

UNION TOOL

DLC-UMD-TY

DLCコート超硬ドリル

UMD-TY

ノンコート超硬ドリル



一般鋼・アルミ・樹脂加工に最適

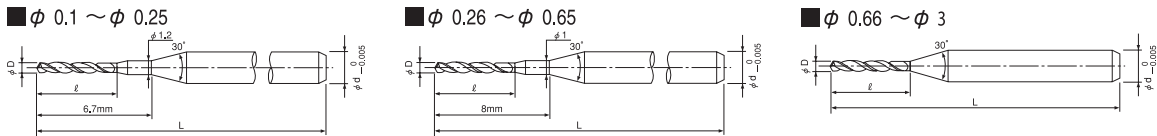


UNION TOOL CO.

※特定代理店商品

DLC-UMD-TY

DLC コート超硬ドリル（アルミ・樹脂加工用）



- ・先端角：120°
- ・サイズ及び公差によって図のような形状にならない場合があります。
- ・φ3は、ストレートタイプ



炭素鋼 S45C S50C	合金鋼 SK SCM	プリハードン鋼 NAK HPM	焼入れ鋼			鋳鉄	アルミ合金	グラファイト	銅	樹脂	ガラス入り樹脂	チタン合金	超耐熱合金	超硬合金	硬脆材
			～ 55HRC	～ 60HRC	～ 70HRC										
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単位：mm

TYコード	型番	直径	溝長	全長	シャンク径
		φD	ℓ	L	φd
UN00292	DLC-UMD-TY 0010	0.1	1.2	38	3
UN00293	DLC-UMD-TY 0011	0.11	1.2	38	3
UN00294	DLC-UMD-TY 0012	0.12	1.4	38	3
UN00295	DLC-UMD-TY 0013	0.13	1.4	38	3
UN00296	DLC-UMD-TY 0014	0.14	1.4	38	3
UN00297	DLC-UMD-TY 0015	0.15	2	38	3
UN00298	DLC-UMD-TY 0016	0.16	2	38	3
UN00299	DLC-UMD-TY 0017	0.17	2	38	3
UN00300	DLC-UMD-TY 0018	0.18	2	38	3
UN00301	DLC-UMD-TY 0019	0.19	2	38	3
UN00302	DLC-UMD-TY 0020	0.2	2.5	38	3
UN00303	DLC-UMD-TY 0021	0.21	2.5	38	3
UN00304	DLC-UMD-TY 0022	0.22	2.5	38	3
UN00305	DLC-UMD-TY 0023	0.23	2.5	38	3
UN00306	DLC-UMD-TY 0024	0.24	2.5	38	3
UN00307	DLC-UMD-TY 0025	0.25	3	38	3
UN00308	DLC-UMD-TY 0026	0.26	3	38	3
UN00309	DLC-UMD-TY 0027	0.27	3	38	3
UN00310	DLC-UMD-TY 0028	0.28	3	38	3
UN00311	DLC-UMD-TY 0029	0.29	3	38	3
UN00312	DLC-UMD-TY 0030	0.3	5	38	3
UN00313	DLC-UMD-TY 0031	0.31	5	38	3
UN00314	DLC-UMD-TY 0032	0.32	5	38	3
UN00315	DLC-UMD-TY 0033	0.33	5	38	3
UN00316	DLC-UMD-TY 0034	0.34	5	38	3
UN00317	DLC-UMD-TY 0035	0.35	6	38	3
UN00318	DLC-UMD-TY 0036	0.36	6	38	3
UN00319	DLC-UMD-TY 0037	0.37	6	38	3
UN00320	DLC-UMD-TY 0038	0.38	6	38	3
UN00321	DLC-UMD-TY 0039	0.39	6	38	3
UN00322	DLC-UMD-TY 0040	0.4	7	38	3
UN00323	DLC-UMD-TY 0041	0.41	7	38	3
UN00324	DLC-UMD-TY 0042	0.42	7	38	3
UN00325	DLC-UMD-TY 0043	0.43	7	38	3
UN00326	DLC-UMD-TY 0044	0.44	7	38	3
UN00327	DLC-UMD-TY 0045	0.45	7	38	3
UN00328	DLC-UMD-TY 0046	0.46	7	38	3
UN00329	DLC-UMD-TY 0047	0.47	7	38	3
UN00330	DLC-UMD-TY 0048	0.48	7	38	3
UN00331	DLC-UMD-TY 0049	0.49	7	38	3
UN00332	DLC-UMD-TY 0050	0.5	7	38	3
UN00333	DLC-UMD-TY 0051	0.51	7	38	3
UN00334	DLC-UMD-TY 0052	0.52	7	38	3
UN00335	DLC-UMD-TY 0053	0.53	7	38	3
UN00336	DLC-UMD-TY 0054	0.54	7	38	3

