

CoroDrill® 860 シリーズ

穴あけ工具カタログ
CD-050J



すべてを超えるドリル、CoroDrill® 860



あらゆる被削材に対応する
ハイスペック超硬ソリッドドリル!!

-PM (鋼用) P1BM	: $\phi 3.0 \sim 20.0$ 、 $L/D=3 \sim 5$ $\phi 3.0 \sim 16.0$ 、 $L/D=7 \sim 8$ $\phi 3.35 \sim 17.5$ 、 $L/D=3$ (面取り付き)
-MM (ステンレス鋼用) M2BM	: $\phi 3.0 \sim 20.0$ 、 $L/D=3 \sim 5$
-SD (ニッケル基耐熱合金用) S2BM	: $\phi 3.0 \sim 16.0$ 、 $L/D=3 \sim 8$ $\phi 3.35 \sim 17.5$ 、 $L/D=3$ (面取り付き)
-SM (チタン合金用) GC1210	: $\phi 3.0 \sim 15.87$ 、 $L/D=3 \sim 5$
-NM (アルミ合金用) H10F	: $\phi 3.0 \sim 20.0$ 、 $L/D=3 \sim 8$
-GM (全被削材用) X1BM	: $\phi 3.0 \sim 16.0$ 、 $L/D=3 \sim 8$

- 各仕様ごとに刃先形状、材種、フルート形状などを最適化
- 高生産性と高精度を、とことん追求したプレミアムモデル
- テーラードにより、短納期でカスタマイズ可能

CoroDrill® 860シリーズ

各ドリルの
加工動画は
こちら

被削材別超硬ソリッドドリル

各被削材に対応

-PM



-MM



-NM



-SD



-SM

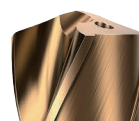


全被削材対応

超硬ソリッドドリル

あらゆる被削材に対応

-GM

超硬ソリッドドリル
製品の選定基準

	ISO P	ISO M	ISO K	ISO N	ISO S	ISO H	ISO O
V 汎用	CoroDrill® 460-XM GC34						
O 最適化	860-PM P1BM	860-MM M2BM	860-GM X1BM CD400 CD430	860-NM H10F CD400 CD430	860-SD S2BM 860-SM GC1210	860-GM X1BM	854 863 N20C H10F
	CoroDrill® 860-GM X1BM						

製品ポートフォリオ

V

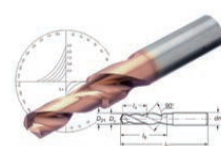
汎用性ソリューション

高い適応性とコスト効率を実現する
高性能製品のラインナップ**O**

最適化ソリューション

特定のニーズを満たすために
改良されたユニークな製品ラインで、
抜群の効率、信頼性、耐久性を提供**C**

カスタマイズソリューション

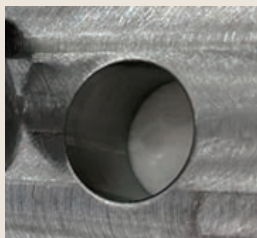
Tailor
Madeテーラーメイドおよび応用特殊品、
性能に関する高い要求を
満たすために個別に設計

CoroDrill® 860-PM



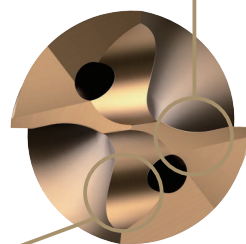
- 鋼専用ドリル
- 低切削抵抗
- 抜けバリの抑制
- 優れた切りくず処理
- 安定した摩耗 ➡ 予測可能な寿命
- コーティング：TiAlSiN+TiSiN

CoroDrill® 860-PM
穴出口の様子
Φ10、3xD
熱間圧延軟鋼板
切削速度：250m/min
回転送り：0.39mm/回転



刃先プレパレーション

▶高度に制御した刃先処理



新しいシンニングタイプ

▶切削抵抗とスラスト力を低減

▶優れた穴精度

▶切りくず生成を改善



フルート形状

▶切りくず排出を助ける

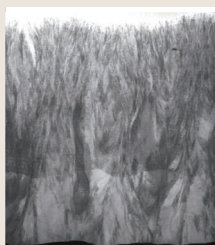
大きなフルート

NEW CoroDrill® 860-MM



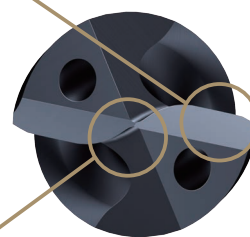
- ステンレス鋼に特化したドリル
- Zertivo® 2.0 コーティング技術
- コーティング：TiAlSiN
- 低切削抵抗

Zertivo® 2.0 テクノロジー
多層コート
アブレイシブ摩耗の抑制



刃先プレパレーション

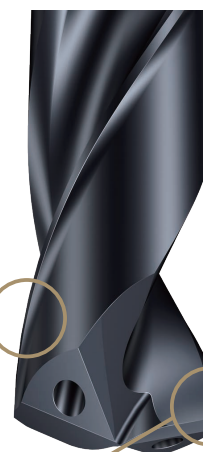
▶強化された刃先は長寿命を実現



最適化されたチゼル

▶低切削抵抗

▶優れた穴位置精度



マージン

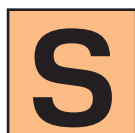
▶熱の抑制

▶安定性の向上

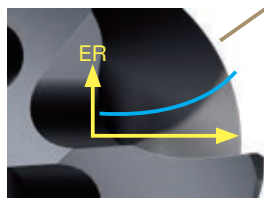
エッジライン
の補強

▶耐チップング

CoroDrill® 860-SD



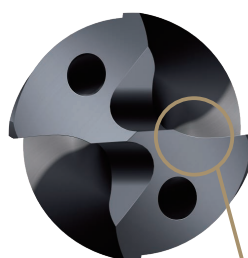
- ニッケル基耐熱合金専用ドリル
- Zertivo® 2.0 コーティング技術
- コーティング：TiAlSiN
- 低切削抵抗



切れ刃形状

▶制御されたホーニング処理

▶厳しい穴精度にも対応



フルート

▶ポリッシュ

▶抜群の切りくず排出性



ダブルマージン

CoroDrill® 860-NM



- 非鉄・アルミ専用ドリル
- ユニークな刃先設計によるバリ抑制
- 構成刃先の抑制
- 材種は超硬ノンコート「H10F」
- テーラーメイドでDLCコートも製作可

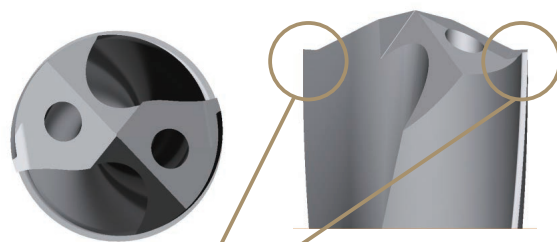
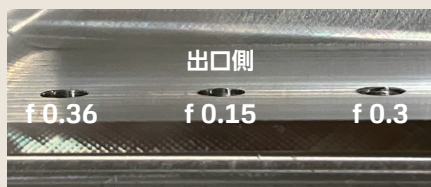
CoroDrill®860-NM

出口バリの様子

φ6

被削材：ADC12

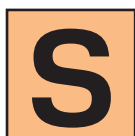
切削速度：188 m/min



切れ刃形状

- ▶食いつき時のカエリ抑制
- ▶抜け際のバリ抑制

CoroDrill® 860-SM

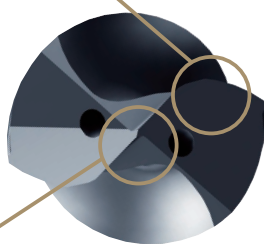


- チタン合金専用ドリル
- 多層コート
- 高いセンタリング能力
- 従来ドリルと比較して長寿命
- コーティング：AlTiN



複合曲線切れ刃

- ▶きれいに形成されたS字状



最適化されたシンニング形状

- ▶低切削抵抗
- ▶優れた穴位置精度



サンドビック・コロマント テーラーメイド

特注のこだわりを
シンプルに、そして迅速に...



こんな時は！ テーラーメイドがお役に立ちます。

- ▶ドリル径を変更したい
- ▶ドリルの先端角を変更したい
- ▶全長・刃長を変更したい
- ▶段付きドリルがあれば...
- ▶面取り刃や座ぐり刃付きのドリルが欲しい

Tailor
Made

テーラーメイドウェブでは、オンライン上でテーラーメイド製品を設計し、型番取得や2D/3D CADデータをその場で出力することが可能です。*ご利用にはウェブサイトのアカウント登録が必要です。

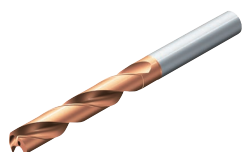
テーラーメイドウェブ

<https://www.sandvik.coromant.com/ja-jp/products/pages/customized-tools.aspx>



CoroDrill® 860-PM (鋼用)

円筒シャンク

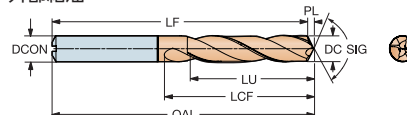


ドリル径: 3.00 - 20.00 mm
 加工深さ: 3 - 8 × DC
 加工公差の目安: H8 - H9
 切削油: 水溶性または不水溶性
 シャンク公差: h6

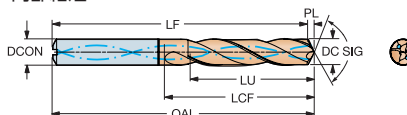


材質: P1BM(超硬コーティング)

外部給油



内部給油

Tailor
Made

ドリル径公差DC

ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

LU = 最大加工深さ

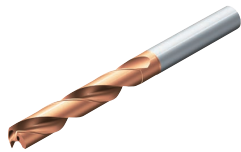
P

ドリル径 DC mm	加工深さ L/D	型番 外部給油	寸法, mm							型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG		DCON	LU	OAL	LF	LCF	PL	SIG
3.00	3	860.1-0300-016A0-PM	6.0	9.5	62	61.5	20	0.4	147°	860.1-0300-016A1-PM	6.0	9.5	62	61.5	20	0.4	147°
	5	860.1-0300-021A0-PM	6.0	15.5	66	65.5	28	0.4	147°	860.1-0300-021A1-PM	6.0	15.5	66	65.5	28	0.4	147°
	8	-	-	-	-	-	-	-	-	860.1-0300-029A1-PM	6.0	24.5	74	73.5	34	0.4	147°
3.10	3	860.1-0310-016A0-PM	6.0	9.8	62	61.5	20	0.5	147°	860.1-0310-016A1-PM	6.0	9.8	62	61.5	20	0.5	147°
	5	860.1-0310-021A0-PM	6.0	16.0	66	65.5	28	0.5	147°	860.1-0310-021A1-PM	6.0	16.0	66	65.5	28	0.5	147°
	8	-	-	-	-	-	-	-	-	860.1-0310-029A1-PM	6.0	25.3	74	73.5	34	0.5	147°
3.17	3	-	-	-	-	-	-	-	-	860.1-0317-016A1-PM	6.0	10.0	62	61.5	20	0.5	147°
	5	-	-	-	-	-	-	-	-	860.1-0317-021A1-PM	6.0	16.4	66	65.5	28	0.5	147°
	8	-	-	-	-	-	-	-	-	860.1-0317-029A1-PM	6.0	25.9	74	73.5	34	0.5	147°
3.20	3	860.1-0320-016A0-PM	6.0	10.1	62	61.5	20	0.5	147°	860.1-0320-016A1-PM	6.0	10.1	62	61.5	20	0.5	147°
	5	860.1-0320-021A0-PM	6.0	16.5	66	65.5	28	0.5	147°	860.1-0320-021A1-PM	6.0	16.5	66	65.5	28	0.5	147°
	8	-	-	-	-	-	-	-	-	860.1-0320-029A1-PM	6.0	26.1	74	73.5	34	0.5	147°
3.30	3	860.1-0330-016A0-PM	6.0	10.5	62	61.4	20	0.5	147°	860.1-0330-016A1-PM	6.0	10.5	62	61.4	20	0.5	147°
	5	860.1-0330-021A0-PM	6.0	17.1	66	65.4	28	0.5	147°	860.1-0330-021A1-PM	6.0	17.1	66	65.4	28	0.5	147°
	8	-	-	-	-	-	-	-	-	860.1-0330-029A1-PM	6.0	27.0	74	73.4	35	0.5	147°
3.38	5	860.1-0338-021A0-PM	6.0	17.5	66	65.4	28	0.5	147°	-	-	-	-	-	-	-	-
	3	860.1-0340-016A0-PM	6.0	10.8	62	61.4	20	0.5	147°	860.1-0340-016A1-PM	6.0	10.8	62	61.4	20	0.5	147°
	5	860.1-0340-021A0-PM	6.0	17.6	66	65.4	28	0.5	147°	860.1-0340-021A1-PM	6.0	17.6	66	65.4	28	0.5	147°
3.40	8	-	-	-	-	-	-	-	-	860.1-0340-029A1-PM	6.0	27.5	74	73.4	35	0.5	147°
	3	-	-	-	-	-	-	-	-	860.1-0345-016A1-PM	6.0	10.9	62	61.4	20	0.5	147°
	5	-	-	-	-	-	-	-	-	860.1-0345-021A1-PM	6.0	17.8	66	65.4	28	0.5	147°
3.45	8	-	-	-	-	-	-	-	-	860.1-0345-029A1-PM	6.0	27.4	74	73.4	35	0.5	147°
3.50	3	860.1-0350-016A0-PM	6.0	11.1	62	61.4	20	0.5	147°	860.1-0350-016A1-PM	6.0	11.1	62	61.4	20	0.5	147°
	5	860.1-0350-021A0-PM	6.0	18.1	66	65.4	28	0.5	147°	860.1-0350-021A1-PM	6.0	18.1	66	65.4	28	0.5	147°
	8	-	-	-	-	-	-	-	-	860.1-0350-029A1-PM	6.0	27.3	74	73.4	35	0.5	147°
3.55	3	-	-	-	-	-	-	-	-	860.1-0355-016A1-PM	6.0	11.2	62	61.4	20	0.5	147°
	3	-	-	-	-	-	-	-	-	860.1-0357-016A1-PM	6.0	11.3	62	61.4	20	0.5	147°
	5	-	-	-	-	-	-	-	-	860.1-0357-021A1-PM	6.0	18.5	66	65.4	28	0.5	147°
3.57	8	-	-	-	-	-	-	-	-	860.1-0357-029A1-PM	6.0	27.1	74	73.4	35	0.5	147°
3.60	3	860.1-0360-016A0-PM	6.0	11.4	62	61.4	20	0.5	147°	860.1-0360-016A1-PM	6.0	11.4	62	61.4	20	0.5	147°
	5	860.1-0360-021A0-PM	6.0	18.6	66	65.4	28	0.5	147°	860.1-0360-021A1-PM	6.0	18.6	66	65.4	28	0.5	147°
	8	-	-	-	-	-	-	-	-	860.1-0360-029A1-PM	6.0	27.1	74	73.4	35	0.5	147°
3.70	3	860.1-0370-016A0-PM	6.0	11.7	62	61.4	20	0.5	147°	860.1-0370-016A1-PM	6.0	11.7	62	61.4	20	0.5	147°
	5	860.1-0370-021A0-PM	6.0	19.1	66	65.4	28	0.5	147°	860.1-0370-021A1-PM	6.0	19.1	66	65.4	28	0.5	147°
	8	-	-	-	-	-	-	-	-	860.1-0370-029A1-PM	6.0	27.9	74	73.4	36	0.5	147°
3.80	3	860.1-0380-018A0-PM	6.0	12.1	66	65.3	24	0.6	147°	860.1-0380-018A1-PM	6.0	12.1	66	65.3	24	0.6	147°
	5	860.1-0380-027A0-PM	6.0	19.7	74	73.3	36	0.6	147°	860.1-0380-027A1-PM	6.0	19.7	74	73.3	36	0.6	147°
	8	-	-	-	-	-	-	-	-	860.1-0380-037A1-PM	6.0	31.1	85	84.3	44	0.6	147°
3.90	3	860.1-0390-018A0-PM	6.0	12.4	66	65.3	24	0.6	147°	860.1-0390-018A1-PM	6.0	12.4	66	65.3	24	0.6	147°
	5	860.1-0390-027A0-PM	6.0	20.2	74	73.3	36	0.6	147°	860.1-0390-027A1-PM	6.0	20.2	74	73.3	36	0.6	147°
	8	-	-	-	-	-	-	-	-	860.1-0390-037A1-PM	6.0	31.9	85	84.3	44	0.6	147°
3.97	3	-	-	-	-	-	-	-	-	860.1-0397-018A1-PM	6.0	12.6	66	65.3	24	0.6	147°
	5	-	-	-	-	-	-	-	-	860.1-0397-027A1-PM	6.0	20.5	74	73.3	36	0.6	147°
	8	-	-	-	-	-	-	-	-	860.1-0397-037A1-PM	6.0	32.4	85	84.3	44	0.6	147°
4.00	3	860.1-0400-018A0-PM	6.0	12.7	66	65.3	24	0.6	147°	860.1-0400-018A1-PM	6.0	12.7	66	65.3	24	0.6	147°
	5	860.1-0400-027A0-PM	6.0	20.7	74	73.3	36	0.6	147°	860.1-0400-027A1-PM	6.0	20.7	74	73.3	36	0.6	147°
	8	-	-	-	-	-	-	-	-	860.1-0400-037A1-PM	6.0	32.7	85	84.3	44	0.6	147°
4.10	3	860.1-0410-018A0-PM	6.0	13.0	66	65.3	24	0.6	147°	860.1-0410-018A1-PM	6.0	13.0	66	65.3	24	0.6	147°
	5	860.1-0410-027A0-PM	6.0	21.2	74	73.3	36	0.6	147°	860.1-0410-027A1-PM	6.0	21.2	74	73.3	36	0.6	147°
	8	-	-	-	-	-	-	-	-	860.1-0410-037A1-PM	6.0	33.5	85	84.3	45	0.6	147°
4.20	3	860.1-0420-018A0-PM	6.0	13.3	66	65.3	24	0.6	147°	860.1-0420-018A1-PM	6.0	13.3	66	65.3	24	0.6	147°
	5	860.1-0420-027A0-PM	6.0	21.7	74	73.3	36	0.6	147°	860.1-0420-027A1-PM	6.0	21.7	74	73.3	36	0.6	147°
	8	-	-	-	-	-	-	-	-	860.1-0420-037A1-PM	6.0	34.3	85	84.3	45	0.6	147°
4.30	3	860.1-0430-018A0-PM	6.0	13.7	66	65.2	24	0.6	147°	860.1-0430-018A1-PM	6.0	13.7	66	65.2	24	0.6	147°
	5	860.1-0430-027A0-PM	6.0	22.3	74	73.2	36	0.6	147°	860.1-0430-027A1-PM	6.0	22.3	74	73.2	36	0.6	147°
	8	-	-	-	-	-	-	-	-	860.1-0430-037A1-PM	6.0	35.2	85	84.2	45	0.6	147°

注文例: 860.1-0300-016A0-PM P1BM 10本

CoroDrill® 860-PM (鋼用)

円筒シャンク

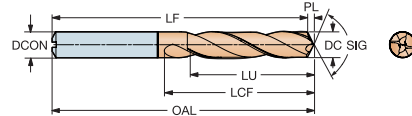


ドリル径: 3.00 - 20.00 mm
 加工深さ: 3 - 8 × DC
 加工公差の目安: H8 - H9
 切削油: 水溶性または不水溶性
 シャンク公差: h6

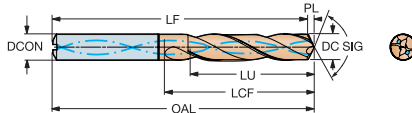


材種: P1BM(超硬コーティング)

外部給油



内部給油

Tailor
Made

ドリル径公差DC	
ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

LU = 最大加工深さ

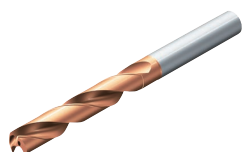
P

ドリル径 DC mm	加工深さ L/D	型番 外部給油	寸法, mm							型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG		DCON	LU	OAL	LF	LCF	PL	SIG
4.36	3	-	-	-	-	-	-	-	-	860.1-0436-018A1-PM	6.0	13.8	66	65.2	24	0.6	147°
	5	-	-	-	-	-	-	-	-	860.1-0436-027A1-PM	6.0	22.6	74	73.2	36	0.6	147°
	8	-	-	-	-	-	-	-	-	860.1-0436-037A1-PM	6.0	35.6	85	84.2	45	0.6	147°
4.40	3	860.1-0440-018A0-PM	6.0	14.0	66	65.2	24	0.7	147°	860.1-0440-018A1-PM	6.0	14.0	66	65.2	24	0.7	147°
	5	860.1-0440-027A0-PM	6.0	22.8	74	73.2	36	0.7	147°	860.1-0440-027A1-PM	6.0	22.8	74	73.2	36	0.7	147°
	8	-	-	-	-	-	-	-	-	860.1-0440-037A1-PM	6.0	36.0	85	84.2	45	0.7	147°
4.50	3	860.1-0450-018A0-PM	6.0	14.3	66	65.2	24	0.7	147°	860.1-0450-018A1-PM	6.0	14.3	66	65.2	24	0.7	147°
	5	860.1-0450-027A0-PM	6.0	23.3	74	73.2	36	0.7	147°	860.1-0450-027A1-PM	6.0	23.3	74	73.2	36	0.7	147°
	8	-	-	-	-	-	-	-	-	860.1-0450-037A1-PM	6.0	36.8	85	84.2	46	0.7	147°
4.55	3	-	-	-	-	-	-	-	-	860.1-0455-018A1-PM	6.0	14.4	66	65.2	24	0.7	147°
	5	860.1-0455-027A0-PM	6.0	23.5	74	73.2	36	0.7	147°	860.1-0455-027A1-PM	6.0	23.5	74	73.2	36	0.7	147°
	8	-	-	-	-	-	-	-	-	860.1-0455-037A1-PM	6.0	36.8	85	84.2	46	0.7	147°
4.60	3	860.1-0460-018A0-PM	6.0	14.6	66	65.2	24	0.7	147°	860.1-0460-018A1-PM	6.0	14.6	66	65.2	24	0.7	147°
	5	860.1-0460-027A0-PM	6.0	23.8	74	73.2	36	0.7	147°	860.1-0460-027A1-PM	6.0	23.8	74	73.2	36	0.7	147°
	8	-	-	-	-	-	-	-	-	860.1-0460-037A1-PM	6.0	36.8	85	84.2	46	0.7	147°
4.70	3	860.1-0470-018A0-PM	6.0	14.6	66	65.2	24	0.7	147°	860.1-0470-018A1-PM	6.0	14.6	66	65.2	24	0.7	147°
	5	860.1-0470-027A0-PM	6.0	24.3	74	73.2	36	0.7	147°	860.1-0470-027A1-PM	6.0	24.3	74	73.2	36	0.7	147°
	8	-	-	-	-	-	-	-	-	860.1-0470-037A1-PM	6.0	36.6	85	84.2	46	0.7	147°
4.76	3	-	-	-	-	-	-	-	-	860.1-0476-019A1-PM	6.0	15.0	66	65.2	28	0.7	147°
	5	-	-	-	-	-	-	-	-	860.1-0476-037A1-PM	6.0	36.5	97	96.2	46	0.7	147°
	8	-	-	-	-	-	-	-	-	860.1-0476-047A1-PM	6.0	38.8	97	96.2	56	0.7	147°
4.80	3	860.1-0480-019A0-PM	6.0	15.2	72	65.2	28	0.7	147°	860.1-0480-019A1-PM	6.0	15.2	72	65.2	28	0.7	147°
	5	860.1-0480-037A0-PM	6.0	24.8	87	81.2	44	0.7	147°	860.1-0480-037A1-PM	6.0	24.8	87	81.2	44	0.7	147°
	8	-	-	-	-	-	-	-	-	860.1-0480-047A1-PM	6.0	39.2	97	96.2	56	0.7	147°
4.90	3	860.1-0490-019A0-PM	6.0	15.5	72	65.2	28	0.7	147°	860.1-0490-019A1-PM	6.0	15.5	72	65.2	28	0.7	147°
	5	860.1-0490-037A0-PM	6.0	25.3	87	81.2	44	0.7	147°	860.1-0490-037A1-PM	6.0	25.3	87	81.2	44	0.7	147°
	8	-	-	-	-	-	-	-	-	860.1-0490-047A1-PM	6.0	40.0	97	96.2	56	0.7	147°
5.00	3	860.1-0500-019A0-PM	6.0	15.8	72	65.2	28	0.7	147°	860.1-0500-019A1-PM	6.0	15.8	72	65.2	28	0.7	147°
	5	860.1-0500-037A0-PM	6.0	25.8	87	81.2	44	0.7	147°	860.1-0500-037A1-PM	6.0	25.8	87	81.2	44	0.7	147°
	8	-	-	-	-	-	-	-	-	860.1-0500-047A1-PM	6.0	40.8	97	96.2	57	0.7	147°
5.10	3	860.1-0510-019A0-PM	6.0	16.1	72	65.2	28	0.8	147°	860.1-0510-019A1-PM	6.0	16.1	72	65.2	28	0.8	147°
	5	860.1-0510-037A0-PM	6.0	26.3	87	81.2	44	0.8	147°	860.1-0510-037A1-PM	6.0	26.3	87	81.2	44	0.8	147°
	8	-	-	-	-	-	-	-	-	860.1-0510-047A1-PM	6.0	41.6	97	96.2	57	0.8	147°
5.16	3	-	-	-	-	-	-	-	-	860.1-0516-019A1-PM	6.0	16.3	72	65.2	28	0.8	147°
	5	-	-	-	-	-	-	-	-	860.1-0516-037A1-PM	6.0	26.6	87	81.2	44	0.8	147°
	8	-	-	-	-	-	-	-	-	860.1-0516-047A1-PM	6.0	42.1	97	96.2	57	0.8	147°
5.20	3	860.1-0520-019A0-PM	6.0	16.4	72	65.2	28	0.8	147°	860.1-0520-019A1-PM	6.0	16.4	72	65.2	28	0.8	147°
	5	860.1-0520-037A0-PM	6.0	26.8	87	81.2	44	0.8	147°	860.1-0520-037A1-PM	6.0	26.8	87	81.2	44	0.8	147°
	8	-	-	-	-	-	-	-	-	860.1-0520-047A1-PM	6.0	42.4	97	96.2	57	0.8	147°
5.25	5	-	-	-	-	-	-	-	-	860.1-0525-037A1-PM	6.0	27.1	87	81.2	44	0.8	147°
5.30	3	860.1-0530-019A0-PM	6.0	16.7	72	65.2	28	0.8	147°	860.1-0530-019A1-PM	6.0	16.7	72	65.2	28	0.8	147°
	5	860.1-0530-037A0-PM	6.0	27.3	87	81.2	44	0.8	147°	860.1-0530-037A1-PM	6.0	27.3	87	81.2	44	0.8	147°
	8	-	-	-	-	-	-	-	-	860.1-0530-047A1-PM	6.0	43.2	97	96.2	57	0.8	147°
5.40	3	860.1-0540-019A0-PM	6.0	17.0	72	65.2	28	0.8	147°	860.1-0540-019A1-PM	6.0	17.0	72	65.2	28	0.8	147°
	5	860.1-0540-037A0-PM	6.0	27.8	87	81.2	44	0.8	147°	860.1-0540-037A1-PM	6.0	27.8	87	81.2	44	0.8	147°
	8	-	-	-	-	-	-	-	-	860.1-0540-047A1-PM	6.0	44.0	97	96.2	57	0.8	147°
5.50	3	860.1-0550-019A0-PM	6.0	17.4	72	65.1	28	0.8	147°	860.1-0550-019A1-PM	6.0	17.4	72	65.1	28	0.8	147°
	5	860.1-0550-037A0-PM	6.0	28.4	87	81.1	44	0.8	147°	860.1-0550-037A1-PM	6.0	28.4	87	81.1	44	0.8	147°
	8	-	-	-	-	-	-	-	-	860.1-0550-047A1-PM	6.0	44.9	97	96.1	57	0.8	147°
5.55	5	-	-	-	-	-	-	-	-	860.1-0555-037A1-PM	6.0	28.7	87	81.1	44	0.8	147°
	3	-	-	-	-	-	-	-	-	860.1-0556-019A1-PM	6.0	17.5	72	65.1	28	0.8	147°
	5	-	-	-	-	-	-	-	-	860.1-0556-037A1-PM	6.0	28.7	87	81.1	44	0.8	147°
5.60	3	860.1-0560-019A0-PM	6.0	17.7	72	65.1	28	0.8	147°	860.1-0560-019A1-PM	6.0	17.7	72	65.1	28	0.8	147°
	5	860.1-0560-037A0-PM	6.0	28.9	87	81.1	44	0.8	147°	860.1-0560-037A1-PM	6.0	28.9	87	81.1	44	0.8	147°
	8	-	-	-	-	-	-	-	-	860.1-0560-047A1-PM	6.0	45.7	97	96.1	58	0.8	147°

注文例: 860.1-0300-016A0-PM P1BM 10 本

CoroDrill® 860-PM (鋼用)

円筒シャンク

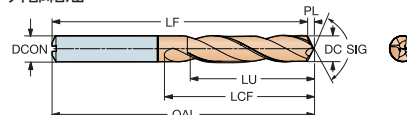


ドリル径: 3.00 - 20.00 mm
 加工深さ: 3 - 8 × DC
 加工公差の目安: H8 - H9
 切削油: 水溶性または不水溶性
 シャンク公差: h6

