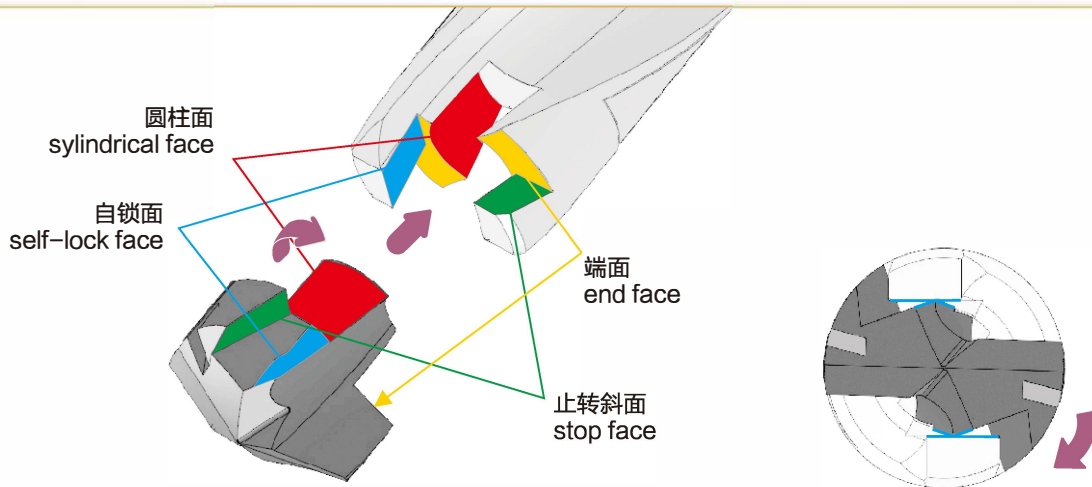


# CONTENT

## 目录

自锁式可换头钻头刀头编码系统 “QuickDrill” Cutting Head Ordering Code System	9
QD...S 标准刀头 Standard Cutting Head	10-12
QD...F 平底刀头 Flat Cutting Head	13
QD...C 定心刀头 Centering Cutting Head	14
自锁式可换头钻头刀体编码系统 “QuickDrill” Toolholder Ordering Code System	15
QD...-1.5D-C 带内冷却水孔快钻刀体 “QuickDrill” Toolholders With Coolant	16
QD...-1.5D-N 无内冷却水孔快钻刀体 “QuickDrill” Toolholders Without Coolant	17
QD...-3D-C 带内冷却水孔快钻刀体 “QuickDrill” Toolholders With Coolant	18
QD...-3D-N 无内冷却水孔快钻刀体 “QuickDrill” Toolholders Without Coolant	19
QD...-5D-C 带内冷却水孔快钻刀体 “QuickDrill” Toolholders With Coolant	20
QD...-8D-C 带内冷却水孔快钻刀体 “QuickDrill” Toolholders With Coolant	21
QD...-12D-C 带内冷却水孔快钻刀体 “QuickDrill” Toolholders Without Coolant	22
推荐的切削参数 Technical Information	23

## 全新的自锁式装夹方式 Innovation Self-Locked Clamping System



刀头、刀体圆柱配合保证同心度  
Centering by cylindrical faces

刀体的弹性变形使刀头拧入后不可回转而自锁  
The cutting head can be self-locked with toolholder while inserted due to its seat elastic deformation

端面承受钻削轴向力  
Axial drill force is transferred to toolholder by end faces

止转斜面承受钻削扭矩  
Drill torque is transferred to toolholder by stop faces

## 可快速更换刀头 No Set-up Time for Changing Cutting Head



无需从机床取下刀体，可方便快捷地在机床上更换刀头  
The cutting head can be changed in the machine tool, No need to take the toolholder out from the spindle

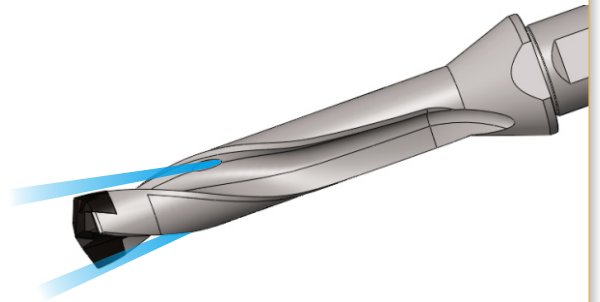
## 完美的抛光刀体 Perfect Polished Toolholders

抛光刀体排屑槽，使切屑更容易排出。  
Toolholder flutes polished Let chips evacuate easily



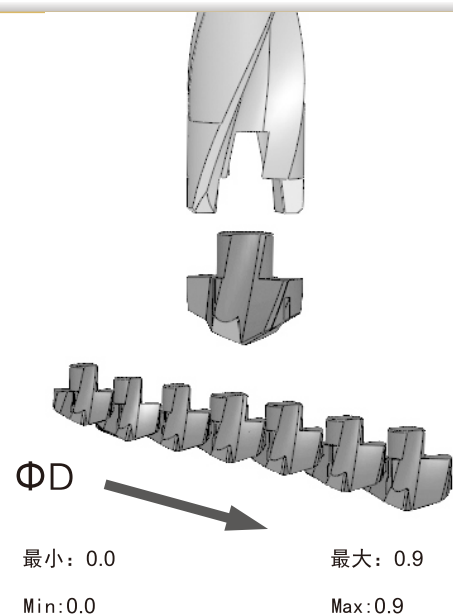
## 带内冷却水孔的刀体 Toolholders with Coolant

带内冷却孔的设计，使刀头钻削时冷却更充分，刀头寿命更长，切屑更容易排出。  
Coolant makes cutting head life much longer and also high pressure cooling liquid pushes chips to evacuate quickly



## 高互换性，管理更柔性 Interchangeability and Flexibility

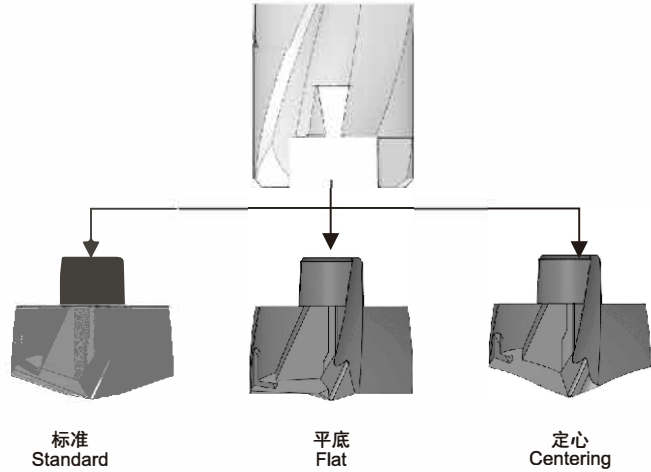
同一刀体可装不同尺寸刀头，可减少刀体数量，刀头与刀体完全互换。  
Different cutting diameter heads can be fixed into one toolholder so as to reduce the number of toolholder, and cutting heads and toolholders are interchangeable totally



## 三种刀头可供选择 Three Different Cutting Heads are Available

可地选择不同用途的标准，平底，定心刀头。

Standard ,flat and self-centering cutting heads are available



## 增值服务 Resharpener Service

提供刀头返厂重磨服务，为用户进一步减少刀具使用成本。  
Supply resharpener cutting head service for customer to cut cast



1

把刀杆装在刀柄上,刀柄装在机床或刀具预调仪上,以便安装刀头

Fix drill holder on arbor  
For cutting head  
exchange,fix arbor on the  
machine or  
set on toolpresetter



2

用压缩空气清洁刀槽

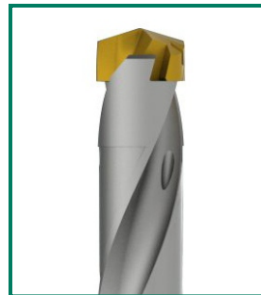
Remove dust using air  
blast



3

把刀头放进刀槽 (戴上手套以防划伤)

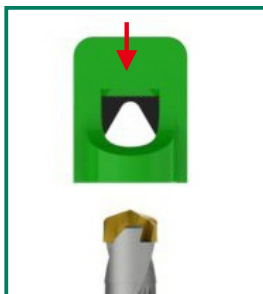
Put a cutting head into  
drill holder.(Use gloves to  
protect your hand from  
any danger)



4

轻轻顺时针方向转动  
(戴上手套以防划伤)

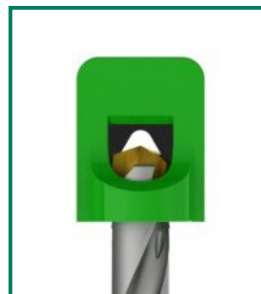
Turn lightly in a  
clockwise direction (Use  
gloves to protect your  
hand from any danger)



5

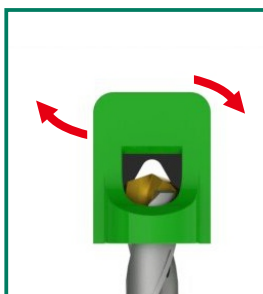
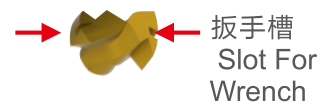
选用合适的扳手

Set the wrench properly



6

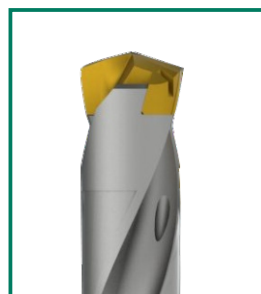
确认扳手卡入扳手槽中  
Make sure the wrench fits  
with cutting head's slot  
for the wrench



7

继续顺时针方向转动,  
用力转过自锁位直到锁紧  
为止

Turn the wrench in a  
clockwise direction slowly,  
then turn strongly while  
passing self-locked face  
untill cutting head won't  
move



