

# PRODUCT NEWS

No. 524

## 新製品

NEW PRODUCT

**NEW**

高硬度材加工用

《EZシリーズ》

**DIJET**<sup>®</sup>

## EZ HARD DRILL DH coat

EZ ハードドリル

EZH形

- 金型高硬度材などの高能率穴あけ加工用
- 高硬度材用新コーティング被膜「DH1」  
採用により耐摩耗性向上



**ダイジェット工業株式会社**

## Features

### Features 1

## Stable drilling high hardened materials up to 70HRC.

By adopting "DH1" coating which provides high hardness & oxidization resistance, improved wear resistance and gives longer tool life.

Adopting micro grain carbide with high toughness, improved chipping resistance.

Added corner radius at outer corner.

### Features 2

## High drill rigidity

The web thickness is 1.6 times or more than that of previous carbide drills

Adopted helix angle 15 degrees

### Features 3

## Incredibly strong against chipping

The chipping resistance has been improved with 15° helix angle and a corner radius on the outer corner.

The chipping resistance on the center edge and chip evacuation has been improved with a thinning shape suitable for hard materials.

Exclusive thinning for high hardened material

Web thickness is 1.6 times more (compare with normal carbide solid drill)

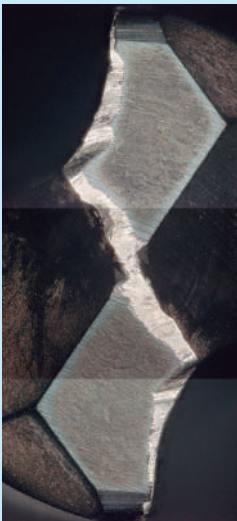
## Newly developed "DH1 COATING"

DH1 COATING gives stable and high-performance machining on high hardened materials even with high speed dry condition, due to higher hardness and higher oxidation resistance than the existing PVD coating.

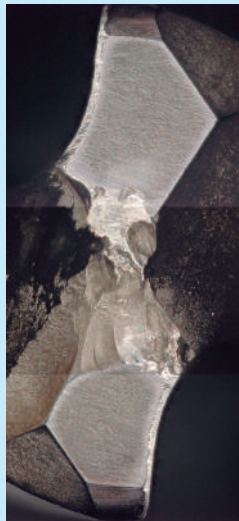
### Characteristic value of various PVD coatings

	DH1 coating	DV coating	DZ coating
Hardness	3,500~3,700	3,300~3,500	2,800~2,900
Oxidization temperature	1,100~1,200	1,000~1,100	700~800
Coefficient of friction	0.5	0.65	0.6

## Cutting performance



**EZH5D0700S08**  
After 180 holes

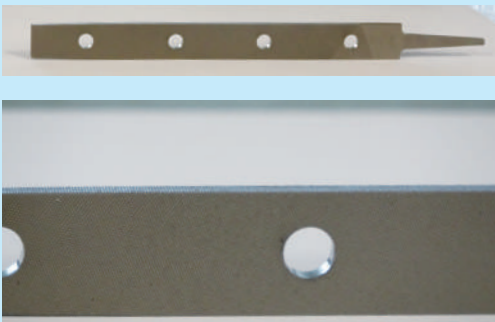


**Conventional**  
After 110 holes

#### Material: Hardened die steel 1.2344 (60HRC)

Cutting conditions: Vertical MC

- Drill dia.:  $\phi 7$  (EZH5D0700S08)
- Cutting conditions:  $n=455\text{min}^{-1}$ ,  $V_c=10\text{m/min}$ ,  $V_f=23\text{mm/min}$ ,  $f=0.05\text{mm/rev}$
- Drilling depth: 23mm (Thru)
- Coolant: Water soluble



#### Material: File (68HRC)

Cutting conditions: Vertical MC

- Drill dia.:  $\phi 10$  (EZH5D1000S010)
- Cutting conditions:  $n=382\text{min}^{-1}$ ,  $V_c=12\text{m/min}$ ,  $f=0.04\text{mm/rev}$
- Drilling depth: 6mm (Thru)
- Coolant: Mist

