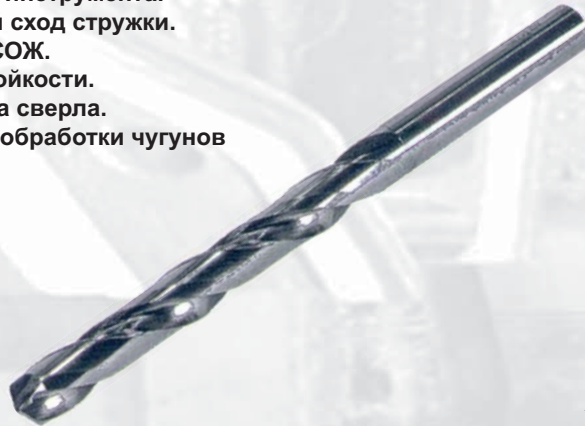




“Sigma Drill-Cast”

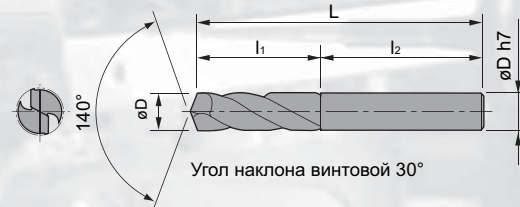
■ FC-DDSM (средняя серия 4xD) без покрытия

1. Высокая прочность инструмента.
2. Беспрепятственный сход стружки.
3. Наружный подвод СОЖ.
4. Высокий период стойкости.
5. Плоскостная заточка сверла.
6. Первый выбор для обработки чугунов



■ Допуск на диаметр сверла, мм

| ØD | Допуск, мм |
|----------------------------|-------------|
| До 3 мм | 0 -0.010 |
| От 3,1 до 5,9 включительно | 0 -0.012 |
| От 6 до 10 включительно | 0 -0.015 |
| От 10 до 18 включит. | 0 -0.018 |
| От 18 до 20 включит. | 0 -0.021 |



- Глубина сверления 4xD
- Без покрытия

| Каталожный номер | Наличие на складе | Размеры, мм | | | |
|------------------|-------------------|-------------|----------------|----------------|----|
| | | ØD | l ₁ | l ₂ | L |
| FC-DDSM030 | ● | 3.0 | 18 | 32 | 50 |
| FC-DDSM031 | ● | 3.1 | 19 | 34 | 53 |
| FC-DDSM032 | ● | 3.2 | 19 | 34 | 53 |
| FC-DDSM033 | ● | 3.3 | 19 | 34 | 53 |
| FC-DDSM034 | ● | 3.4 | 19 | 34 | 53 |
| FC-DDSM035 | ● | 3.5 | 21 | 34 | 55 |
| FC-DDSM036 | ● | 3.6 | 21 | 34 | 55 |
| FC-DDSM037 | ● | 3.7 | 21 | 34 | 55 |
| FC-DDSM038 | ● | 3.8 | 23 | 34 | 57 |
| FC-DDSM039 | ● | 3.9 | 23 | 34 | 57 |
| FC-DDSM040 | ● | 4.0 | 23 | 34 | 57 |
| FC-DDSM041 | ● | 4.1 | 26 | 34 | 60 |
| FC-DDSM042 | ● | 4.2 | 26 | 34 | 60 |
| FC-DDSM043 | ● | 4.3 | 26 | 34 | 60 |
| FC-DDSM044 | ● | 4.4 | 26 | 34 | 60 |
| FC-DDSM045 | ● | 4.5 | 26 | 34 | 60 |
| FC-DDSM046 | ● | 4.6 | 29 | 36 | 65 |
| FC-DDSM047 | ● | 4.7 | 29 | 36 | 65 |
| FC-DDSM048 | ● | 4.8 | 29 | 36 | 65 |
| FC-DDSM049 | ● | 4.9 | 29 | 36 | 65 |
| FC-DDSM050 | ● | 5.0 | 29 | 36 | 65 |
| FC-DDSM051 | ● | 5.1 | 32 | 38 | 70 |
| FC-DDSM052 | ● | 5.2 | 32 | 38 | 70 |
| FC-DDSM053 | ● | 5.3 | 32 | 38 | 70 |
| FC-DDSM054 | ● | 5.4 | 32 | 38 | 70 |
| FC-DDSM055 | ● | 5.5 | 32 | 38 | 70 |
| FC-DDSM056 | ● | 5.6 | 35 | 40 | 75 |
| FC-DDSM057 | ● | 5.7 | 35 | 40 | 75 |

