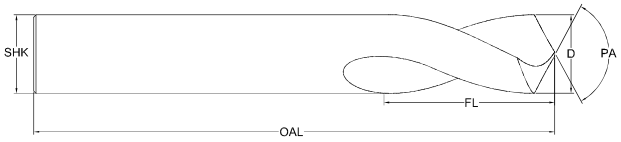
K2DSP

Work Materials

P	M	K	N	S
■	■	■	■	□

SOLID CARBIDE 2-FLUTE NC SPOT DRILL

2刃钨钢中心钻



FEATURES:

- Use for pre-drilling spotting holes for high-performance drills in most steels, with hardness up to 50 HRc, cast irons, and aluminium alloys.
- 4-facet point design with narrow chisel edge & constant web, allows re-sharpening without a need for web thinning.

DIA Tolerance
h7
SHK Tolerance
h6

PRODUCT CODE	PA	DIA	SHK	FL	OAL
K2DSP 090 050U	**90**				
K2DSP 120 050U	**120**	**5.0**	5	14	62
K2DSP 142 050U	**142**				
K2DSP 090 080U	**90**				
K2DSP 120 080U	**120**	**8.0**	8	21	79
K2DSP 142 080U	**142**				
K2DSP 090 100U	**90**				
K2DSP 120 100U	**120**	**10.0**	10	25	89
K2DSP 142 100U	**142**				
K2DSP 090 120U	**90**				
K2DSP 120 120U	**120**	**12.0**	12	30	102
K2DSP 142 120U	**142**				
K2DSP 090 160U	**90**				
K2DSP 120 160U	**120**	**16.0**	16	37.5	115
K2DSP 142 160U	**142**				

Note: For extended tool life,
AL or S coating are recommended.

K2DDSF (Diameter 4.0 - 16.0 mm)

Work Materials

P	M	K	N
▢	▢	▣	▣

SOLID CARBIDE 2-FLUTE DOUBLE-MARGIN STRAIGHT FLUTE DRILL

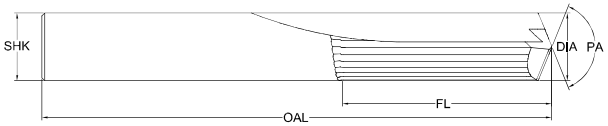
2刃钨钢双边直刃钻头

3X

MG | HELIX 0° | 135° | AL

FEATURES:

- Straight flute with double-margin for edge strength and precision tight tolerance.
- 135° notched drill point.
- Ideally suitable for bronze, Aluminium Alloys & Cast Aluminium > 10% Si.



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 3X				
K2DDSF 22 040AL	**4.0**	4	22	66
K2DDSF 26 050AL	**5.0**	5	26	66
K2DDSF 28 060AL	**6.0**	6	28	66
K2DDSF 34 070AL	**7.0**	7	34	79
K2DDSF 37 080AL	**8.0**	8	37	89
K2DDSF 40 100AL	**10.0**	10	40	89
K2DDSF 43 120AL	**12.0**	12	43	102
K2DDSF 54 140AL	**14.0**	14	54	107
K2DDSF 56 160AL	**16.0**	16	56	115

Note: For extended tool life, S coating are recommended.

DIA Tolerance
+ 0 / - 0.015 mm
SHK Tolerance
h6

K2DDSF (Diameter 4.0 - 16.0 mm)

Work Materials

P	M	K	N
▢	▢	▣	▣

SOLID CARBIDE 2-FLUTE DOUBLE-MARGIN STRAIGHT FLUTE DRILL

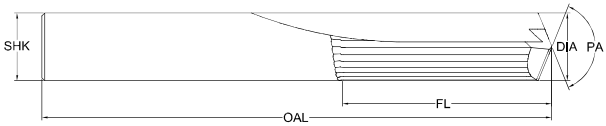
2刃钨钢双边直刃钻头

5X

MG | HELIX 0° | 135° | AL

FEATURES:

- Straight flute with double-margin for edge strength and precision tight tolerance.
- 135° notched drill point.
- Ideally suitable for bronze, Aluminium Alloys & Cast Aluminium > 10% Si.



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 5X				
K2DDSF 36 040AL	**4.0**	4	36	74
K2DDSF 44 050AL	**5.0**	5	44	82
K2DDSF 44 060AL	**6.0**	6	44	91
K2DDSF 53 070AL	**7.0**	7	53	91
K2DDSF 61 080AL	**8.0**	8	61	102
K2DDSF 61 100AL	**10.0**	10	61	102
K2DDSF 71 120AL	**12.0**	12	71	118
K2DDSF 77 140AL	**14.0**	14	77	124
K2DDSF 83 160AL	**16.0**	16	83	130

Note: For extended tool life, S coating are recommended.

DIA Tolerance
+ 0 / - 0.015 mm
SHK Tolerance
h6

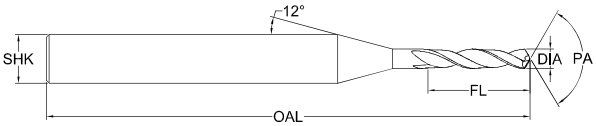
K2DS (Diameter 0.20 - 3.00 mm, Increment of 0.05 mm)

Work Materials

P	M	K	N	S	H
■	■	■	□	■	□

SOLID CARBIDE 2-FLUTE MICRO DRILL

2刃钨钢微型钻头



FEATURES:

- For diameter sizes ≥ 0.5mm, web-thinning is applied.
- Self centering 4-facet split point design for enhanced penetration rate with low thrust forces.
- Superior precision with run-out accuracy & lip height different within 2 µm tolerance.
- Ideally suitable for various types of applications.

DIA Tolerance
h7
SHK Tolerance
h6

PRODUCT CODE	DIA	SHK	FL	OAL
K2DS 02 0020C	0.20	3	2	38
K2DS 02 0025C	0.25	3	2	38
K2DS 03 0030C	0.30	3	3	38
K2DS 03 0035C	0.35	3	3	38
K2DS 03 0040C	0.40	3	3	38
K2DS 03 0045C	0.45	3	3	38
K2DS 03 0050C	0.50	3	3	38
K2DS 03 0055C	0.55	3	3	38
K2DS 03 0060C	0.60	3	3	38
K2DS 03 0065C	0.65	3	3	38
K2DS 03 0070C	0.70	3	3	38
K2DS 03 0075C	0.75	3	3	38
K2DS 05 0080C	0.80	3	5	38
K2DS 05 0085C	0.85	3	5	38
K2DS 06 0090C	0.90	3	6	38
K2DS 06 0095C	0.95	3	6	38
K2DS 06 0100C	1.00	3	6	38
K2DS 06 0105C	1.05	3	6	38
K2DS 08 0110C	1.10	3	8	38
K2DS 08 0115C	1.15	3	8	38
K2DS 08 0120C	1.20	3	8	38
K2DS 08 0125C	1.25	3	8	38
K2DS 08 0130C	1.30	3	8	38
K2DS 08 0135C	1.35	3	8	38
K2DS 08 0140C	1.40	3	8	38
K2DS 08 0145C	1.45	3	8	38
K2DS 08 0150C	1.50	3	8	38
K2DS 08 0155C	1.55	3	8	38
K2DS 09 0160C	1.60	3	9	38
K2DS 09 0165C	1.65	3	9	38

Note: For extended tool life, AL or S coating are recommended.

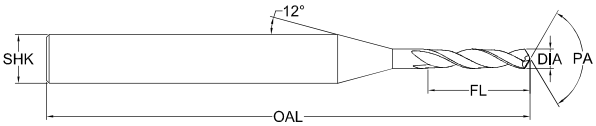
K2DS (Diameter 0.20 - 3.00 mm, Increment of 0.05 mm)

Work Materials

P	M	K	N	S	H
■	■	■	□	■	□

SOLID CARBIDE 2-FLUTE MICRO DRILL

2刃钨钢微型钻头



FEATURES:

- For diameter sizes ≥ 0.5mm, web-thinning is applied.
- Self centering 4-facet split point design for enhanced penetration rate with low thrust forces.
- Superior precision with run-out accuracy & lip height different within 2 µm tolerance.
- Ideally suitable for various types of applications.

DIA Tolerance
h7
SHK Tolerance
h6

PRODUCT CODE	DIA	SHK	FL	OAL
K2DS 09 0170C	1.70	3	9	38
K2DS 09 0175C	1.75	3	9	38
K2DS 09 0180C	1.80	3	9	38
K2DS 09 0185C	1.85	3	9	38
K2DS 09 0190C	1.90	3	9	38
K2DS 09 0200C	2.00	3	9	38
K2DS 09 0205C	2.05	3	9	38
K2DS 09 0210C	2.10	3	9	38
K2DS 09 0215C	2.15	3	9	38
K2DS 10 0220C	2.20	3	10	38
K2DS 10 0225C	2.25	3	10	38
K2DS 10 0230C	2.30	3	10	38
K2DS 10 0235C	2.35	3	10	38
K2DS 10 0240C	2.40	3	10	38
K2DS 10 0245C	2.45	3	10	38
K2DS 10 0250C	2.50	3	10	38
K2DS 10 0255C	2.55	3	10	38
K2DS 12 0260C	2.60	3	12	38
K2DS 12 0265C	2.65	3	12	38
K2DS 12 0270C	2.70	3	12	38
K2DS 12 0275C	2.75	3	12	38
K2DS 12 0280C	2.80	3	12	38
K2DS 12 0285C	2.85	3	12	38
K2DS 12 0290C	2.90	3	12	38
K2DS 12 0295C	2.95	3	12	38
K2DS 12 0300C	3.00	3	12	38

Note: For extended tool life, AL or S coating are recommended.

KRIS®

Drill Depth

3XD

>Size Range<

Ø 3.0 - 20.0 mm

DM

Series

Solid Carbide Drill for Die & Mold Machining

K2DM (Diameter 3.0 - 5.5 mm)

Work Materials

P	K	H
■	■	□

SOLID CARBIDE 2-FLUTE DRILL

2刃钨钢钻头

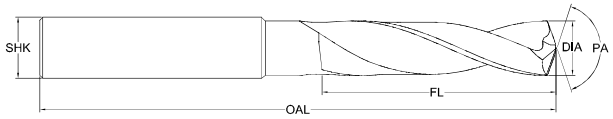
3X

MG | HELIX 25° | 140° | AL

FEATURES:

- General purpose drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 3x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
- Low Helix Angle to maximize tools' rigidity.

DIA Tolerance	
Dia ≤ 3.0 mm	+ 0 / - 0.010 mm
Dia > 3.0 mm	+ 0 / - 0.012 mm
SHK Tolerance	
h6	



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 3X				
K2DM 020 030AL	**3.0**	6	20	62
K2DM 020 031AL	**3.1**	6	20	62
K2DM 020 032AL	**3.2**	6	20	62
K2DM 020 033AL	**3.3**	6	20	62
K2DM 020 034AL	**3.4**	6	20	62
K2DM 020 035AL	**3.5**	6	20	62
K2DM 020 036AL	**3.6**	6	20	62
K2DM 020 037AL	**3.7**	6	20	62
K2DM 024 038AL	**3.8**	6	24	66
K2DM 024 039AL	**3.9**	6	24	66
K2DM 024 040AL	**4.0**	6	24	66
K2DM 024 041AL	**4.1**	6	24	66
K2DM 024 042AL	**4.2**	6	24	66
K2DM 024 043AL	**4.3**	6	24	66
K2DM 024 044AL	**4.4**	6	24	66
K2DM 024 045AL	**4.5**	6	24	66
K2DM 024 046AL	**4.6**	6	24	66
K2DM 024 047AL	**4.7**	6	24	66
K2DM 028 048AL	**4.8**	6	28	66
K2DM 028 049AL	**4.9**	6	28	66
K2DM 028 050AL	**5.0**	6	28	66
K2DM 028 051AL	**5.1**	6	28	66
K2DM 028 052AL	**5.2**	6	28	66
K2DM 028 053AL	**5.3**	6	28	66
K2DM 028 054AL	**5.4**	6	28	66
K2DM 028 055AL	**5.5**	6	28	66

Note: For extended tool life, S coating are recommended.

