

# SDX series

**超硬 鋼用ソリッドドリル<強力型>**

Solid Carbide Drills for Steels(High Power Type)

**SDX2A**(2D用)

φ0.5~13.0mm

**SDX4A**(4D用) **NEW**

φ3.0~20.0mm

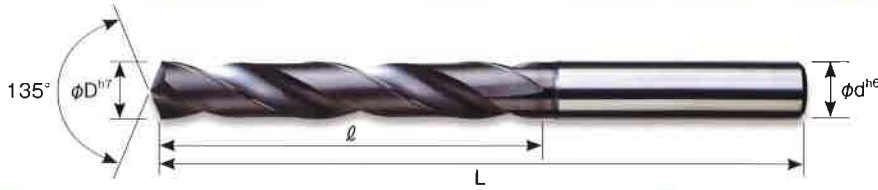
Solid Carbide Drills for Steels

## 特長 Feature

- 1/ 寿命が3倍!** Tool life is triple!  
 強力刃型とOKコートプレミアムの効果で、従来品に比べ寿命が3倍!(当社比)  
 By High Power Blade and OK Coat Premium effect, triple tool life of conventional product.
- 2/ 4D用が新登場!**(4D用:刃径×4倍の穴深さ可能) 4D-type was standardized!  
 2D用に加え、4D用をラインナップ! 刃径はφ20まで対応!  
 Standardized for 2D and for 4D. Prepared outer diameter until φ20.
- 3/ リーマ用下穴の微調整可能!** It can fine-tune the pilot hole for the reamer!  
 リーマの下穴として「あったら便利!」なサイズ(φ□.85)を追加。(ジャスト寸法仕上用)  
 Added the size that is "Convenience size!" for reamer.

# 超硬 鋼用ドリル(強力型) 2D / 4D

Solid Carbide Drills for Steels  
(High Power Type)



- 対象ワーク：鋼・鋳鉄
- 先端刃型：曲線刃型(φ3~)
- 加工穴深さ：2D用/4D用
- 給油仕様：外部給油仕様
- 超硬材質：超微粒子超硬合金
- 表面処理：OKコートプレミアム

