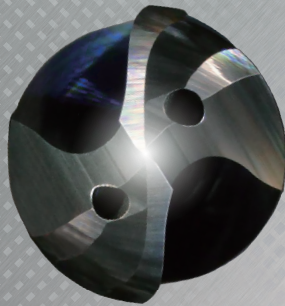


AXV 5D-0H

For Aluminum, Copper Alloy, Resin



Drilling video available



ZERO BURR × High Efficiency

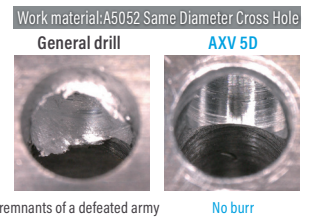
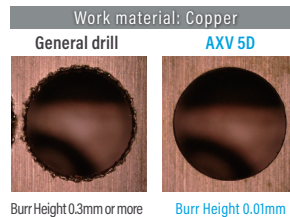
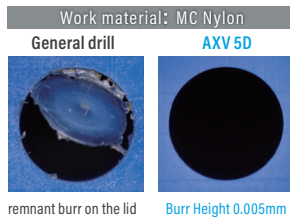
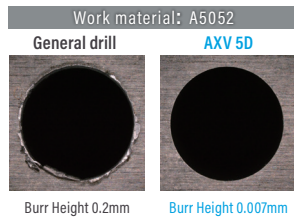
Greatly improved chip evacuation performance and machining speed! New model ideal for mass production machining!

1 Deburring performance



No deburring process required!
Satisfactory finish for cross holes of the same diameter

1



2 Machining speed



Significant reduction in Machining time while maintaining the same quality!

2



従来品
Vc = 80m/min (4246rpm)
f = 0.06mm/rev (F = 254mm/min)
Machining time: approx. 7.1 sec. per hole

AXV 5D
Vc = 150m/min (7957rpm)
f = 0.18mm/rev (F = 1432mm/min)
Machining time: approx. 1.2 sec. per hole

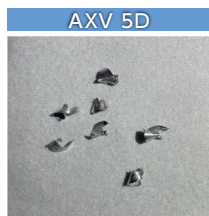
<Common cutting conditions> work material: A5052 / Drill Dia.: φ6 / Hole depth: 30mm

3 Chip removal performance



Chips are broken into small pieces for smooth discharge. Trouble caused by chips is also eliminated.

3



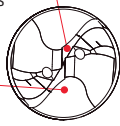
<Common cutting conditions> work material: A7075 / Drill Dia.: φ6 / Cutting oil material: water-soluble



ZERO BURR AXV 5D-OH For mass production Aluminum Brass Resin Cross hole **The superior characteristics of ZEROBURR AXV**

Curviness Edge

The curved blade shape reduces resistance and eliminates burrs at the edge of the cut.

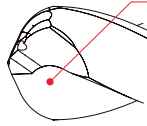


SP Flute

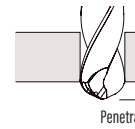
Optimized flute shape improves cutting performance and chip evacuation.

Wide Gash

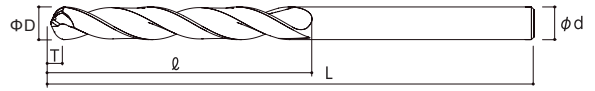
The wide pocket allows for smooth chip removal.



PRECAUTIONS



- * Please use for wet drilling.
- * Be sure to fix the work material firmly, and use the drill to completely pass through the penetration depth.



ZEROBURR AXV5D-OH LINEUP (Hole Depth 5D/ DLC Coating) Outer diameter tolerance 0~+0.01 *Regrinding orders are accepted for sizes φ2 and above.