8

完成

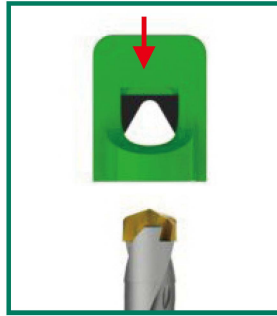
Complete

## 怎样卸刀头 How To Detach Cutting Heads



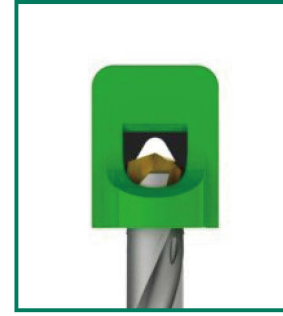
1

用压缩空气清洁刀头  
Remove dust from cutting head  
using air blast



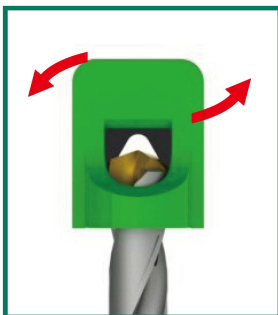
2

选用合适的扳手  
Set the wrench properly



3

确认扳手卡入扳手槽中  
Fit the wrench to cutting head  
slot



4

反时针方向转动扳手  
Turn the wrench in a counter-  
clockwise direction



5

一旦失去自锁，用手转动  
刀头（戴上手套以防划  
伤）

Once self-lock is  
released, cutting head  
can be turned by fingers  
(Use gloves to protect  
your hand from any  
danger)

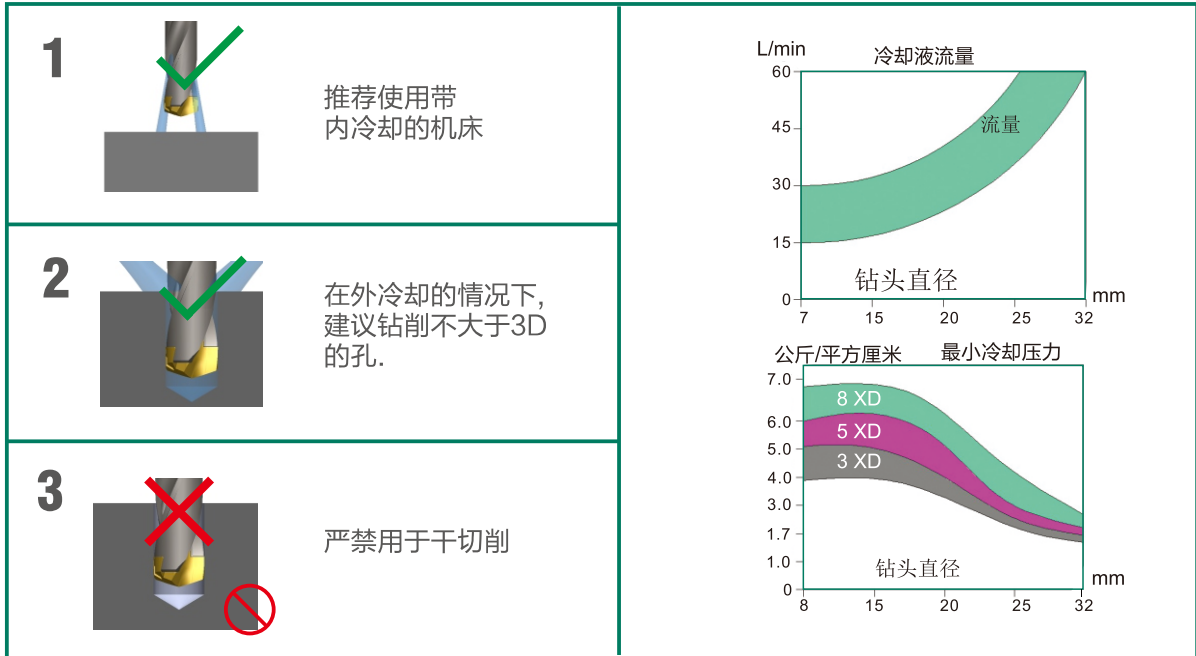


6

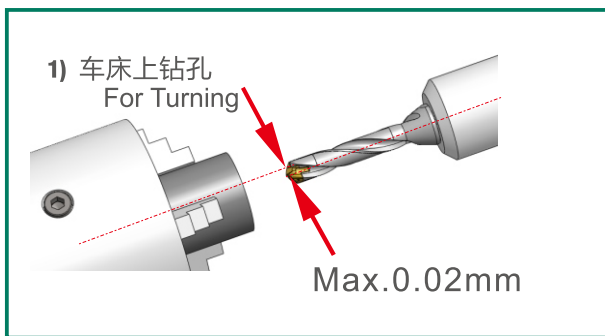
取下刀头（戴上手套以防  
划伤）

Remove cutting head (Use  
gloves to protect your hand  
from any danger)

## 冷却 Coolant

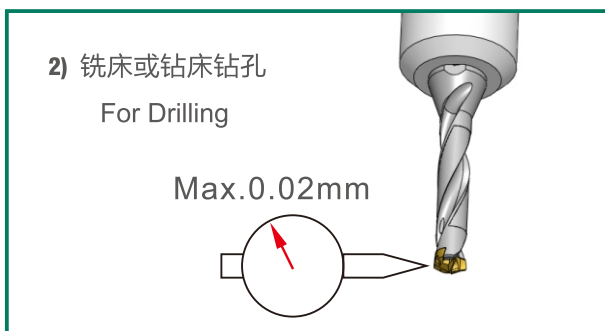


## 应用警示 Usage Precautions core deviation



工件与钻头偏心量不大于0.02毫米

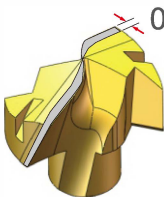
Set deviation amount under 0.02mm between the workpiece and the drill



禁止使用粗糙的刀柄。刀柄的偏心量不大于0.02毫米

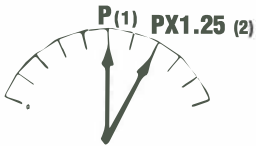
Do not use any arbor with a deformed attachment surface.  
Center of arbor deviation must be within 0.02mm

钻头更换判断标准 Indication of Cutting Head Wear



0.2-0.3mm

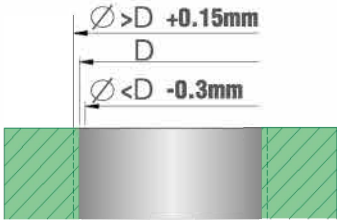
a) 磨损极限  
Wear Limit



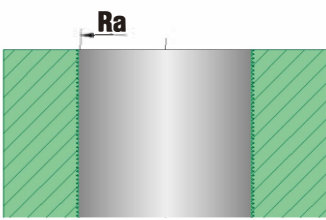
P(1) PX1.25 (2)

b) 功耗  
Power Restriction


(1)新钻头 New cutting head  
(2)磨损钻头比新钻头大25% Increase 25% for wore-out cutting head



c) 孔径变化大  
Diameter Change



d) 光洁度急剧变差  
Surface Finish Deterioration



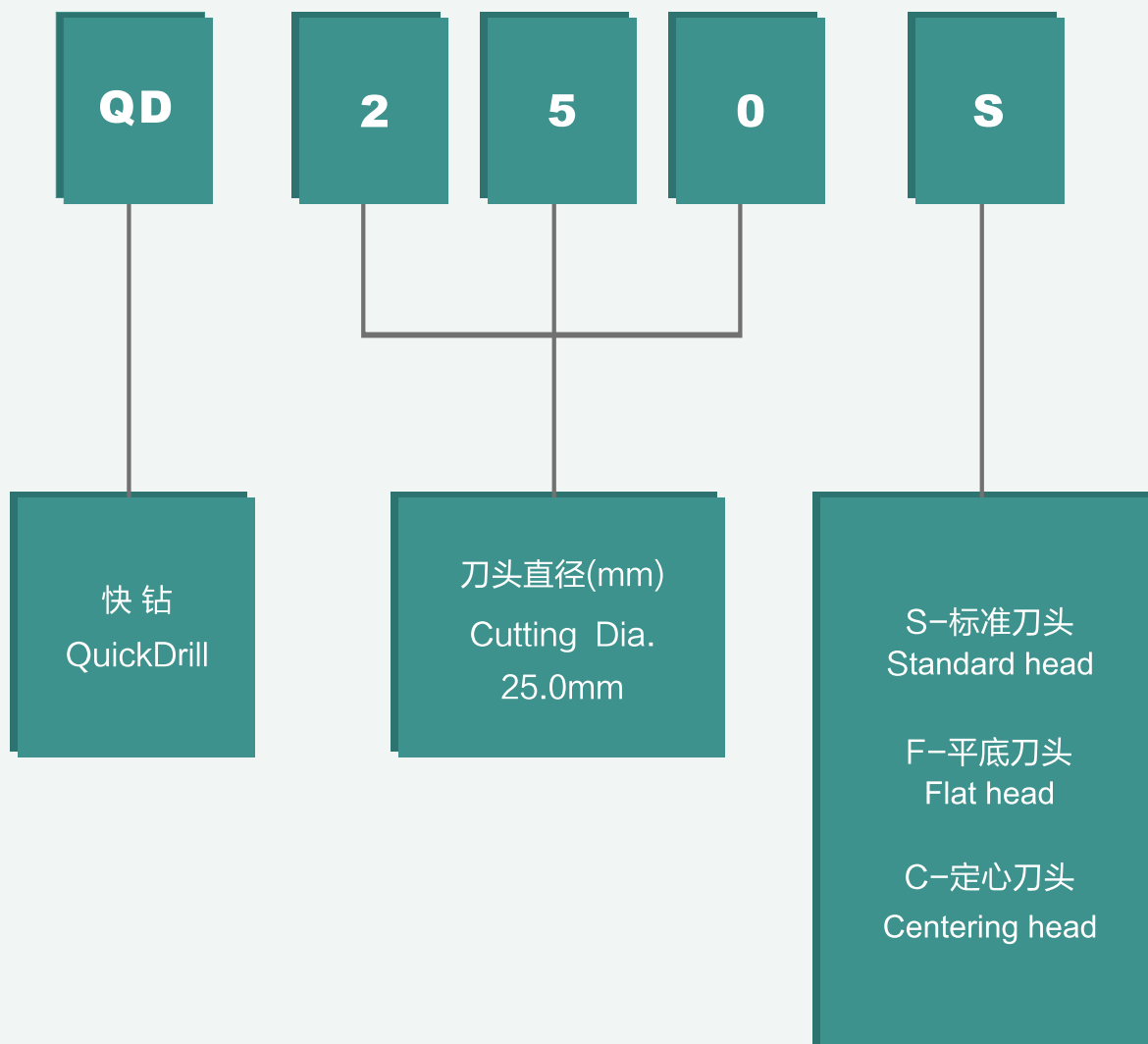
e) 振动噪音急剧上升  
Vibration Noise Drastically Increases

