD	8xD	12xD		
12.0 – 42.0 15/32 – 1.5/8	12.0 – 30.5 15/32 – 1.3/16	12.0 – 42.0 15/32 – 1.5/8	12.0 – 30.0 31/64 – 1.3/16	12.0 – 42.5 31/64 – 1.3/16	12.0 – 42.5 31/64 – 1.3/16	14.0 – 42.5 14.0 – 25.0	14.00 – 25.00	N1 – N7	N1 – N6
9 – 11			12 – 15					16	

DC [mm] / [inch]	R950	R960	R970	H851 1,5xD	H853 3xD	H855 5xD	H858 8xD	H8512 12xD	H860	H861
15/32"	R95015/32	R96015/32	R97015/32	H85112.0 H85131/64	H85312.0 H85331/64	H85512.0 H85531/64	-	-	H860N1	H861N1
12.0	R95012.0	R96012.0	R97012.0							
12.1	R95012.1	R96012.1	R97012.1							
12.2	R95012.2	R96012.2	R97012.2							
31/64"	R95031/64	R96031/64	R97031/64							
12.5	R95012.5	R96012.5	R97012.5	H85112.5 H8511/2	H85312.5 H8531/2	H85512.5 H8551/2	-	-		
12.6	R95012.6	R96012.6	R97012.6							
1/2"	R9501/2	R9601/2	R9701/2							
12.8	R95012.8	R96012.8	R97012.8							
12.9	R95012.9	R96012.9	R97012.9							
13.0	R95013.0	R96013.0	R97013.0	H85113.0 H85117/32	H85313.0 H85317/32	H85513.0 H85517/32	-	-		
33/64"	R95033/64	R96033/64	R97033/64							
13.2	R95013.2	R96013.2	R97013.2							
17/32"	R95017/32	R96017/32	R97017/32							
13.5	R95013.5	R96013.5	R97013.5							
13.6	R95013.6	R96013.6	R97013.6	H85114.0 H8519/16	H85314.0 H8539/16	H85514.0 H8559/16	H85814.0	H851214.0		
13.7	R95013.7	R96013.7	R97013.7							
13.8	R95013.8	R96013.8	R97013.8							
35/64"	R95035/64	R96035/64	R97035/64							
14.0	R95014.0	R96014.0	R97014.0							
14.1	R95014.1	R96014.1	R97014.1							
14.2	R95014.2	R96014.2	R97014.2							
9/16"	R9509/16	R9609/16	R9709/16							
14.5	R95014.5	R96014.5	R97014.5	H85115.0 H85139/64	H85315.0 H85339/64	H85515.0 H85539/64	H85815.0	H851215.0		
14.6	R95014.6	R96014.6	R97014.6							
37/64"	R95037/64	R96037/64	R97037/64							
14.7	R95014.7	R96014.7	R97014.7							
14.8	R95014.8	R96014.8	R97014.8							
15.0	R95015.0	R96015.0	R97015.0							
19/32"	R95019/32	R96019/32	R97019/32							
15.1	R95015.1	R96015.1	R97015.1							
15.2	R95015.2	R96015.2	R97015.2							
15.24	R95015.24	R96015.24	R97015.24							
39/64"	R95039/64	R96039/64	R97039/64							
15.5	R95015.5	R96015.5	R97015.5							

DC [mm] / [inch]	R950	R960	R970	H851 1,5xD	H853 3xD	H855 5xD	H858 8xD	H8512 12xD	H860	H861		
15.6	R95015.6	R96015.6	R97015.6	H85116.0 H85141/64	H85316.0 H85341/64	H85516.0 H85541/64	H85816.0	H851216.0	H860N2	H861N2		
15.7	R95015.7	R96015.7	R97015.7									
5/8"	R9505/8	R9605/8	R9705/8									
16.0	R95016.0	R96016.0	R97016.0									
16.08	R95016.08	R96016.08	R97016.08									
16.1	R95016.1	R96016.1	R97016.1									
16.2	R95016.2	R96016.2	R97016.2									
16.3	R95016.3	R96016.3	R97016.3									
41/64"	R95041/64	R96041/64	R97041/64									
16.5	R95016.5	R96016.5	R97016.5	H85117.0 H85111/16	H85317.0 H85311/16	H85517.0 H85511/16	H85817.0	H851217.0				
16.6	R95016.6	R96016.6	R97016.6									
21/32"	R95021/32	R96021/32	R97021/32									
16.7	R95016.7	R96016.7	R97016.7									
17.0	R95017.0	R96017.0	R97017.0									
43/64"	R95043/64	R96043/64	R97043/64									
17.1	R95017.1	R96017.1	R97017.1									
17.2	R95017.2	R96017.2	R97017.2									
11/16"	R95011/16	R96011/16	R97011/16									
17.5	R95017.5	R96017.5	R97017.5	H85118.0 H85123/32	H85318.0 H85323/32	H85518.0 H85523/32	H85818.0	H851218.0				
17.6	R95017.6	R96017.6	R97017.6									
17.7	R95017.7	R96017.7	R97017.7									
45/64"	R95045/64	R96045/64	R97045/64									
18.0	R95018.0	R96018.0	R97018.0									
18.1	R95018.1	R96018.1	R97018.1									
18.2	R95018.2	R96018.2	R97018.2									
23/32"	R95023/32	R96023/32	R97023/32									
18.5	R95018.5	R96018.5	R97018.5									
18.6	R95018.6	R96018.6	R97018.6	H85119.0 H85149/64	H85319.0 H85349/64	H85519.0 H85549/64	H85819.0	H851219.0	H860N3	H861N3		
47/64"	R95047/64	R96047/64	R97047/64									
18.7	R95018.7	R96018.7	R97018.7									
18.9	R95018.9	R96018.9	R97018.9									
19.0	R95019.0	R96019.0	R97019.0									
3/4"	R9503/4	R9603/4	R9703/4									
19.1	R95019.1	R96019.1	R97019.1									
19.2	R95019.2	R96019.2	R97019.2									
19.25	R95019.25	R96019.25	R97019.25									
19.3	R95019.3	R96019.3	R97019.3									
19.35	R95019.35	R96019.35	R97019.35									
49/64"	R95049/64	R96049/64	R97049/64									
19.5	R95019.5	R96019.5	R97019.5	H85120.0 H85151/64	H85320.0 H85351/64	H85520.0 H85551/64	H85820.0	H851220.0				
19.6	R95019.6	R96019.6	R97019.6									
19.7	R95019.7	R96019.7	R97019.7									
25/32"	R95025/32	R96025/32	R97025/32									
20.0	R95020.0	R96020.0	R97020.0	H85121.0 H85127/32	H85321.0 H85327/32	H85521.0 H85527/32	H85821.0	H851221.0				
51/64"	R95051/64	R96051/64	R97051/64									
20.5	R95020.5	R96020.5	R97020.5									
13/16"	R95013/16	R96013/16	R97013/16									
21.0	R95021.0	R96021.0	R97021.0	H85122.0 H85157/64	H85322.0 H85357/64	H85522.0 H85557/64	H85822.0	H851222.0				
53/64"	R95053/64	R96053/64	R97053/64									
27/32"	R95027/32	R96027/32	R97027/32									
21.5	R95021.5	R96021.5	R97021.5									
55/64"	R95055/64	R96055/64	R97055/64	H85123.0 H85159/64	H85323.0 H85359/64	H85523.0 H85559/64	H85823.0	H851223.0	H860N4			
22.0	R95022.0	R96022.0	R97022.0									
7/8"	R9507/8	R9607/8	R9707/8									
22.5	R95022.5	R96022.5	R97022.5									
57/64"	R95057/64	R96057/64	R97057/64	H85123.0 H85159/64	H85323.0 H85359/64	H85523.0 H85559/64	H85823.0	H851223.0				
22.7	R95022.7	R96022.7	R97022.7									
23.0	R95023.0	R96023.0	R97023.0									
29/32"	R95029/32	R96029/32	R97029/32									
59/64"	R95059/64	R96059/64	R97059/64									
23.5	R95023.5	R96023.5	R97023.5									