TYコード	型番	直径	溝長	全長	シャンク径
		φD	ℓ	L	φd
UN00337	DLC-UMD-TY 0055	0.55	7	38	3
UN00338	DLC-UMD-TY 0056	0.56	7	38	3
UN00339	DLC-UMD-TY 0057	0.57	7	38	3
UN00340	DLC-UMD-TY 0058	0.58	7	38	3
UN00341	DLC-UMD-TY 0059	0.59	7	38	3
UN00342	DLC-UMD-TY 0060	0.6	7	38	3
UN00343	DLC-UMD-TY 0061	0.61	7	38	3
UN00344	DLC-UMD-TY 0062	0.62	7	38	3
UN00345	DLC-UMD-TY 0063	0.63	7	38	3
UN00346	DLC-UMD-TY 0064	0.64	7	38	3
UN00347	DLC-UMD-TY 0065	0.65	7	38	3
UN00348	DLC-UMD-TY 0066	0.66	7	38	3
UN00349	DLC-UMD-TY 0067	0.67	7	38	3
UN00350	DLC-UMD-TY 0068	0.68	7	38	3
UN00351	DLC-UMD-TY 0069	0.69	7	38	3
UN00352	DLC-UMD-TY 0070	0.7	8	38	3
UN00353	DLC-UMD-TY 0071	0.71	8	38	3
UN00354	DLC-UMD-TY 0072	0.72	8	38	3
UN00355	DLC-UMD-TY 0073	0.73	8	38	3
UN00356	DLC-UMD-TY 0074	0.74	8	38	3
UN00357	DLC-UMD-TY 0075	0.75	8	38	3
UN00358	DLC-UMD-TY 0076	0.76	8	38	3
UN00359	DLC-UMD-TY 0077	0.77	8	38	3
UN00360	DLC-UMD-TY 0078	0.78	8	38	3
UN00361	DLC-UMD-TY 0079	0.79	8	38	3
UN00362	DLC-UMD-TY 0080	0.8	10	38	3
UN00363	DLC-UMD-TY 0081	0.81	10	38	3
UN00364	DLC-UMD-TY 0082	0.82	10	38	3
UN00365	DLC-UMD-TY 0083	0.83	10	38	3
UN00366	DLC-UMD-TY 0084	0.84	10	38	3
UN00367	DLC-UMD-TY 0085	0.85	10	38	3
UN00368	DLC-UMD-TY 0086	0.86	10	38	3
UN00369	DLC-UMD-TY 0087	0.87	10	38	3
UN00370	DLC-UMD-TY 0088	0.88	10	38	3
UN00371	DLC-UMD-TY 0089	0.89	10	38	3
UN00372	DLC-UMD-TY 0090	0.9	10	38	3
UN00373	DLC-UMD-TY 0091	0.91	10	38	3
UN00374	DLC-UMD-TY 0092	0.92	10	38	3
UN00375	DLC-UMD-TY 0093	0.93	10	38	3
UN00376	DLC-UMD-TY 0094	0.94	10	38	3
UN00377	DLC-UMD-TY 0095	0.95	10	38	3
UN00378	DLC-UMD-TY 0096	0.96	10	38	3
UN00379	DLC-UMD-TY 0097	0.97	10	38	3
UN00380	DLC-UMD-TY 0098	0.98	10	38	3
UN00381	DLC-UMD-TY 0099	0.99	10	38	3

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単位 : mm

TYコード	型番	直径	溝長	全長	シャンク径
		φD	ℓ	L	φd
UN00382	DLC-UMD-TY 0100	1	10	38	3
UN00383	DLC-UMD-TY 0101	1.01	10	38	3
UN00384	DLC-UMD-TY 0102	1.02	10	38	3
UN00385	DLC-UMD-TY 0103	1.03	10	38	3
UN00386	DLC-UMD-TY 0104	1.04	10	38	3
UN00387	DLC-UMD-TY 0105	1.05	10	38	3
UN00388	DLC-UMD-TY 0106	1.06	10	38	3
UN00389	DLC-UMD-TY 0107	1.07	10	38	3
UN00390	DLC-UMD-TY 0108	1.08	10	38	3
UN00391	DLC-UMD-TY 0109	1.09	10	38	3
UN00392	DLC-UMD-TY 0110	1.1	10	38	3
UN00393	DLC-UMD-TY 0111	1.11	10	38	3
UN00394	DLC-UMD-TY 0112	1.12	10	38	3
UN00395	DLC-UMD-TY 0113	1.13	10	38	3
UN00396	DLC-UMD-TY 0114	1.14	10	38	3
UN00397	DLC-UMD-TY 0115	1.15	10	38	3
UN00398	DLC-UMD-TY 0116	1.16	10	38	3
UN00399	DLC-UMD-TY 0117	1.17	10	38	3
UN00400	DLC-UMD-TY 0118	1.18	10	38	3
UN00401	DLC-UMD-TY 0119	1.19	10	38	3
UN00402	DLC-UMD-TY 0120	1.2	10	38	3
UN00403	DLC-UMD-TY 0121	1.21	10	38	3
UN00404	DLC-UMD-TY 0122	1.22	10	38	3
UN00405	DLC-UMD-TY 0123	1.23	10	38	3
UN00406	DLC-UMD-TY 0124	1.24	10	38	3
UN00407	DLC-UMD-TY 0125	1.25	10	38	3
UN00408	DLC-UMD-TY 0126	1.26	10	38	3
UN00409	DLC-UMD-TY 0127	1.27	10	38	3
UN00410	DLC-UMD-TY 0128	1.28	10	38	3
UN00411	DLC-UMD-TY 0129	1.29	10	38	3
UN00412	DLC-UMD-TY 0130	1.3	10	38	3
UN00413	DLC-UMD-TY 0131	1.31	10	38	3
UN00414	DLC-UMD-TY 0132	1.32	10	38	3
UN00415	DLC-UMD-TY 0133	1.33	10	38	3
UN00416	DLC-UMD-TY 0134	1.34	10	38	3
UN00417	DLC-UMD-TY 0135	1.35	10	38	3
UN00418	DLC-UMD-TY 0136	1.36	10	38	3
UN00419	DLC-UMD-TY 0137	1.37	10	38	3
UN00420	DLC-UMD-TY 0138	1.38	10	38	3
UN00421	DLC-UMD-TY 0139	1.39	10	38	3
UN00422	DLC-UMD-TY 0140	1.4	10	38	3
UN00423	DLC-UMD-TY 0141	1.41	10	38	3
UN00424	DLC-UMD-TY 0142	1.42	10	38	3
UN00425	DLC-UMD-TY 0143	1.43	10	38	3
UN00426	DLC-UMD-TY 0144	1.44	10	38	3
UN00427	DLC-UMD-TY 0145	1.45	10	38	3
UN00428	DLC-UMD-TY 0146	1.46	10	38	3
UN00429	DLC-UMD-TY 0147	1.47	10	38	3
UN00430	DLC-UMD-TY 0148	1.48	10	38	3
UN00431	DLC-UMD-TY 0149	1.49	10	38	3
UN00432	DLC-UMD-TY 0150	1.5	10	38	3
UN00433	DLC-UMD-TY 0151	1.51	10	38	3
UN00434	DLC-UMD-TY 0152	1.52	10	38	3
UN00435	DLC-UMD-TY 0153	1.53	10	38	3
UN00436	DLC-UMD-TY 0154	1.54	10	38	3
UN00437	DLC-UMD-TY 0155	1.55	10	38	3
UN00438	DLC-UMD-TY 0156	1.56	10	38	3
UN00439	DLC-UMD-TY 0157	1.57	10	38	3
UN00440	DLC-UMD-TY 0158	1.58	10	38	3
UN00441	DLC-UMD-TY 0159	1.59	10	38	3
UN00442	DLC-UMD-TY 0160	1.6	12	38	3
UN00443	DLC-UMD-TY 0161	1.61	12	38	3

