

B6 DRILL

T-DRILL



B6 - **3** **185** - **S25**

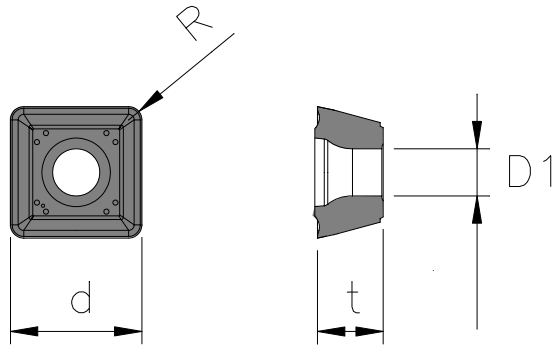
↓ ↓ ↓ ↓

드릴종류 가공깊이 가공직경 Ø18.5 상크직경 Ø25
Drill group Drilling depth 3D Drilling diameter Ø18.5 Shank diameter Ø25

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Contact
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A: 115 Young St, Carrington, NSW 2294

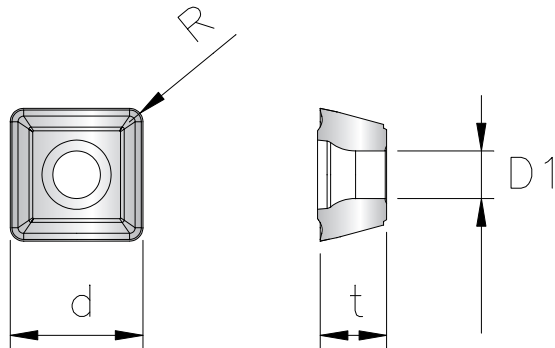
B6드릴 Insert T-DRILL



For general purpose

Order No. 주문형번	Coated	Dimension (mm)			
	6000	d	t	r	D1
SPMG 050204 DE	●	5.00	2.38	0.4	2.25
SPMG 060204 DE	●	6.00	2.38	0.4	2.61
SPMG 07T308 DE	●	7.94	3.97	0.8	2.85
SPMG 090408 DE	●	9.80	4.30	0.8	4.05
SPMG 110408 DE	●	11.50	4.80	0.8	4.45
SPMG 140512 DE	●	14.30	5.20	1.2	5.75

● : Standard item

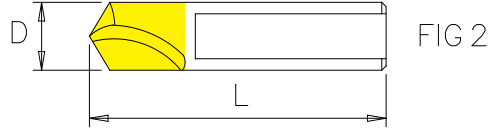
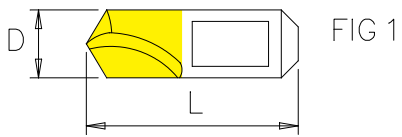


For aluminum

Order No. 주문형번	Uncoated	Dimension (mm)			
	K10	d	t	r	D1
SPGG 050204 DA	●	5.00	2.38	0.4	2.25
SPGG 060204 DA	●	6.00	2.38	0.4	2.61
SPGG 07T308 DA	●	7.94	3.97	0.8	2.85
SPGG 090408 DA	●	9.80	4.30	0.8	4.05
SPGG 110408 DA	●	11.50	4.80	0.8	4.45
SPGG 140512 DA	●	14.30	5.20	1.2	5.75

● : Standard item

PLD 드릴 Pilot Drill



• PLD ⇒ BPK

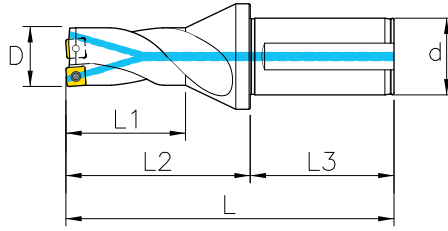
Order No. 주문형번	D	L	Coolant hole	Coating	FIG.	
PLD-V0630	6	30	X	TIN	2	
PLD-V0835	8	35	X	TIN	2	
PLD-V1035 - H	10	35	💧	TIN	2	
PLD-V1238 - H	12	38	💧	TIN	2	
PLD-V1645 - H	16	45	💧	TIN	2	
PLD-2045 - H	20	45	💧	TIN	2	
PLD-2556 - H	25	56	💧	TIN	2	
PLD-3068 - H	30	68	💧	TIN	2	
PLD-0620	6	20	X	TIN	1	
PLD-0825	8	25	X	TIN	1	
PLD-1030 - H	10	30	💧	TIN	1	
PLD-1236 - H	12	36	💧	TIN	1	