刃径 D	SDX2A (2D用)						刃径 D	SDX4A (4D用)					
	有効深さ ℓe	溝長 ℓ	全長 L	柄径 d	品番 Product No.	標準価格(¥) Standard Price		有効深さ ℓe	溝長 ℓ	全長 L	柄径 d	品番 Product No.	標準価格(¥) Standard Price
0.5	3	6	45	3	SDX2A005	3,800	0.5						
0.6	3	6	45	3	SDX2A006	3,800	0.6						
0.7	3	6	45	3	SDX2A007	3,800	0.7						
0.8	3	6	45	3	SDX2A008	3,800	0.8						
0.85	3	6	45	3	SDX2A0085	3,800	0.85						
0.9	3	6	45	3	SDX2A009	3,800	0.9						
1.0	6	10	50	3	SDX2A010	3,500	1.0						
1.1	5	10	50	3	SDX2A011	3,500	1.1						
1.2	5	10	50	3	SDX2A012	3,500	1.2						
1.3	5	10	50	3	SDX2A013	3,500	1.3						
1.4	5	10	50	3	SDX2A014	3,500	1.4						
1.5	5	10	50	3	SDX2A015	3,500	1.5						
1.6	7	13	50	3	SDX2A016	3,500	1.6						
1.7	7	13	50	3	SDX2A017	3,500	1.7						
1.8	7	13	50	3	SDX2A018	3,500	1.8						
1.85	7	13	50	3	SDX2A0185	3,500	1.85						
1.9	7	13	50	3	SDX2A019	3,500	1.9						
2.0	7	13	50	3	SDX2A020	3,500	2.0						
2.1	8	15	50	3	SDX2A021	3,500	2.1						
2.2	8	15	50	3	SDX2A022	3,500	2.2						
2.3	8	15	50	3	SDX2A023	3,500	2.3						
2.4	8	15	50	3	SDX2A024	3,500	2.4						
2.5	8	15	50	3	SDX2A025	3,500	2.5						
2.6	10	18	50	3	SDX2A026	3,500	2.6						
2.7	10	18	50	3	SDX2A027	3,500	2.7						
2.8	10	18	50	3	SDX2A028	3,500	2.8						
2.85	10	18	50	3	SDX2A0285	3,500	2.85						
2.9	10	18	50	3	SDX2A029	3,500	2.9						
3.0	9	18	50	3	SDX2A030	3,500	3.0	15	25	68	4	SDX4A030	3,900
3.1	11	20	58	4	SDX2A031	4,300	3.1	15	25	68	4	SDX4A031	4,800
3.2	11	20	58	4	SDX2A032	4,300	3.2	15	25	68	4	SDX4A032	4,800
3.3	11	20	58	4	SDX2A033	4,300	3.3	15	25	68	4	SDX4A033	4,800
3.4	10	20	58	4	SDX2A034	4,300	3.4	14	25	68	4	SDX4A034	4,800
3.5	10	20	58	4	SDX2A035	4,300	3.5	14	25	68	4	SDX4A035	4,800
3.6	12	22	58	4	SDX2A036	4,300	3.6	17	28	68	4	SDX4A036	4,800
3.7	12	22	58	4	SDX2A037	4,300	3.7	17	28	68	4	SDX4A037	4,800
3.8	12	22	58	4	SDX2A038	4,300	3.8	17	28	68	4	SDX4A038	4,800
3.85	12	22	58	4	SDX2A0385	4,300	3.85	17	28	68	4	SDX4A0385	4,800
3.9	11	22	58	4	SDX2A039	4,300	3.9	17	28	68	4	SDX4A039	4,800
4.0	11	22	58	4	SDX2A040	4,300	4.0	17	28	68	4	SDX4A040	4,800
4.1	13	24	60	5	SDX2A041	4,600	4.1	20	32	75	5	SDX4A041	5,000
4.2	13	24	60	5	SDX2A042	4,600	4.2	20	32	75	5	SDX4A042	5,000
4.3	13	24	60	5	SDX2A043	4,600	4.3	20	32	75	5	SDX4A043	5,000
4.4	13	24	60	5	SDX2A044	4,600	4.4	20	32	75	5	SDX4A044	5,000
4.5	12	24	60	5	SDX2A045	4,600	4.5	20	32	75	5	SDX4A045	5,000
4.6	14	26	60	5	SDX2A046	5,000	4.6	26	38	75	5	SDX4A046	5,500
4.7	14	26	60	5	SDX2A047	5,000	4.7	25	38	75	5	SDX4A047	5,500
4.8	14	26	60	5	SDX2A048	5,000	4.8	25	38	75	5	SDX4A048	5,500
4.85	14	26	60	5	SDX2A0485	5,000	4.85	25	38	75	5	SDX4A0485	5,500
4.9	14	26	60	5	SDX2A049	5,000	4.9	25	38	75	5	SDX4A049	5,500
5.0	14	26	60	5	SDX2A050	5,000	5.0	25	38	75	5	SDX4A050	5,500
5.1	15	28	70	6	SDX2A051	5,500	5.1	31	44	79	6	SDX4A051	6,000
5.2	15	28	70	6	SDX2A052	5,500	5.2	31	44	79	6	SDX4A052	6,000
5.3	15	28	70	6	SDX2A053	5,500	5.3	31	44	79	6	SDX4A053	6,000
5.4	15	28	70	6	SDX2A054	5,500	5.4	30	44	79	6	SDX4A054	6,000