DC [mm] / [inch]	R950	R960	R970	H851 1,5xD	H853 3xD	H855 5xD	H858 8xD	H8512 12xD	H860	H861
15/16	R95015/16	R96015/16	R97015/16	H85124.0 H85131/32	H85324.0 H85331/32	H85524.0 H85531/32	H85824.0	H851224.0	H860N4	H861N3
24.0	R95024.0	R96024.0	R97024.0							
61/64	R95061/64	R96061/64	R97061/64							
24.5	R95024.5	R96024.5	R97024.5							
31/32"	R95031/32	R96031/32	R97031/32	H85125.0 H8511.1/64	H85325.0 H8531.1/64	H85525.0 H8551.1/64	H85825.0	H851225.0	H860N5	H861N4
25.0	R95025.0	R96025.0	R97025.0							
63/64"	R95063/64	R96063/64	R97063/64							
1"	R9501	R9601	R9701							
25.5	R95025.5	R96025.5	R97025.5							
25.6	R95025.6	-	-							
25.65	R95025.65	R96025.65	R97025.65							
1.1/64"	R9501.1/64	R9601.1/64	R9701.1/64	H85126.0 H8511.3/64	H85326.0 H8531.3/64	H85526.0 H8551.3/64	H85826.0	-		
26.0	R95026.0	R96026.0	R97026.0							
1.1/32"	R9501.1/32	R9601.1/32	R9701.1/32							
26.5	R95026.5	R96026.5	R97026.5							
1.3/64	R9501.3/64	R9601.3/64	R9701.3/64	H85127.0 H8511.3/32	H85327.0 H8531.3/32	H85527.0 H8551.3/32	H85827.0	-		
1.1/16"	R9501.1/16	R9601.1/16	R9701.1/16							
27.0	R95027.0	R96027.0	R97027.0							
1.5/64"	R9501.5/64	R9601.5/64	R9701.5/64							
27.5	R95027.5	R96027.5	R97027.5	H85128.0 H8511.1/8	H85328.0 H8531.1/8	H85528.0 H8551.1/8	H85828.0	-		
1.3/32"	R9501.3/32	R9601.3/32	R9701.3/32							
28.0	R95028.0	R96028.0	R97028.0							
1.7/64"	R9501.7/64	R9601.7/64	R9701.7/64							
28.5	R95028.5	R96028.5	R97028.5	H85129.0 H8511.11/64	H85329.0 H8531.11/64	H85529.0 H8551.11/64	H85829.0	-		
1.1/8"	R9501.1/8	R9601.1/8	R9701.1/8							
1.9/64"	R9501.9/64	R9601.9/64	R9701.9/64							
29.0	R95029.0	R96029.0	R97029.0							
1.5/32"	R9501.5/32	R9601.5/32	R9701.5/32	H85130.0 H8511.3/16	H85330.0 H8531.3/16	H85530.0 H8551.3/16	H85830.0	-		
29.5	R95029.5	R96029.5	R97029.5							
1.11/64"	R9501.11/64	R9601.11/64	R9701.11/64							
30.0	R95030.0	R96030.0	R97030.0							
1.3/16"	R9501.3/16	R9601.3/16	R9701.3/16	-	H85332.0	H85532.0	H85832.0	-		
30.5	R95030.5	R96030.5	R97030.5							
1.7/32"	R9501.7/32	-	R9701.7/32							
31.0	R95031.0	-	R97031.0							
1.1/4"	R9501.1/4	-	R9701.1/4	-	H85333.5	H85533.5	H85833.5	-		
32.0	R95032.0	-	R97032.0							
32.5	R95032.5	-	R97032.5							
1.19/64"	R9501.19/64	-	R9701.19/64							
33.0	R95033.0	-	R97033.0	-	H85335.0	H85535.0	H85835.0	-		
33.5	R95033.5	-	R97033.5							
34.0	R95034.0	-	R97034.0							
1.11/32"	R9501.11/32	-	R9701.11/32							
34.5	R95034.5	-	R97034.5	-	H85336.5	H85536.5	H85836.5	-		
1.3/8"	R9501.3/8	-	R9701.3/8							
35.0	R95035.0	-	R97035.0							
36.0	R95036.0	-	R97036.0							
1.27/64"	R9501.27/64	-	R9701.27/64	-	H85338.0	H85538.0	H85838.0	-		
36.5	R95036.5	-	R97036.5							
37.0	R95037.0	-	R97037.0							
1.15/32"	R9501.15/32	-	R9701.15/32							
37.5	R95037.5	-	R97037.5	-	H85339.5	H85539.5	H85839.5	-		
38.0	R95038.0	-	R97038.0							
1.1/2"	R9501.1/2	-	R9701.1/2							
38.5	R95038.5	-	R97038.5							
1.17/32"	R9501.17/32	-	R9701.17/32	-	H85341.0	H85541.0	H85841.0	-		
39.0	R95039.0	-	R97039.0							
39.5	R95039.5	-	R97039.5							
1.9/16"	R9501.9/16	-	R9701.9/16							
40.0	R95040.0	-	R97040.0	-	H85342.5	H85542.5	H85842.5	-		
41.0	R95041.0	-	R97041.0							
1.5/8"	R9501.5/8	-	R9701.5/8							
42.0	R95042.0	-	R97042.0							

