

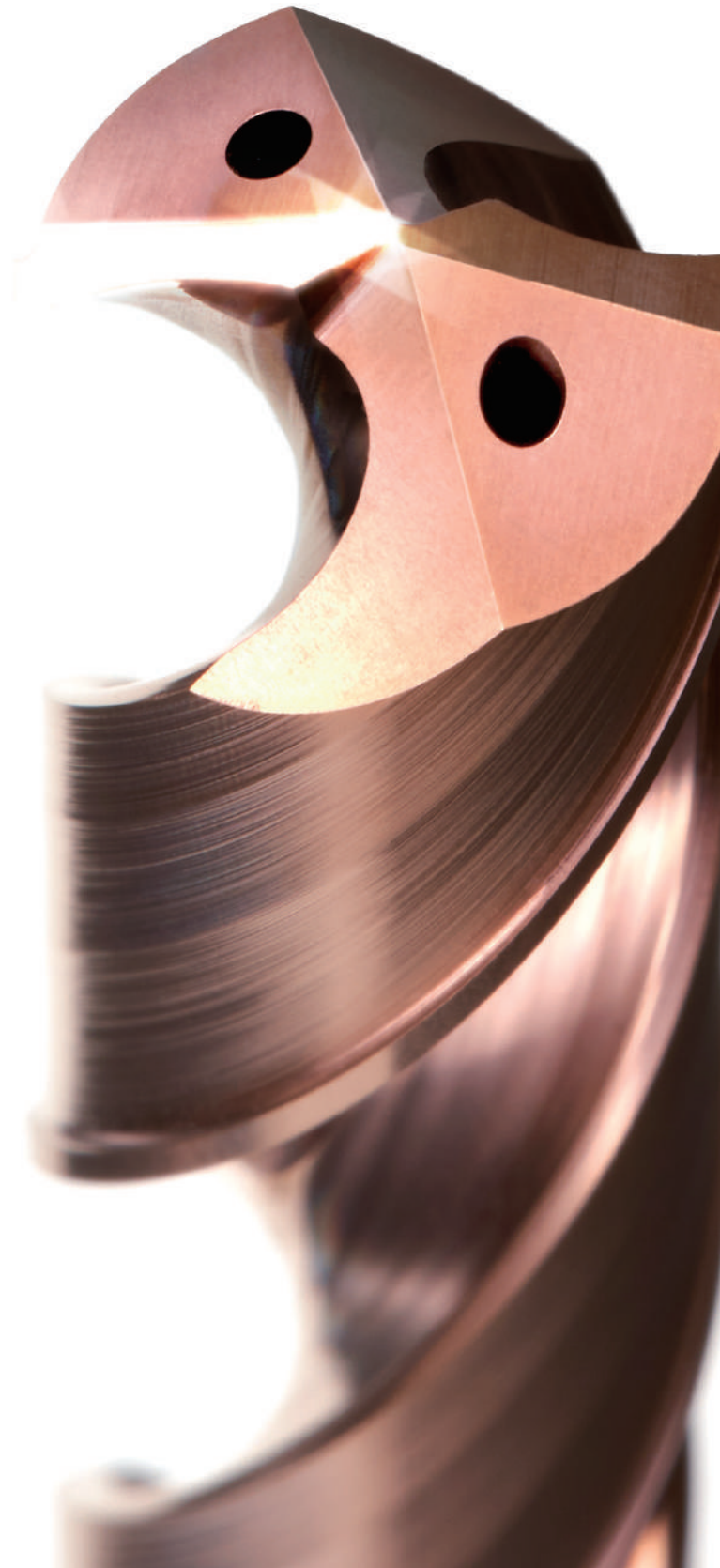
K-series

High Efficiency
Coated Solid Carbide Drill

KDA

**Highly Efficient and Cost Effective
New Universal Solid Carbide Drill
is Now Available!**

**High-Precision Design for a Wide Variety of
Machining Solutions**



Striking the Perfect Balance b

High Efficiency Coated Solid Carbide Drill

KDA

New K-series is Now Available for Excellent All-Around Drilling Performance

The perfect balance between performance and cost

Large lineup accommodates a wide variety of applications

Styles Available



Type N

Normal type

Universal Design without Coolant Holes
Economical Style for Machining with External Coolant

Diameter
Range

3D

5D

ø3~ø16

Cutting diameters available in 0.1 mm increments



Type C

with Coolant hole

Coolant-Through Design
Provides Higher Efficiency and Stable Machining with Stainless Steel, etc.