TYコード	型番	直径	溝長	全長	シャンク径
		φD	ℓ	L	φd
UN00444	DLC-UMD-TY 0162	1.62	12	38	3
UN00445	DLC-UMD-TY 0163	1.63	12	38	3
UN00446	DLC-UMD-TY 0164	1.64	12	38	3
UN00447	DLC-UMD-TY 0165	1.65	12	38	3
UN00448	DLC-UMD-TY 0166	1.66	12	38	3
UN00449	DLC-UMD-TY 0167	1.67	12	38	3
UN00450	DLC-UMD-TY 0168	1.68	12	38	3
UN00451	DLC-UMD-TY 0169	1.69	12	38	3
UN00452	DLC-UMD-TY 0170	1.7	12	38	3
UN00453	DLC-UMD-TY 0171	1.71	12	38	3
UN00454	DLC-UMD-TY 0172	1.72	12	38	3
UN00455	DLC-UMD-TY 0173	1.73	12	38	3
UN00456	DLC-UMD-TY 0174	1.74	12	38	3
UN00457	DLC-UMD-TY 0175	1.75	12	38	3
UN00458	DLC-UMD-TY 0176	1.76	12	38	3
UN00459	DLC-UMD-TY 0177	1.77	12	38	3
UN00460	DLC-UMD-TY 0178	1.78	12	38	3
UN00461	DLC-UMD-TY 0179	1.79	12	38	3
UN00462	DLC-UMD-TY 0180	1.8	12	38	3
UN00463	DLC-UMD-TY 0181	1.81	12	38	3
UN00464	DLC-UMD-TY 0182	1.82	12	38	3
UN00465	DLC-UMD-TY 0183	1.83	12	38	3
UN00466	DLC-UMD-TY 0184	1.84	12	38	3
UN00467	DLC-UMD-TY 0185	1.85	12	38	3
UN00468	DLC-UMD-TY 0186	1.86	12	38	3
UN00469	DLC-UMD-TY 0187	1.87	12	38	3
UN00470	DLC-UMD-TY 0188	1.88	12	38	3
UN00471	DLC-UMD-TY 0189	1.89	12	38	3
UN00472	DLC-UMD-TY 0190	1.9	12	38	3
UN00473	DLC-UMD-TY 0191	1.91	12	38	3
UN00474	DLC-UMD-TY 0192	1.92	12	38	3
UN00475	DLC-UMD-TY 0193	1.93	12	38	3
UN00476	DLC-UMD-TY 0194	1.94	12	38	3
UN00477	DLC-UMD-TY 0195	1.95	12	38	3
UN00478	DLC-UMD-TY 0196	1.96	12	38	3
UN00479	DLC-UMD-TY 0197	1.97	12	38	3
UN00480	DLC-UMD-TY 0198	1.98	12	38	3
UN00481	DLC-UMD-TY 0199	1.99	12	38	3
UN00482	DLC-UMD-TY 0200	2	12	38	3
UN00483	DLC-UMD-TY 0201	2.01	12	38	3
UN00484	DLC-UMD-TY 0202	2.02	12	38	3
UN00485	DLC-UMD-TY 0203	2.03	12	38	3
UN00486	DLC-UMD-TY 0204	2.04	12	38	3
UN00487	DLC-UMD-TY 0205	2.05	12	38	3
UN00488	DLC-UMD-TY 0206	2.06	12	38	3
UN00489	DLC-UMD-TY 0207	2.07	12	38	3
UN00490	DLC-UMD-TY 0208	2.08	12	38	3
UN00491	DLC-UMD-TY 0209	2.09	12	38	3
UN00492	DLC-UMD-TY 0210	2.1	12	38	3
UN00493	DLC-UMD-TY 0211	2.11	12	38	3
UN00494	DLC-UMD-TY 0212	2.12	12	38	3
UN00495	DLC-UMD-TY 0213	2.13	12	38	3
UN00496	DLC-UMD-TY 0214	2.14	12	38	3
UN00497	DLC-UMD-TY 0215	2.15	12	38	3
UN00498	DLC-UMD-TY 0216	2.16	12	38	3
UN00499	DLC-UMD-TY 0217	2.17	12	38	3
UN00500	DLC-UMD-TY 0218	2.18	12	38	3
UN00501	DLC-UMD-TY 0219	2.19	12	38	3
UN00502	DLC-UMD-TY 0220	2.2	12	38	3
UN00503	DLC-UMD-TY 0221	2.21	12	38	3
UN00504	DLC-UMD-TY 0222	2.22	12	38	3
UN00505	DLC-UMD-TY 0223	2.23	12	38	3