K2DM (Diameter 5.6 - 8.0 mm)

Work Materials

P	K	H
■	■	□

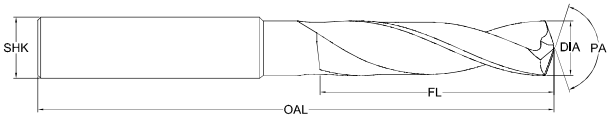
SOLID CARBIDE 2-FLUTE DRILL

2刃钨钢钻头

3X

FEATURES:

- General purpose drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 3x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
- Low Helix Angle to maximize tools' rigidity.



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 3X				
K2DM 028 056AL	**5.6**	6	28	66
K2DM 028 057AL	**5.7**	6	28	66
K2DM 028 058AL	**5.8**	6	28	66
K2DM 028 059AL	**5.9**	6	28	66
K2DM 028 060AL	**6.0**	6	28	66
K2DM 034 061AL	**6.1**	8	34	72
K2DM 034 062AL	**6.2**	8	34	72
K2DM 034 063AL	**6.3**	8	34	72
K2DM 034 064AL	**6.4**	8	34	72
K2DM 034 065AL	**6.5**	8	34	72
K2DM 034 066AL	**6.6**	8	34	72
K2DM 034 067AL	**6.7**	8	34	72
K2DM 034 068AL	**6.8**	8	34	72
K2DM 034 069AL	**6.9**	8	34	72
K2DM 034 070AL	**7.0**	8	34	72
K2DM 041 071AL	**7.1**	8	41	79
K2DM 041 072AL	**7.2**	8	41	79
K2DM 041 073AL	**7.3**	8	41	79
K2DM 041 074AL	**7.4**	8	41	79
K2DM 041 075AL	**7.5**	8	41	79
K2DM 041 076AL	**7.6**	8	41	79
K2DM 041 077AL	**7.7**	8	41	79
K2DM 041 078AL	**7.8**	8	41	79
K2DM 041 079AL	**7.9**	8	41	79
K2DM 041 080AL	**8.0**	8	41	79

Note: For extended tool life, S coating are recommended.

DIA Tolerance	
Dia ≤ 6.0 mm	+ 0 / - 0.012 mm
Dia > 6.0 mm	+ 0 / - 0.015 mm
SHK Tolerance	
h6	

K2DM (Diameter 8.1 - 10.8 mm)

Work Materials

P	K	H
■	■	□

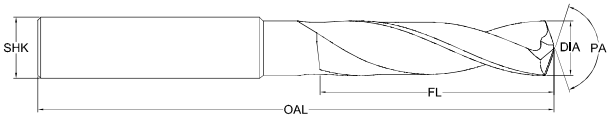
SOLID CARBIDE 2-FLUTE DRILL

2刃钨钢钻头

3X

FEATURES:

- General purpose drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 3x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
- Low Helix Angle to maximize tools' rigidity.



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 3X				
K2DM 047 081AL	**8.1**	10	47	89
K2DM 047 082AL	**8.2**	10	47	89
K2DM 047 083AL	**8.3**	10	47	89
K2DM 047 084AL	**8.4**	10	47	89
K2DM 047 085AL	**8.5**	10	47	89
K2DM 047 086AL	**8.6**	10	47	89
K2DM 047 087AL	**8.7**	10	47	89
K2DM 047 088AL	**8.8**	10	47	89
K2DM 047 089AL	**8.9**	10	47	89
K2DM 047 090AL	**9.0**	10	47	89
K2DM 047 091AL	**9.1**	10	47	89
K2DM 047 092AL	**9.2**	10	47	89
K2DM 047 093AL	**9.3**	10	47	89
K2DM 047 094AL	**9.4**	10	47	89
K2DM 047 095AL	**9.5**	10	47	89
K2DM 047 096AL	**9.6**	10	47	89
K2DM 047 097AL	**9.7**	10	47	89
K2DM 047 098AL	**9.8**	10	47	89
K2DM 047 099AL	**9.9**	10	47	89
K2DM 047 100AL	**10.0**	10	47	89
K2DM 055 102AL	**10.2**	12	55	102
K2DM 055 105AL	**10.5**	12	55	102
K2DM 055 108AL	**10.8**	12	55	102

Note: For extended tool life, S coating are recommended.

DIA Tolerance	
Dia ≤ 10.0 mm	+ 0 / - 0.015 mm
Dia > 10.0 mm	+ 0 / - 0.018 mm
SHK Tolerance	
h6	

K2DM (Diameter 11.0 - 20.0 mm)

Work Materials

P	K	H
■	■	□

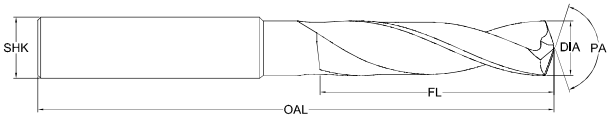
SOLID CARBIDE 2-FLUTE DRILL

2刃钨钢钻头

3X

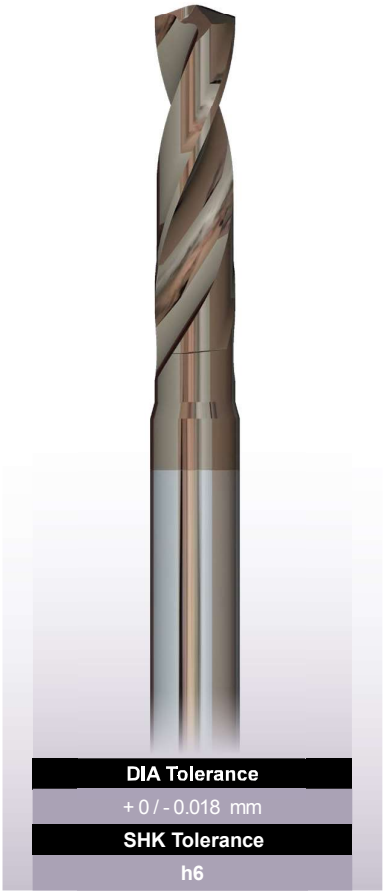
FEATURES:

- General purpose drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 3x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
- Low Helix Angle to maximize tools' rigidity.



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 3X				
K2DM 055 110AL	**11.0**	12	55	102
K2DM 055 115AL	**11.5**	12	55	102
K2DM 055 120AL	**12.0**	12	55	102
K2DM 060 125AL	**12.5**	14	60	107
K2DM 060 130AL	**13.0**	14	60	107
K2DM 060 135AL	**13.5**	14	60	107
K2DM 060 140AL	**14.0**	14	60	107
K2DM 065 145AL	**14.5**	16	65	115
K2DM 065 150AL	**15.0**	16	65	115
K2DM 065 155AL	**15.5**	16	65	115
K2DM 065 160AL	**16.0**	16	65	115
K2DM 073 165AL	**16.5**	18	73	123
K2DM 073 170AL	**17.0**	18	73	123
K2DM 073 175AL	**17.5**	18	73	123
K2DM 073 180AL	**18.0**	18	73	123
K2DM 079 185AL	**18.5**	20	79	131
K2DM 079 190AL	**19.0**	20	79	131
K2DM 079 195AL	**19.5**	20	79	131
K2DM 079 200AL	**20.0**	20	79	131

Note: For extended tool life, S coating are recommended.



DIA Tolerance
+ 0 / - 0.018 mm
SHK Tolerance
h6

KRIS®

Drill Depth

5XD

>Size Range<

Ø 3.0 - 15.5 mm

DM

Series

Solid Carbide Drill for Die & Mold Machining

K2DM (Diameter 3.0 - 5.5 mm)

Work Materials

P	K	H
■	■	□

SOLID CARBIDE 2-FLUTE DRILL

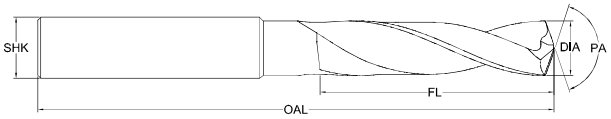
2刃钨钢钻头

5X

FEATURES:

- General purpose drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 5x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
- Low Helix Angle to maximize tools' rigidity.

DIA Tolerance	
Dia ≤ 3.0 mm	+ 0 / - 0.010 mm
Dia > 3.0 mm	+ 0 / - 0.012 mm
SHK Tolerance	
h6	



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 5X				
K2DM 028 030AL	**3.0**	6	28	66
K2DM 028 031AL	**3.1**	6	28	66
K2DM 028 032AL	**3.2**	6	28	66
K2DM 028 033AL	**3.3**	6	28	66
K2DM 028 034AL	**3.4**	6	28	66
K2DM 028 035AL	**3.5**	6	28	66
K2DM 028 036AL	**3.6**	6	28	66
K2DM 028 037AL	**3.7**	6	28	66
K2DM 036 038AL	**3.8**	6	36	74
K2DM 036 039AL	**3.9**	6	36	74
K2DM 036 040AL	**4.0**	6	36	74
K2DM 036 041AL	**4.1**	6	36	74
K2DM 036 042AL	**4.2**	6	36	74
K2DM 036 043AL	**4.3**	6	36	74
K2DM 036 044AL	**4.4**	6	36	74
K2DM 036 045AL	**4.5**	6	36	74
K2DM 036 046AL	**4.6**	6	36	74
K2DM 036 047AL	**4.7**	6	36	74
K2DM 044 048AL	**4.8**	6	44	82
K2DM 044 049AL	**4.9**	6	44	82
K2DM 044 050AL	**5.0**	6	44	82
K2DM 044 051AL	**5.1**	6	44	82
K2DM 044 052AL	**5.2**	6	44	82
K2DM 044 053AL	**5.3**	6	44	82
K2DM 044 054AL	**5.4**	6	44	82
K2DM 044 055AL	**5.5**	6	44	82

Note: For extended tool life, S coating are recommended.

K2DM (Diameter 5.6 – 8.0 mm)

Work Materials

P	K	H
■	■	□

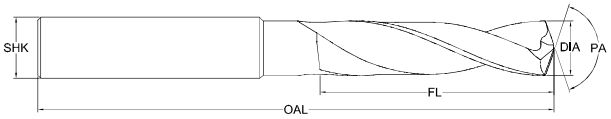
SOLID CARBIDE 2-FLUTE DRILL

2刃钨钢钻头

5X

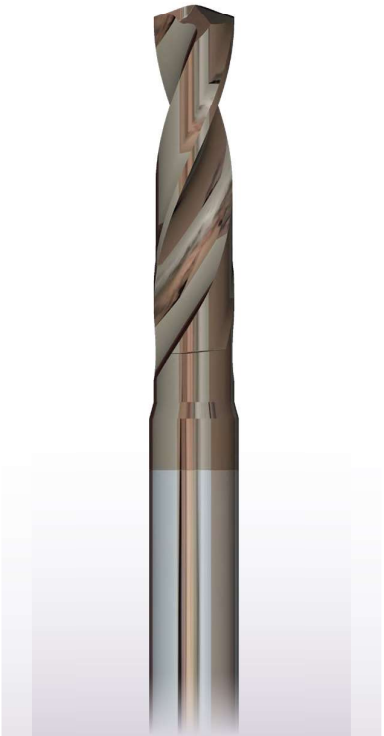
FEATURES:

- General purpose drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 5x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
- Low Helix Angle to maximize tools' rigidity.