B6-2D 드릴 T-DRILL

특허 제 10-0838176
Patent #10-0838176



초경용접
Carbide welding



• INSERTS ⇒ **BPK, TAEGU-TEC**

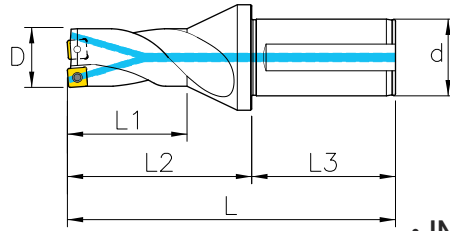
Order No. 주문형번	Dimension (mm)				Shank					
	D	L	L1	L2	d	L3				
B6-2125-S20	12.5	94	26	44	20	50	SPMG 050204	TSB-0204	TXL-06	
B6-2130-S20	13	94	26	44	20	50				
B6-2135-S20	13.5	96	28	46	20	50				
B6-2140-S20	14	96	28	46	20	50				
B6-2145-S20	14.5	99	30	49	20	50				
B6-2150-S20	15	99	30	49	20	50	SPMG 060204	TSB-22060	TXL-06	
B6-2155-S25	15.5	108	32	52	25	56				
B6-2160-S25	16	108	32	52	25	56				
B6-2165-S25	16.5	110	34	54	25	56				
B6-2170-S25	17	110	34	54	25	56				
B6-2175-S25	17.5	113	36	57	25	56				
B6-2180-S25	18	113	36	57	25	56				
B6-2185-S25	18.5	115	38	59	25	56				
B6-2190-S25	19	115	38	59	25	56				
B6-2195-S25	19.5	119	40	63	25	56				
B6-2200-S25	20	119	40	63	25	56	SPMG 07T308	TSB-25065	TXL-07	
B6-2205-S25	20.5	121	42	65	25	56				
B6-2210-S25	21	121	42	65	25	56				
B6-2215-S25	21.5	123	44	67	25	56				
B6-2220-S25	22	123	44	67	25	56				
B6-2225-S32	22.5	131	46	71	32	60				
B6-2230-S25	23	127	46	71	25	56				
B6-2230-S32	23	131	46	71	32	60				
B6-2235-S32	23.5	134	48	74	32	60				
B6-2240-S25	24	130	48	74	25	56				
B6-2240-S32	24	134	48	74	32	60				
B6-2245-S32	24.5	137	50	77	32	60				
B6-2250-S25	25	133	50	77	25	56				
B6-2250-S32	25	137	50	77	32	60				
B6-2255-S32	25.5	139	52	79	32	60				
B6-2260-S25	26	135	52	79	25	56				
B6-2260-S32	26	139	52	79	32	60				
B6-2265-S32	26.5	141	54	81	32	60				
B6-2270-S25	27	137	54	81	25	56				
B6-2270-S32	27	141	54	81	32	60				
B6-2275-S32	27.5	144	56	84	32	60				

B6-2D 드릴 T-DRILL

특허 제 10-0838176
Patent #10-0838176



초경용접
Carbide welding



• INSERTS ⇒ **BPK, TAEGU-TEC**

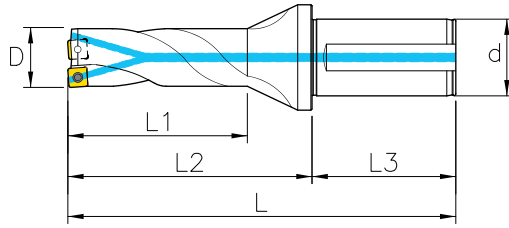
Order No. 주문형번	Dimension (mm)				Shank						
	D	L	L1	L2	d	L3					
B6-2280-S25	28	140	56	84	25	56	SPMG 090408	TSB-3508	TXL-15		
B6-2280-S32	28	144	56	84	32	60					
B6-2285-S32	28.5	146	58	86	32	60					
B6-2290-S25	29	142	58	86	25	56					
B6-2290-S32	29	146	58	86	32	60					
B6-2295-S32	29.5	151	60	91	32	60					
B6-2300-S32	30	151	60	91	32	60					
B6-2305-S32	30.5	154	62	94	32	60					
B6-2310-S32	31	154	62	94	32	60					
B6-2320-S32	32	156	64	96	32	60					
B6-2330-S32	33	159	66	99	32	60					
B6-2340-S32	34	161	68	101	32	60				SPMG 110408	TSB-0410
B6-2340-S40	34	171	68	101	40	70					
B6-2350-S32	35	164	70	104	32	60					
B6-2350-S40	35	174	70	104	40	70					
B6-2360-S32	36	167	72	107	32	60					
B6-2360-S40	36	177	72	107	40	70					
B6-2370-S32	37	170	74	110	32	60					
B6-2370-S40	37	180	74	110	40	70					
B6-2380-S32	38	173	76	113	32	60					
B6-2380-S40	38	183	76	113	40	70					
B6-2390-S32	39	175	78	115	32	60					
B6-2390-S40	39	185	78	115	40	70					
B6-2400-S32	40	178	80	118	32	60	SPMG 140512	TSB-243	TXL-20		
B6-2400-S40	40	188	80	118	40	70					
B6-2410-S32	41	181	82	121	32	60					
B6-2410-S40	41	191	82	121	40	70					
B6-2420-S32	42	183	84	123	32	60					
B6-2420-S40	42	193	84	123	40	70					
B6-2430-S32	43	186	86	126	32	60					
B6-2430-S40	43	196	86	126	40	70					
B6-2440-S32	44	188	88	128	32	60					
B6-2440-S40	44	198	88	128	40	70					
B6-2450-S32	45	192	90	132	32	60					
B6-2450-S40	45	202	90	132	40	70					
B6-2460-S32	46	195	92	135	32	60					
B6-2460-S40	46	205	92	135	40	70					
B6-2470-S32	47	197	94	137	32	60					
B6-2470-S40	47	207	94	137	40	70					
B6-2480-S32	48	200	96	140	32	60					
B6-2480-S40	48	210	96	140	40	70					
B6-2490-S32	49	202	98	142	32	60					
B6-2490-S40	49	212	98	142	40	70					
B6-2500-S32	50	205	100	145	32	60					
B6-2500-S40	50	215	100	145	40	70					