应用 Application

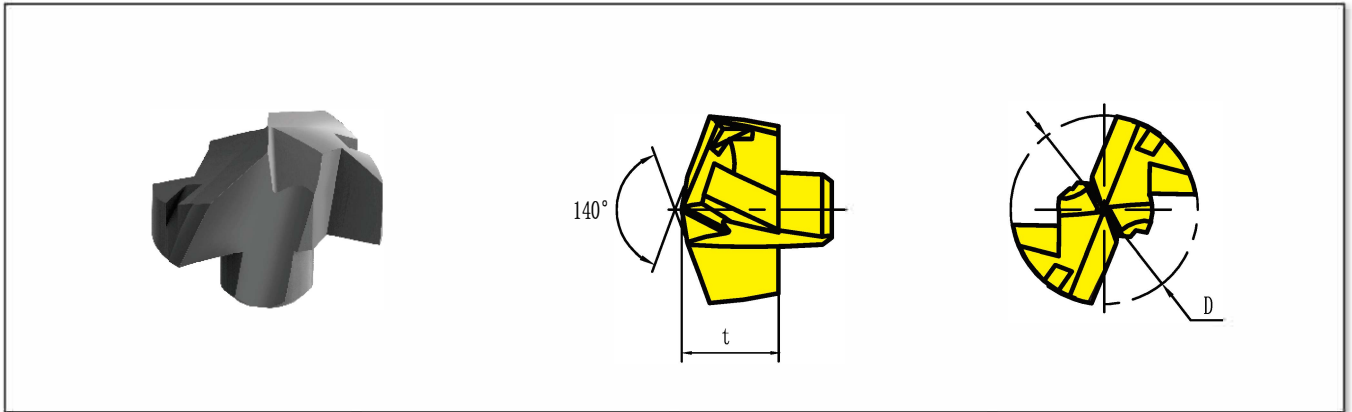
推荐应用 Application Recommendation	工件形状 Workpiece Shape	不推荐应用 Application Not Recommendation	工件形状 Workpiece Shape
平面孔 推荐 Flat Face Recommended		重叠孔 禁用 Hole Expansion Not Recommended	
叠板孔 重叠加固可用 Stacked Plates Recommended(absolutely don't move between plates)		斜面孔 禁用 Slanted Surface Not Recommended	
曲面孔 减少进给量一半可用 Concave Surface Recommended(reduce a half of feed tate as narmal)		半边孔 禁用 Half Cylindrical Not Recommended	
管壁孔 过管中心可用 Pipe Material Recommended		型芯孔 禁用 Cored Hole Not Recommended	







自锁式可换头钻头刀头编码系统 “QuickDrill” Cutting Head Ordering Code System



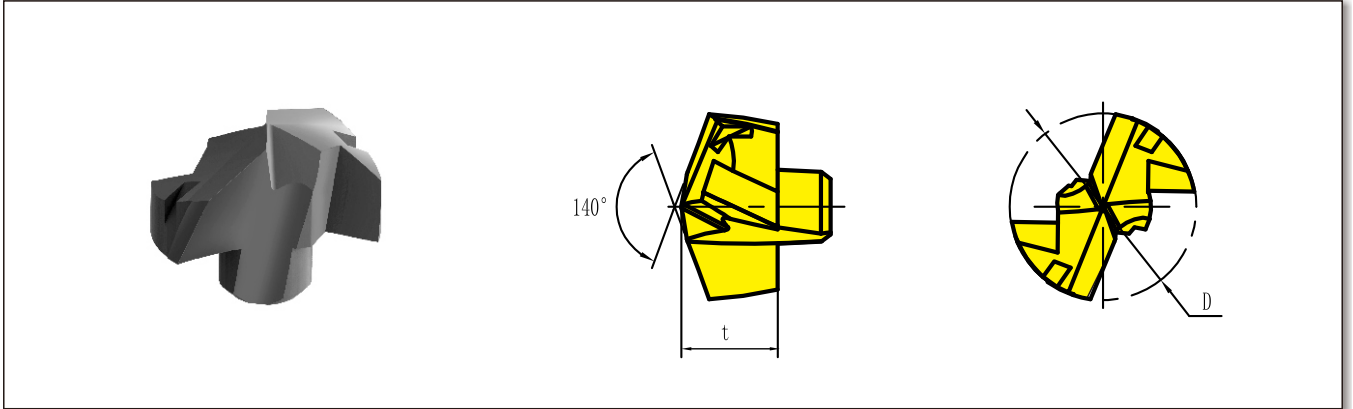
## QD...S 标准钻头 Standard Cutting Head







订货号 Order No.	尺寸 Dimensions(mm)		刀体 tool holders
	D	t	
			
QD-080-S	8.0	5.4	QD080-089-12-..D-..
QD-081-S	8.1	5.4	
QD-082-S	8.2	5.4	
QD-083-S	8.3	5.4	
QD-084-S	8.4	5.4	
QD-085-S	8.5	5.4	
QD-086-S	8.6	5.4	
QD-087-S	8.7	5.4	
QD-088-S	8.8	5.4	
QD-089-S	8.9	5.4	
QD-090-S	9.0	5.8	QD090-099-12-..D-..
QD-091-S	9.1	5.8	
QD-092-S	9.2	5.8	
QD-093-S	9.3	5.8	
QD-094-S	9.4	5.8	
QD-095-S	9.5	5.8	
QD-096-S	9.6	5.8	
QD-097-S	9.7	5.8	
QD-098-S	9.8	5.8	
QD-099-S	9.9	5.8	
QD-100-S	10.0	6.2	QD100-109-16-..D-..
QD-101-S	10.1	6.2	
QD-102-S	10.2	6.2	
QD-103-S	10.3	6.2	
QD-104-S	10.4	6.2	
QD-105-S	10.5	6.2	
QD-106-S	10.6	6.2	
QD-107-S	10.7	6.2	
QD-108-S	10.8	6.2	
QD-109-S	10.9	6.2	

订货号 Order No.	尺寸 Dimensions(mm)		刀体 tool holders
	D	t	
			
QD-110-S	11.0	6.6	QD110-119-16-..D-..
QD-111-S	11.1	6.6	
QD-112-S	11.2	6.6	
QD-113-S	11.3	6.6	
QD-114-S	11.4	6.6	
QD-115-S	11.5	6.6	
QD-116-S	11.6	6.6	
QD-117-S	11.7	6.6	
QD-118-S	11.8	6.6	
QD-119-S	11.9	6.6	
QD-120-S	12.0	7.0	QD120-129-16-..D-..
QD-121-S	12.1	7.0	
QD-122-S	12.2	7.0	
QD-123-S	12.3	7.0	
QD-124-S	12.4	7.0	
QD-125-S	12.5	7.0	
QD-126-S	12.6	7.0	
QD-127-S	12.7	7.0	
QD-128-S	12.8	7.0	
QD-129-S	12.9	7.0	
QD-130-S	13.0	7.6	QD130-139-16-..D-..
QD-131-S	13.1	7.6	
QD-132-S	13.2	7.6	
QD-133-S	13.3	7.6	
QD-134-S	13.4	7.6	
QD-135-S	13.5	7.6	
QD-136-S	13.6	7.6	
QD-137-S	13.7	7.6	
QD-138-S	13.8	7.6	
QD-139-S	13.9	7.6	