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 5X				
K2DM 044 056AL	**5.6**	6	44	82
K2DM 044 057AL	**5.7**	6	44	82
K2DM 044 058AL	**5.8**	6	44	82
K2DM 044 059AL	**5.9**	6	44	82
K2DM 044 060AL	**6.0**	6	44	82
K2DM 053 061AL	**6.1**	8	53	91
K2DM 053 062AL	**6.2**	8	53	91
K2DM 053 063AL	**6.3**	8	53	91
K2DM 053 064AL	**6.4**	8	53	91
K2DM 053 065AL	**6.5**	8	53	91
K2DM 053 066AL	**6.6**	8	53	91
K2DM 053 067AL	**6.7**	8	53	91
K2DM 053 068AL	**6.8**	8	53	91
K2DM 053 069AL	**6.9**	8	53	91
K2DM 053 070AL	**7.0**	8	53	91
K2DM 053 071AL	**7.1**	8	53	91
K2DM 053 072AL	**7.2**	8	53	91
K2DM 053 073AL	**7.3**	8	53	91
K2DM 053 074AL	**7.4**	8	53	91
K2DM 053 075AL	**7.5**	8	53	91
K2DM 053 076AL	**7.6**	8	53	91
K2DM 053 077AL	**7.7**	8	53	91
K2DM 053 078AL	**7.8**	8	53	91
K2DM 053 079AL	**7.9**	8	53	91
K2DM 053 080AL	**8.0**	8	53	91

Note: For extended tool life, S coating are recommended.



DIA Tolerance	
Dia ≤ 6.0 mm	+ 0 / - 0.012 mm
Dia > 6.0 mm	+ 0 / - 0.015 mm
SHK Tolerance	
h6	

K2DM (Diameter 8.1 - 10.8 mm)

Work Materials

P	K	H
■	■	□

SOLID CARBIDE 2-FLUTE DRILL

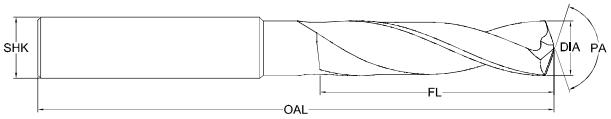
2刃钨钢钻头

5X

FEATURES:

- General purpose drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 5x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
- Low Helix Angle to maximize tools' rigidity.

DIA Tolerance	
Dia ≤ 10.0 mm	+ 0 / - 0.015 mm
Dia > 10.0 mm	+ 0 / - 0.018 mm
SHK Tolerance	
h6	



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 5X				
K2DM 061 081AL	**8.1**	10	61	103
K2DM 061 082AL	**8.2**	10	61	103
K2DM 061 083AL	**8.3**	10	61	103
K2DM 061 084AL	**8.4**	10	61	103
K2DM 061 085AL	**8.5**	10	61	103
K2DM 061 086AL	**8.6**	10	61	103
K2DM 061 087AL	**8.7**	10	61	103
K2DM 061 088AL	**8.8**	10	61	103
K2DM 061 089AL	**8.9**	10	61	103
K2DM 061 090AL	**9.0**	10	61	103
K2DM 061 091AL	**9.1**	10	61	103
K2DM 061 092AL	**9.2**	10	61	103
K2DM 061 093AL	**9.3**	10	61	103
K2DM 061 094AL	**9.4**	10	61	103
K2DM 061 095AL	**9.5**	10	61	103
K2DM 061 096AL	**9.6**	10	61	103
K2DM 061 097AL	**9.7**	10	61	103
K2DM 061 098AL	**9.8**	10	61	103
K2DM 061 099AL	**9.9**	10	61	103
K2DM 061 100AL	**10.0**	10	61	103
K2DM 071 102AL	**10.2**	12	71	118
K2DM 071 105AL	**10.5**	12	71	118
K2DM 071 108AL	**10.8**	12	71	118

Note: For extended tool life, S coating are recommended.

K2DM (Diameter 11.0 - 20.0 mm)

Work Materials

P	K	H
■	■	□

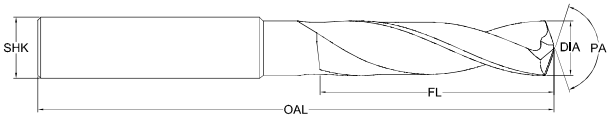
SOLID CARBIDE 2-FLUTE DRILL

2刃钨钢钻头

5X

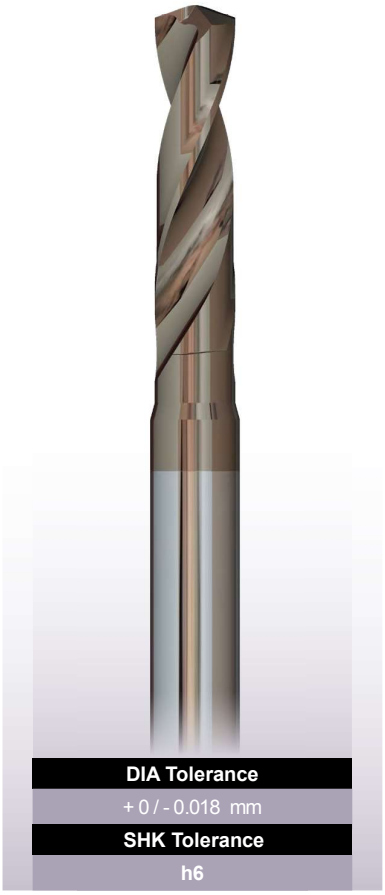
FEATURES:

- General purpose drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 5x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
- Low Helix Angle to maximize tools' rigidity.



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 5X				
K2DM 071 110AL	**11.0**	12	71	118
K2DM 071 115AL	**11.5**	12	71	118
K2DM 071 120AL	**12.0**	12	71	118
K2DM 077 125AL	**12.5**	14	77	124
K2DM 077 130AL	**13.0**	14	77	124
K2DM 077 135AL	**13.5**	14	77	124
K2DM 077 140AL	**14.0**	14	77	124
K2DM 083 145AL	**14.5**	16	83	133
K2DM 083 150AL	**15.0**	16	83	133
K2DM 083 155AL	**15.5**	16	83	133
K2DM 083 160AL	**16.0**	16	83	133
K2DM 093 165AL	**16.5**	18	93	143
K2DM 093 170AL	**17.0**	18	93	143
K2DM 093 175AL	**17.5**	18	93	143
K2DM 093 180AL	**18.0**	18	93	143
K2DM 101 185AL	**18.5**	20	101	153
K2DM 101 190AL	**19.0**	20	101	153
K2DM 101 195AL	**19.5**	20	101	153
K2DM 101 200AL	**20.0**	20	101	153

Note: For extended tool life, S coating are recommended.



DIA Tolerance
+ 0 / - 0.018 mm
SHK Tolerance
h6

KRIS®

Drill Depth
3XD

>Size Range<

Ø 3.0 - 20.0 mm

Coolant Fed

DMC
Series

Solid Carbide Drill for Die & Mold Machining

K2DMC (Diameter 3.0 - 5.5 mm)

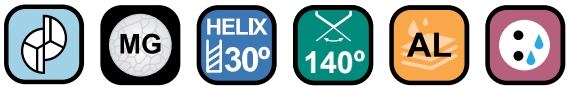
Work Materials

P	K	H
■	■	□

SOLID CARBIDE 2 -FLUTE DRILL (COOLANT FED)

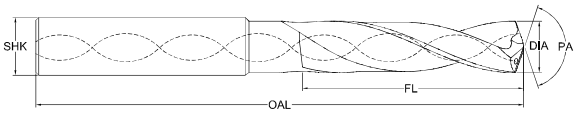
2刃钨钢双孔螺旋钻头

3X



FEATURES:

- General purpose coolant fed drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 3x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
- Low Helix Angle to maximize tools' rigidity.



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 3X				
K2DMC 020 030AL	**3.0**	6	20	62
K2DMC 020 031AL	**3.1**	6	20	62
K2DMC 020 032AL	**3.2**	6	20	62
K2DMC 020 033AL	**3.3**	6	20	62
K2DMC 020 034AL	**3.4**	6	20	62
K2DMC 020 035AL	**3.5**	6	20	62
K2DMC 020 036AL	**3.6**	6	20	62
K2DMC 020 037AL	**3.7**	6	20	62
K2DMC 024 038AL	**3.8**	6	24	66
K2DMC 024 039AL	**3.9**	6	24	66
K2DMC 024 040AL	**4.0**	6	24	66
K2DMC 024 041AL	**4.1**	6	24	66
K2DMC 024 042AL	**4.2**	6	24	66
K2DMC 024 043AL	**4.3**	6	24	66
K2DMC 024 044AL	**4.4**	6	24	66
K2DMC 024 045AL	**4.5**	6	24	66
K2DMC 024 046AL	**4.6**	6	24	66
K2DMC 024 047AL	**4.7**	6	24	66
K2DMC 028 048AL	**4.8**	6	28	66
K2DMC 028 049AL	**4.9**	6	28	66
K2DMC 028 050AL	**5.0**	6	28	66
K2DMC 028 051AL	**5.1**	6	28	66
K2DMC 028 052AL	**5.2**	6	28	66
K2DMC 028 053AL	**5.3**	6	28	66
K2DMC 028 054AL	**5.4**	6	28	66
K2DMC 028 055AL	**5.5**	6	28	66

DIA Tolerance	
Dia ≤ 3.0 mm	+ 0 / - 0.010 mm
Dia > 3.0 mm	+ 0 / - 0.012 mm
SHK Tolerance	
h6	

Note: For extended tool life, S coating are recommended.

K2DMC (Diameter 5.6 - 8.0 mm)

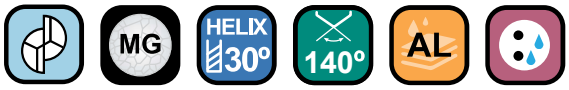
Work Materials

P	K	H
■	■	□

SOLID CARBIDE 2-FLUTE DRILL (COOLANT FED)

2刃钨钢双孔螺旋钻头

3X



FEATURES:

- General purpose coolant fed drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 3x diameter in depth.
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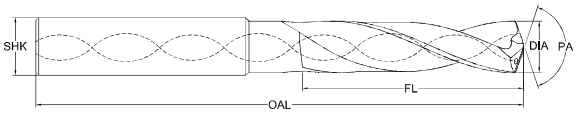


PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 3X				
K2DMC 028 056AL	**5.6**	6	28	66
K2DMC 028 057AL	**5.7**	6	28	66
K2DMC 028 058AL	**5.8**	6	28	66
K2DMC 028 059AL	**5.9**	6	28	66
K2DMC 028 060AL	**6.0**	6	28	66
K2DMC 034 061AL	**6.1**	8	34	72
K2DMC 034 062AL	**6.2**	8	34	72
K2DMC 034 063AL	**6.3**	8	34	72
K2DMC 034 064AL	**6.4**	8	34	72
K2DMC 034 065AL	**6.5**	8	34	72
K2DMC 034 066AL	**6.6**	8	34	72
K2DMC 034 067AL	**6.7**	8	34	72
K2DMC 034 068AL	**6.8**	8	34	72
K2DMC 034 069AL	**6.9**	8	34	72
K2DMC 034 070AL	**7.0**	8	34	72
K2DMC 041 071AL	**7.1**	8	41	79
K2DMC 041 072AL	**7.2**	8	41	79
K2DMC 041 073AL	**7.3**	8	41	79
K2DMC 041 074AL	**7.4**	8	41	79
K2DMC 041 075AL	**7.5**	8	41	79
K2DMC 041 076AL	**7.6**	8	41	79
K2DMC 041 077AL	**7.7**	8	41	79
K2DMC 041 078AL	**7.8**	8	41	79
K2DMC 041 079AL	**7.9**	8	41	79
K2DMC 041 080AL	**8.0**	8	41	79

DIA Tolerance	
Dia ≤ 6.0 mm	+ 0 / - 0.012 mm
Dia > 6.0 mm	+ 0 / - 0.015 mm
SHK Tolerance	
h6	

Note: For extended tool life, S coating are recommended.