Diameter
Range

3D

5D

ø3~ø16

Cutting diameters available in 0.1 mm increments



etween Performance and Cost





Features

1

**Universal Design and Lineup
Applicable to a Wide Range of
Machining Applications**

Type N: No Coolant Holes
Type C: With Coolant Holes
3D and 5D depths available



3D / 131 Items
5D / 131 Items



3D / 131 Items
5D / 131 Items

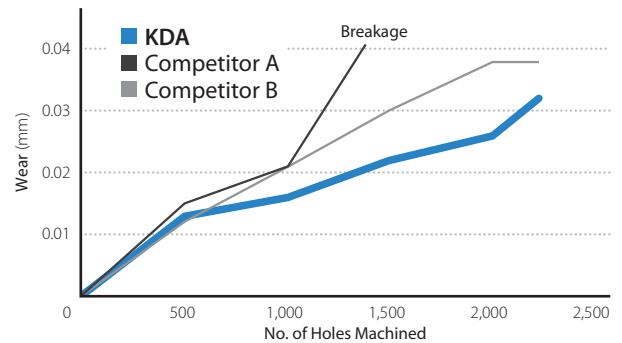
Features

2

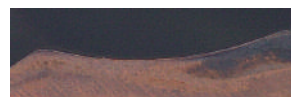
**High-Performance Coating
Maintains Long tool life**

**Excellent Wear and Heat Resistance
Aluminum Chrome (AlCr) Coating**

Wear Resistance Comparison (Internal evaluation)



Cutting Conditions: Vc = 120 m/min, f = 0.23 mm/rev, H = 24 mm,
Wet (Internal coolant) S50 C BT 50 ø 6 (5D) Type C



KDA



Competitor B



Features

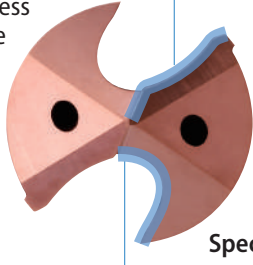
3

Stable Machining with Unique Shape

Curved Cutting-edge Design and Special Flute Shape

Curved Cutting-edge Design

Excellent sharpness and cutting edge strength



Special Flute Shape

Excellent chip control and high rigidity



KDA

Chip Condition (Internal evaluation)

Cutting Conditions:
 $V_c = 80 \text{ m/min}$, $f = 0.14 \text{ mm/rev}$,
 $H = 24 \text{ mm}$, Wet (Internal coolant)
 BT 50 $\phi 6$ (5D) Type C

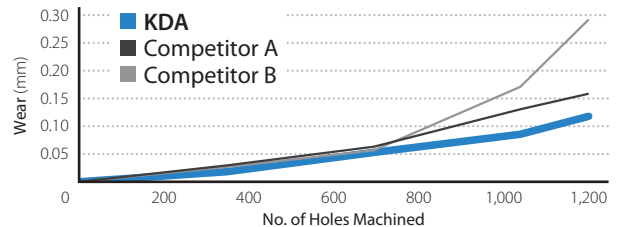
Features

4

Supports a Variety of Workpieces

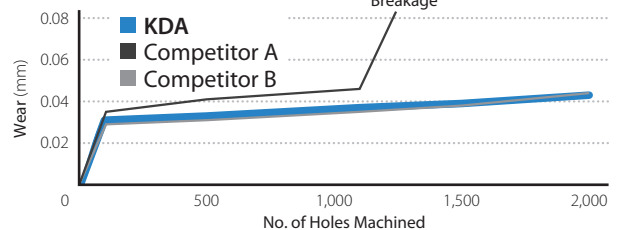
Compatible not only with carbon steel, but also mold steel, stainless steel, cast iron machining, etc.

Alloy Steel SCM 440 (32 HRC) (Internal evaluation)



Cutting Conditions: $V_c = 100 \text{ m/min}$, $f = 0.15 \text{ mm/rev}$, $H = 24 \text{ mm}$, Wet (Internal coolant) BT 50 $\phi 6$ (5D) Type C

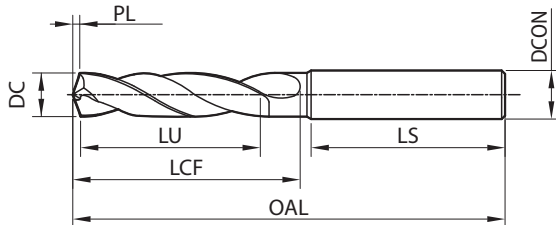
Stainless Steel SUS 304 (Internal evaluation)



Cutting Conditions: $V_c = 80 \text{ m/min}$, $f = 0.14 \text{ mm/rev}$, $H = 24 \text{ mm}$, Wet (Internal coolant) BT 50 $\phi 6$ (5D) Type C

Type N No Coolant Holes 3D

3D
Approximate indication of drilling depth*



Carbide

No Coolant Holes

Cutting-edge Angle **140°**

Helix Angle **22°~32°**

Shank Dia. DCON Tolerance **h6**

Cutting Dia. DC Tolerance **m7**

Cutting Dia. DC	Tolerance m7 (mm)
ø3.0	+0.002 ~ +0.012
ø3.1 ~ ø6	+0.004 ~ +0.016
ø6.1 ~ ø10	+0.006 ~ +0.021
ø10.1 ~ ø16	+0.007 ~ +0.025

Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0300X03S060N	●	3	6	62	15.5	20	36	0.5
KDA0310X03S060N	●	3.1	6	62	15.3	20	36	0.5
KDA0320X03S060N	●	3.2	6	62	15.2	20	36	0.5
KDA0330X03S060N	●	3.3	6	62	15.0	20	36	0.6
KDA0340X03S060N	●	3.4	6	62	14.9	20	36	0.6
KDA0350X03S060N	●	3.5	6	62	14.7	20	36	0.6
KDA0360X03S060N	●	3.6	6	62	14.6	20	36	0.6
KDA0370X03S060N	●	3.7	6	62	14.4	20	36	0.6
KDA0380X03S060N	●	3.8	6	66	18.3	24	36	0.6
KDA0390X03S060N	●	3.9	6	66	18.1	24	36	0.7
KDA0400X03S060N	●	4	6	66	18.0	24	36	0.7
KDA0410X03S060N	●	4.1	6	66	17.8	24	36	0.7
KDA0420X03S060N	●	4.2	6	66	17.7	24	36	0.7
KDA0430X03S060N	●	4.3	6	66	17.5	24	36	0.7
KDA0440X03S060N	●	4.4	6	66	17.4	24	36	0.8
KDA0450X03S060N	●	4.5	6	66	17.2	24	36	0.8
KDA0460X03S060N	●	4.6	6	66	17.1	24	36	0.8
KDA0470X03S060N	●	4.7	6	66	16.9	24	36	0.8
KDA0480X03S060N	●	4.8	6	66	20.8	28	36	0.8
KDA0490X03S060N	●	4.9	6	66	20.6	28	36	0.8
KDA0500X03S060N	●	5	6	66	20.5	28	36	0.9
KDA0510X03S060N	●	5.1	6	66	20.3	28	36	0.9
KDA0520X03S060N	●	5.2	6	66	20.2	28	36	0.9
KDA0530X03S060N	●	5.3	6	66	20.0	28	36	0.9
KDA0540X03S060N	●	5.4	6	66	19.9	28	36	0.9
KDA0550X03S060N	●	5.5	6	66	19.7	28	36	1.0
KDA0560X03S060N	●	5.6	6	66	19.6	28	36	1.0
KDA0570X03S060N	●	5.7	6	66	19.4	28	36	1.0
KDA0580X03S060N	●	5.8	6	66	19.3	28	36	1.0
KDA0590X03S060N	●	5.9	6	66	19.1	28	36	1.0
KDA0600X03S060N	●	6	6	66	19.0	28	36	1.0
KDA0610X03S080N	●	6.1	8	79	24.8	34	36	1.1
KDA0620X03S080N	●	6.2	8	79	24.7	34	36	1.1

Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0630X03S080N	●	6.3	8	79	24.5	34	36	1.1
KDA0640X03S080N	●	6.4	8	79	24.4	34	36	1.1
KDA0650X03S080N	●	6.5	8	79	24.2	34	36	1.1
KDA0660X03S080N	●	6.6	8	79	24.1	34	36	1.2
KDA0670X03S080N	●	6.7	8	79	23.9	34	36	1.2
KDA0680X03S080N	●	6.8	8	79	23.8	34	36	1.2
KDA0690X03S080N	●	6.9	8	79	23.6	34	36	1.2
KDA0700X03S080N	●	7	8	79	23.5	34	36	1.2
KDA0710X03S080N	●	7.1	8	79	30.3	41	36	1.2
KDA0720X03S080N	●	7.2	8	79	30.2	41	36	1.3
KDA0730X03S080N	●	7.3	8	79	30.0	41	36	1.3
KDA0740X03S080N	●	7.4	8	79	29.9	41	36	1.3
KDA0750X03S080N	●	7.5	8	79	29.7	41	36	1.3
KDA0760X03S080N	●	7.6	8	79	29.6	41	36	1.3
KDA0770X03S080N	●	7.7	8	79	29.4	41	36	1.4
KDA0780X03S080N	●	7.8	8	79	29.3	41	36	1.4
KDA0790X03S080N	●	7.9	8	79	29.1	41	36	1.4
KDA0800X03S080N	●	8	8	79	29.0	41	36	1.4
KDA0810X03S100N	●	8.1	10	89	34.8	47	40	1.4
KDA0820X03S100N	●	8.2	10	89	34.7	47	40	1.4
KDA0830X03S100N	●	8.3	10	89	34.5	47	40	1.5
KDA0840X03S100N	●	8.4	10	89	34.4	47	40	1.5
KDA0850X03S100N	●	8.5	10	89	34.2	47	40	1.5
KDA0860X03S100N	●	8.6	10	89	34.1	47	40	1.5
KDA0870X03S100N	●	8.7	10	89	33.9	47	40	1.5
KDA0880X03S100N	●	8.8	10	89	33.8	47	40	1.6
KDA0890X03S100N	●	8.9	10	89	33.6	47	40	1.6
KDA0900X03S100N	●	9	10	89	33.5	47	40	1.6
KDA0910X03S100N	●	9.1	10	89	33.3	47	40	1.6
KDA0920X03S100N	●	9.2	10	89	33.2	47	40	1.6
KDA0930X03S100N	●	9.3	10	89	33.0	47	40	1.6
KDA0940X03S100N	●	9.4	10	89	32.9	47	40	1.7
KDA0950X03S100N	●	9.5	10	89	32.7	47	40	1.7

Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0960X03S100N	●	9.6	10	89	32.6	47	40	1.7
KDA0970X03S100N	●	9.7	10	89	32.4	47	40	1.7
KDA0980X03S100N	●	9.8	10	89	32.3	47	40	1.7
KDA0990X03S100N	●	9.9	10	89	32.1	47	40	1.8
KDA1000X03S100N	●	10	10	89	32.0	47	40	1.8
KDA1010X03S120N	●	10.1	12	102	39.8	55	45	1.8
KDA1020X03S120N	●	10.2	12	102	39.7	55	45	1.8
KDA1030X03S120N	●	10.3	12	102	39.5	55	45	1.8
KDA1040X03S120N	●	10.4	12	102	39.4	55	45	1.8
KDA1050X03S120N	●	10.5	12	102	39.2	55	45	1.9
KDA1060X03S120N	●	10.6	12	102	39.1	55	45	1.9
KDA1070X03S120N	●	10.7	12	102	38.9	55	45	1.9
KDA1080X03S120N	●	10.8	12	102	38.8	55	45	1.9
KDA1090X03S120N	●	10.9	12	102	38.6	55	45	1.9
KDA1100X03S120N	●	11	12	102	38.5	55	45	2.0
KDA1110X03S120N	●	11.1	12	102	38.3	55	45	2.0
KDA1120X03S120N	●	11.2	12	102	38.2	55	45	2.0
KDA1130X03S120N	●	11.3	12	102	38.0	55	45	2.0
KDA1140X03S120N	●	11.4	12	102	37.9	55	45	2.0
KDA1150X03S120N	●	11.5	12	102	37.7	55	45	2.0
KDA1160X03S120N	●	11.6	12	102	37.6	55	45	2.1
KDA1170X03S120N	●	11.7	12	102	37.4	55	45	2.1
KDA1180X03S120N	●	11.8	12	102	37.3	55	45	2.1
KDA1190X03S120N	●	11.9	12	102	37.1	55	45	2.1
KDA1200X03S120N	●	12	12	102	37.0	55	45	2.1
KDA1210X03S140N	●	12.1	14	107	41.8	60	45	2.2
KDA1220X03S140N	●	12.2	14	107	41.7	60	45	2.2
KDA1230X03S140N	●	12.3	14	107	41.5	60	45	2.2
KDA1240X03S140N	●	12.4	14	107	41.4	60	45	2.2
KDA1250X03S140N	●	12.5	14	107	41.2	60	45	2.2
KDA1260X03S140N	●	12.6	14	107	41.1	60	45	2.2
KDA1270X03S140N	●	12.7	14	107	40.9	60	45	2.3
KDA1280X03S140N	●	12.8	14	107	40.8	60	45	2.3

Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA1290X03S140N	●	12.9	14	107	40.6	60	45	2.3
KDA1300X03S140N	●	13	14	107	40.5	60	45	2.3
KDA1310X03S140N	●	13.1	14	107	40.3	60	45	2.3
KDA1320X03S140N	●	13.2	14	107	40.2	60	45	2.4
KDA1330X03S140N	●	13.3	14	107	40.0	60	45	2.4
KDA1340X03S140N	●	13.4	14	107	39.9	60	45	2.4
KDA1350X03S140N	●	13.5	14	107	39.7	60	45	2.4
KDA1360X03S140N	●	13.6	14	107	39.6	60	45	2.4
KDA1370X03S140N	●	13.7	14	107	39.4	60	45	2.4
KDA1380X03S140N	●	13.8	14	107	39.3	60	45	2.5
KDA1390X03S140N	●	13.9	14	107	39.1	60	45	2.5
KDA1400X03S140N	●	14	14	107	39.0	60	45	2.5
KDA1410X03S160N	●	14.1	16	115	43.8	65	48	2.5
KDA1420X03S160N	●	14.2	16	115	43.7	65	48	2.5
KDA1430X03S160N	●	14.3	16	115	43.5	65	48	2.6
KDA1440X03S160N	●	14.4	16	115	43.4	65	48	2.6
KDA1450X03S160N	●	14.5	16	115	43.2	65	48	2.6
KDA1460X03S160N	●	14.6	16	115	43.1	65	48	2.6
KDA1470X03S160N	●	14.7	16	115	42.9	65	48	2.6
KDA1480X03S160N	●	14.8	16	115	42.8	65	48	2.6
KDA1490X03S160N	●	14.9	16	115	42.6	65	48	2.7
KDA1500X03S160N	●	15	16	115	42.5	65	48	2.7
KDA1510X03S160N	●	15.1	16	115	42.3	65	48	2.7
KDA1520X03S160N	●	15.2	16	115	42.2	65	48	2.7
KDA1530X03S160N	●	15.3	16	115	42.0	65	48	2.7
KDA1540X03S160N	●	15.4	16	115	41.9	65	48	2.8
KDA1550X03S160N	●	15.5	16	115	41.7	65	48	2.8
KDA1560X03S160N	●	15.6	16	115	41.6	65	48	2.8
KDA1570X03S160N	●	15.7	16	115	41.4	65	48	2.8
KDA1580X03S160N	●	15.8	16	115	41.3	65	48	2.8
KDA1590X03S160N	●	15.9	16	115	41.1	65	48	2.8
KDA1600X03S160N	●	16	16	115	41.0	65	48	2.9