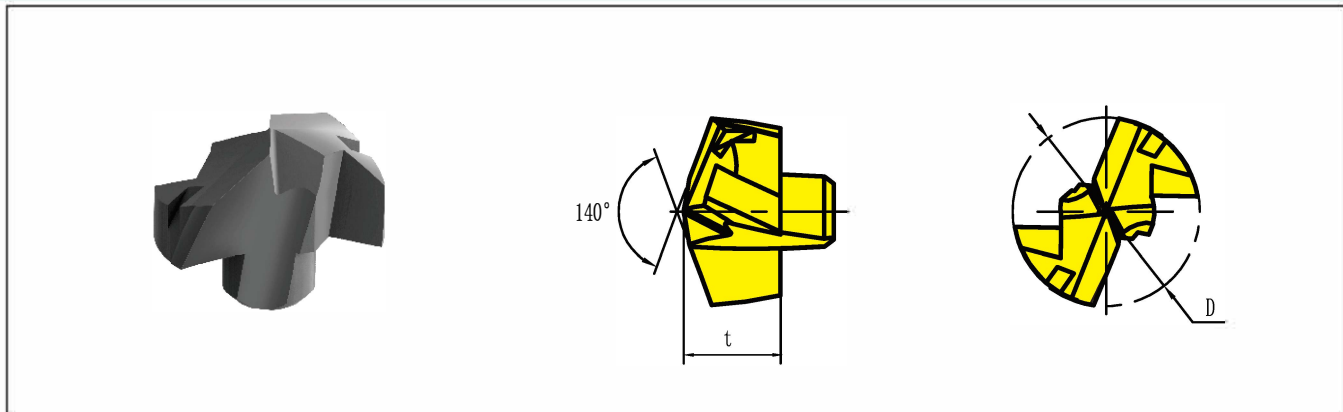
## QD...S 标准钻头 Standard Cutting Head







订货号 Order No.	尺寸 Dimensions(mm)		刀体 tool holders
	D	t	
			
QD-140-S	14.0	8.1	QD140-149-16-..D-..
QD-141-S	14.1	8.1	
QD-142-S	14.2	8.1	
QD-143-S	14.3	8.1	
QD-144-S	14.4	8.1	
QD-145-S	14.5	8.1	
QD-146-S	14.6	8.1	
QD-147-S	14.7	8.1	
QD-148-S	14.8	8.1	
QD-149-S	14.9	8.1	
QD-150-S	15.0	8.7	QD150-159-20-..D-..
QD-151-S	15.1	8.7	
QD-152-S	15.2	8.7	
QD-153-S	15.3	8.7	
QD-154-S	15.4	8.7	
QD-155-S	15.5	8.7	
QD-156-S	15.6	8.7	
QD-157-S	15.7	8.7	
QD-158-S	15.8	8.7	
QD-159-S	15.9	8.7	
QD-160-S	16.0	9.3	QD160-169-20-..D-..
QD-161-S	16.1	9.3	
QD-162-S	16.2	9.3	
QD-163-S	16.3	9.3	
QD-164-S	16.4	9.3	
QD-165-S	16.5	9.3	
QD-166-S	16.6	9.3	
QD-167-S	16.7	9.3	
QD-168-S	16.8	9.3	
QD-169-S	16.9	9.3	

订货号 Order No.	尺寸 Dimensions(mm)		刀体 tool holders
	D	t	
			
QD-170-S	17.0	9.9	QD170-179-20-..D-..
QD-171-S	17.1	9.9	
QD-172-S	17.2	9.9	
QD-173-S	17.3	9.9	
QD-174-S	17.4	9.9	
QD-175-S	17.5	9.9	
QD-176-S	17.6	9.9	
QD-177-S	17.7	9.9	
QD-178-S	17.8	9.9	
QD-179-S	17.9	9.9	
QD-180-S	18.0	10.5	QD180-189-25-..D-..
QD-181-S	18.1	10.5	
QD-182-S	18.2	10.5	
QD-183-S	18.3	10.5	
QD-184-S	18.4	10.5	
QD-185-S	18.5	10.5	
QD-186-S	18.6	10.5	
QD-187-S	18.7	10.5	
QD-188-S	18.8	10.5	
QD-189-S	18.9	10.5	
QD-190-S	19.0	11.0	QD190-199-25-..D-..
QD-191-S	19.1	11.0	
QD-192-S	19.2	11.0	
QD-193-S	19.3	11.0	
QD-194-S	19.4	11.0	
QD-195-S	19.5	11.0	
QD-196-S	19.6	11.0	
QD-197-S	19.7	11.0	
QD-198-S	19.8	11.0	
QD-199-S	19.9	11.0	

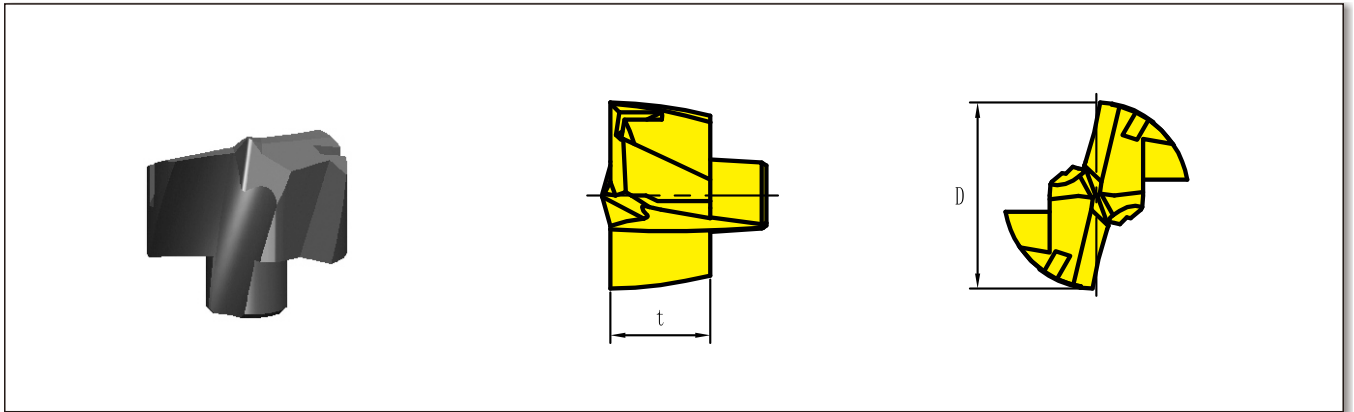
## QD...S 标准钻头 Standard Cutting Head





订货号 Order No.	尺寸 Dimensions(mm)		刀体 tool holders
	D	t	
			
QD-200-S	20.0	11.6	QD200-209-25-..D-..
QD-201-S	20.1	11.6	
QD-202-S	20.2	11.6	
QD-203-S	20.3	11.6	
QD-204-S	20.4	11.6	
QD-205-S	20.5	11.6	
QD-206-S	20.6	11.6	
QD-207-S	20.7	11.6	
QD-208-S	20.8	11.6	
QD-209-S	20.9	11.6	
QD-210-S	21.0	12.1	QD210-219-25-..D-..
QD-211-S	21.1	12.1	
QD-212-S	21.2	12.1	
QD-213-S	21.3	12.1	
QD-214-S	21.4	12.1	
QD-215-S	21.5	12.1	
QD-216-S	21.6	12.1	
QD-217-S	21.7	12.1	
QD-218-S	21.8	12.1	
QD-219-S	21.9	12.1	
QD-220-S	22.0	12.7	QD220-229-25-..D-..
QD-221-S	22.1	12.7	
QD-222-S	22.2	12.7	
QD-223-S	22.3	12.7	
QD-224-S	22.4	12.7	
QD-225-S	22.5	12.7	
QD-226-S	22.6	12.7	
QD-227-S	22.7	12.7	
QD-228-S	22.8	12.7	
QD-229-S	22.9	12.7	

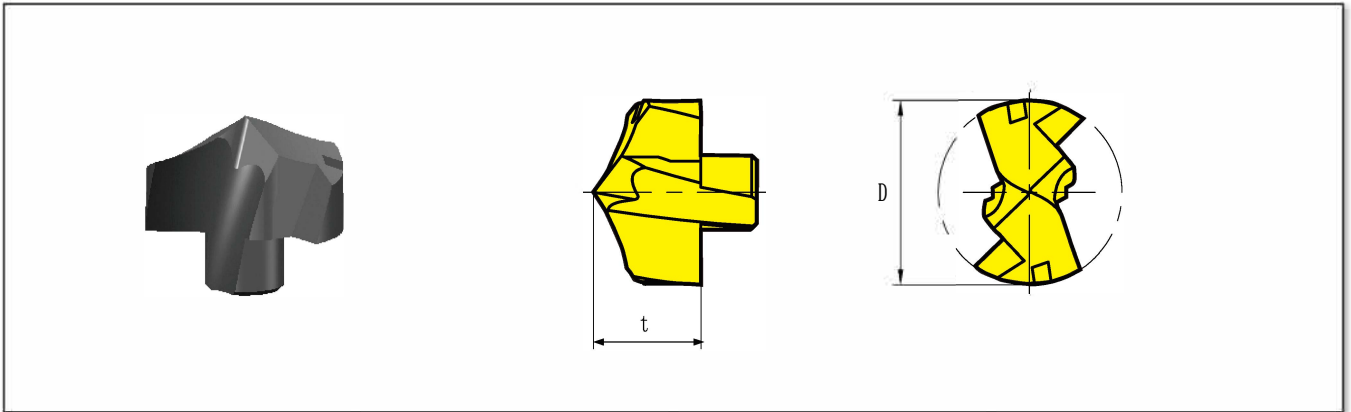
订货号 Order No.	尺寸 Dimensions(mm)		刀体 tool holders
	D	t	
			
QD-230-S	23.0	13.3	QD230-239-32-..D-..
QD-231-S	23.1	13.3	
QD-232-S	23.2	13.3	
QD-233-S	23.3	13.3	
QD-234-S	23.4	13.3	
QD-235-S	23.5	13.3	
QD-236-S	23.6	13.3	
QD-237-S	23.7	13.3	
QD-238-S	23.8	13.3	
QD-239-S	23.9	13.3	
QD-240-S	24.0	13.9	QD240-249-32-..D-..
QD-241-S	24.1	13.9	
QD-242-S	24.2	13.9	
QD-243-S	24.3	13.9	
QD-244-S	24.4	13.9	
QD-245-S	24.5	13.9	
QD-246-S	24.6	13.9	
QD-247-S	24.7	13.9	
QD-248-S	24.8	13.9	
QD-249-S	24.9	13.9	
QD-250-S	25.0	14.5	QD250-260-32-..D-..
QD-251-S	25.1	14.5	
QD-252-S	25.2	14.5	
QD-253-S	25.3	14.5	
QD-254-S	25.4	14.5	
QD-255-S	25.5	14.5	
QD-256-S	25.6	14.5	
QD-257-S	25.7	14.5	
QD-258-S	25.8	14.5	
QD-259-S	25.9	14.5	