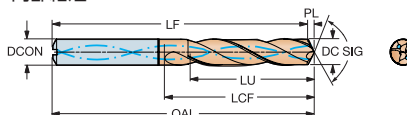


材種: P1BM(超硬コーティング)

外部給油



内部給油

Tailor
Made

ドリル径公差DC

ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

LU = 最大加工深さ

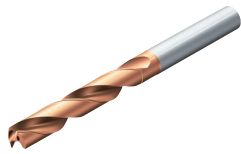
P

ドリル径 DC mm	加工深さ L/D	型番 外部給油	寸法, mm							型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG		DCON	LU	OAL	LF	LCF	PL	SIG
5.70	3	860.1-0570-019A0-PM	6.0	17.7	72	65.1	28	0.8	147°	860.1-0570-019A1-PM	6.0	17.7	72	65.1	28	0.8	147°
	5	860.1-0570-037A0-PM	6.0	29.4	87	81.1	44	0.8	147°	860.1-0570-037A1-PM	6.0	29.4	87	81.1	44	0.8	147°
	8	-	-	-	-	-	-	-	-	860.1-0570-047A1-PM	6.0	46.5	97	96.1	58	0.8	147°
5.80	3	860.1-0580-019A0-PM	6.0	17.6	72	65.1	28	0.9	147°	860.1-0580-019A1-PM	6.0	17.6	72	65.1	28	0.9	147°
	5	860.1-0580-037A0-PM	6.0	29.9	87	81.1	44	0.9	147°	860.1-0580-037A1-PM	6.0	29.9	87	81.1	44	0.9	147°
	8	-	-	-	-	-	-	-	-	860.1-0580-047A1-PM	6.0	47.0	97	96.1	58	0.9	147°
5.90	3	860.1-0590-019A0-PM	6.0	17.4	72	65.1	28	0.9	147°	860.1-0590-019A1-PM	6.0	17.4	72	65.1	28	0.9	147°
	5	860.1-0590-037A0-PM	6.0	30.4	87	81.1	44	0.9	147°	860.1-0590-037A1-PM	6.0	30.4	87	81.1	44	0.9	147°
	8	-	-	-	-	-	-	-	-	860.1-0590-047A1-PM	6.0	47.0	97	96.1	58	0.9	147°
5.95	3	-	-	-	-	-	-	-	-	860.1-0595-019A1-PM	6.0	17.3	72	65.1	28	0.9	147°
	5	-	-	-	-	-	-	-	-	860.1-0595-037A1-PM	6.0	30.7	87	81.1	44	0.9	147°
	8	-	-	-	-	-	-	-	-	860.1-0595-047A1-PM	6.0	47.0	97	96.1	58	0.9	147°
6.00	3	860.1-0600-019A0-PM	6.0	18.9	72	65.1	28	0.9	147°	860.1-0600-019A1-PM	6.0	18.9	72	65.1	28	0.9	147°
	5	860.1-0600-037A0-PM	6.0	30.9	87	81.1	44	0.9	147°	860.1-0600-037A1-PM	6.0	30.9	87	81.1	44	0.9	147°
	8	-	-	-	-	-	-	-	-	860.1-0600-047A1-PM	6.0	47.0	97	96.1	58	0.9	147°
6.10	3	860.1-0610-024A0-PM	8.0	19.3	79	78.0	34	0.9	147°	860.1-0610-024A1-PM	8.0	19.3	79	78.0	34	0.9	147°
	5	860.1-0610-040A0-PM	8.0	31.5	91	90.0	53	0.9	147°	860.1-0610-040A1-PM	8.0	31.5	91	90.0	53	0.9	147°
	8	-	-	-	-	-	-	-	-	860.1-0610-055A1-PM	8.0	49.8	106	105.0	66	0.9	147°
6.20	3	860.1-0620-024A0-PM	8.0	19.6	79	78.0	34	0.9	147°	860.1-0620-024A1-PM	8.0	19.6	79	78.0	34	0.9	147°
	5	860.1-0620-040A0-PM	8.0	32.0	91	90.0	53	0.9	147°	860.1-0620-040A1-PM	8.0	32.0	91	90.0	53	0.9	147°
	8	-	-	-	-	-	-	-	-	860.1-0620-055A1-PM	8.0	50.6	106	105.0	67	0.9	147°
6.30	3	860.1-0630-024A0-PM	8.0	19.9	79	78.0	34	0.9	147°	860.1-0630-024A1-PM	8.0	19.9	79	78.0	34	0.9	147°
	5	860.1-0630-040A0-PM	8.0	32.5	91	90.0	53	0.9	147°	860.1-0630-040A1-PM	8.0	32.5	91	90.0	53	0.9	147°
	8	-	-	-	-	-	-	-	-	860.1-0630-055A1-PM	8.0	51.4	106	105.0	67	0.9	147°
6.35	3	-	-	-	-	-	-	-	-	860.1-0635-024A1-PM	8.0	20.1	79	78.0	34	0.9	147°
	5	-	-	-	-	-	-	-	-	860.1-0635-040A1-PM	8.0	32.8	91	90.0	53	0.9	147°
	8	-	-	-	-	-	-	-	-	860.1-0635-055A1-PM	8.0	51.8	106	105.0	67	0.9	147°
6.40	3	860.1-0640-024A0-PM	8.0	20.2	79	78.0	34	0.9	147°	860.1-0640-024A1-PM	8.0	20.2	79	78.0	34	0.9	147°
	5	860.1-0640-040A0-PM	8.0	33.0	91	90.0	53	0.9	147°	860.1-0640-040A1-PM	8.0	33.0	91	90.0	53	0.9	147°
	8	-	-	-	-	-	-	-	-	860.1-0640-055A1-PM	8.0	52.2	106	105.0	67	0.9	147°
6.50	3	860.1-0650-024A0-PM	8.0	20.6	79	77.9	34	1.0	147°	860.1-0650-024A1-PM	8.0	20.6	79	77.9	34	1.0	147°
	5	860.1-0650-040A0-PM	8.0	33.6	91	89.9	53	1.0	147°	860.1-0650-040A1-PM	8.0	33.6	91	89.9	53	1.0	147°
	8	-	-	-	-	-	-	-	-	860.1-0650-055A1-PM	8.0	53.1	106	104.9	67	1.0	147°
6.60	3	860.1-0660-024A0-PM	8.0	20.9	79	77.9	34	1.0	147°	860.1-0660-024A1-PM	8.0	20.9	79	77.9	34	1.0	147°
	5	860.1-0660-040A0-PM	8.0	34.1	91	89.9	53	1.0	147°	860.1-0660-040A1-PM	8.0	34.1	91	89.9	53	1.0	147°
	8	-	-	-	-	-	-	-	-	860.1-0660-055A1-PM	8.0	53.9	106	104.9	67	1.0	147°
6.70	3	860.1-0670-024A0-PM	8.0	21.2	79	77.9	34	1.0	147°	860.1-0670-024A1-PM	8.0	21.2	79	77.9	34	1.0	147°
	5	860.1-0670-040A0-PM	8.0	34.6	91	89.9	53	1.0	147°	860.1-0670-040A1-PM	8.0	34.6	91	89.9	53	1.0	147°
	8	-	-	-	-	-	-	-	-	860.1-0670-055A1-PM	8.0	54.7	106	104.9	67	1.0	147°
6.75	3	-	-	-	-	-	-	-	-	860.1-0675-024A1-PM	8.0	21.3	79	77.9	34	1.0	147°
	5	-	-	-	-	-	-	-	-	860.1-0675-040A1-PM	8.0	34.8	91	89.9	53	1.0	147°
	8	-	-	-	-	-	-	-	-	860.1-0675-055A1-PM	8.0	55.0	106	104.9	67	1.0	147°
6.80	3	860.1-0680-024A0-PM	8.0	21.5	79	77.9	34	1.0	147°	860.1-0680-024A1-PM	8.0	21.5	79	77.9	34	1.0	147°
	5	860.1-0680-040A0-PM	8.0	35.1	91	89.9	53	1.0	147°	860.1-0680-040A1-PM	8.0	35.1	91	89.9	53	1.0	147°
	8	-	-	-	-	-	-	-	-	860.1-0680-055A1-PM	8.0	55.0	106	104.9	67	1.0	147°
6.90	3	860.1-0690-024A0-PM	8.0	21.8	79	77.9	34	1.0	147°	860.1-0690-024A1-PM	8.0	21.8	79	77.9	34	1.0	147°
	5	860.1-0690-040A0-PM	8.0	35.6	91	89.9	53	1.0	147°	860.1-0690-040A1-PM	8.0	35.6	91	89.9	53	1.0	147°
	8	-	-	-	-	-	-	-	-	860.1-0690-055A1-PM	8.0	55.0	106	104.9	68	1.0	147°
7.00	3	860.1-0700-024A0-PM	8.0	22.1	79	77.9	34	1.0	147°	860.1-0700-024A1-PM	8.0	22.1	79	77.9	34	1.0	147°
	5	860.1-0700-040A0-PM	8.0	36.1	91	89.9	53	1.0	147°	860.1-0700-040A1-PM	8.0	36.1	91	89.9	53	1.0	147°
	8	-	-	-	-	-	-	-	-	860.1-0700-055A1-PM	8.0	55.0	106	104.9	68	1.0	147°
7.10	3	860.1-0710-028A0-PM	8.0	22.4	79	77.9	41	1.1	147°	860.1-0710-028A1-PM	8.0	22.4	79	77.9	41	1.1	147°
	5	860.1-0710-040A0-PM	8.0	36.6	91	89.9	53	1.1	147°	860.1-0710-040A1-PM	8.0	36.6	91	89.9	53	1.1	147°
	8	-	-	-	-	-	-	-	-	860.1-0710-064A1-PM	8.0	57.9	116	114.9	77	1.1	147°
7.14	3	-	-	-	-	-	-	-	-	860.1-0714-028A1-PM	8.0	22.6	79	77.8	41	1.1	147°
	5	-	-	-	-	-	-	-	-	860.1-0714-040A1-PM	8.0	36.9	91	89.8	53	1.1	147°
	8	-	-	-	-	-	-	-	-	860.1-0714-064A1-PM	8.0	58.3	116	114.8	77	1.1	147°

注文例: 860.1-0300-016A0-PM P1BM 10本

CoroDrill® 860-PM (鋼用)

円筒シャンク

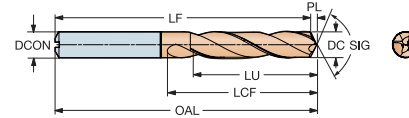


ドリル径: 3.00 - 20.00 mm
 加工深さ: 3 - 8 × DC
 加工公差の目安: H8 - H9
 切削油: 水溶性または不水溶性
 シャンク公差: h6

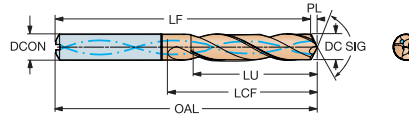


材種: P1BM(超硬コーティング)

外部給油



内部給油

Tailor
Made

ドリル径公差DC

ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

LU = 最大加工深さ

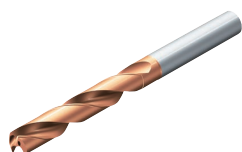
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ドリル径		型番	寸法, mm							型番	寸法, mm						
DC mm	加工深さ L/D		外部給油	DCON	LU	OAL	LF	LCF	PL		SIG	内部給油	DCON	LU	OAL	LF	LCF
7.20	3	860.1-0720-028A0-PM	8.0	22.8	79	77.8	41	1.1	147°	860.1-0720-028A1-PM	8.0	22.8	79	77.8	41	1.1	147°
	5	860.1-0720-040A0-PM	8.0	37.2	91	89.8	53	1.1	147°	860.1-0720-040A1-PM	8.0	37.2	91	89.8	53	1.1	147°
	8	-	-	-	-	-	-	-	-	860.1-0720-064A1-PM	8.0	58.8	116	114.8	77	1.1	147°
7.30	3	860.1-0730-028A0-PM	8.0	23.1	79	77.8	41	1.1	147°	860.1-0730-028A1-PM	8.0	23.1	79	77.8	41	1.1	147°
	5	860.1-0730-040A0-PM	8.0	37.7	91	89.8	53	1.1	147°	860.1-0730-040A1-PM	8.0	37.7	91	89.8	53	1.1	147°
	8	-	-	-	-	-	-	-	-	860.1-0730-064A1-PM	8.0	59.6	116	114.8	77	1.1	147°
7.40	3	860.1-0740-028A0-PM	8.0	23.4	79	77.8	41	1.1	147°	860.1-0740-028A1-PM	8.0	23.4	79	77.8	41	1.1	147°
	5	860.1-0740-040A0-PM	8.0	38.2	91	89.8	53	1.1	147°	860.1-0740-040A1-PM	8.0	38.2	91	89.8	53	1.1	147°
	8	-	-	-	-	-	-	-	-	860.1-0740-064A1-PM	8.0	60.4	116	114.8	77	1.1	147°
7.50	3	860.1-0750-028A0-PM	8.0	23.7	79	77.8	41	1.1	147°	860.1-0750-028A1-PM	8.0	23.7	79	77.8	41	1.1	147°
	5	860.1-0750-040A0-PM	8.0	38.7	91	89.8	53	1.1	147°	860.1-0750-040A1-PM	8.0	38.7	91	89.8	53	1.1	147°
	8	-	-	-	-	-	-	-	-	860.1-0750-064A1-PM	8.0	61.2	116	114.8	77	1.1	147°
7.54	3	-	-	-	-	-	-	-	-	860.1-0754-028A1-PM	8.0	23.8	79	77.8	41	1.1	147°
	5	-	-	-	-	-	-	-	-	860.1-0754-040A1-PM	8.0	38.9	91	89.8	53	1.1	147°
	8	-	-	-	-	-	-	-	-	860.1-0754-064A1-PM	8.0	62.0	116	114.8	77	1.1	147°
7.60	3	860.1-0760-028A0-PM	8.0	24.0	79	77.8	41	1.1	147°	860.1-0760-028A1-PM	8.0	24.0	79	77.8	41	1.1	147°
	5	-	-	-	-	-	-	-	-	860.1-0760-040A1-PM	8.0	39.2	91	89.8	53	1.1	147°
	8	-	-	-	-	-	-	-	-	860.1-0760-064A1-PM	8.0	62.0	116	114.8	77	1.1	147°
7.70	3	860.1-0770-028A0-PM	8.0	24.3	79	77.8	41	1.1	147°	860.1-0770-028A1-PM	8.0	24.3	79	77.8	41	1.1	147°
	5	860.1-0770-040A0-PM	8.0	39.7	91	89.8	53	1.1	147°	860.1-0770-040A1-PM	8.0	39.7	91	89.8	53	1.1	147°
	8	-	-	-	-	-	-	-	-	860.1-0770-064A1-PM	8.0	62.8	116	114.8	78	1.1	147°
7.80	3	860.1-0780-028A0-PM	8.0	24.7	79	77.7	41	1.2	147°	860.1-0780-028A1-PM	8.0	24.7	79	77.7	41	1.2	147°
	5	860.1-0780-040A0-PM	8.0	40.0	91	89.7	53	1.2	147°	860.1-0780-040A1-PM	8.0	40.0	91	89.7	53	1.2	147°
	8	-	-	-	-	-	-	-	-	860.1-0780-064A1-PM	8.0	63.7	116	114.7	78	1.2	147°
7.90	3	860.1-0790-028A0-PM	8.0	25.0	79	77.7	41	1.2	147°	860.1-0790-028A1-PM	8.0	25.0	79	77.7	41	1.2	147°
	5	860.1-0790-040A0-PM	8.0	40.0	91	89.7	53	1.2	147°	860.1-0790-040A1-PM	8.0	40.0	91	89.7	53	1.2	147°
	8	-	-	-	-	-	-	-	-	860.1-0790-064A1-PM	8.0	64.0	116	114.7	78	1.2	147°
7.94	3	-	-	-	-	-	-	-	-	860.1-0794-028A1-PM	8.0	25.1	79	77.7	41	1.2	147°
	5	-	-	-	-	-	-	-	-	860.1-0794-040A1-PM	8.0	40.0	91	89.7	53	1.2	147°
	8	-	-	-	-	-	-	-	-	860.1-0794-064A1-PM	8.0	64.0	116	114.7	78	1.2	147°
8.00	3	860.1-0800-028A0-PM	8.0	25.3	79	77.7	41	1.2	147°	860.1-0800-028A1-PM	8.0	25.3	79	77.7	41	1.2	147°
	5	860.1-0800-040A0-PM	8.0	40.0	91	89.7	53	1.2	147°	860.1-0800-040A1-PM	8.0	40.0	91	89.7	53	1.2	147°
										860.1-0800-064A1-PM	8.0	64.0	116	114.7	78	1.2	147°
8.10	3	860.1-0810-031A0-PM	10.0	25.6	89	87.7	47	1.2	147°	860.1-0810-031A1-PM	10.0	25.6	89	87.7	47	1.2	147°
	5	860.1-0810-045A0-PM	10.0	41.8	103	101.7	61	1.2	147°	860.1-0810-045A1-PM	10.0	41.8	103	101.7	61	1.2	147°
	8	-	-	-	-	-	-	-	-	860.1-0810-080A1-PM	10.0	66.1	139	137.7	94	1.2	147°
8.15	5	-	-	-	-	-	-	-	-	860.1-0815-045A1-PM	10.0	42.1	103	101.7	61	1.2	147°
8.20	3	860.1-0820-031A0-PM	10.0	25.9	89	87.7	47	1.2	147°	860.1-0820-031A1-PM	10.0	25.9	89	87.7	47	1.2	147°
	5	860.1-0820-045A0-PM	10.0	42.3	103	101.7	61	1.2	147°	860.1-0820-045A1-PM	10.0	42.3	103	101.7	61	1.2	147°
	8	-	-	-	-	-	-	-	-	860.1-0820-080A1-PM	10.0	66.9	139	137.7	94	1.2	147°
8.30	3	860.1-0830-031A0-PM	10.0	26.3	89	87.6	47	1.2	147°	860.1-0830-031A1-PM	10.0	26.3	89	87.6	47	1.2	147°
	5	860.1-0830-045A0-PM	10.0	42.9	103	101.6	61	1.2	147°	860.1-0830-045A1-PM	10.0	42.9	103	101.6	61	1.2	147°
	8	-	-	-	-	-	-	-	-	860.1-0830-080A1-PM	10.0	67.8	139	137.6	94	1.2	147°
8.33	5	-	-	-	-	-	-	-	-	860.1-0833-045A1-PM	10.0	43.0	103	101.6	61	1.2	147°
8.40	3	860.1-0840-031A0-PM	10.0	26.6	89	87.6	47	1.2	147°	860.1-0840-031A1-PM	10.0	26.6	89	87.6	47	1.2	147°
	5	860.1-0840-045A0-PM	10.0	43.4	103	101.6	61	1.2	147°	860.1-0840-045A1-PM	10.0	43.4	103	101.6	61	1.2	147°
	8	-	-	-	-	-	-	-	-	860.1-0840-080A1-PM	10.0	68.6	139	137.6	94	1.2	147°
8.50	3	860.1-0850-031A0-PM	10.0	26.9	89	87.6	47	1.3	147°	860.1-0850-031A1-PM	10.0	26.9	89	87.6	47	1.3	147°
	5	860.1-0850-045A0-PM	10.0	43.9	103	101.6	61	1.3	147°	860.1-0850-045A1-PM	10.0	43.9	103	101.6	61	1.3	147°
	8	-	-	-	-	-	-	-	-	860.1-0850-080A1-PM	10.0	69.4	139	137.6	95	1.3	147°
8.60	3	860.1-0860-031A0-PM	10.0	27.2	89	87.6	47	1.3	147°	860.1-0860-031A1-PM	10.0	27.2	89	87.6	47	1.3	147°
	5	860.1-0860-045A0-PM	10.0	44.4	103	101.6	61	1.3	147°	860.1-0860-045A1-PM	10.0	44.4	103	101.6	61	1.3	147°
	8	-	-	-	-	-	-	-	-	860.1-0860-080A1-PM	10.0	70.2	139	137.6	95	1.3	147°
8.70	3	860.1-0870-031A0-PM	10.0	27.5	89	87.6	47	1.3	147°	860.1-0870-031A1-PM	10.0	27.5	89	87.6	47	1.3	147°
	5	860.1-0870-045A0-PM	10.0	44.9	103	101.6	61	1.3	147°	860.1-0870-045A1-PM	10.0	44.9	103	101.6	61	1.3	147°
	8	-	-	-	-	-	-	-	-	860.1-0870-080A1-PM	10.0	71.0	139	137.6	95	1.3	147°
8.73	3	-	-	-	-	-	-	-	-	860.1-0873-031A1-PM	10.0	27.6	89	87.6	47	1.3	147°
	5	-	-	-	-	-	-	-	-	860.1-0873-045A1-PM	10.0	45.0	103	101.6	61	1.3	147°
	8	-	-	-	-	-	-	-	-	860.1-0873-080A1-PM	10.0	71.3	139	137.6	95	1.3	147°

注文例: 860.1-0300-016A0-PM P1BM 10本

CoroDrill® 860-PM (鋼用)

円筒シャンク

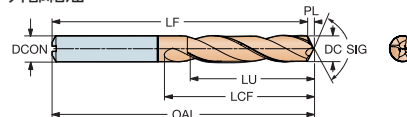


ドリル径: 3.00 - 20.00 mm
 加工深さ: 3 - 8 × DC
 加工公差の目安: H8 - H9
 切削油: 水溶性または不水溶性
 シャンク公差: h6

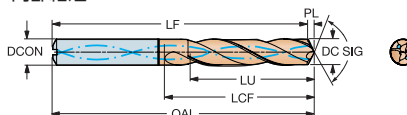


材種: P1BM(超硬コーティング)

外部給油



内部給油

Tailor
Made

ドリル径公差DC

ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

LU = 最大加工深さ

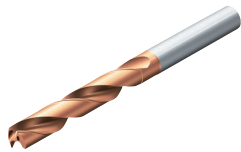
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ドリル径		型番	寸法, mm								型番	寸法, mm							
DC mm	加工深さ L/D	外部給油	DCON	LU	OAL	LF	LCF	PL	SIG	内部給油	DCON	LU	OAL	LF	LCF	PL	SIG		
8.80	3	860.1-0880-031A0-PM	10.0	27.8	89	87.6	47	1.3	147°	860.1-0880-031A1-PM	10.0	27.8	89	87.6	47	1.3	147°		
	5	860.1-0880-045A0-PM	10.0	45.0	103	101.6	61	1.3	147°	860.1-0880-045A1-PM	10.0	45.0	103	101.6	61	1.3	147°		
	8	-	-	-	-	-	-	-	-	860.1-0880-080A1-PM	10.0	71.8	139	137.6	95	1.3	147°		
8.90	3	-	-	-	-	-	-	-	-	860.1-0890-031A1-PM	10.0	28.1	89	87.6	47	1.3	147°		
	5	-	-	-	-	-	-	-	-	860.1-0890-045A1-PM	10.0	45.0	103	101.6	61	1.3	147°		
	8	-	-	-	-	-	-	-	-	860.1-0890-080A1-PM	10.0	72.6	139	137.6	95	1.3	147°		
9.00	3	860.1-0900-031A0-PM	10.0	28.5	89	87.5	47	1.3	147°	860.1-0900-031A1-PM	10.0	28.5	89	87.5	47	1.3	147°		
	5	860.1-0900-045A0-PM	10.0	45.0	103	101.5	61	1.3	147°	860.1-0900-045A1-PM	10.0	45.0	103	101.5	61	1.3	147°		
	8	-	-	-	-	-	-	-	-	860.1-0900-080A1-PM	10.0	73.5	139	137.5	95	1.3	147°		
9.10	3	860.1-0910-031A0-PM	10.0	28.8	89	87.5	47	1.3	147°	860.1-0910-031A1-PM	10.0	28.8	89	87.5	47	1.3	147°		
	5	-	-	-	-	-	-	-	-	860.1-0910-045A1-PM	10.0	45.0	103	101.5	61	1.3	147°		
	8	-	-	-	-	-	-	-	-	860.1-0910-080A1-PM	10.0	74.3	139	137.5	95	1.3	147°		
9.13	3	-	-	-	-	-	-	-	860.1-0913-031A1-PM	10.0	28.9	89	87.5	47	1.4	147°			
9.20	3	860.1-0920-031A0-PM	10.0	29.1	89	87.5	47	1.4	147°	860.1-0920-031A1-PM	10.0	29.1	89	87.5	47	1.4	147°		
	5	860.1-0920-045A0-PM	10.0	45.0	103	101.5	61	1.4	147°	860.1-0920-045A1-PM	10.0	45.0	103	101.5	61	1.4	147°		
	8	-	-	-	-	-	-	-	-	860.1-0920-080A1-PM	10.0	75.1	139	137.5	95	1.4	147°		
9.30	3	860.1-0930-031A0-PM	10.0	29.4	89	87.5	47	1.4	147°	860.1-0930-031A1-PM	10.0	29.4	89	87.5	47	1.4	147°		
	5	860.1-0930-045A0-PM	10.0	45.0	103	101.5	61	1.4	147°	860.1-0930-045A1-PM	10.0	45.0	103	101.5	61	1.4	147°		
	8	-	-	-	-	-	-	-	-	860.1-0930-080A1-PM	10.0	75.9	139	137.5	95	1.4	147°		
9.40	3	860.1-0940-031A0-PM	10.0	29.7	89	87.5	47	1.4	147°	860.1-0940-031A1-PM	10.0	29.7	89	87.5	47	1.4	147°		
	5	-	-	-	-	-	-	-	-	860.1-0940-045A1-PM	10.0	45.0	103	101.5	61	1.4	147°		
	8	-	-	-	-	-	-	-	-	860.1-0940-080A1-PM	10.0	76.7	139	137.5	96	1.4	147°		
9.50	3	860.1-0950-031A0-PM	10.0	30.0	89	87.5	47	1.4	147°	860.1-0950-031A1-PM	10.0	30.0	89	87.5	47	1.4	147°		
	5	860.1-0950-045A0-PM	10.0	45.0	103	101.5	61	1.4	147°	860.1-0950-045A1-PM	10.0	45.0	103	101.5	61	1.4	147°		
	8	-	-	-	-	-	-	-	-	860.1-0950-080A1-PM	10.0	77.5	139	137.5	96	1.4	147°		
9.52	3	-	-	-	-	-	-	-	-	860.1-0952-031A1-PM	10.0	30.1	89	87.5	47	1.4	147°		
	5	-	-	-	-	-	-	-	-	860.1-0952-045A1-PM	10.0	45.0	103	101.5	61	1.4	147°		
	8	-	-	-	-	-	-	-	-	860.1-0952-080A1-PM	10.0	77.7	139	137.5	96	1.4	147°		
9.55	5	-	-	-	-	-	-	-	860.1-0955-045A1-PM	10.0	45.0	103	101.5	61	1.4	147°			
9.60	3	860.1-0960-031A0-PM	10.0	30.3	89	87.5	47	1.4	147°	860.1-0960-031A1-PM	10.0	30.3	89	87.5	47	1.4	147°		
	5	860.1-0960-045A0-PM	10.0	45.0	103	101.5	61	1.4	147°	860.1-0960-045A1-PM	10.0	45.0	103	101.5	61	1.4	147°		
	8	-	-	-	-	-	-	-	-	860.1-0960-080A1-PM	10.0	78.3	139	137.5	96	1.4	147°		
9.70	3	860.1-0970-031A0-PM	10.0	30.7	89	87.4	47	1.4	147°	860.1-0970-031A1-PM	10.0	30.7	89	87.4	47	1.4	147°		
	5	860.1-0970-045A0-PM	10.0	45.0	103	101.4	61	1.4	147°	860.1-0970-045A1-PM	10.0	45.0	103	101.4	61	1.4	147°		
	8	-	-	-	-	-	-	-	-	860.1-0970-080A1-PM	10.0	79.2	139	137.4	96	1.4	147°		
9.80	3	860.1-0980-031A0-PM	10.0	31.0	89	87.4	47	1.5	147°	860.1-0980-031A1-PM	10.0	31.0	89	87.4	47	1.5	147°		
	5	860.1-0980-045A0-PM	10.0	45.0	103	101.4	61	1.5	147°	860.1-0980-045A1-PM	10.0	45.0	103	101.4	61	1.5	147°		
	8	-	-	-	-	-	-	-	-	860.1-0980-080A1-PM	10.0	80.0	139	137.4	96	1.5	147°		
9.90	3	860.1-0990-031A0-PM	10.0	31.0	89	87.4	47	1.5	147°	860.1-0990-031A1-PM	10.0	31.0	89	87.4	47	1.5	147°		
	5	860.1-0990-045A0-PM	10.0	45.0	103	101.4	61	1.5	147°	860.1-0990-045A1-PM	10.0	45.0	103	101.4	61	1.5	147°		
	8	-	-	-	-	-	-	-	-	860.1-0990-080A1-PM	10.0	80.0	139	137.4	96	1.5	147°		
9.92	3	-	-	-	-	-	-	-	-	860.1-0992-031A1-PM	10.0	31.0	89	87.4	47	1.5	147°		
	5	-	-	-	-	-	-	-	-	860.1-0992-045A1-PM	10.0	45.0	103	101.4	61	1.5	147°		
	8	-	-	-	-	-	-	-	-	860.1-0992-080A1-PM	10.0	80.0	139	137.4	96	1.5	147°		
10.00	3	860.1-1000-031A0-PM	10.0	31.0	89	87.4	47	1.5	147°	860.1-1000-031A1-PM	10.0	31.0	89	87.4	47	1.5	147°		
	5	860.1-1000-045A0-PM	10.0	45.0	103	101.4	61	1.5	147°	860.1-1000-045A1-PM	10.0	45.0	103	101.4	61	1.5	147°		
	8	-	-	-	-	-	-	-	-	860.1-1000-080A1-PM	10.0	80.0	139	137.4	96	1.5	147°		
10.10	3	860.1-1010-037A0-PM	12.0	31.9	102	100.4	55	1.5	147°	860.1-1010-037A1-PM	12.0	31.9	102	100.4	55	1.5	147°		
	5	860.1-1010-053A0-PM	12.0	52.1	118	116.4	71	1.5	147°	860.1-1010-053A1-PM	12.0	52.1	118	116.4	71	1.5	147°		
	8	-	-	-	-	-	-	-	-	860.1-1010-098A1-PM	12.0	82.4	163	161.4	114	1.5	147°		
10.20	3	860.1-1020-037A0-PM	12.0	32.3	102	100.3	55	1.5	147°	860.1-1020-037A1-PM	12.0	32.3	102	100.3	55	1.5	147°		
	5	860.1-1020-053A0-PM	12.0	52.7	118	116.3	71	1.5	147°	860.1-1020-053A1-PM	12.0	52.7	118	116.3	71	1.5	147°		
	8	-	-	-	-	-	-	-	-	860.1-1020-098A1-PM	12.0	83.3	163	161.3	114	1.5	147°		
10.30	3	860.1-1030-037A0-PM	12.0	32.6	102	100.3	55	1.5	147°	860.1-1030-037A1-PM	12.0	32.6	102	100.3	55	1.5	147°		
	5	860.1-1030-053A0-PM	12.0	53.0	118	116.3	71	1.5	147°	860.1-1030-053A1-PM	12.0	53.0	118	116.3	71	1.5	147°		
	8	-	-	-	-	-	-	-	-	860.1-1030-098A1-PM	12.0	84.1	163	161.3	114	1.5	147°		
10.32	3	-	-	-	-	-	-	-	-	860.1-1032-037A1-PM	12.0	32.6	102	100.3	55	1.5	147°		
	5	-	-	-	-	-	-	-	-	860.1-1032-053A1-PM	12.0	53.0	118	116.3	71	1.5	147°		
	8	-	-	-	-	-	-	-	-	860.1-1032-098A1-PM	12.0	84.2	163	161.3	114	1.5	147°		