| Каталожный номер | Наличие на складе | Размеры, мм | | | |
|------------------|-------------------|-------------|----------------|----------------|----|
| | | ØD | l ₁ | l ₂ | L |
| FC-DDSM058 | ● | 5.8 | 35 | 40 | 75 |
| FC-DDSM059 | ● | 5.9 | 35 | 40 | 75 |
| FC-DDSM060 | ● | 6.0 | 35 | 40 | 75 |
| FC-DDSM061 | ● | 6.1 | 38 | 42 | 80 |
| FC-DDSM062 | ● | 6.2 | 38 | 42 | 80 |
| FC-DDSM063 | ● | 6.3 | 38 | 42 | 80 |
| FC-DDSM064 | ● | 6.4 | 38 | 42 | 80 |
| FC-DDSM065 | ● | 6.5 | 38 | 42 | 80 |
| FC-DDSM066 | ● | 6.6 | 42 | 43 | 85 |
| FC-DDSM067 | ● | 6.7 | 42 | 43 | 85 |
| FC-DDSM068 | ● | 6.8 | 42 | 43 | 85 |
| FC-DDSM069 | ● | 6.9 | 42 | 43 | 85 |
| FC-DDSM070 | ● | 7.0 | 42 | 43 | 85 |
| FC-DDSM071 | ● | 7.1 | 45 | 45 | 90 |
| FC-DDSM072 | ● | 7.2 | 45 | 45 | 90 |
| FC-DDSM073 | ● | 7.3 | 45 | 45 | 90 |
| FC-DDSM074 | ● | 7.4 | 45 | 45 | 90 |
| FC-DDSM075 | ● | 7.5 | 45 | 45 | 90 |
| FC-DDSM076 | ● | 7.6 | 47 | 45 | 92 |
| FC-DDSM077 | ● | 7.7 | 47 | 45 | 92 |
| FC-DDSM078 | ● | 7.8 | 47 | 45 | 92 |
| FC-DDSM079 | ● | 7.9 | 47 | 45 | 92 |
| FC-DDSM080 | ● | 8.0 | 47 | 45 | 92 |
| FC-DDSM-081 | ● | 8.1 | 50 | 45 | 95 |
| FC-DDSM082 | ● | 8.2 | 50 | 45 | 95 |
| FC-DDSM083 | ● | 8.3 | 50 | 45 | 95 |
| FC-DDSM084 | ● | 8.4 | 50 | 45 | 95 |
| FC-DDSM085 | ● | 8.5 | 50 | 45 | 95 |



“Sigma Drill-Cast”

■ FC-DDSM (средняя серия 4xD) без покрытия

| Каталожный номер | Наличие на складе | Размеры, мм | | | |
|------------------|-------------------|-------------|----------------|----------------|-----|
| | | ØD | l ₁ | l ₂ | L |
| FC-DDSM086 | ● | 8.6 | 53 | 45 | 98 |
| FC-DDSM087 | ● | 8.7 | 53 | 45 | 98 |
| FC-DDSM088 | ● | 8.8 | 53 | 45 | 98 |
| FC-DDSM089 | ● | 8.9 | 53 | 45 | 98 |
| FC-DDSM090 | ● | 9.0 | 53 | 45 | 98 |
| FC-DDSM091 | ● | 9.1 | 55 | 45 | 100 |
| FC-DDSM092 | ● | 9.2 | 55 | 45 | 100 |
| FC-DDSM093 | ● | 9.3 | 55 | 45 | 100 |
| FC-DDSM094 | ● | 9.4 | 55 | 45 | 100 |
| FC-DDSM095 | ● | 9.5 | 55 | 45 | 100 |
| FC-DDSM096 | ● | 9.6 | 60 | 45 | 105 |
| FC-DDSM097 | ● | 9.7 | 60 | 45 | 105 |
| FC-DDSM098 | ● | 9.8 | 60 | 45 | 105 |
| FC-DDSM099 | ● | 9.9 | 60 | 45 | 105 |
| FC-DDSM100 | ● | 10.0 | 60 | 45 | 105 |
| FC-DDSM101 | ● | 10.1 | 64 | 46 | 110 |
| FC-DDSM102 | ● | 10.2 | 64 | 46 | 110 |
| FC-DDSM103 | ● | 10.3 | 64 | 46 | 110 |
| FC-DDSM104 | ● | 10.4 | 64 | 46 | 110 |
| FC-DDSM105 | ● | 10.5 | 64 | 46 | 110 |
| FC-DDSM106 | ● | 10.6 | 68 | 47 | 115 |
| FC-DDSM107 | ● | 10.7 | 68 | 47 | 115 |
| FC-DDSM108 | ● | 10.8 | 68 | 47 | 115 |
| FC-DDSM109 | ● | 10.9 | 68 | 47 | 115 |
| FC-DDSM110 | ● | 11.0 | 68 | 47 | 115 |
| FC-DDSM111 | ● | 11.1 | 68 | 47 | 115 |
| FC-DDSM112 | ● | 11.2 | 68 | 47 | 115 |
| FC-DDSM113 | ● | 11.3 | 68 | 47 | 115 |
| FC-DDSM114 | ● | 11.4 | 68 | 47 | 115 |
| FC-DDSM115 | ● | 11.5 | 68 | 47 | 115 |
| FC-DDSM116 | ● | 11.6 | 72 | 48 | 120 |
| FC-DDSM117 | ● | 11.7 | 72 | 48 | 120 |