## QD...F 平底刀头 Flat Cutting Head



订货号 Order No.	尺寸 Dimensions(mm)		刀体 tool holders
	D	t	
QD-080-F	8.0	4.0	QD080-089-12-..D-..
QD-085-F	8.5	4.0	
QD-090-F	9.0	4.2	QD090-099-12-..D-..
QD-095-F	9.5	4.2	
QD-100-F	10.0	4.4	QD100-109-16-..D-..
QD-105-F	10.5	4.4	
QD-110-F	11.0	4.5	QD110-119-16-..D-..
QD-115-F	11.5	4.5	
QD-120-F	12.0	4.8	QD120-129-16-..D-..
QD-125-F	12.5	4.8	
QD-130-F	13.0	5.1	QD130-139-16-..D-..
QD-135-F	13.5	5.1	
QD-140-F	14.0	5.5	QD140-149-16-..D-..
QD-145-F	14.5	5.5	
QD-150-F	15.0	5.9	QD150-159-20-..D-..
QD-155-F	15.5	5.9	
QD-160-F	16.0	6.3	QD160-169-20-..D-..
QD-165-F	16.5	6.3	
QD-170-F	17.0	6.6	QD170-179-20-..D-..
QD-175-F	17.5	6.6	
QD-180-F	18.0	6.9	QD180-189-25-..D-..
QD-185-F	18.5	6.9	
QD-190-F	19.0	7.2	QD190-199-25-..D-..
QD-195-F	19.5	7.2	
QD-200-F	20.0	8.2	QD200-209-25-..D-..
QD-205-F	20.5	8.2	
QD-210-F	21.0	8.6	QD210-219-25-..D-..
QD-215-F	21.5	8.6	
QD-220-F	22.0	8.9	QD220-229-25-..D-..
QD-225-F	22.5	8.9	
QD-230-F	23.0	9.3	QD230-239-32-..D-..
QD-235-F	23.5	9.3	
QD-240-F	24.0	9.7	QD240-249-32-..D-..
QD-245-F	24.5	9.7	
QD-250-F	25.0	10.1	QD250-260-32-..D-..
QD-255-F	25.5	10.1	
QD-260-F	26.0	10.1	

## QD...C 定心刀头 Centering Cutting Head



订货号 Order No.	尺寸 Dimensions(mm)		刀体 tool holders
	D	t	
			
QD-080-C	8.0	5.4	QD080-089-12-..D-..
QD-085-C	8.5	5.4	
QD-090-C	9.0	5.8	QD090-099-12-..D-..
QD-095-C	9.5	5.8	
QD-100-C	10.0	6.2	QD100-109-16-..D-..
QD-105-C	10.5	6.2	
QD-110-C	11.0	6.6	QD110-119-16-..D-..
QD-115-C	11.5	6.6	
QD-120-C	12.0	7.0	QD120-129-16-..D-..
QD-125-C	12.5	7.0	
QD-130-C	13.0	7.6	QD130-139-16-..D-..
QD-135-C	13.5	7.6	
QD-140-C	14.0	8.2	QD140-149-16-..D-..
QD-145-C	14.5	8.2	
QD-150-C	15.0	8.7	QD150-159-20-..D-..
QD-155-C	15.5	8.7	
QD-160-C	16.0	9.3	QD160-169-20-..D-..
QD-165-C	16.5	9.3	
QD-170-C	17.0	9.9	QD170-179-20-..D-..
QD-175-C	17.5	9.9	
QD-180-C	18.0	10.5	QD180-189-25-..D-..
QD-185-C	18.5	10.5	
QD-190-C	19.0	11.0	QD190-199-25-..D-..
QD-195-C	19.5	11.0	
QD-200-C	20.0	11.6	QD200-209-25-..D-..
QD-205-C	20.5	11.6	
QD-210-C	21.0	12.2	QD210-219-25-..D-..
QD-215-C	21.5	12.2	
QD-220-C	22.0	12.8	QD220-229-25-..D-..
QD-225-C	22.5	12.8	
QD-230-C	23.0	13.3	QD230-239-32-..D-..
QD-235-C	23.5	13.3	
QD-240-C	24.0	13.9	QD240-249-32-..D-..
QD-245-C	24.5	13.9	
QD-250-C	25.0	14.5	QD250-260-32-..D-..
QD-255-C	25.5	14.5	
QD-260-C	26.0	14.5	

# 自锁式可换头钻头刀体编码系统 “QuickDrill” Toolholder Ordering Code System

C—有内冷却孔 With coolant

N—无内冷却孔 Without coolant

**QD**

**1**

**2**

**0**

**- 1**

**2**

**9**

**- 1**

**6**

**- 3D**

**- C**

快 钻  
QuickDrill

可适用最小  
刀头直径  
Applicable min  
cutting head  
Dia.(mm)  
12.0mm

可适用最大  
刀头直径  
Applicable max  
cutting head  
Dia.(mm)  
12.9mm

柄 径  
Shank  
Dia(mm)  
16.0mm

1.5D—1.5倍直径  
Drill depth  $1.5 \times D$

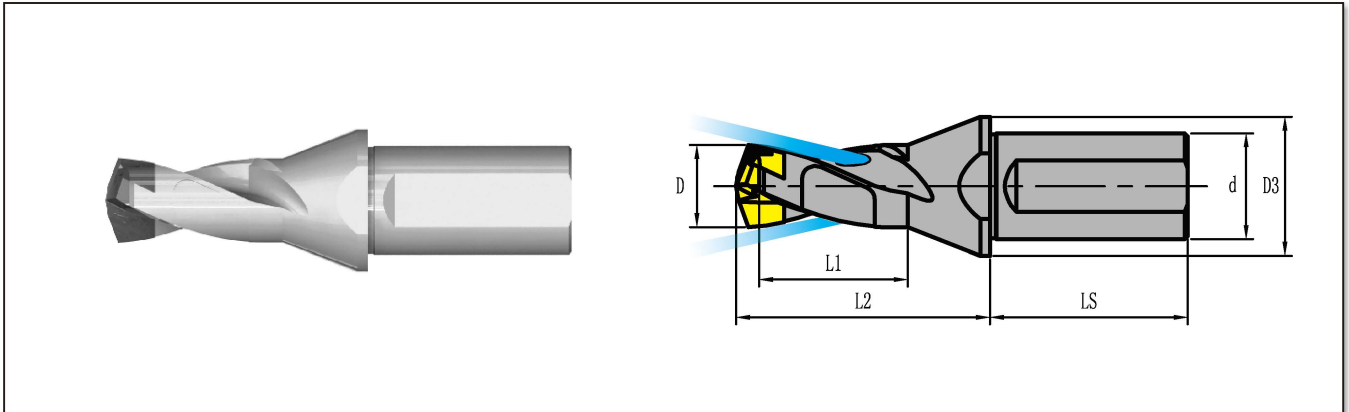
3D—3倍直径  
Drill depth  $3 \times D$

5D—5倍直径  
Drill depth  $5 \times D$

8D—8倍直径  
Drill depth  $8 \times D$

12D—12倍直径  
Drill depth  $12 \times D$

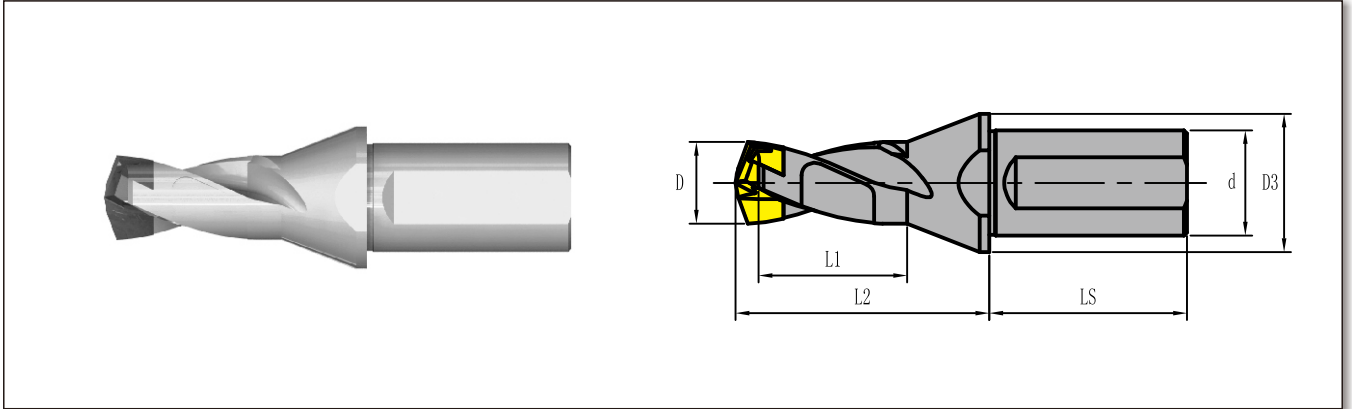
## QD...-1.5D-C 带内冷却水孔快钻刀体 “QuickDrill” Toolholders with Coolant



订货号 Order No.	刀头直径范围 Applicable cutting head Dia.(mm)	尺寸 Dimensions(mm)						锁紧钥匙 Wrench
		d	D3	L1	L2	Ls	D	
QD080-089-12-1.5D-C	8.0~8.9	12	16	12	27.9	45	8	8-12
QD090-099-12-1.5D-C	9.0~9.9	12	16	14	29.3	45	9	
QD100-109-16-1.5D-C	10.0~10.9	16	20	15	31.2	48	10	
QD110-119-16-1.5D-C	11.0~11.9	16	20	17	33.1	48	11	
QD120-129-16-1.5D-C	12.0~12.9	16	20	18	35.0	48	12	12-17
QD130-139-16-1.5D-C	13.0~13.9	16	20	20	37.1	48	13	
QD140-149-16-1.5D-C	14.0~14.9	16	20	21	41.1	48	14	
QD150-159-20-1.5D-C	15.0~15.9	20	25	23	46.2	50	15	
QD160-169-20-1.5D-C	16.0~16.9	20	25	24	49.3	50	16	17-21
QD170-179-20-1.5D-C	17.0~17.9	20	25	26	52.4	50	17	
QD180-189-25-1.5D-C	18.0~18.9	25	32	27	55.5	56	18	
QD190-199-25-1.5D-C	19.0~19.9	25	32	29	58.5	56	19	
QD200-209-25-1.5D-C	20.0~20.9	25	32	30	61.6	56	20	21-26
QD210-219-25-1.5D-C	21.0~21.9	25	32	32	64.7	56	21	
QD220-229-25-1.5D-C	22.0~22.9	25	32	32	67.8	56	21	
QD230-239-32-1.5D-C	23.0~23.9	32	42	35	70.9	60	23	
QD240-249-32-1.5D-C	24.0~24.9	32	42	36	74.0	60	24	
QD250-260-32-1.5D-C	25.0~26.0	32	42	38	77.0	60	25	