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単位：mm

TYコード	型番	直径	溝長	全長	シャンク径
		φD	ℓ	L	φd
UN00506	DLC-UMD-TY 0224	2.24	12	38	3
UN00507	DLC-UMD-TY 0225	2.25	12	38	3
UN00508	DLC-UMD-TY 0226	2.26	12	38	3
UN00509	DLC-UMD-TY 0227	2.27	12	38	3
UN00510	DLC-UMD-TY 0228	2.28	12	38	3
UN00511	DLC-UMD-TY 0229	2.29	12	38	3
UN00512	DLC-UMD-TY 0230	2.3	12	38	3
UN00513	DLC-UMD-TY 0231	2.31	12	38	3
UN00514	DLC-UMD-TY 0232	2.32	12	38	3
UN00515	DLC-UMD-TY 0233	2.33	12	38	3
UN00516	DLC-UMD-TY 0234	2.34	12	38	3
UN00517	DLC-UMD-TY 0235	2.35	12	38	3
UN00518	DLC-UMD-TY 0236	2.36	12	38	3
UN00519	DLC-UMD-TY 0237	2.37	12	38	3
UN00520	DLC-UMD-TY 0238	2.38	12	38	3
UN00521	DLC-UMD-TY 0239	2.39	12	38	3
UN00522	DLC-UMD-TY 0240	2.4	12	38	3
UN00523	DLC-UMD-TY 0241	2.41	12	38	3
UN00524	DLC-UMD-TY 0242	2.42	12	38	3
UN00525	DLC-UMD-TY 0243	2.43	12	38	3
UN00526	DLC-UMD-TY 0244	2.44	12	38	3
UN00527	DLC-UMD-TY 0245	2.45	12	38	3
UN00528	DLC-UMD-TY 0246	2.46	12	38	3
UN00529	DLC-UMD-TY 0247	2.47	12	38	3
UN00530	DLC-UMD-TY 0248	2.48	12	38	3
UN00531	DLC-UMD-TY 0249	2.49	12	38	3
UN00532	DLC-UMD-TY 0250	2.5	12	38	3
UN00533	DLC-UMD-TY 0251	2.51	12	38	3
UN00534	DLC-UMD-TY 0252	2.52	12	38	3
UN00535	DLC-UMD-TY 0253	2.53	12	38	3
UN00536	DLC-UMD-TY 0254	2.54	12	38	3
UN00537	DLC-UMD-TY 0255	2.55	12	38	3
UN00538	DLC-UMD-TY 0256	2.56	12	38	3
UN00539	DLC-UMD-TY 0257	2.57	12	38	3
UN00540	DLC-UMD-TY 0258	2.58	12	38	3
UN00541	DLC-UMD-TY 0259	2.59	12	38	3
UN00542	DLC-UMD-TY 0260	2.6	12	38	3
UN00543	DLC-UMD-TY 0261	2.61	12	38	3
UN00544	DLC-UMD-TY 0262	2.62	12	38	3

TYコード	型番	直径	溝長	全長	シャンク径
		φD	ℓ	L	φd
UN00545	DLC-UMD-TY 0263	2.63	12	38	3
UN00546	DLC-UMD-TY 0264	2.64	12	38	3
UN00547	DLC-UMD-TY 0265	2.65	12	38	3
UN00548	DLC-UMD-TY 0266	2.66	12	38	3
UN00549	DLC-UMD-TY 0267	2.67	12	38	3
UN00550	DLC-UMD-TY 0268	2.68	12	38	3
UN00551	DLC-UMD-TY 0269	2.69	12	38	3
UN00552	DLC-UMD-TY 0270	2.7	12	38	3
UN00553	DLC-UMD-TY 0271	2.71	12	38	3
UN00554	DLC-UMD-TY 0272	2.72	12	38	3
UN00555	DLC-UMD-TY 0273	2.73	12	38	3
UN00556	DLC-UMD-TY 0274	2.74	12	38	3
UN00557	DLC-UMD-TY 0275	2.75	12	38	3
UN00558	DLC-UMD-TY 0276	2.76	12	38	3
UN00559	DLC-UMD-TY 0277	2.77	12	38	3
UN00560	DLC-UMD-TY 0278	2.78	12	38	3
UN00561	DLC-UMD-TY 0279	2.79	12	38	3
UN00562	DLC-UMD-TY 0280	2.8	12	38	3
UN00563	DLC-UMD-TY 0281	2.81	12	38	3
UN00564	DLC-UMD-TY 0282	2.82	12	38	3
UN00565	DLC-UMD-TY 0283	2.83	12	38	3
UN00566	DLC-UMD-TY 0284	2.84	12	38	3
UN00567	DLC-UMD-TY 0285	2.85	12	38	3
UN00568	DLC-UMD-TY 0286	2.86	12	38	3
UN00569	DLC-UMD-TY 0287	2.87	12	38	3
UN00570	DLC-UMD-TY 0288	2.88	12	38	3
UN00571	DLC-UMD-TY 0289	2.89	12	38	3
UN00572	DLC-UMD-TY 0290	2.9	12	38	3
UN00573	DLC-UMD-TY 0291	2.91	12	38	3
UN00574	DLC-UMD-TY 0292	2.92	12	38	3
UN00575	DLC-UMD-TY 0293	2.93	12	38	3
UN00576	DLC-UMD-TY 0294	2.94	12	38	3
UN00577	DLC-UMD-TY 0295	2.95	12	38	3
UN00578	DLC-UMD-TY 0296	2.96	12	38	3
UN00579	DLC-UMD-TY 0297	2.97	12	38	3
UN00580	DLC-UMD-TY 0298	2.98	12	38	3
UN00581	DLC-UMD-TY 0299	2.99	12	38	3
UN00582	DLC-UMD-TY 0300	3	12	38	3