注文例: 860.1-0300-016A0-PM P1BM 10本

CoroDrill® 860-PM (鋼用)

円筒シャンク

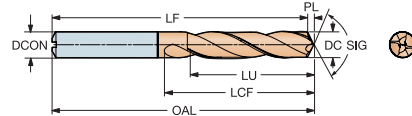


ドリル径: 3.00 - 20.00 mm
 加工深さ: 3 - 8 × DC
 加工公差の目安: H8 - H9
 切削油: 水溶性または不水溶性
 シャンク公差: h6

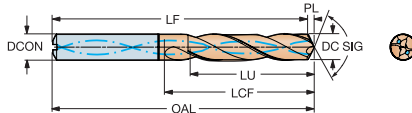


材種: P1BM(超硬コーティング)

外部給油



内部給油

Tailor
Made

ドリル径公差DC

ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

LU = 最大加工深さ

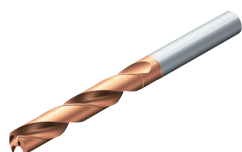


ドリル径 DC mm	加工深さ L/D	型番 外部給油	寸法, mm							型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG		DCON	LU	OAL	LF	LCF	PL	SIG
10.40	3	860.1-1040-037A0-PM	12.0	32.9	102	100.3	55	1.5	147°	860.1-1040-037A1-PM	12.0	32.9	102	100.3	55	1.5	147°
	5	860.1-1040-053A0-PM	12.0	53.0	118	116.3	71	1.5	147°	860.1-1040-053A1-PM	12.0	53.0	118	116.3	71	1.5	147°
	8	-	-	-	-	-	-	-	-	860.1-1040-098A1-PM	12.0	84.9	163	161.3	115	1.5	147°
10.45	5	-	-	-	-	-	-	-	-	860.1-1045-053A1-PM	12.0	53.0	118	116.3	71	1.5	147°
10.50	3	860.1-1050-037A0-PM	12.0	33.2	102	100.3	55	1.6	147°	860.1-1050-037A1-PM	12.0	33.2	102	100.3	55	1.6	147°
	5	860.1-1050-053A0-PM	12.0	53.0	118	116.3	71	1.6	147°	860.1-1050-053A1-PM	12.0	53.0	118	116.3	71	1.6	147°
	8	-	-	-	-	-	-	-	-	860.1-1050-098A1-PM	12.0	85.7	163	161.3	115	1.6	147°
10.60	3	860.1-1060-037A0-PM	12.0	33.5	102	100.3	55	1.6	147°	860.1-1060-037A1-PM	12.0	33.5	102	100.3	55	1.6	147°
	5	860.1-1060-053A0-PM	12.0	53.0	118	116.3	71	1.6	147°	860.1-1060-053A1-PM	12.0	53.0	118	116.3	71	1.6	147°
	8	-	-	-	-	-	-	-	-	860.1-1060-098A1-PM	12.0	87.3	163	161.3	115	1.6	147°
10.70	3	860.1-1070-037A0-PM	12.0	33.8	102	100.3	55	1.6	147°	860.1-1070-037A1-PM	12.0	33.8	102	100.3	55	1.6	147°
	5	860.1-1070-053A0-PM	12.0	53.0	118	116.3	71	1.6	147°	860.1-1070-053A1-PM	12.0	53.0	118	116.3	71	1.6	147°
	8	-	-	-	-	-	-	-	-	860.1-1070-098A1-PM	12.0	87.3	163	161.3	115	1.6	147°
10.71	3	-	-	-	-	-	-	-	-	860.1-1071-037A1-PM	12.0	33.9	102	100.3	55	1.6	147°
	5	-	-	-	-	-	-	-	-	860.1-1071-053A1-PM	12.0	53.0	118	116.3	71	1.6	147°
	8	-	-	-	-	-	-	-	-	860.1-1071-098A1-PM	12.0	88.2	163	161.2	115	1.6	147°
10.80	3	860.1-1080-037A0-PM	12.0	34.2	102	100.2	55	1.6	147°	860.1-1080-037A1-PM	12.0	34.2	102	100.2	55	1.6	147°
	5	860.1-1080-053A0-PM	12.0	53.0	118	116.2	71	1.6	147°	860.1-1080-053A1-PM	12.0	53.0	118	116.2	71	1.6	147°
	8	-	-	-	-	-	-	-	-	860.1-1080-098A1-PM	12.0	88.2	163	161.2	115	1.6	147°
10.90	3	860.1-1090-037A0-PM	12.0	34.5	102	100.2	55	1.6	147°	860.1-1090-037A1-PM	12.0	34.5	102	100.2	55	1.6	147°
	5	-	-	-	-	-	-	-	-	860.1-1090-053A1-PM	12.0	53.0	118	116.2	71	1.6	147°
	8	-	-	-	-	-	-	-	-	860.1-1090-098A1-PM	12.0	89.8	163	161.2	115	1.6	147°
11.00	3	860.1-1100-037A0-PM	12.0	34.8	102	100.2	55	1.6	147°	860.1-1100-037A1-PM	12.0	34.8	102	100.2	55	1.6	147°
	5	860.1-1100-053A0-PM	12.0	53.0	118	116.2	71	1.6	147°	860.1-1100-053A1-PM	12.0	53.0	118	116.2	71	1.6	147°
	8	-	-	-	-	-	-	-	-	860.1-1100-098A1-PM	12.0	89.8	163	161.2	115	1.6	147°
11.10	3	860.1-1110-037A0-PM	12.0	35.1	102	100.2	55	1.6	147°	860.1-1110-037A1-PM	12.0	35.1	102	100.2	55	1.6	147°
	5	860.1-1110-053A0-PM	12.0	53.0	118	116.2	71	1.6	147°	860.1-1110-053A1-PM	12.0	53.0	118	116.2	71	1.6	147°
	8	-	-	-	-	-	-	-	-	860.1-1110-098A1-PM	12.0	90.6	163	161.2	115	1.6	147°
11.11	3	-	-	-	-	-	-	-	-	860.1-1111-037A1-PM	12.0	35.1	102	100.2	55	1.6	147°
	5	-	-	-	-	-	-	-	-	860.1-1111-053A1-PM	12.0	53.0	118	116.2	71	1.6	147°
	8	-	-	-	-	-	-	-	-	860.1-1111-098A1-PM	12.0	90.7	163	161.2	115	1.6	147°
11.20	3	860.1-1120-037A0-PM	12.0	35.4	102	100.2	55	1.7	147°	860.1-1120-037A1-PM	12.0	35.4	102	100.2	55	1.7	147°
	5	860.1-1120-053A0-PM	12.0	53.0	118	116.2	71	1.7	147°	860.1-1120-053A1-PM	12.0	53.0	118	116.2	71	1.7	147°
	8	-	-	-	-	-	-	-	-	860.1-1120-098A1-PM	12.0	91.4	163	161.2	115	1.7	147°
11.30	3	-	-	-	-	-	-	-	-	860.1-1130-037A1-PM	12.0	35.7	102	100.2	55	1.7	147°
	5	-	-	-	-	-	-	-	-	860.1-1130-053A1-PM	12.0	53.0	118	116.2	71	1.7	147°
	8	-	-	-	-	-	-	-	-	860.1-1130-098A1-PM	12.0	92.2	163	161.2	115	1.7	147°
11.40	3	-	-	-	-	-	-	-	-	860.1-1140-037A1-PM	12.0	36.1	102	100.1	55	1.7	147°
	5	-	-	-	-	-	-	-	-	860.1-1140-053A1-PM	12.0	53.0	118	116.1	71	1.7	147°
	8	-	-	-	-	-	-	-	-	860.1-1140-098A1-PM	12.0	93.1	163	161.1	115	1.7	147°
11.50	3	860.1-1150-037A0-PM	12.0	36.4	102	100.1	55	1.7	147°	860.1-1150-037A1-PM	12.0	36.4	102	100.1	55	1.7	147°
	5	860.1-1150-053A0-PM	12.0	53.0	118	116.1	71	1.7	147°	860.1-1150-053A1-PM	12.0	53.0	118	116.1	71	1.7	147°
	8	-	-	-	-	-	-	-	-	860.1-1150-098A1-PM	12.0	93.9	163	161.1	116	1.7	147°
11.51	3	-	-	-	-	-	-	-	-	860.1-1151-037A1-PM	12.0	36.4	102	100.1	55	1.7	147°
	5	-	-	-	-	-	-	-	-	860.1-1151-053A1-PM	12.0	53.0	118	116.1	71	1.7	147°
	8	-	-	-	-	-	-	-	-	860.1-1151-098A1-PM	12.0	93.9	163	161.1	116	1.7	147°
11.60	3	860.1-1160-037A0-PM	12.0	36.7	102	100.1	55	1.7	147°	860.1-1160-037A1-PM	12.0	36.7	102	100.1	55	1.7	147°
	5	-	-	-	-	-	-	-	-	860.1-1160-053A1-PM	12.0	53.0	118	116.1	71	1.7	147°
	8	-	-	-	-	-	-	-	-	860.1-1160-098A1-PM	12.0	95.0	163	161.1	116	1.7	147°
11.70	3	860.1-1170-037A0-PM	12.0	37.0	102	100.1	55	1.7	147°	860.1-1170-037A1-PM	12.0	37.0	102	100.1	55	1.7	147°
	5	860.1-1170-053A0-PM	12.0	53.0	118	116.1	71	1.7	147°	860.1-1170-053A1-PM	12.0	53.0	118	116.1	71	1.7	147°
	8	-	-	-	-	-	-	-	-	860.1-1170-098A1-PM	12.0	95.5	163	161.1	116	1.7	147°
11.80	3	860.1-1180-037A0-PM	12.0	37.0	102	100.1	55	1.7	147°	860.1-1180-037A1-PM	12.0	37.0	102	100.1	55	1.7	147°
	4	860.1-1180-053A0-PM	12.0	53.0	118	116.1	71	1.7	147°	860.1-1180-053A1-PM	12.0	53.0	118	116.1	71	1.7	147°
	8	-	-	-	-	-	-	-	-	860.1-1180-098A1-PM	12.0	96.3	163	161.1	116	1.7	147°
11.90	3	-	-	-	-	-	-	-	-	860.1-1190-037A1-PM	12.0	37.0	102	100.1	55	1.8	147°
	4	-	-	-	-	-	-	-	-	860.1-1190-053A1-PM	12.0	53.0	118	116.1	71	1.8	147°
	8	-	-	-	-	-	-	-	-	860.1-1190-098A1-PM	12.0	97.1	163	161.1	116	1.8	147°
12.00	3	860.1-1200-037A0-PM	12.0	37.0	102	100.0	55	1.8	147°	860.1-1200-037A1-PM	12.0	37.0	102	100.0	55	1.8	147°
	4	860.1-1200-053A0-PM	12.0	53.0	118	116.0	71	1.8	147°	860.1-1200-053A1-PM	12.0	53.0	118	116.0	71	1.8	147°
	8	-	-	-	-	-	-	-	-	860.1-1200-098A1-PM	12.0	98.0	163	161.0	116	1.8	147°
12.10	3	860.1-1210-040A0-PM	14.0	38.3	107	105.0	60	1.8	147°	860.1-1210-040A1-PM	14.0	38.3	107	105.0	60	1.8	147°
	5	860.1-1210-057A0-PM	14.0	57.0	124	122.0	77	1.8	147°	860.1-1210-057A1-PM	14.0	57.0	124	122.0	77	1.8	147°
	8	-	-	-	-	-	-	-	-	860.1-1210-115A1-PM	14.0	98.8	182	180.0	133	1.8	147°

注文例: 860.1-0300-016A0-PM P1BM 10本

CoroDrill® 860-PM (鋼用)

円筒シャンク

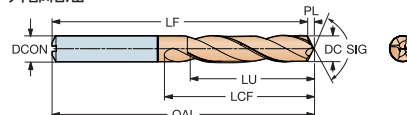


ドリル径: 3.00 - 20.00 mm
 加工深さ: 3 - 8 × DC
 加工公差の目安: H8 - H9
 切削油: 水溶性または不水溶性
 シャンク公差: h6

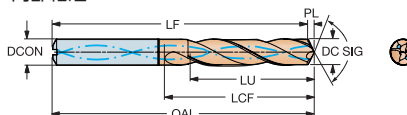


材種: P1BM(超硬コーティング)

外部給油



内部給油

Tailor
Made

ドリル径公差DC

ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

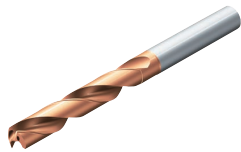
LU = 最大加工深さ

P

ドリル径		型番		寸法, mm							型番		寸法, mm						
DC mm	加工深さ L/D	外部給油		DCON	LU	OAL	LF	LCF	PL	SIG	内部給油		DCON	LU	OAL	LF	LCF	PL	SIG
12.20	3	860.1-1220-040A0-PM		14.0	38.6	107	105.0	60	1.8	147°	860.1-1220-040A1-PM		14.0	38.6	107	105.0	60	1.8	147°
	5	860.1-1220-057A0-PM		14.0	57.0	124	122.0	77	1.8	147°	860.1-1220-057A1-PM		14.0	57.0	124	122.0	77	1.8	147°
	8	-		-	-	-	-	-	-	-	860.1-1220-115A1-PM		14.0	99.6	182	180.0	133	1.8	147°
12.30	3	860.1-1230-040A0-PM		14.0	38.9	107	105.0	60	1.8	147°	860.1-1230-040A1-PM		14.0	38.9	107	105.0	60	1.8	147°
	5	860.1-1230-057A0-PM		14.0	57.0	124	122.0	77	1.8	147°	860.1-1230-057A1-PM		14.0	57.0	124	122.0	77	1.8	147°
	8	-		-	-	-	-	-	-	-	860.1-1230-115A1-PM		14.0	100.4	182	180.0	133	1.8	147°
12.40	3	860.1-1240-040A0-PM		14.0	39.2	107	105.0	60	1.8	147°	-		-	-	-	-	-	-	-
	5	-		-	-	-	-	-	-	-	860.1-1240-057A1-PM		14.0	57.0	124	122.0	77	1.8	147°
	8	-		-	-	-	-	-	-	-	860.1-1240-115A1-PM		14.0	101.2	182	180.0	133	1.8	147°
12.50	3	860.1-1250-040A0-PM		14.0	39.5	107	105.0	60	1.9	147°	860.1-1250-040A1-PM		14.0	39.5	107	105.0	60	1.9	147°
	5	860.1-1250-057A0-PM		14.0	57.0	124	122.0	77	1.9	147°	860.1-1250-057A1-PM		14.0	57.0	124	122.0	77	1.9	147°
	8	-		-	-	-	-	-	-	-	860.1-1250-115A1-PM		14.0	102.0	182	180.0	133	1.9	147°
12.60	3	860.1-1260-040A0-PM		14.0	39.9	107	104.9	60	1.9	147°	860.1-1260-040A1-PM		14.0	39.9	107	104.9	60	1.9	147°
	5	860.1-1260-057A0-PM		14.0	57.0	124	121.9	77	1.9	147°	-		-	-	-	-	-	-	
12.70	3	860.1-1270-040A0-PM		14.0	40.0	107	104.9	60	1.9	147°	860.1-1270-040A1-PM		14.0	40.0	107	104.9	60	1.9	147°
	4	860.1-1270-057A0-PM		14.0	57.0	124	121.9	77	1.9	147°	860.1-1270-057A1-PM		14.0	57.0	124	121.9	77	1.9	147°
	8	-		-	-	-	-	-	-	-	860.1-1270-115A1-PM		14.0	103.7	182	179.9	134	1.9	147°
12.80	3	860.1-1280-040A0-PM		14.0	40.0	107	104.9	60	1.9	147°	860.1-1280-040A1-PM		14.0	40.0	107	104.9	60	1.9	147°
	5	-		-	-	-	-	-	-	-	860.1-1280-057A1-PM		14.0	57.0	124	121.9	77	1.9	147°
	8	-		-	-	-	-	-	-	-	860.1-1280-115A1-PM		14.0	104.5	182	179.9	134	1.9	147°
13.00	3	860.1-1300-040A0-PM		14.0	40.0	107	104.9	60	1.9	147°	860.1-1300-040A1-PM		14.0	40.0	107	104.9	60	1.9	147°
	4	860.1-1300-057A0-PM		14.0	57.0	124	121.9	77	1.9	147°	860.1-1300-057A1-PM		14.0	57.0	124	121.9	77	1.9	147°
	8	-		-	-	-	-	-	-	-	860.1-1300-115A1-PM		14.0	106.1	182	179.9	134	1.9	147°
13.10	3	-		-	-	-	-	-	-	-	860.1-1310-040A1-PM		14.0	40.0	107	104.9	60	1.9	147°
	4	-		-	-	-	-	-	-	-	860.1-1310-057A1-PM		14.0	57.0	124	121.9	77	1.9	147°
	8	-		-	-	-	-	-	-	-	860.1-1310-115A1-PM		14.0	106.9	182	179.9	134	1.9	147°
13.25	3	-		-	-	-	-	-	-	-	860.1-1325-040A1-PM		14.0	40.0	107	104.9	60	2.0	147°
	4	-		-	-	-	-	-	-	-	860.1-1325-057A1-PM		14.0	57.0	124	121.9	77	2.0	147°
	8	-		-	-	-	-	-	-	-	860.1-1325-115A1-PM		14.0	108.1	182	179.9	134	2.0	147°
13.50	3	860.1-1350-040A0-PM		14.0	40.0	107	104.8	60	2.0	147°	860.1-1350-040A1-PM		14.0	40.0	107	104.8	60	2.0	147°
	4	860.1-1350-057A0-PM		14.0	57.0	124	121.8	77	2.0	147°	860.1-1350-057A1-PM		14.0	57.0	124	121.8	77	2.0	147°
	8	-		-	-	-	-	-	-	-	860.1-1350-115A1-PM		14.0	110.2	182	179.8	134	2.0	147°
13.75	3	-		-	-	-	-	-	-	-	860.1-1375-040A1-PM		14.0	40.0	107	104.8	60	2.0	147°
	4	-		-	-	-	-	-	-	-	860.1-1375-057A1-PM		14.0	57.0	124	121.8	77	2.0	147°
13.80	3	860.1-1380-040A0-PM		14.0	40.0	107	104.8	60	2.0	147°	860.1-1380-040A1-PM		14.0	40.0	107	104.8	60	2.0	147°
	4	860.1-1380-057A0-PM		14.0	57.0	124	121.8	77	2.0	147°	860.1-1380-057A1-PM		14.0	57.0	124	121.8	77	2.0	147°
	8	-		-	-	-	-	-	-	-	860.1-1380-115A1-PM		14.0	112.6	182	179.8	134	2.0	147°
13.89	4	-		-	-	-	-	-	-	-	860.1-1389-057A1-PM		14.0	57.0	124	121.8	77	2.1	147°
14.00	3	860.1-1400-040A0-PM		14.0	40.0	107	104.7	60	2.1	147°	860.1-1400-040A1-PM		14.0	40.0	107	104.7	60	2.1	147°
	4	860.1-1400-057A0-PM		14.0	57.0	124	121.7	77	2.1	147°	860.1-1400-057A1-PM		14.0	57.0	124	121.7	77	2.1	147°
	8	-		-	-	-	-	-	-	-	860.1-1400-115A1-PM		14.0	114.3	182	179.7	134	2.1	147°
14.25	3	860.1-1425-044A0-PM		16.0	44.0	115	112.7	65	2.1	147°	860.1-1425-044A1-PM		16.0	44.0	115	112.7	65	2.1	147°
	4	860.1-1425-062A0-PM		16.0	62.0	133	130.7	83	2.1	147°	860.1-1425-062A1-PM		16.0	62.0	133	130.7	83	2.1	147°
14.29	3	-		-	-	-	-	-	-	-	860.1-1429-044A1-PM		16.0	44.0	115	112.7	65	2.1	147°
	4	-		-	-	-	-	-	-	-	860.1-1429-062A1-PM		16.0	62.0	133	130.7	83	2.1	147°
14.50	3	860.1-1450-044A0-PM		16.0	44.0	115	112.7	65	2.1	147°	860.1-1450-044A1-PM		16.0	44.0	115	112.7	65	2.1	147°
	4	860.1-1450-062A0-PM		16.0	62.0	133	130.7	83	2.1	147°	860.1-1450-062A1-PM		16.0	62.0	133	130.7	83	2.1	147°
14.69	3	-		-	-	-	-	-	-	-	860.1-1469-044A1-PM		16.0	44.0	115	112.7	65	2.2	147°
	4	-		-	-	-	-	-	-	-	860.1-1469-062A1-PM		16.0	62.0	133	130.7	83	2.2	147°
14.75	4	-		-	-	-	-	-	-	-	860.1-1475-062A1-PM		16.0	62.0	133	130.6	83	2.2	147°
14.80	4	-		-	-	-	-	-	-	-	860.1-1480-062A1-PM		16.0	62.0	133	130.6	83	2.2	147°
15.00	3	860.1-1500-044A0-PM		16.0	44.0	115	112.6	65	2.2	147°	860.1-1500-044A1-PM		16.0	44.0	115	112.6	65	2.2	147°
	4	860.1-1500-062A0-PM		16.0	62.0	133	130.6	83	2.2	147°	860.1-1500-062A1-PM		16.0	62.0	133	130.6	83	2.2	147°
15.10	3	860.1-1510-044A0-PM		16.0	44.0	115	112.6	65	2.2	147°	860.1-1510-044A1-PM		16.0	44.0	115	112.6	65	2.2	147°
	4	860.1-1510-062A0-PM		16.0	62.0	133	130.6	83	2.2	147°	860.1-1510-062A1-PM		16.0	62.0	133	130.6	83	2.2	147°
15.50	3	860.1-1550-044A0-PM		16.0	44.0	115	112.5	65	2.3	147°	860.1-1550-044A1-PM		16.0	44.0	115	112.5	65	2.3	147°
	4	-		-	-	-	-	-	-	-	860.1-1550-062A1-PM		16.0	62.0	133	130.5	83	2.3	147°
15.80	3	860.1-1580-044A0-PM		16.0	44.0	115	112.5	65	2.3	147°	860.1-1580-044A1-PM		16.0	44.0	115	112.5	65	2.3	147°
	4	860.1-1580-062A0-PM		16.0	62.0	133	130.5	83	2.3	147°	860.1-1580-062A1-PM		16.0	62.0	133	130.5	83	2.3	147°

CoroDrill® 860-PM (鋼用)

円筒シャンク

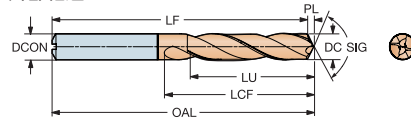


ドリル径: 3.00 - 20.00 mm
 加工深さ: 3 - 8 × DC
 加工公差の目安: H8 - H9
 切削油: 水溶性または不水溶性
 シャンク公差: h6

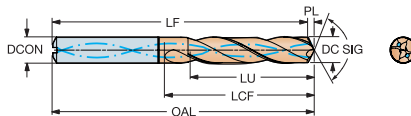


材質: P1BM(超硬コーティング)

外部給油



内部給油

Tailor
Made

ドリル径公差DC

ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

LU = 最大加工深さ

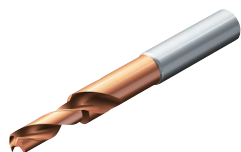
P

ドリル径 DC mm	加工深さ L/D	型番 外部給油	寸法, mm							型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG		DCON	LU	OAL	LF	LCF	PL	SIG
15.87	3	-	-	-	-	-	-	-	-	860.1-1587-044A1-PM	16.0	44.0	115	112.5	65	2.4	147°
	4	-	-	-	-	-	-	-	-	860.1-1587-062A1-PM	16.0	62.0	133	130.5	83	2.4	147°
16.00	3	860.1-1600-044A0-PM	16.0	44.0	115	112.5	65	2.4	147°	860.1-1600-044A1-PM	16.0	44.0	115	112.5	65	2.4	147°
	4	860.1-1600-062A0-PM	16.0	62.0	133	130.5	83	2.4	147°	860.1-1600-062A1-PM	16.0	62.0	133	130.5	83	2.4	147°
16.10	3	-	-	-	-	-	-	-	-	860.1-1610-050A1-PM	18.0	50.0	123	120.4	73	2.4	147°
	4	-	-	-	-	-	-	-	-	860.1-1610-070A1-PM	18.0	70.0	143	140.4	93	2.4	147°
16.50	3	860.1-1650-050A0-PM	18.0	50.0	123	120.4	73	2.4	147°	860.1-1650-050A1-PM	18.0	50.0	123	120.4	73	2.4	147°
	4	860.1-1650-070A0-PM	18.0	70.0	143	140.4	93	2.4	147°	860.1-1650-070A1-PM	18.0	70.0	143	140.4	93	2.4	147°
16.67	3	-	-	-	-	-	-	-	-	860.1-1667-050A1-PM	18.0	50.0	123	120.4	73	2.5	147°
	4	-	-	-	-	-	-	-	-	860.1-1667-070A1-PM	18.0	70.0	143	140.4	93	2.5	147°
16.80	3	-	-	-	-	-	-	-	-	860.1-1680-050A1-PM	18.0	50.0	123	120.4	73	2.5	147°
	4	-	-	-	-	-	-	-	-	860.1-1680-070A1-PM	18.0	70.0	143	140.4	93	2.5	147°
17.00	3	860.1-1700-050A0-PM	18.0	50.0	123	120.3	73	2.5	147°	860.1-1700-050A1-PM	18.0	50.0	123	120.3	73	2.5	147°
	4	860.1-1700-070A0-PM	18.0	70.0	143	140.3	93	2.5	147°	860.1-1700-070A1-PM	18.0	70.0	143	140.3	93	2.5	147°
17.50	3	860.1-1750-050A0-PM	18.0	50.0	123	120.3	73	2.6	147°	860.1-1750-050A1-PM	18.0	50.0	123	120.3	73	2.6	147°
	4	860.1-1750-070A0-PM	18.0	70.0	143	140.3	93	2.6	147°	860.1-1750-070A1-PM	18.0	70.0	143	140.3	93	2.6	147°
17.80	3	-	-	-	-	-	-	-	-	860.1-1780-050A1-PM	18.0	50.0	123	120.2	73	2.7	147°
	4	-	-	-	-	-	-	-	-	860.1-1780-070A1-PM	18.0	70.0	143	140.2	93	2.7	147°
18.00	3	860.1-1800-050A0-PM	18.0	50.0	123	120.2	73	2.7	147°	860.1-1800-050A1-PM	18.0	50.0	123	120.2	73	2.7	147°
	4	860.1-1800-070A0-PM	18.0	70.0	143	140.2	93	2.7	147°	860.1-1800-070A1-PM	18.0	70.0	143	140.2	93	2.7	147°
18.50	3	860.1-1850-055A0-PM	20.0	55.0	131	128.1	79	2.7	147°	860.1-1850-055A1-PM	20.0	55.0	131	128.1	79	2.7	147°
	4	-	-	-	-	-	-	-	-	860.1-1880-055A1-PM	20.0	55.0	131	128.1	79	2.8	147°
18.80	3	-	-	-	-	-	-	-	-	860.1-1880-077A1-PM	20.0	77.0	153	150.1	101	2.8	147°
	4	-	-	-	-	-	-	-	-	860.1-1900-055A1-PM	20.0	55.0	131	128.1	79	2.8	147°
19.00	3	860.1-1900-055A0-PM	20.0	55.0	131	128.1	79	2.8	147°	860.1-1900-055A1-PM	20.0	55.0	131	128.1	79	2.8	147°
	4	-	-	-	-	-	-	-	-	860.1-1900-077A1-PM	20.0	77.0	153	150.1	101	2.8	147°
19.05	3	-	-	-	-	-	-	-	-	860.1-1905-055A1-PM	20.0	55.0	131	128.0	79	2.8	147°
	4	-	-	-	-	-	-	-	-	860.1-1905-077A1-PM	20.0	77.0	153	150.0	101	2.8	147°
19.80	3	-	-	-	-	-	-	-	-	860.1-1980-055A1-PM	20.0	55.0	131	128.0	79	2.9	147°
	4	-	-	-	-	-	-	-	-	860.1-2000-055A1-PM	20.0	55.0	131	127.9	79	3.0	147°
20.00	3	860.1-2000-055A0-PM	20.0	55.0	131	127.9	79	3.0	147°	860.1-2000-055A1-PM	20.0	55.0	131	127.9	79	3.0	147°
	4	860.1-2000-077A0-PM	20.0	77.0	153	149.9	101	3.0	147°	860.1-2000-077A1-PM	20.0	77.0	153	149.9	101	3.0	147°