Model number	φD Diameter	ℓ Groove Length	L Overall Length	φd Shank	T Penetration Depth	● Stock ※ built-to-order
AXV5D-OH 0200	2	18	65	3	●	●
AXV5D-OH 0201	2.01					
AXV5D-OH 0202	2.02					
AXV5D-OH 0203	2.03					
AXV5D-OH 0210	2.1					
AXV5D-OH 0220	2.2					
AXV5D-OH 0230	2.3					
AXV5D-OH 0240	2.4					
AXV5D-OH 0250	2.5					
AXV5D-OH 0260	2.6					
AXV5D-OH 0270	2.7	22	75	4	●	●
AXV5D-OH 0280	2.8					
AXV5D-OH 0290	2.9					
AXV5D-OH 0300	3					
AXV5D-OH 0301	3.01					
AXV5D-OH 0302	3.02					
AXV5D-OH 0303	3.03					
AXV5D-OH 0310	3.1					
AXV5D-OH 0320	3.2					
AXV5D-OH 0330	3.3					
AXV5D-OH 0340	3.4	26	30	4	●	●
AXV5D-OH 0350	3.5					
AXV5D-OH 0360	3.6					
AXV5D-OH 0370	3.7					
AXV5D-OH 0380	3.8					
AXV5D-OH 0390	3.9					
AXV5D-OH 0400	4					
AXV5D-OH 0401	4.01					
AXV5D-OH 0402	4.02					
AXV5D-OH 0403	4.03					
AXV5D-OH 0410	4.1	34	46	4	●	●
AXV5D-OH 0420	4.2					
AXV5D-OH 0430	4.3					
AXV5D-OH 0440	4.4					
AXV5D-OH 0450	4.5					
AXV5D-OH 0460	4.6					
AXV5D-OH 0470	4.7					
AXV5D-OH 0480	4.8					
AXV5D-OH 0490	4.9					
AXV5D-OH 0500	5					
AXV5D-OH 0501	5.01	42	54	4	●	●
AXV5D-OH 0502	5.02					
AXV5D-OH 0503	5.03					
AXV5D-OH 0510	5.1					
AXV5D-OH 0520	5.2					
AXV5D-OH 0530	5.3					
AXV5D-OH 0540	5.4					
AXV5D-OH 0550	5.5					
AXV5D-OH 0560	5.6					
AXV5D-OH 0570	5.7					
AXV5D-OH 0580	5.8					
AXV5D-OH 0590	5.9					
AXV5D-OH 0600	6	48	62	4	●	●
AXV5D-OH 0601	6.01					
AXV5D-OH 0602	6.02					
AXV5D-OH 0603	6.03					
AXV5D-OH 0610	6.1					
AXV5D-OH 0620	6.2					
AXV5D-OH 0630	6.3					
AXV5D-OH 0640	6.4					
AXV5D-OH 0650	6.5					
AXV5D-OH 0660	6.6					

Model number	φD Diameter	ℓ Groove Length	L Overall Length	φd Shank	T Penetration Depth	● Stock ※ built-to-order
AXV5D-OH 0670	6.7	54	100	8	8	●
AXV5D-OH 0680	6.8					
AXV5D-OH 0690	6.9					
AXV5D-OH 0700	7					
AXV5D-OH 0701	7.01					
AXV5D-OH 0702	7.02					
AXV5D-OH 0703	7.03					
AXV5D-OH 0710	7.1					
AXV5D-OH 0720	7.2					
AXV5D-OH 0730	7.3					
AXV5D-OH 0740	7.4	62	110	8	●	●
AXV5D-OH 0750	7.5					
AXV5D-OH 0760	7.6					
AXV5D-OH 0770	7.7					
AXV5D-OH 0780	7.8					
AXV5D-OH 0790	7.9					
AXV5D-OH 0800	8					
AXV5D-OH 0801	8.01					
AXV5D-OH 0802	8.02					
AXV5D-OH 0803	8.03					
AXV5D-OH 0810	8.1	70	120	8	●	●
AXV5D-OH 0820	8.2					
AXV5D-OH 0830	8.3					
AXV5D-OH 0840	8.4					
AXV5D-OH 0850	8.5					
AXV5D-OH 0860	8.6					
AXV5D-OH 0870	8.7					
AXV5D-OH 0880	8.8					
AXV5D-OH 0890	8.9					
AXV5D-OH 0900	9					
AXV5D-OH 0901	9.01	78	130	8	●	●
AXV5D-OH 0902	9.02					
AXV5D-OH 0903	9.03					
AXV5D-OH 0910	9.1					
AXV5D-OH 0920	9.2					
AXV5D-OH 0930	9.3					
AXV5D-OH 0940	9.4					
AXV5D-OH 0950	9.5					
AXV5D-OH 0960	9.6					
AXV5D-OH 0970	9.7					
AXV5D-OH 0980	9.8	86	145	8	●	●
AXV5D-OH 0990	9.9					
AXV5D-OH 1000	10					
AXV5D-OH 1001	10.01					
AXV5D-OH 1002	10.02					
AXV5D-OH 1003	10.03					
AXV5D-OH 1010	10.1					
AXV5D-OH 1020	10.2					
AXV5D-OH 1030	10.3					
AXV5D-OH 1040	10.4					
AXV5D-OH 1050	10.5	90	150	8	●	●
AXV5D-OH 1060	10.6					
AXV5D-OH 1070	10.7					
AXV5D-OH 1080	10.8					
AXV5D-OH 1090	10.9					
AXV5D-OH 1100	11					
AXV5D-OH 1101	11.01					
AXV5D-OH 1102	11.02					
AXV5D-OH 1103	11.03					
AXV5D-OH 1110	11.1					
AXV5D-OH 1120	11.2					
AXV5D-OH 1130	11.3					