DLC-UMD-TY 切削条件表

被削材	アルミ合金 A5052 等		銅合金		樹脂 ポリカーボネート等	
直径 (D) (mm)	回転速度 (min-1)	送り速度 (mm/min)	回転速度 (min-1)	送り速度 (mm/min)	回転速度 (min-1)	送り速度 (mm/min)
0.3	20,000	400	20,000	80	20,000	320
0.4	20,000	690	17,400	100	20,000	550
0.5	20,000	1,000	15,900	160	20,000	800
0.6	19,900	1,050	14,100	160	19,900	880
0.7	19,900	1,120	12,800	180	19,900	950
0.8	19,900	1,190	11,900	200	19,900	1,000
0.9	17,600	1,220	10,500	200	17,600	1,020
1	15,900	1,270	9,500	200	15,900	1,080
2	9,500	950	5,600	340	9,500	820
3	6,400	640	3,700	300	6,400	550

【備考】 ステップ量：アルミ合金，樹脂 0.2D～0.5D。 その他 0.1D～0.2D。

※特定代理店商品

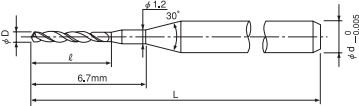


UMD-TY

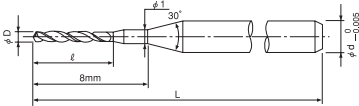
ノンコート超硬ドリル



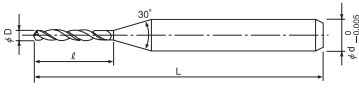
■ $\phi 0.1 \sim \phi 0.25$



■ $\phi 0.26 \sim \phi 0.65$



■ $\phi 0.66 \sim \phi 3$



- ・先端角：120°
- ・サイズ及び公差によって図のような形状にならない場合があります。
- ・ $\phi 3$ は、ストレートタイプ



炭素鋼 S45C S50C	合金鋼 SK SCM	プリハードン鋼 NAK HPM	焼入れ鋼			鋳鉄	アルミ合金	グラファイト	銅	樹脂	ガラス入り樹脂	チタン合金	超耐熱合金	超硬合金	硬脆材
			～ 55HRC	～ 60HRC	～ 70HRC										
○							◎			◎					

単位：mm

TYコード	型番	直径	溝長	全長	シャンク径
		ϕD	ℓ	L	ϕd
UN00001	UMD-TY 0010	0.1	1.2	38	3
UN00002	UMD-TY 0011	0.11	1.2	38	3
UN00003	UMD-TY 0012	0.12	1.4	38	3
UN00004	UMD-TY 0013	0.13	1.4	38	3
UN00005	UMD-TY 0014	0.14	1.4	38	3
UN00006	UMD-TY 0015	0.15	2	38	3
UN00007	UMD-TY 0016	0.16	2	38	3
UN00008	UMD-TY 0017	0.17	2	38	3
UN00009	UMD-TY 0018	0.18	2	38	3
UN00010	UMD-TY 0019	0.19	2	38	3
UN00011	UMD-TY 0020	0.2	2.5	38	3
UN00012	UMD-TY 0021	0.21	2.5	38	3
UN00013	UMD-TY 0022	0.22	2.5	38	3
UN00014	UMD-TY 0023	0.23	2.5	38	3
UN00015	UMD-TY 0024	0.24	2.5	38	3
UN00016	UMD-TY 0025	0.25	3	38	3
UN00017	UMD-TY 0026	0.26	3	38	3
UN00018	UMD-TY 0027	0.27	3	38	3
UN00019	UMD-TY 0028	0.28	3	38	3
UN00020	UMD-TY 0029	0.29	3	38	3
UN00021	UMD-TY 0030	0.3	5	38	3
UN00022	UMD-TY 0031	0.31	5	38	3
UN00023	UMD-TY 0032	0.32	5	38	3
UN00024	UMD-TY 0033	0.33	5	38	3
UN00025	UMD-TY 0034	0.34	5	38	3
UN00026	UMD-TY 0035	0.35	6	38	3
UN00027	UMD-TY 0036	0.36	6	38	3
UN00028	UMD-TY 0037	0.37	6	38	3
UN00029	UMD-TY 0038	0.38	6	38	3
UN00030	UMD-TY 0039	0.39	6	38	3
UN00031	UMD-TY 0040	0.4	7	38	3
UN00032	UMD-TY 0041	0.41	7	38	3
UN00033	UMD-TY 0042	0.42	7	38	3
UN00034	UMD-TY 0043	0.43	7	38	3
UN00035	UMD-TY 0044	0.44	7	38	3
UN00036	UMD-TY 0045	0.45	7	38	3
UN00037	UMD-TY 0046	0.46	7	38	3
UN00038	UMD-TY 0047	0.47	7	38	3
UN00039	UMD-TY 0048	0.48	7	38	3
UN00040	UMD-TY 0049	0.49	7	38	3
UN00041	UMD-TY 0050	0.5	7	38	3
UN00042	UMD-TY 0051	0.51	7	38	3
UN00043	UMD-TY 0052	0.52	7	38	3
UN00044	UMD-TY 0053	0.53	7	38	3
UN00045	UMD-TY 0054	0.54	7	38	3