		HM	HM	HM	HSS	HSS	HSS	HSS	HSS		
					1.5XD	3XD	5XD	8XD	12XD		

R950

适用于钢件的天龙钻头。

R960

适用于不锈钢的天龙钻头。

R970

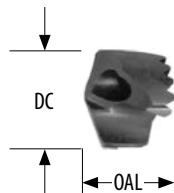
适用于铸铁的天龙钻头。

R950	P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M2.3	M4.2	K2.1	K2.2	K2.3	K3.1	K3.2
	133W	148W	154W	114W	100W	88W	125W	101W	85W	75W	63W	52T	41T	35T	102V	88V	70V	96V	73V
	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3										
	59V	89V	67V	49V	42V	35V	100V	76V	58V										
R960	P1.1	P1.2	P1.3	P2.1	M1.1	M1.2	M2.1	M2.2	M2.3	M3.1	M3.2	M3.3	M4.1	M4.2	K1.1	K1.2	K1.3	K2.1	K2.2
	133W	148W	154W	114W	82V	70V	73V	60V	50T	58T	50T	45T	40T	34T	120V	89V	67V	108V	88V
	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3	S1.1	S1.2	S1.3	S2.1	S2.2	S3.1	S3.2
	70V	96V	73V	59V	89V	67V	49V	42V	35V	100V	76V	58V	45T	35T	30S	40S	35S	30S	25S
	S4.1	S4.2																	
R970	K1.1	K1.2	K1.3	K2.1	K2.2	K2.3	K3.1	K3.2	K3.3	K4.1	K4.2	K4.3	K4.4	K4.5	K5.1	K5.2	K5.3		
	120V	89V	67V	98V	80V	64V	97V	67V	54V	81V	61V	45V	38V	32V	91V	69V	53V		

R950
R960
R970



DORMER



R950	R960	R970
HYDRA 12.0 - 42.0 15/32 - 1.5/8	HYDRA 12.0 - 30.5 15/32 - 1.3/16	HYDRA 12.0 - 42.0 15/32 - 1.5/8

DC h ₁ [inch]	DC h ₁ [mm]	DC [decimal inch]	OAL [mm]	R950	R960	R970
15/32	11.91	0.4688	9.1	R95015/32	R96015/32	R97015/32
	12.00	0.4724	9.1	R95012.0	R96012.0	R97012.0
	12.10	0.4764	9.1	R95012.1	R96012.1	R97012.1
	12.20	0.4803	9.1	R95012.2	R96012.2	R97012.2
31/64	12.30	0.4844	9.1	R95031/64	R96031/64	R97031/64
	12.50	0.4921	9.4	R95012.5	R96012.5	R97012.5
	12.60	0.4961	9.4	R95012.6	R96012.6	R97012.6
1/2	12.70	0.5000	9.4	R9501/2	R9601/2	R9701/2
	12.80	0.5039	9.4	R95012.8	R96012.8	R97012.8
	12.90	0.5079	9.4	R95012.9	R96012.9	R97012.9
	13.00	0.5118	9.7	R95013.0	R96013.0	R97013.0
33/64	13.10	0.5156	9.7	R95033/64	R96033/64	R97033/64
	13.20	0.5197	9.7	R95013.2	R96013.2	R97013.2
17/32	13.49	0.5313	9.7	R95017/32	R96017/32	R97017/32
	13.50	0.5315	10.3	R95013.5	R96013.5	R97013.5
	13.60	0.5354	10.3	R95013.6	R96013.6	R97013.6
	13.70	0.5394	10.3	R95013.7	R96013.7	R97013.7
	13.80	0.5433	10.3	R95013.8	R96013.8	R97013.8
35/64	13.89	0.5469	10.3	R95035/64	R96035/64	R97035/64
	14.00	0.5512	10.3	R95014.0	R96014.0	R97014.0
	14.10	0.5551	10.3	R95014.1	R96014.1	R97014.1
	14.20	0.5591	10.3	R95014.2	R96014.2	R97014.2
9/16	14.29	0.5625	10.3	R9509/16	R9609/16	R9709/16
	14.50	0.5709	10.3	R95014.5	R96014.5	R97014.5
	14.60	0.5748	11.0	R95014.6	R96014.6	R97014.6