注文例: 860.1-0300-016A0-PM P1BM 10本

CoroDrill® 860-PM (鋼用)

円筒シャンク

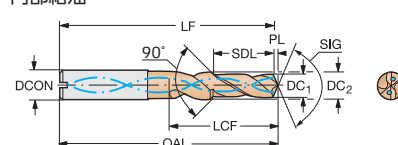


ドリル径: 3.35 - 17.50 mm
 加工深さ: 3 × DC
 加工公差の目安: H8 - H9
 切削油: 水溶性または不水溶性
 シャンク公差: h6



材質: P1BM(超硬コーティング)

内部給油



Tailor Made

ドリル径公差DC

ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

3×DCタップ下穴用面取りドリル 内部給油

LU = 最大加工深さ



ドリル径 DC1 mm	加工深さ L/D	型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	SDL	PL	SIG
3.35	4	860.2-0335-011A1-PM	6.0	12.1	74	73.4	11.0	0.6	147°
3.40	4	860.2-0340-011A1-PM	6.0	12.2	74	73.4	11.0	0.6	147°
3.70	4	860.2-0370-012A1-PM	6.0	14.3	74	73.4	13.0	0.6	147°
4.25	4	860.2-0425-013A1-PM	6.0	15.5	74	73.3	14.0	0.7	147°
4.30	4	860.2-0430-013A1-PM	6.0	15.5	74	73.2	14.0	0.8	147°
4.65	3	860.2-0465-014A1-PM	6.0	15.4	74	73.2	14.0	0.8	147°
5.00	3	860.2-0500-015A1-PM	8.0	16.7	79	78.2	15.0	0.8	147°
5.10	3	860.2-0510-016A1-PM	8.0	17.7	79	78.2	16.0	0.8	147°
5.30	3	860.2-0530-016A1-PM	8.0	17.8	79	78.2	16.0	0.8	147°
5.50	3	860.2-0550-017A1-PM	8.0	18.8	79	78.1	17.0	0.9	147°
5.55	3	860.2-0555-017A1-PM	8.0	18.8	79	78.1	17.0	0.9	147°
6.60	3	860.2-0660-020A1-PM	10.0	22.2	89	87.9	20.0	1.1	147°
6.75	3	860.2-0675-021A1-PM	10.0	23.3	89	87.9	21.0	1.1	147°
6.85	3	860.2-0685-021A1-PM	10.0	23.3	89	87.9	21.0	1.1	147°
6.90	3	860.2-0690-021A1-PM	10.0	23.3	89	87.9	21.0	1.1	147°
7.00	3	860.2-0700-021A1-PM	10.0	23.4	89	87.9	21.0	1.1	147°
7.25	3	860.2-0725-022A1-PM	10.0	24.3	89	87.8	22.0	1.2	147°
7.40	3	860.2-0740-022A1-PM	10.0	24.4	89	87.8	22.0	1.2	147°
8.00	3	860.2-0800-024A1-PM	12.0	26.7	102	100.7	24.0	1.3	147°
8.50	3	860.2-0850-026A1-PM	12.0	28.9	102	100.6	26.0	1.4	147°
8.60	3	860.2-0860-026A1-PM	12.0	28.9	102	100.6	26.0	1.4	147°
8.70	3	860.2-0870-026A1-PM	12.0	28.9	102	100.6	26.0	1.4	147°
9.00	3	860.2-0900-027A1-PM	12.0	29.9	102	100.5	27.0	1.5	147°
9.25	3	860.2-0925-028A1-PM	14.0	31.1	112	110.5	28.0	1.5	147°
9.30	3	860.2-0930-028A1-PM	14.0	31.2	112	110.5	28.0	1.5	147°
10.25	3	860.2-1025-031A1-PM	14.0	34.4	112	110.3	31.0	1.7	147°
10.30	3	860.2-1030-031A1-PM	14.0	34.4	112	110.3	31.0	1.7	147°
10.40	3	860.2-1040-031A1-PM	14.0	34.4	112	110.3	31.0	1.7	147°
10.50	3	860.2-1050-032A1-PM	14.0	35.4	112	110.3	32.0	1.7	147°
10.80	3	860.2-1080-033A1-PM	16.0	36.7	124	122.2	33.0	1.8	147°
11.00	3	860.2-1100-033A1-PM	16.0	36.7	124	122.2	33.0	1.8	147°
11.20	3	860.2-1120-034A1-PM	16.0	37.8	124	122.2	34.0	1.8	147°
11.50	3	860.2-1150-035A1-PM	16.0	38.7	124	122.1	35.0	1.9	147°
12.00	3	860.2-1200-036A1-PM	16.0	40.9	124	122.0	37.0	2.0	147°
12.10	3	860.2-1210-037A1-PM	18.0	41.1	124	122.0	37.0	2.0	147°
12.25	3	860.2-1225-037A1-PM	18.0	41.0	124	122.0	37.0	2.0	147°
12.50	3	860.2-1250-038A1-PM	18.0	42.2	124	122.0	38.0	2.0	147°
13.50	3	860.2-1350-041A1-PM	18.0	45.3	131	128.8	41.0	2.2	147°
14.00	3	860.2-1400-042A1-PM	20.0	46.7	142	139.7	42.0	2.3	147°
14.10	3	860.2-1410-043A1-PM	20.0	47.7	142	139.7	43.0	2.3	147°
14.25	3	860.2-1425-043A1-PM	20.0	47.8	142	139.7	43.0	2.3	147°
14.50	3	860.2-1450-044A1-PM	20.0	48.9	142	139.7	44.0	2.3	147°
15.00	3	860.2-1500-045A1-PM	20.0	49.7	142	139.6	45.0	2.4	147°
15.10	3	860.2-1510-046A1-PM	20.0	50.6	142	139.6	46.0	2.4	147°
15.50	3	860.2-1550-047A1-PM	20.0	51.5	142	139.5	47.0	2.5	147°
16.50	3	860.2-1650-050A1-PM	20.0	54.2	153	150.4	50.0	2.6	147°
17.50	3	860.2-1750-053A1-PM	20.0	56.8	153	150.3	53.0	2.7	147°

注文例: 860.2-0335-011A1-PM P1BM 10 本

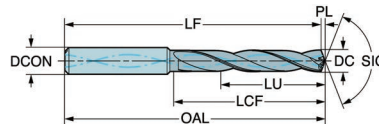
CoroDrill® 860-MM (ステンレス鋼用)

油穴つき

加工径 DC: 3.00 - 20.00mm
 加工深さ: 3 - 5 × DC
 加工公差の目安: H9
 シャンク公差: h6



材種: M2BM (超硬コーティング)

Tailor
Made

ドリル径公差DC	
ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

LU = 最大加工深さ **M**

ドリル径 DC1 mm	加工深さ L/D	型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG
3.00	3	860.1-0300-014A1-MM M2BM	6.0	14	62	61.5	20.0	0.5	140°
	5	860.1-0300-019A1-MM M2BM	6.0	19	66	65.5	24.0	0.5	140°
3.10	3	860.1-0310-014A1-MM M2BM	6.0	14	62	61.4	20.0	0.6	140°
	5	860.1-0310-019A1-MM M2BM	6.0	19	66	65.4	24.0	0.6	140°
3.18	3	860.1-0318-014A1-MM M2BM	6.0	14	62	61.4	20.0	0.6	140°
	5	860.1-0318-019A1-MM M2BM	6.0	19	66	65.4	24.0	0.6	140°
3.20	3	860.1-0320-014A1-MM M2BM	6.0	14	62	61.4	20.0	0.6	140°
	5	860.1-0320-019A1-MM M2BM	6.0	19	66	65.4	24.0	0.6	140°
3.25	3	860.1-0325-014A1-MM M2BM	6.0	14	62	61.4	20.0	0.6	140°
	5	860.1-0325-019A1-MM M2BM	6.0	19	66	65.4	24.0	0.6	140°
3.30	3	860.1-0330-014A1-MM M2BM	6.0	14	62	61.4	20.0	0.6	140°
	5	860.1-0330-019A1-MM M2BM	6.0	19	66	65.4	24.0	0.6	140°
3.40	3	860.1-0340-014A1-MM M2BM	6.0	14	62	61.4	20.0	0.6	140°
	5	860.1-0340-019A1-MM M2BM	6.0	19	66	65.4	24.0	0.6	140°
3.50	3	860.1-0350-014A1-MM M2BM	6.0	14	62	61.4	20.0	0.6	140°
	5	860.1-0350-019A1-MM M2BM	6.0	19	66	65.4	24.0	0.6	140°
3.57	3	860.1-0357-014A1-MM M2BM	6.0	14	62	61.4	20.0	0.7	140°
	5	860.1-0357-019A1-MM M2BM	6.0	19	66	65.4	24.0	0.7	140°
3.60	3	860.1-0360-014A1-MM M2BM	6.0	14	62	61.3	20.0	0.7	140°
	5	860.1-0360-019A1-MM M2BM	6.0	19	66	65.3	24.0	0.7	140°
3.70	3	860.1-0370-014A1-MM M2BM	6.0	14	62	61.3	20.0	0.7	140°
	5	860.1-0370-019A1-MM M2BM	6.0	19	66	65.3	24.0	0.7	140°
3.80	3	860.1-0380-017A1-MM M2BM	6.0	17	66	65.3	24.0	0.7	140°
	5	860.1-0380-029A1-MM M2BM	6.0	29	74	73.3	36.0	0.7	140°
3.90	3	860.1-0390-017A1-MM M2BM	6.0	17	66	65.3	24.0	0.7	140°
	5	860.1-0390-029A1-MM M2BM	6.0	29	74	73.3	36.0	0.7	140°
3.97	3	860.1-0397-017A1-MM M2BM	6.0	17	66	65.3	24.0	0.7	140°
	5	860.1-0397-029A1-MM M2BM	6.0	29	74	73.3	36.0	0.7	140°
4.00	3	860.1-0400-017A1-MM M2BM	6.0	17	66	65.3	24.0	0.7	140°
	5	860.1-0400-029A1-MM M2BM	6.0	29	74	73.3	36.0	0.7	140°
4.10	3	860.1-0410-017A1-MM M2BM	6.0	17	66	65.3	24.0	0.7	140°
	5	860.1-0410-029A1-MM M2BM	6.0	29	74	73.3	36.0	0.7	140°
4.20	3	860.1-0420-017A1-MM M2BM	6.0	17	66	65.2	24.0	0.8	140°
	5	860.1-0420-029A1-MM M2BM	6.0	29	74	73.2	36.0	0.8	140°
4.30	3	860.1-0430-017A1-MM M2BM	6.0	17	66	65.2	24.0	0.8	140°
	5	860.1-0430-029A1-MM M2BM	6.0	29	74	73.2	36.0	0.8	140°
4.37	3	860.1-0437-017A1-MM M2BM	6.0	17	66	65.2	24.0	0.8	140°
	5	860.1-0437-029A1-MM M2BM	6.0	29	74	73.2	36.0	0.8	140°
4.40	3	860.1-0440-017A1-MM M2BM	6.0	17	66	65.2	24.0	0.8	140°
	5	860.1-0440-029A1-MM M2BM	6.0	29	74	73.2	36.0	0.8	140°
4.50	3	860.1-0450-017A1-MM M2BM	6.0	17	66	65.2	24.0	0.8	140°
	5	860.1-0450-029A1-MM M2BM	6.0	29	74	73.2	36.0	0.8	140°
4.60	3	860.1-0460-017A1-MM M2BM	6.0	17	66	65.2	24.0	0.8	140°
	5	860.1-0460-029A1-MM M2BM	6.0	29	74	73.2	36.0	0.8	140°
4.65	3	860.1-0465-017A1-MM M2BM	6.0	17	66	65.2	24.0	0.8	140°
	5	860.1-0465-029A1-MM M2BM	6.0	29	74	73.2	36.0	0.8	140°
4.70	3	860.1-0470-017A1-MM M2BM	6.0	17	66	65.1	24.0	0.9	140°
	5	860.1-0470-029A1-MM M2BM	6.0	29	74	73.1	36.0	0.9	140°
4.76	3	860.1-0476-020A1-MM M2BM	6.0	20	66	65.1	28.0	0.9	140°
	5	860.1-0476-035A1-MM M2BM	6.0	35	82	81.1	44.0	0.9	140°
4.80	3	860.1-0480-020A1-MM M2BM	6.0	20	66	65.1	28.0	0.9	140°
	5	860.1-0480-035A1-MM M2BM	6.0	35	82	81.1	44.0	0.9	140°
4.90	3	860.1-0490-020A1-MM M2BM	6.0	20	66	65.1	28.0	0.9	140°
	5	860.1-0490-035A1-MM M2BM	6.0	35	82	81.1	44.0	0.9	140°
5.00	3	860.1-0500-020A1-MM M2BM	6.0	20	66	65.1	28.0	0.9	140°
	5	860.1-0500-035A1-MM M2BM	6.0	35	82	81.1	44.0	0.9	140°
5.10	3	860.1-0510-020A1-MM M2BM	6.0	20	66	65.1	28.0	0.9	140°
	5	860.1-0510-035A1-MM M2BM	6.0	35	82	81.1	44.0	0.9	140°
5.16	3	860.1-0516-020A1-MM M2BM	6.0	20	66	65.1	28.0	0.9	140°
	5	860.1-0516-035A1-MM M2BM	6.0	35	82	81.1	44.0	0.9	140°
5.20	3	860.1-0520-020A1-MM M2BM	6.0	20	66	65.1	28.0	0.9	140°
	5	860.1-0520-035A1-MM M2BM	6.0	35	82	81.1	44.0	0.9	140°

ドリル径 DC1 mm	加工深さ L/D	型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG
5.30	3	860.1-0530-020A1-MM M2BM	6.0	20	66	65.0	28.0	1.0	140°
	5	860.1-0530-035A1-MM M2BM	6.0	35	82	81.0	44.0	1.0	140°
5.40	3	860.1-0540-020A1-MM M2BM	6.0	20	66	65.0	28.0	1.0	140°
	5	860.1-0540-035A1-MM M2BM	6.0	35	82	81.0	44.0	1.0	140°
5.50	3	860.1-0550-020A1-MM M2BM	6.0	20	66	65.0	28.0	1.0	140°
	5	860.1-0550-035A1-MM M2BM	6.0	35	82	81.0	44.0	1.0	140°
5.55	3	860.1-0555-020A1-MM M2BM	6.0	20	66	65.0	28.0	1.0	140°
	5	860.1-0555-035A1-MM M2BM	6.0	35	82	81.0	44.0	1.0	140°
5.56	3	860.1-0556-020A1-MM M2BM	6.0	20	66	65.0	28.0	1.0	140°
	5	860.1-0556-035A1-MM M2BM	6.0	35	82	81.0	44.0	1.0	140°
5.60	3	860.1-0560-020A1-MM M2BM	6.0	20	66	65.0	28.0	1.0	140°
	5	860.1-0560-035A1-MM M2BM	6.0	35	82	81.0	44.0	1.0	140°
5.70	3	860.1-0570-020A1-MM M2BM	6.0	20	66	65.0	28.0	1.0	140°
	5	860.1-0570-035A1-MM M2BM	6.0	35	82	81.0	44.0	1.0	140°
5.80	3	860.1-0580-020A1-MM M2BM	6.0	20	66	64.9	28.0	1.1	140°
	5	860.1-0580-035A1-MM M2BM	6.0	35	82	80.9	44.0	1.1	140°
5.90	3	860.1-0590-020A1-MM M2BM	6.0	20	66	64.9	28.0	1.1	140°
	5	860.1-0590-035A1-MM M2BM	6.0	35	82	80.9	44.0	1.1	140°
5.95	3	860.1-0595-020A1-MM M2BM	6.0	20	66	64.9	28.0	1.1	140°
	5	860.1-0595-035A1-MM M2BM	6.0	35	82	80.9	44.0	1.1	140°
6.00	3	860.1-0600-020A1-MM M2BM	6.0	20	66	64.9	28.0	1.1	140°
	5	860.1-0600-035A1-MM M2BM	6.0	35	82	80.9	44.0	1.1	140°
6.10	3	860.1-0610-024A1-MM M2BM	8.0	24	79	77.9	34.0	1.1	140°
	5	860.1-0610-043A1-MM M2BM	8.0	43	91	89.9	53.0	1.1	140°
6.20	3	860.1-0620-024A1-MM M2BM	8.0	24	79	77.9	34.0	1.1	140°
	5	860.1-0620-043A1-MM M2BM	8.0	43	91	89.9	53.0	1.1	140°
6.30	3	860.1-0630-024A1-MM M2BM	8.0	24	79	77.9	34.0	1.1	140°
	5	860.1-0630-043A1-MM M2BM	8.0	43	91	89.9	53.0	1.1	140°
6.35	3	860.1-0635-024A1-MM M2BM	8.0	24	79	77.8	34.0	1.2	140°
	5	860.1-0635-043A1-MM M2BM	8.0	43	91	89.8	53.0	1.2	140°
6.40	3	860.1-0640-024A1-MM M2BM	8.0	24	79	77.8	34.0	1.2	140°
	5	860.1-0640-043A1-MM M2BM	8.0	43	91	89.8	53.0	1.2	140°
6.50	3	860.1-0650-024A1-MM M2BM	8.0	24	79	77.8	34.0	1.2	140°
	5	860.1-0650-043A1-MM M2BM	8.0	43	91	89.8	53.0	1.2	140°
6.60	3	860.1-0660-024A1-MM M2BM	8.0	24	79	77.8	34.0	1.2	140°
	5	860.1-0660-043A1-MM M2BM	8.0	43	91	89.8	53.0	1.2	140°
6.70	3	860.1-0670-024A1-MM M2BM	8.0	24	79	77.8	34.0	1.2	140°
	5	860.1-0670-043A1-MM M2BM	8.0	43	91	89.8	53.0	1.2	140°
6.75	3	860.1-0675-024A1-MM M2BM	8.0	24	79	77.8	34.0	1.2	140°
	5	860.1-0675-043A1-MM M2BM	8.0	43	91	89.8	53.0	1.2	140°
6.80	3	860.1-0680-024A1-MM M2BM	8.0	24	79	77.8	34.0	1.2	140°
	5	860.1-0680-043A1-MM M2BM	8.0	43	91	89.8	53.0	1.2	140°
6.90	3	860.1-0690-024A1-MM M2BM	8.0	24	79	77.7	34.0	1.3	140°
	5	860.1-0690-043A1-MM M2BM	8.0	43	91	89.7	53.0	1.3	140°
7.00	3	860.1-0700-024A1-MM M2BM	8.0	24	79	77.7	34.0	1.3	140°
	5	860.1-0700-043A1-MM M2BM	8.0	43	91	89.7	53.0	1.3	140°
7.10	3	860.1-0710-029A1-MM M2BM	8.0	29	79	77.7	41.0	1.3	140°
	5	860.1-0710-043A1-MM M2BM	8.0	43	91	89.7	53.0	1.3	140°
7.14	3	860.1-0714-029A1-MM M2BM	8.0	29	79	77.7	41.0	1.3	140°
	5	860.1-0714-043A1-MM M2BM	8.0	43	91	89.7	53.0	1.3	140°
7.20	3	860.1-0720-029A1-MM M2BM	8.0	29	79	77.7	41.0	1.3	140°
	5	860.1-0720-043A1-MM M2BM	8.0	43	91	89.7	53.0	1.3	140°
7.30	3	860.1-0730-029A1-MM M2BM	8.0	29	79	77.7	41.0	1.3	140°
	5	860.1-0730-043A1-MM M2BM	8.0	43	91	89.7	53.0	1.3	140°
7.40	3	860.1-0740-029A1-MM M2BM	8.0	29	79	77.7	41.0	1.3	140°
	5	860.1-0740-043A1-MM M2BM	8.0	43	91	89.7	53.0	1.3	140°
7.50	3	860.1-0750-029A1-MM M2BM	8.0	29	79	77.6	41.0	1.4	140°
	5	860.1-0750-043A1-MM M2BM	8.0	43	91	89.6	53.0	1.4	140°
7.54	3	860.1-0754-029A1-MM M2BM	8.0	29	79	77.6	41.0	1.4	140°
	5	860.1-0754-043A1-MM M2BM	8.0	43	91	89.6	53.0	1.4	140°
7.60	3	860.1-0760-029A1-MM M2BM	8.0	29	79	77.6	41.0	1.4	140°
	5	860.1-0760-043A1-MM M2BM	8.0	43	91	89.6	53.0	1.4	140°

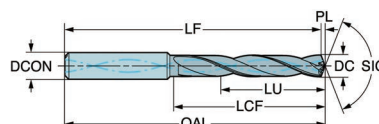
CoroDrill® 860-MM (ステンレス鋼用)

油穴つき

加工径 DC: 3.00 - 20.00mm
 加工深さ: 3 - 5 × DC
 加工公差の目安: H9
 シャンク公差: h6



材種: M2BM (超硬コーティング)



Tailor Made

ドリル径公差DC	
ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

LU = 最大加工深さ



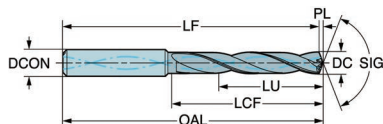
ドリル径 DC1 mm	加工深さ L/D	型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG
7.70	3	860.1-0770-029A1-MM M2BM	8.0	29	79	77.6	41.0	1.4	140°
	5	860.1-0770-043A1-MM M2BM	8.0	43	91	89.6	53.0	1.4	140°
7.80	3	860.1-0780-029A1-MM M2BM	8.0	29	79	77.6	41.0	1.4	140°
	5	860.1-0780-043A1-MM M2BM	8.0	43	91	89.6	53.0	1.4	140°
7.90	3	860.1-0790-029A1-MM M2BM	8.0	29	79	77.6	41.0	1.4	140°
	5	860.1-0790-043A1-MM M2BM	8.0	43	91	89.6	53.0	1.4	140°
7.94	3	860.1-0794-029A1-MM M2BM	8.0	29	79	77.6	41.0	1.4	140°
	5	860.1-0794-043A1-MM M2BM	8.0	43	91	89.6	53.0	1.4	140°
8.00	3	860.1-0800-029A1-MM M2BM	8.0	29	79	77.5	41.0	1.5	140°
	5	860.1-0800-043A1-MM M2BM	8.0	43	91	89.5	53.0	1.5	140°
8.10	3	860.1-0810-035A1-MM M2BM	10.0	35	89	87.5	47.0	1.5	140°
	5	860.1-0810-049A1-MM M2BM	10.0	49	103	101.5	61.0	1.5	140°
8.20	3	860.1-0820-035A1-MM M2BM	10.0	35	89	87.5	47.0	1.5	140°
	5	860.1-0820-049A1-MM M2BM	10.0	49	103	101.5	61.0	1.5	140°
8.30	3	860.1-0830-035A1-MM M2BM	10.0	35	89	87.5	47.0	1.5	140°
	5	860.1-0830-049A1-MM M2BM	10.0	49	103	101.5	61.0	1.5	140°
8.33	3	860.1-0833-035A1-MM M2BM	10.0	35	89	87.5	47.0	1.5	140°
	5	860.1-0833-049A1-MM M2BM	10.0	49	103	101.5	61.0	1.5	140°
8.40	3	860.1-0840-035A1-MM M2BM	10.0	35	89	87.5	47.0	1.5	140°
	5	860.1-0840-049A1-MM M2BM	10.0	49	103	101.5	61.0	1.5	140°
8.50	3	860.1-0850-035A1-MM M2BM	10.0	35	89	87.5	47.0	1.5	140°
	5	860.1-0850-049A1-MM M2BM	10.0	49	103	101.5	61.0	1.5	140°
8.60	3	860.1-0860-035A1-MM M2BM	10.0	35	89	87.4	47.0	1.6	140°
	5	860.1-0860-049A1-MM M2BM	10.0	49	103	101.4	61.0	1.6	140°
8.70	3	860.1-0870-035A1-MM M2BM	10.0	35	89	87.4	47.0	1.6	140°
	5	860.1-0870-049A1-MM M2BM	10.0	49	103	101.4	61.0	1.6	140°
8.73	3	860.1-0873-035A1-MM M2BM	10.0	35	89	87.4	47.0	1.6	140°
	5	860.1-0873-049A1-MM M2BM	10.0	49	103	101.4	61.0	1.6	140°
8.80	3	860.1-0880-035A1-MM M2BM	10.0	35	89	87.4	47.0	1.6	140°
	5	860.1-0880-049A1-MM M2BM	10.0	49	103	101.4	61.0	1.6	140°
8.90	3	860.1-0890-035A1-MM M2BM	10.0	35	89	87.4	47.0	1.6	140°
	5	860.1-0890-049A1-MM M2BM	10.0	49	103	101.4	61.0	1.6	140°
9.00	3	860.1-0900-035A1-MM M2BM	10.0	35	89	87.4	47.0	1.6	140°
	5	860.1-0900-049A1-MM M2BM	10.0	49	103	101.4	61.0	1.6	140°
9.10	3	860.1-0910-035A1-MM M2BM	10.0	35	89	87.3	47.0	1.7	140°
	5	860.1-0910-049A1-MM M2BM	10.0	49	103	101.3	61.0	1.7	140°
9.13	3	860.1-0913-035A1-MM M2BM	10.0	35	89	87.3	47.0	1.7	140°
	5	860.1-0913-049A1-MM M2BM	10.0	49	103	101.3	61.0	1.7	140°
9.20	3	860.1-0920-035A1-MM M2BM	10.0	35	89	87.3	47.0	1.7	140°
	5	860.1-0920-049A1-MM M2BM	10.0	49	103	101.3	61.0	1.7	140°
9.30	3	860.1-0930-035A1-MM M2BM	10.0	35	89	87.3	47.0	1.7	140°
	5	860.1-0930-049A1-MM M2BM	10.0	49	103	101.3	61.0	1.7	140°
9.40	3	860.1-0940-035A1-MM M2BM	10.0	35	89	87.3	47.0	1.7	140°
	5	860.1-0940-049A1-MM M2BM	10.0	49	103	101.3	61.0	1.7	140°
9.50	3	860.1-0950-035A1-MM M2BM	10.0	35	89	87.3	47.0	1.7	140°
	5	860.1-0950-049A1-MM M2BM	10.0	49	103	101.3	61.0	1.7	140°
9.53	3	860.1-0953-035A1-MM M2BM	10.0	35	89	87.3	47.0	1.7	140°
	5	860.1-0953-049A1-MM M2BM	10.0	49	103	101.3	61.0	1.7	140°
9.60	3	860.1-0960-035A1-MM M2BM	10.0	35	89	87.3	47.0	1.7	140°
	5	860.1-0960-049A1-MM M2BM	10.0	49	103	101.3	61.0	1.7	140°
9.70	3	860.1-0970-035A1-MM M2BM	10.0	35	89	87.2	47.0	1.8	140°
	5	860.1-0970-049A1-MM M2BM	10.0	49	103	101.2	61.0	1.8	140°
9.80	3	860.1-0980-035A1-MM M2BM	10.0	35	89	87.2	47.0	1.8	140°
	5	860.1-0980-049A1-MM M2BM	10.0	49	103	101.2	61.0	1.8	140°
9.90	3	860.1-0990-035A1-MM M2BM	10.0	35	89	87.2	47.0	1.8	140°
	5	860.1-0990-049A1-MM M2BM	10.0	49	103	101.2	61.0	1.8	140°
9.92	3	860.1-0992-035A1-MM M2BM	10.0	35	89	87.2	47.0	1.8	140°
	5	860.1-0992-049A1-MM M2BM	10.0	49	103	101.2	61.0	1.8	140°
10.00	3	860.1-1000-035A1-MM M2BM	10.0	35	89	87.2	47.0	1.8	140°
	5	860.1-1000-049A1-MM M2BM	10.0	49	103	101.2	61.0	1.8	140°
10.10	3	860.1-1010-040A1-MM M2BM	12.0	40	102	100.2	55.0	1.8	140°
	5	860.1-1010-056A1-MM M2BM	12.0	56	118	116.2	71.0	1.8	140°