B6-3D 드릴 T-DRILL

특허 제 10-0838176
Patent #10-0838176



초경용접
Carbide welding



• INSERTS ⇒ BPK, TAEGU-TEC

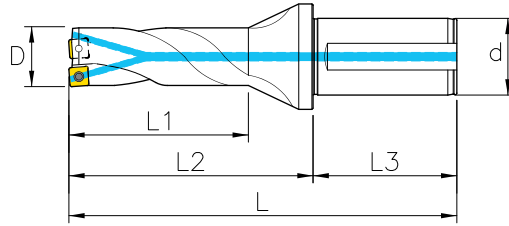
Order No. 주문형번	Dimension (mm)				Shank					
	D	L	L1	L2	d	L3				
B6-3125-S20	12.5	107	39	57	20	50	SPMG 050204	TSB-0204	TXL-06	
B6-3130-S20	13	107	39	57	20	50				
B6-3135-S20	13.5	110	42	60	20	50				
B6-3140-S20	14	110	42	60	20	50				
B6-3145-S20	14.5	114	45	64	20	50				
B6-3150-S20	15	114	45	64	20	50	SPMG 060204	TSB-22060	TXL-06	
B6-3155-S25	15.5	124	48	68	25	56				
B6-3160-S25	16	124	48	68	25	56				
B6-3165-S25	16.5	127	51	71	25	56				
B6-3170-S25	17	127	51	71	25	56				
B6-3175-S25	17.5	131	54	75	25	56				
B6-3180-S25	18	131	54	75	25	56				
B6-3185-S25	18.5	134	57	78	25	56				
B6-3190-S25	19	134	57	78	25	56				
B6-3195-S25	19.5	139	60	83	25	56				
B6-3200-S25	20	139	60	83	25	56				
B6-3205-S25	20.5	142	63	86	25	56				
B6-3210-S25	21	142	63	86	25	56				
B6-3215-S25	21.5	145	66	89	25	56				
B6-3220-S25	22	145	66	89	25	56				SPMG 07T308
B6-3225-S32	22.5	154	69	94	32	60				
B6-3230-S25	23	150	69	94	25	56				
B6-3230-S32	23	154	69	94	32	60				
B6-3235-S32	23.5	158	72	98	32	60				
B6-3240-S25	24	154	72	98	25	56				
B6-3240-S32	24	158	72	98	32	60				
B6-3245-S32	24.5	162	75	102	32	60				
B6-3250-S25	25	158	75	102	25	56				
B6-3250-S32	25	162	75	102	32	60				
B6-3255-S32	25.5	165	78	105	32	60				
B6-3260-S25	26	161	78	105	25	56				
B6-3260-S32	26	165	78	105	32	60				
B6-3265-S32	26.5	168	81	108	32	60				
B6-3270-S25	27	164	81	108	25	56				
B6-3270-S32	27	168	81	108	32	60				
B6-3275-S32	27.5	172	84	112	32	60				

B6-3D 드릴 T-DRILL

특허 제 10-0838176
Patent #10-0838176



초경용접
Carbide welding



• INSERTS ⇒ **BPK, TAEGU-TEC**

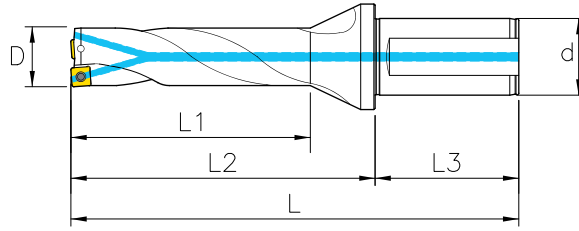
Order No. 주문형번	Dimension (mm)				Shank					
	D	L	L1	L2	d	L3				
B6-3280-S25	28	168	84	112	25	56	SPMG 090408	TSB-3508	TXL-15	
B6-3280-S32	28	172	84	112	32	60				
B6-3285-S32	28.5	175	87	115	32	60				
B6-3290-S25	29	171	87	115	25	56				
B6-3290-S32	29	175	87	115	32	60				
B6-3295-S32	29.5	181	90	121	32	60				
B6-3300-S32	30	181	90	121	32	60				
B6-3305-S32	30.5	185	93	125	32	60				
B6-3310-S32	31	185	93	125	32	60				
B6-3320-S32	32	188	96	128	32	60				
B6-3330-S32	33	192	99	132	32	60				
B6-3340-S32	34	195	102	135	32	60				SPMG 110408
B6-3340-S40	34	205	102	135	40	70				
B6-3350-S32	35	199	105	139	32	60				
B6-3350-S40	35	209	105	139	40	70				
B6-3360-S32	36	203	108	143	32	60				
B6-3360-S40	36	213	108	143	40	70				
B6-3370-S32	37	207	111	147	32	60				
B6-3370-S40	37	217	111	147	40	70				
B6-3380-S32	38	211	114	151	32	60				
B6-3380-S40	38	221	114	151	40	70				
B6-3390-S32	39	214	117	154	32	60				
B6-3390-S40	39	224	117	154	40	70				
B6-3400-S32	40	218	120	158	32	60	SPMG 140512	TSB-243	TXL-20	
B6-3400-S40	40	228	120	158	40	70				
B6-3410-S32	41	222	123	162	32	60				
B6-3410-S40	41	232	123	162	40	70				
B6-3420-S32	42	225	126	165	32	60				
B6-3420-S40	42	235	126	165	40	70				
B6-3430-S32	43	229	129	169	32	60				
B6-3430-S40	43	239	129	169	40	70				
B6-3440-S32	44	232	132	172	32	60				
B6-3440-S40	44	242	132	172	40	70				
B6-3450-S32	45	237	135	177	32	60				
B6-3450-S40	45	247	135	177	40	70				
B6-3460-S32	46	241	138	181	32	60				
B6-3460-S40	46	251	138	181	40	70				
B6-3470-S32	47	244	141	184	32	60				
B6-3470-S40	47	254	141	184	40	70				
B6-3480-S32	48	248	144	188	32	60				
B6-3480-S40	48	258	144	188	40	70				
B6-3490-S32	49	251	147	191	32	60				
B6-3490-S40	49	261	147	191	40	70				
B6-3500-S32	50	255	150	195	32	60				
B6-3500-S40	50	265	150	195	40	70				