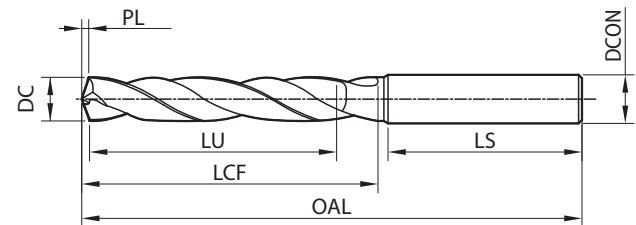
* Drilling depth is an approximate indication of L/D.
Depending on the size, it may be smaller than the listed L/D.

● : Standard Stock

Type N No Coolant Holes 5D

5D

Approximate indication of drilling depth*



Carbide

No Coolant Holes

Cutting-edge Angle **140°**

Helix Angle **22°~32°**

Shank Dia. DCON Tolerance **h6**

Cutting Dia. DC Tolerance **m7**

Cutting Dia. DC	Tolerance m7 (mm)
ø3.0	+0.002 ~ +0.012
ø3.1 ~ ø6	+0.004 ~ +0.016
ø6.1 ~ ø10	+0.006 ~ +0.021
ø10.1 ~ ø16	+0.007 ~ +0.025

Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0300X05S060N	●	3	6	66	23.5	28	36	0.5
KDA0310X05S060N	●	3.1	6	66	23.3	28	36	0.5
KDA0320X05S060N	●	3.2	6	66	23.2	28	36	0.5
KDA0330X05S060N	●	3.3	6	66	23.0	28	36	0.6
KDA0340X05S060N	●	3.4	6	66	22.9	28	36	0.6
KDA0350X05S060N	●	3.5	6	66	22.7	28	36	0.6
KDA0360X05S060N	●	3.6	6	66	22.6	28	36	0.6
KDA0370X05S060N	●	3.7	6	66	22.4	28	36	0.6
KDA0380X05S060N	●	3.8	6	74	30.3	36	36	0.6
KDA0390X05S060N	●	3.9	6	74	30.1	36	36	0.7
KDA0400X05S060N	●	4	6	74	30.0	36	36	0.7
KDA0410X05S060N	●	4.1	6	74	29.8	36	36	0.7
KDA0420X05S060N	●	4.2	6	74	29.7	36	36	0.7
KDA0430X05S060N	●	4.3	6	74	29.5	36	36	0.7
KDA0440X05S060N	●	4.4	6	74	29.4	36	36	0.8
KDA0450X05S060N	●	4.5	6	74	29.2	36	36	0.8
KDA0460X05S060N	●	4.6	6	74	29.1	36	36	0.8
KDA0470X05S060N	●	4.7	6	74	28.9	36	36	0.8
KDA0480X05S060N	●	4.8	6	82	36.8	44	36	0.8
KDA0490X05S060N	●	4.9	6	82	36.6	44	36	0.8
KDA0500X05S060N	●	5	6	82	36.5	44	36	0.9
KDA0510X05S060N	●	5.1	6	82	36.3	44	36	0.9
KDA0520X05S060N	●	5.2	6	82	36.2	44	36	0.9
KDA0530X05S060N	●	5.3	6	82	36.0	44	36	0.9
KDA0540X05S060N	●	5.4	6	82	35.9	44	36	0.9
KDA0550X05S060N	●	5.5	6	82	35.7	44	36	1.0
KDA0560X05S060N	●	5.6	6	82	35.6	44	36	1.0
KDA0570X05S060N	●	5.7	6	82	35.4	44	36	1.0
KDA0580X05S060N	●	5.8	6	82	35.3	44	36	1.0
KDA0590X05S060N	●	5.9	6	82	35.1	44	36	1.0
KDA0600X05S060N	●	6	6	82	35.0	44	36	1.0
KDA0610X05S080N	●	6.1	8	91	43.8	53	36	1.1
KDA0620X05S080N	●	6.2	8	91	43.7	53	36	1.1

Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0630X05S080N	●	6.3	8	91	43.5	53	36	1.1
KDA0640X05S080N	●	6.4	8	91	43.4	53	36	1.1
KDA0650X05S080N	●	6.5	8	91	43.2	53	36	1.1
KDA0660X05S080N	●	6.6	8	91	43.1	53	36	1.2
KDA0670X05S080N	●	6.7	8	91	42.9	53	36	1.2
KDA0680X05S080N	●	6.8	8	91	42.8	53	36	1.2
KDA0690X05S080N	●	6.9	8	91	42.6	53	36	1.2
KDA0700X05S080N	●	7	8	91	42.5	53	36	1.2
KDA0710X05S080N	●	7.1	8	91	42.3	53	36	1.2
KDA0720X05S080N	●	7.2	8	91	42.2	53	36	1.3
KDA0730X05S080N	●	7.3	8	91	42.0	53	36	1.3
KDA0740X05S080N	●	7.4	8	91	41.9	53	36	1.3
KDA0750X05S080N	●	7.5	8	91	41.7	53	36	1.3
KDA0760X05S080N	●	7.6	8	91	41.6	53	36	1.3
KDA0770X05S080N	●	7.7	8	91	41.4	53	36	1.4
KDA0780X05S080N	●	7.8	8	91	41.3	53	36	1.4
KDA0790X05S080N	●	7.9	8	91	41.1	53	36	1.4
KDA0800X05S080N	●	8	8	91	41.0	53	36	1.4
KDA0810X05S100N	●	8.1	10	103	48.8	61	40	1.4
KDA0820X05S100N	●	8.2	10	103	48.7	61	40	1.4
KDA0830X05S100N	●	8.3	10	103	48.5	61	40	1.5
KDA0840X05S100N	●	8.4	10	103	48.4	61	40	1.5
KDA0850X05S100N	●	8.5	10	103	48.2	61	40	1.5
KDA0860X05S100N	●	8.6	10	103	48.1	61	40	1.5
KDA0870X05S100N	●	8.7	10	103	47.9	61	40	1.5
KDA0880X05S100N	●	8.8	10	103	47.8	61	40	1.6
KDA0890X05S100N	●	8.9	10	103	47.6	61	40	1.6
KDA0900X05S100N	●	9	10	103	47.5	61	40	1.6
KDA0910X05S100N	●	9.1	10	103	47.3	61	40	1.6
KDA0920X05S100N	●	9.2	10	103	47.2	61	40	1.6
KDA0930X05S100N	●	9.3	10	103	47.0	61	40	1.6
KDA0940X05S100N	●	9.4	10	103	46.9	61	40	1.7
KDA0950X05S100N	●	9.5	10	103	46.7	61	40	1.7

Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0960X05S100N	●	9.6	10	103	46.6	61	40	1.7
KDA0970X05S100N	●	9.7	10	103	46.4	61	40	1.7
KDA0980X05S100N	●	9.8	10	103	46.3	61	40	1.7
KDA0990X05S100N	●	9.9	10	103	46.1	61	40	1.8
KDA1000X05S100N	●	10	10	103	46.0	61	40	1.8
KDA1010X05S120N	●	10.1	12	118	55.8	71	45	1.8
KDA1020X05S120N	●	10.2	12	118	55.7	71	45	1.8
KDA1030X05S120N	●	10.3	12	118	55.5	71	45	1.8
KDA1040X05S120N	●	10.4	12	118	55.4	71	45	1.8
KDA1050X05S120N	●	10.5	12	118	55.2	71	45	1.9
KDA1060X05S120N	●	10.6	12	118	55.1	71	45	1.9
KDA1070X05S120N	●	10.7	12	118	54.9	71	45	1.9
KDA1080X05S120N	●	10.8	12	118	54.8	71	45	1.9
KDA1090X05S120N	●	10.9	12	118	54.6	71	45	1.9
KDA1100X05S120N	●	11	12	118	54.5	71	45	2.0
KDA1110X05S120N	●	11.1	12	118	54.3	71	45	2.0
KDA1120X05S120N	●	11.2	12	118	54.2	71	45	2.0
KDA1130X05S120N	●	11.3	12	118	54.0	71	45	2.0
KDA1140X05S120N	●	11.4	12	118	53.9	71	45	2.0
KDA1150X05S120N	●	11.5	12	118	53.7	71	45	2.0
KDA1160X05S120N	●	11.6	12	118	53.6	71	45	2.1
KDA1170X05S120N	●	11.7	12	118	53.4	71	45	2.1
KDA1180X05S120N	●	11.8	12	118	53.3	71	45	2.1
KDA1190X05S120N	●	11.9	12	118	53.1	71	45	2.1
KDA1200X05S120N	●	12	12	118	53.0	71	45	2.1
KDA1210X05S140N	●	12.1	14	124	58.8	77	45	2.2
KDA1220X05S140N	●	12.2	14	124	58.7	77	45	2.2
KDA1230X05S140N	●	12.3	14	124	58.5	77	45	2.2
KDA1240X05S140N	●	12.4	14	124	58.4	77	45	2.2
KDA1250X05S140N	●	12.5	14	124	58.2	77	45	2.2
KDA1260X05S140N	●	12.6	14	124	58.1	77	45	2.2
KDA1270X05S140N	●	12.7	14	124	57.9	77	45	2.3
KDA1280X05S140N	●	12.8	14	124	57.8	77	45	2.3