DC h ₇ [inch]	DC h ₇ [mm]	DC [decimal inch]	OAL [mm]	R950	R960	R970
37/64	14.68	0.5781	11.0	R95037/64	R96037/64	R97037/64
	14.70	0.5787	11.0	R95014.7	R96014.7	R97014.7
	14.80	0.5827	11.0	R95014.8	R96014.8	R97014.8
	15.00	0.5906	11.0	R95015.0	R96015.0	R97015.0
19/32	15.08	0.5938	11.0	R95019/32	R96019/32	R97019/32
	15.10	0.5945	11.0	R95015.1	R96015.1	R97015.1
	15.20	0.5984	11.0	R95015.2	R96015.2	R97015.2
39/64	15.48	0.6094	11.0	R95039/64	R96039/64	R97039/64
	15.50	0.6102	11.0	R95015.5	R96015.5	R97015.5
	15.60	0.6142	11.6	R95015.6	R96015.6	R97015.6
	15.70	0.6181	11.6	R95015.7	R96015.7	R97015.7
5/8	15.88	0.6250	11.6	R9505/8	R9605/8	R9705/8
	16.00	0.6299	11.6	R95016.0	R96016.0	R97016.0
	16.10	0.6339	11.6	R95016.1	R96016.1	R97016.1
	16.20	0.6378	11.6	R95016.2	R96016.2	R97016.2
41/64	16.27	0.6406	11.6	R95041/64	R96041/64	R97041/64
	16.50	0.6496	11.6	R95016.5	R96016.5	R97016.5
	16.60	0.6535	12.2	R95016.6	R96016.6	R97016.6
21/32	16.67	0.6563	12.2	R95021/32	R96021/32	R97021/32
	16.70	0.6575	12.2	R95016.7	R96016.7	R97016.7
	17.00	0.6693	12.2	R95017.0	R96017.0	R97017.0
43/64	17.07	0.6719	12.2	R95043/64	R96043/64	R97043/64
	17.10	0.6732	12.2	R95017.1	R96017.1	R97017.1
	17.20	0.6772	12.2	R95017.2	R96017.2	R97017.2
11/16	17.46	0.6875	12.2	R95011/16	R96011/16	R97011/16
	17.50	0.6890	12.2	R95017.5	R96017.5	R97017.5
	17.60	0.6929	12.9	R95017.6	R96017.6	R97017.6
	17.70	0.6969	12.9	R95017.7	R96017.7	R97017.7
45/64	17.86	0.7031	12.9	R95045/64	R96045/64	R97045/64
	18.00	0.7087	12.9	R95018.0	R96018.0	R97018.0
	18.10	0.7126	12.9	R95018.1	R96018.1	R97018.1
	18.20	0.7165	12.9	R95018.2	R96018.2	R97018.2
23/32	18.26	0.7188	12.9	R95023/32	R96023/32	R97023/32
	18.50	0.7283	12.9	R95018.5	R96018.5	R97018.5
	18.60	0.7323	13.5	R95018.6	R96018.6	R97018.6
47/64	18.65	0.7344	13.5	R95047/64	R96047/64	R97047/64
	18.70	0.7362	13.5	R95018.7	R96018.7	R97018.7
	18.90	0.7441	13.5	R95018.9	R96018.9	R97018.9
	19.00	0.7480	13.5	R95019.0	R96019.0	R97019.0
3/4	19.05	0.7500	13.5	R9503/4	R9603/4	R9703/4
	19.10	0.7520	13.5	R95019.1	R96019.1	R97019.1
	19.20	0.7559	13.5	R95019.2	R96019.2	R97019.2
	19.25	0.7579	13.5	R95019.25	R96019.25	R97019.25
49/64	19.45	0.7656	13.5	R95049/64	R96049/64	R97049/64
	19.50	0.7677	13.5	R95019.5	R96019.5	R97019.5
	19.60	0.7717	14.1	R95019.6	R96019.6	R97019.6
	19.70	0.7756	14.1	R95019.7	R96019.7	R97019.7
25/32	19.84	0.7813	14.1	R95025/32	R96025/32	R97025/32
	20.00	0.7874	14.1	R95020.0	R96020.0	R97020.0
51/64	20.24	0.7969	14.1	R95051/64	R96051/64	R97051/64
	20.50	0.8071	14.1	R95020.5	R96020.5	R97020.5
13/16	20.64	0.8125	14.8	R95013/16	R96013/16	R97013/16
	21.00	0.8268	14.8	R95021.0	R96021.0	R97021.0
53/64	21.03	0.8281	14.8	R95053/64	R96053/64	R97053/64
27/32	21.43	0.8438	14.8	R95027/32	R96027/32	R97027/32
	21.50	0.8465	14.8	R95021.5	R96021.5	R97021.5
55/64	21.83	0.8594	15.0	R95055/64	R96055/64	R97055/64
	22.00	0.8661	15.0	R95022.0	R96022.0	R97022.0
7/8	22.22	0.8750	15.0	R9507/8	R9607/8	R9707/8
	22.50	0.8858	15.0	R95022.5	R96022.5	R97022.5
57/64	22.62	0.8906	15.0	R95057/64	R96057/64	R97057/64
	22.70	0.8937	15.0	R95022.7	R96022.7	R97022.7
	23.00	0.9055	15.1	R95023.0	R96023.0	R97023.0
29/32	23.02	0.9063	15.1	R95029/32	R96029/32	R97029/32
59/64	23.42	0.9219	15.1	R95059/64	R96059/64	R97059/64