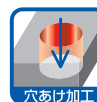
Video→



## Line up

## EZ HARD DRILL EZH type

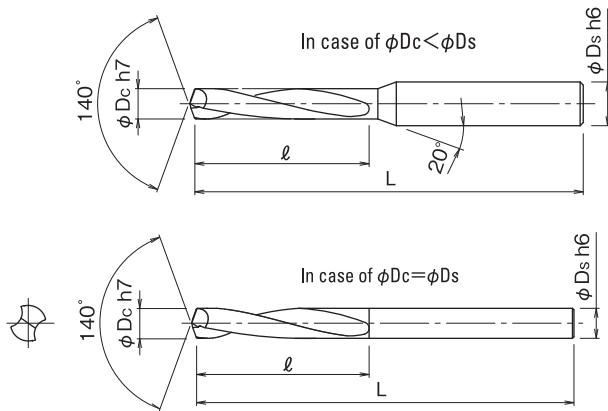
- For high hardened steel up to 70HRC.
- Drilling depth: 5D
- Helix angle: 15°



Cat. No.	Stock	Dimensions (mm)			
		φDc	ℓ	L	φDs
EZH5D0200S03	●	2	16	55	3
EZH5D0200S03-12	●	2	12	55	3
EZH5D0200S03-21	●	2	21	55	3
EZH5D0205S03	□	2.05	16	55	3
EZH5D0210S03	●	2.1	16	55	3
EZH5D0215S03	□	2.15	16	55	3
EZH5D0220S03	●	2.2	16	55	3
EZH5D0225S03	□	2.25	16	55	3
EZH5D0230S03	●	2.3	16	55	3
EZH5D0235S03	□	2.35	16	55	3
EZH5D0240S03	●	2.4	16	55	3
EZH5D0245S03	□	2.45	16	55	3
EZH5D0250S03	●	2.5	16	55	3
EZH5D0250S03-21	●	2.5	21	55	3
EZH5D0255S03	□	2.55	16	55	3
EZH5D0260S03	●	2.6	16	55	3
EZH5D0265S03	□	2.65	16	55	3
EZH5D0270S03	●	2.7	16	55	3
EZH5D0275S03	□	2.75	16	55	3
EZH5D0280S03	●	2.8	16	55	3
EZH5D0285S03	□	2.85	16	55	3
EZH5D0290S03	●	2.9	16	55	3
EZH5D0295S04	□	2.95	21	59	4
EZH5D0300S04	●	3	21	59	4
EZH5D0305S04	□	3.05	24	59	4
EZH5D0310S04	□	3.1	24	59	4
EZH5D0315S04	□	3.15	24	59	4

Cat. No.	Stock	Dimensions (mm)			
		φDc	ℓ	L	φDs
EZH5D0320S04	□	3.2	24	59	4
EZH5D0325S04	□	3.25	24	59	4
EZH5D0330S04	●	3.3	24	59	4
EZH5D0335S04	□	3.35	24	59	4
EZH5D0340S04	●	3.4	24	59	4
EZH5D0345S04	□	3.45	24	59	4
EZH5D0350S04	●	3.5	24	59	4
EZH5D0355S04	□	3.55	27	59	4
EZH5D0360S04	□	3.6	27	59	4
EZH5D0365S04	□	3.65	27	59	4
EZH5D0370S04	□	3.7	27	59	4
EZH5D0375S04	□	3.75	27	59	4
EZH5D0380S04	●	3.8	27	59	4
EZH5D0385S04	□	3.85	27	59	4
EZH5D0390S04	●	3.9	27	59	4
EZH5D0395S04	□	3.95	27	59	4
EZH5D0400S04	●	4	27	59	4
EZH5D0405S06	□	4.05	29	74	6
EZH5D0410S06	□	4.1	29	74	6
EZH5D0415S06	□	4.15	29	74	6
EZH5D0420S06	●	4.2	29	74	6
EZH5D0425S06	□	4.25	29	74	6
EZH5D0430S06	●	4.3	29	74	6
EZH5D0435S06	□	4.35	29	74	6
EZH5D0440S06	●	4.4	29	74	6
EZH5D0445S06	□	4.45	29	74	6
EZH5D0450S06	●	4.5	29	74	6