刃径 D	SDX2A (2D用)						刃径 D	SDX4A (4D用)					
	有効深さ ℓe	溝長 ℓ	全長 L	柄径 d	品番 Product No.	標準価格(¥) Standard Price		有効深さ ℓe	溝長 ℓ	全長 L	柄径 d	品番 Product No.	標準価格(¥) Standard Price
5.5	15	28	70	6	SDX2A055	5,500	5.5	30	44	79	6	SDX4A055	6,000
5.6	16	30	70	6	SDX2A056	5,800	5.6	30	44	79	6	SDX4A056	6,400
5.7	16	30	70	6	SDX2A057	5,800	5.7	30	44	79	6	SDX4A057	6,400
5.8	16	30	70	6	SDX2A058	5,800	5.8	30	44	79	6	SDX4A058	6,400
5.85	16	30	70	6	SDX2A0585	5,800	5.85	30	44	79	6	SDX4A0585	6,400
5.9	16	30	70	6	SDX2A059	5,800	5.9	30	44	79	6	SDX4A059	6,400
6.0	16	30	70	6	SDX2A060	5,800	6.0	30	44	79	6	SDX4A060	6,400
6.1	20	34	80	7	SDX2A061	6,200	6.1	35	50	88	7	SDX4A061	6,800
6.2	19	34	80	7	SDX2A062	6,200	6.2	35	50	88	7	SDX4A062	6,800
6.3	19	34	80	7	SDX2A063	6,200	6.3	35	50	88	7	SDX4A063	6,800
6.4	19	34	80	7	SDX2A064	6,200	6.4	35	50	88	7	SDX4A064	6,800
6.5	19	34	80	7	SDX2A065	6,200	6.5	35	50	88	7	SDX4A065	6,800
6.6	21	36	80	7	SDX2A066	6,500	6.6	36	51	88	7	SDX4A066	7,100
6.7	20	36	80	7	SDX2A067	6,500	6.7	35	51	88	7	SDX4A067	7,100
6.8	20	36	80	7	SDX2A068	6,500	6.8	35	51	88	7	SDX4A068	7,100
6.85	20	36	80	7	SDX2A0685	6,500	6.85	35	51	88	7	SDX4A0685	7,100
6.9	20	36	80	7	SDX2A069	6,500	6.9	35	51	88	7	SDX4A069	7,100
7.0	20	36	80	7	SDX2A070	6,500	7.0	35	51	88	7	SDX4A070	7,100
7.1	22	38	85	8	SDX2A071	6,900	7.1	36	52	88	8	SDX4A071	7,600
7.2	22	38	85	8	SDX2A072	6,900	7.2	36	52	88	8	SDX4A072	7,600
7.3	21	38	85	8	SDX2A073	6,900	7.3	36	52	88	8	SDX4A073	7,600
7.4	21	38	85	8	SDX2A074	6,900	7.4	35	52	88	8	SDX4A074	7,600
7.5	21	38	85	8	SDX2A075	6,900	7.5	35	52	88	8	SDX4A075	7,600
7.6	21	38	85	8	SDX2A076	6,900	7.6	36	53	88	8	SDX4A076	7,600
7.7	21	38	85	8	SDX2A077	6,900	7.7	36	53	88	8	SDX4A077	7,600
7.8	20	38	85	8	SDX2A078	6,900	7.8	36	53	88	8	SDX4A078	7,600
7.85	20	38	85	8	SDX2A0785	6,900	7.85	36	53	88	8	SDX4A0785	7,600
7.9	20	38	85	8	SDX2A079	6,900	7.9	36	53	88	8	SDX4A079	7,600
8.0	20	38	85	8	SDX2A080	6,900	8.0	36	53	88	8	SDX4A080	7,600
8.1	22	40	85	9	SDX2A081	7,700	8.1	43	61	98	9	SDX4A081	8,500
8.2	22	40	85	9	SDX2A082	7,700	8.2	43	61	98	9	SDX4A082	8,500
8.3	22	40	85	9	SDX2A083	7,700	8.3	43	61	98	9	SDX4A083	8,500
8.4	21	40	85	9	SDX2A084	7,700	8.4	43	61	98	9	SDX4A084	8,500
8.5	21	40	85	9	SDX2A085	7,700	8.5	43	61	98	9	SDX4A085	8,500
8.6	21	40	85	9	SDX2A086	7,700	8.6	43	61	98	9	SDX4A086	8,500
8.7	21	40	85	9	SDX2A087	7,700	8.7	42	61	98	9	SDX4A087	8,500
8.8	21	40	85	9	SDX2A088	7,700	8.8	42	61	98	9	SDX4A088	8,500
8.85	21	40	85	9	SDX2A0885	7,700	8.85	42	61	98	9	SDX4A0885	8,500
8.9	20	40	85	9	SDX2A089	7,700	8.9	42	61	98	9	SDX4A089	8,500
9.0	20	40	85	9	SDX2A090	7,700	9.0	42	61	98	9	SDX4A090	8,500
9.1	23	43	90	10	SDX2A091	8,700	9.1	42	61	98	10	SDX4A091	9,600
9.2	23	43	90	10	SDX2A092	8,700	9.2	42	61	98	10	SDX4A092	9,600
9.3	23	43	90	10	SDX2A093	8,700	9.3	42	61	98	10	SDX4A093	9,600
9.4	23	43	90	10	SDX2A094	8,700	9.4	41	61	98	10	SDX4A094	9,600
9.5	22	43	90	10	SDX2A095	8,700	9.5	41	61	98	10	SDX4A095	9,600
9.6	22	43	90	10	SDX2A096	8,700	9.6	41	61	98	10	SDX4A096	9,600
9.7	22	43	90	10	SDX2A097	8,700	9.7	41	61	98	10	SDX4A097	9,600
9.8	22	43	90	10	SDX2A098	8,700	9.8	41	61	98	10	SDX4A098	9,600
9.85	22	43	90	10	SDX2A0985	8,700	9.85	41	61	98	10	SDX4A0985	9,600
9.9	22	43	90	10	SDX2A099	8,700	9.9	41	61	98	10	SDX4A099	9,600
10.0	23	43	90	10	SDX2A100	8,700	10.0	41	61	98	10	SDX4A100	9,600
10.1	26	47	97	11	SDX2A101	9,700	10.1	50	71	120	11	SDX4A101	10,600
10.2	26	47	97	11	SDX2A102	9,700	10.2	50	71	120	11	SDX4A102	10,600
10.3	26	47	97	11	SDX2A103	9,700	10.3	50	71	120	11	SDX4A103	10,600
10.4	26	47	97	11	SDX2A104	9,700	10.4	50	71	120	11	SDX4A104	10,600
10.5	26	47	97	11	SDX2A105	9,700	10.5	50	71	120	11	SDX4A105	10,600
10.6	26	47	97	11	SDX2A106	9,700	10.6	50	71	120	11	SDX4A106	10,600
10.7	25	47	97	11	SDX2A107	9,700	10.7	49	71	120	11	SDX4A107	10,600
10.8	25	47	97	11	SDX2A108	9,700	10.8	49	71	120	11	SDX4A108	10,600
10.85	25	47	97	11	SDX2A1085	9,700	10.85	49	71	120	11	SDX4A1085	10,600
10.9	25	47	97	11	SDX2A109	9,700	10.9	49	71	120	11	SDX4A109	10,600
11.0	25	47	97	11	SDX2A110	9,700	11.0	49	71	120	11	SDX4A110	10,600
11.1	28	50	107	12	SDX2A111	10,700	11.1	52	74	120	12	SDX4A111	12,000
11.2	28	50	107	12	SDX2A112	10,700	11.2	52	74	120	12	SDX4A112	12,000
11.3	28	50	107	12	SDX2A113	10,700	11.3	52	74	120	12	SDX4A113	12,000
11.4	27	50	107	12	SDX2A114	10,700	11.4	51	74	120	12	SDX4A114	12,000

