

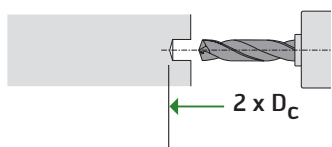

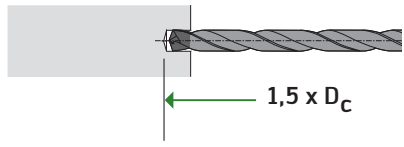

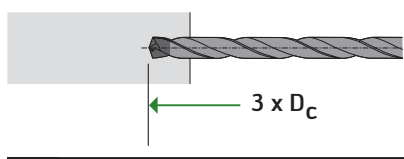

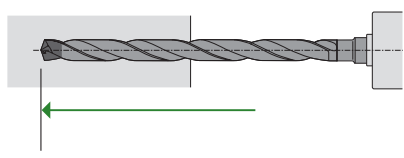

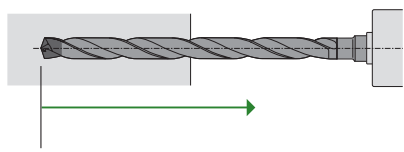

加工手順1:

XD Technology $\leq 30 \times D_c$

以下に最適:

- A6685TFP	- A6985TFP
- A6785TFP	- A6794TFP
- A6885TFP	- A6994TFP

P	M	K	N	S	H	O
✓	✓	✓		✓	✓	✓

<p>1 パイロット穴あけ1</p> 	 <p>10 ~ 30 bar on</p>	<p>2 x D_c A6181TFT A7191TFT K5191TFT K3281TFT</p>
<p>2 挿入</p> 	 <p>off</p>	<p>XD Technology</p> <p>$n_{max} = 100 \text{ rpm}$ $v_f = 1000 \text{ mm/min}$</p>
<p>3 穴あけ</p> 	 <p>10 ~ 30 bar on</p>	<p>XD Technology</p> <p>$v_c = 25 \sim 50 \%$ $v_f = 25 \sim 50 \%$</p>
<p>4 深穴あけ</p> 	 <p>10 ~ 30 bar on</p>	<p>XD Technology</p> <p>$v_c = 100 \%$ $v_f = 100 \%$</p>
<p>5 リトラクト</p> 	 <p>off</p>	<p>XD Technology</p> <p>$n_{max} = 100 \text{ rpm}$ $v_f = 1000 \text{ mm/min}$</p>

$V_c / V_f \rightarrow$  GPS

加工手順 2:

XD Technology ≤ 50 x D_C

以下に最適:

- A7495TTP - A7595TTP

P	M	K	N	S	H	O
✓		✓	✓			

- 1** パイロット穴あけ1

10 ~ 30 bar
on

2 x D_C
A6181TFT
A7191TFT
K3281TFT

- 2** パイロット穴あけ2

10 ~ 30 bar
on

12 x D_C
A6589DPP

- 3** 挿入

off

XD Technology

左回転:
n_{max} = 100 rpm
v_f = 1000 mm/min

- 4** 挿入

off

XD Technology

右回転で続行:
n_{max} = 100 rpm
v_f = 1000 mm/min

- 5** 深穴あけ

20 ~ 40 bar
on

XD Technology

v_C = 100 %
v_f = 100 %

- 6** リトラクト

off

XD Technology

n_{max} = 100 rpm
v_f = 1000 mm/min

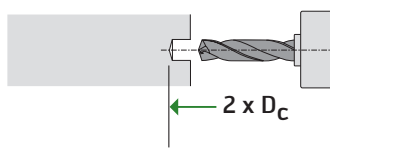

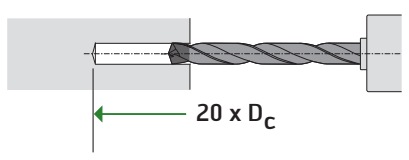

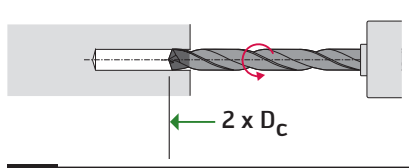

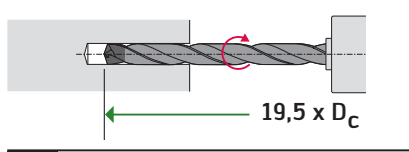

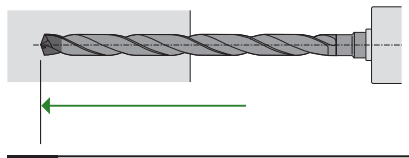

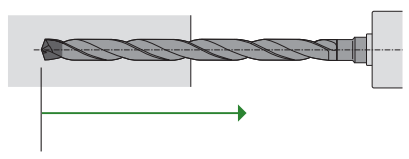

加工手順3:

XD Technology $\leq 50 \sim 70 \times D_C$

以下に最適:

$\geq 50 \times D_C$ の特殊ボーリング工具

P	M	K	N	S	H	O
✓		✓	✓			

<p>1 パイロット穴あけ1</p> 	 <p>10 ~ 30 bar on</p>	<p>2 x D_C A6181TFT A7191TFT K3281TFT</p>
<p>2 パイロット穴あけ2</p> 	 <p>10 ~ 30 bar on</p>	<p>20 x D_C A6785TFP</p>
<p>3 挿入</p> 	 <p>off</p>	<p>XD Technology</p> <p>左回転: $n_{max} = 100 \text{ rpm}$ $v_f = 1000 \text{ mm/min}$</p>
<p>4 挿入</p> 	 <p>off</p>	<p>XD Technology</p> <p>右回転で続行: $n_{max} = 100 \text{ rpm}$ $v_f = 1000 \text{ mm/min}$</p>
<p>5 深穴あけ</p> 	 <p>20 ~ 40 bar on</p>	<p>XD Technology</p> <p>$v_C = 100 \%$ $v_f = 100 \%$</p>
<p>6 リトラクト</p> 	 <p>off</p>	<p>XD Technology</p> <p>$n_{max} = 100 \text{ rpm}$ $v_f = 1000 \text{ mm/min}$</p>