K2DMC (Diameter 8.1 - 10.8 mm)

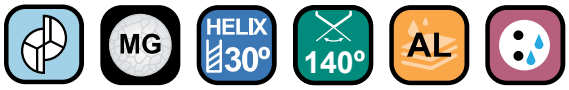
Work Materials

P	K	H
■	■	□

SOLID CARBIDE 2-FLUTE DRILL (COOLANT FED)

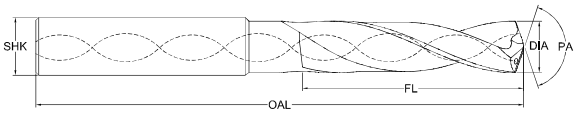
2刃钨钢双孔螺旋钻头

3X



FEATURES:

- General purpose coolant fed drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 3x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
- Low Helix Angle to maximize tools' rigidity.



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 3X				
K2DMC 047 081AL	**8.1**	10	47	89
K2DMC 047 082AL	**8.2**	10	47	89
K2DMC 047 083AL	**8.3**	10	47	89
K2DMC 047 084AL	**8.4**	10	47	89
K2DMC 047 085AL	**8.5**	10	47	89
K2DMC 047 086AL	**8.6**	10	47	89
K2DMC 047 087AL	**8.7**	10	47	89
K2DMC 047 088AL	**8.8**	10	47	89
K2DMC 047 089AL	**8.9**	10	47	89
K2DMC 047 090AL	**9.0**	10	47	89
K2DMC 047 091AL	**9.1**	10	47	89
K2DMC 047 092AL	**9.2**	10	47	89
K2DMC 047 093AL	**9.3**	10	47	89
K2DMC 047 094AL	**9.4**	10	47	89
K2DMC 047 095AL	**9.5**	10	47	89
K2DMC 047 096AL	**9.6**	10	47	89
K2DMC 047 097AL	**9.7**	10	47	89
K2DMC 047 098AL	**9.8**	10	47	89
K2DMC 047 099AL	**9.9**	10	47	89
K2DMC 047 100AL	**10.0**	10	47	89
K2DMC 055 102AL	**10.2**	12	55	102
K2DMC 055 105AL	**10.5**	12	55	102
K2DMC 055 108AL	**10.8**	12	55	102

DIA Tolerance	
Dia ≤ 10.0 mm	+ 0 / - 0.015 mm
Dia > 10.0 mm	+ 0 / - 0.018 mm
SHK Tolerance	
h6	

Note: For extended tool life, S coating are recommended.

K2DMC (Diameter 11.0 - 20.0 mm)

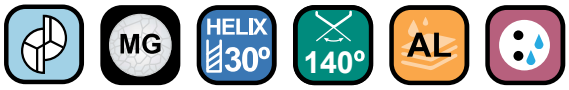
Work Materials

P	K	H
■	■	□

SOLID CARBIDE 2-FLUTE DRILL (COOLANT FED)

2刃钨钢双孔螺旋钻头

3X



FEATURES:

- General purpose coolant fed drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 3x diameter in depth.
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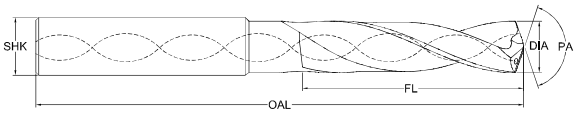
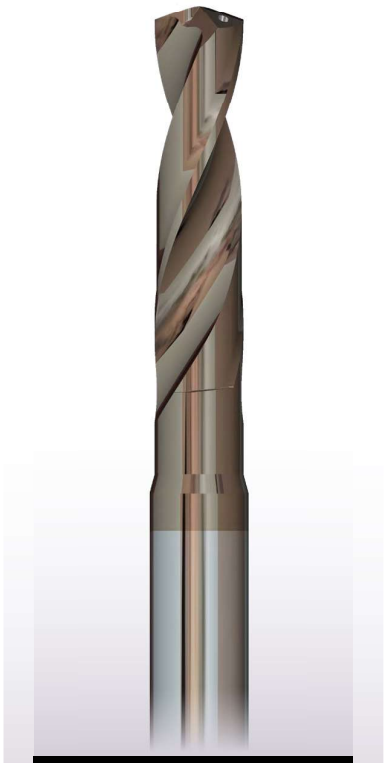


PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 3X				
K2DMC 055 110AL	11.0	12	55	102
K2DMC 055 115AL	11.5	12	55	102
K2DMC 055 120AL	12.0	12	55	102
K2DMC 060 125AL	12.5	14	60	107
K2DMC 060 130AL	13.0	14	60	107
K2DMC 060 135AL	13.5	14	60	107
K2DMC 060 140AL	14.0	14	60	107
K2DMC 065 145AL	14.5	16	65	115
K2DMC 065 150AL	15.0	16	65	115
K2DMC 065 155AL	15.5	16	65	115
K2DMC 065 160AL	16.0	16	65	115
K2DMC 073 165AL	16.5	18	73	123
K2DMC 073 170AL	17.0	18	73	123
K2DMC 073 175AL	17.5	18	73	123
K2DMC 073 180AL	18.0	18	73	123
K2DMC 079 185AL	18.5	20	79	131
K2DMC 079 190AL	19.0	20	79	131
K2DMC 079 195AL	19.5	20	79	131
K2DMC 079 200AL	20.0	20	79	131

Note: For extended tool life, S coating are recommended.



DIA Tolerance
+ 0 / - 0.018 mm
SHK Tolerance
h6

KRIS®

Drill Depth
5XD

>Size Range<

Ø 3.0 - 20.0 mm

Coolant Fed

DMC
Series

Solid Carbide Drill for Die & Mold Machining

K2DMC (Diameter 3.0 - 5.5 mm)

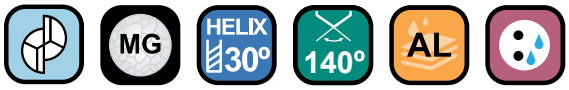
Work Materials

P	K	H
■	■	□

SOLID CARBIDE 2-FLUTE DRILL (COOLANT FED)

2刃钨钢双孔螺旋钻头

5X



FEATURES:

- General purpose coolant fed drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 5x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
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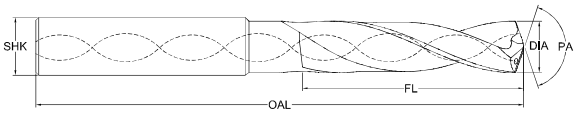


PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 5X				
K2DMC 028 030AL	**3.0**	6	28	66
K2DMC 028 031AL	**3.1**	6	28	66
K2DMC 028 032AL	**3.2**	6	28	66
K2DMC 028 033AL	**3.3**	6	28	66
K2DMC 028 034AL	**3.4**	6	28	66
K2DMC 028 035AL	**3.5**	6	28	66
K2DMC 028 036AL	**3.6**	6	28	66
K2DMC 028 037AL	**3.7**	6	28	66
K2DMC 036 038AL	**3.8**	6	36	74
K2DMC 036 039AL	**3.9**	6	36	74
K2DMC 036 040AL	**4.0**	6	36	74
K2DMC 036 041AL	**4.1**	6	36	74
K2DMC 036 042AL	**4.2**	6	36	74
K2DMC 036 043AL	**4.3**	6	36	74
K2DMC 036 044AL	**4.4**	6	36	74
K2DMC 036 045AL	**4.5**	6	36	74
K2DMC 036 046AL	**4.6**	6	36	74
K2DMC 036 047AL	**4.7**	6	36	74
K2DMC 044 048AL	**4.8**	6	44	82
K2DMC 044 049AL	**4.9**	6	44	82
K2DMC 044 050AL	**5.0**	6	44	82
K2DMC 044 051AL	**5.1**	6	44	82
K2DMC 044 052AL	**5.2**	6	44	82
K2DMC 044 053AL	**5.3**	6	44	82
K2DMC 044 054AL	**5.4**	6	44	82
K2DMC 044 055AL	**5.5**	6	44	82

DIA Tolerance	
Dia ≤ 3.0 mm	+ 0 / - 0.010 mm
Dia > 3.0 mm	+ 0 / - 0.012 mm
SHK Tolerance	
h6	

Note: For extended tool life, S coating are recommended.

K2DMC (Diameter 5.6 - 8.0 mm)

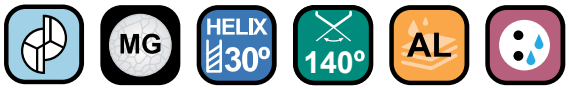
Work Materials

P	K	H
■	■	□

SOLID CARBIDE 2-FLUTE DRILL (COOLANT FED)

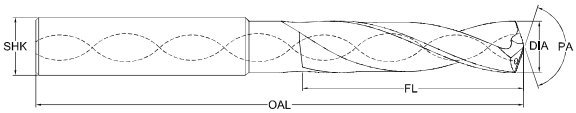
2刃钨钢双孔螺旋钻头

5X



FEATURES:

- General purpose coolant fed drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 5x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
- Low Helix Angle to maximize tools' rigidity.



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 5X				
K2DMC 044 056AL	**5.6**	6	44	82
K2DMC 044 057AL	**5.7**	6	44	82
K2DMC 044 058AL	**5.8**	6	44	82
K2DMC 044 059AL	**5.9**	6	44	82
K2DMC 044 060AL	**6.0**	6	44	82
K2DMC 053 061AL	**6.1**	8	53	91
K2DMC 053 062AL	**6.2**	8	53	91
K2DMC 053 063AL	**6.3**	8	53	91
K2DMC 053 064AL	**6.4**	8	53	91
K2DMC 053 065AL	**6.5**	8	53	91
K2DMC 053 066AL	**6.6**	8	53	91
K2DMC 053 067AL	**6.7**	8	53	91
K2DMC 053 068AL	**6.8**	8	53	91
K2DMC 053 069AL	**6.9**	8	53	91
K2DMC 053 070AL	**7.0**	8	53	91
K2DMC 053 071AL	**7.1**	8	53	91
K2DMC 053 072AL	**7.2**	8	53	91
K2DMC 053 073AL	**7.3**	8	53	91
K2DMC 053 074AL	**7.4**	8	53	91
K2DMC 053 075AL	**7.5**	8	53	91
K2DMC 053 076AL	**7.6**	8	53	91
K2DMC 053 077AL	**7.7**	8	53	91
K2DMC 053 078AL	**7.8**	8	53	91
K2DMC 053 079AL	**7.9**	8	53	91
K2DMC 053 080AL	**8.0**	8	53	91

DIA Tolerance	
Dia ≤ 6.0 mm	+ 0 / - 0.012 mm
Dia > 6.0 mm	+ 0 / - 0.015 mm
SHK Tolerance	
h6	

Note: For extended tool life, S coating are recommended.

K2DMC (Diameter 8.1 - 10.8 mm)

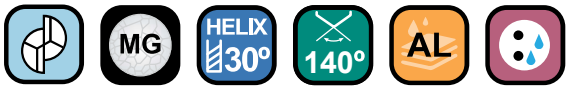
Work Materials

P	K	H
■	■	□

SOLID CARBIDE 2-FLUTE DRILL (COOLANT FED)

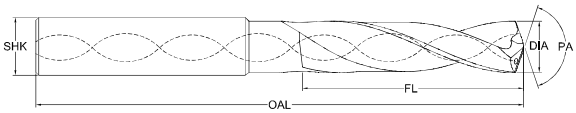
2刃钨钢双孔螺旋钻头

5X



FEATURES:

- General purpose coolant fed drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 5x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
- Low Helix Angle to maximize tools' rigidity.



