

高硬度钢、钛合金、耐热合金用 高速钢钻头

VPH - GDS



高碳素钢，铸铁 都可以

特点

- 用于加工硬度为 HRC 30 ~ 50 的材料
- 材料是高级粉末高速钢 (XPM)
- WD1涂层
- 良好的锋利度
- 工具刚性较好

切削性能

Size: $\phi 5.6$

Material: Ti-6Al-4V(32HRC)

Depth of hole: 15mm (Through)

Coolant: Non Water soluble

Speed: 6m/min

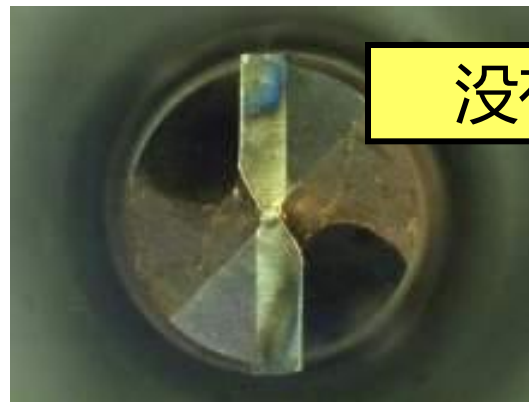
Feed : 0.06mm/rev

普通钻头



发生溶着

VPH-GDS



没有溶着



切屑连续



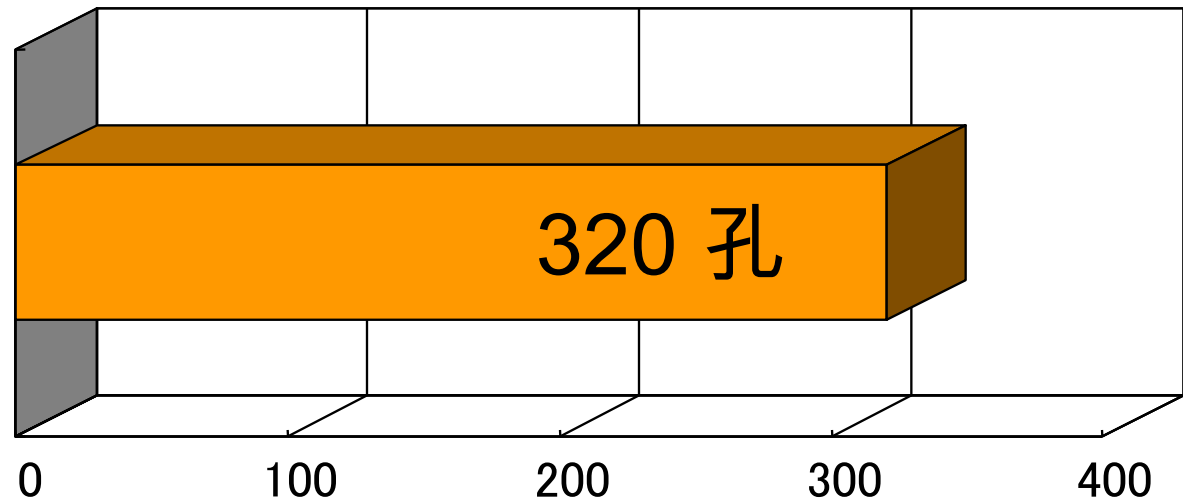
断屑良好

VPH-GDS 加工事例. 1

φ9.8

Ti-6Al-4V (38HRC)

VPH-GDS
φ9.8



Cutting Speed : 12m/min

Feed rate : 0.13mm/rev

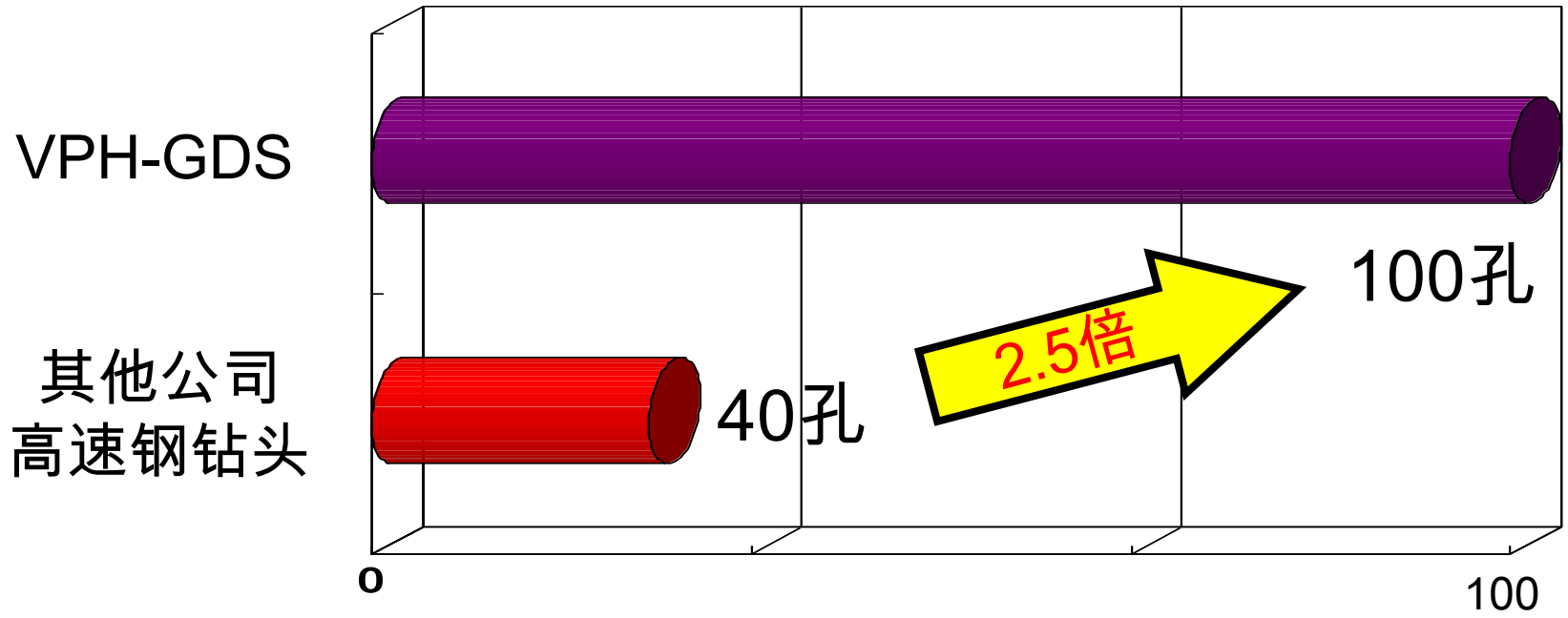
Depth of holes : 10mm

Machine : Vertical M/C

Lubrication : 水溶性

VPH-GDS 加工事例. 2 $\phi 8$

SKD61 (50HRC)



Cutting Speed : 6m/min

Feed rate : 0.16mm/rev

Depth of holes : 25mm

Machine : Vertical M/C

Lubrication : Water soluble coolant (5%)