TYコード	型番	直径	溝長	全長	シャンク径
		ϕD	ℓ	L	ϕd
UN00046	UMD-TY 0055	0.55	7	38	3
UN00047	UMD-TY 0056	0.56	7	38	3
UN00048	UMD-TY 0057	0.57	7	38	3
UN00049	UMD-TY 0058	0.58	7	38	3
UN00050	UMD-TY 0059	0.59	7	38	3
UN00051	UMD-TY 0060	0.6	7	38	3
UN00052	UMD-TY 0061	0.61	7	38	3
UN00053	UMD-TY 0062	0.62	7	38	3
UN00054	UMD-TY 0063	0.63	7	38	3
UN00055	UMD-TY 0064	0.64	7	38	3
UN00056	UMD-TY 0065	0.65	7	38	3
UN00057	UMD-TY 0066	0.66	7	38	3
UN00058	UMD-TY 0067	0.67	7	38	3
UN00059	UMD-TY 0068	0.68	7	38	3
UN00060	UMD-TY 0069	0.69	7	38	3
UN00061	UMD-TY 0070	0.7	8	38	3
UN00062	UMD-TY 0071	0.71	8	38	3
UN00063	UMD-TY 0072	0.72	8	38	3
UN00064	UMD-TY 0073	0.73	8	38	3
UN00065	UMD-TY 0074	0.74	8	38	3
UN00066	UMD-TY 0075	0.75	8	38	3
UN00067	UMD-TY 0076	0.76	8	38	3
UN00068	UMD-TY 0077	0.77	8	38	3
UN00069	UMD-TY 0078	0.78	8	38	3
UN00070	UMD-TY 0079	0.79	8	38	3
UN00071	UMD-TY 0080	0.8	10	38	3
UN00072	UMD-TY 0081	0.81	10	38	3
UN00073	UMD-TY 0082	0.82	10	38	3
UN00074	UMD-TY 0083	0.83	10	38	3
UN00075	UMD-TY 0084	0.84	10	38	3
UN00076	UMD-TY 0085	0.85	10	38	3
UN00077	UMD-TY 0086	0.86	10	38	3
UN00078	UMD-TY 0087	0.87	10	38	3
UN00079	UMD-TY 0088	0.88	10	38	3
UN00080	UMD-TY 0089	0.89	10	38	3
UN00081	UMD-TY 0090	0.9	10	38	3
UN00082	UMD-TY 0091	0.91	10	38	3
UN00083	UMD-TY 0092	0.92	10	38	3
UN00084	UMD-TY 0093	0.93	10	38	3
UN00085	UMD-TY 0094	0.94	10	38	3
UN00086	UMD-TY 0095	0.95	10	38	3
UN00087	UMD-TY 0096	0.96	10	38	3
UN00088	UMD-TY 0097	0.97	10	38	3
UN00089	UMD-TY 0098	0.98	10	38	3
UN00090	UMD-TY 0099	0.99	10	38	3

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単位 : mm

TYコード	型番	直径	溝長	全長	シャンク径
		φD	ℓ	L	φd
UN00091	UMD-TY 0100	1	10	38	3
UN00092	UMD-TY 0101	1.01	10	38	3
UN00093	UMD-TY 0102	1.02	10	38	3
UN00094	UMD-TY 0103	1.03	10	38	3
UN00095	UMD-TY 0104	1.04	10	38	3
UN00096	UMD-TY 0105	1.05	10	38	3
UN00097	UMD-TY 0106	1.06	10	38	3
UN00098	UMD-TY 0107	1.07	10	38	3
UN00099	UMD-TY 0108	1.08	10	38	3
UN00100	UMD-TY 0109	1.09	10	38	3
UN00101	UMD-TY 0110	1.1	10	38	3
UN00102	UMD-TY 0111	1.11	10	38	3
UN00103	UMD-TY 0112	1.12	10	38	3
UN00104	UMD-TY 0113	1.13	10	38	3
UN00105	UMD-TY 0114	1.14	10	38	3
UN00106	UMD-TY 0115	1.15	10	38	3
UN00107	UMD-TY 0116	1.16	10	38	3
UN00108	UMD-TY 0117	1.17	10	38	3
UN00109	UMD-TY 0118	1.18	10	38	3
UN00110	UMD-TY 0119	1.19	10	38	3
UN00111	UMD-TY 0120	1.2	10	38	3
UN00112	UMD-TY 0121	1.21	10	38	3
UN00113	UMD-TY 0122	1.22	10	38	3
UN00114	UMD-TY 0123	1.23	10	38	3
UN00115	UMD-TY 0124	1.24	10	38	3
UN00116	UMD-TY 0125	1.25	10	38	3
UN00117	UMD-TY 0126	1.26	10	38	3
UN00118	UMD-TY 0127	1.27	10	38	3
UN00119	UMD-TY 0128	1.28	10	38	3
UN00120	UMD-TY 0129	1.29	10	38	3
UN00121	UMD-TY 0130	1.3	10	38	3
UN00122	UMD-TY 0131	1.31	10	38	3
UN00123	UMD-TY 0132	1.32	10	38	3
UN00124	UMD-TY 0133	1.33	10	38	3
UN00125	UMD-TY 0134	1.34	10	38	3
UN00126	UMD-TY 0135	1.35	10	38	3
UN00127	UMD-TY 0136	1.36	10	38	3
UN00128	UMD-TY 0137	1.37	10	38	3
UN00129	UMD-TY 0138	1.38	10	38	3
UN00130	UMD-TY 0139	1.39	10	38	3
UN00131	UMD-TY 0140	1.4	10	38	3
UN00132	UMD-TY 0141	1.41	10	38	3
UN00133	UMD-TY 0142	1.42	10	38	3
UN00134	UMD-TY 0143	1.43	10	38	3
UN00135	UMD-TY 0144	1.44	10	38	3
UN00136	UMD-TY 0145	1.45	10	38	3
UN00137	UMD-TY 0146	1.46	10	38	3
UN00138	UMD-TY 0147	1.47	10	38	3
UN00139	UMD-TY 0148	1.48	10	38	3
UN00140	UMD-TY 0149	1.49	10	38	3
UN00141	UMD-TY 0150	1.5	10	38	3
UN00142	UMD-TY 0151	1.51	10	38	3
UN00143	UMD-TY 0152	1.52	10	38	3
UN00144	UMD-TY 0153	1.53	10	38	3
UN00145	UMD-TY 0154	1.54	10	38	3
UN00146	UMD-TY 0155	1.55	10	38	3
UN00147	UMD-TY 0156	1.56	10	38	3
UN00148	UMD-TY 0157	1.57	10	38	3
UN00149	UMD-TY 0158	1.58	10	38	3
UN00150	UMD-TY 0159	1.59	10	38	3
UN00151	UMD-TY 0160	1.6	12	38	3
UN00152	UMD-TY 0161	1.61	12	38	3