DC h ₇ [inch]	DC h ₇ [mm]	DC [decimal inch]	OAL [mm]	R950	R960	R970
	23.50	0.9252	15.1	R95023.5	R96023.5	R97023.5
15/16	23.81	0.9375	15.4	R95015/16	R96015/16	R97015/16
	24.00	0.9449	15.4	R95024.0	R96024.0	R97024.0
61/64	24.21	0.9531	15.4	R95061/64	R96061/64	R97061/64
	24.50	0.9646	15.4	R95024.5	R96024.5	R97024.5
31/32	24.61	0.9688	15.4	R95031/32	R96031/32	R97031/32
	25.00	0.9844	15.8	R95025.0	R96025.0	R97025.0
63/64	25.00	0.9844	15.8	R95025.0	R96025.0	R97025.0
1"	25.40	1.0000	15.8	R9501	R9601	R9701
	25.50	1.0039	15.8	R95025.5	R96025.5	R97025.5
	25.65	1.0098	15.8	R95025.65	R96025.65	R97025.65
1.1/64	25.80	1.0156	15.8	R9501.1/64	R9601.1/64	R9701.1/64
	26.00	1.0236	16.4	R95026.0	R96026.0	R97026.0
1.1/32	26.19	1.0313	16.4	R9501.1/32	R9601.1/32	R9701.1/32
	26.50	1.0433	16.4	R95026.5	R96026.5	R97026.5
1.3/64	26.59	1.0469	16.4	R9501.3/64	R9601.3/64	R9701.3/64
1.1/16	26.99	1.0625	17.1	R9501.1/16	R9601.1/16	R9701.1/16
	27.00	1.0630	17.1	R95027.0	R96027.0	R97027.0
1.5/64	27.38	1.0781	17.1	R9501.5/64	R9601.5/64	R9701.5/64
	27.50	1.0827	17.1	R95027.5	R96027.5	R97027.5
1.3/32	27.78	1.0938	17.1	R9501.3/32	R9601.3/32	R9701.3/32
	28.00	1.1024	17.7	R95028.0	R96028.0	R97028.0
1.7/64	28.18	1.1094	17.7	R9501.7/64	R9601.7/64	R9701.7/64
	28.50	1.1220	17.7	R95028.5	R96028.5	R97028.5
1.1/8	28.58	1.1250	17.7	R9501.1/8	R9601.1/8	R9701.1/8
1.9/64	28.97	1.1406	18.3	R9501.9/64	R9601.9/64	R9701.9/64
	29.00	1.1417	18.3	R95029.0	R96029.0	R97029.0
1.5/32	29.37	1.1563	18.3	R9501.5/32	R9601.5/32	R9701.5/32
	29.50	1.1614	18.3	R95029.5	R96029.5	R97029.5
1.11/64	29.77	1.1719	18.3	R9501.11/64	R9601.11/64	R9701.11/64
	30.00	1.1811	19.0	R95030.0	R96030.0	R97030.0
1.3/16	30.16	1.1875	19.0	R9501.3/16	R9601.3/16	R9701.3/16
	30.50	1.2008	19.0	R95030.5	R96030.5	R97030.5
1.7/32	30.96	1.2188	21.0	R9501.7/32		R9701.7/32
	31.00	1.2205	21.0	R95031.0		R97031.0
1.1/4	31.75	1.2500	21.0	R9501.1/4		R9701.1/4
	32.00	1.2598	21.0	R95032.0		R97032.0
	32.50	1.2795	21.0	R95032.5		R97032.5
1.19/64	32.94	1.2969	21.0	R9501.19/64		R9701.19/64
	33.00	1.2992	21.0	R95033.0		R97033.0
	33.50	1.3189	21.0	R95033.5		R97033.5
	34.00	1.3386	23.0	R95034.0		R97034.0
1.11/32	34.13	1.3438	23.0	R9501.11/32		R9701.11/32
	34.50	1.3583	23.0	R95034.5		R97034.5
1.3/8	34.93	1.3750	23.0	R9501.3/8		R9701.3/8
	35.00	1.3780	23.0	R95035.0		R97035.0
	36.00	1.4173	23.0	R95036.0		R97036.0
1.27/64	36.12	1.4219	23.0	R9501.27/64		R9701.27/64
	36.50	1.4370	23.0	R95036.5		R97036.5
	37.00	1.4567	25.0	R95037.0		R97037.0
1.15/32	37.31	1.4688	25.0	R9501.15/32		R9701.15/32
	37.50	1.4764	25.0	R95037.5		R97037.5
	38.00	1.4961	25.0	R95038.0		R97038.0
1.1/2	38.10	1.5000	25.0	R9501.1/2		R9701.1/2
	38.50	1.5157	25.0	R95038.5		R97038.5
1.17/32	38.89	1.5313	25.0	R9501.17/32		R9701.17/32
	39.00	1.5354	25.0	R95039.0		R97039.0
	39.50	1.5551	25.0	R95039.5		R97039.5
1.9/16	39.69	1.5625	27.0	R9501.9/16		R9701.9/16
	40.00	1.5748	27.0	R95040.0		R97040.0
	41.00	1.6142	27.0	R95041.0		R97041.0
1.5/8	41.28	1.6250	27.0	R9501.5/8		R9701.5/8
	42.00	1.6535	27.0	R95042.0		R97042.0

H858

天龙钻刀体 1.5×D (倍径)。钻头刀体内包括 4 螺钉和 1 螺丝刀。

H853

天龙钻刀体 3×D。钻头刀体内包括 4 螺钉和 1 螺丝刀。

H855

天龙钻刀体 5×D。钻头刀体内包括 4 螺钉和 1 螺丝刀。

H858

天龙钻刀体 8×D。钻头刀体内包括 4 螺钉和 1 螺丝刀。

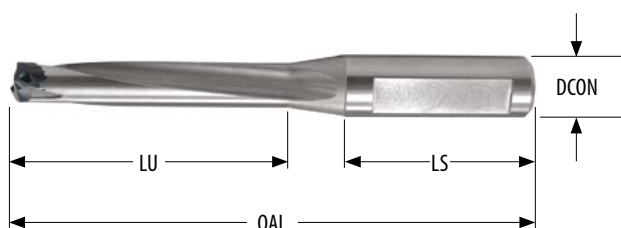
H8512

天龙钻刀体 12×D (倍径)。钻头刀体内包括 4 螺钉和 1 螺丝刀。

H851	应用于转速和进给量的初始值,校正系数为 1.10
H853	应用于转速和进给量的初始值,校正系数为 1.00
H855	应用于转速和进给量的初始值,校正系数为 0.95
H858	应用于转速和进给量的初始值,校正系数为 0.90
H8512	应用于转速和进给量的初始值,校正系数为 0.80

H851	HSS	DORMER	1.5XD			ISO 9766			
H853	HSS	DORMER	3XD			DIN 6535HB DIN 6535HE			
H855	HSS	DORMER	5XD			DIN 6535HB DIN 6535HE			
H858	HSS	DORMER	8XD			DIN 6535HE			
H8512	HSS	DORMER	12XD						

DORMER



H851	H853	H855	H858	H8512
NEW HYDRA	HYDRA	HYDRA	HYDRA	NEW HYDRA
12.0 – 30.0 31/64 – 1.3/16	12.0 – 42.5 31/64 – 1.3/16	12.0 – 42.5 31/64 – 1.3/16	14.0 – 42.5	14.0 – 25.0