ドリル径		型番	寸法, mm							
DC1 mm	加工深さ L/D		内部給油	DCON	LU	OAL	LF	LCF	PL	SIG
10.20	3	860.1-1020-040A1-MM M2BM	12.0	40	102	100.1	55.0	1.9	140°	
	5	860.1-1020-056A1-MM M2BM	12.0	56	118	116.1	71.0	1.9	140°	
10.30	3	860.1-1030-040A1-MM M2BM	12.0	40	102	100.1	55.0	1.9	140°	
	5	860.1-1030-056A1-MM M2BM	12.0	56	118	116.1	71.0	1.9	140°	
10.32	3	860.1-1032-040A1-MM M2BM	12.0	40	102	100.1	55.0	1.9	140°	
	5	860.1-1032-056A1-MM M2BM	12.0	56	118	116.1	71.0	1.9	140°	
10.40	3	860.1-1040-040A1-MM M2BM	12.0	40	102	100.1	55.0	1.9	140°	
	5	860.1-1040-056A1-MM M2BM	12.0	56	118	116.1	71.0	1.9	140°	
10.50	3	860.1-1050-040A1-MM M2BM	12.0	40	102	100.1	55.0	1.9	140°	
	5	860.1-1050-056A1-MM M2BM	12.0	56	118	116.1	71.0	1.9	140°	
10.60	3	860.1-1060-040A1-MM M2BM	12.0	40	102	100.1	55.0	1.9	140°	
	5	860.1-1060-056A1-MM M2BM	12.0	56	118	116.1	71.0	1.9	140°	
10.70	3	860.1-1070-040A1-MM M2BM	12.0	40	102	100.1	55.0	1.9	140°	
	5	860.1-1070-056A1-MM M2BM	12.0	56	118	116.1	71.0	1.9	140°	
10.72	3	860.1-1072-040A1-MM M2BM	12.0	40	102	100.0	55.0	2.0	140°	
	5	860.1-1072-056A1-MM M2BM	12.0	56	118	116.0	71.0	2.0	140°	
10.80	3	860.1-1080-040A1-MM M2BM	12.0	40	102	100.0	55.0	2.0	140°	
	5	860.1-1080-056A1-MM M2BM	12.0	56	118	116.0	71.0	2.0	140°	
10.90	3	860.1-1090-040A1-MM M2BM	12.0	40	102	100.0	55.0	2.0	140°	
	5	860.1-1090-056A1-MM M2BM	12.0	56	118	116.0	71.0	2.0	140°	
11.00	3	860.1-1100-040A1-MM M2BM	12.0	40	102	100.0	55.0	2.0	140°	
	5	860.1-1100-056A1-MM M2BM	12.0	56	118	116.0	71.0	2.0	140°	
11.10	3	860.1-1110-040A1-MM M2BM	12.0	40	102	100.0	55.0	2.0	140°	
	5	860.1-1110-056A1-MM M2BM	12.0	56	118	116.0	71.0	2.0	140°	
11.11	3	860.1-1111-040A1-MM M2BM	12.0	40	102	100.0	55.0	2.0	140°	
	5	860.1-1111-056A1-MM M2BM	12.0	56	118	116.0	71.0	2.0	140°	
11.20	3	860.1-1120-040A1-MM M2BM	12.0	40	102	100.0	55.0	2.0	140°	
	5	860.1-1120-056A1-MM M2BM	12.0	56	118	116.0	71.0	2.0	140°	
11.30	3	860.1-1130-040A1-MM M2BM	12.0	40	102	99.9	55.0	2.1	140°	
	5	860.1-1130-056A1-MM M2BM	12.0	56	118	115.9	71.0	2.1	140°	
11.40	3	860.1-1140-040A1-MM M2BM	12.0	40	102	99.9	55.0	2.1	140°	
	5	860.1-1140-056A1-MM M2BM	12.0	56	118	115.9	71.0	2.1	140°	
11.50	3	860.1-1150-040A1-MM M2BM	12.0	40	102	99.9	55.0	2.1	140°	
	5	860.1-1150-056A1-MM M2BM	12.0	56	118	115.9	71.0	2.1	140°	
11.51	3	860.1-1151-040A1-MM M2BM	12.0	40	102	99.9	55.0	2.1	140°	
	5	860.1-1151-056A1-MM M2BM	12.0	56	118	115.9	71.0	2.1	140°	
11.60	3	860.1-1160-040A1-MM M2BM	12.0	40	102	99.9	55.0	2.1	140°	
	5	860.1-1160-056A1-MM M2BM	12.0	56	118	115.9	71.0	2.1	140°	
11.70	3	860.1-1170-040A1-MM M2BM	12.0	40	102	99.9	55.0	2.1	140°	
	5	860.1-1170-056A1-MM M2BM	12.0	56	118	115.9	71.0	2.1	140°	
11.80	3	860.1-1180-040A1-MM M2BM	12.0	40	102	99.9	55.0	2.1	140°	
	5	860.1-1180-056A1-MM M2BM	12.0	56	118	115.9	71.0	2.1	140°	
11.90	3	860.1-1190-040A1-MM M2BM	12.0	40	102	99.8	55.0	2.2	140°	
	5	860.1-1190-056A1-MM M2BM	12.0	56	118	115.8	71.0	2.2	140°	
12.00	3	860.1-1200-040A1-MM M2BM	12.0	40	102	99.8	55.0	2.2	140°	
	5	860.1-1200-056A1-MM M2BM	12.0	56	118	115.8	71.0	2.2	140°	
12.10	3	860.1-1210-043A1-MM M2BM	14.0	43	107	104.8	60.0	2.2	140°	
	5	860.1-1210-060A1-MM M2BM	14.0	60	124	121.8	77.0	2.2	140°	
12.20	3	860.1-1220-043A1-MM M2BM	14.0	43	107	104.8	60.0	2.2	140°	
	5	860.1-1220-060A1-MM M2BM	14.0	60	124	121.8	77.0	2.2	140°	
12.30	3	860.1-1230-043A1-MM M2BM	14.0	43	107	104.8	60.0	2.2	140°	
	5	860.1-1230-060A1-MM M2BM	14.0	60	124	121.8	77.0	2.2	140°	
12.50	3	860.1-1250-043A1-MM M2BM	14.0	43	107	104.7	60.0	2.3	140°	
	5	860.1-1250-060A1-MM M2BM	14.0	60	124	121.7	77.0	2.3	140°	
12.60	3	860.1-1260-043A1-MM M2BM	14.0	43	107	104.7	60.0	2.3	140°	
	5	860.1-1260-060A1-MM M2BM	14.0	60	124	121.7	77.0	2.3	140°	
12.70	3	860.1-1270-043A1-MM M2BM	14.0	43	107	104.7	60.0	2.3	140°	
	5	860.1-1270-060A1-MM M2BM	14.0	60	124	121.7	77.0	2.3	140°	
12.80	3	860.1-1280-043A1-MM M2BM	14.0	43	107	104.7	60.0	2.3	140°	
	5	860.1-1280-060A1-MM M2BM	14.0	60	124	121.7	77.0	2.3	140°	
12.90	3	860.1-1290-043A1-MM M2BM	14.0	43	107	104.7	60.0	2.3	140°	
	5	860.1-1290-060A1-MM M2BM	14.0	60	124	121.7	77.0	2.3	140°	

CoroDrill® 860-MM (ステンレス鋼用)

油穴つき

加工径 DC: 3.00 - 20.00mm
 加工深さ: 3 - 5 × DC
 加工公差の目安: H9
 シャンク公差: h6



Tailor
Made

ドリル径公差DC

ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

材種: M2BM (超硬コーティング)

LU = 最大加工深さ



ドリル径 DC1 mm	加工深さ L/D	型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG
13.00	3	860.1-1300-043A1-MM M2BM	14.0	43	107	104.6	60.0	2.4	140°
	5	860.1-1300-060A1-MM M2BM	14.0	60	124	121.6	77.0	2.4	140°
13.10	3	860.1-1310-043A1-MM M2BM	14.0	43	107	104.6	60.0	2.4	140°
	5	860.1-1310-060A1-MM M2BM	14.0	60	124	121.6	77.0	2.4	140°
13.30	3	860.1-1330-043A1-MM M2BM	14.0	43	107	104.6	60.0	2.4	140°
	5	860.1-1330-060A1-MM M2BM	14.0	60	124	121.6	77.0	2.4	140°
13.49	3	860.1-1349-043A1-MM M2BM	14.0	43	107	104.5	60.0	2.5	140°
	5	860.1-1349-060A1-MM M2BM	14.0	60	124	121.5	77.0	2.5	140°
13.50	3	860.1-1350-043A1-MM M2BM	14.0	43	107	104.5	60.0	2.5	140°
	5	860.1-1350-060A1-MM M2BM	14.0	60	124	121.5	77.0	2.5	140°
13.80	3	860.1-1380-043A1-MM M2BM	14.0	43	107	104.5	60.0	2.5	140°
	5	860.1-1380-060A1-MM M2BM	14.0	60	124	121.5	77.0	2.5	140°
14.00	3	860.1-1400-043A1-MM M2BM	14.0	43	107	104.5	60.0	2.5	140°
	5	860.1-1400-060A1-MM M2BM	14.0	60	124	121.5	77.0	2.5	140°
14.20	3	860.1-1420-045A1-MM M2BM	16.0	45	115	112.4	65.0	2.6	140°
	5	860.1-1420-063A1-MM M2BM	16.0	63	133	130.4	83.0	2.6	140°
14.29	3	860.1-1429-045A1-MM M2BM	16.0	45	115	112.4	65.0	2.6	140°
	5	860.1-1429-063A1-MM M2BM	16.0	63	133	130.4	83.0	2.6	140°
14.40	3	860.1-1440-045A1-MM M2BM	16.0	45	115	112.4	65.0	2.6	140°
	5	860.1-1440-063A1-MM M2BM	16.0	63	133	130.4	83.0	2.6	140°
14.50	3	860.1-1450-045A1-MM M2BM	16.0	45	115	112.4	65.0	2.6	140°
	5	860.1-1450-063A1-MM M2BM	16.0	63	133	130.4	83.0	2.6	140°
14.75	3	860.1-1475-045A1-MM M2BM	16.0	45	115	112.3	65.0	2.7	140°
	5	860.1-1475-063A1-MM M2BM	16.0	63	133	130.3	83.0	2.7	140°
14.80	3	860.1-1480-045A1-MM M2BM	16.0	45	115	112.3	65.0	2.7	140°
	5	860.1-1480-063A1-MM M2BM	16.0	63	133	130.3	83.0	2.7	140°
15.00	3	860.1-1500-045A1-MM M2BM	16.0	45	115	112.3	65.0	2.7	140°
	5	860.1-1500-063A1-MM M2BM	16.0	63	133	130.3	83.0	2.7	140°
15.10	3	860.1-1510-045A1-MM M2BM	16.0	45	115	112.3	65.0	2.7	140°
	5	860.1-1510-063A1-MM M2BM	16.0	63	133	130.3	83.0	2.7	140°
15.20	3	860.1-1520-045A1-MM M2BM	16.0	45	115	112.2	65.0	2.8	140°
	5	860.1-1520-063A1-MM M2BM	16.0	63	133	130.2	83.0	2.8	140°
15.30	3	860.1-1530-045A1-MM M2BM	16.0	45	115	112.2	65.0	2.8	140°
	5	860.1-1530-063A1-MM M2BM	16.0	63	133	130.2	83.0	2.8	140°
15.50	3	860.1-1550-045A1-MM M2BM	16.0	45	115	112.2	65.0	2.8	140°
	5	860.1-1550-063A1-MM M2BM	16.0	63	133	130.2	83.0	2.8	140°
15.80	3	860.1-1580-045A1-MM M2BM	16.0	45	115	112.1	65.0	2.9	140°
	5	860.1-1580-063A1-MM M2BM	16.0	63	133	130.1	83.0	2.9	140°
15.88	3	860.1-1588-045A1-MM M2BM	16.0	45	115	112.1	65.0	2.9	140°
	5	860.1-1588-063A1-MM M2BM	16.0	63	133	130.1	83.0	2.9	140°
16.00	3	860.1-1600-045A1-MM M2BM	16.0	45	115	112.1	65.0	2.9	140°
	5	860.1-1600-063A1-MM M2BM	16.0	63	133	130.1	83.0	2.9	140°
16.50	3	860.1-1650-051A1-MM M2BM	18.0	51	123	120.0	73.0	3.0	140°
	5	860.1-1650-071A1-MM M2BM	18.0	71	143	140.0	93.0	3.0	140°
17.00	3	860.1-1700-051A1-MM M2BM	18.0	51	123	119.9	73.0	3.1	140°
	5	860.1-1700-071A1-MM M2BM	18.0	71	143	139.9	93.0	3.1	140°
17.50	3	860.1-1750-051A1-MM M2BM	18.0	51	123	119.8	73.0	3.2	140°
	5	860.1-1750-071A1-MM M2BM	18.0	71	143	139.8	93.0	3.2	140°
18.00	3	860.1-1800-051A1-MM M2BM	18.0	51	123	119.7	73.0	3.3	140°
	5	860.1-1800-071A1-MM M2BM	18.0	71	143	139.7	93.0	3.3	140°
18.50	3	860.1-1850-055A1-MM M2BM	20.0	55	131	127.6	79.0	3.4	140°
	5	860.1-1850-077A1-MM M2BM	20.0	77	153	149.6	101.0	3.4	140°
19.00	3	860.1-1900-055A1-MM M2BM	20.0	55	131	127.5	79.0	3.5	140°
	5	860.1-1900-077A1-MM M2BM	20.0	77	153	149.5	101.0	3.5	140°
19.50	3	860.1-1950-055A1-MM M2BM	20.0	55	131	127.5	79.0	3.5	140°
	5	860.1-1950-077A1-MM M2BM	20.0	77	153	149.5	101.0	3.5	140°
20.00	3	860.1-2000-055A1-MM M2BM	20.0	55	131	127.4	79.0	3.6	140°
	5	860.1-2000-077A1-MM M2BM	20.0	77	153	149.4	101.0	3.6	140°

注文例: 860.1-0300-014A1-MM M2BM GC2214 10本

CoroDrill® 860-SD (ニッケル基耐熱合金用)

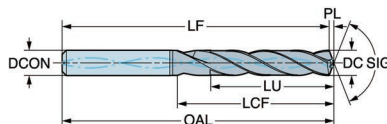
油穴つき



加工径 DC: 3.00 - 16.00mm
 加工深さ: 3 - 8 × DC
 加工公差の目安: H9
 シャンク公差: h6



材質: S2BM (超硬コーティング)

Tailor
Made

ドリル径公差DC	
ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

LU = 最大加工深さ

S

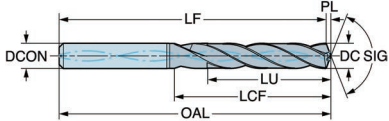
ドリル径 DC1 mm	加工深さ L/D	型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG
3.00	3	860.1-0300-009A1-SD	6.0	9.6	62	61.5	20	0.5	140°
	5	860.1-0300-015A1-SD	6.0	15.6	66	65.5	28	0.5	140°
	8	860.1-0300-024A1-SD	6.0	24.6	79	78.5	37	0.5	140°
3.10	3	860.1-0310-009A1-SD	6.0	9.9	62	61.4	20	0.6	140°
	5	860.1-0310-016A1-SD	6.0	16.1	66	65.4	28	0.6	140°
	8	860.1-0310-025A1-SD	6.0	25.4	79	78.4	37	0.6	140°
3.17	3	860.1-0317-010A1-SD	6.0	10.1	62	61.4	20	0.6	140°
	5	860.1-0317-016A1-SD	6.0	16.4	66	65.4	28	0.6	140°
	8	860.1-0317-025A1-SD	6.0	25.9	79	78.4	37	0.6	140°
3.18	3	860.1-0318-010A1-SD	6.0	10.1	62	61.4	20	0.6	140°
	5	860.1-0318-016A1-SD	6.0	16.5	66	65.4	28	0.6	140°
	8	860.1-0318-026A1-SD	6.0	26.0	79	78.4	37	0.6	140°
3.20	3	860.1-0320-010A1-SD	6.0	10.2	62	61.4	20	0.6	140°
	5	860.1-0320-016A1-SD	6.0	16.6	66	65.4	28	0.6	140°
	8	860.1-0320-026A1-SD	6.0	26.2	79	78.4	37	0.6	140°
3.25	3	860.1-0325-010A1-SD	6.0	10.3	62	61.4	20	0.6	140°
	5	860.1-0325-016A1-SD	6.0	16.8	66	65.4	28	0.6	140°
	8	860.1-0325-026A1-SD	6.0	26.6	79	78.4	37	0.6	140°
3.30	3	860.1-0330-010A1-SD	6.0	10.5	62	61.4	20	0.6	140°
	5	860.1-0330-017A1-SD	6.0	17.1	66	65.4	28	0.6	140°
	8	860.1-0330-027A1-SD	6.0	27.0	79	78.4	37	0.6	140°
3.38	3	860.1-0338-010A1-SD	6.0	10.8	62	61.4	20	0.6	140°
	5	860.1-0338-017A1-SD	6.0	17.5	66	65.4	28	0.6	140°
	8	860.1-0338-027A1-SD	6.0	27.7	79	78.4	37	0.6	140°
3.40	3	860.1-0340-010A1-SD	6.0	10.8	62	61.4	20	0.6	140°
	5	860.1-0340-017A1-SD	6.0	17.6	66	65.4	28	0.6	140°
	8	860.1-0340-027A1-SD	6.0	27.8	79	78.4	37	0.6	140°
3.45	3	860.1-0345-010A1-SD	6.0	11.0	62	61.4	20	0.6	140°
	5	860.1-0345-017A1-SD	6.0	17.9	66	65.4	28	0.6	140°
	8	860.1-0345-028A1-SD	6.0	28.2	79	78.4	37	0.6	140°
3.50	3	860.1-0350-011A1-SD	6.0	11.1	62	61.4	20	0.6	140°
	5	860.1-0350-018A1-SD	6.0	18.1	66	65.4	28	0.6	140°
	8	860.1-0350-028A1-SD	6.0	28.6	79	78.4	37	0.6	140°
3.55	3	860.1-0355-011A1-SD	6.0	11.3	62	61.4	20	0.6	140°
	5	860.1-0355-018A1-SD	6.0	18.4	66	65.4	28	0.6	140°
	8	860.1-0355-029A1-SD	6.0	29.1	79	78.4	37	0.6	140°
3.57	3	860.1-0357-011A1-SD	6.0	11.4	62	61.4	20	0.7	140°
	5	860.1-0357-018A1-SD	6.0	18.5	66	65.4	28	0.7	140°
	8	860.1-0357-029A1-SD	6.0	29.2	79	78.4	37	0.7	140°
3.60	3	860.1-0360-011A1-SD	6.0	11.5	62	61.3	20	0.7	140°
	5	860.1-0360-018A1-SD	6.0	18.7	66	65.3	28	0.7	140°
	8	860.1-0360-029A1-SD	6.0	29.5	79	78.3	37	0.7	140°
3.70	3	860.1-0370-011A1-SD	6.0	11.8	62	61.3	20	0.7	140°
	5	860.1-0370-019A1-SD	6.0	19.2	66	65.3	28	0.7	140°
	8	860.1-0370-030A1-SD	6.0	30.3	79	78.3	37	0.7	140°
3.80	3	860.1-0380-012A1-SD	6.0	12.1	66	65.3	24	0.7	140°
	5	860.1-0380-019A1-SD	6.0	19.7	74	73.3	36	0.7	140°
	8	860.1-0380-031A1-SD	6.0	31.1	90	89.3	48	0.7	140°
3.90	3	860.1-0390-012A1-SD	6.0	12.4	66	65.3	24	0.7	140°
	5	860.1-0390-020A1-SD	6.0	20.2	74	73.3	36	0.7	140°
	8	860.1-0390-031A1-SD	6.0	31.9	90	89.3	48	0.7	140°
3.97	3	860.1-0397-012A1-SD	6.0	12.6	66	65.3	24	0.7	140°
	5	860.1-0397-020A1-SD	6.0	20.6	74	73.3	36	0.7	140°
	8	860.1-0397-032A1-SD	6.0	32.5	90	89.3	48	0.7	140°
4.00	3	860.1-0400-012A1-SD	6.0	12.7	66	65.3	24	0.7	140°
	5	860.1-0400-020A1-SD	6.0	20.7	74	73.3	36	0.7	140°
	8	860.1-0400-032A1-SD	6.0	32.7	90	89.3	48	0.7	140°
4.10	3	860.1-0410-013A1-SD	6.0	13.1	66	65.3	24	0.7	140°
	5	860.1-0410-021A1-SD	6.0	21.3	74	73.3	36	0.7	140°
	8	860.1-0410-033A1-SD	6.0	33.6	90	89.3	48	0.7	140°
4.15	3	860.1-0415-013A1-SD	6.0	13.2	66	65.2	24	0.8	140°
	5	860.1-0415-021A1-SD	6.0	21.5	74	73.2	36	0.8	140°
	8	860.1-0415-033A1-SD	6.0	34.0	90	89.2	48	0.8	140°

ドリル径 DC1 mm	加工深さ L/D	型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG
4.20	3	860.1-0420-013A1-SD	6.0	13.4	66	65.2	24	0.8	140°
	5	860.1-0420-021A1-SD	6.0	21.8	74	73.2	36	0.8	140°
	8	860.1-0420-034A1-SD	6.0	34.4	90	89.2	48	0.8	140°
4.30	3	860.1-0430-013A1-SD	6.0	13.7	66	65.2	24	0.8	140°
	5	860.1-0430-022A1-SD	6.0	22.3	74	73.2	36	0.8	140°
	8	860.1-0430-035A1-SD	6.0	35.2	90	89.2	48	0.8	140°
4.37	3	860.1-0437-013A1-SD	6.0	13.9	66	65.2	24	0.8	140°
	5	860.1-0437-022A1-SD	6.0	22.7	74	73.2	36	0.8	140°
	8	860.1-0437-035A1-SD	6.0	35.8	90	89.2	48	0.8	140°
4.40	3	860.1-0440-014A1-SD	6.0	14.0	66	65.2	24	0.8	140°
	5	860.1-0440-022A1-SD	6.0	22.8	74	73.2	36	0.8	140°
	8	860.1-0440-036A1-SD	6.0	36.0	90	89.2	48	0.8	140°
4.50	3	860.1-0450-014A1-SD	6.0	14.3	66	65.2	24	0.8	140°
	5	860.1-0450-023A1-SD	6.0	23.3	74	73.2	36	0.8	140°
	8	860.1-0450-036A1-SD	6.0	36.8	90	89.2	48	0.8	140°
4.55	3	860.1-0455-014A1-SD	6.0	14.5	66	65.2	24	0.8	140°
	5	860.1-0455-023A1-SD	6.0	23.6	74	73.2	36	0.8	140°
	8	860.1-0455-037A1-SD	6.0	37.2	90	89.2	48	0.8	140°
4.60	3	860.1-0460-014A1-SD	6.0	14.6	66	65.2	24	0.8	140°
	5	860.1-0460-023A1-SD	6.0	23.8	74	73.2	36	0.8	140°
	8	860.1-0460-037A1-SD	6.0	37.6	90	89.2	48	0.8	140°
4.65	3	860.1-0465-014A1-SD	6.0	14.8	66	65.2	24	0.8	140°
	5	860.1-0465-024A1-SD	6.0	24.1	74	73.2	36	0.8	140°
	8	860.1-0465-038A1-SD	6.0	38.1	90	89.2	48	0.8	140°
4.70	3	860.1-0470-014A1-SD	6.0	15.0	66	65.1	24	0.9	140°
	5	860.1-0470-024A1-SD	6.0	24.4	74	73.1	36	0.9	140°
	8	860.1-0470-038A1-SD	6.0	38.5	90	89.1	48	0.9	140°
4.76	3	860.1-0476-015A1-SD	6.0	15.2	66	65.1	28	0.9	140°
	5	860.1-0476-024A1-SD	6.0	24.7	82	81.1	44	0.9	140°
	8	860.1-0476-038A1-SD	6.0	39.0	104	103.1	62	0.9	140°
4.80	3	860.1-0480-015A1-SD	6.0	15.3	66	65.1	28	0.9	140°
	5	860.1-0480-024A1-SD	6.0	24.9	82	81.1	44	0.9	140°
	8	860.1-0480-039A1-SD	6.0	39.3	104	103.1	62	0.9	140°
4.90	3	860.1-0490-015A1-SD	6.0	15.6	66	65.1	28	0.9	140°
	5	860.1-0490-025A1-SD	6.0	25.4	82	81.1	44	0.9	140°
	8	860.1-0490-040A1-SD	6.0	40.1	104	103.1	62	0.9	140°
5.00	3	860.1-0500-015A1-SD	6.0	15.9	66	65.1	28	0.9	140°
	5	860.1-0500-025A1-SD	6.0	25.9	82	81.1	44	0.9	140°
	8	860.1-0500-040A1-SD	6.0	40.9	104	103.1	62	0.9	140°
5.10	3	860.1-0510-016A1-SD	6.0	16.2	66	65.1	28	0.9	140°
	5	860.1-0510-026A1-SD	6.0	26.4	82	81.1	44	0.9	140°
	8	860.1-0510-041A1-SD	6.0	41.7	104	103.1	62	0.9	140°
5.16	3	860.1-0516-016A1-SD	6.0	16.4	66	65.1	28	0.9	140°
	5	860.1-0516-026A1-SD	6.0	26.7	82	81.1	44	0.9	140°
	8	860.1-0516-042A1-SD	6.0	42.2	104	103.1	62	0.9	140°</

CoroDrill® 860-SD（ニッケル基耐熱合金用）

油穴つき

加工径 DC: 3.00 - 16.00mm
加工深さ: 3 - 8 × DC
加工公差の目安: H9
シャンク公差: h6



Tailor Made

ドリル径公差DC	
ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

材質：S2BM(超硬コーティング)

LU = 最大加工深さ

S

ドリル径 DC1 mm	加工深さ L/D	型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG
5.56	3	860.1-0556-017A1-SD	6.0	17.7	66	65.0	28	1.0	140°
	5	860.1-0556-028A1-SD	6.0	28.8	82	81.0	44	1.0	140°
	8	860.1-0556-045A1-SD	6.0	45.5	104	103.0	62	1.0	140°
5.60	3	860.1-0560-017A1-SD	6.0	17.8	66	65.0	28	1.0	140°
	5	860.1-0560-029A1-SD	6.0	29.0	82	81.0	44	1.0	140°
	8	860.1-0560-045A1-SD	6.0	45.8	104	103.0	62	1.0	140°
5.70	3	860.1-0570-018A1-SD	6.0	18.1	66	65.0	28	1.0	140°
	5	860.1-0570-029A1-SD	6.0	29.5	82	81.0	44	1.0	140°
	8	860.1-0570-046A1-SD	6.0	46.6	104	103.0	62	1.0	140°
5.80	3	860.1-0580-018A1-SD	6.0	18.5	66	64.9	28	1.1	140°
	5	860.1-0580-030A1-SD	6.0	30.1	82	80.9	44	1.1	140°
	8	860.1-0580-047A1-SD	6.0	47.5	104	102.9	62	1.1	140°
5.90	3	860.1-0590-018A1-SD	6.0	18.8	66	64.9	28	1.1	140°
	5	860.1-0590-030A1-SD	6.0	30.6	82	80.9	44	1.1	140°
	8	860.1-0590-048A1-SD	6.0	48.3	104	102.9	62	1.1	140°
5.95	3	860.1-0595-018A1-SD	6.0	18.9	66	64.9	28	1.1	140°
	5	860.1-0595-030A1-SD	6.0	30.8	82	80.9	44	1.1	140°
	8	860.1-0595-048A1-SD	6.0	48.7	104	102.9	62	1.1	140°
6.00	3	860.1-0600-019A1-SD	6.0	19.1	66	64.9	28	1.1	140°
	5	860.1-0600-031A1-SD	6.0	31.1	82	80.9	44	1.1	140°
	8	860.1-0600-049A1-SD	6.0	49.1	104	102.9	62	1.1	140°
6.10	3	860.1-0610-019A1-SD	8.0	19.4	79	77.9	34	1.1	140°
	5	860.1-0610-031A1-SD	8.0	31.6	91	89.9	53	1.1	140°
	8	860.1-0610-049A1-SD	8.0	49.9	126	124.9	84	1.1	140°
6.20	3	860.1-0620-019A1-SD	8.0	19.7	79	77.9	34	1.1	140°
	5	860.1-0620-032A1-SD	8.0	32.1	91	89.9	53	1.1	140°
	8	860.1-0620-050A1-SD	8.0	50.7	126	124.9	84	1.1	140°
6.30	3	860.1-0630-020A1-SD	8.0	20.1	79	77.9	34	1.1	140°
	5	860.1-0630-032A1-SD	8.0	32.7	91	89.9	53	1.1	140°
	8	860.1-0630-051A1-SD	8.0	51.6	126	124.9	84	1.1	140°
6.35	3	860.1-0635-020A1-SD	8.0	20.2	79	77.8	34	1.2	140°
	5	860.1-0635-032A1-SD	8.0	32.9	91	89.8	53	1.2	140°
	8	860.1-0635-051A1-SD	8.0	52.0	126	124.8	84	1.2	140°
6.40	3	860.1-0640-020A1-SD	8.0	20.4	79	77.8	34	1.2	140°
	5	860.1-0640-033A1-SD	8.0	33.2	91	89.8	53	1.2	140°
	8	860.1-0640-052A1-SD	8.0	52.4	126	124.8	84	1.2	140°
6.50	3	860.1-0650-020A1-SD	8.0	20.7	79	77.8	34	1.2	140°
	5	860.1-0650-033A1-SD	8.0	33.7	91	89.8	53	1.2	140°
	8	860.1-0650-053A1-SD	8.0	53.2	126	124.8	84	1.2	140°
6.60	3	860.1-0660-021A1-SD	8.0	21.0	79	77.8	34	1.2	140°
	5	860.1-0660-034A1-SD	8.0	34.2	91	89.8	53	1.2	140°
	8	860.1-0660-054A1-SD	8.0	54.0	126	124.8	84	1.2	140°
6.70	3	860.1-0670-021A1-SD	8.0	21.3	79	77.8	34	1.2	140°
	5	860.1-0670-034A1-SD	8.0	34.7	91	89.8	53	1.2	140°
	8	860.1-0670-054A1-SD	8.0	54.8	126	124.8	84	1.2	140°
6.75	3	860.1-0675-021A1-SD	8.0	21.5	79	77.8	34	1.2	140°
	5	860.1-0675-034A1-SD	8.0	35.0	91	89.8	53	1.2	140°
	8	860.1-0675-055A1-SD	8.0	55.2	126	124.8	84	1.2	140°
6.80	3	860.1-0680-021A1-SD	8.0	21.6	79	77.8	34	1.2	140°
	5	860.1-0680-035A1-SD	8.0	35.2	91	89.8	53	1.2	140°
	8	860.1-0680-055A1-SD	8.0	55.6	126	124.8	84	1.2	140°
6.90	3	860.1-0690-021A1-SD	8.0	22.0	79	77.7	34	1.3	140°
	5	860.1-0690-035A1-SD	8.0	35.8	91	89.7	53	1.3	140°
	8	860.1-0690-056A1-SD	8.0	56.5	126	124.7	84	1.3	140°
7.00	3	860.1-0700-022A1-SD	8.0	22.3	79	77.7	34	1.3	140°
	5	860.1-0700-036A1-SD	8.0	36.3	91	89.7	53	1.3	140°
	8	860.1-0700-057A1-SD	8.0	57.3	126	124.7	84	1.3	140°
7.10	3	860.1-0710-022A1-SD	8.0	22.6	79	77.7	41	1.3	140°
	5	860.1-0710-036A1-SD	8.0	36.8	91	89.7	53	1.3	140°
	8	860.1-0710-058A1-SD	8.0	58.1	126	124.7	84	1.3	140°
7.14	3	860.1-0714-022A1-SD	8.0	22.7	79	77.7	41	1.3	140°
	5	860.1-0714-036A1-SD	8.0	37.0	91	89.7	53	1.3	140°
	8	860.1-0714-058A1-SD	8.0	58.4	126	124.7	84	1.3	140°