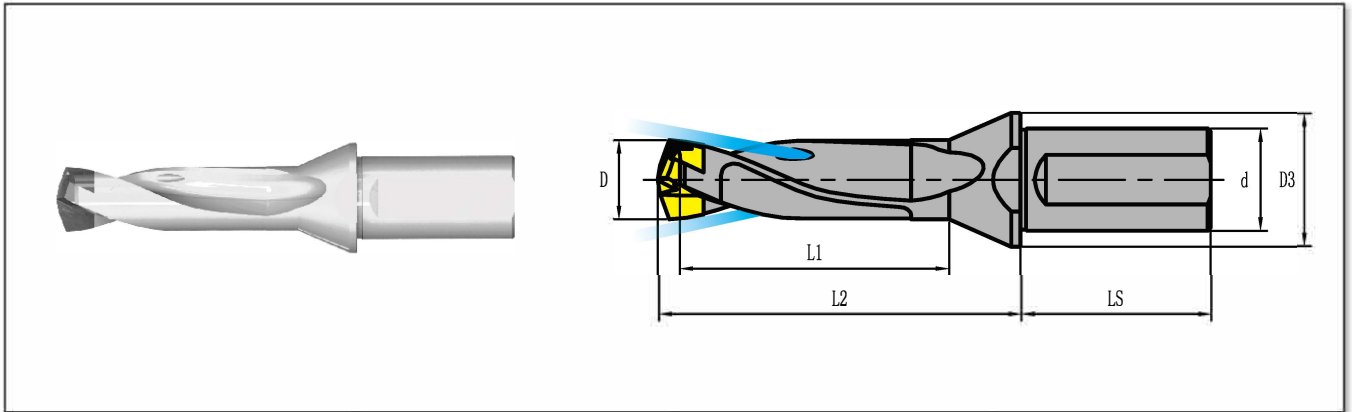


QD...-1.5D-N 无内冷却水孔快钻刀体 “QuickDrill” Toolholders without Coolant



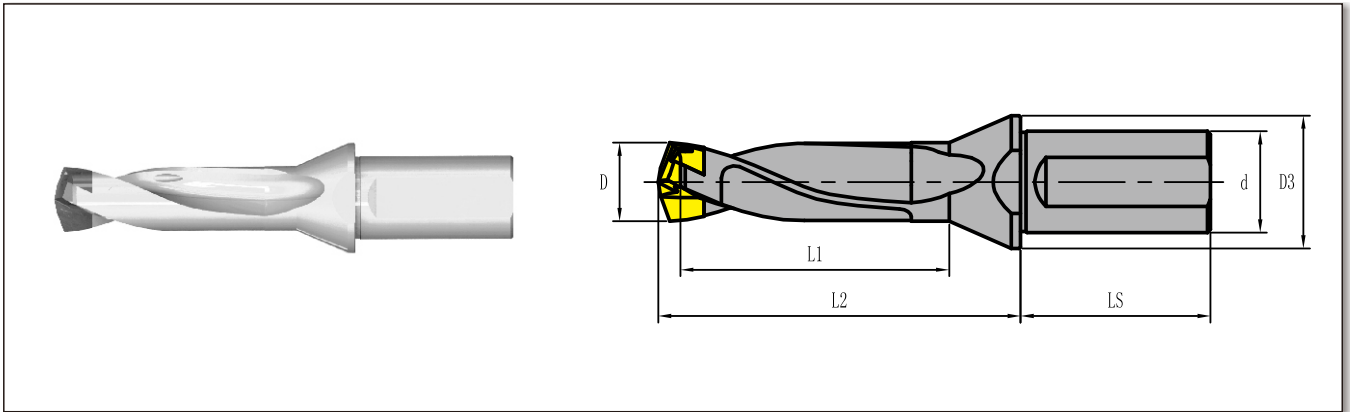
订货号 Order No.	刀头直径范围 Applicable cutting head Dia.(mm)	尺寸 Dimensions(mm)						锁紧钥匙 Wrench
		d	D3	L1	L2	Ls	D	
QD080-089-12-1.5D-N	8.0~8.9	12	16	12	27.9	45	8	8-12
QD090-099-12-1.5D-N	9.0~9.9	12	16	14	29.3	45	9	
QD100-109-16-1.5D-N	10.0~10.9	16	20	15	31.2	48	10	
QD110-119-16-1.5D-N	11.0~11.9	16	20	17	33.1	48	11	
QD120-129-16-1.5D-N	12.0~12.9	16	20	18	35.0	48	12	12-17
QD130-139-16-1.5D-N	13.0~13.9	16	20	20	37.1	48	13	
QD140-149-16-1.5D-N	14.0~14.9	16	20	21	41.1	48	14	
QD150-159-20-1.5D-N	15.0~15.9	20	25	23	46.2	50	15	
QD160-169-20-1.5D-N	16.0~16.9	20	25	24	49.3	50	16	17-21
QD170-179-20-1.5D-N	17.0~17.9	20	25	26	52.4	50	17	
QD180-189-25-1.5D-N	18.0~18.9	25	32	27	55.5	56	18	
QD190-199-25-1.5D-N	19.0~19.9	25	32	29	58.5	56	19	
QD200-209-25-1.5D-N	20.0~20.9	25	32	30	61.6	56	20	21-26
QD210-219-25-1.5D-N	21.0~21.9	25	32	32	64.7	56	21	
QD220-229-25-1.5D-N	22.0~22.9	25	32	33	67.8	56	22	
QD230-239-32-1.5D-N	23.0~23.9	32	42	35	70.9	60	23	
QD240-249-32-1.5D-N	24.0~24.9	32	42	36	74.0	60	24	21-26
QD250-260-32-1.5D-N	25.0~26.0	32	42	38	77.0	60	25	

## QD...-3D-C 带内冷却水孔快钻刀体 “QuickDrill” Toolholders with Coolant



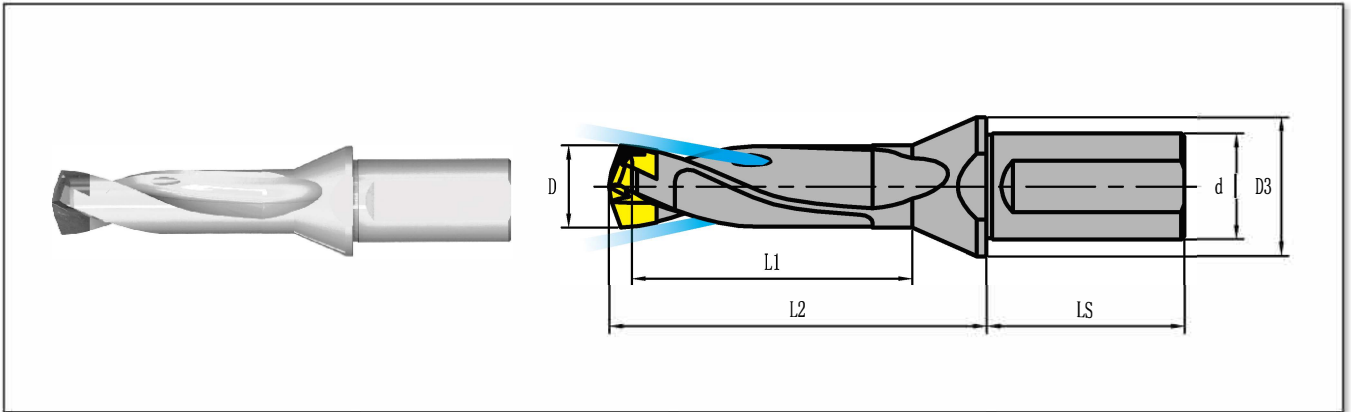
订货号 Order No.	刀头直径范围 Applicable cutting head Dia.(mm)	尺寸 Dimensions(mm)						锁紧钥匙 Wrench
		d	D3	L1	L2	Ls	D	
QD080-084-12-3D-C	8.0~8.4	12	16	24	39.4	45	8	8-12
QD085-089-12-3D-C	8.5~8.9	12	16	26	40.9	45	8	
QD090-094-12-3D-C	9.0~9.4	12	16	27	42.8	45	9	
QD095-099-12-3D-C	9.5~9.9	12	16	29	44.3	45	9	
QD100-104-16-3D-C	10.0~10.4	16	20	30	46.2	48	10	
QD105-109-16-3D-C	10.5~10.9	16	20	32	47.7	48	10	
QD110-114-16-3D-C	11.0~11.4	16	20	33	49.6	48	11	
QD115-119-16-3D-C	11.5~11.9	16	20	35	51.1	48	11	
QD120-124-16-3D-C	12.0~12.4	16	20	36	53.0	48	12	12-17
QD125-129-16-3D-C	12.5~12.9	16	20	37	54.5	48	12	
QD130-134-16-3D-C	13.0~13.4	16	20	39	56.6	48	13	
QD135-139-16-3D-C	13.5~13.9	16	20	41	58.1	48	13	
QD140-144-16-3D-C	14.0~14.4	16	20	42	62.1	48	14	
QD145-149-16-3D-C	14.5~14.9	16	20	44	63.6	48	14	
QD150-159-20-3D-C	15.0~15.9	20	25	45	68.7	50	15	17-21
QD160-169-20-3D-C	16.0~16.9	20	25	48	73.3	50	16	
QD170-179-20-3D-C	17.0~17.9	20	25	51	77.9	50	17	
QD180-189-25-3D-C	18.0~18.9	25	32	54	82.5	56	18	
QD190-199-25-3D-C	19.0~19.9	25	32	57	87.0	56	19	21-26
QD200-209-25-3D-C	20.0~20.9	25	32	60	91.6	56	20	
QD210-219-25-3D-C	21.0~21.9	25	32	63	96.2	56	21	
QD220-229-25-3DvC	22.0~22.9	25	32	66	100.8	56	22	
QD230-239-32-3D-C	23.0~23.9	32	42	69	105.4	60	23	
QD240-249-32-3D-C	24.0~24.9	32	42	72	109.9	60	24	
QD250-260-32-3D-C	25.0~26.0	32	42	75	114.5	60	25	