DCON h ₆	DCON h ₆	LU	OAL	LS	ADINTMS	H851	H853	H855	H858	H8512
[inch]	[mm]	[mm]	[mm]	[mm]						
	16.00	25.5	88.5	48.0	ISO9766	H85112.0				
	16.00	44.0	105.0	48.0	DIN6535HE		H85312.0			
	16.00	69.0	130.0	48.0	DIN6535HE			H85512.0		
5/8	15.88	25.5	88.5	47.63		H85131/64				
5/8	15.88	44.0	105.0	48.0	DIN6535HB		H85331/64			
5/8	15.88	69.0	130.0	48.0	DIN6535HB			H85531/64		
	16.00	25.8	88.8	48.0	ISO9766	H85112.5				
	16.00	44.0	105.0	48.0	DIN6535HE		H85312.5			
	16.00	69.0	130.0	48.0	DIN6535HE			H85512.5		

DCON h ₆	DCON h ₆	LU	OAL	LS	ADINTMS	H851	H853	H855	H858	H8512
[inch]	[mm]	[mm]	[mm]	[mm]						
5/8	15.88	25.8	88.8	47.63		H8511/2				
5/8	15.88	44.0	105.0	48.0	DIN6535HB		H8531/2			
5/8	15.88	69.0	130.0	48.0	DIN6535HB			H8551/2		
	16.00	27.0	90.0	48.0	ISO9766	H85113.0				
	16.00	47.0	110.0	48.0	DIN6535HE		H85313.0			
	16.00	74.0	140.0	48.0	DIN6535HE			H85513.0		
5/8	15.88	30.9	93.9	47.63		H85117/32				
5/8	15.88	47.0	110.0	48.0	DIN6535HB		H85317/32			
5/8	15.88	74.0	140.0	48.0	DIN6535HB			H85517/32		
	16.00	30.9	93.9	48.0	DIN6535HE	H85114.0				
	16.00	52.5	116.5	48.0	DIN6535HE		H85314.0			
	16.00	81.5	146.5	48.0	DIN6535HE			H85514.0		
	16.00	124.5	191.5	48.0	DIN6535HE				H85814.0	
	16.00	168.0	236.0	48.0						H851214.0
3/4	19.05	30.3	93.9	50.8		H8519/16				
3/4	19.05	52.5	116.5	48.0	DIN6535HB		H8539/16			
3/4	19.05	81.5	146.5	48.0	DIN6535HB			H8559/16		
	20.00	32.3	97.3	50.0	ISO9766	H85115.0				
	20.00	55.5	126.5	50.0	DIN6535HE		H85315.0			
	20.00	86.5	156.5	50.0	DIN6535HE			H85515.0		
	20.00	133.5	201.5	50.0	DIN6535HE				H85815.0	
	20.00	180.0	250.3	50.0						H851215.0
3/4	19.05	32.3	97.3	50.8		H85139/64				
3/4	19.05	55.5	126.5	50.0	DIN6535HB		H85339/64			
3/4	19.05	86.5	156.5	50.0	DIN6535HB			H85539/64		
	20.00	34.9	99.9	50.0	ISO9766	H85116.0				
	20.00	59.5	131.5	50.0	DIN6535HE		H85316.0			
	20.00	92.5	166.5	50.0	DIN6535HE			H85516.0		
	20.00	141.5	211.5	50.0	DIN6535HE				H85816.0	
	20.00	192.0	262.6	50.0						H851216.0
3/4	19.05	34.9	99.9	50.8		H85141/64				
3/4	19.05	59.5	131.5	50.0	DIN6535HB		H85341/64			
3/4	19.05	92.5	166.5	50.0	DIN6535HB			H85541/64		
	20.00	36.4	101.4	50.0	ISO9766	H85117.0				
	20.00	62.5	136.5	50.0	DIN6535HE		H85317.0			
	20.00	97.5	171.5	50.0	DIN6535HE			H85517.0		
	20.00	150.5	221.5	50.0	DIN6535HE				H85817.0	
	20.00	204.0	275.0	50.0						H851217.0
3/4	19.05	36.4	101.4	50.8		H85111/16				
3/4	19.05	62.5	136.5	50.0	DIN6535HB		H85311/16			
3/4	19.05	97.5	171.5	50.0	DIN6535HB			H85511/16		
	20.00	39.0	104.0	50.0	ISO9766	H85118.0				
	20.00	66.5	141.5	50.0	DIN6535HE		H85318.0			
	20.00	103.5	176.5	50.0	DIN6535HE			H85518.0		
	20.00	158.5	226.5	50.0	DIN6535HE				H85818.0	
	20.00	216.0	287.2	50.0						H851218.0
3/4	19.05	39.0	104.0	50.8		H85123/32				
3/4	19.05	66.5	141.5	50.0	DIN6535HB		H85323/32			
3/4	19.05	103.5	176.5	50.0	DIN6535HB			H85523/32		
	25.00	40.4	111.4	56.0	ISO9766	H85119.0				
	25.00	69.5	156.5	56.0	DIN6535HE		H85319.0			
	25.00	108.5	191.5	56.0	DIN6535HE			H85519.0		
	25.00	167.5	251.5	56.0	DIN6535HE				H85819.0	
	25.00	228.0	305.6	56.0						H851219.0
1"	25.40	40.4	111.4	57.15		H85149/64				
1"	25.40	69.5	156.5	56.0	DIN6535HB		H85349/64			
1"	25.40	108.5	191.5	56.0	DIN6535HB			H85549/64		
	25.00	43.0	114.0	56.0	ISO9766	H85120.0				
	25.00	73.5	156.5	56.0	DIN6535HE		H85320.0			
	25.00	114.5	196.5	56.0	DIN6535HE			H85520.0		
	25.00	175.5	264.5	56.0	DIN6535HE				H85820.0	
	25.00	240.0	317.8	56.0						H851220.0