B6-4D 드릴 T-DRILL

특허 제 10-0838176
Patent #10-0838176



초경용접
Carbide welding



• INSERTS ⇒ BPK, TAEGU-TEC

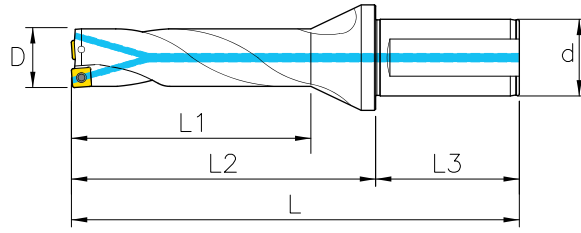
Order No. 주문형번	Dimension (mm)				Shank					
	D	L	L1	L2	d	L3				
B6-4125-S20	12.5	120	52	70	20	50	SPMG 050204	TSB-0204	TXL-06	
B6-4130-S20	13	120	52	70	20	50				
B6-4135-S20	13.5	124	56	74	20	50				
B6-4140-S20	14	124	56	74	20	50				
B6-4145-S20	14.5	129	60	79	20	50				
B6-4150-S20	15	129	60	79	20	50	SPMG 060204	TSB-22060	TXL-06	
B6-4155-S25	15.5	140	64	84	25	56				
B6-4160-S25	16	140	64	84	25	56				
B6-4165-S25	16.5	144	68	88	25	56				
B6-4170-S25	17	144	68	88	25	56				
B6-4175-S25	17.5	149	72	93	25	56				
B6-4180-S25	18	149	72	93	25	56				
B6-4185-S25	18.5	153	76	97	25	56				
B6-4190-S25	19	153	76	97	25	56				
B6-4195-S25	19.5	159	80	103	25	56				
B6-4200-S25	20	159	80	103	25	56	SPMG 07T308	TSB-25065	TXL-07	
B6-4205-S25	20.5	163	84	107	25	56				
B6-4210-S25	21	163	84	107	25	56				
B6-4215-S25	21.5	167	88	111	25	56				
B6-4220-S25	22	167	88	111	25	56				
B6-4225-S32	22.5	177	92	117	32	60				
B6-4230-S25	23	173	92	117	25	56				
B6-4230-S32	23	177	92	117	32	60				
B6-4235-S32	23.5	182	96	122	32	60				
B6-4240-S25	24	178	96	122	25	56				
B6-4240-S32	24	182	96	122	32	60				
B6-4245-S32	24.5	187	100	127	32	60				
B6-4250-S25	25	183	100	127	25	56				
B6-4250-S32	25	187	100	127	32	60				
B6-4255-S32	25.5	191	104	131	32	60				
B6-4260-S25	26	187	104	131	25	56				
B6-4260-S32	26	191	104	131	32	60				
B6-4265-S32	26.5	195	108	135	32	60				
B6-4270-S25	27	191	108	135	25	56				
B6-4270-S32	27	195	108	135	32	60				
B6-4275-S32	27.5	200	112	140	32	60				

B6-4D 드릴 T-DRILL

특허 제 10-0838176
Patent #10-0838176



초경용접
Carbide welding



• INSERTS ⇒ **BPK, TAEGU-TEC**

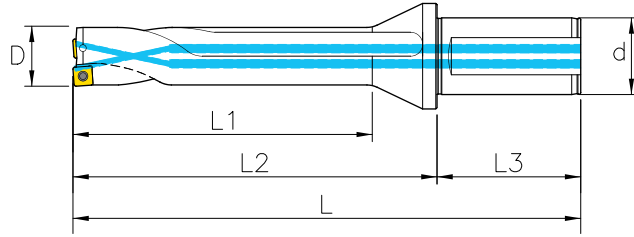
Order No. 주문형번	Dimension (mm)				Shank								
	D	L	L1	L2	d	L3							
B6-4280-S25	28	196	112	140	25	56	SPMG 090408	TSB-3508	TXL-15				
B6-4280-S32	28	200	112	140	32	60							
B6-4285-S32	28.5	204	116	144	32	60							
B6-4290-S25	29	200	116	144	25	56							
B6-4290-S32	29	204	116	144	32	60							
B6-4295-S32	29.5	211	120	151	32	60							
B6-4300-S32	30	211	120	151	32	60							
B6-4305-S32	30.5	216	124	156	32	60							
B6-4310-S32	31	216	124	156	32	60							
B6-4320-S32	32	220	128	160	32	60							
B6-4330-S32	33	225	132	165	32	60							
B6-4340-S32	34	229	136	169	32	60				SPMG 110408	TSB-0410	TXL-15	
B6-4340-S40	34	239	136	169	40	70							
B6-4350-S32	35	234	140	174	32	60							
B6-4350-S40	35	244	140	174	40	70							
B6-4360-S32	36	239	144	179	32	60							
B6-4360-S40	36	249	144	179	40	70							
B6-4370-S32	37	244	148	184	32	60							
B6-4370-S40	37	254	148	184	40	70							
B6-4380-S32	38	249	152	189	32	60							
B6-4380-S40	38	259	152	189	40	70							
B6-4390-S32	39	253	156	193	32	60	SPMG 140512	TSB-243	TXL-20				
B6-4390-S40	39	263	156	193	40	70							
B6-4400-S32	40	258	160	198	32	60							
B6-4400-S40	40	268	160	198	40	70							
B6-4410-S32	41	263	164	203	32	60							
B6-4410-S40	41	273	164	203	40	70							
B6-4420-S32	42	267	168	207	32	60							
B6-4420-S40	42	277	168	207	40	70							
B6-4430-S32	43	272	172	212	32	60							
B6-4430-S40	43	282	172	212	40	70							
B6-4440-S32	44	276	176	216	32	60							
B6-4440-S40	44	286	176	216	40	70							
B6-4450-S32	45	282	180	222	32	60							
B6-4450-S40	45	292	180	222	40	70							
B6-4460-S32	46	287	184	227	32	60							
B6-4460-S40	46	297	184	227	40	70							
B6-4470-S32	47	291	188	231	32	60							
B6-4470-S40	47	301	188	231	40	70							
B6-4480-S32	48	296	192	236	32	60							
B6-4480-S40	48	306	192	236	40	70							
B6-4490-S32	49	300	196	240	32	60							
B6-4490-S40	49	310	196	240	40	70							
B6-4500-S32	50	305	200	245	32	60							
B6-4500-S40	50	315	200	245	40	70							