## QD...-3D-N 无内冷却水孔快钻刀体 “QuickDrill” Toolholders without Coolant



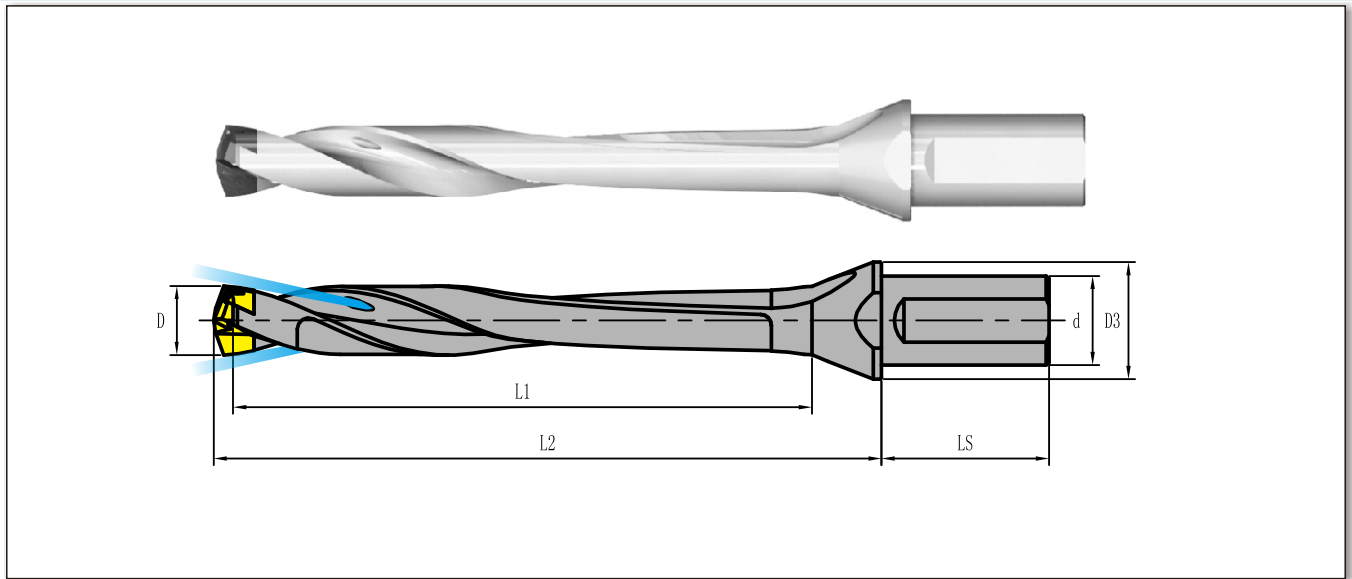
订货号 Order No.	刀头直径范围 Applicable cutting head Dia.(mm)	尺寸 Dimensions(mm)						锁紧钥匙 Wrench
		d	D3	L1	L2	Ls	D	
QD080-084-12-3D-N	8.0~8.4	12	16	24	39.4	45	8	8-12
QD085-089-12-3D-N	8.5~8.9	12	16	26	40.9	45	8	
QD090-094-12-3D-N	9.0~9.4	12	16	27	42.8	45	9	
QD095-099-12-3D-N	9.5~9.9	12	16	29	44.3	45	9	
QD100-104-16-3D-N	10.0~10.4	16	20	30	46.2	48	10	
QD105-109-16-3D-N	10.5~10.9	16	20	32	47.7	48	10	
QD110-114-16-3D-N	11.0~11.4	16	20	33	49.6	48	11	
QD115-119-16-3D-N	11.5~11.9	16	20	35	51.1	48	11	
QD120-124-16-3D-N	12.0~12.4	16	20	36	53.0	48	12	12-17
QD125-129-16-3D-N	12.5~12.9	16	20	37	54.5	48	12	
QD130-134-16-3D-N	13.0~13.4	16	20	39	56.6	48	13	
QD135-139-16-3D-N	13.5~13.9	16	20	41	58.1	48	13	
QD140-144-16-3D-N	14.0~14.4	16	20	42	62.1	48	14	
QD145-149-16-3D-N	14.5~14.9	16	20	44	63.6	48	14	
QD150-159-20-3D-N	15.0~15.9	20	25	45	68.7	50	15	17-21
QD160-169-20-3D-N	16.0~16.9	20	25	48	73.3	50	16	
QD170-179-20-3D-N	17.0~17.9	20	25	51	77.9	50	17	
QD180-189-25-3D-N	18.0~18.9	25	32	54	82.5	56	18	
QD190-199-25-3D-N	19.0~19.9	25	32	57	87.0	56	19	
QD200-209-25-3D-N	20.0~20.9	25	32	60	91.6	56	20	
QD210-219-25-3D-N	21.0~21.9	25	32	63	96.2	56	21	21-26
QD220-229-25-3D-N	22.0~22.9	25	32	66	100.8	56	22	
QD230-239-32-3D-N	23.0~23.9	32	42	69	105.4	60	23	
QD240-249-32-3D-N	24.0~24.9	32	42	72	109.9	60	24	
QD250-260-32-3D-N	25.0~26.0	32	42	75	114.5	60	25	

QD...-5D-C 带内冷却水孔快钻刀体 “QuickDrill” Toolholders with Coolant



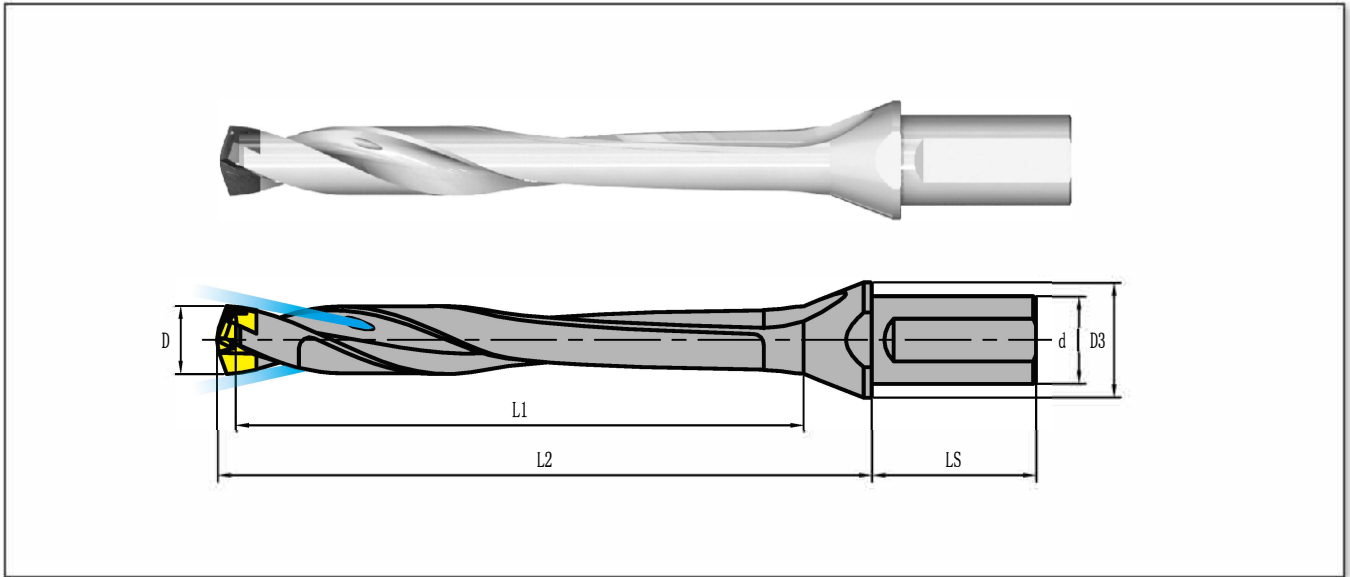
订货号 Order No.	刀头直径范围 Applicable cutting head Dia.(mm)	尺寸 Dimensions(mm)						锁紧钥匙 Wrench
		d	D3	L1	L2	Ls	D	
QD080-084-12-5D-C	8.0~8.4	12	16	40	55.4	45	8	8-12
QD085-089-12-5D-C	8.5~8.9	12	16	43	57.9	45	8	
QD090-094-12-5D-C	9.0~9.4	12	16	45	60.8	45	9	
QD095-099-12-5D-C	9.5~9.9	12	16	48	63.3	45	9	
QD100-104-16-5D-C	10.0~10.4	16	20	50	66.2	48	10	
QD105-109-16-5D-C	10.5~10.9	16	20	53	68.7	48	10	
QD110-114-16-5D-C	11.0~11.4	16	20	55	71.6	48	11	
QD115-119-16-5D-C	11.5~11.9	16	20	58	74.1	48	11	
QD120-124-16-5D-C	12.0~12.4	16	20	60	77.0	48	12	12-17
QD125-129-16-5D-C	12.5~12.9	16	20	62	79.5	48	12	
QD130-134-16-5D-C	13.0~13.4	16	20	65	82.6	48	13	
QD135-139-16-5D-C	13.5~13.9	16	20	68	85.1	48	13	
QD140-144-16-5D-C	14.0~14.4	16	20	70	90.2	48	14	
QD145-149-16-5D-C	14.5~14.9	16	20	73	92.7	48	14	
QD150-159-20-5D-C	15.0~15.9	20	25	75	98.7	50	15	17-21
QD160-169-20-5D-C	16.0~16.9	20	25	80	105.3	50	16	
QD170-179-20-5D-C	17.0~17.9	20	25	85	111.9	50	17	
QD180-189-25-5D-C	18.0~18.9	25	32	90	118.5	56	18	
QD190-199-25-5D-C	19.0~19.9	25	32	95	125.0	56	19	
QD200-209-25-5D-C	20.0~20.9	25	32	100	131.6	56	20	
QD210-219-25-5D-C	21.0~21.9	25	32	105	138.2	56	21	21-26
QD220-229-25-5D-C	22.0~22.9	25	32	110	144.8	56	22	
QD230-239-32-5D-C	23.0~23.9	32	42	115	151.4	60	23	
QD240-249-32-5D-C	24.0~24.9	32	42	120	158.0	60	24	
QD250-260-32-5D-C	25.0~26.0	32	42	125	164.5	60	25	