Model number	φD Diameter	ℓ Groove Length	L Overall Length	φd Shank	T Penetration Depth	● Stock ※ built-to-order
AXV5D-OH 1140	11.4	90	145	12	8	●
AXV5D-OH 1150	11.5					
AXV5D-OH 1160	11.6					
AXV5D-OH 1170	11.7					
AXV5D-OH 1180	11.8					
AXV5D-OH 1190	11.9					
AXV5D-OH 1200	12					
AXV5D-OH 1201	12.01					
AXV5D-OH 1202	12.02					
AXV5D-OH 1203	12.03					
AXV5D-OH 1210	12.1	98	155	12	●	●
AXV5D-OH 1220	12.2					
AXV5D-OH 1230	12.3					
AXV5D-OH 1240	12.4					
AXV5D-OH 1250	12.5					
AXV5D-OH 1260	12.6					
AXV5D-OH 1270	12.7					
AXV5D-OH 1280	12.8					
AXV5D-OH 1290	12.9					
AXV5D-OH 1300	13					
AXV5D-OH 1301	13.01	106	165	12	●	●
AXV5D-OH 1302	13.02					
AXV5D-OH 1303	13.03					
AXV5D-OH 1310	13.1					
AXV5D-OH 1320	13.2					
AXV5D-OH 1330	13.3					
AXV5D-OH 1340	13.4					
AXV5D-OH 1350	13.5					
AXV5D-OH 1360	13.6					
AXV5D-OH 1370	13.7					
AXV5D-OH 1380	13.8	110	175	12	●	●
AXV5D-OH 1390	13.9					
AXV5D-OH 1400	14					
AXV5D-OH 1401	14.01					
AXV5D-OH 1402	14.02					
AXV5D-OH 1403	14.03					
AXV5D-OH 1410	14.1					
AXV5D-OH 1420	14.2					
AXV5D-OH 1430	14.3					
AXV5D-OH 1440	14.4					
AXV5D-OH 1450	14.5	118	185	12	●	●
AXV5D-OH 1460	14.6					
AXV5D-OH 1470	14.7					
AXV5D-OH 1480	14.8					
AXV5D-OH 1490	14.9					
AXV5D-OH 1500	15					
AXV5D-OH 1501	15.01					
AXV5D-OH 1502	15.02					
AXV5D-OH 1503	15.03					
AXV5D-OH 1510	15.1					
AXV5D-OH 1520	15.2					
AXV5D-OH 1530	15.3	126	195	12	●	●
AXV5D-OH 1540	15.4					
AXV5D-OH 1550	15.5					
AXV5D-OH 1560	15.6					
AXV5D-OH 1570	15.7					
AXV5D-OH 1580	15.8					
AXV5D-OH 1590	15.9					
AXV5D-OH 1600	16					
AXV5D-OH 1610	16.01					
AXV5D-OH 1620	16.02					
AXV5D-OH 1630	16.03					

Recommended cutting conditions *Please read the following precautions carefully before use.

Work Material	Aluminum Alloy Casting ADC • AC		Aluminum Wrought Material A7075 • A2024 Zn-Mg Cu group		Aluminum Wrought Material A5052 • A6063 Mg-Si Mg group		Copper Alloy C1020 • C6140		Hard Resin Acrylic		Soft Resin MC Nylon • PP • PE • PVC			
	Cutting Speed	100~150m/min	100~150m/min	100~150m/min	150~200m/min	50~80m/min	40~65m/min	40~65m/min	Step Machining	Rotation Speed (min-1)	Feed Amount (mm/rev)	Step Machining		
Diameter	Rotation Speed (min-1)	Feed Amount (mm/rev)	Rotation Speed (min-1)	Feed Amount (mm/rev)	Rotation Speed (min-1)	Feed Amount (mm/rev)	Rotation Speed (min-1)	Feed Amount (mm/rev)	Rotation Speed (min-1)	Feed Amount (mm/rev)	Step Machining	Rotation Speed (min-1)	Feed Amount (mm/rev)	Step Machining
3	13,270	0.07~0.15	13,270	0.07~0.15	17,516	0.06~0.09	10,616	0.015~0.045	5,839	0.06~0.12	1~3mm spacing	5,839	0.15~0.24	1~3mm interval
4	9,952	0.1~0.2	9,952	0.1~0.2	13,137	0.08~0.12	7,962	0.02~0.06	4,379	0.08~0.16		4,379	0.2~0.32	
5	7,962	0.12~0.25	7,962	0.12~0.25	10,510	0.1~0.15	6,369	0.025~0.075	3,503	0.1~0.2		3,503	0.25~0.4	
6	6,635	0.15~0.3	6,635	0.15~0.3	8,758	0.12~0.18	5,308	0.03~0.09	2,919	0.12~0.24		2,919	0.3~0.48	
8	4,976	0.2~0.4	4,976	0.2~0.4	6,568	0.16~0.24	3,981	0.04~0.12	2,189	0.16~0.32		2,189	0.4~0.64	
10	3,981	0.25~0.5	3,981	0.25~0.5	5,255	0.2~0.3	3,185	0.05~0.15	1,752	0.2~0.4		1,752	0.5~0.8	
12	3,317	0.3~0.6	3,317	0.3~0.6	4,379	0.24~0.36	2,654	0.06~0.18	1,460	0.24~0.48	1,460	0.6~0.96		

*The above cutting conditions are for the use of water-soluble cutting fluid and internal lubrication. *Keep runout at 0.02 mm or less when mounting the drill.

*Hold the workpiece firmly to prevent deflection or vibration. *If chips extend, perform step machining.