DCON h ₆ [inch]	DCON h ₆ [mm]	LU [mm]	OAL [mm]	LS [mm]	ADINTMS	H851	H853	H855	H858	H8512
1"	25.40	43.0	114.0	57.15		H85151/64				
1"	25.40	73.5	156.5	56.0	DIN6535HB		H85351/64			
1"	25.40	114.5	196.5	56.0	DIN6535HB			H85551/64		
	25.00	44.5	115.5	56.0	ISO9766	H85121.0				
	25.00	76.5	156.5	56.0	DIN6535HE		H85321.0			
	25.00	119.5	196.5	56.0	DIN6535HE			H85521.0		
	25.00	184.5	266.5	56.0	DIN6535HE				H85821.0	
	25.00	252.0	330.1	56.0						H851221.0
1"	25.40	44.5	115.5	57.15		H85127/32				
1"	25.40	76.5	156.5	56.0	DIN6535HB		H85327/32			
1"	25.40	119.5	196.5	56.0	DIN6535HB			H85527/32		
	25.00	46.1	117.1	56.0	ISO9766	H85122.0				
	25.00	80.1	161.5	56.0	DIN6535HE		H85322.0			
	25.00	125.1	201.1	56.0	DIN6535HE			H85522.0		
	25.00	192.1	271.1	56.0	DIN6535HE				H85822.0	
	25.00	264.0	343.0	56.0						H851222.0
1"	25.40	46.1	117.1	57.15		H85157/64				
1"	25.40	80.1	161.5	56.0	DIN6535HB		H85357/64			
1"	25.40	125.1	201.1	56.0	DIN6535HB			H85557/64		
	25.00	47.0	118.0	56.0	ISO9766	H85123.0				
	25.00	82.5	160.5	56.0	DIN6535HE		H85323.0			
	25.00	129.5	210.5	56.0	DIN6535HE			H85523.0		
	25.00	200.5	280.5	56.0	DIN6535HE				H85823.0	
	25.00	276.0	354.8	56.0						H851223.0
1"	25.40	47.0	118.0	57.15		H85159/64				
1"	25.40	82.5	160.5	56.0	DIN6535HB		H85359/64			
1"	25.40	129.5	210.5	56.0	DIN6535HB			H85559/64		
	32.00	49.3	124.3	60.0	ISO9766	H85124.0				
	32.00	86.2	170.2	60.0	DIN6535HE		H85324.0			
	32.00	135.2	220.2	60.0	DIN6535HE			H85524.0		
	32.00	208.2	295.2	60.0	DIN6535HE				H85824.0	
	32.00	288.0	371.7	60.0						H851224.0
1"	25.40	49.3	124.3	57.15		H85131/32				
1"	25.40	86.2	170.2	60.0	DIN6535HB		H85331/32			
1"	25.40	135.2	220.2	60.0	DIN6535HB			H85531/32		
	32.00	49.7	124.7	60.0	ISO9766	H85125.0				
	32.00	88.0	170.0	60.0	DIN6535HE		H85325.0			
	32.00	140.0	225.0	60.0	DIN6535HE			H85525.0		
	32.00	217.0	300.0	60.0	DIN6535HE				H85825.0	
	32.00	300.0	383.8	60.0						H851225.0
1.1/4	31.75	49.7	124.7	60.33		H8511.1/64				
1.1/4	31.75	88.0	170.0	60.0	DIN6535HB		H8531.1/64			
1.1/4	31.75	140.0	225.0	60.0	DIN6535HB			H8551.1/64		
	32.00	52.3	127.3	60.0	ISO9766	H85126.0				
	32.00	92.0	175.0	60.0	DIN6535HE		H85326.0			
	32.00	146.0	230.0	60.0	DIN6535HE			H85526.0		
	32.00	225.0	310.0	60.0	DIN6535HE				H85826.0	
1.1/4	31.75	52.3	127.3	60.33		H8511.3/64				
1.1/4	31.75	92.0	175.0	60.0	DIN6535HB		H8531.3/64			
1.1/4	31.75	146.0	230.0	60.0	DIN6535HB			H8551.3/64		
	32.00	52.8	127.8	60.0	ISO9766	H85127.0				
	32.00	94.0	175.0	60.0	DIN6535HE		H85327.0			
	32.00	151.0	235.0	60.0	DIN6535HE			H85527.0		
	32.00	234.0	320.0	60.0	DIN6535HE				H85827.0	
1.1/4	31.75	52.8	127.8	60.33		H8511.3/32				
1.1/4	31.75	94.0	175.0	60.0	DIN6535HB		H8531.3/32			
1.1/4	31.75	151.0	235.0	60.0	DIN6535HB			H8551.3/32		
	32.00	54.4	129.4	60.0	ISO9766	H85128.0				
	32.00	97.0	180.0	60.0	DIN6535HE		H85328.0			
	32.00	157.0	240.0	60.0	DIN6535HE			H85528.0		
	32.00	242.0	325.0	60.0	DIN6535HE				H85828.0	
1.1/4	31.75	54.4	129.4	60.33		H8511.1/8				

DCON h ₆	DCON h ₆	LU	OAL	LS	ADINTMS	H851	H853	H855	H858	H8512
[inch]	[mm]	[mm]	[mm]	[mm]						
1.1/4	31.75	97.0	180.0	60.0	DIN6535HB		H8531.1/8			
1.1/4	31.75	157.0	240.0	60.0	DIN6535HB			H8551.1/8		
	32.00	55.8	130.8	60.0	ISO9766	H85129.0				
	32.00	100.0	185.0	60.0	DIN6535HE		H85329.0			
	32.00	162.0	245.0	60.0	DIN6535HE			H85529.0		
	32.00	251.0	335.0	60.0	DIN6535HE				H85829.0	
1.1/4	31.75	55.8	130.8	60.33		H8511.11/64				
1.1/4	31.75	100.0	185.0	60.0	DIN6535HB		H8531.11/64			
1.1/4	31.75	162.0	245.0	60.0	DIN6535HB			H8551.11/64		
	32.00	58.4	133.4	60.0	ISO9766	H85130.0				
	32.00	104.0	185.0	60.0	DIN6535HE		H85330.0			
	32.00	167.0	255.0	60.0	DIN6535HE			H85530.0		
	32.00	259.0	345.0	60.0	DIN6535HE				H85830.0	
1.1/4	31.75	58.4	133.4	60.33		H8511.3/16				
1.1/4	31.75	104.0	185.0	60.0	DIN6535HB		H8531.3/16			
1.1/4	31.75	167.0	255.0	60.0	DIN6535HB			H8551.3/16		
	32.00	111.5	196.5	60.0	DIN6535HE		H85332.0			
	32.00	176.5	261.5	60.0	DIN6535HE			H85532.0		
	32.00	271.5	356.5	60.0	DIN6535HE				H85832.0	
	32.00	116.5	201.5	60.0	DIN6535HE		H85333.5			
	32.00	186.5	271.5	60.0	DIN6535HE			H85533.5		
	32.00	286.5	371.5	60.0	DIN6535HE				H85833.5	
	40.00	121.5	216.5	70.0	DIN6535HB		H85335.0			
	40.00	196.5	291.5	70.0	DIN6535HB			H85535.0		
	40.00	301.5	396.5	70.0	DIN6535HB				H85835.0	
	40.00	125.5	221.5	70.0	DIN6535HB		H85336.5			
	40.00	201.5	296.5	70.0	DIN6535HB			H85536.5		
	40.00	311.5	406.5	70.0	DIN6535HB				H85836.5	
	40.00	131.5	226.5	70.0	DIN6535HB		H85338.0			
	40.00	211.5	306.5	70.0	DIN6535HB			H85538.0		
	40.00	326.5	421.5	70.0	DIN6535HB				H85838.0	
	40.00	136.5	231.5	70.0	DIN6535HB		H85339.5			
	40.00	221.5	316.5	70.0	DIN6535HB			H85539.5		
	40.00	336.5	431.5	70.0	DIN6535HB				H85839.5	
	40.00	146.5	246.5	70.0	DIN6535HB		H85341.0			
	40.00	226.5	325.6	70.0	DIN6535HB			H85541.0		
	40.00	351.5	451.5	70.0	DIN6535HB				H85841.0	
	40.00	151.6	251.6	70.0	DIN6535HB		H85342.5			
	40.00	236.5	336.5	70.0	DIN6535HB			H85542.5		
	40.00	361.5	461.5	70.0	DIN6535HB				H85842.5	