●: Standard Stock items □: Exclusive distributor stock items



● Tolerance for  $\phi D_c$

Tool dia. $\phi D_c$	Tolerance
3 Up to	0 -0.01
3 Over 6 Up to	0 -0.012
6 Over 10 Up to	0 -0.015
10 Over 18 Up to	0 -0.018

Cat. No.	Stock	Dimensions (mm)			
		$\phi D_c$	$\ell$	L	$\phi D_s$
EZH5D0455S06	□	4.55	32	74	6
EZH5D0460S06	□	4.6	32	74	6
EZH5D0465S06	□	4.65	32	74	6
EZH5D0470S06	□	4.7	32	74	6
EZH5D0475S06	□	4.75	32	74	6
EZH5D0480S06	□	4.8	32	74	6
EZH5D0485S06	□	4.85	32	74	6
EZH5D0490S06	●	4.9	32	74	6
EZH5D0495S06	□	4.95	32	74	6
EZH5D0500S06	●	5	32	74	6
EZH5D0505S06	□	5.05	34	79	6
EZH5D0510S06	●	5.1	34	79	6
EZH5D0515S06	□	5.15	34	79	6
EZH5D0520S06	●	5.2	34	79	6
EZH5D0525S06	□	5.25	34	79	6
EZH5D0530S06	□	5.3	34	79	6
EZH5D0535S06	□	5.35	34	79	6
EZH5D0540S06	□	5.4	34	79	6
EZH5D0545S06	□	5.45	34	79	6
EZH5D0550S06	□	5.5	34	79	6
EZH5D0555S06	□	5.55	36	79	6
EZH5D0560S06	□	5.6	36	79	6
EZH5D0565S06	□	5.65	36	79	6
EZH5D0570S06	□	5.7	36	79	6
EZH5D0575S06	□	5.75	36	79	6
EZH5D0580S06	□	5.8	36	79	6
EZH5D0585S06	□	5.85	36	79	6
EZH5D0590S06	●	5.9	36	79	6
EZH5D0595S06	□	5.95	41	79	6

Cat. No.	Stock	Dimensions (mm)			
		$\phi D_c$	$\ell$	L	$\phi D_s$
EZH5D0600S06	●	6	41	79	6
EZH5D0605S08	□	6.05	41	88	8
EZH5D0610S08	□	6.1	41	88	8
EZH5D0615S08	□	6.15	41	88	8
EZH5D0620S08	□	6.2	41	88	8
EZH5D0625S08	□	6.25	41	88	8
EZH5D0630S08	□	6.3	41	88	8
EZH5D0635S08	□	6.35	41	88	8
EZH5D0640S08	□	6.4	41	88	8
EZH5D0645S08	□	6.45	41	88	8
EZH5D0650S08	□	6.5	41	88	8
EZH5D0655S08	□	6.55	43	88	8
EZH5D0660S08	□	6.6	43	88	8
EZH5D0665S08	□	6.65	43	88	8
EZH5D0670S08	□	6.7	43	88	8
EZH5D0675S08	□	6.75	43	88	8
EZH5D0680S08	●	6.8	43	88	8
EZH5D0685S08	□	6.85	43	88	8
EZH5D0690S08	●	6.9	43	88	8
EZH5D0695S08	□	6.95	43	88	8
EZH5D0700S08	●	7	43	88	8
EZH5D0705S08	□	7.05	45	93	8
EZH5D0710S08	□	7.1	45	93	8
EZH5D0715S08	□	7.15	45	93	8
EZH5D0720S08	□	7.2	45	93	8
EZH5D0725S08	□	7.25	45	93	8
EZH5D0730S08	□	7.3	45	93	8
EZH5D0735S08	□	7.35	45	93	8