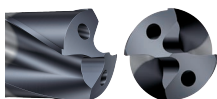
ドリル径		型番 内部給油	寸法, mm						
DC1 mm	加工深さ L/D		DCON	LU	OAL	LF	LCF	PL	SIG
7.20	3	860.1-0720-022A1-SD	8.0	22.9	79	77.7	41	1.3	140°
	5	860.1-0720-037A1-SD	8.0	37.3	91	89.7	53	1.3	140°
	8	860.1-0720-058A1-SD	8.0	58.9	126	124.7	84	1.3	140°
7.30	3	860.1-0730-023A1-SD	8.0	23.2	79	77.7	41	1.3	140°
	5	860.1-0730-037A1-SD	8.0	37.8	91	89.7	53	1.3	140°
	8	860.1-0730-059A1-SD	8.0	59.7	126	124.7	84	1.3	140°
7.40	3	860.1-0740-023A1-SD	8.0	23.6	79	77.7	41	1.3	140°
	5	860.1-0740-038A1-SD	8.0	38.4	91	89.7	53	1.3	140°
	8	860.1-0740-060A1-SD	8.0	60.6	126	124.7	84	1.3	140°
7.50	3	860.1-0750-023A1-SD	8.0	23.9	79	77.6	41	1.4	140°
	5	860.1-0750-038A1-SD	8.0	38.9	91	89.6	53	1.4	140°
	8	860.1-0750-061A1-SD	8.0	61.4	126	124.6	84	1.4	140°
7.54	3	860.1-0754-023A1-SD	8.0	24.0	79	77.6	41	1.4	140°
	5	860.1-0754-039A1-SD	8.0	39.1	91	89.6	53	1.4	140°
	8	860.1-0754-061A1-SD	8.0	61.7	126	124.6	84	1.4	140°
7.60	3	860.1-0760-024A1-SD	8.0	24.2	79	77.6	41	1.4	140°
	5	860.1-0760-039A1-SD	8.0	39.4	91	89.6	53	1.4	140°
	8	860.1-0760-062A1-SD	8.0	62.2	126	124.6	84	1.4	140°
7.70	3	860.1-0770-024A1-SD	8.0	24.5	79	77.6	41	1.4	140°
	5	860.1-0770-039A1-SD	8.0	39.9	91	89.6	53	1.4	140°
	8	860.1-0770-063A1-SD	8.0	63.0	126	124.6	84	1.4	140°
7.80	3	860.1-0780-024A1-SD	8.0	24.8	79	77.6	41	1.4	140°
	5	860.1-0780-040A1-SD	8.0	40.4	91	89.6	53	1.4	140°
	8	860.1-0780-063A1-SD	8.0	63.8	126	124.6	84	1.4	140°
7.90	3	860.1-0790-025A1-SD	8.0	25.1	79	77.6	41	1.4	140°
	5	860.1-0790-040A1-SD	8.0	40.9	91	89.6	53	1.4	140°
	8	860.1-0790-064A1-SD	8.0	64.6	126	124.6	84	1.4	140°
7.94	3	860.1-0794-025A1-SD	8.0	25.3	79	77.6	41	1.4	140°
	5	860.1-0794-041A1-SD	8.0	41.1	91	89.6	53	1.4	140°
	8	860.1-0794-064A1-SD	8.0	65.0	126	124.6	84	1.4	140°
8.00	3	860.1-0800-025A1-SD	8.0	25.5	79	77.5	41	1.5	140°
	5	860.1-0800-041A1-SD	8.0	41.5	91	89.5	53	1.5	140°
	8	860.1-0800-065A1-SD	8.0	65.5	126	124.5	84	1.5	140°
8.10	3	860.1-0810-025A1-SD	10.0	25.8	89	87.5	47	1.5	140°
	5	860.1-0810-041A1-SD	10.0	42.0	103	101.5	61	1.5	140°
	8	860.1-0810-066A1-SD	10.0	66.3	152	150.5	106	1.5	140°
8.15	3	860.1-0815-025A1-SD	10.0	25.9	89	87.5	47	1.5	140°
	5	860.1-0815-042A1-SD	10.0	42.2	103	101.5	61	1.5	140°
	8	860.1-0815-066A1-SD	10.0	66.7	152	150.5	106	1.5	140°
8.20	3	860.1-0820-026A1-SD	10.0	26.1	89	87.5	47	1.5	140°
	5	860.1-0820-042A1-SD	10.0	42.5	103	101.5	61	1.5	140°
	8	860.1-0820-067A1-SD	10.0	67.1	152	150.5	106	1.5	140°
8.30	3	860.1-0830-026A1-SD	10.0	26.4	89	87.5	47	1.5	140°
	5	860.1-0830-043A1-SD	10.0	43.0	103	101.5	61	1.5	140°
	8	860.1-0830-067A1-SD	10.0	67.9	152	150.5	106	1.5	140°
8.33	3	860.1-0833-026A1-SD	10.0	26.5	89	87.5	47	1.5	140°
	5	860.1-0833-043A1-SD	10.0	43.2	103	101.5	61	1.5	140°
	8	860.1-0833-068A1-SD	10.0	68.2	152	150.5	106	1.5	140°
8.40	3	860.1-0840-026A1-SD	10.0	26.7	89	87.5	47	1.5	140°
	5	860.1-0840-043A1-SD	10.0	43.5	103	101.5	61	1.5	140°
	8	860.1-0840-068A1-SD	10.0	68.7	152	150.5	106	1.5	140°
8.45	3	860.1-0845-026A1-SD	10.0	26.9	89	87.5	47	1.5	140°
	5	860.1-0845-043A1-SD	10.0	43.8	103	101.5	61	1.5	140°
	8	860.1-0845-069A1-SD	10.0	69.1	152	150.5	106	1.5	140°
8.50	3	860.1-0850-027A1-SD	10.0	27.1	89	87.5	47	1.5	140°
	5	860.1-0850-044A1-SD	10.0	44.1	103	101.5	61	1.5	140°
	8	860.1-0850-069A1-SD	10.0	69.6	152	150.5	106	1.5	140°
8.60	3	860.1-0860-027A1-SD	10.0	27.4	89	87.4	47	1.6	140°
	5	860.1-0860-044A1-SD	10.0	44.6	103	101.4	61	1.6	140°
	8	860.1-0860-070A1-SD	10.0	70.4	152	150.4	106	1.6	140°
8.65	3	860.1-0865-027A1-SD	10.0	27.5	89	87.4	47	1.6	140°
	5	860.1-0865-044A1-SD	10.0	44.8	103	101.4	61	1.6	140°
	8	860.1-0865-070A1-SD	10.0	70.8	152	150.4	106	1.6	140°

CoroDrill® 860-SD (ニッケル基耐熱合金用)

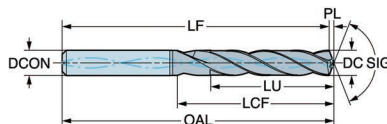
油穴つき



加工径 DC: 3.00 - 16.00mm
 加工深さ: 3 - 8 × DC
 加工公差の目安: H9
 シャンク公差: h6



材質: S2BM (超硬コーティング)

Tailor
Made

ドリル径公差DC	
ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

LU = 最大加工深さ

S

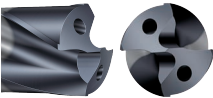
ドリル径 DC1 mm	加工深さ L/D	型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG
8.70	3	860.1-0870-027A1-SD	10.0	27.7	89	87.4	47	1.6	140°
	5	860.1-0870-045A1-SD	10.0	45.1	103	101.4	61	1.6	140°
	8	860.1-0870-071A1-SD	10.0	71.2	152	150.4	106	1.6	140°
8.73	3	860.1-0873-027A1-SD	10.0	27.8	89	87.4	47	1.6	140°
	5	860.1-0873-045A1-SD	10.0	45.2	103	101.4	61	1.6	140°
	8	860.1-0873-071A1-SD	10.0	71.4	152	150.4	106	1.6	140°
8.80	3	860.1-0880-028A1-SD	10.0	28.0	89	87.4	47	1.6	140°
	5	860.1-0880-045A1-SD	10.0	45.6	103	101.4	61	1.6	140°
	8	860.1-0880-072A1-SD	10.0	72.0	152	150.4	106	1.6	140°
8.85	3	860.1-0885-028A1-SD	10.0	28.2	89	87.4	47	1.6	140°
	5	860.1-0885-045A1-SD	10.0	45.9	103	101.4	61	1.6	140°
	8	860.1-0885-072A1-SD	10.0	72.4	152	150.4	106	1.6	140°
8.90	3	860.1-0890-028A1-SD	10.0	28.3	89	87.4	47	1.6	140°
	5	860.1-0890-046A1-SD	10.0	46.1	103	101.4	61	1.6	140°
	8	860.1-0890-072A1-SD	10.0	72.8	152	150.4	106	1.6	140°
9.00	3	860.1-0900-028A1-SD	10.0	28.6	89	87.4	47	1.6	140°
	5	860.1-0900-046A1-SD	10.0	46.6	103	101.4	61	1.6	140°
	8	860.1-0900-073A1-SD	10.0	73.6	152	150.4	106	1.6	140°
9.10	3	860.1-0910-028A1-SD	10.0	29.0	89	87.3	47	1.7	140°
	5	860.1-0910-047A1-SD	10.0	47.2	103	101.3	61	1.7	140°
	8	860.1-0910-074A1-SD	10.0	74.5	152	150.3	106	1.7	140°
9.13	3	860.1-0913-029A1-SD	10.0	29.1	89	87.3	47	1.7	140°
	5	860.1-0913-047A1-SD	10.0	47.3	103	101.3	61	1.7	140°
	8	860.1-0913-074A1-SD	10.0	74.7	152	150.3	106	1.7	140°
9.20	3	860.1-0920-029A1-SD	10.0	29.3	89	87.3	47	1.7	140°
	5	860.1-0920-047A1-SD	10.0	47.5	103	101.3	61	1.7	140°
	8	860.1-0920-075A1-SD	10.0	75.3	152	150.3	106	1.7	140°
9.30	3	860.1-0930-029A1-SD	10.0	29.6	89	87.3	47	1.7	140°
	5	860.1-0930-047A1-SD	10.0	47.4	103	101.3	61	1.7	140°
	8	860.1-0930-076A1-SD	10.0	76.1	152	150.3	106	1.7	140°
9.40	3	860.1-0940-029A1-SD	10.0	29.9	89	87.3	47	1.7	140°
	5	860.1-0940-047A1-SD	10.0	47.4	103	101.3	61	1.7	140°
	8	860.1-0940-076A1-SD	10.0	76.9	152	150.3	106	1.7	140°
9.50	3	860.1-0950-030A1-SD	10.0	30.2	89	87.3	47	1.7	140°
	4	860.1-0950-047A1-SD	10.0	47.3	103	101.3	61	1.7	140°
	8	860.1-0950-077A1-SD	10.0	77.7	152	150.3	106	1.7	140°
9.52	3	860.1-0952-030A1-SD	10.0	30.3	89	87.3	47	1.7	140°
	4	860.1-0952-047A1-SD	10.0	47.3	103	101.3	61	1.7	140°
	8	860.1-0952-077A1-SD	10.0	77.9	152	150.3	106	1.7	140°
9.53	3	860.1-0953-030A1-SD	10.0	30.3	89	87.3	47	1.7	140°
	4	860.1-0953-047A1-SD	10.0	47.3	103	101.3	61	1.7	140°
	8	860.1-0953-077A1-SD	10.0	78.0	152	150.3	106	1.7	140°
9.55	3	860.1-0955-030A1-SD	10.0	30.4	89	87.3	47	1.7	140°
	4	860.1-0955-047A1-SD	10.0	47.2	103	101.3	61	1.7	140°
	8	860.1-0955-078A1-SD	10.0	78.1	152	150.3	106	1.7	140°
9.60	3	860.1-0960-030A1-SD	10.0	30.6	89	87.3	47	1.7	140°
	4	860.1-0960-047A1-SD	10.0	47.2	103	101.3	61	1.7	140°
	8	860.1-0960-078A1-SD	10.0	78.6	152	150.3	106	1.7	140°
9.70	3	860.1-0970-030A1-SD	10.0	30.9	89	87.2	47	1.8	140°
	4	860.1-0970-047A1-SD	10.0	47.1	103	101.2	61	1.8	140°
	8	860.1-0970-079A1-SD	10.0	79.4	152	150.2	106	1.8	140°
9.75	3	860.1-0975-031A1-SD	10.0	30.8	49	87.2	47	1.8	140°
	5	860.1-0975-047A1-SD	10.0	49.0	63	101.2	61	1.8	140°
	8	860.1-0975-079A1-SD	10.0	79.3	112	150.2	106	1.8	140°
9.80	3	860.1-0980-031A1-SD	10.0	31.2	89	87.2	47	1.8	140°
	4	860.1-0980-047A1-SD	10.0	47.0	103	101.2	61	1.8	140°
	8	860.1-0980-080A1-SD	10.0	80.2	152	150.2	106	1.8	140°
9.90	3	860.1-0990-031A1-SD	10.0	31.5	89	87.2	47	1.8	140°
	4	860.1-0990-047A1-SD	10.0	47.0	103	101.2	61	1.8	140°
	8	860.1-0990-081A1-SD	10.0	81.0	152	150.2	106	1.8	140°
9.92	3	860.1-0992-031A1-SD	10.0	31.6	89	87.2	47	1.8	140°
	4	860.1-0992-047A1-SD	10.0	47.0	103	101.2	61	1.8	140°
	8	860.1-0992-081A1-SD	10.0	81.2	152	150.2	106	1.8	140°

ドリル径 DC1 mm	加工深さ L/D	型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG
10.00	3	860.1-1000-031A1-SD	10.0	31.8	89	87.2	47	1.8	140°
	4	860.1-1000-046A1-SD	10.0	46.9	103	101.2	61	1.8	140°
	8	860.1-1000-081A1-SD	10.0	81.8	152	150.2	106	1.8	140°
10.10	3	860.1-1010-032A1-SD	12.0	32.1	102	100.2	55	1.8	140°
	5	860.1-1010-052A1-SD	12.0	52.3	118	116.2	71	1.8	140°
	8	860.1-1010-082A1-SD	12.0	82.6	180	178.2	128	1.8	140°
10.20	3	860.1-1020-032A1-SD	12.0	32.5	102	100.1	55	1.9	140°
	5	860.1-1020-052A1-SD	12.0	52.9	118	116.1	71	1.9	140°
	8	860.1-1020-083A1-SD	12.0	83.5	180	178.1	128	1.9	140°
10.30	3	860.1-1030-032A1-SD	12.0	32.8	102	100.1	55	1.9	140°
	5	860.1-1030-053A1-SD	12.0	53.4	118	116.1	71	1.9	140°
	8	860.1-1030-084A1-SD	12.0	84.3	180	178.1	128	1.9	140°
10.32	3	860.1-1032-032A1-SD	12.0	32.8	102	100.1	55	1.9	140°
	5	860.1-1032-053A1-SD	12.0	53.5	118	116.1	71	1.9	140°
	8	860.1-1032-084A1-SD	12.0	84.4	180	178.1	128	1.9	140°
10.40	3	860.1-1040-033A1-SD	12.0	33.1	102	100.1	55	1.9	140°
	5	860.1-1040-053A1-SD	12.0	53.9	118	116.1	71	1.9	140°
	8	860.1-1040-085A1-SD	12.0	85.1	180	178.1	128	1.9	140°
10.45	3	860.1-1045-033A1-SD	12.0	33.3	102	100.1	55	1.9	140°
	5	860.1-1045-054A1-SD	12.0	54.2	118	116.1	71	1.9	140°
	8	860.1-1045-085A1-SD	12.0	85.5	180	178.1	128	1.9	140°
10.50	3	860.1-1050-033A1-SD	12.0	33.4	102	100.1	55	1.9	140°
	5	860.1-1050-054A1-SD	12.0	54.4	118	116.1	71	1.9	140°
	8	860.1-1050-085A1-SD	12.0	85.9	180	178.1	128	1.9	140°
10.60	3	860.1-1060-033A1-SD	12.0	33.7	102	100.1	55	1.9	140°
	5	860.1-1060-054A1-SD	12.0	54.9	118	116.1	71	1.9	140°
	8	860.1-1060-086A1-SD	12.0	86.7	180	178.1	128	1.9	140°
10.70	3	860.1-1070-034A1-SD	12.0	34.1	102	100.1	55	1.9	140°
	5	860.1-1070-055A1-SD	12.0	55.5	118	116.1	71	1.9	140°
	8	860.1-1070-087A1-SD	12.0	87.6	180	178.1	128	1.9	140°
10.72	3	860.1-1072-034A1-SD	12.0	34.1	102	100.0	55	2.0	140°
	5	860.1-1072-055A1-SD	12.0	55.5	118	116.0	71	2.0	140°
	8	860.1-1072-087A1-SD	12.0	87.7	180	178.0	128	2.0	140°
10.80	3	860.1-1080-034A1-SD	12.0	34.4	102	100.0	55	2.0	140°
	5	860.1-1080-055A1-SD	12.0	55.5	118	116.0	71	2.0	140°
	8	860.1-1080-088A1-SD	12.0	88.4	180	178.0	128	2.0	140°
10.90	3	860.1-1090-034A1-SD	12.0	34.7	102	100.0	55	2.0	140°
	5	860.1-1090-055A1-SD	12.0	55.4	118	116.0	71	2.0	140°
	8	860.1-1090-089A1-SD	12.0	89.2	180	178.0	128	2.0	140°
11.00	3	860.1-1100-035A1-SD	12.0	35.0	102	100.0	55	2.0	140°
	5	860.1-1100-055A1-SD	12.0	55.3	118	116.0	71	2.0	140°
	8	860.1-1100-090A1-SD	12.0	90.0	180	178.0	128	2.0	140°

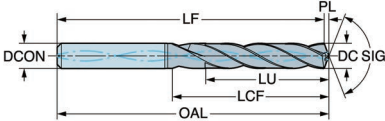
CoroDrill® 860-SD（ニッケル基耐熱合金用）

油穴つき

加工径 DC: 3.00 - 16.00mm
加工深さ: 3 - 8 × DC
加工公差の目安: H9
シャンク公差: h6



材質：S2BM(超硬コーティング)



Tailor Made

ドリル径公差DC	
ドリル径	m7
DC≤3	+0.002~+0.012
3<DC≤6	+0.004~+0.016
6<DC≤10	+0.006~+0.021
10<DC≤18	+0.007~+0.025
18<DC≤20	+0.008~+0.029

LU = 最大加工深さ



ドリル径 DC1 mm	加工深さ L/D	型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG
11.60	3	860.1-1160-036A1-SD	12.0	36.9	102	99.9	55	2.1	140°
	4	860.1-1160-054A1-SD	12.0	54.8	118	115.9	71	2.1	140°
	8	860.1-1160-094A1-SD	12.0	94.9	180	177.9	128	2.1	140°
11.70	3	860.1-1170-037A1-SD	12.0	37.2	102	99.9	55	2.1	140°
	4	860.1-1170-054A1-SD	12.0	54.8	118	115.9	71	2.1	140°
	8	860.1-1170-095A1-SD	12.0	95.7	180	177.9	128	2.1	140°
11.80	3	860.1-1180-037A1-SD	12.0	37.6	102	99.9	55	2.1	140°
	4	860.1-1180-054A1-SD	12.0	54.7	118	115.9	71	2.1	140°
	8	860.1-1180-096A1-SD	12.0	96.6	180	177.9	128	2.1	140°
11.90	3	860.1-1190-037A1-SD	12.0	37.9	102	99.8	55	2.2	140°
	4	860.1-1190-054A1-SD	12.0	54.6	118	115.8	71	2.2	140°
	8	860.1-1190-097A1-SD	12.0	97.4	180	177.8	128	2.2	140°
12.00	3	860.1-1200-038A1-SD	12.0	38.2	102	99.8	55	2.2	140°
	4	860.1-1200-054A1-SD	12.0	54.6	118	115.8	71	2.2	140°
	8	860.1-1200-098A1-SD	12.0	98.2	180	177.8	128	2.2	140°
12.10	3	860.1-1210-038A1-SD	14.0	38.5	107	104.8	60	2.2	140°
	4	860.1-1210-059A1-SD	14.0	59.7	124	121.8	77	2.2	140°
	8	860.1-1210-099A1-SD	14.0	99.0	202	199.8	151	2.2	140°
12.20	3	860.1-1220-038A1-SD	14.0	38.8	107	104.8	60	2.2	140°
	4	860.1-1220-059A1-SD	14.0	59.6	124	121.8	77	2.2	140°
	8	860.1-1220-099A1-SD	14.0	99.8	202	199.8	151	2.2	140°
12.30	3	860.1-1230-039A1-SD	14.0	39.1	107	104.8	60	2.2	140°
	4	860.1-1230-059A1-SD	14.0	59.5	124	121.8	77	2.2	140°
	8	860.1-1230-100A1-SD	14.0	100.6	202	199.8	151	2.2	140°
12.40	3	860.1-1240-039A1-SD	14.0	39.5	107	104.7	60	2.3	140°
	4	860.1-1240-059A1-SD	14.0	59.4	124	121.7	77	2.3	140°
	8	860.1-1240-101A1-SD	14.0	101.5	202	199.7	151	2.3	140°
12.50	3	860.1-1250-039A1-SD	14.0	39.8	107	104.7	60	2.3	140°
	4	860.1-1250-059A1-SD	14.0	59.4	124	121.7	77	2.3	140°
	8	860.1-1250-102A1-SD	14.0	102.3	202	199.7	151	2.3	140°
12.60	3	860.1-1260-040A1-SD	14.0	40.1	107	104.7	60	2.3	140°
	4	860.1-1260-059A1-SD	14.0	59.3	124	121.7	77	2.3	140°
	8	860.1-1260-103A1-SD	14.0	103.1	202	199.7	151	2.3	140°
12.70	3	860.1-1270-040A1-SD	14.0	40.4	107	104.7	60	2.3	140°
	4	860.1-1270-059A1-SD	14.0	59.2	124	121.7	77	2.3	140°
	8	860.1-1270-103A1-SD	14.0	103.9	202	199.7	151	2.3	140°
12.80	3	860.1-1280-040A1-SD	14.0	40.7	107	104.7	60	2.3	140°
	4	860.1-1280-059A1-SD	14.0	59.1	124	121.7	77	2.3	140°
	8	860.1-1280-104A1-SD	14.0	104.7	202	199.7	151	2.3	140°
12.90	3	860.1-1290-041A1-SD	14.0	41.1	107	104.7	60	2.3	140°
	4	860.1-1290-059A1-SD	14.0	59.0	124	121.7	77	2.3	140°
	8	860.1-1290-105A1-SD	14.0	105.6	202	199.7	151	2.3	140°
13.00	3	860.1-1300-041A1-SD	14.0	41.4	107	104.6	60	2.4	140°
	4	860.1-1300-059A1-SD	14.0	59.0	124	121.6	77	2.4	140°
	8	860.1-1300-106A1-SD	14.0	106.4	202	199.6	151	2.4	140°
13.10	3	860.1-1310-041A1-SD	14.0	41.7	107	104.6	60	2.4	140°
	4	860.1-1310-058A1-SD	14.0	58.9	124	121.6	77	2.4	140°
	8	860.1-1310-107A1-SD	14.0	107.2	202	199.6	151	2.4	140°
13.25	3	860.1-1325-041A1-SD	14.0	41.8	107	104.6	60	2.4	140°
	4	860.1-1325-058A1-SD	14.0	58.8	124	121.6	77	2.4	140°
	8	860.1-1325-108A1-SD	14.0	108.4	202	199.6	151	2.4	140°
13.30	3	860.1-1330-041A1-SD	14.0	41.7	107	104.6	60	2.4	140°
	4	860.1-1330-058A1-SD	14.0	58.7	124	121.6	77	2.4	140°
	8	860.1-1330-108A1-SD	14.0	108.8	202	199.6	151	2.4	140°
13.49	3	860.1-1349-041A1-SD	14.0	41.6	107	104.5	60	2.5	140°
	4	860.1-1349-058A1-SD	14.0	58.6	124	121.5	77	2.5	140°
	8	860.1-1349-110A1-SD	14.0	110.4	202	199.5	151	2.5	140°
13.50	3	860.1-1350-041A1-SD	14.0	41.6	107	104.5	60	2.5	140°
	4	860.1-1350-058A1-SD	14.0	58.6	124	121.5	77	2.5	140°
	8	860.1-1350-110A1-SD	14.0	110.5	202	199.5	151	2.5	140°
13.70	3	860.1-1370-041A1-SD	14.0	41.4	107	104.5	60	2.5	140°
	4	860.1-1370-058A1-SD	14.0	58.4	124	121.5	77	2.5	140°
	8	860.1-1370-112A1-SD	14.0	112.1	202	199.5	151	2.5	140°