TYコード	型番	直径	溝長	全長	シャンク径
		φD	ℓ	L	φd
UN00153	UMD-TY 0162	1.62	12	38	3
UN00154	UMD-TY 0163	1.63	12	38	3
UN00155	UMD-TY 0164	1.64	12	38	3
UN00156	UMD-TY 0165	1.65	12	38	3
UN00157	UMD-TY 0166	1.66	12	38	3
UN00158	UMD-TY 0167	1.67	12	38	3
UN00159	UMD-TY 0168	1.68	12	38	3
UN00160	UMD-TY 0169	1.69	12	38	3
UN00161	UMD-TY 0170	1.7	12	38	3
UN00162	UMD-TY 0171	1.71	12	38	3
UN00163	UMD-TY 0172	1.72	12	38	3
UN00164	UMD-TY 0173	1.73	12	38	3
UN00165	UMD-TY 0174	1.74	12	38	3
UN00166	UMD-TY 0175	1.75	12	38	3
UN00167	UMD-TY 0176	1.76	12	38	3
UN00168	UMD-TY 0177	1.77	12	38	3
UN00169	UMD-TY 0178	1.78	12	38	3
UN00170	UMD-TY 0179	1.79	12	38	3
UN00171	UMD-TY 0180	1.8	12	38	3
UN00172	UMD-TY 0181	1.81	12	38	3
UN00173	UMD-TY 0182	1.82	12	38	3
UN00174	UMD-TY 0183	1.83	12	38	3
UN00175	UMD-TY 0184	1.84	12	38	3
UN00176	UMD-TY 0185	1.85	12	38	3
UN00177	UMD-TY 0186	1.86	12	38	3
UN00178	UMD-TY 0187	1.87	12	38	3
UN00179	UMD-TY 0188	1.88	12	38	3
UN00180	UMD-TY 0189	1.89	12	38	3
UN00181	UMD-TY 0190	1.9	12	38	3
UN00182	UMD-TY 0191	1.91	12	38	3
UN00183	UMD-TY 0192	1.92	12	38	3
UN00184	UMD-TY 0193	1.93	12	38	3
UN00185	UMD-TY 0194	1.94	12	38	3
UN00186	UMD-TY 0195	1.95	12	38	3
UN00187	UMD-TY 0196	1.96	12	38	3
UN00188	UMD-TY 0197	1.97	12	38	3
UN00189	UMD-TY 0198	1.98	12	38	3
UN00190	UMD-TY 0199	1.99	12	38	3
UN00191	UMD-TY 0200	2	12	38	3
UN00192	UMD-TY 0201	2.01	12	38	3
UN00193	UMD-TY 0202	2.02	12	38	3
UN00194	UMD-TY 0203	2.03	12	38	3
UN00195	UMD-TY 0204	2.04	12	38	3
UN00196	UMD-TY 0205	2.05	12	38	3
UN00197	UMD-TY 0206	2.06	12	38	3
UN00198	UMD-TY 0207	2.07	12	38	3
UN00199	UMD-TY 0208	2.08	12	38	3
UN00200	UMD-TY 0209	2.09	12	38	3
UN00201	UMD-TY 0210	2.1	12	38	3
UN00202	UMD-TY 0211	2.11	12	38	3
UN00203	UMD-TY 0212	2.12	12	38	3
UN00204	UMD-TY 0213	2.13	12	38	3
UN00205	UMD-TY 0214	2.14	12	38	3
UN00206	UMD-TY 0215	2.15	12	38	3
UN00207	UMD-TY 0216	2.16	12	38	3
UN00208	UMD-TY 0217	2.17	12	38	3
UN00209	UMD-TY 0218	2.18	12	38	3
UN00210	UMD-TY 0219	2.19	12	38	3
UN00211	UMD-TY 0220	2.2	12	38	3
UN00212	UMD-TY 0221	2.21	12	38	3
UN00213	UMD-TY 0222	2.22	12	38	3
UN00214	UMD-TY 0223	2.23	12	38	3