## Line up

## EZ HARD DRILL EZH type

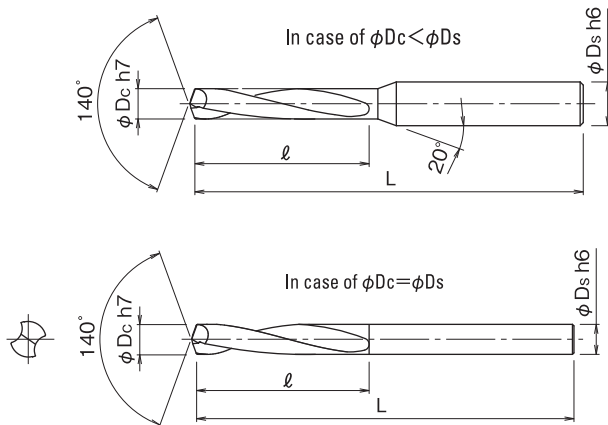
- For high hardened steel up to 70HRC.
- Drilling depth: 5D
- Helix angle: 15°



Cat. No.	Stock	Dimensions (mm)			
		φDc	ℓ	L	φDs
EZH5D0740S08	□	7.4	45	93	8
EZH5D0745S08	□	7.45	45	93	8
EZH5D0750S08	□	7.5	45	93	8
EZH5D0755S08	□	7.55	48	93	8
EZH5D0760S08	□	7.6	48	93	8
EZH5D0765S08	□	7.65	48	93	8
EZH5D0770S08	□	7.7	48	93	8
EZH5D0775S08	□	7.75	48	93	8
EZH5D0780S08	□	7.8	48	93	8
EZH5D0785S08	□	7.85	48	93	8
EZH5D0790S08	●	7.9	48	93	8
EZH5D0795S08	□	7.95	48	93	8
EZH5D0800S08	●	8	48	93	8
EZH5D0805S10	□	8.05	53	98	10
EZH5D0810S10	□	8.1	53	98	10
EZH5D0815S10	□	8.15	53	98	10
EZH5D0820S10	□	8.2	53	98	10
EZH5D0825S10	□	8.25	53	98	10
EZH5D0830S10	□	8.3	53	98	10
EZH5D0835S10	□	8.35	53	98	10
EZH5D0840S10	□	8.4	53	98	10
EZH5D0845S10	□	8.45	53	98	10
EZH5D0850S10	●	8.5	53	98	10
EZH5D0855S10	□	8.55	55	98	10
EZH5D0860S10	●	8.6	55	98	10
EZH5D0865S10	□	8.65	55	98	10
EZH5D0870S10	□	8.7	55	98	10
EZH5D0875S10	□	8.75	55	98	10
EZH5D0880S10	□	8.8	55	98	10

Cat. No.	Stock	Dimensions (mm)			
		φDc	ℓ	L	φDs
EZH5D0885S10	□	8.85	55	98	10
EZH5D0890S10	□	8.9	55	98	10
EZH5D0895S10	□	8.95	55	98	10
EZH5D0900S10	●	9	55	98	10
EZH5D0905S10	□	9.05	58	108	10
EZH5D0910S10	□	9.1	58	108	10
EZH5D0915S10	□	9.15	58	108	10
EZH5D0920S10	□	9.2	58	108	10
EZH5D0925S10	□	9.25	58	108	10
EZH5D0930S10	□	9.3	58	108	10
EZH5D0935S10	□	9.35	58	108	10
EZH5D0940S10	□	9.4	58	108	10
EZH5D0945S10	□	9.45	58	108	10
EZH5D0950S10	□	9.5	58	108	10
EZH5D0955S10	□	9.55	60	108	10
EZH5D0960S10	□	9.6	60	108	10
EZH5D0965S10	□	9.65	60	108	10
EZH5D0970S10	□	9.7	60	108	10
EZH5D0975S10	□	9.75	60	108	10
EZH5D0980S10	□	9.8	60	108	10
EZH5D0985S10	□	9.85	60	108	10
EZH5D0990S10	●	9.9	60	108	10
EZH5D0995S10	□	9.95	60	108	10
EZH5D1000S10	●	10	60	108	10
EZH5D1005S12	□	10.05	66	117	12
EZH5D1010S12	□	10.1	66	117	12
EZH5D1015S12	□	10.15	66	117	12
EZH5D1020S12	□	10.2	66	117	12