## QD...-8D-C 带内冷却水孔快钻刀体 “QuickDrill” Toolholders with Coolant



订货号 Order No.	刀头直径范围 Applicable cutting head Dia.(mm)	尺寸 Dimensions(mm)						锁紧钥匙 Wrench
		d	D3	L1	L2	Ls	D	
QD080-084-12-8D-C	8.0~8.4	12	16	64	79.4	45	8	8-12
QD085-089-12-8D-C	8.5~8.9	12	16	68	84.4	45	8	
QD090-094-12-8D-C	9.0~9.4	12	16	72	87.8	45	9	
QD095-099-12-8D-C	9.5~9.9	12	16	76	92.7	45	9	
QD100-104-16-8D-C	10.0~10.4	16	20	80	96.2	48	10	
QD105-109-16-8D-C	10.5~10.9	16	20	84	100.2	48	10	
QD110-114-16-8D-C	11.0~11.4	16	20	88	104.6	48	11	
QD115-119-16-8D-C	11.5~11.9	16	20	92	108.6	48	11	
QD120-124-16-8D-C	12.0~12.4	16	20	96	113.0	48	12	12-17
QD125-129-16-8D-C	12.5~12.9	16	20	100	117.0	48	12	
QD130-134-16-8D-C	13.0~13.4	16	20	104	121.6	48	13	
QD135-139-16-8D-C	13.5~13.9	16	20	108	125.5	48	13	
QD140-144-16-8D-C	14.0~14.4	16	20	112	132.1	48	14	
QD145-149-16-8D-C	14.5~14.9	16	20	116	136.2	48	14	
QD150-159-20-8D-C	15.0~15.9	20	25	120	143.7	50	15	
QD160-169-20-8D-C	16.0~16.9	20	25	128	153.3	50	16	
QD170-179-20-8D-C	17.0~17.9	20	25	136	162.9	50	17	17-21
QD180-189-25-8D-C	18.0~18.9	25	32	144	172.5	56	18	
QD190-199-25-8D-C	19.0~19.9	25	32	152	182.0	56	19	
QD200-209-25-8D-C	20.0~20.9	25	32	160	191.6	56	20	
QD210-219-25-8D-C	21.0~21.9	25	32	168	201.2	56	21	21-26
QD220-229-25-8D-C	22.0~22.9	25	32	176	210.8	56	22	
QD230-239-32-8D-C	23.0~23.9	32	42	184	220.4	60	23	
QD240-249-32-8D-C	24.0~24.9	32	42	192	230.0	60	24	
QD250-260-32-8D-C	25.0~26.0	32	42	200	239.5	60	25	

QD...-12D-C 带内冷却水孔快钻刀体 “QuickDrill” Toolholders without Coolant



订货号 Order No.	刀头直径范围 Applicable cutting head Dia.(mm)	尺寸 Dimensions(mm)						锁紧钥匙 Wrench
		d	D3	L1	L2	Ls	D	
QD120-124-16-12D-C	12.0~12.4	16	20	144	161	48	12	12-17
QD125-129-16-12D-C	12.5~12.9	16	20	150	167	48	12	
QD130-134-16-12D-C	13.0~13.4	16	20	156	173	48	13	
QD135-139-16-12D-C	13.5~13.9	16	20	162	179	48	13	
QD140-144-16-12D-C	14.0~14.4	16	20	168	188	48	14	
QD145-149-16-12D-C	14.5~14.9	16	20	174	194	48	14	
QD150-159-20-12D-C	15.0~15.9	20	25	180	210	50	15	
QD160-169-20-12D-C	16.0~16.9	20	25	192	224	50	16	17-21
QD170-179-20-12D-C	17.0~17.9	20	25	204	238	50	17	
QD180-189-25-12D-C	18.0~18.9	25	32	216	252	56	18	
QD190-199-25-12D-C	19.0~19.9	25	32	228	266	56	19	
QD200-209-25-12D-C	20.0~20.9	25	32	240	280	56	20	21-26
QD210-219-25-12D-C	21.0~21.9	25	32	252	294	56	21	
QD220-230-25-12D-C	22.0~23.0	25	32	264	308	56	22	

## 推荐的切削参数 Technical Information

ISO	被加工材料 materials	条件 heat treatment	拉伸力 (N/mm <sup>2</sup> ) drawing force	布氏硬度 (HB) hardness	切削速度 Vc(m/min) cutting speed	进给 (mm/rev) Feed rate(mm/rev)					
						D<10	D=10~11.9	D=12~13.9	D=14~15.9	D=16~19.9	D=20~25.9
P	非合金钢 un alloy steel	<0.25% C 退火 annealed	420	125	80~140						
		>=0.25% C 退火 annealed	650	190	80~130	0.12	0.15	0.18	0.20	0.25	0.25
	铸铁 cast iron	<0.55% C 退火和调质 annealing and tempering	850	250	80~120	0.17	0.21	0.24	0.27	0.35	0.35
		>=0.55% C 退火 annealed	750	220	70~110	0.22	0.28	0.30	0.35	0.45	0.45
	易切削钢 free cutting steel	退火和调质 annealing and tempering	1000	300	50~90						
		退火 annealed	600	200	70~120	0.12	0.14	0.16	0.18	0.23	0.25
	低碳合金钢, low carbon steel	退火和调质 annealing and tempering	930	275	70~110	0.18	0.21	0.24	0.26	0.31	0.35
		铸钢(合金成分 低于5%) cast iron(alloy composition<5%)	1000	300	50~90	0.25	0.28	0.32	0.35	0.40	0.45
	高合金钢,铸钢 high alloy steel,cast iron	退火 annealed	680	200	50~90	0.12	0.12	0.15	0.18	0.20	0.22
		退火和调质 annealing and tempering	1100	325	40~80	0.16	0.17	0.20	0.23	0.25	0.27
M	不锈钢,铸钢 stainless steel cast iron	铁素体/马氏体 ferritic/martensite	680	200	40~70	0.20	0.22	0.25	0.28	0.30	0.33
		马氏体 martensite	820	240	40~70	0.10	0.12	0.14	0.16	0.16	0.18
		奥氏体 austenitic	600	180	30~70	0.12	0.15	0.17	0.20	0.21	0.24
K	灰铸铁(GG) gray cast iron	铁素体 ferritic		160	90~160						
		珠光体 pearlitic		250	80~140	0.15	0.18	0.20	0.24	0.26	0.30
	球墨铸铁(GGG) nodular SG iron	铁素体 ferritic		180	90~180	0.15	0.20	0.25	0.30	0.35	0.35
		珠光体 pearlitic		260	80~140	0.22	0.27	0.32	0.37	0.45	0.37
	可锻铸铁 malleable cast iron	铁素体 ferritic		130	90~160	0.30	0.35	0.40	0.45	0.55	0.60
珠光体 pearlitic			230	80~140							
N	锻铝合金 cast aluminium alloy	未固化 unsolidification		60	90~220						
		固化 solidification		100	90~220						
	铸铝合金 cast aluminium alloy	<=12% Si 未固化 unsolidification		75	90~220	0.20	0.25	0.30	0.35	0.40	0.45
		固化 solidification		90	90~220	0.27	0.32	0.37	0.42	0.50	0.57
	铜合金 copper alloy	>12% Si 高温处理 high temperature treatment		130	80~160	0.35	0.40	0.45	0.50	0.60	0.70
		>1% Pb 易切 free cutting		110	90~220						
	非铁金属 non-metallic material	黄铜 copper		90	90~220						
		电解铜 cathode copper		100	90~220						
S	高温合金 high temperature alloys	退火 annealed			30~60	0.06	0.08	0.10	0.12	0.12	0.14
		铁基 iron-base 固化 solidification		200	20~50	0.08	0.10	0.12	0.15	0.16	0.18
		镍基或 inckelbase 退火 annealed		280	20~50	0.11	0.13	0.15	0.18	0.20	0.22
		固化 solidification		250	20~50	0.06	0.08	0.10	0.12	0.14	0.16
		钴基 cobolt base Cast		350	20~50	0.09	0.11	0.14	0.16	0.18	0.20
	钛,钛合金 titanium,titanium alloys		Rm400	320	20~50	0.12	0.15	0.18	0.20	0.22	0.25
		α + β 合金固化 α + β alloys	RM1050		20~50	0.06	0.08	0.10	0.12	0.14	0.16
H	高硬钢 hard steel	淬硬 harden		55HRC	20~50	0.09	0.11	0.14	0.16	0.18	0.20
		淬硬 harden		60HRC	20~50	0.12	0.15	0.18	0.20	0.22	0.25
	冷硬铸铁 chilled cast iron	铸造 cast		400							
铸铁 cast iron	淬硬 harden		55HRC								

\* 如果选用超过8倍径的和无冷却水孔的刀体请降低切削速度和进给率

\* Lower cutting speed and feed rate should be used for tool holders of 8D or 12D and without coolant