B6K-5D 드릴 T-DRILL

특허 제 10-0838176
Patent #10-0838176



초경용접
Carbide welding



• INSERTS ⇒ **BPK, TAEGU-TEC**

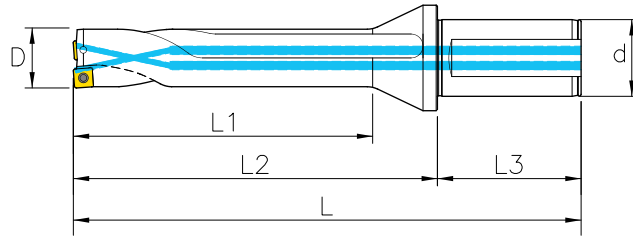
Order No. 주문형번	Dimension (mm)				Shank				
	D	L	L1	L2	d	L3			
B6K-5125-S20	12.5	133	65	83	20	50	SPMG 050204	TSB-0204	TXL-06
B6K-5130-S20	13	133	65	83	20	50			
B6K-5135-S20	13.5	138	70	88	20	50			
B6K-5140-S20	14	138	70	88	20	50			
B6K-5145-S20	14.5	144	75	94	20	50			
B6K-5150-S20	15	144	75	94	20	50			
B6K-5155-S25	15.5	156	80	100	25	56	SPMG 060204	TSB-22065	TXL-06
B6K-5160-S25	16	156	80	100	25	56			
B6K-5165-S25	16.5	161	85	105	25	56			
B6K-5170-S25	17	161	85	105	25	56			
B6K-5175-S25	17.5	167	90	111	25	56			
B6K-5180-S25	18	167	90	111	25	56			
B6K-5185-S25	18.5	172	95	116	25	56			
B6K-5190-S25	19	172	95	116	25	56			
B6K-5195-S25	19.5	179	100	123	25	56			
B6K-5200-S25	20	179	100	123	25	56			
B6K-5205-S25	20.5	184	105	128	25	56			
B6K-5210-S25	21	184	105	128	25	56			
B6K-5215-S25	21.5	189	110	133	25	56			
B6K-5220-S25	22	189	110	133	25	56			
B6K-5225-S32	22.5	200	115	140	32	60			
B6K-5230-S25	23	196	115	140	25	56			
B6K-5230-S32	23	200	115	140	32	60			
B6K-5235-S32	23.5	206	120	146	32	60			
B6K-5240-S25	24	202	120	146	25	56			
B6K-5240-S32	24	206	120	146	32	60			
B6K-5245-S32	24.5	212	125	152	32	60			
B6K-5250-S25	25	208	125	152	25	56			
B6K-5250-S32	25	212	125	152	32	60			
B6K-5255-S32	25.5	217	130	157	32	60			
B6K-5260-S32	26	217	130	157	32	60			
B6K-5265-S32	26.5	222	135	162	32	60			
B6K-5270-S32	27	222	135	162	32	60			
B6K-5275-S32	27.5	228	140	168	32	60			

B6K-5D 드릴 T-DRILL

특허 제 10-0838176
Patent #10-0838176



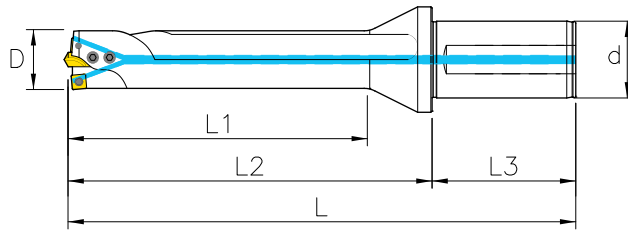
초경용접
Carbide welding








• INSERTS ⇒ BPK, TAEGU-TEC

Order No. 주문형번	Dimension (mm)				Shank		SPMG	TSB	TXL
	D	L	L1	L2	d	L3			
B6K-5280-S32	28	228	140	168	32	60	SPMG 090408	TSB-3508	TXL-15
B6K-5285-S32	28.5	233	145	173	32	60			
B6K-5290-S32	29	233	145	173	32	60			
B6K-5295-S32	29.5	241	150	181	32	60			
B6K-5300-S32	30	241	150	181	32	60			
B6K-5310-S32	31	247	155	187	32	60			
B6K-5320-S32	32	252	160	192	32	60			
B6K-5330-S32	33	258	165	198	32	60			
B6K-5340-S32	34	263	170	203	32	60			
B6K-5340-S40	34	273	170	203	40	70			
B6K-5350-S32	35	269	175	209	32	60	SPMG 110408	TSB-0410	TXL-15
B6K-5350-S40	35	279	175	209	40	70			
B6K-5360-S32	36	275	180	215	32	60			
B6K-5360-S40	36	285	180	215	40	70			
B6K-5370-S32	37	281	185	221	32	60			
B6K-5370-S40	37	291	185	221	40	70			
B6K-5380-S32	38	287	190	227	32	60			
B6K-5380-S40	38	297	190	227	40	70			
B6K-5390-S32	39	292	195	232	32	60			
B6K-5390-S40	39	302	195	232	40	70			
B6K-5400-S32	40	298	200	238	32	60	SPMG 140512	TSB-243	TXL-20
B6K-5400-S40	40	308	200	238	40	70			
B6K-5410-S32	41	304	205	244	32	60			
B6K-5410-S40	41	314	205	244	40	70			
B6K-5420-S40	42	319	210	249	40	70			
B6K-5430-S40	43	325	215	255	40	70			
B6K-5440-S40	44	330	220	260	40	70			
B6K-5450-S40	45	337	225	267	40	70			
B6K-5460-S40	46	343	230	273	40	70			
B6K-5470-S40	47	348	235	278	40	70			
B6K-5480-S40	48	354	240	284	40	70			
B6K-5490-S40	49	359	245	289	40	70			
B6K-5500-S40	50	365	250	295	40	70			