●: Standard Stock items □: Exclusive distributor stock items



● Tolerance for  $\phi D_c$

Tool dia. $\phi D_c$	Tolerance
3 Up to	0 -0.01
3 Over 6 Up to	0 -0.012
6 Over 10 Up to	0 -0.015
10 Over 18 Up to	0 -0.018

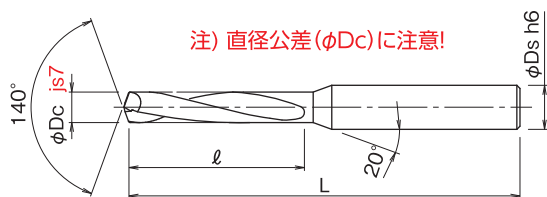
Cat. No.	Stock	Dimensions (mm)			
		$\phi D_c$	$\ell$	L	$\phi D_s$
EZH5D1025S12	□	10.25	66	117	12
EZH5D1030S12	●	10.3	66	117	12
EZH5D1035S12	□	10.35	66	117	12
EZH5D1040S12	●	10.4	66	117	12
EZH5D1045S12	□	10.45	66	117	12
EZH5D1050S12	□	10.5	66	117	12
EZH5D1055S12	□	10.55	68	117	12
EZH5D1060S12	□	10.6	68	117	12
EZH5D1065S12	□	10.65	68	117	12
EZH5D1070S12	□	10.7	68	117	12
EZH5D1075S12	□	10.75	68	117	12
EZH5D1080S12	□	10.8	68	117	12
EZH5D1085S12	□	10.85	68	117	12
EZH5D1090S12	□	10.9	68	117	12
EZH5D1095S12	□	10.95	68	117	12
EZH5D1100S12	●	11	68	117	12
EZH5D1105S12	□	11.05	71	117	12
EZH5D1110S12	□	11.1	71	117	12
EZH5D1120S12	□	11.2	71	117	12
EZH5D1130S12	□	11.3	71	117	12
EZH5D1140S12	□	11.4	71	117	12
EZH5D1150S12	□	11.5	71	117	12
EZH5D1160S12	□	11.6	73	117	12
EZH5D1170S12	□	11.7	73	117	12
EZH5D1180S12	□	11.8	73	117	12
EZH5D1190S12	●	11.9	73	117	12
EZH5D1200S12	●	12	73	117	12
EZH5D1205S14	□	12.05	74	130	14

Cat. No.	Stock	Dimensions (mm)			
		$\phi D_c$	$\ell$	L	$\phi D_s$
EZH5D1210S14	□	12.1	74	130	14
EZH5D1220S14	□	12.2	74	130	14
EZH5D1250S14	□	12.5	74	130	14
EZH5D1260S14	□	12.6	74	135	14
EZH5D1270S14	□	12.7	74	135	14
EZH5D1280S14	□	12.8	74	135	14
EZH5D1290S14	□	12.9	74	135	14
EZH5D1300S14	□	13	74	135	14
EZH5D1305S14	□	13.05	78	140	14
EZH5D1310S14	□	13.1	78	140	14
EZH5D1350S14	□	13.5	78	140	14
EZH5D1400S14	□	14	80	140	14
EZH5D1410S15	□	14.1	82	145	15
EZH5D1450S15	□	14.5	82	145	15
EZH5D1460S15	□	14.6	82	150	15
EZH5D1500S15	□	15	85	150	15
EZH5D1510S16	□	15.1	90	155	16
EZH5D1550S16	□	15.5	90	155	16
EZH5D1560S16	□	15.6	95	160	16
EZH5D1580S16	□	15.8	95	160	16
EZH5D1590S16	□	15.9	95	160	16
EZH5D1600S16	□	16	95	160	16
EZH5D1610S16	□	16.1	100	165	16