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 5X				
K2DMC 061 081AL	**8.1**	10	61	103
K2DMC 061 082AL	**8.2**	10	61	103
K2DMC 061 083AL	**8.3**	10	61	103
K2DMC 061 084AL	**8.4**	10	61	103
K2DMC 061 085AL	**8.5**	10	61	103
K2DMC 061 086AL	**8.6**	10	61	103
K2DMC 061 087AL	**8.7**	10	61	103
K2DMC 061 088AL	**8.8**	10	61	103
K2DMC 061 089AL	**8.9**	10	61	103
K2DMC 061 090AL	**9.0**	10	61	103
K2DMC 061 091AL	**9.1**	10	61	103
K2DMC 061 092AL	**9.2**	10	61	103
K2DMC 061 093AL	**9.3**	10	61	103
K2DMC 061 094AL	**9.4**	10	61	103
K2DMC 061 095AL	**9.5**	10	61	103
K2DMC 061 096AL	**9.6**	10	61	103
K2DMC 061 097AL	**9.7**	10	61	103
K2DMC 061 098AL	**9.8**	10	61	103
K2DMC 061 099AL	**9.9**	10	61	103
K2DMC 061 100AL	**10.0**	10	61	103
K2DMC 071 102AL	**10.2**	12	71	118
K2DMC 071 105AL	**10.5**	12	71	118
K2DMC 071 108AL	**10.8**	12	71	118

DIA Tolerance	
Dia ≤ 10.0 mm	+ 0 / - 0.015 mm
Dia > 10.0 mm	+ 0 / - 0.018 mm
SHK Tolerance	
h6	

Note: For extended tool life, S coating are recommended.

K2DMC (Diameter 11.0 - 20.0 mm)

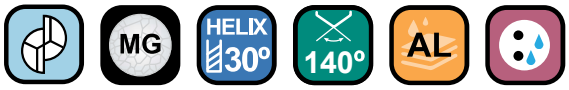
Work Materials

P	K	H
■	■	□

SOLID CARBIDE 2-FLUTE DRILL (COOLANT FED)

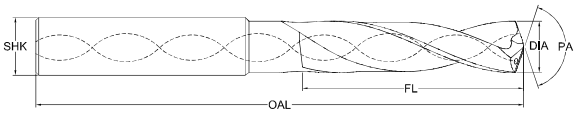
2刃钨钢双孔螺旋钻头

5X



FEATURES:

- General purpose coolant fed drills for die & mold machining.
- Ideal for drilling applications of work materials up to 55 HRc hardness.
- Drill up to 5x diameter in depth.
- 4-facet point with radius gash provides fast self-centering penetration.
- Low Helix Angle to maximize tools' rigidity.



PRODUCT CODE	DIA	SHK	FL	OAL
Drill Depth 5X				
K2DMC 071 110AL	11.0	12	71	118
K2DMC 071 115AL	11.5	12	71	118
K2DMC 071 120AL	12.0	12	71	118
K2DMC 077 125AL	12.5	14	77	124
K2DMC 077 130AL	13.0	14	77	124
K2DMC 077 135AL	13.5	14	77	124
K2DMC 077 140AL	14.0	14	77	124
K2DMC 083 145AL	14.5	16	83	133
K2DMC 083 150AL	15.0	16	83	133
K2DMC 083 155AL	15.5	16	83	133
K2DMC 083 160AL	16.0	16	83	133
K2DMC 093 165AL	16.5	18	93	143
K2DMC 093 170AL	17.0	18	93	143
K2DMC 093 175AL	17.5	18	93	143
K2DMC 093 180AL	18.0	18	93	143
K2DMC 101 185AL	18.5	20	101	153
K2DMC 101 190AL	19.0	20	101	153
K2DMC 101 195AL	19.5	20	101	153
K2DMC 101 200AL	20.0	20	101	153

Note: For extended tool life, S coating are recommended.

DIA Tolerance
+ 0 / - 0.018 mm
SHK Tolerance
h6

K4STRM / K6STRM

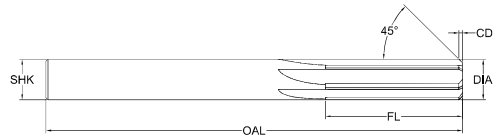
Work Materials

P	M	K	N
▢	▢	▣	▣

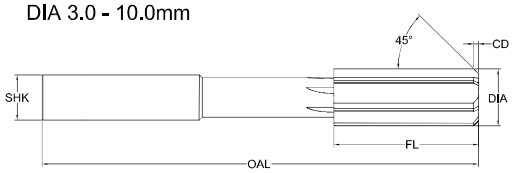
SOLID CARBIDE 4 / 6-FLUTE STRAIGHT FLUTE REAMER

4/6刃钨钢直刃绞刀

MG | HELIX 0° | C | U



DIA 3.0 - 10.0mm



DIA 11.0 - 20.0mm

FEATURES:

- Straight flute reamer suited for both blind & through hole applications.
- Flat bottom shape with 45 degree chamfer.
- Direct reaming upon pilot-hole drilling, without a necessity of hole correction by end mill.

PRODUCT CODE	DIA (h7)	Z	CD	SHK	FL	OAL
K4STRM 030U	**3.0**	4	0.5	3	15	61
K4STRM 040U	**4.0**	4	0.5	4	27	60
K6STRM 050U	**5.0**	6	0.5	5	27	60
K6STRM 060U	**6.0**	6	0.8	6	27	60
K6STRM 070U	**7.0**	6	0.8	7	30	70
K6STRM 080U	**8.0**	6	0.8	8	30	70
K6STRM 090U	**9.0**	6	1.0	9	30	70
K6STRM 100U	**10.0**	6	1.0	10	38	80
K6STRM 110U	**11.0**	6	1.0	10	41	80
K6STRM 120U	**12.0**	6	1.0	10	44	80
K6STRM 130U	**13.0**	6	1.0	10	44	80
K6STRM 140U	**14.0**	6	1.0	12	47	80
K6STRM 150U	**15.0**	6	2.0	12	52	80
K6STRM 160U	**16.0**	6	2.0	12	52	80
K6STRM 180U	**18.0**	6	2.0	14	56	80
K6STRM 200U	**20.0**	6	2.0	16	60	80

DIA Tolerance
h7
SHK Tolerance
h6

K3CS

Work Materials

P	M	K	N	S
■	■	■	■	□

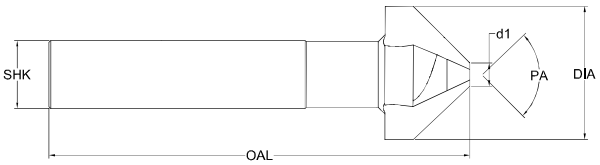
SOLID CARBIDE 3-FLUTE COUNTERSINK

3刃钨钢倒角刀

MG | HELIX 20° | AL

FEATURES:

- Designed with constant 20 degree rake angle & eccentric relief.
- Suitable for countersinking operation of cap screw holes.
- 3-Flutes countersink head with typical point angle, PA = 60°, 82°, 90° & 120°.



PRODUCT CODE	PA	DIA	d1	SHK	OAL
Tolerance	-1°	+0.3	h8	h6	±1.0
K3CS 060 060AL	60°	6.0	1	6	38
K3CS 060 100AL		10.0	1	6	50
K3CS 060 120AL		12.0	2	8	57
K3CS 060 150AL		15.0	2	8	60
K3CS 060 200AL		20.0	2	10	75
K3CS 060 250AL		25.0	3	12	80
K3CS 060 300AL		30.0	3	12	100
K3CS 082 060AL	82°	6.0	1	6	41
K3CS 082 100AL		10.0	1	6	46
K3CS 082 120AL		12.0	2	8	51
K3CS 082 150AL		15.0	2	8	56
K3CS 082 200AL		20.0	2	10	66
K3CS 082 250AL		25.0	3	12	80
K3CS 082 300AL		30.0	3	12	90
K3CS 090 060AL	90°	6.0	1	6	40
K3CS 090 080AL		8.0	1	6	40
K3CS 090 100AL		10.0	2	6	50
K3CS 090 120AL		12.0	2	8	50
K3CS 090 150AL		15.0	2	8	57
K3CS 090 200AL		20.0	2	10	63
K3CS 090 250AL		25.0	3	12	80
K3CS 090 300AL		30.0	3	12	92
K3CS 120 100AL	120°	10.0	2	6	50
K3CS 120 120AL		12.0	2	8	50
K3CS 120 150AL		15.0	2	8	57
K3CS 120 200AL		20.0	2	10	63
K3CS 120 250AL		25.0	3	12	73
K3CS 120 300AL		30.0	3	12	80

Note: For extended tool life, S coating are recommended.

K2FD

Work Materials

P	M	K	N	S
■	■	■	■	□

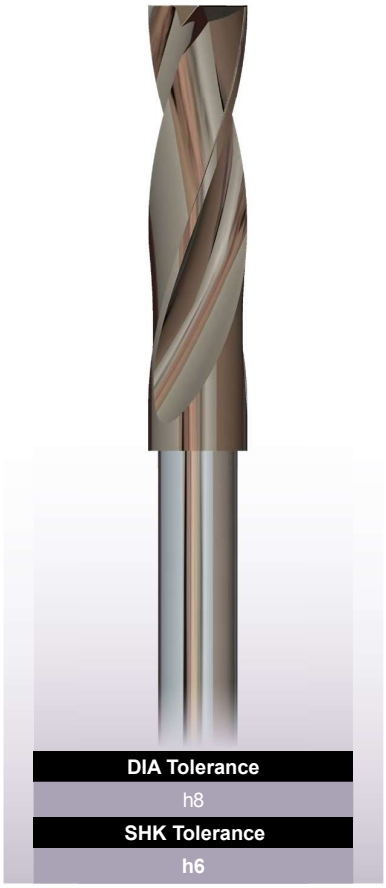
SOLID CARBIDE 2-FLUTE FLAT DRILL (COUNTERBORE)

2刃钨钢扁钻

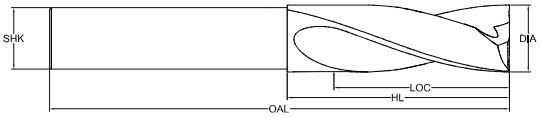
MG | HELIX 20° | AL

FEATURES:

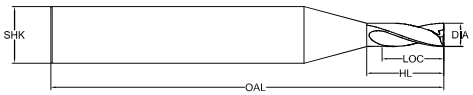
- Designed with end face of end mill with zero dish angle.
- Its flat bottom (no dish) design allows spot facing or counterboring on irregular surfaces.
- Also suitable for straightening of misaligned holes or bottom face reaming.



DIA Tolerance
h8
SHK Tolerance
h6



DIA 6.0 - 20.0mm



DIA 2.0 - 4.5mm

PRODUCT CODE	DIA	SHK	FL	HL	OAL
K2FD 10 020AL	**2.0**	4	10	10.3	50
K2FD 12 025AL	**2.5**	4	12	12.5	50
K2FD 15 030AL	**3.0**	6	15	11.4	55
K2FD 16 035AL	**3.5**	6	16	12.3	55
K2FD 19 040AL	**4.0**	6	19	18.3	60
K2FD 21 045AL	**4.5**	6	21	19.2	60
K2FD 27 060AL	**6.0**	6	27	27	65
K2FD 30 065AL	**6.5**	6	30	32	70
K2FD 34 080AL	**8.0**	8	34	36	75
K2FD 38 085AL	**8.5**	8	38	40	80
K2FD 42 100AL	**10.0**	10	42	44	85
K2FD 46 105AL	**10.5**	10	46	48	90
K2FD 50 120AL	**12.0**	12	50	52	95
K2FD 56 125AL	**12.5**	12	56	58	100
K2FD 60 140AL	**14.0**	12	60	62	105
K2FD 64 145AL	**14.5**	12	64	66	110
K2FD 68 160AL	**16.0**	16	68	70	115
K2FD 74 165AL	**16.5**	16	74	76	125
K2FD 78 180AL	**18.0**	16	78	80	130
K2FD 84 185AL	**18.5**	16	84	86	135
K2FD 88 200AL	**20.0**	20	88	90	140

Note: For extended tool life, S coating are recommended.