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単位：mm

TYコード	型番	直径	溝長	全長	シャンク径
		φD	ℓ	L	φd
UN00215	UMD-TY 0224	2.24	12	38	3
UN00216	UMD-TY 0225	2.25	12	38	3
UN00217	UMD-TY 0226	2.26	12	38	3
UN00218	UMD-TY 0227	2.27	12	38	3
UN00219	UMD-TY 0228	2.28	12	38	3
UN00220	UMD-TY 0229	2.29	12	38	3
UN00221	UMD-TY 0230	2.3	12	38	3
UN00222	UMD-TY 0231	2.31	12	38	3
UN00223	UMD-TY 0232	2.32	12	38	3
UN00224	UMD-TY 0233	2.33	12	38	3
UN00225	UMD-TY 0234	2.34	12	38	3
UN00226	UMD-TY 0235	2.35	12	38	3
UN00227	UMD-TY 0236	2.36	12	38	3
UN00228	UMD-TY 0237	2.37	12	38	3
UN00229	UMD-TY 0238	2.38	12	38	3
UN00230	UMD-TY 0239	2.39	12	38	3
UN00231	UMD-TY 0240	2.4	12	38	3
UN00232	UMD-TY 0241	2.41	12	38	3
UN00233	UMD-TY 0242	2.42	12	38	3
UN00234	UMD-TY 0243	2.43	12	38	3
UN00235	UMD-TY 0244	2.44	12	38	3
UN00236	UMD-TY 0245	2.45	12	38	3
UN00237	UMD-TY 0246	2.46	12	38	3
UN00238	UMD-TY 0247	2.47	12	38	3
UN00239	UMD-TY 0248	2.48	12	38	3
UN00240	UMD-TY 0249	2.49	12	38	3
UN00241	UMD-TY 0250	2.5	12	38	3
UN00242	UMD-TY 0251	2.51	12	38	3
UN00243	UMD-TY 0252	2.52	12	38	3
UN00244	UMD-TY 0253	2.53	12	38	3
UN00245	UMD-TY 0254	2.54	12	38	3
UN00246	UMD-TY 0255	2.55	12	38	3
UN00247	UMD-TY 0256	2.56	12	38	3
UN00248	UMD-TY 0257	2.57	12	38	3
UN00249	UMD-TY 0258	2.58	12	38	3
UN00250	UMD-TY 0259	2.59	12	38	3
UN00251	UMD-TY 0260	2.6	12	38	3
UN00252	UMD-TY 0261	2.61	12	38	3
UN00253	UMD-TY 0262	2.62	12	38	3

TYコード	型番	直径	溝長	全長	シャンク径
		φD	ℓ	L	φd
UN00254	UMD-TY 0263	2.63	12	38	3
UN00255	UMD-TY 0264	2.64	12	38	3
UN00256	UMD-TY 0265	2.65	12	38	3
UN00257	UMD-TY 0266	2.66	12	38	3
UN00258	UMD-TY 0267	2.67	12	38	3
UN00259	UMD-TY 0268	2.68	12	38	3
UN00260	UMD-TY 0269	2.69	12	38	3
UN00261	UMD-TY 0270	2.7	12	38	3
UN00262	UMD-TY 0271	2.71	12	38	3
UN00263	UMD-TY 0272	2.72	12	38	3
UN00264	UMD-TY 0273	2.73	12	38	3
UN00265	UMD-TY 0274	2.74	12	38	3
UN00266	UMD-TY 0275	2.75	12	38	3
UN00267	UMD-TY 0276	2.76	12	38	3
UN00268	UMD-TY 0277	2.77	12	38	3
UN00269	UMD-TY 0278	2.78	12	38	3
UN00270	UMD-TY 0279	2.79	12	38	3
UN00271	UMD-TY 0280	2.8	12	38	3
UN00272	UMD-TY 0281	2.81	12	38	3
UN00273	UMD-TY 0282	2.82	12	38	3
UN00274	UMD-TY 0283	2.83	12	38	3
UN00275	UMD-TY 0284	2.84	12	38	3
UN00276	UMD-TY 0285	2.85	12	38	3
UN00277	UMD-TY 0286	2.86	12	38	3
UN00278	UMD-TY 0287	2.87	12	38	3
UN00279	UMD-TY 0288	2.88	12	38	3
UN00280	UMD-TY 0289	2.89	12	38	3
UN00281	UMD-TY 0290	2.9	12	38	3
UN00282	UMD-TY 0291	2.91	12	38	3
UN00283	UMD-TY 0292	2.92	12	38	3
UN00284	UMD-TY 0293	2.93	12	38	3
UN00285	UMD-TY 0294	2.94	12	38	3
UN00286	UMD-TY 0295	2.95	12	38	3
UN00287	UMD-TY 0296	2.96	12	38	3
UN00288	UMD-TY 0297	2.97	12	38	3
UN00289	UMD-TY 0298	2.98	12	38	3
UN00290	UMD-TY 0299	2.99	12	38	3
UN00291	UMD-TY 0300	3	12	38	3

UMD-TY 切削条件表

被削材	炭素鋼 S45C/S50C		アルミ合金 A5052 等		樹脂 ポリカーボネート等	
	直径 (D) (mm)	回転速度 (min-1)	送り速度 (mm/min)	回転速度 (min-1)	送り速度 (mm/min)	送り速度 (mm/min)
0.3		20,000	40	20,000	320	320
0.4		17,400	50	20,000	550	550
0.5		15,900	80	20,000	800	800
0.6		14,100	80	19,900	880	880
0.7		12,800	90	19,900	950	950
0.8		11,900	100	19,900	1,000	1,000
0.9		10,500	100	17,600	1,020	1,020
1		9,500	100	15,900	1,080	1,080
2		5,600	170	9,500	820	820
3		3,700	150	6,400	550	550

【備考】 ステップ量：アルミ合金，樹脂 0.2D～0.5D。 その他 0.1D～0.2D。