## Line up

## EZ HARD DRILL 0.02 Over series

- For high hardened steel up to 70HRC.
- Drilling depth: 5D
- Helix angle: 15°



- Tolerance for  $\phi Dc$

Tool dia. $\phi Dc$	Tolerance
3 under	$\pm 0.005$
From 3 to 6	$\pm 0.006$
From 6 to 10	$\pm 0.007$
10 over	$\pm 0.009$

Cat. No.	Stock	Dimensions (mm)			
		$\phi Dc$	$\ell$	L	$\phi Ds$
EZH5D0202S03	<input type="checkbox"/>	2.02	16	55	3
EZH5D0252S03	<input type="checkbox"/>	2.52	16	55	3
EZH5D0302S04	<input type="checkbox"/>	3.02	24	59	4
EZH5D0352S04	<input type="checkbox"/>	3.52	27	59	4
EZH5D0402S06	<input type="checkbox"/>	4.02	29	74	6
EZH5D0452S06	<input type="checkbox"/>	4.52	32	74	6
EZH5D0502S06	<input type="checkbox"/>	5.02	34	79	6
EZH5D0602S08	<input type="checkbox"/>	6.02	41	88	8
EZH5D0702S08	<input type="checkbox"/>	7.02	45	93	8
EZH5D0802S10	<input type="checkbox"/>	8.02	53	98	10
EZH5D0902S10	<input type="checkbox"/>	9.02	58	108	10

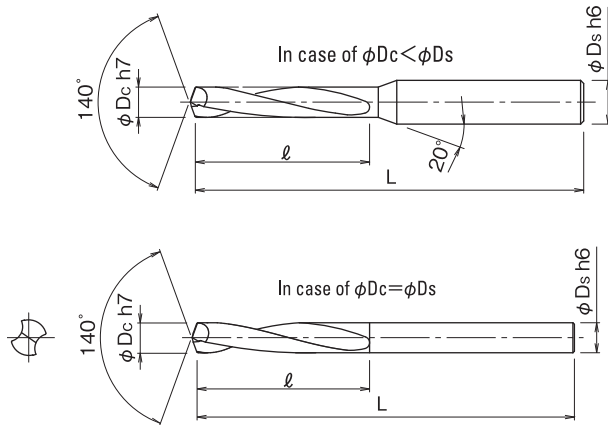
Cat. No.	Stock	Dimensions (mm)			
		$\phi Dc$	$\ell$	L	$\phi Ds$
EZH5D1002S12	<input type="checkbox"/>	10.02	66	117	12
EZH5D1102S12	<input type="checkbox"/>	11.02	71	117	12
EZH5D1202S14	<input type="checkbox"/>	12.02	74	130	14
EZH5D1302S14	<input type="checkbox"/>	13.02	78	140	14
EZH5D1402S15	<input type="checkbox"/>	14.02	82	145	15
EZH5D1502S15	<input type="checkbox"/>	15.02	85	155	15
EZH5D1602S16	<input type="checkbox"/>	16.02	100	165	16

●: Standard Stock items    □: Exclusive distributor stock items

## Line up

### ● EZ HARD DRILL EZH-LS type

- For high hardened steel up to 70HRC.
- Drilling depth: 5D
- Helix angle: 15°



- Tolerance for  $\phi D_c$

Tool dia. $\phi D_c$	Tolerance
3 Up to	0 -0.01
3 Over 6 Up to	0 -0.012
6 Over 10 Up to	0 -0.015
10 Over 18 Up to	0 -0.018