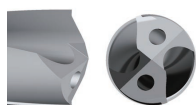
ドリル径		型番	寸法, mm						
DC1 mm	加工深さ L/D		内部給油	DCON	LU	OAL	LF	LCF	PL
13.75	3	860.1-1375-041A1-SD	14.0	41.4	107	104.5	60	2.5	140°
	4	860.1-1375-058A1-SD	14.0	58.4	124	121.5	77	2.5	140°
	8	860.1-1375-112A1-SD	14.0	112.5	202	199.5	151	2.5	140°
13.80	3	860.1-1380-041A1-SD	14.0	41.4	107	104.5	60	2.5	140°
	4	860.1-1380-058A1-SD	14.0	58.4	124	121.5	77	2.5	140°
	8	860.1-1380-112A1-SD	14.0	112.9	202	199.5	151	2.5	140°
13.89	3	860.1-1389-041A1-SD	14.0	41.3	107	104.5	60	2.5	140°
	4	860.1-1389-058A1-SD	14.0	58.3	124	121.5	77	2.5	140°
	8	860.1-1389-113A1-SD	14.0	113.7	202	199.5	151	2.5	140°
14.00	3	860.1-1400-041A1-SD	14.0	41.2	107	104.5	60	2.5	140°
	4	860.1-1400-058A1-SD	14.0	58.2	124	121.5	77	2.5	140°
	8	860.1-1400-114A1-SD	14.0	114.6	202	199.5	151	2.5	140°
14.10	3	860.1-1410-044A1-SD	16.0	45.5	115	112.4	65	2.6	140°
	4	860.1-1410-063A1-SD	16.0	63.5	133	130.4	83	2.6	140°
	8	860.1-1410-115A1-SD	16.0	115.4	227	224.4	172	2.6	140°
14.20	3	860.1-1420-045A1-SD	16.0	45.5	115	112.4	65	2.6	140°
	4	860.1-1420-066A1-SD	16.0	66.5	133	130.4	86	2.6	140°
	8	860.1-1420-116A1-SD	16.0	116.2	227	224.4	172	2.6	140°
14.25	3	860.1-1425-045A1-SD	16.0	45.4	115	112.4	65	2.6	140°
	4	860.1-1425-063A1-SD	16.0	63.4	133	130.4	83	2.6	140°
	8	860.1-1425-116A1-SD	16.0	116.6	227	224.4	172	2.6	140°
14.29	3	860.1-1429-045A1-SD	16.0	45.4	115	112.4	65	2.6	140°
	4	860.1-1429-063A1-SD	16.0	63.4	133	130.4	83	2.6	140°
	8	860.1-1429-116A1-SD	16.0	116.9	227	224.4	172	2.6	140°
14.50	3	860.1-1450-045A1-SD	16.0	45.2	115	112.4	65	2.6	140°
	4	860.1-1450-063A1-SD	16.0	63.2	133	130.4	83	2.6	140°
	8	860.1-1450-118A1-SD	16.0	118.6	227	224.4	172	2.6	140°
14.69	3	860.1-1469-045A1-SD	16.0	45.0	115	112.3	65	2.7	140°
	4	860.1-1469-063A1-SD	16.0	63.0	133	130.3	83	2.7	140°
	8	860.1-1469-120A1-SD	16.0	120.2	227	224.3	172	2.7	140°
14.75	3	860.1-1475-045A1-SD	16.0	45.0	115	112.3	65	2.7	140°
	4	860.1-1475-063A1-SD	16.0	63.0	133	130.3	83	2.7	140°
	8	860.1-1475-120A1-SD	16.0	120.7	227	224.3	172	2.7	140°
14.80	3	860.1-1480-045A1-SD	16.0	45.0	115	112.3	65	2.7	140°
	4	860.1-1480-063A1-SD	16.0	63.0	133	130.3	83	2.7	140°
	8	860.1-1480-121A1-SD	16.0	121.1	227	224.3	172	2.7	140°
15.00	3	860.1-1500-044A1-SD	16.0	44.8	115	112.3	65	2.7	140°
	4	860.1-1500-062A1-SD	16.0	62.8	133	130.3	83	2.7	140°
	8	860.1-1500-122A1-SD	16.0	122.7	227	224.3	172	2.7	140°
15.10	3	860.1-1510-044A1-SD	16.0	44.7	115	112.3	65	2.7	140°
	4	860.1-1510-062A1-SD	16.0	62.7	133	130.3	83	2.7	140°
	8	860.1-1510-123A1-SD	16.0	123.6	227	224.3	172	2.7	140°
15.20	3	860.1-1520-044A1-SD	16.0	44.6	115	112.2	65	2.8	140°
	4	860.1-1520-062A1-SD	16.0	62.6	133	130.2	83	2.8	140°
	8	860.1-1520-124A1-SD	16.0	124.4	227	224.2	172	2.8	140°
15.30	3	860.1-1530-044A1-SD	16.0	44.6	115	112.2	65	2.8	140°
	4	860.1-1530-062A1-SD	16.0	62.6	133	130.2	83	2.8	140°
	8	860.1-1530-125A1-SD	16.0	125.2	227	224.2	172	2.8	140°
15.50	3	860.1-1550-044A1-SD	16.0	44.4	115	112.2	65	2.8	140°
	4	860.1-1550-062A1-SD	16.0	62.4	133	130.2	83	2.8	140°
	8	860.1-1550-126A1-SD	16.0	126.8	227	224.2	172	2.8	140°
15.80	3	860.1-1580-044A1-SD	16.0	44.2	115	112.1	65	2.9	140°
	3	860.1-1580-062A1-SD	16.0	62.2	133	130.1	83	2.9	140°
	8	860.1-1580-129A1-SD	16.0	129.3	227	224.1	172	2.9	140°
15.87	3	860.1-1587-044A1-SD	16.0	44.1	115	112.1	65	2.9	140°
	3	860.1-1587-062A1-SD	16.0	62.1	133	130.1	83	2.9	140°
	8	860.1-1587-129A1-SD	16.0	129.9	227	224.1	172	2.9	140°
16.00	3	860.1-1600-044A1-SD	16.0	44.0	115	112.1	65	2.9	140°
	3	860.1-1600-062A1-SD	16.0	62.0	133	130.1	83	2.9	140°
	8	860.1-1600-130A1-SD	16.0	130.9	227	224.1	172	2.9	140°

CoroDrill® 860-NM (アルミ合金用)

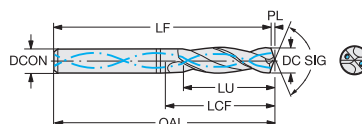
円筒シャンク



加工径 DC: 3.00 - 20.00 mm
 加工深さ: 3 - 8 × DC
 加工公差の目安: H8 - H9
 シャンク公差: h6



材種: H10F(超硬ノンコート)



Tailor Made

ドリル径公差DC

ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

LU = 最大加工深さ

N

ドリル径 DC1 mm	加工深さ L/D	型番 内部給油	寸法, mm						
			DCON	LU	OAL	LF	LCF	PL	SIG
3.00	3	860.1-0300-009A1-NM	6.0	9.4	62	61.6	20	0.4	130°
	8	860.1-0300-024A1-NM	6.0	24.4	77	76.6	36	0.4	130°
3.18	3	860.1-0318-010A1-NM	6.0	10.0	62	61.6	20	0.4	130°
	8	860.1-0318-025A1-NM	6.0	25.8	77	76.6	36	0.4	130°
3.20	3	860.1-0320-010A1-NM	6.0	10.0	62	61.6	20	0.4	130°
	8	860.1-0320-026A1-NM	6.0	26.0	77	76.6	36	0.4	130°
3.30	3	860.1-0330-013A1-NM	6.0	10.3	62	61.6	20	0.4	130°
	8	860.1-0330-026A1-NM	6.0	26.8	77	76.6	36	0.4	130°
3.50	8	860.1-0350-028A1-NM	6.0	28.3	77	76.5	36	0.5	130°
	8	860.1-0357-029A1-NM	6.0	28.1	77	76.5	36	0.5	130°
3.70	8	860.1-0370-030A1-NM	6.0	27.9	77	76.5	36	0.5	130°
	8	860.1-0400-012A1-NM	6.0	12.5	66	65.5	24	0.5	130°
4.00	3	860.1-0400-032A1-NM	6.0	32.5	86	85.5	47	0.5	130°
	8	860.1-0410-033A1-NM	6.0	33.3	86	85.5	47	0.5	130°
4.10	8	860.1-0410-033A1-NM	6.0	33.3	86	85.5	47	0.5	130°
	8	860.1-0420-013A1-NM	6.0	13.2	66	65.4	24	0.6	130°
4.20	8	860.1-0420-034A1-NM	6.0	34.2	86	85.4	47	0.6	130°
	8	860.1-0437-013A1-NM	6.0	13.7	66	65.4	24	0.6	130°
4.37	3	860.1-0437-035A1-NM	6.0	35.5	86	85.4	47	0.6	130°
	8	860.1-0450-014A1-NM	6.0	14.1	66	65.4	24	0.6	130°
4.50	3	860.1-0450-036A1-NM	6.0	36.6	86	85.4	47	0.6	130°
	8	860.1-0460-014A1-NM	6.0	14.4	66	65.4	24	0.6	130°
4.60	8	860.1-0460-037A1-NM	6.0	37.4	86	85.4	47	0.6	130°
	8	860.1-0476-038A1-NM	6.0	38.7	99	98.4	60	0.6	130°
4.76	8	860.1-0476-038A1-NM	6.0	38.7	99	98.4	60	0.6	130°
	8	860.1-0500-015A1-NM	6.0	15.7	66	65.3	28	0.7	130°
5.00	3	860.1-0500-040A1-NM	6.0	40.7	99	98.3	60	0.7	130°
	8	860.1-0510-015A1-NM	6.0	16.0	66	65.3	28	0.7	130°
5.10	8	860.1-0510-041A1-NM	6.0	41.5	99	98.3	60	0.7	130°
	8	860.1-0516-041A1-NM	6.0	42.0	99	98.3	60	0.7	130°
5.16	8	860.1-0516-041A1-NM	6.0	42.0	99	98.3	60	0.7	130°
	8	860.1-0520-016A1-NM	6.0	16.3	66	65.3	28	0.7	130°
5.20	8	860.1-0520-042A1-NM	6.0	42.3	99	98.3	60	0.7	130°
	8	860.1-0550-017A1-NM	6.0	17.2	66	65.3	28	0.7	130°
5.50	3	860.1-0550-044A1-NM	6.0	44.7	99	98.3	60	0.7	130°
	8	860.1-0556-017A1-NM	6.0	17.4	66	65.3	28	0.7	130°
5.56	8	860.1-0556-044A1-NM	6.0	45.2	99	98.3	60	0.7	130°
	8	860.1-0580-017A1-NM	6.0	17.6	66	65.2	28	0.8	130°
5.80	3	860.1-0580-046A1-NM	6.0	47.2	99	98.2	60	0.8	130°
	8	860.1-0600-018A1-NM	6.0	18.8	66	65.2	28	0.8	130°
6.00	8	860.1-0600-048A1-NM	6.0	48.8	99	98.2	60	0.8	130°
	8	860.1-0630-019A1-NM	8.0	19.7	79	78.2	34	0.8	130°
6.30	3	860.1-0630-050A1-NM	8.0	51.2	121	120.2	80	0.8	130°
	8	860.1-0635-019A1-NM	8.0	19.9	79	78.1	34	0.9	130°
6.35	8	860.1-0635-051A1-NM	8.0	51.7	121	120.1	80	0.9	130°
	8	860.1-0650-020A1-NM	8.0	20.4	79	78.1	34	0.9	130°
6.50	3	860.1-0650-052A1-NM	8.0	52.9	121	120.1	80	0.9	130°
	8	860.1-0660-020A1-NM	8.0	20.7	79	78.1	34	0.9	130°
6.60	8	860.1-0660-053A1-NM	8.0	53.7	121	120.1	80	0.9	130°
	8	860.1-0675-020A1-NM	8.0	21.1	79	78.1	34	0.9	130°
6.75	3	860.1-0675-054A1-NM	8.0	54.9	121	120.1	80	0.9	130°
	8	860.1-0680-020A1-NM	8.0	21.3	79	78.1	34	0.9	130°
6.80	8	860.1-0680-054A1-NM	8.0	55.3	121	120.1	80	0.9	130°
	8	860.1-0700-021A1-NM	8.0	21.9	79	78.1	34	0.9	130°
7.00	3	860.1-0700-056A1-NM	8.0	56.9	121	120.1	80	0.9	130°
	8	860.1-0714-021A1-NM	8.0	22.4	79	78.0	41	1.0	130°
7.14	8	860.1-0714-021A1-NM	8.0	22.4	79	78.0	41	1.0	130°
	8	860.1-0714-057A1-NM	8.0	58.1	121	120.0	80	1.0	130°
7.30	3	860.1-0730-022A1-NM	8.0	22.9	79	78.0	41	1.0	130°
	8	860.1-0730-058A1-NM	8.0	59.4	121	120.0	80	1.0	130°
7.40	3	860.1-0740-022A1-NM	8.0	23.2	79	78.0	41	1.0	130°
	8	860.1-0740-059A1-NM	8.0	60.2	121	120.0	80	1.0	130°

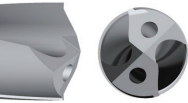
ドリル径		型番 内部給油	寸法, mm						
DC1 mm	加工深さ L/D		DCON	LU	OAL	LF	LCF	PL	SIG
7.50	3	860.1-0750-023A1-NM	8.0	23.5	79	78.0	41	1.0	130°
	8	860.1-0750-060A1-NM	8.0	61.0	121	120.0	80	1.0	130°
7.94	3	860.1-0794-024A1-NM	8.0	24.9	79	77.9	41	1.1	130°
	8	860.1-0794-064A1-NM	8.0	64.6	121	119.9	80	1.1	130°
8.00	3	860.1-0800-024A1-NM	8.0	25.1	79	77.9	41	1.1	130°
	8	860.1-0800-064A1-NM	8.0	65.1	121	119.9	80	1.1	130°
8.33	3	860.1-0833-025A1-NM	10.0	26.1	89	87.9	47	1.1	130°
	8	860.1-0833-067A1-NM	10.0	67.8	145	143.9	100	1.1	130°
8.50	3	860.1-0850-026A1-NM	10.0	26.6	89	87.9	47	1.1	130°
	8	860.1-0850-068A1-NM	10.0	69.1	145	143.9	100	1.1	130°
8.60	3	860.1-0860-026A1-NM	10.0	27.0	89	87.8	47	1.2	130°
	8	860.1-0860-069A1-NM	10.0	70.0	145	143.8	100	1.2	130°
8.70	8	860.1-0870-070A1-NM	10.0	70.8	145	143.8	100	1.2	130°
8.80	3	860.1-0880-026A1-NM	10.0	27.6	89	87.8	47	1.2	130°
	8	860.1-0880-070A1-NM	10.0	71.6	145	143.8	100	1.2	130°
9.00	3	860.1-0900-027A1-NM	10.0	28.2	89	87.8	47	1.2	130°
	8	860.1-0900-072A1-NM	10.0	73.2	145	143.8	100	1.2	130°
9.13	8	860.1-0913-073A1-NM	10.0	74.2	145	143.8	100	1.2	130°
9.30	3	860.1-0930-028A1-NM	10.0	29.1	89	87.8	47	1.2	130°
	8	860.1-0930-074A1-NM	10.0	75.6	145	143.8	100	1.2	130°
9.50	3	860.1-0950-029A1-NM	10.0	29.8	89	87.7	47	1.3	130°
	8	860.1-0950-076A1-NM	10.0	77.3	145	143.7	100	1.3	130°
9.53	3	860.1-0953-029A1-NM	10.0	29.9	89	87.7	47	1.3	130°
	8	860.1-0953-076A1-NM	10.0	77.5	145	143.7	100	1.3	130°
9.92	8	860.1-0992-079A1-NM	10.0	80.7	145	143.7	100	1.3	130°
10.00	3	860.1-1000-030A1-NM	10.0	31.3	89	87.7	47	1.3	130°
	8	860.1-1000-080A1-NM	10.0	81.3	145	143.7	100	1.3	130°
10.20	3	860.1-1020-031A1-NM	12.0	32.0	102	100.6	55	1.4	130°
	8	860.1-1020-082A1-NM	12.0	83.0	171	169.6	120	1.4	130°
10.30	3	860.1-1030-031A1-NM	12.0	32.3	102	100.6	55	1.4	130°
	8	860.1-1030-082A1-NM	12.0	83.8	171	169.6	120	1.4	130°
10.50	3	860.1-1050-032A1-NM	12.0	32.9	102	100.6	55	1.4	130°
	8	860.1-1050-084A1-NM	12.0	85.4	171	169.6	120	1.4	130°
10.72	3	860.1-1072-032A1-NM	12.0	33.6	102	100.6	55	1.4	130°
	8	860.1-1072-086A1-NM	12.0	87.2	171	169.6	120	1.4	130°
10.80	8	860.1-1080-086A1-NM	12.0	87.8	171	169.6	120	1.4	130°
11.00	3	860.1-1100-033A1-NM	12.0	34.5	102	100.5	55	1.5	130°
	8	860.1-1100-088A1-NM	12.0	89.5	171	169.5	120	1.5	130°
11.10	3	860.1-1110-033A1-NM	12.0	34.8	102	100.5	55	1.5	130°
	8	860.1-1110-089A1-NM	12.0	90.3	171	169.5	120	1.5	130°
11.11	3	860.1-1111-033A1-NM	12.0	34.8	102	100.5	55	1.5	130°
	8	860.1-1111-089A1-NM	12.0	90.4	171	169.5	120	1.5	130°
11.20	3	860.1-1120-034A1-NM	12.0	35.1	102	100.5	55	1.5	130°
	8	860.1-1120-090A1-NM	12.0	91.1	171	169.5	120	1.5	130°
11.50	8	860.1-1150-092A1-NM	12.0	93.5	171	169.5	120	1.5	130°
11.80	3	860.1-1180-035A1-NM	12.0	37.0	102	100.4	55	1.6	130°
	8	860.1-1180-094A1-NM	12.0	96.0	171	169.4	120	1.6	130°
12.00	3	860.1-1200-036A1-NM	12.0	37.6	102	100.4	55	1.6	130°
	8	860.1-1200-096A1-NM	12.0	97.6	171	169.4	120	1.6	130°
12.10	3	860.1-1210-036A1-NM	14.0	37.9	107	105.4	60	1.6	130°
12.30	3	860.1-1230-037A1-NM	14.0	38.6	107	105.4	60	1.6	130°
	8	860.1-1230-098A1-NM	14.0	100.1	190	188.4	140	1.6	130°
12.50	3	860.1-1250-038A1-NM	14.0	39.2	107	105.3	60	1.7	130°
	8	860.1-1250-100A1-NM	14.0	101.7	190	188.3	140	1.7	130°
12.70	3	860.1-1270-038A1-NM	14.0	39.8	107	105.3	60	1.7	130°
	8	860.1-1270-102A1-NM	14.0	103.3	190	188.3	140	1.7	130°
13.00	3	860.1-1300-039A1-NM	14.0	40.7	107	105.3	60	1.7	130°
	8	860.1-1300-104A1-NM	14.0	105.7	190	188.3	140	1.7	130°

CoroDrill® 860-NM（アルミ合金用）

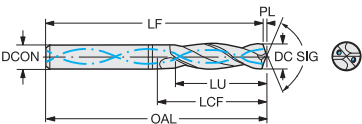
円筒シャンク



加工径 DC: 3.00 - 20.00 mm
加工深さ: 3 - 8 × DC
加工公差の目安: H8 - H9
シャンク公差: h6



材種 : H10F (超硬ノンコート)



Tailor
Made

ドリル径公差DC	
ドリル径	m7
DC≤3	+0.002~+0.012
3<DC≤6	+0.004~+0.016
6<DC≤10	+0.006~+0.021
10<DC≤18	+0.007~+0.025
18<DC≤20	+0.008~+0.029

LU= 最大加工深さ **N**

ドリル径		型番	寸法, mm							
DC1 mm	加工深さ L/D		内部給油							
			DCON	LU	OAL	LF	LCF	PL	SIG	
13.10	3	860.1-1310-039A1-NM	14.0	41.0	107	105.2	60	1.8	130°	
	8	860.1-1310-105A1-NM	14.0	106.5	190	188.2	140	1.8	130°	
13.50	3	860.1-1350-041A1-NM	14.0	42.3	107	105.2	60	1.8	130°	
	8	860.1-1350-108A1-NM	14.0	109.8	190	188.2	140	1.8	130°	
13.89	3	860.1-1389-042A1-NM	14.0	43.3	107	105.1	60	1.9	130°	
14.00	3	860.1-1400-042A1-NM	14.0	43.9	107	105.1	60	1.9	130°	
	8	860.1-1400-112A1-NM	14.0	113.9	190	188.1	140	1.9	130°	
14.20	3	860.1-1420-043A1-NM	16.0	44.5	115	113.1	65	1.9	130°	
14.29	3	860.1-1429-043A1-NM	16.0	44.8	115	113.1	65	1.9	130°	
14.50	3	860.1-1450-044A1-NM	16.0	45.4	115	113.1	65	1.9	130°	
	8	860.1-1450-116A1-NM	16.0	117.9	213	211.1	160	1.9	130°	
14.68	8	860.1-1468-117A1-NM	16.0	119.4	213	211.0	160	2.0	130°	
14.75	3	860.1-1475-044A1-NM	16.0	46.2	115	113.0	65	2.0	130°	
15.00	3	860.1-1500-045A1-NM	16.0	47.0	115	113.0	65	2.0	130°	
	8	860.1-1500-120A1-NM	16.0	122.0	213	211.0	160	2.0	130°	
15.50	3	860.1-1550-047A1-NM	16.0	48.6	115	112.9	65	2.1	130°	
	8	860.1-1550-124A1-NM	16.0	126.1	213	210.9	160	2.1	130°	
15.88	8	860.1-1588-127A1-NM	16.0	129.1	213	210.9	160	2.1	130°	
16.00	3	860.1-1600-048A1-NM	16.0	49.0	115	112.9	65	2.1	130°	
	8	860.1-1600-128A1-NM	16.0	130.1	213	210.9	160	2.1	130°	
17.00	3	860.1-1700-051A1-NM	18.0	53.3	123	120.7	73	2.3	130°	
	8	860.1-1700-136A1-NM	18.0	138.3	234	231.7	180	2.3	130°	
17.50	3	860.1-1750-053A1-NM	18.0	54.8	123	120.7	73	2.3	130°	
18.00	3	860.1-1800-054A1-NM	18.0	56.4	123	120.6	73	2.4	130°	
19.00	3	860.1-1900-057A1-NM	20.0	59.5	131	128.5	79	2.5	130°	
	8	860.1-1900-152A1-NM	20.0	154.5	257	254.5	200	2.5	130°	
20.00	3	860.1-2000-060A1-NM	20.0	62.7	131	128.3	79	2.7	130°	

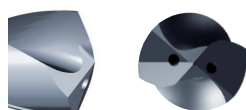
注文例 : 860.1-0300-009A1-NM H10F 10 本

CoroDrill® 860-SM (チタン合金用)

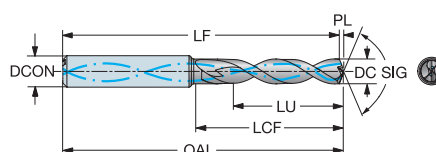
油穴つき



ドリル径 DC: 3.00 - 16.00mm
 加工深さ: 2 - 5 × DC
 加工公差の目安: H9
 シャンク公差: h6



材質: GC1210(超硬コーティング)



Tailor Made

ドリル径公差DC	
ドリル径	m7
DC ≤ 3	+0.002 ~ +0.012
3 < DC ≤ 6	+0.004 ~ +0.016
6 < DC ≤ 10	+0.006 ~ +0.021
10 < DC ≤ 18	+0.007 ~ +0.025
18 < DC ≤ 20	+0.008 ~ +0.029

LU = 最大加工深さ

S

ドリル径		型番 内部給油	寸法, mm							
DC1 mm	加工深さ L/D		DCON	LU	OAL	LF	LCF	PL	SIG	
3.00	3	860.1-0300-009A1-SM	6.0	9.5	62	61.5	20	0.6	140°	
	5	860.1-0300-015A1-SM	6.0	15.5	66	65.5	28	0.6	140°	
3.10	3	860.1-0310-009A1-SM	6.0	9.9	62	61.5	20	0.6	140°	
3.17	5	860.1-0317-016A1-SM	6.0	16.4	66	65.5	28	0.6	140°	
3.18	3	860.1-0318-010A1-SM	6.0	10.1	62	61.5	20	0.6	140°	
3.20	3	860.1-0320-010A1-SM	6.0	10.2	62	61.5	20	0.6	140°	
	5	860.1-0320-016A1-SM	6.0	16.6	66	65.5	28	0.6	140°	
3.30	3	860.1-0330-010A1-SM	6.0	10.5	62	61.5	20	0.6	140°	
	5	860.1-0330-017A1-SM	6.0	17.1	66	65.5	28	0.6	140°	
3.40	3	860.1-0340-010A1-SM	6.0	10.8	62	61.4	20	0.6	140°	
3.50	3	860.1-0350-011A1-SM	6.0	11.1	62	61.4	20	0.6	140°	
	5	860.1-0350-018A1-SM	6.0	18.1	66	65.4	28	0.6	140°	
3.57	3	860.1-0357-011A1-SM	6.0	11.4	62	61.4	20	0.7	140°	
3.60	3	860.1-0360-011A1-SM	6.0	11.5	62	61.4	20	0.7	140°	
3.70	3	860.1-0370-011A1-SM	6.0	11.8	62	61.4	20	0.7	140°	
	5	860.1-0370-019A1-SM	6.0	19.2	66	65.4	28	0.7	140°	
3.80	3	860.1-0380-011A1-SM	6.0	11.7	66	65.4	20	0.7	140°	
3.90	3	860.1-0390-011A1-SM	6.0	11.6	66	65.4	20	0.7	140°	
	5	860.1-0390-019A1-SM	6.0	19.6	74	73.4	28	0.7	140°	
4.00	3	860.1-0400-012A1-SM	6.0	12.7	66	65.3	24	0.7	140°	
	5	860.1-0400-020A1-SM	6.0	20.7	74	73.3	36	0.7	140°	
4.10	3	860.1-0410-013A1-SM	6.0	13.0	66	65.3	24	0.8	140°	
4.15	5	860.1-0415-021A1-SM	6.0	21.5	74	73.3	36	0.8	140°	
4.20	3	860.1-0420-013A1-SM	6.0	13.4	66	65.3	24	0.8	140°	
	5	860.1-0420-021A1-SM	6.0	21.8	74	73.3	36	0.8	140°	
4.30	3	860.1-0430-013A1-SM	6.0	13.7	66	65.3	24	0.8	140°	
4.37	3	860.1-0437-013A1-SM	6.0	13.9	66	65.3	24	0.8	140°	
4.40	5	860.1-0440-022A1-SM	6.0	22.8	74	73.3	36	0.8	140°	
4.50	3	860.1-0450-014A1-SM	6.0	14.3	66	65.3	24	0.8	140°	
	5	860.1-0450-023A1-SM	6.0	23.3	74	73.3	36	0.8	140°	
4.60	3	860.1-0460-014A1-SM	6.0	14.6	66	65.2	24	0.8	140°	
	5	860.1-0460-023A1-SM	6.0	23.8	74	73.2	36	0.8	140°	
4.70	3	860.1-0470-014A1-SM	6.0	15.0	66	65.2	24	0.9	140°	
	5	860.1-0470-024A1-SM	6.0	24.4	74	73.2	36	0.9	140°	
4.76	3	860.1-0476-013A1-SM	6.0	13.6	66	65.2	24	0.9	140°	
	5	860.1-0476-024A1-SM	6.0	24.7	82	81.2	36	0.9	140°	
4.80	3	860.1-0480-015A1-SM	6.0	15.3	66	65.2	28	0.9	140°	
	5	860.1-0480-024A1-SM	6.0	24.9	82	81.2	36	0.9	140°	
4.90	3	860.1-0490-015A1-SM	6.0	15.6	66	65.2	28	0.9	140°	
	5	860.1-0490-025A1-SM	6.0	25.4	82	81.2	44	0.9	140°	
5.00	3	860.1-0500-015A1-SM	6.0	15.9	66	65.2	28	0.9	140°	
	5	860.1-0500-025A1-SM	6.0	25.9	82	81.2	44	0.9	140°	
5.10	3	860.1-0510-016A1-SM	6.0	16.2	66	65.2	28	0.9	140°	
	5	860.1-0510-026A1-SM	6.0	26.4	82	81.2	44	0.9	140°	
5.16	3	860.1-0516-016A1-SM	6.0	16.4	66	65.1	28	0.9	140°	
5.20	3	860.1-0520-016A1-SM	6.0	16.5	66	65.1	28	1.0	140°	
5.25	3	860.1-0525-016A1-SM	6.0	16.7	66	65.1	28	1.0	140°	
5.30	3	860.1-0530-016A1-SM	6.0	16.9	66	65.1	28	1.0	140°	
	5	860.1-0530-027A1-SM	6.0	27.5	82	81.1	44	1.0	140°	
5.40	3	860.1-0540-017A1-SM	6.0	17.2	66	65.1	28	1.0	140°	
5.50	3	860.1-0550-017A1-SM	6.0	17.5	66	65.1	28	1.0	140°	
	5	860.1-0550-028A1-SM	6.0	28.5	82	81.1	44	1.0	140°	
5.55	3	860.1-0555-017A1-SM	6.0	17.6	66	65.1	28	1.0	140°	
5.56	3	860.1-0556-017A1-SM	6.0	17.6	66	65.1	28	1.0	140°	
	5	860.1-0556-028A1-SM	6.0	28.8	82	81.1	44	1.0	140°	
5.60	3	860.1-0560-017A1-SM	6.0	17.6	66	65.1	28	1.0	140°	
	5	860.1-0560-029A1-SM	6.0	29.0	82	81.1	44	1.0	140°	
5.70	3	860.1-0570-017A1-SM	6.0	17.6	66	65.1	28	1.0	140°	
	5	860.1-0570-029A1-SM	6.0	29.5	82	81.1	44	1.0	140°	