B6T-6D, 9D 드릴 Turbo Drill



• INSERTS ⇒ BPK, TAEGU-TEC

Order No. 주문형번	D	PLD	L	L1	L2	d	L3										
B6T-6180-S25	D18	PLD - 0620	191	112	135	D25	56	SPMX 050204	TSB-0204	M506SS	M506CP	TXL-06					
B6T-6190-S25	D19		197	118	141	D25	56										
B6T-6200-S25	D20		203	124	147	D25	56										
B6T-6210-S25	D21		209	130	153	D25	56										
B6T-6220-S25	D22		215	136	159	D25	56										
B6T-6230-S32	D23		228	142	168	D32	60										
B6T-6240-S32	D24		234	148	174	D32	60										
B6T-6250-S32	D25	240	154	180	D32	60	SPMX 060204	TSB-22060	M508SS	M508CP	TXL-06						
B6T-6260-S32	D26	246	160	186	D32	60											
B6T-6270-S32	D27	252	166	192	D32	60											
B6T-6280-S32	D28	258	172	198	D32	60						SPMX 07T308	TSB-25065	M608SS	M610CP	TXL-07	
B6T-6290-S32	D29	0825	264	178	204	D32											60
B6T-6300-S32	D30	270	184	210	D32	60											
B6T-9180-S25	D18	PLD - 0620	245	166	189	D25						56	SPMX 050204	TSB-0204	M506SS	M506CP	TXL-06
B6T-9190-S25	D19		254	175	198	D25	56										
B6T-9200-S25	D20		263	184	207	D25	56										
B6T-9210-S25	D21		272	193	216	D25	56										
B6T-9220-S25	D22		281	202	225	D25	56										
B6T-9230-S32	D23		297	211	237	D32	60										
B6T-9240-S32	D24		306	220	246	D32	60	SPMX 060204	TSB-22060	M508SS	M508CP	TXL-06					
B6T-9250-S32	D25	315	229	255	D32	60											
B6T-9260-S32	D26	324	238	264	D32	60											
B6T-9270-S32	D27	PLD	333	247	273	D32	60										
B6T-9280-S32	D28	-	342	256	282	D32	60						SPMX 07T308	TSB-25065	M608SS	M610CP	TXL-07
B6T-9290-S32	D29	0825	351	265	291	D32	60										
B6T-9300-S32	D30	360	274	300	D32	60											

B6-2D, 3D, 4D / B6K - 5D 드릴 절삭 데이터 B6-2D, 3D, 4D / B6K - 5D Drill Cutting Data

Material 피삭재		Speed 속도 (m/min)	Feed 이송 (mm/rev)					
			ø12.5 ~ ø15	ø15.5 ~ ø21.5	ø22 ~ ø27.5	ø28 ~ ø33	ø34 ~ ø41	ø42 ~ ø50
P 강 Steel	저탄소강 (-0.25%) (Unalloyed steel)	180 ~ 250	0.05 ~ 0.08	0.06 ~ 0.10	0.06 ~ 0.12	0.07 ~ 0.13	0.08 ~ 0.15	0.08 ~ 0.16
	고탄소강 (0.25% -) (Low - alloy steel)	160 ~ 220	0.06 ~ 0.12	0.08 ~ 0.15	0.10 ~ 0.18	0.12 ~ 0.22	0.12 ~ 0.24	0.13 ~ 0.25
	경합금강 (-HB300) (Low - alloy steel)	150 ~ 220	0.06 ~ 0.12	0.08 ~ 0.14	0.10 ~ 0.18	0.12 ~ 0.22	0.12 ~ 0.23	0.13 ~ 0.24
	고합금강 (HB300 -) (High - alloy steel)	130 ~ 180	0.06 ~ 0.10	0.06 ~ 0.12	0.08 ~ 0.15	0.09 ~ 0.16	0.10 ~ 0.17	0.11 ~ 0.19
M 스테인레스강 Stainless steel	스테인레스강 Stainless steel	170 ~ 240	0.05 ~ 0.10	0.06 ~ 0.12	0.08 ~ 0.15	0.09 ~ 0.16	0.10 ~ 0.17	0.11 ~ 0.19
K 주철 Cast iron	회주철 Grey cast iron	180 ~ 250	0.06 ~ 0.12	0.08 ~ 0.16	0.12 ~ 0.20	0.15 ~ 0.25	0.16 ~ 0.28	0.18 ~ 0.30
	구상흑연주철 Cast iron with nodular cast	130 ~ 200	0.06 ~ 0.10	0.08 ~ 0.15	0.10 ~ 0.18	0.12 ~ 0.20	0.15 ~ 0.23	0.16 ~ 0.25
N 비철금속 Nonferrous metals	알루미늄 Aluminium	330 ~ 380	0.06 ~ 0.14	0.08 ~ 0.15	0.10 ~ 0.20	0.12 ~ 0.22	0.14 ~ 0.23	0.15 ~ 0.26
S 내열합금 Super-alloys and titanium	고경도 합금강 Super-alloys and titanium	30 ~ 60	0.05 ~ 0.15	0.06 ~ 0.14	0.08 ~ 0.18	0.10 ~ 0.22	0.12 ~ 0.22	0.14 ~ 0.24