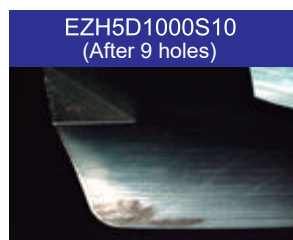
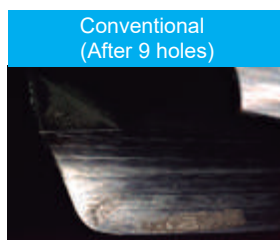
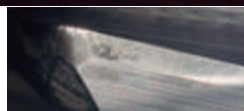
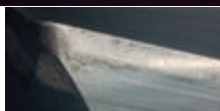
Cat. No.	Stock	Dimensions (mm)			
		$\phi D_c$	$\ell$	L	$\phi D_s$
EZH5D0300S04-LS	●	3	25	69	4
EZH5D0310S04-LS	□	3.1	25	69	4
EZH5D0320S04-LS	□	3.2	25	69	4
EZH5D0330S04-LS	●	3.3	25	79	4
EZH5D0340S04-LS	□	3.4	25	79	4
EZH5D0350S04-LS	□	3.5	25	79	4
EZH5D0360S04-LS	□	3.6	30	79	4
EZH5D0370S04-LS	□	3.7	30	79	4
EZH5D0380S04-LS	●	3.8	30	79	4
EZH5D0390S04-LS	□	3.9	30	79	4
EZH5D0400S04-LS	●	4	30	79	4

Cat. No.	Stock	Dimensions (mm)			
		$\phi D_c$	$\ell$	L	$\phi D_s$
EZH5D0410S05-LS	□	4.1	30	85	5
EZH5D0420S05-LS	□	4.2	30	85	5
EZH5D0430S05-LS	□	4.3	30	85	5
EZH5D0440S05-LS	□	4.4	30	85	5
EZH5D0450S05-LS	□	4.5	30	85	5
EZH5D0460S05-LS	□	4.6	35	85	5
EZH5D0470S05-LS	□	4.7	35	85	5
EZH5D0480S05-LS	□	4.8	35	85	5
EZH5D0490S05-LS	□	4.9	35	85	5
EZH5D0500S05-LS	□	5	35	85	5

●: Standard Stock items □: Exclusive distributor stock items

## Cutting data

## Drilling for Die steel ( After quenching)

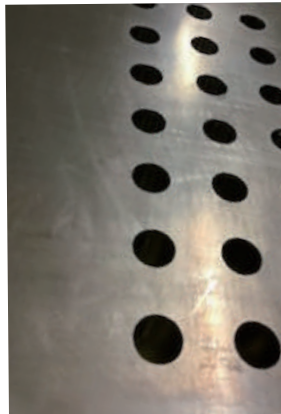
EZH5D1000S10  
(After 9 holes)Conventional  
(After 9 holes)

## Result

Possible to drill after 9 holes with EZH5D1000S10  
Achieved 100 holes, still able to continue.

Work	Part name	Test piece	
	Material	Die steel DC53	
	Hardness	59.5HRC	
Tool	Cat.No.	EZH5D1000S10(φ10)	
	Grade	DH coating	
Cutting conditions	Spindle speed	$n$	$n=299\text{min}^{-1}$
	Cutting speed	$V_c$	$V_c=9.4\text{m/min}$
	Feed speed	$V_f$	$V_f=15\text{mm/min}$
	Feed	$f$	$f=0.05\text{mm/rev}$
	Drilling depth	30mm (Blind)	
	Coolant	Water soluble (external)	
	Machine	VerticalMC	

## Drilling for high hardened materials



## Result

Changing tool from end mill(helical milling) to drilling  
possible to reduce machining time.  
Achieved 82 holes(Blind) continuous machining.  
EZ HARD DRILL achieved more than 4 times longer tool life  
compared with competitors

Work	Part name	Test piece	
	Material	Tool steel (SKD11)	
	Hardness	60HRC	
Tool	Cat.No.	EZH5D1200S12(φ12)	
	Grade	DH coating	
Cutting conditions	Spindle speed	$n$	$n=345\text{min}^{-1}$
	Cutting speed	$V_c$	$V_c=13\text{m/min}$
	Feed speed	$V_f$	$V_f=26\text{mm/min}$
	Feed	$f$	$f=0.075\text{mm/rev}$
	Drilling depth	40mm (Blind)	
	Clamp	Good	
	Coolant	Water soluble (external)	
	Machine	VerticalMC	

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## Recommended cutting conditions