K2DSP

ISO WORK MATERIAL CODE	P	Low Carbon Steel (C < 0.3 %)		P	Carbon Steel (~30HRC)		P	Alloy Steel (~30HRC)	
Examples		S275 ▪ SS400			S45C ▪ S50C			SCM ▪ SCr ▪ SNCM	
Cutting Speed		70 ~ 120 m/min			60 ~ 120 m/min			60 ~ 120 m/min	
Dc (mm)		n (min-1)	Vf (mm/min)		n (min-1)	Vf (mm/min)		n (min-1)	Vf (mm/min)
5.0		4400	300 - 350		3800	260 - 270		3800	260 - 270
8.0		2800	270 - 290		2400	240 - 250		2400	240 - 250
10.0		2200	250 - 280		1900	220 - 240		1900	220 - 240
12.0		1800	230 - 260		1600	180 - 210		1600	180 - 210
16.0		1400	180 - 230		1200	160 - 190		1200	160 - 190

ISO WORK MATERIAL CODE	K	Cast Iron (~ 350 N/mm²)		M	Stainless Steel (400 ~ 800 N/mm²)		N	Aluminium Alloy (≤ 20 HRc)	
Examples		FC250			SUS304 ▪ SUS316			A6061 ▪ A7075	
Cutting Speed		60 ~ 120 m/min			40 ~ 80 m/min			40 ~ 80 m/min	
Dc (mm)		n (min-1)	Vf (mm/min)		n (min-1)	Vf (mm/min)		n (min-1)	Vf (mm/min)
5.0		4400	300 - 350		1300	350 - 380		7650	850 - 1000
8.0		2800	320 - 330		800	330 - 340		4800	780 - 820
10.0		2200	300 - 320		640	300 - 320		3800	690 - 760
12.0		1800	280 - 300		530	280 - 300		3200	610 - 640
16.0		1400	250 - 280		400	250 - 270		2400	550 - 600

Note: ▪ The above operating parameters are for tool coated with AL-coating. For uncoated tools, please reduce 30% of the provided spindle speed, **n** (min-1) & feedrate, **vf**.

▪ Adjust drilling conditions when unusual vibration or different sound occurs.

Operating Parameters provided as a starting guide, actual performance may defer subject to work material, machine condition and setup.

Dc = Cutter Diameter (mm) 切削直径 **n** = Spindle Speed (mm^{-1}) 转速 **Vf** = Feed Rate (mm/min) 进给速

Ap = Depth of cut (mm) 切削深度 **Ae** = Width of Cut (mm) 切削宽度

K2DDSF

ISO WORK MATERIAL CODE	K	Cast Iron (~ 350 N/mm)	N	Bronze (≤ 25 HRc)	N	Aluminium Alloy & Cast Aluminium	
Examples		FC250		BC2 ▪ BC3		A6061 ▪ ADC12	
Cutting Speed		60 ~ 120 m/min		60 ~ 120 m/min		40 ~ 80 m/min	
Dc (mm)		n (min^{-1})		Vf (mm/min)		n (min^{-1})	Vf (mm/min)
4.0		8900		990 - 1150		5880	420 - 440	10200	1420 - 1530
5.0		7640		850 - 960		5100	380 - 410	8920	1270 - 1380
6.0		6370		300 - 800		4250	310 - 340	7430	980 - 1190
7.0		5570		680 - 740		3720	270 - 290	6500	920 - 950
8.0		4780		520 - 600		3190	230 - 260	5570	780 - 890
10.0		3820		430 - 480		2550	180 - 200	4460	680 - 710
12.0		3190		380 - 400		2150	150 - 170	3720	570 - 600
16.0		2390		270 - 300		1590	100 - 130	2790	420 - 450

Note: ▪ Adjust drilling conditions when unusual vibration or different sound occurs.
▪ For hole depths greater than 3 x **D**c , pecking is recommended.

Operating Parameters provided as a starting guide, actual performance may defer subject to work material, machine condition and setup.

Dc = Cutter Diameter (mm) 切削直径
n = Spindle Speed (mm^{-1}) 转速
Vf = Feed Rate (mm/min) 进给速
Ap = Depth of cut (mm) 切削深度
Ae = Width of Cut (mm) 切削宽度

K2DS

SURFACE SPEED

ISO WORK MATERIAL CODE		Examples	Vc (mm/min)
P	Low Carbon Steel	S45C, S50C, SS400	40 - 80
P	Alloy Steel	SCM-420, SCM-440 , 4140	30 - 45
P	Pre-Hardened Steel ≤ 45HRc	NAK55, NAK80	
P	Ferritic & Martensitic Stainless Steel	SUS 420, SUS 421 & 500 Series	
P	PH Stainless Steel	13-8 PH, 15-5 PH, 17-4 PH	15 - 20
M	Austenitic, Duplex & Cast Stainless Steel	SUS 303, SUS 304, SUS 316, SUS 316L, Nitronic 60, SUS 323, SUS 329, F55, 2205, S329000	25 - 40
K	Cast Iron	FC200, FC250, FC300, FCH15, FCH30	40 - 80
S	Titanium & Titanium Alloy	Ti98.8, Ti 98.9, Ti-Al5-Sn2, Ti-Al6-V4, Ti-Al6-Zr5	15 -20
S	High Temperature Alloy	Inconel, Inconel 718, Monel, Nimonic, Hastelloy	
H	Hardened Steel 50 - 55 HRc	HPM38, SKT4, SKD61	15 - 20
N	Non-Ferrous	A2024, A6061, A7075	40 - 80

FEEDRATE

ISO WORK MATERIAL CODE		Drill Diameter Dc (mm) >>> fn (mm/rev)												
		0.2	0.35	0.5	0.75	1.0	1.3	1.5	1.75	2.0	2.25	2.5	2.75	3.0
P	Low Carbon Steel	0.004	0.006	0.008	0.014	0.025	0.032	0.045	0.050	0.055	0.060	0.065	0.070	0.075
P	Alloy Steel	0.004	0.005	0.007	0.008	0.015	0.024	0.034	0.040	0.050	0.058	0.063	0.071	0.075
P	Pre-Hardened Steel ≤ 45HRc	0.003	0.004	0.005	0.008	0.012	0.017	0.021	0.030	0.040	0.045	0.050	0.055	0.060
P	Ferritic & Martensitic Stainless Steel	0.003	0.005	0.006	0.010	0.015	0.020	0.035	0.040	0.050	0.055	0.060	0.070	0.075
P	PH Stainless Steel	0.002	0.004	0.005	0.008	0.010	0.015	0.020	0.025	0.030	0.030	0.032	0.032	0.035
M	Austenitic, Duplex & Cast Stainless Steel	0.003	0.005	0.006	0.010	0.015	0.020	0.028	0.035	0.050	0.055	0.060	0.070	0.075
K	Cast Iron	0.004	0.006	0.007	0.012	0.020	0.030	0.040	0.045	0.050	0.055	0.060	0.065	0.070
S	Titanium, Titanium Alloy & High Temperature Alloy	0.002	0.004	0.005	0.008	0.010	0.015	0.020	0.025	0.030	0.030	0.032	0.033	0.035
H	Hardened Steels 50 - 55 HRc	0.002	0.004	0.005	0.006	0.010	0.012	0.014	0.016	0.020	0.025	0.030	0.032	0.035
N	Non-Ferrous	0.007	0.011	0.015	0.020	0.025	0.035	0.050	0.060	0.075	0.080	0.085	0.090	0.100

Calculating Spindle Speed & Feedrate: Spindle Speed, **n** (min-1) = (318.26 x **V**c) / **D**c Feedrate, **V**f (mm/min) = **n** x **f**n

Note:
- Adjust drilling conditions when unusual vibration or different sound occurs.
- For hole depths greater than 3 x **D**c , pecking is recommended. (Please refer to provided Pecking Depth Table below.)

Operating Parameters provided as a starting guide, actual performance may defer subject to work material, machine condition and setup.

PECKING DEPTH

ISO WORK MATERIAL CODE		Drill Diameter Dc (mm) >>> Peck Amount Q (mm)					
		0.2 - 0.96	1.0 - 1.45	1.5 - 1.95	2.0 - 2.45	2.5 - 2.95	3.0
P	Low Carbon Steel	0.1 x **D**c	0.2 x **D**c	0.2 x **D**c	0.2 x **D**c	0.2 x **D**c	0.2 x **D**c
P	Alloy Steel	0.1 x **D**c	0.2 x **D**c	0.2 x **D**c	0.2 x **D**c	0.2 x **D**c	0.2 x **D**c
P	Pre-Hardened Steel ≤ 45HRc	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c
P	Ferritic & Martensitic Stainless Steel	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c
P	PH Stainless Steel	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c
M	Austenitic, Duplex & Cast Stainless Steel	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c
K	Cast Iron	0.1 x **D**c	0.2 x **D**c	0.2 x **D**c	0.2 x **D**c	0.2 x **D**c	0.2 x **D**c
S	Titanium, Titanium Alloy & High Temperature Alloy	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c
H	Hardened Steel 50 - 55 HRc	0.05 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c	0.1 x **D**c
N	Non-Ferrous	0.1 x **D**c	0.5 x **D**c	1.0 x **D**c	1.5 x **D**c	2.0 x **D**c	3.0 x **D**c

Dc = Cutter Diameter (mm) 切削直径
n = Spindle Speed (mm^{-1}) 转速
Vf = Feed Rate (mm/min) 进给速
Ap = Depth of cut (mm) 切削深度
Ae = Width of Cut (mm) 切削宽度