B6T - 6D, 9D 드릴 절삭 데이터 B6T-6D, 9D Drill Cutting Data

Material 피삭재		Speed 속도 (m/min)	Feed 이송 (mm/rev)	
			ø 18 ~ ø 25	ø 26 ~ ø 30
P 강 Steel	저탄소강 (-0.25%) Unalloyed steel	130 ~ 190	0.06 ~ 0.10	0.07 ~ 0.11
	고탄소강 (0.25% -) Low - alloy steel	130 ~ 190	0.06 ~ 0.10	0.07 ~ 0.11
	경합금강 (-HB300) Low - alloy steel	100 ~ 140	0.06 ~ 0.10	0.07 ~ 0.11
	고합금강 (HB300 -) High - alloy steel	60 ~ 100	0.05 ~ 0.07	0.05 ~ 0.07
M 스테인레스강 Stainless steel	스테인레스강 Stainless steel	60 ~ 110	0.04 ~ 0.07	0.04 ~ 0.11
K 주철 Cast iron	회주철 Grey cast iron	130 ~ 190	0.07 ~ 0.13	0.07 ~ 0.15
	구상흑연주철 Cast iron with nodular cast	110 ~ 190	0.04 ~ 0.13	0.07 ~ 0.15
N 비철금속 Nonferrous metals	알루미늄 단조강 Aluminium forging alloys	200 ~ 300	0.04 ~ 0.06	0.07 ~ 0.12
	알루미늄 주물강 Aluminium cast alloys	140 ~ 300	0.04 ~ 0.06	0.06 ~ 0.12

B6 드릴 기술자료 B6 Drill Technical data

B6 드릴 추천 절삭유압 Recommended coolant supply for B6 drill

■ 드릴 작업시 추천 절삭유압을 공급하여야 합니다.

It is important to ensure that the recommended coolant pressure is applied.

- 절삭유압이 낮을 시 드릴 가공시 드릴이 떨며 공구 수명이 단축됩니다.

Low pressure can cause vibration and reduced tool life

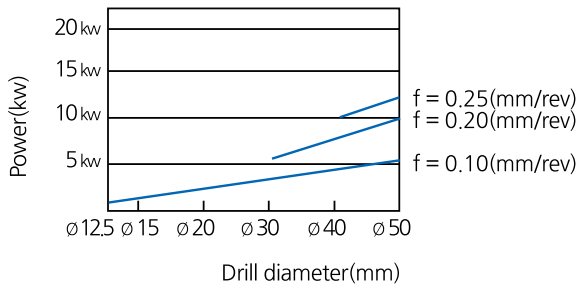
- 2D, 3D의 경우 최소 4kg/cm 이며 4D, 5D의 경우 최소 5kg/cm 입니다.

The recommended minimum pressure is 4Kg/cm for 2D and 3D and for the 4D and 5D minimum recommended pressure is 5kg/cm

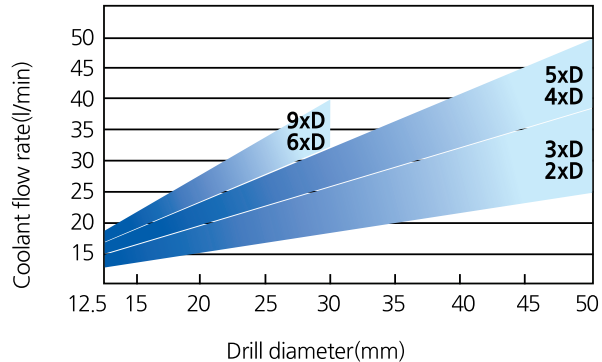
실 소비 전력과 절삭유압 Net power consumption & coolant



실 소비 전력
Net power consumption



절삭유압
Coolant volume



문제 발생시 Trouble shooting



칩 배출 관련 문제점
The Problems of chip evacuation



해결책
Solution

길고 늘어지는 칩
Long chip



P 연한 피삭재
Soft materials
저탄소강
Low carbon steel

M 써스
SUS

회전 speed ↑ 이송 feed ↓

P 합금강
Alloy steel
탄소강
Carbon steel

회전 speed ↑ 이송 feed —

짧거나 붙는 칩
Short or tight chip



절삭유압을 높일 것
Increase coolant pressure

회전 speed ↑ 이송 feed ↓

B6 드릴 기술자료 B6 Drill Technical data

선반 작업시 셋팅 Set-up

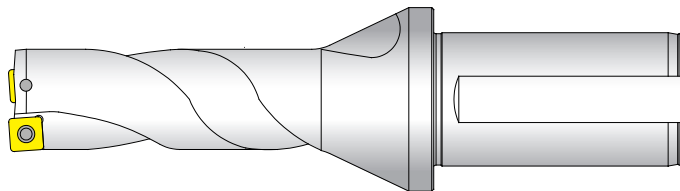
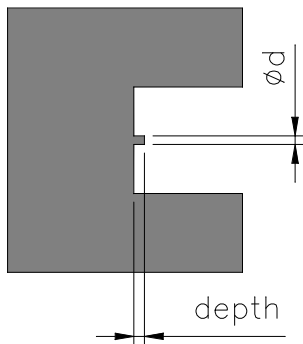
- 첫홀 가공 - 피삭재를 3~6mm가량 드릴링 한 후 코어(Core)가 크기가 0.2~0.7mm 되는지 확인하여 주십시오.
One first hole - please retract the drill after drilling to a depth of 3~6mm and check it has produced a small core within 0.2~0.7mm