Work material	Hardened die steel (1.2344, 1.2379) 48~56HRC		Hardened die steel (1.2344, 1.2379) 57~62HRC		High speed tool steel (1.3343) 63~70HRC	
Vc (m/min)	15~20( $\phi$ 2) 15~25( $\phi$ 2.5~ $\phi$ 12) 10~20( $\phi$ 13 ~ $\phi$ 16)		10~15( $\phi$ 2~ $\phi$ 12) 7~13( $\phi$ 13~ $\phi$ 16)		5~10( $\phi$ 2) 7~12( $\phi$ 2.5~ $\phi$ 12) 6~10( $\phi$ 13 ~ $\phi$ 16)	
f (mm/rev)	0.03~0.05( $\phi$ 3~ $\phi$ 4) 0.04~0.06( $\phi$ 5) 0.06~0.08( $\phi$ 6~ $\phi$ 7) 0.06~0.09( $\phi$ 8~ $\phi$ 9) 0.06~0.10( $\phi$ 10~ $\phi$ 11) 0.07~0.12( $\phi$ 12~ $\phi$ 16)		0.03~0.05( $\phi$ 2~ $\phi$ 4) 0.04~0.06( $\phi$ 5) 0.05~0.07( $\phi$ 6~ $\phi$ 7) 0.05~0.08( $\phi$ 8~ $\phi$ 9) 0.05~0.09( $\phi$ 10~ $\phi$ 11) 0.05~0.10( $\phi$ 12~ $\phi$ 13) 0.07~0.12( $\phi$ 14~ $\phi$ 16)		0.02~0.04( $\phi$ 2~ $\phi$ 4) 0.03~0.05( $\phi$ 5) 0.04~0.06( $\phi$ 6~ $\phi$ 9) 0.04~0.07( $\phi$ 10~ $\phi$ 11) 0.05~0.08( $\phi$ 12~ $\phi$ 13) 0.06~0.09( $\phi$ 14~ $\phi$ 16)	
Drill dia. (mm)	n (min <sup>-1</sup> )	Vf (mm/min)	n (min <sup>-1</sup> )	Vf (mm/min)	n (min <sup>-1</sup> )	Vf (mm/min)
2	2,860	115	2,070	86	1,270	38
2.5	2,550	102	1,660	66	1,270	38
3	2,100	84	1,380	55	1,060	31
4	1,590	63	1,035	41	795	23
5	1,270	62	830	41	635	25
6	1,060	74	690	41	530	26
7	910	63	590	35	455	22
8	795	60	520	34	400	20
9	710	54	460	30	355	18
10	640	51	415	29	320	17
11	580	46	375	26	290	16
12	530	47	345	26	265	16
13	370	33	250	20	200	13
14	330	30	220	20	180	13
15	320	30	210	20	170	13
16	320	30	200	19	160	12

■Attention for use:

- 1) Use water soluble oil.
- 2) Not recommend to use for non-heat treated material. Recommend to use STRIKE DRILL(EZN type).
- 3) Recommend to use for over 50HRC up to 70HRC.
- 4) Use a rigid machine and precise holder.
- 5) This data is relevant for drilling depth at 3Dc. In case of drilling depth over 3Dc, use step feed.
- 6) Recommend to use for blind hole. In case of through hole, use back up under the work.
- 7) Above data is relevant to EZH type. In case of use for EZH5D-LS type, recommend applying lower cutting conditions.

STRIKEDRILL →



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**ご使用上の注意** 工具を安全にご使用いただくために

- 不適切な切削条件で使用しないでください。●大きな摩耗や欠けのある工具は使用しないでください。
- 切りくずの飛散、巻き付きによるケガにご注意ください。又、保護眼鏡や安全カバーをご使用ください。

**WARNING:** \*Grinding produces hazardous dust. \*To avoid adverse health, use adequate ventilation and read Material Safety Data Sheet first.  
 \*Cutting tools may fragment in use. Wear eye protection in the vicinity of their operation.

●工具仕様は、改良のため予告なく変更することがあります。 **Specification shall be changed without notice.**

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