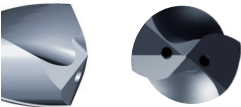
ドリル径		型番 内部給油	寸法, mm							
DC1 mm	加工深さ L/D		DCON	LU	OAL	LF	LCF	PL	SIG	
5.80	3	860.1-0580-017A1-SM	6.0	17.7	66	65.0	28	1.1	140°	
	5	860.1-0580-030A1-SM	6.0	30.1	82	81.0	44	1.1	140°	
5.95	3	860.1-0595-017A1-SM	6.0	17.7	66	65.0	28	1.1	140°	
6.00	3	860.1-0600-019A1-SM	6.0	19.1	66	65.0	34	1.1	140°	
	5	860.1-0600-031A1-SM	6.0	31.1	82	81.0	44	1.1	140°	
6.10	3	860.1-0610-019A1-SM	8.0	19.4	79	78.0	34	1.1	140°	
	5	860.1-0610-031A1-SM	8.0	31.6	91	90.0	53	1.1	140°	
6.20	3	860.1-0620-019A1-SM	8.0	19.7	79	78.0	34	1.1	140°	
	5	860.1-0620-032A1-SM	8.0	32.1	91	90.0	53	1.1	140°	
6.35	3	860.1-0635-020A1-SM	8.0	20.2	79	77.9	34	1.2	140°	
	5	860.1-0635-032A1-SM	8.0	32.9	91	89.9	53	1.2	140°	
6.40	3	860.1-0640-020A1-SM	8.0	20.4	79	77.9	34	1.2	140°	
	5	860.1-0640-033A1-SM	8.0	33.2	91	89.9	53	1.2	140°	
6.50	3	860.1-0650-020A1-SM	8.0	20.7	79	77.9	34	1.2	140°	
	5	860.1-0650-033A1-SM	8.0	33.7	91	89.9	53	1.2	140°	
6.60	3	860.1-0660-021A1-SM	8.0	21.0	79	77.9	34	1.2	140°	
	5	860.1-0660-034A1-SM	8.0	34.2	91	89.9	53	1.2	140°	
6.70	3	860.1-0670-021A1-SM	8.0	21.3	79	77.9	34	1.2	140°	
	5	860.1-0670-034A1-SM	8.0	34.7	91	89.9	53	1.2	140°	
6.80	3	860.1-0680-021A1-SM	8.0	21.6	79	77.9	34	1.2	140°	
	5	860.1-0680-035A1-SM	8.0	35.2	91	89.9	53	1.2	140°	
6.90	3	860.1-0690-021A1-SM	8.0	21.6	79	77.8	34	1.3	140°	
	5	860.1-0690-035A1-SM	8.0	35.8	91	89.8	53	1.3	140°	
7.00	3	860.1-0700-021A1-SM	8.0	21.6	79	77.8	34	1.3	140°	
	5	860.1-0700-036A1-SM	8.0	36.3	91	89.8	53	1.3	140°	
7.10	3	860.1-0710-022A1-SM	8.0	22.6	79	77.8	41	1.3	140°	
	5	860.1-0710-036A1-SM	8.0	36.8	91	89.8	53	1.3	140°	
7.14	3	860.1-0714-022A1-SM	8.0	22.7	79	77.8	41	1.3	140°	
	5	860.1-0714-036A1-SM	8.0	37.0	91	89.8	53	1.3	140°	
7.20	3	860.1-0720-022A1-SM	8.0	22.9	79	77.8	41	1.3	140°	
	5	860.1-0720-037A1-SM	8.0	37.3	91	89.8	53	1.3	140°	
7.30	3	860.1-0730-023A1-SM	8.0	23.2	79	77.8	41	1.3	140°	
	5	860.1-0730-037A1-SM	8.0	37.8	91	89.8	53	1.3	140°	
7.40	3	860.1-0740-023A1-SM	8.0	23.5	79	77.8	41	1.4	140°	
	5	860.1-0740-038A1-SM	8.0	38.3	91	89.8	53	1.4	140°	
7.50	3	860.1-0750-023A1-SM	8.0	23.9	79	77.7	41	1.4	140°	
	5	860.1-0750-038A1-SM	8.0	38.9	91	89.7	53	1.4	140°	
7.60	3	860.1-0760-024A1-SM	8.0	24.0	79	77.6	41	1.4	140°	
7.70	3	860.1-0770-024A1-SM	8.0	24.5	79	77.7	41	1.4	140°	
7.80	3	860.1-0780-024A1-SM	8.0	24.8	79	77.7	41	1.4	140°	
7.94	3	860.1-0794-025A1-SM	8.0	25.3	79	77.7	41	1.4	140°	
8.00	3	860.1-0800-025A1-SM	8.0	25.5	79	77.7	41	1.5	140°	
	5	860.1-0800-040A1-SM	8.0	40.9	91	89.7	53	1.5	140°	
8.10	3	860.1-0810-025A1-SM	10.0	25.8	89	87.6	47	1.5	140°	
	5	860.1-0810-041A1-SM	10.0	42.0	103	101.6	61	1.5	140°	
8.20	3	860.1-0820-026A1-SM	10.0	26.1	89	87.6	47	1.5	140°	
8.30	3	860.1-0830-026A1-SM	10.0	26.4	89	87.6	47	1.5	140°	
8.33	3	860.1-0833-026A1-SM	10.0	26.5	89	87.6	47	1.5	140°	
8.40	3	860.1-0840-026A1-SM	10.0	26.7	89	87.6	47	1.5	140°	
	5	860.1-0840-043A1-SM	10.0	43.5	103	101.6	61	1.5	140°	
8.45	3	860.1-0845-026A1-SM	10.0	26.9	89	87.6	47	1.5	140°	
8.50	3	860.1-0850-027A1-SM	10.0	27.0	89	87.6	47	1.6	140°	
	5	860.1-0850-044A1-SM	10.0	44.0	103	101.6	61	1.6	140°	
8.60	3	860.1-0860-027A1-SM	10.0	27.4	89	87.6	47	1.6	140°	
	5	860.1-0860-044A1-SM	10.0	44.6	103	101.6	61	1.6	140°	
8.65	3	860.1-0865-027A1-SM	10.0	27.5	89	87.6	47	1.6	140°	
8.70	3	860.1-0870-027A1-SM	10.0	27.7	89	87.5	47	1.6	140°	
8.73	3	860.1-0873-027A1-SM	10.0	27.8	89	87.5	47	1.6	140°	
	5	860.1-0873-045A1-SM	10.0	45.2	103	101.5	61	1.6	140°	

CoroDrill® 860-SM (チタン合金用)

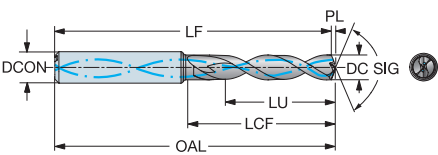
油穴つき



ドリル径 DC: 3.00 - 16.00mm
加工深さ: 2 - 5 × DC
加工公差の目安: H9
シャンク公差: h6



材種 : GC1210(超硬コーティング)



Tailor Made

ドリル径公差DC	
ドリル径	m7
DC≤3	+0.002~+0.012
3<DC≤6	+0.004~+0.016
6<DC≤10	+0.006~+0.021
10<DC≤18	+0.007~+0.025
18<DC≤20	+0.008~+0.029

LU= 最大加工深さ **S**

ドリル径		型番	寸法, mm							
DC1 mm	加工深さ L/D		内部給油	DCON	LU	OAL	LF	LCF	PL	SIG
8.80	3	860.1-0880-028A1-SM		10.0	28.0	89	87.5	47	1.6	140°
8.85	3	860.1-0885-028A1-SM		10.0	28.2	89	87.5	47	1.6	140°
9.00	3	860.1-0900-028A1-SM		10.0	28.6	89	87.5	47	1.6	140°
	5	860.1-0900-046A1-SM		10.0	46.2	103	101.5	61	1.6	140°
9.20	3	860.1-0920-029A1-SM		10.0	29.3	89	87.5	47	1.7	140°
9.30	3	860.1-0930-029A1-SM		10.0	29.6	89	87.4	47	1.7	140°
	5	860.1-0930-046A1-SM		10.0	46.3	103	101.4	61	1.7	140°
9.40	3	860.1-0940-029A1-SM		10.0	29.9	89	87.4	47	1.7	140°
9.50	3	860.1-0950-030A1-SM		10.0	30.2	89	87.4	47	1.7	140°
9.52	3	860.1-0952-030A1-SM		10.0	30.3	89	87.4	47	1.7	140°
9.53	3	860.1-0953-030A1-SM		10.0	30.3	89	87.4	47	1.7	140°
9.60	3	860.1-0960-030A1-SM		10.0	30.5	89	87.4	47	1.8	140°
9.70	3	860.1-0970-030A1-SM		10.0	30.9	89	87.4	47	1.8	140°
9.80	3	860.1-0980-031A1-SM		10.0	31.2	89	87.4	47	1.8	140°
	5	860.1-0980-046A1-SM		10.0	46.4	103	101.4	61	1.8	140°
9.90	5	860.1-0990-046A1-SM		10.0	46.5	103	101.3	61	1.8	140°
9.92	3	860.1-0992-031A1-SM		10.0	31.6	89	87.3	47	1.8	140°
10.00	3	860.1-1000-031A1-SM		10.0	31.8	89	87.3	47	1.8	140°
	5	860.1-1000-046A1-SM		10.0	46.5	103	101.3	61	1.8	140°
10.10	3	860.1-1010-032A1-SM		12.0	32.1	102	100.3	55	1.8	140°
10.20	3	860.1-1020-032A1-SM		12.0	32.5	102	100.3	55	1.9	140°
10.30	3	860.1-1030-032A1-SM		12.0	32.8	102	100.3	55	1.9	140°
	5	860.1-1030-053A1-SM		12.0	53.4	118	116.3	71	1.9	140°
10.32	3	860.1-1032-032A1-SM		12.0	32.8	102	100.3	55	1.9	140°
10.50	3	860.1-1050-033A1-SM		12.0	33.4	102	100.2	55	1.9	140°
	5	860.1-1050-054A1-SM		12.0	54.2	118	116.2	71	1.9	140°
10.80	3	860.1-1080-034A1-SM		12.0	34.4	102	100.2	55	2.0	140°
11.00	3	860.1-1100-035A1-SM		12.0	35.0	102	100.2	55	2.0	140°
	5	860.1-1100-054A1-SM		12.0	54.2	118	116.2	71	2.0	140°
11.11	3	860.1-1111-035A1-SM		12.0	35.4	102	100.1	55	2.0	140°
11.20	3	860.1-1120-035A1-SM		12.0	35.6	102	100.1	55	2.0	140°
11.50	3	860.1-1150-036A1-SM		12.0	36.6	102	100.1	55	2.1	140°
11.80	3	860.1-1180-037A1-SM		12.0	37.5	102	100.0	55	2.2	140°
	5	860.1-1200-038A1-SM		12.0	38.2	102	100.0	55	2.2	140°
12.00	3	860.1-1200-038A1-SM		12.0	38.2	102	100.0	55	2.2	140°
	5	860.1-1200-054A1-SM		12.0	54.3	118	116.0	71	2.2	140°
12.10	3	860.1-1210-038A1-SM		14.0	38.5	107	105.0	60	2.2	140°
12.20	3	860.1-1220-038A1-SM		14.0	38.8	107	105.0	60	2.2	140°
12.40	3	860.1-1240-039A1-SM		14.0	39.5	107	104.9	60	2.3	140°
12.50	3	860.1-1250-039A1-SM		14.0	39.8	107	104.9	60	2.3	140°
12.70	3	860.1-1270-040A1-SM		14.0	40.4	107	104.9	60	2.3	140°
	5	860.1-1270-057A1-SM		14.0	57.6	124	121.9	77	2.3	140°
12.90	3	860.1-1290-040A1-SM		14.0	40.6	107	104.8	60	2.4	140°
13.00	3	860.1-1300-040A1-SM		14.0	40.5	107	104.8	60	2.4	140°
13.25	3	860.1-1325-040A1-SM		14.0	40.5	107	104.8	60	2.4	140°
13.50	3	860.1-1350-040A1-SM		14.0	40.6	107	104.7	60	2.5	140°
13.70	3	860.1-1370-040A1-SM		14.0	40.6	107	104.7	60	2.5	140°
	4	860.1-1370-057A1-SM		14.0	57.6	124	121.7	77	2.5	140°
13.75	3	860.1-1375-040A1-SM		14.0	40.6	107	104.7	60	2.5	140°
14.00	3	860.1-1400-040A1-SM		14.0	40.6	107	104.7	60	2.6	140°
15.50	3	860.1-1550-043A1-SM		16.0	43.6	115	112.4	65	2.8	140°
15.87	3	860.1-1587-061A1-SM		16.0	50.5	133	130.3	83	2.9	140°

注文例 : 860.1-0300-009A1-SM 2214 10 本

CoroDrill® 860切削条件

-PM内部給油

ISO	MC No.	被削材	ブリネル 硬さ HB	材種	切削速度 (Vc)、m/min	ドリル径							
						3mm	4mm	6mm	8mm	10mm	12mm	16mm	20mm
						送り f _r mm/rev (Min-開始-Max)							
P					DC 3.00 - 20.00 mm	(Min-開始-Max)							
	P1.1.Z.AN	炭素鋼 C = 0.05-0.10%	125	P1BM	140-200-250	0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
	P1.1.Z.AN	C = 0.1-0.25%	125	P1BM	140-200-250	0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
	P1.2.Z.AN	C = 0.25-0.55%	150	P1BM	140-180-250	0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
	P1.3.Z.AN	C = 0.55-0.80%	170	P1BM	140-180-250	0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
	P1.3.Z.AN	高炭素鋼											
	P1.3.Z.AN	炭素工具鋼	210	P1BM	150-170-220	0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.32	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
	P2.1.Z.AN	低合金鋼											
	P2.1.Z.AN	非焼入れ	175	P1BM	120-170-240	0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.30	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
	P2.5.Z.HT	焼入れ、焼戻し	275	P1BM	80-110-140	0.08-0.14-0.20	0.14-0.18-0.24	0.18-0.24-0.32	0.20-0.28-0.36	0.20-0.32-0.40	0.22-0.36-0.44	0.24-0.40-0.48	0.26-0.44-0.50
	P2.5.Z.HT	焼入れ、焼戻し	350	P1BM	60-80-100	0.08-0.12-0.18	0.14-0.16-0.22	0.18-0.22-0.30	0.20-0.25-0.33	0.20-0.29-0.37	0.22-0.33-0.41	0.24-0.36-0.42	0.26-0.40-0.48
		高合金鋼											
	P3.0.Z.AN	焼きなまし	200	P1BM	60-120-140	0.08-0.14-0.22	0.10-0.18-0.24	0.12-0.20-0.26	0.15-0.22-0.28	0.16-0.24-0.32	0.18-0.28-0.40	0.20-0.30-0.42	0.22-0.32-0.44
	P3.0.Z.HT	焼入れ工具鋼	300	P1BM	60-80-100	0.08-0.12-0.16	0.10-0.15-0.18	0.12-0.18-0.22	0.15-0.20-0.28	0.16-0.22-0.32	0.18-0.26-0.36	0.20-0.28-0.40	0.22-0.30-0.42
		鋳鋼											
	P1.5.C.UT	炭素鋼	150	P1BM	120-170-210	0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.30	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48
	P2.6.C.UT	低合金 (合金成分≤5%)	200	P1BM	120-160-220	0.06-0.10-0.20	0.10-0.14-0.24	0.12-0.18-0.28	0.14-0.22-0.30	0.15-0.24-0.39	0.18-0.27-0.42	0.21-0.30-0.45	0.24-0.33-0.48

-MM内部給油

ISO	MC No.	被削材	ブリネル 硬さ HB	材種	切削速度 (Vc)、m/min	ドリル径				
						3.00-6.00mm	6.01-10.00mm	10.01-13.00mm	13.01-16.00mm	16.01-20.00mm
						送り f _r mm/rev (Min-Max)				
M					DC 3.00 - 20.00 mm	(Min-Max)				
	M1.0.Z.AQ		200		55-68 (180-223)	0.07-0.12 (.0028-.0047)	0.10-0.14 (.0039-.0055)	0.12-0.16 (.0047-.0063)	0.15-0.18 (.0059-.0071)	0.17-0.2 (.0067-.0079)
	M1.0.Z.PH	オーステナイト系ステンレス鋼	300		50-65 (164-213)	0.07-0.12 (.0028-.0047)	0.10-0.14 (.0039-.0055)	0.12-0.16 (.0047-.0063)	0.15-0.18 (.0059-.0071)	0.17-0.2 (.0067-.0079)
	M1.0.C.UT		200		55-68 (180-223)	0.07-0.12 (.0028-.0047)	0.10-0.14 (.0039-.0055)	0.12-0.16 (.0047-.0063)	0.15-0.18 (.0059-.0071)	0.17-0.2 (.0067-.0079)
	M1.1.Z.AQ		200		55-68 (180-223)	0.07-0.12 (.0028-.0047)	0.10-0.14 (.0039-.0055)	0.12-0.16 (.0047-.0063)	0.15-0.18 (.0059-.0071)	0.17-0.2 (.0067-.0079)
	M1.3.Z.AQ		200		55-68 (180-223)	0.07-0.12 (.0028-.0047)	0.10-0.14 (.0039-.0055)	0.12-0.16 (.0047-.0063)	0.15-0.18 (.0059-.0071)	0.17-0.2 (.0067-.0079)
	M1.3.C.AQ		200		55-68 (180-223)	0.07-0.12 (.0028-.0047)	0.10-0.14 (.0039-.0055)	0.12-0.16 (.0047-.0063)	0.15-0.18 (.0059-.0071)	0.17-0.2 (.0067-.0079)
	M2.0.Z.AQ	スーパーオーステナイト系ステンレス鋼	200		45-55 (148-180)	0.07-0.12 (.0028-.0047)	0.10-0.14 (.0039-.0055)	0.12-0.16 (.0047-.0063)	0.15-0.18 (.0059-.0071)	0.17-0.2 (.0067-.0079)
	M2.0.C.AQ	Ni≥20%	200		45-55 (148-180)	0.07-0.12 (.0028-.0047)	0.10-0.14 (.0039-.0055)	0.12-0.16 (.0047-.0063)	0.15-0.18 (.0059-.0071)	0.17-0.2 (.0067-.0079)
	M3.1.Z.AQ	2相ステンレス	230		37-46 (121-151)	0.05-0.09 (.0020-.0035)	0.08-0.12 (.0031-.0047)	0.11-0.14 (.0043-.0055)	0.13-0.15 (.0051-.0059)	0.14-0.17 (.0055-.0067)
	M3.1.C.AQ		230		37-46 (121-151)	0.05-0.09 (.0020-.0035)	0.08-0.12 (.0031-.0047)	0.11-0.14 (.0043-.0055)	0.13-0.15 (.0051-.0059)	0.14-0.17 (.0055-.0067)
	M3.2.Z.AQ		260		35-45 (115-148)	0.05-0.09 (.0020-.0035)	0.08-0.12 (.0031-.0047)	0.11-0.14 (.0043-.0055)	0.13-0.15 (.0051-.0059)	0.14-0.17 (.0055-.0067)
	M3.2.C.AQ		260		35-45 (115-148)	0.05-0.09 (.0020-.0035)	0.08-0.12 (.0031-.0047)	0.11-0.14 (.0043-.0055)	0.13-0.15 (.0051-.0059)	0.14-0.17 (.0055-.0067)
	M3.2.C.AQ		260		35-45 (115-148)	0.05-0.09 (.0020-.0035)	0.08-0.12 (.0031-.0047)	0.11-0.14 (.0043-.0055)	0.13-0.15 (.0051-.0059)	0.14-0.17 (.0055-.0067)

-SD内部給油

ISO	MC No.	被削材	ブリネル 硬さ HB	材種	切削速度 (Vc)、m/min	ドリル径			
						3.00-6.00mm	6.01-10.00mm	10.01-13.00mm	13.01-16.00mm
						送り f _r mm/rev (Min-Max)			
S					DC 3.00 - 20.00 mm	(Min-Max)			
	S1.0.U.AN	耐熱合金	200	S2BM	20-28	0.08-0.14	0.12-0.16	0.14-0.2	0.18-0.24
	S1.0.U.AG		280	S2BM	20-28	0.08-0.14	0.12-0.16	0.14-0.2	0.18-0.24
	S2.0.Z.AN	ニッケルベース	250	S2BM	20-28	0.08-0.14	0.12-0.16	0.14-0.2	0.18-0.24
	S2.0.Z.AN		350	S2BM	20-28	0.08-0.14	0.12-0.16	0.14-0.2	0.18-0.24
	S2.0.Z.UT		275	S2BM	20-28	0.08-0.14	0.12-0.16	0.14-0.2	0.18-0.24
	S2.0.Z.NS		320	S2BM	20-28	0.08-0.14	0.12-0.16	0.14-0.2	0.18-0.24
	S3.0.Z.AN	コバルトベース耐熱合金	200	S2BM	16-24	0.06-0.12	0.1-0.14	0.12-0.18	0.16-0.22
	S3.0.Z.AG		300	S2BM	16-24	0.06-0.12	0.1-0.14	0.12-0.18	0.16-0.22
	S3.0.C.NS		320	S2BM	16-24	0.06-0.12	0.1-0.14	0.12-0.18	0.16-0.22

-SM内部給油

ISO	MC No.	被削材	ブリネル 硬さ HB	材種	切削速度 (Vc)、m/min	ドリル径							
						3mm	4mm	6mm	8mm	10mm	12mm	16mm	20mm
						送り f _r mm/rev (Min-Max)							
S					DC 3.00 - 20.00 mm	(Min-Max)							
	S4.1.Z.UT	チタン合金	200	1210	40-60	0.06-0.12	0.06-0.12	0.06-0.12	0.08-0.20	0.08-0.20	0.14-0.28	0.16-0.30	0.16-0.30
	S4.2.Z.AN		320	1210	40-60	0.06-0.12	0.06-0.12	0.06-0.12	0.08-0.20	0.08-0.20	0.14-0.28	0.16-0.30	0.16-0.30
	S4.3.Z.AN		330	1210	40-60	0.06-0.12	0.06-0.12	0.06-0.12	0.08-0.20	0.08-0.20	0.14-0.28	0.16-0.30	0.16-0.30
	S4.3.Z.AG		375	1210	40-60	0.06-0.12	0.06-0.12	0.06-0.12	0.08-0.20	0.08-0.20	0.14-0.28	0.16-0.30	0.16-0.30
	S4.4.Z.AN		330	1210	40-60	0.06-0.12	0.06-0.12	0.06-0.12	0.08-0.20	0.08-0.20	0.14-0.28	0.16-0.30	0.16-0.30
	S4.4.Z.AG		410	1210	40-60	0.06-0.12	0.06-0.12	0.06-0.12	0.08-0.20	0.08-0.20	0.14-0.28	0.16-0.30	0.16-0.30
	S4.4.Z.AG		410	1210	40-60	0.06-0.12	0.06-0.12	0.06-0.12	0.08-0.20	0.08-0.20	0.14-0.28	0.16-0.30	0.16-0.30

-NM内部給油 3 x DC

ISO	MC No.	被削材	プリネル 硬さ HB	材種	切削速度 (Vc)、m/min DC 3.00 - 20.00 mm	ドリル径							
						3mm	4mm	6mm	8mm	10mm	12mm	16mm	20mm
						送り f _n mm/rev (Min-開始-Max)							
N	N1.3.C.UT	アルミ合金 (鋳物、非時効)	75	H10F	320-400-480 (Min-開始-Max)	0.20-0.25-0.30	0.26-0.33-0.39	0.43-0.53-0.64	0.64-0.80-0.96	0.80-1.00-1.20	0.88-1.20-1.44	0.96-1.20-1.44	0.96-1.20-1.44
	N2.0.C.UT	マグネシウム合金	90	H10F	200-250-300	0.14-0.18-0.22	0.18-0.22-0.26	0.25-0.32-0.38	0.34-0.43-0.52	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.59-0.74-0.89

-NM内部給油 8 x DC

N	N1.3.C.UT	アルミ合金 (鋳物、非時効)	75	H10F	(Min-開始-Max) 320-400-480	0.14-0.18-0.22	0.18-0.22-0.26	0.25-0.32-0.38	0.34-0.43-0.52	0.44-0.55-0.66	0.56-0.70-0.84	0.56-0.70-0.84	0.59-0.74-0.89
	N2.0.C.UT	マグネシウム合金	90	H10F	200-250-300	0.12-0.15-0.18	0.14-0.18-0.22	0.20-0.25-0.30	0.27-0.33-0.40	0.34-0.42-0.50	0.38-0.48-0.58	0.44-0.55-0.66	0.46-0.58-0.70

推奨切削速度は、内部給油仕様で最高の性能を発揮します。
推奨最小圧力 1.5MPa

外部給油を使用する場合：
- 良好な切りくず生成と排出には、切削条件の調整がより重要になります。
- 内部給油の場合よりも低い加工深さになることがあります。

再研磨は製作した
工具メーカーに
お任せ！

再研磨サービス
使用済みコロマントの超硬ソリッド工具に当社の再研磨・再コーティングサービスを利用することにより、お客様の総工具費を削減することができます。独自の再研磨・再コーティングサービスは、使用済みの超硬ソリッド工具を3回目の再研磨まで新品とほぼ同じ性能まで回復させることができます。

1穴あたりの工具費

再研磨回数	平均工具費 (%)
新品	100%
1回	65%
2回	50%
3回	45%

サンドビック再研磨基準 [下記までが再研磨受入れ基準]

●逃げ面摩耗
最大逃げ面摩耗量ドリル径の4%以下
例：ドリル径 Dc8mmの場合: 8mm x 0.04 =0.32mm

最大でドリル径の4%

●マージンとすくい面の摩耗
軸方向に0.6 mm以下の摩耗・チッピング

最大 0.6 mm

0.6 mm以上は再研磨不可

再研磨ご依頼の際は運送中に破損が起きないように梱包にご注意願います。詳細については最寄りのサンドビック・コロマントの営業所へお問い合わせください。

リコンディショニングセンター瀬峰

- 当社の超硬ソリッド工具をすべて再研磨します
- お客様のリードタイムの短縮とコストの削減に
- 環境への配慮！ 再研磨・再コーティングサービスの開始で持続可能な社会づくり

【対象製品】	CoroMill® Pluraシリーズ	CoroMill® 316	CoroDrill® 860シリーズ	CoroMill® Dura

加工事例

加工事例1

P

ドリル：860.1-0910-045A1-PM
被削材：S15C
使用機械：複合加工機

	他社製品	CoroDrill® 860-PM
切削速度 v_c (m/min)	55	143
回転数 n (min^{-1})	1924	5000
回転送り f_n (mm/rev)	0.36	0.23
テーブル送り V_f (mm/min)	693	1150
加工数 (台)	600	600

生産性 1.7倍！



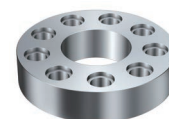
加工事例2

P

ドリル：860.1-0510-037A1-PM P1BM
被削材：S45C相当品
使用機械：マシニングセンタ

	他社製品	CoroDrill® 860-PM
切削速度 v_c (m/min)	87	120
回転数 n (min^{-1})	5,432	7,943
回転送り f_n (mm/rev)	0.13	0.18
テーブル送り V_f (mm/min)	706	1,348
加工長 (m)	20	80

寿命 4倍！
生産性 1.9倍！



加工事例3

M

ドリル：860.1-0750-043A1-MM M2BM
被削材：2相ステンレス

	他社製品	CoroDrill® 860-MM
切削速度 v_c (m/min)	32.8	65.6
回転数 n (min^{-1})	1,392	2,784
回転送り f_n (mm/rev)	0.117	0.117
テーブル送り V_f (mm/min)	163	326
加工長 (m)	22.32	25.09

寿命 1.12倍！
生産性 2.0倍！

加工事例4

S

ドリル：860.1-0800-041A1-SD S2BM
被削材：Inconel 718 (398HB)
使用機械：マシニングセンター
クーラント：外部給油

	他社品	CoroDrill® 860-SD
切削速度 v_c (m/min)	11	20
回転数 n (min^{-1})	438	796
回転送り f_n (mm/rev)	0.08	0.1
テーブル送り V_f (mm/min)	35	80
加工長 (m)	0.15	750
加工数 (穴)	10	50

寿命 5倍！
生産性 2.3倍！

加工事例5

N

ドリル：860.1-0520-016A1-NM H10F
被削材：A7075相当品 (アルミ合金)

	他社製品	CoroDrill® 860-NM
切削速度 v_c (m/min)	98	114
回転数 n (min^{-1})	6,000	7,000
回転送り f_n (mm/rev)	0.1	0.16
テーブル送り V_f (mm/min)	600	1,100
加工数 (台)	400	400

生産性 1.8倍！



加工事例6

S

ドリル：CoroDrill®860-SM、φ10.2
被削材：Ti-6Al-4V (36 HRC)

	他社品	CoroDrill® 860-SM
切削速度 v_c (m/min)	60	60
回転数 n (min^{-1})	1,873	1,873
回転送り f_n (mm/rev)	0.14	0.14
テーブル送り V_f (mm/min)	262	262
加工長 (m)	15	42

寿命 2.8倍！

その他のソリッド工具

CoroMill® Dura

超硬ソリッド万能汎用エンドミル

工具径：φ1～25



CoroMill® Plura

種類豊富なエンドミル

工具径：0.4-25mm



CoroDrill® 861

深穴用ソリッドドリル

加工径：3-20mm

加工深さ：12-30×DC

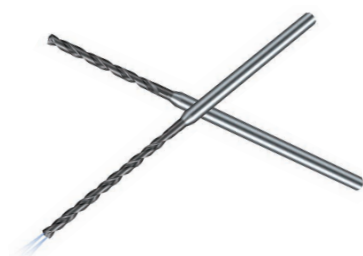


CoroDrill® 862

小径ソリッドドリル

加工径：0.3-3.0mm

加工深さ：9-16×DC



CoroTap®

高生産性タップ

加工径：M3-M24



CoroDrill® 452

CFRP用ソリッドドリル

加工径：2.5-12.7mm



CoroDrill® 400/430

アルミ合金／鋳物加工用ソリッドドリル

加工径：3-25mm

加工深さ：-8×DC



CoroReamer®

高精度超硬リーマ

加工径：3.97-20mm



CoroDrill® 460

万能ソリッドドリル

加工径：3-20mm

加工深さ：2-8×DC



安全について

- 切れ刃や切りくずには直接手で触らないでください。 ● 推奨条件の範囲内でご使用し、工具交換は早めに行ってください。
- 高温の切りくずが飛散したり、長く伸びた切りくずが排出されることがあります。安全カバーや保護メガネなどの保護具を使用してください。
- 不水溶性切削油剤を使用する場合は、防火対策を必ず行ってください。 ● チップや部品の取付けは、付属のレンチやスパナを用いて確実に取り付けてください。

ニュースレター 会員募集中!!

新製品情報、新しいソリューション・技術情報などいち早くお届けします。サンドビックコロマントのホームページから登録ください。



TEL : 0800-919-0291

E-mail: jp.coromant@sandvik.com

サンドビック株式会社 コロマントカンパニー

www.sandvik.coromant.com