



■ サイズ一覧表 (— 転造タップ下穴サイズ)

型式	先端径	溝長	全長	シャンク	定価	型式	先端径	溝長	全長	シャンク	定価	型式	先端径	溝長	全長	シャンク	定価
ODR4R-0027.6-OH	2.76	15.0	52.0	3	16,000	ODR4R-0060-OH	6	30.0	74.0	6	22,000	ODR4R-0093.8-OH	9.38	50.0	100.0	10	31,500
ODR4R-0027.7-OH	2.77	15.0	52.0	3	16,000	ODR4R-0061-OH	6.1	35.0	79.0	7	23,000	ODR4R-0093.9-OH	9.39	50.0	100.0	10	31,500
ODR4R-0027.8-OH	2.78	15.0	52.0	3	16,000	ODR4R-0062-OH	6.2	35.0	79.0	7	23,000	ODR4R-0094-OH	9.4	50.0	100.0	10	31,500
ODR4R-0030-OH	3	15.0	52.0	3	16,000	ODR4R-0063-OH	6.3	35.0	79.0	7	23,000	ODR4R-0095-OH	9.5	50.0	100.0	10	31,500
ODR4R-0031-OH	3.1	20.0	57.0	4	16,000	ODR4R-0064-OH	6.4	35.0	79.0	7	23,000	ODR4R-0095.3-OH	9.53	50.0	100.0	10	31,500
ODR4R-0032-OH	3.2	20.0	57.0	4	16,000	ODR4R-0065-OH	6.5	35.0	79.0	7	23,000	ODR4R-0095.4-OH	9.54	50.0	100.0	10	31,500
ODR4R-0033-OH	3.3	20.0	57.0	4	16,000	ODR4R-0066-OH	6.6	35.0	79.0	7	23,000	ODR4R-0095.5-OH	9.55	50.0	100.0	10	31,500
ODR4R-0034-OH	3.4	20.0	57.0	4	16,000	ODR4R-0067-OH	6.7	35.0	79.0	7	23,000	ODR4R-0096-OH	9.6	50.0	100.0	10	31,500
ODR4R-0035-OH	3.5	20.0	57.0	4	16,000	ODR4R-0068-OH	6.8	35.0	79.0	7	23,000	ODR4R-0097-OH	9.7	50.0	100.0	10	31,500
ODR4R-0036-OH	3.6	20.0	57.0	4	16,000	ODR4R-0069-OH	6.9	35.0	79.0	7	23,000	ODR4R-0098-OH	9.8	50.0	100.0	10	31,500
ODR4R-0036.6-OH	3.66	20.0	57.0	4	16,000	ODR4R-0070-OH	7	35.0	79.0	7	23,500	ODR4R-0099-OH	9.9	50.0	100.0	10	31,500
ODR4R-0036.7-OH	3.67	20.0	57.0	4	16,000	ODR4R-0071-OH	7.1	40.0	84.0	8	25,000	ODR4R-0100-OH	10	50.0	100.0	10	33,000
ODR4R-0036.8-OH	3.68	20.0	57.0	4	16,000	ODR4R-0072-OH	7.2	40.0	84.0	8	25,000	ODR4R-0101-OH	10.1	55.0	112.0	11	34,000
ODR4R-0037-OH	3.7	20.0	57.0	4	16,000	ODR4R-0073-OH	7.3	40.0	84.0	8	25,000	ODR4R-0102-OH	10.2	55.0	112.0	11	34,000
ODR4R-0038-OH	3.8	20.0	57.0	4	16,000	ODR4R-0073.9-OH	7.39	40.0	84.0	8	25,000	ODR4R-0103-OH	10.3	55.0	112.0	11	34,000
ODR4R-0039-OH	3.9	20.0	57.0	4	16,000	ODR4R-0074-OH	7.4	40.0	84.0	8	25,000	ODR4R-0104-OH	10.4	55.0	112.0	11	34,000
ODR4R-0040-OH	4	20.0	57.0	4	17,000	ODR4R-0074.1-OH	7.41	40.0	84.0	8	25,000	ODR4R-0105-OH	10.5	55.0	112.0	11	34,000
ODR4R-0041-OH	4.1	25.0	69.0	5	18,000	ODR4R-0075-OH	7.5	40.0	84.0	8	25,000	ODR4R-0106-OH	10.6	55.0	112.0	11	34,000
ODR4R-0042-OH	4.2	25.0	69.0	5	18,000	ODR4R-0075.3-OH	7.53	40.0	84.0	8	25,000	ODR4R-0107-OH	10.7	55.0	112.0	11	34,000
ODR4R-0043-OH	4.3	25.0	69.0	5	18,000	ODR4R-0075.4-OH	7.54	40.0	84.0	8	25,000	ODR4R-0108-OH	10.8	55.0	112.0	11	34,000
ODR4R-0044-OH	4.4	25.0	69.0	5	18,000	ODR4R-0075.5-OH	7.55	40.0	84.0	8	25,000	ODR4R-0109-OH	10.9	55.0	112.0	11	34,000
ODR4R-0045-OH	4.5	25.0	69.0	5	18,000	ODR4R-0076-OH	7.6	40.0	84.0	8	25,000	ODR4R-0110-OH	11	55.0	112.0	11	35,000