K2DM

ISO WORK MATERIAL CODE	P Carbon Steel		P Low Alloyed Steel (~24HRC)		P High Alloyed Steel (~30HRC)		H Hardened Steel (30~38HRC)		H Hardened Steel (38~45HRC)		K Cast Iron	
Cutting Speed	60 ~ 100 m/min		60 ~ 100 m/min		60 ~ 100 m/min		40 ~ 65 m/min		30 ~ 45 m/min		60 ~ 120 m/min	
Dc (mm)	**n** (min^{-1})	**fn** (mm/rev)	**n** (min^{-1})	**fn** (mm/rev)	**n** (min^{-1})	**fn** (mm/rev)	**n** (min^{-1})	**fn** (mm/rev)	**n** (min^{-1})	**fn** (mm/rev)	**n** (min^{-1})	**fn** (mm/rev)
3.0	8000	0.09	8000	0.09	8000	0.09	5000	0.09	4000	0.09	8000	0.09
3.5	7100	0.09	7100	0.09	7100	0.09	4400	0.09	3900	0.09	7100	0.09
4.0	6300	0.10	6300	0.10	6300	0.10	3800	0.10	3800	0.10	6300	0.10
4.5	5600	0.11	5600	0.11	5600	0.11	3400	0.11	3400	0.11	5600	0.11
5.0	5000	0.12	5000	0.12	5000	0.12	3000	0.12	3000	0.12	5000	0.12
5.5	4600	0.13	4600	0.13	4600	0.13	2800	0.13	2800	0.13	4600	0.13
6.0	4200	0.14	4200	0.14	4200	0.14	2600	0.14	2600	0.14	4200	0.14
6.5	3950	0.14	3950	0.14	3950	0.14	3425	0.14	3425	0.14	3950	0.14
7.0	3700	0.15	3700	0.15	3700	0.15	2250	0.15	2250	0.15	3700	0.15
7.5	3450	0.15	3450	0.15	3450	0.15	2075	0.15	2075	0.15	3450	0.15
8.0	3200	0.16	3200	0.16	3200	0.16	1900	0.16	1900	0.16	3200	0.16
8.5	3050	0.16	3050	0.16	3050	0.16	1825	0.16	1825	0.16	3050	0.16
9.0	2870	0.17	2870	0.17	2870	0.17	1750	0.17	1750	0.17	2870	0.17
9.5	2700	0.17	2700	0.17	2700	0.17	1675	0.17	1675	0.17	2700	0.17
10.0	2550	0.18	2550	0.18	2550	0.18	1600	0.18	1600	0.18	2550	0.18
10.5	2450	0.18	2450	0.18	2450	0.18	1525	0.18	1525	0.18	2450	0.18
11.0	2350	0.19	2350	0.19	2350	0.19	1450	0.19	1450	0.19	2350	0.19
11.5	2225	0.19	2225	0.19	2225	0.19	1375	0.19	1375	0.19	2225	0.19
12.0	2100	0.20	2100	0.20	2100	0.20	1300	0.20	1300	0.20	2100	0.20
12.5	1975	0.20	1975	0.20	1975	0.20	1225	0.20	1225	0.20	1975	0.20
13.0	1850	0.21	1850	0.21	1850	0.21	1150	0.21	1150	0.21	1850	0.21
13.5	1850	0.21	1850	0.21	1850	0.21	1150	0.21	1150	0.21	1850	0.21
14.0	1800	0.22	1800	0.22	1800	0.22	1100	0.22	1100	0.22	1800	0.22
14.5	1750	0.22	1750	0.22	1750	0.22	1075	0.22	1075	0.22	1750	0.22
15.0	1700	0.23	1700	0.23	1700	0.23	1025	0.23	1025	0.23	1700	0.23
15.5	1650	0.24	1650	0.24	1650	0.24	980	0.24	980	0.24	1650	0.24
16.0	1600	0.25	1600	0.25	1600	0.25	950	0.25	950	0.25	1600	0.25
16.5	1550	0.25	1550	0.25	1550	0.25	925	0.25	925	0.25	1550	0.25
17.0	1500	0.26	1500	0.26	1500	0.26	900	0.26	900	0.26	1500	0.26
17.5	1450	0.26	1450	0.26	1450	0.26	875	0.26	875	0.26	1450	0.26
18.0	1400	0.28	1400	0.28	1400	0.28	850	0.28	850	0.28	1400	0.28
18.5	1400	0.28	1400	0.28	1400	0.28	825	0.28	825	0.28	1400	0.28
19.0	1350	0.29	1350	0.29	1350	0.29	800	0.29	800	0.29	1350	0.29
19.5	1350	0.29	1350	0.29	1350	0.29	780	0.29	780	0.29	1350	0.29
20.0	1300	0.30	1300	0.30	1300	0.30	780	0.30	760	0.30	1300	0.30

Note:
- Adjust drilling conditions when unusual vibration or different sound occurs.
- For hole depths greater than 3 x **D**c , pecking is recommended.

Operating Parameters provided as a starting guide, actual performance may defer subject to work material, machine condition and setup.

Dc = Cutter Diameter (mm) 切削直径
n = Spindle Speed (mm^{-1}) 转速
Vf = Feed Rate (mm/min) 进给速
Ap = Depth of cut (mm) 切削深度
Ae = Width of Cut (mm) 切削宽度

K2DMC

Coolant Fed

ISO WORK MATERIAL CODE	P Carbon Steel		P Low Alloyed Steel (~24HRC)		P High Alloyed Steel (~30HRC)		H Hardened Steel (30~38HRC)		H Hardened Steel (38~45HRC)		M Stainless Steel		K Cast Iron	
Cutting Speed	80 ~ 150 m/min		80 ~ 150 m/min		80 ~ 150 m/min		40 ~ 70 m/min		32 ~ 50 m/min		50 ~ 80 m/min		80 ~ 150 m/min	
Dc (mm)	n (min^{-1})	fn (mm/rev)	n (min^{-1})	fn (mm/rev)	n (min^{-1})	fn (mm/rev)	n (min^{-1})	fn (mm/rev)	n (min^{-1})	fn (mm/rev)	n (min^{-1})	fn (mm/rev)	n (min^{-1})	fn (mm/rev)
3.0	13000	0.09	13000	0.09	13000	0.09	6400	0.09	5300	0.09	6300	0.09	13000	0.09
3.5	11250	0.09	11250	0.09	11250	0.09	5600	0.09	4600	0.09	5500	0.09	11250	0.09
4.0	9500	0.10	9500	0.10	9500	0.10	4800	0.10	4000	0.10	4700	0.10	9500	0.10
4.5	8500	0.11	8500	0.11	8500	0.11	4200	0.11	3600	0.11	4250	0.11	8500	0.11
5.0	7600	0.12	7600	0.12	7600	0.12	3800	0.12	3200	0.12	3800	0.12	7600	0.12
5.5	7000	0.13	7000	0.13	7000	0.13	3500	0.13	2920	0.13	3500	0.13	7000	0.13
6.0	6400	0.14	6400	0.14	6400	0.14	3200	0.14	2650	0.14	3200	0.14	6400	0.14
6.5	6000	0.14	6000	0.14	6000	0.14	3000	0.14	2480	0.14	3000	0.15	6000	0.14
7.0	5600	0.15	5600	0.15	5600	0.15	2800	0.15	2320	0.15	2800	0.15	5600	0.15
7.5	5200	0.15	5200	0.15	5200	0.15	2600	0.15	2160	0.15	2600	0.15	5200	0.15
8.0	4800	0.16	4800	0.16	4800	0.16	2400	0.16	2000	0.16	2400	0.16	4800	0.16
8.5	4550	0.16	4550	0.16	4550	0.16	2275	0.16	1900	0.16	2275	0.16	4550	0.16
9.0	4300	0.17	4300	0.17	4300	0.17	2150	0.17	1800	0.17	2150	0.17	4300	0.17
9.5	4050	0.17	4050	0.17	4050	0.17	2025	0.17	1700	0.17	2025	0.17	4050	0.17
10.0	3800	0.18	3800	0.18	3800	0.18	1900	0.18	1600	0.18	1900	0.18	3800	0.18
10.5	3650	0.18	3650	0.18	3650	0.18	1825	0.18	1525	0.18	1825	0.18	3650	0.18
11.0	3500	0.19	3500	0.19	3500	0.19	1750	0.19	1450	0.19	1750	0.19	3500	0.19
11.5	3350	0.19	3350	0.19	3350	0.19	1675	0.19	1375	0.19	1675	0.19	3350	0.19
12.0	3200	0.20	3200	0.20	3200	0.20	1600	0.20	1300	0.20	1600	0.20	3200	0.20
12.5	3075	0.20	3075	0.20	3075	0.20	1535	0.20	1225	0.20	1530	0.20	3075	0.20
13.0	2950	0.21	2950	0.21	2950	0.21	1475	0.21	1150	0.21	1475	0.21	2950	0.21
13.5	2825	0.21	2825	0.21	2825	0.21	1410	0.21	1150	0.21	1410	0.21	2825	0.21
14.0	2700	0.22	2700	0.22	2700	0.22	1350	0.22	1100	0.22	1350	0.22	2700	0.22
14.5	2625	0.22	2625	0.22	2625	0.22	1310	0.22	1075	0.22	1310	0.23	2625	0.23
15.0	2550	0.23	2550	0.23	2550	0.23	1275	0.23	1025	0.23	1275	0.24	2550	0.24
15.5	2475	0.24	2475	0.24	2475	0.24	1230	0.24	980	0.24	1235	0.24	2475	0.24
16.0	2400	0.25	2400	0.25	2400	0.25	1200	0.25	950	0.25	1200	0.25	2400	0.25
16.5	2325	0.25	2325	0.25	2325	0.25	1175	0.25	925	0.25	1175	0.26	2325	0.25
17.0	2250	0.26	2250	0.26	2250	0.26	1150	0.26	900	0.26	1150	0.27	2250	0.26
17.5	2475	0.26	2475	0.26	2475	0.26	1125	0.26	875	0.26	1125	0.27	2175	0.26
18.0	2400	0.28	2400	0.28	2400	0.28	1100	0.28	850	0.28	1100	0.28	2100	0.28
18.5	2325	0.28	2325	0.28	2325	0.28	1075	0.28	825	0.28	1065	0.28	2050	0.28
19.0	2250	0.29	2250	0.29	2250	0.29	1050	0.29	800	0.29	1025	0.29	2000	0.29
19.5	2175	0.29	2175	0.29	2175	0.29	1025	0.29	780	0.29	980	0.29	1950	0.29
20.0	2100	0.30	2100	0.30	2100	0.30	1000	0.30	760	0.30	950	0.30	1900	0.30

Note: ▪ Adjust drilling conditions when unusual vibration or different sound occurs.
▪ For hole depths greater than 3 x **D**c , pecking is recommended.

Operating Parameters provided as a starting guide, actual performance may defer subject to work material, machine condition and setup.

Dc = Cutter Diameter (mm) 切削直径
n = Spindle Speed (mm^{-1}) 转速
Vf = Feed Rate (mm/min) 进给速
Ap = Depth of cut (mm) 切削深度
Ae = Width of Cut (mm) 切削宽度

K4STRM / K6STRM

w (mm) = stock allowance for reamer

ISO WORK MATERIAL CODE	P Carbon Steel		P Low Alloyed Steel (~24HRC)		P High Alloyed Steel (~30HRC)		H Hardened Steel (30~38HRC)		H Hardened Steel (38~48HRC)	
Cutting Speed	Vc: 10 ~ 20 m/min		Vc: 10 ~ 20 m/min		Vc: 18 ~ 15 m/min		Vc: 5 ~ 10 m/min		Vc: 4 ~ 10 m/min	
Dc (mm)	w (mm)	Vf (mm/min)	w (mm)	Vf (mm/min)	w (mm)	Vf (mm/min)	w (mm)	Vf (mm/min)	w (mm)	Vf (mm/min)
3.0	0.05 - 0.15	0.02 - 0.03	0.05 - 0.15	0.018 - 0.03	0.05 - 0.15	0.018 - 0.03	0.05 - 0.15	0.015 - 0.027	0.03 - 0.08	0.01 - 0.02
4.0	0.10 - 0.20	0.025 - 0.045	0.10 - 0.20	0.03 - 0.045	0.10 - 0.20	0.03 - 0.045	0.10 - 0.20	0.023 - 0.04	0.03 - 0.08	0.012 - 0.03
5.0	0.10 - 0.20	0.04 - 0.06	0.10 - 0.20	0.04 - 0.06	0.10 - 0.20	0.04 - 0.06	0.10 - 0.20	0.032 - 0.052	0.03 - 0.08	0.015 - 0.035
6.0	0.10 - 0.20	0.05 - 0.09	0.10 - 0.20	0.05 - 0.09	0.10 - 0.20	0.05 - 0.09	0.10 - 0.20	0.04 - 0.08	0.03 - 0.08	0.02 - 0.05
8.0	0.10 - 0.20	0.06 - 0.15	0.10 - 0.20	0.06 - 0.12	0.10 - 0.20	0.06 - 0.12	0.10 - 0.20	0.06 - 0.10	0.03 - 0.08	0.025 - 0.055
10.0	0.10 - 0.20	0.07 - 0.13	0.10 - 0.20	0.07 - 0.13	0.10 - 0.20	0.07 - 0.13	0.10 - 0.20	0.05 - 0.12	0.03 - 0.08	0.025 - 0.06
12.0	0.10 - 0.20	0.08 - 0.15	0.10 - 0.20	0.08 - 0.15	0.10 - 0.20	0.08 - 0.15	0.10 - 0.20	0.06 - 0.13	0.03 - 0.08	0.03 - 0.075
14.0	0.10 - 0.20	0.09 - 0.18	0.10 - 0.20	0.10 - 0.18	0.10 - 0.20	0.10 - 0.18	0.10 - 0.20	0.07 - 0.18	0.03 - 0.08	0.04 - 0.075
16.0	0.10 - 0.20	0.10 - 0.20	0.10 - 0.20	0.10 - 0.20	0.10 - 0.20	0.10 - 0.20	0.10 - 0.20	0.08 - 0.18	0.03 - 0.08	0.04 - 0.08
18.0	0.10 - 0.20	0.12 - 0.18	0.10 - 0.20	0.10 - 0.20	0.10 - 0.20	0.10 - 0.20	0.10 - 0.20	0.10 - 0.18	0.03 - 0.08	0.04 - 0.09
20.0	0.10 - 0.20	0.12 - 0.22	0.10 - 0.20	0.10 - 0.20	0.10 - 0.20	0.10 - 0.20	0.10 - 0.20	0.10 - 0.20	0.03 - 0.08	0.04 - 0.09