刃径 D	SDX2A (2D用)						刃径 D	SDX4A (4D用)					
	有効深さ ℓe	溝長 ℓ	全長 L	柄径 d	品番 Product No.	標準価格(¥) Standard Price		有効深さ ℓe	溝長 ℓ	全長 L	柄径 d	品番 Product No.	標準価格(¥) Standard Price
11.5	27	50	107	12	SDX2A115	10,700	11.5	51	74	120	12	SDX4A115	12,000
11.6	27	50	107	12	SDX2A116	10,700	11.6	51	74	120	12	SDX4A116	12,000
11.7	27	50	107	12	SDX2A117	10,700	11.7	51	74	120	12	SDX4A117	12,000
11.8	27	50	107	12	SDX2A118	10,700	11.8	51	74	120	12	SDX4A118	12,000
11.85	27	50	107	12	SDX2A1185	10,700	11.85	51	74	120	12	SDX4A1185	12,000
11.9	27	50	107	12	SDX2A119	10,700	11.9	51	74	120	12	SDX4A119	12,000
12.0	27	50	107	12	SDX2A120	10,700	12.0	51	74	120	12	SDX4A120	12,000
12.1	30	54	120	13	SDX2A121	13,900	12.1	56	80	130	13	SDX4A121	14,500
12.2	30	54	120	13	SDX2A122	13,900	12.2	56	80	130	13	SDX4A122	14,500
12.3	30	54	120	13	SDX2A123	13,900	12.3	56	80	130	13	SDX4A123	14,500
12.4	30	54	120	13	SDX2A124	13,900	12.4	56	80	130	13	SDX4A124	14,500
12.5	30	54	120	13	SDX2A125	13,900	12.5	56	80	130	13	SDX4A125	14,500
12.6	30	54	120	13	SDX2A126	13,900	12.6	56	80	130	13	SDX4A126	14,500
12.7	29	54	120	13	SDX2A127	13,900	12.7	55	80	130	13	SDX4A127	14,500
12.8	29	54	120	13	SDX2A128	13,900	12.8	55	80	130	13	SDX4A128	14,500
12.9	29	54	120	13	SDX2A129	13,900	12.9	55	80	130	13	SDX4A129	14,500
13.0	29	54	120	13	SDX2A130	13,900	13.0	55	80	130	13	SDX4A130	14,500
13.5							13.5	60	86	140	14	SDX4A135	15,900
14.0							14.0	60	86	140	14	SDX4A140	16,500
14.5							14.5	65	92	150	15	SDX4A145	17,100
15.0							15.0	64	92	150	15	SDX4A150	17,600
15.5							15.5	69	98	155	16	SDX4A155	18,100
16.0							16.0	69	98	155	16	SDX4A160	18,700
16.5							16.5	72	102	160	17	SDX4A165	20,900
17.0							17.0	71	102	160	17	SDX4A170	22,500
17.5							17.5	74	106	165	18	SDX4A175	24,700
18.0							18.0	74	106	165	18	SDX4A180	26,800
18.5							18.5	78	111	170	19	SDX4A185	29,200
19.0							19.0	77	111	170	19	SDX4A190	30,000
19.5							19.5	80	115	175	20	SDX4A195	31,000
20.0							20.0	80	115	175	20	SDX4A200	32,000