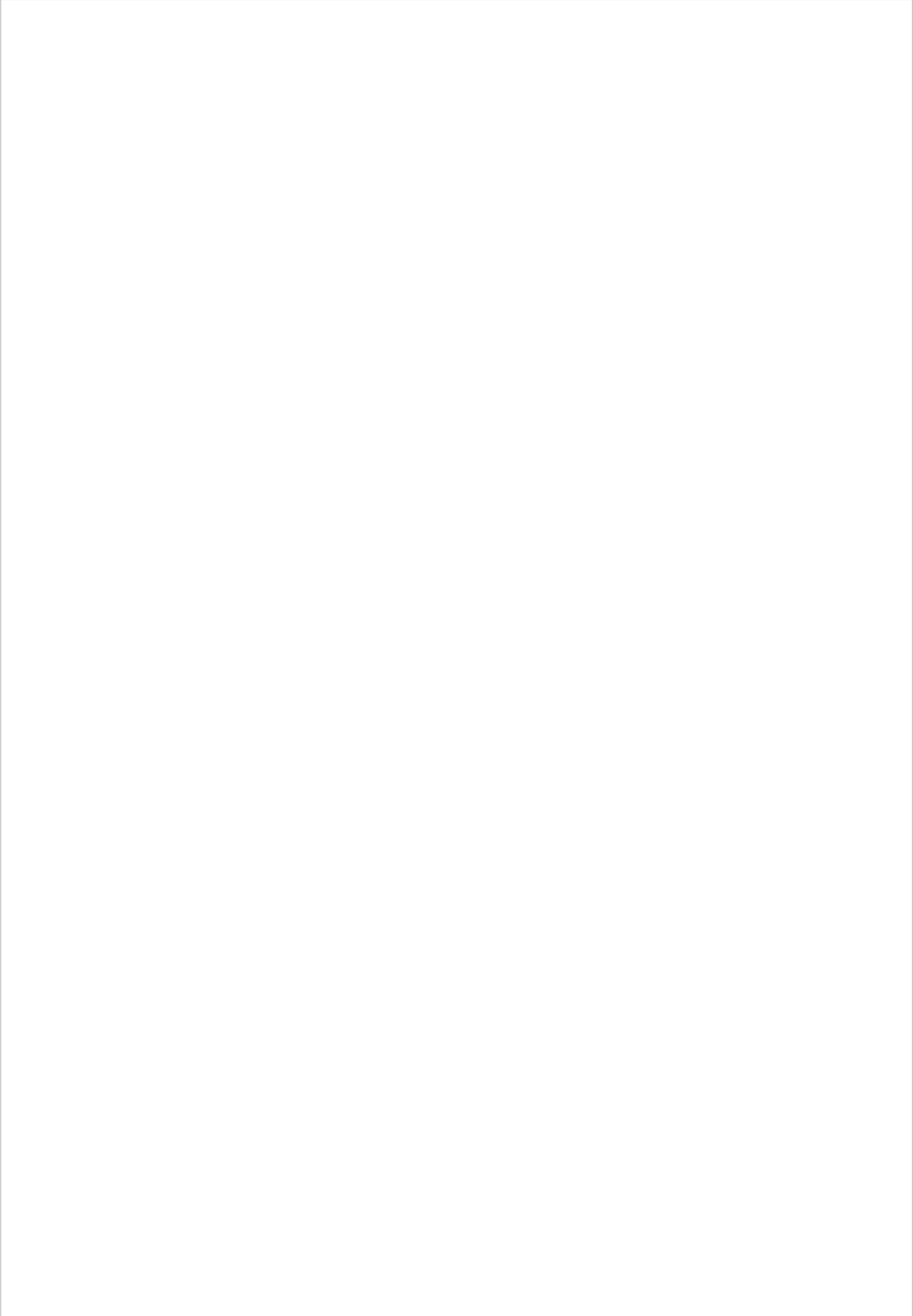
H860
H861

天龙钻用螺钉.
天龙钻用螺丝刀.



H860	H861
	
N1 - N7	N1 - N6

H860	H861
H860N7	H861N6
H860N6	H861N5
H860N5	H861N4
H860N4	H861N3
H860N3	
H860N2	H861N2
H860N1	H861N1



SIMPLY RELIABLE

作为你可以通过切屑判断工件质量的专业公司。该切屑是清洁和简单的形状这本身就在讲述了一个故事。这是一个清晰和一致的信号，这就是为什么我们使用它作为简洁可靠的符号。

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