ISO WORK MATERIAL CODE	M Stainless Steel		K Cast Iron		N Aluminium		N Copper	
Cutting Speed	Vc: 8 ~ 15 m/min		Vc: 8 ~ 18 m/min		Vc: 15 ~ 30 m/min		Vc: 10 ~ 25 m/min	
Dc (mm)	w (mm)	Vf (mm/min)	w (mm)	Vf (mm/min)	w (mm)	Vf (mm/min)	w (mm)	Vf (mm/min)
3.0	0.05 - 0.15	0.018 - 0.03	0.05 - 0.10	0.008 - 0.015	0.10 - 0.20	0.018 - 0.03	0.05 - 0.15	0.018 - 0.03
4.0	0.10 - 0.20	0.028 - 0.045	0.05 - 0.10	0.028 - 0.045	0.10 - 0.20	0.028 - 0.045	0.10 - 0.20	0.028 - 0.045
5.0	0.10 - 0.20	0.04 - 0.06	0.05 - 0.10	0.04 - 0.06	0.10 - 0.20	0.04 - 0.06	0.10 - 0.20	0.04 - 0.06
6.0	0.10 - 0.20	0.05 - 0.09	0.05 - 0.10	0.05 - 0.09	0.10 - 0.20	0.06 - 0.09	0.10 - 0.20	0.05 - 0.09
8.0	0.10 - 0.20	0.06 - 0 12	0.05 - 0.10	0.06 - 0.12	0.10 - 0.20	0.07 - 0.12	0.10 - 0.20	0.06 - 0.12
10.0	0.10 - 0.20	0.06 - 0 12	0.05 - 0.10	0.07 - 0.13	0.10 - 0.20	0.08 - 0.17	0.10 - 0.20	0.07 - 0.13
12.0	0.10 - 0.20	0.08 - 0.15	0.05 - 0.10	0.08 - 0.15	0.10 - 0.20	0.08 - 0.18	0.10 - 0.20	0.08 - 0.15
14.0	0.10 - 0.20	0.08 - 0.15	0.05 - 0.10	0.10 - 0.18	0.10 - 0.20	0.08 - 0.20	0.10 - 0.20	0.08 - 0.15
16.0	0.10 - 0.20	0.10 - 0.20	0.05 - 0.10	0.10 - 0.20	0.10 - 0.20	0.10 - 0.22	0.10 - 0.20	0.10 - 0.20
18.0	0.10 - 0.20	0.11 - 0.21	0.05 - 0.10	0.12 - 0.20	0.10 - 0.20	0.12 - 0.27	0.10 - 0.20	0.10 - 0.21
20.0	0.10 - 0.20	0.12 – 0.22	0.05 - 0.10	0.12 - 0.23	0.10 - 0.20	0.13 - 0.30	0.10 - 0.20	0.12 - 0.23

Calculating Spindle Speed & Feedrate: Spindle Speed, **n** (min-1) = (318.26 x **V**c) / **D**c

Note:
- Please work with good rigidity / high precision facilities & collet chuck
- Please choose proper cutting fluid
- The cutting data is reference value only, adjust accordingly to your real working condition.
- If RPM Is lower than the reference value, please reduce the Feedrate, Vf & RPM by the same proportion.

Dc = Cutter Diameter (mm) 切削直径
n = Spindle Speed (mm^{-1}) 转速
Vf = Feed Rate (mm/min) 进给速
Ap = Depth of cut (mm) 切削深度
Ae = Width of Cut (mm) 切削宽度

K3CS

DEBURRING / COUNTERSINKING

ISO WORK MATERIAL CODE		Vc (m/min)	Drill Diameter Dc (mm) >>> Peck Amount Q (mm)		
			10	20	30
			Vf (mm/min)		
P	Low Carbon Steel	40 ~ 80	250	125	85
P	Alloy Steel	30 ~ 60	100	60	45
P	Pre-Hardened Steel ≤ 45HRc	30 ~ 60	85	45	25
P	Ferritic & Martensitic Stainless Steel	20 ~ 50	90	50	40
P	PH Stainless Steel	16 ~ 20	80	40	30
M	Austenitic, Duplex & Cast Stainless Steel	20 ~ 40	100	60	40
K	Cast Iron	40 ~ 80	250	150	100
S	Titanium, Titanium Alloy & High Temperature Alloy	10 ~ 12	28	16	10
H	Hardened Steel 50 - 55 HRc	8 ~ 10	20	10	8
N	Non-Ferrous	40 ~ 100	350	230	200

CHAMFERING / COUNTOURING

ISO WORK MATERIAL CODE		Vc (m/min)	Drill Diameter Dc (mm) >>> Peck Amount Q (mm)		
			10	20	30
			Vf (mm/min)		
P	Low Carbon Steel	40 ~ 80	280	140	95
P	Alloy Steel	30 ~ 60	112	68	50
P	Pre-Hardened Steel ≤ 45HRc	30 ~ 60	95	50	28
P	Ferritic & Martensitic Stainless Steel	20 ~ 50	100	55	45
P	PH Stainless Steel	16 ~ 20	90	45	32
M	Austenitic, Duplex & Cast Stainless Steel	20 ~ 40	112	68	45
K	Cast Iron	40 ~ 80	280	165	110
S	Titanium, Titanium Alloy & High Temperature Alloy	10 ~ 12	32	18	12
H	Hardened Steel 50 - 55 HRc	8 ~ 10	22	12	9
N	Non-Ferrous	40 ~ 100	390	255	220

Calculating Spindle Speed & Feedrate: Spindle Speed, **n** (min-1) = (318.26 x **V**c) / **D**c

Note: ▪ Adjust machining conditions when unusual vibration or different sound occurs.
▪ Feedrate, **V**f (mm/min) provided as above table.

Operating Parameters provided as a starting guide, actual performance may defer subject to work material, machine condition and setup.

Dc = Cutter Diameter (mm) 切削直径
n = Spindle Speed (mm^{-1}) 转速
Vf = Feed Rate (mm/min) 进给速
Ap = Depth of cut (mm) 切削深度
Ae = Width of Cut (mm) 切削宽度

K2FD

ISO WORK MATERIAL CODE	P	Carbon Steel ~ 30 HRc		P	Alloy Steel ~ 30 HRc		P	Pre-hardened Steel ≤ 45 HRc	
Examples		SS400 ▪ S45C ▪ S50C			SCM ▪ SCr ▪ SNCM			HPM ▪ NAK	
Cutting Speed		60 ~ 100 m/min			30 ~ 90m/min			20 ~ 40 m/min	
Dc (mm)		n (min^{-1})	Vf (mm/min)		n (min^{-1})	Vf (mm/min)		n (min^{-1})	Vf (mm/min)
2.0		12700	0.01 - 0.06		9550	0.01 - 0.06		4750	0.01 - 0.04
3.0		8500	0.015 - 0.09		6350	0.015 - 0.09		3200	0.015 - 0.06
4.0		6250	0.02 - 0.12		4750	0.02 - 0.12		2400	0.02 - 0.08
6.0		4250	0.03 - 0.18		3200	0.03 - 0.18		1600	0.03 - 0.12
8.0		2200	0.04 - 0.24		2400	0.04 - 0.24		1200	0.04 - 0.16
10.0		2550	0.05 - 0.30		1900	0.05 - 0.30		950	0.05 - 0.20
12.0		2100	0.06 - 0.32		1600	0.06 - 0.32		800	0.06 - 0.24
14.0		1800	0.07 - 0.35		1350	0.07 - 0.35		700	0.07 - 0.28
16.0		1600	0.08 - 0.36		1200	0.08 - 0.36		600	0.08 - 0.32
18.0		1400	0.09 - 0.38		1050	0.09 - 0.38		550	0.09 - 0.36
20.0		1250	0.10 - 0.40		950	0.10 - 0.40		500	0.10 - 0.40

ISO WORK MATERIAL CODE	K	Cast Iron ~ 350 N/mm^2		H	Hardened Steel 50 -55 HRc		N	Aluminium Alloy & Cast Aluminium	
Examples		FC250			HPM38 ▪ SKT4 ▪ SKD61			A6061 ▪ A7075 ▪ ADC	
Cutting Speed		60 ~ 120 m/min			20 ~ 30 m/min			8 ~ 200 m/min	
Dc (mm)		n (min^{-1})	Vf (mm/min)		n (min^{-1})	Vf (mm/min)		n (min^{-1})	Vf (mm/min)
2.0		14300	0.01 - 0.06		4000	0.01 - 0.03		22300	0.01 - 0.06
3.0		9550	0.015 - 0.09		2650	0.015 - 0.045		14850	0.015 - 0.09
4.0		7150	0.02 - 0.12		2000	0.02 - 0.06		11150	0.02 - 0.12
6.0		4750	0.03 - 0.18		1350	0.03 - 0.09		7450	0.03 - 0.18
8.0		3600	0.04 - 0.24		1000	0.04 - 0.12		5550	0.04 - 0.24
10.0		2850	0.05 - 0.30		800	0.05 - 0.15		4450	0.05 - 0.30
12.0		2400	0.06 - 0.32		650	0.06 - 0.18		3700	0.06 - 0.36
14.0		2050	0.07 - 0.35		550	0.07 - 0.21		3200	0.07 - 0.42
16.0		1800	0.08 - 0.36		500	0.08 - 0.24		2800	0.08 - 0.48
18.0		1600	0.09 - 0.38		450	0.09 - 0.27		2500	0.09 - 0.54
20.0		1450	0.10 - 0.40		400	0.10 - 0.30		2250	0.10 - 0.60

Note: ▪ The above operating parameters are for tool coated with AL-coating. For uncoated tools, please reduce 30% of the provided spindle speed, **n** (min-1) & feedrate, **v**f.

▪ Adjust drilling conditions when unusual vibration or different sound occurs.

Operating Parameters provided as a starting guide, actual performance may defer subject to work material, machine condition and setup.

Dc = Cutter Diameter (mm) 切削直径 **n** = Spindle Speed (mm^{-1}) 转速 **V**f = Feed Rate (mm/min) 进给速

Ap = Depth of cut (mm) 切削深度 **A**e = Width of Cut (mm) 切削宽度