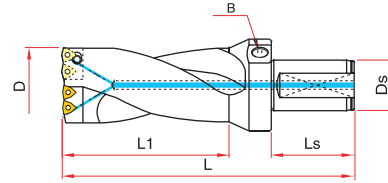


HIGH SPEED DRILL

HSD-V Big diameter Drill(Cartridge type)

STD-V 대구경 드릴 (카트리지 타입)

※ 범용선반 가공시, 가공직경 $\phi 40$ 이상은 TSD나, MXD 사용을 권장함.



● Shank ISO9766, Parallel with clamping flat

▶ HSD-V 2XD CARTRIDGE TYPE

CODE NO.	D	L1	L	Ds	Ls	INSERT	SCREW	DRIVER	CARTRIDGE
HSD-V596520D S40	59-65	130	240	40	70	WC..06T308	TSB-35090	TXL-15	HSC-V5965N/T
HSD-V657020D S40	65-70	140	250						HSC-V6570N/T
HSD-V707520D S40	70-75	150	260						HSC-V7075N/T
HSD-V758020D S40	75-80	160	270						HSC-V7580N/T

▶ HSD-V 3XD CARTRIDGE TYPE

CODE NO.	D	L1	L	Ds	Ls	INSERT	SCREW	DRIVER	CARTRIDGE
HSD-V596530D S40	59-65	195	305	40	70	WC..06T308	TSB-35090	TXL-15	HSC-V5965N/T
HSD-V657030D S40	65-70	210	320						HSC-V6570N/T
HSD-V707530D S40	70-75	225	335						HSC-V7075N/T
HSD-V758030D S40	75-80	240	350						HSC-V7580N/T

▶ HSD-V 4XD CARTRIDGE TYPE

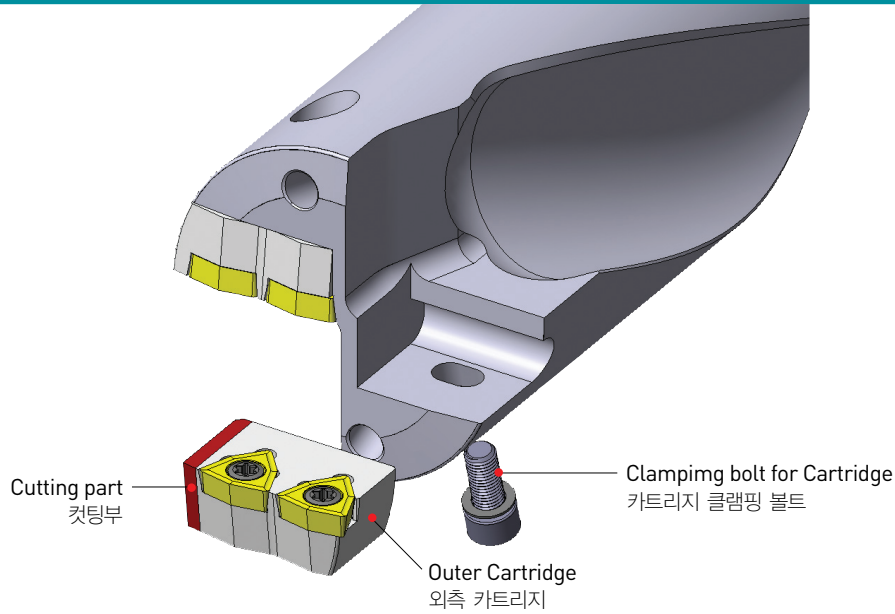
CODE NO.	D	L1	L	Ds	Ls	INSERT	SCREW	DRIVER	CARTRIDGE
HSD-V596540D S40	59-65	260	370	40	70	WC..06T308	TSB-35090	TXL-15	HSC-V5965N/T
HSD-V657040D S40	65-70	280	390						HSC-V6570N/T
HSD-V707540D S40	70-75	300	410						HSC-V7075N/T
HSD-V758040D S40	75-80	320	430						HSC-V7580N/T

* HSD-V drill will be sold after HSD drill is sold out.

* HSD-V 대구경 드릴은, HSD 대구경 드릴 재고 소진 후 판매됩니다.

The setting procedures for the big dia drill(Cartridge type)

HSD-V 대구경 드릴 (카트리지 타입) 셋팅 방법



- 1) Loosen the clamping bolt of the outer cartridge and remove it from the drill body.
외측카트리지를, 카트리지 클램핑 볼트를 풀어 바디에서 이탈시킨다.
- 2) Cut off the inside part, the contacted side of the outer cartridge by milling after calculating the drilling diameter.
외측카트리지의 측면 밀착부를, 가공하려는 직경을 계산하여 밀링작업한다.
- 3) Slick the sharp corner of the cut cartridge.
컷팅된 외측카트리지의 날카로운 모서리면을 모따기 처리한다.
- 4) Adhere the cartridge closely to the drill body not happen gap and fix the cartridge with bolt tightly.
외측카트리지를 틈이 발생되지 않도록 바디에 밀착시키면서 카트리지 클램핑 볼트로 단단히 고정한다.

Example If you set HSD-V707530D to $\phi 72$
HSD-707530D를 $\phi 72$ 로 셋팅한다면,
The standard drill diameter is $\phi 75$ so $\phi 75 - \phi 72 = 3 \Rightarrow 3 \div 2 = 1.5$ (calculation by semidiameter),
1.5mm is cut off.
기본 직경은 $\phi 75$ 이므로, $\phi 75 - \phi 72 = 3 \Rightarrow 3 \div 2 = 1.5$ (반지름으로 계산), 1.5mm를 컷팅한다.