| Каталожный номер | Наличие на складе | Размеры, мм | | | |
|------------------|-------------------|-------------|----------------|----------------|-----|
| | | ØD | l ₁ | l ₂ | L |
| FC-DDSM118 | ● | 11.8 | 72 | 48 | 120 |
| FC-DDSM119 | ● | 11.9 | 72 | 48 | 120 |
| FC-DDSM120 | ● | 12.0 | 72 | 48 | 120 |
| FC-DDSM121 | ● | 12.1 | 74 | 51 | 125 |
| FC-DDSM122 | ● | 12.2 | 74 | 51 | 125 |
| FC-DDSM123 | ● | 12.3 | 74 | 51 | 125 |
| FC-DDSM124 | ● | 12.4 | 74 | 51 | 125 |
| FC-DDSM125 | ● | 12.5 | 74 | 51 | 125 |
| FC-DDSM126 | ● | 12.6 | 79 | 51 | 130 |
| FC-DDSM127 | ● | 12.7 | 79 | 51 | 130 |
| FC-DDSM128 | ● | 12.8 | 79 | 51 | 130 |
| FC-DDSM129 | ● | 12.9 | 79 | 51 | 130 |
| FC-DDSM130 | ● | 13.0 | 79 | 51 | 130 |
| FC-DDSM132 | ● | 13.2 | 82 | 53 | 135 |
| FC-DDSM135 | ● | 13.5 | 82 | 53 | 135 |
| FC-DDSM136 | ● | 13.6 | 82 | 53 | 135 |
| FC-DDSM138 | ● | 13.8 | 82 | 53 | 135 |
| FC-DDSM140 | ● | 14.0 | 82 | 53 | 135 |
| FC-DDSM142 | ● | 14.2 | 84 | 56 | 140 |
| FC-DDSM145 | ● | 14.5 | 84 | 56 | 140 |
| FC-DDSM148 | ● | 14.8 | 89 | 56 | 145 |
| FC-DDSM150 | ● | 15.0 | 89 | 56 | 145 |
| FC-DDSM152 | ● | 15.2 | 90 | 60 | 150 |
| FC-DDSM155 | ● | 15.5 | 90 | 60 | 150 |
| FC-DDSM158 | ● | 15.8 | 95 | 60 | 155 |
| FC-DDSM160 | ● | 16.0 | 95 | 60 | 155 |
| FC-DDSM170 | ● | 17.0 | 102 | 68 | 170 |
| FC-DDSM175 | ● | 17.5 | 107 | 68 | 175 |
| FC-DDSM180 | ● | 18.0 | 107 | 68 | 175 |
| FC-DDSM185 | ● | 18.5 | 115 | 70 | 185 |
| FC-DDSM190 | ● | 19.0 | 115 | 70 | 185 |
| FC-DDSM200 | ● | 20.0 | 120 | 70 | 190 |

■ Рекомендуемые режимы резания для сверл FC-DDSM

| Works Materials | Высокопрочный чугун (например, ВЧ40), 230HB | | | Серый чугун (например, СЧ25), 220HB | | | Примечание |
|-----------------|---|-------------------------|-------------------------------------|-------------------------------------|-------------------------|-------------------------------------|------------|
| | Диаметр, мм ØD (mm) | Скорость резания, м/мин | Частота вращения, мин ⁻¹ | Подача, мм/об | Скорость резания, м/мин | Частота вращения, мин ⁻¹ | |
| | 3 | 35 | 3,710 | 0.07~0.15 | 40 | 4,240 | 0.1~0.2 |
| | 4 | 40 | 3,180 | 0.1~0.2 | 45 | 3,580 | 0.15~0.25 |
| | 5 | 40 | 2,250 | 0.1~0.2 | 45 | 2,860 | 0.15~0.25 |
| | 6 | 45 | 2,390 | 0.15~0.25 | 50 | 2,650 | 0.2~0.3 |
| | 8 | 45 | 1,790 | 0.15~0.25 | 50 | 1,990 | 0.2~0.3 |
| | 10 | 50 | 1,590 | 0.2~0.3 | 55 | 1,750 | 0.25~0.35 |
| | 12 | 50 | 1,330 | 0.2~0.3 | 55 | 1,460 | 0.25~0.35 |
| | 13 | 55 | 1,350 | 0.2~0.3 | 60 | 1,470 | 0.25~0.35 |
| | 14 | 55 | 1,250 | 0.2~0.3 | 60 | 1,360 | 0.25~0.35 |
| | 16 | 55 | 1,090 | 0.25~0.35 | 60 | 1,190 | 0.3~0.4 |
| | 18 | 55 | 970 | 0.25~0.35 | 60 | 1,060 | 0.3~0.4 |
| | 20 | 55 | 880 | 0.3~0.4 | 60 | 950 | 0.35~0.45 |

1. Данные режимы приведены при использовании СОЖ на водной основе. Рекомендуется использовать СОЖ для тяжелых условий обработки.

2. Рекомендуется использовать с прецизионными фрезерными патронами.