만약 코어(Core)가 생성되지 않았다면 :
If a core is not created :

- 이는 인서트 파손이나 가공시 떨림을 발생 시킬 수 있습니다.
It can cause insert breakage and vibration when is drilling operation.
- 드릴을 180도 회전하여 다시 시도하여 주십시오.
Please reverse the drill body 108 degrees in tool post and try again

만약 코어(Core)가 추천 크기
(0.2~0.7mm)보다 클 때 :
If core size is a higher than
recommended values :

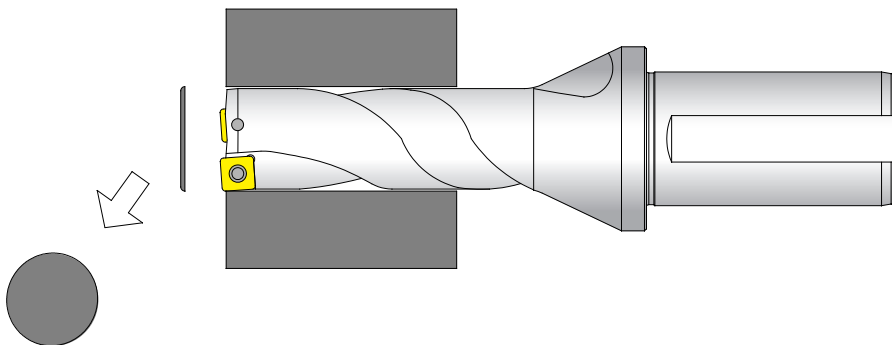
- 코어(Core)크기가 추천 크기가 되도록 오프셋량을 조정하여 주십시오.
Please adjust offsets to bring core to correct size
- 오프셋량 조정없이 가공시 과부하와 떨림 발생을 야기 할 수 있습니다.
Failure to do this, it can cause overload and vibration during drilling



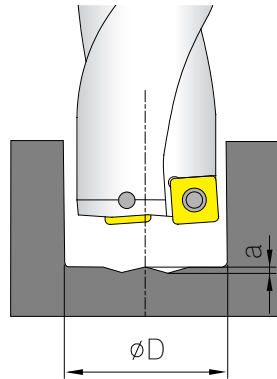
안전 유의 사항 Safety precaution

유의 사항 :
Precaution :

- 선반에서 관통 작업을 할 경우, 원판(Disk)이 떨어져 나가며 부상의 위험이 발생할 수 있으니 반드시 안전 커버를 사용하십시오.
On a stationary drilling application, there is a risk of accidents caused by the disc being thrown from the parts.



B6 드릴 기술자료 B6 Drill Technical data



• B6, B6K 바닥형상 Hole bottom shape of B6, B6K drill

Drill Diameter 드릴크기	Insert	a
$\phi 13 \sim \phi 15$	SPMG 050204	0.4
$\phi 16 \sim \phi 21$	SPMG 060204	0.5
$\phi 22 \sim \phi 27$	SPMG 07T308	0.5
$\phi 28 \sim \phi 33$	SPMG 090408	0.6
$\phi 34 \sim \phi 41$	SPMG 110408	0.8
$\phi 42 \sim \phi 50$	SPMG 140512	1.0

• Choose the shortest possible drill for best performance and productivity results

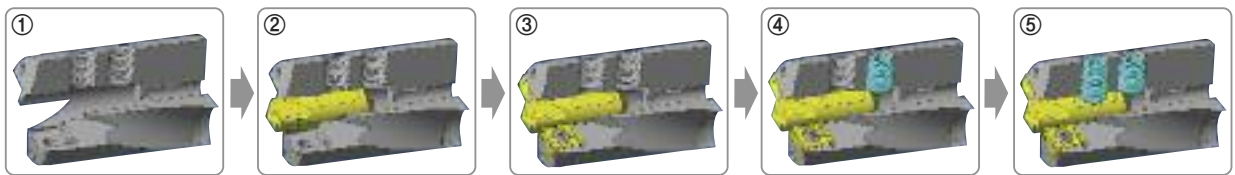
• B6, B6K 드릴 구멍공차 The hole tolerance of B6, B6K drill

Drill Diameter 드릴크기	2xD	3xD	4xD	5xD
$\phi 13 \sim \phi 21.5$	-0.10 ~ +0.15	-0.10 ~ +0.18	-0.15 ~ +0.20	-0.15 ~ +0.25
$\phi 22 \sim \phi 50$	-0.10 ~ +0.15	-0.12 ~ +0.20	-0.15 ~ +0.25	-0.15 ~ +0.30

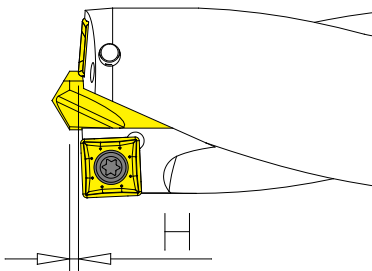
※ 홀 공차는 드릴의 길이, 피삭재, 장비, 가공조건 등에 따라 차이가 생길 수 있습니다.

※ The length of drill, kind of workpiece, machine stability, and cutting condition could affect the hole tolerance.

• B6T 조립순서 B6T Setting View



• PLD 셋팅 높이 PLD Adjustment



H			
P M K	S	P Soft Steel	N
1.0	1.2	1.2	1.5
1.2	1.4	1.4	1.7

※ Turbo drill works on P, K, M as B6, B6K drill. Pilot drill is only for guiding center. Cutting is be SPMG insert.

P 강 Steel **M** 써스 Sus **K** 주철 Cast iron **N** 비철금속 Nonferrous metals