### タップ下穴表 Drill Diameters for Tapping

メートル並目ネジ Metric Coarse Thread					
呼び Nominal	ドリル径 Drill dia	呼び Nominal	ドリル径 Drill dia	呼び Nominal	ドリル径 Drill dia
M2×0.4	1.6	M6×1.0	5.0	M12×1.75	10.3
M2.5×0.45	2.1	M7×1.0	6.0	M14×2.0	12.0
M3×0.5	2.5	M8×1.25	6.8	M16×2.0	14.0
M3.5×0.6	2.9	M9×1.25	7.8	M18×2.5	15.5
M4×0.7	3.3	M10×1.5	8.5	M20×2.5	17.5
M5×0.8	4.2	M11×1.5	9.5	M22×2.5	19.5

メートル細目ネジ Metric the Screw Thread											
呼び Nominal	ドリル径 Drill dia	呼び Nominal	ドリル径 Drill dia	呼び Nominal	ドリル径 Drill dia	呼び Nominal	ドリル径 Drill dia	呼び Nominal	ドリル径 Drill dia	呼び Nominal	ドリル径 Drill dia
M2.5×0.35	2.2	M7×0.75	6.3	M10×1.0	9.0	M12×1.0	11.0	M16×1.0	15.0	M20×2.0	18.0
M3×0.35	2.7	M8×1.0	7.0	M10×0.75	9.3	M14×1.5	12.5	M17×1.5	15.5	M20×1.5	18.5
M3.5×0.35	3.2	M8×0.75	7.3	M11×1.0	10.0	M14×1.0	13.0	M17×1.0	16.0	M20×1.0	19.0
M4×0.5	3.5	M9×1.0	8.0	M11×0.75	10.3	M15×1.5	13.5	M18×2.0	16.0	M22×2.0	20.0
M5×0.5	4.5	M9×0.75	8.3	M12×1.5	10.5	M15×1.0	14.0	M18×1.5	16.5	M22×1.5	20.5
M6×0.75	5.3	M10×1.25	8.8	M12×1.25	10.8	M16×1.5	14.5	M18×1.0	17.0	M22×1.0	21.0

### SDX2A・4A : 推奨切削条件 Recommended Drilling Conditions for SDX2A/4A

被削材 Work Material	一般構造用鋼・炭素鋼・合金鋼・鋳鉄 Structural Steels, Carbon Steels, Alloy Steels, Cast Iron SS400, S55C, SCM, SK, SKD, FCD						球状黒鉛鋳鉄 Ductile Cast Iron (FCD600)			
	~30HRC			30~45HRC			45~55HRC			
切削速度 Cutting Speed	60~100m/min			40~50m/min			15~20m/min		50~70m/min	
切削条件 Cutting Conditions	回転数(RPM) Spindle Speed	送り(mm/rev) Feed	回転数(RPM) Spindle Speed	送り(mm/rev) Feed	回転数(RPM) Spindle Speed	送り(mm/rev) Feed	回転数(RPM) Spindle Speed	送り(mm/rev) Feed	回転数(RPM) Spindle Speed	送り(mm/rev) Feed
刃径(mm)										
2	10,000	0.10	7,000	0.05	2,400	0.04	8,000	0.10		
4	5,200	0.17	3,800	0.08	1,200	0.07	4,400	0.17		
6	4,000	0.20	2,700	0.09	800	0.07	3,400	0.20		
8	3,200	0.23	2,000	0.10	600	0.08	2,600	0.23		
10	2,500	0.25	1,600	0.12	480	0.08	2,100	0.25		
12	2,100	0.25	1,250	0.12	400	0.08	1,750	0.25		
14	1,900	0.27	1,150	0.13	400	0.08	1,500	0.27		
16	1,800	0.27	1,000	0.13	400	0.08	1,300	0.28		
18	1,650	0.30	900	0.14	350	0.08	1,200	0.30		
20	1,500	0.30	800	0.15	320	0.10	1,100	0.30		

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