ODR4R-0046-OH	4.6	25.0	69.0	5	18,000	ODR4R-0077-OH	7.7	40.0	84.0	8	25,000	ODR4R-0111-OH	11.1	60.0	117.0	12	36,000
ODR4R-0046.1-OH	4.61	25.0	69.0	5	18,000	ODR4R-0078-OH	7.8	40.0	84.0	8	25,000	ODR4R-0111.7-OH	11.17	60.0	117.0	12	36,000
ODR4R-0046.2-OH	4.62	25.0	69.0	5	18,000	ODR4R-0079-OH	7.9	40.0	84.0	8	25,000	ODR4R-0111.8-OH	11.18	60.0	117.0	12	36,000
ODR4R-0046.3-OH	4.63	25.0	69.0	5	18,000	ODR4R-0080-OH	8	40.0	84.0	8	27,000	ODR4R-0111.9-OH	11.19	60.0	117.0	12	36,000
ODR4R-0047-OH	4.7	25.0	69.0	5	18,000	ODR4R-0081-OH	8.1	45.0	95.0	9	28,500	ODR4R-0112-OH	11.2	60.0	117.0	12	36,000
ODR4R-0048-OH	4.8	25.0	69.0	5	18,000	ODR4R-0082-OH	8.2	45.0	95.0	9	28,500	ODR4R-0113-OH	11.3	60.0	117.0	12	36,000
ODR4R-0049-OH	4.9	25.0	69.0	5	18,000	ODR4R-0083-OH	8.3	45.0	95.0	9	28,500	ODR4R-0113.1-OH	11.31	60.0	117.0	12	36,000
ODR4R-0050-OH	5	25.0	69.0	5	20,000	ODR4R-0084-OH	8.4	45.0	95.0	9	28,500	ODR4R-0113.2-OH	11.32	60.0	117.0	12	36,000
ODR4R-0051-OH	5.1	30.0	74.0	6	21,000	ODR4R-0085-OH	8.5	45.0	95.0	9	28,500	ODR4R-0113.9-OH	11.39	60.0	117.0	12	36,000
ODR4R-0052-OH	5.2	30.0	74.0	6	21,000	ODR4R-0086-OH	8.6	45.0	95.0	9	28,500	ODR4R-0114-OH	11.4	60.0	117.0	12	36,000
ODR4R-0053-OH	5.3	30.0	74.0	6	21,000	ODR4R-0087-OH	8.7	45.0	95.0	9	28,500	ODR4R-0114.1-OH	11.41	60.0	117.0	12	36,000
ODR4R-0054-OH	5.4	30.0	74.0	6	21,000	ODR4R-0088-OH	8.8	45.0	95.0	9	28,500	ODR4R-0115-OH	11.5	60.0	117.0	12	36,000
ODR4R-0055-OH	5.5	30.0	74.0	6	21,000	ODR4R-0089-OH	8.9	45.0	95.0	9	28,500	ODR4R-0115.3-OH	11.53	60.0	117.0	12	36,000
ODR4R-0055.3-OH	5.53	30.0	74.0	6	21,000	ODR4R-0090-OH	9	45.0	95.0	9	30,000	ODR4R-0115.4-OH	11.54	60.0	117.0	12	36,000
ODR4R-0055.4-OH	5.54	30.0	74.0	6	21,000	ODR4R-0091-OH	9.1	50.0	100.0	10	31,500	ODR4R-0115.5-OH	11.55	60.0	117.0	12	36,000
ODR4R-0055.5-OH	5.55	30.0	74.0	6	21,000	ODR4R-0092-OH	9.2	50.0	100.0	10	31,500	ODR4R-0116-OH	11.6	60.0	117.0	12	36,000
ODR4R-0056-OH	5.6	30.0	74.0	6	21,000	ODR4R-0092.7-OH	9.27	50.0	100.0	10	31,500	ODR4R-0117-OH	11.7	60.0	117.0	12	36,000
ODR4R-0057-OH	5.7	30.0	74.0	6	21,000	ODR4R-0092.8-OH	9.28	50.0	100.0	10	31,500	ODR4R-0118-OH	11.8	60.0	117.0	12	36,000
ODR4R-0058-OH	5.8	30.0	74.0	6	21,000	ODR4R-0092.9-OH	9.29	50.0	100.0	10	31,500	ODR4R-0119-OH	11.9	60.0	117.0	12	36,000
ODR4R-0059-OH	5.9	30.0	74.0	6	21,000	ODR4R-0093-OH	9.3	50.0	100.0	10	31,500	ODR4R-0120-OH	12	60.0	117.0	12	38,000

※先端径公差は0~+0.006となります。 ※メーカー推奨再研磨回数(再コート) Φ3以下/1回、Φ3.1以上Φ6以下/2回、Φ6.1以上Φ10以下/3回、Φ10.1以上/4回

■ 切削条件

被削材	低炭素鋼	高炭素鋼	合金鋼・調質鋼	鋳鉄
	S10C SS	S45C SK	SCr SCM	FC FCD
周速(V) m/min	45~80	50~90	45~100	45~100
送り(f) mm/rev	0.08~0.15	0.08~0.15	0.08~0.15	0.08~0.15

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