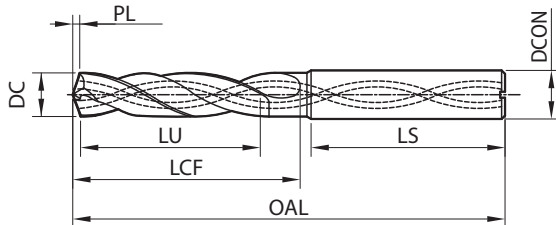
Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA1290X05S140N	●	12.9	14	124	57.6	77	45	2.3
KDA1300X05S140N	●	13	14	124	57.5	77	45	2.3
KDA1310X05S140N	●	13.1	14	124	57.3	77	45	2.3
KDA1320X05S140N	●	13.2	14	124	57.2	77	45	2.4
KDA1330X05S140N	●	13.3	14	124	57.0	77	45	2.4
KDA1340X05S140N	●	13.4	14	124	56.9	77	45	2.4
KDA1350X05S140N	●	13.5	14	124	56.7	77	45	2.4
KDA1360X05S140N	●	13.6	14	124	56.6	77	45	2.4
KDA1370X05S140N	●	13.7	14	124	56.4	77	45	2.4
KDA1380X05S140N	●	13.8	14	124	56.3	77	45	2.5
KDA1390X05S140N	●	13.9	14	124	56.1	77	45	2.5
KDA1400X05S140N	●	14	14	124	56.0	77	45	2.5
KDA1410X05S160N	●	14.1	16	133	61.8	83	48	2.5
KDA1420X05S160N	●	14.2	16	133	61.7	83	48	2.5
KDA1430X05S160N	●	14.3	16	133	61.5	83	48	2.6
KDA1440X05S160N	●	14.4	16	133	61.4	83	48	2.6
KDA1450X05S160N	●	14.5	16	133	61.2	83	48	2.6
KDA1460X05S160N	●	14.6	16	133	61.1	83	48	2.6
KDA1470X05S160N	●	14.7	16	133	60.9	83	48	2.6
KDA1480X05S160N	●	14.8	16	133	60.8	83	48	2.6
KDA1490X05S160N	●	14.9	16	133	60.6	83	48	2.7
KDA1500X05S160N	●	15	16	133	60.5	83	48	2.7
KDA1510X05S160N	●	15.1	16	133	60.3	83	48	2.7
KDA1520X05S160N	●	15.2	16	133	60.2	83	48	2.7
KDA1530X05S160N	●	15.3	16	133	60.0	83	48	2.7
KDA1540X05S160N	●	15.4	16	133	59.9	83	48	2.8
KDA1550X05S160N	●	15.5	16	133	59.7	83	48	2.8
KDA1560X05S160N	●	15.6	16	133	59.6	83	48	2.8
KDA1570X05S160N	●	15.7	16	133	59.4	83	48	2.8
KDA1580X05S160N	●	15.8	16	133	59.3	83	48	2.8
KDA1590X05S160N	●	15.9	16	133	59.1	83	48	2.8
KDA1600X05S160N	●	16	16	133	59.0	83	48	2.9

* Drilling depth is an approximate indication of L/D.
Depending on the size, it may be smaller than the listed L/D.

● : Standard Stock

Type C with Coolant Holes 3D

3D
Approximate indication of drilling depth*



Carbide

With Coolant Holes

Cutting-edge Angle
140°

Helix Angle
22°~32°

Shank Dia. DCON Tolerance
h6

Cutting Dia. DC Tolerance
m7

Cutting Dia. DC		Tolerance m7 (mm)	
ø3.0		+0.002 ~ +0.012	
ø3.1 ~ ø6		+0.004 ~ +0.016	
ø6.1 ~ ø10		+0.006 ~ +0.021	
ø10.1 ~ ø16		+0.007 ~ +0.025	

Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0300X03S060C	●	3	6	62	15.5	20	36	0.5
KDA0310X03S060C	●	3.1	6	62	15.3	20	36	0.5
KDA0320X03S060C	●	3.2	6	62	15.2	20	36	0.5
KDA0330X03S060C	●	3.3	6	62	15.0	20	36	0.6
KDA0340X03S060C	●	3.4	6	62	14.9	20	36	0.6
KDA0350X03S060C	●	3.5	6	62	14.7	20	36	0.6
KDA0360X03S060C	●	3.6	6	62	14.6	20	36	0.6
KDA0370X03S060C	●	3.7	6	62	14.4	20	36	0.6
KDA0380X03S060C	●	3.8	6	66	18.3	24	36	0.6
KDA0390X03S060C	●	3.9	6	66	18.1	24	36	0.7
KDA0400X03S060C	●	4	6	66	18.0	24	36	0.7
KDA0410X03S060C	●	4.1	6	66	17.8	24	36	0.7
KDA0420X03S060C	●	4.2	6	66	17.7	24	36	0.7
KDA0430X03S060C	●	4.3	6	66	17.5	24	36	0.7
KDA0440X03S060C	●	4.4	6	66	17.4	24	36	0.8
KDA0450X03S060C	●	4.5	6	66	17.2	24	36	0.8
KDA0460X03S060C	●	4.6	6	66	17.1	24	36	0.8
KDA0470X03S060C	●	4.7	6	66	16.9	24	36	0.8
KDA0480X03S060C	●	4.8	6	66	20.8	28	36	0.8
KDA0490X03S060C	●	4.9	6	66	20.6	28	36	0.8
KDA0500X03S060C	●	5	6	66	20.5	28	36	0.9
KDA0510X03S060C	●	5.1	6	66	20.3	28	36	0.9
KDA0520X03S060C	●	5.2	6	66	20.2	28	36	0.9
KDA0530X03S060C	●	5.3	6	66	20.0	28	36	0.9
KDA0540X03S060C	●	5.4	6	66	19.9	28	36	0.9
KDA0550X03S060C	●	5.5	6	66	19.7	28	36	1.0
KDA0560X03S060C	●	5.6	6	66	19.6	28	36	1.0
KDA0570X03S060C	●	5.7	6	66	19.4	28	36	1.0
KDA0580X03S060C	●	5.8	6	66	19.3	28	36	1.0
KDA0590X03S060C	●	5.9	6	66	19.1	28	36	1.0
KDA0600X03S060C	●	6	6	66	19.0	28	36	1.0
KDA0610X03S080C	●	6.1	8	79	24.8	34	36	1.1
KDA0620X03S080C	●	6.2	8	79	24.7	34	36	1.1

Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0630X03S080C	●	6.3	8	79	24.5	34	36	1.1
KDA0640X03S080C	●	6.4	8	79	24.4	34	36	1.1
KDA0650X03S080C	●	6.5	8	79	24.2	34	36	1.1
KDA0660X03S080C	●	6.6	8	79	24.1	34	36	1.2
KDA0670X03S080C	●	6.7	8	79	23.9	34	36	1.2
KDA0680X03S080C	●	6.8	8	79	23.8	34	36	1.2
KDA0690X03S080C	●	6.9	8	79	23.6	34	36	1.2
KDA0700X03S080C	●	7	8	79	23.5	34	36	1.2
KDA0710X03S080C	●	7.1	8	79	30.3	41	36	1.2
KDA0720X03S080C	●	7.2	8	79	30.2	41	36	1.3
KDA0730X03S080C	●	7.3	8	79	30.0	41	36	1.3
KDA0740X03S080C	●	7.4	8	79	29.9	41	36	1.3
KDA0750X03S080C	●	7.5	8	79	29.7	41	36	1.3
KDA0760X03S080C	●	7.6	8	79	29.6	41	36	1.3
KDA0770X03S080C	●	7.7	8	79	29.4	41	36	1.4
KDA0780X03S080C	●	7.8	8	79	29.3	41	36	1.4
KDA0790X03S080C	●	7.9	8	79	29.1	41	36	1.4
KDA0800X03S080C	●	8	8	79	29.0	41	36	1.4
KDA0810X03S100C	●	8.1	10	89	34.8	47	40	1.4
KDA0820X03S100C	●	8.2	10	89	34.7	47	40	1.4
KDA0830X03S100C	●	8.3	10	89	34.5	47	40	1.5
KDA0840X03S100C	●	8.4	10	89	34.4	47	40	1.5
KDA0850X03S100C	●	8.5	10	89	34.2	47	40	1.5
KDA0860X03S100C	●	8.6	10	89	34.1	47	40	1.5
KDA0870X03S100C	●	8.7	10	89	33.9	47	40	1.5
KDA0880X03S100C	●	8.8	10	89	33.8	47	40	1.6
KDA0890X03S100C	●	8.9	10	89	33.6	47	40	1.6
KDA0900X03S100C	●	9	10	89	33.5	47	40	1.6
KDA0910X03S100C	●	9.1	10	89	33.3	47	40	1.6
KDA0920X03S100C	●	9.2	10	89	33.2	47	40	1.6
KDA0930X03S100C	●	9.3	10	89	33.0	47	40	1.6
KDA0940X03S100C	●	9.4	10	89	32.9	47	40	1.7
KDA0950X03S100C	●	9.5	10	89	32.7	47	40	1.7

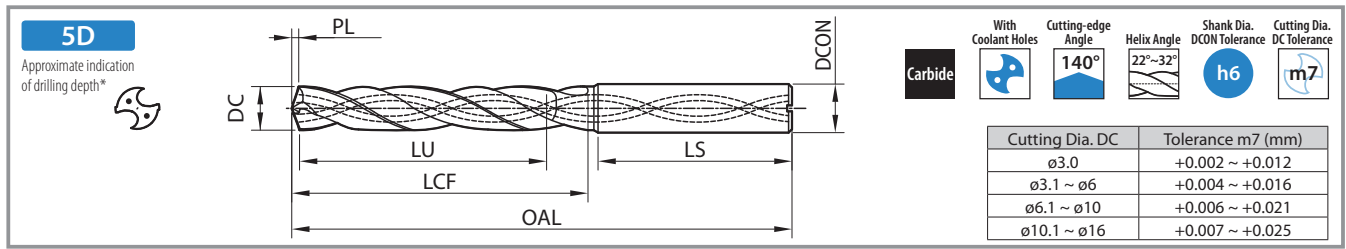
Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0960X03S100C	●	9.6	10	89	32.6	47	40	1.7
KDA0970X03S100C	●	9.7	10	89	32.4	47	40	1.7
KDA0980X03S100C	●	9.8	10	89	32.3	47	40	1.7
KDA0990X03S100C	●	9.9	10	89	32.1	47	40	1.8
KDA1000X03S100C	●	10	10	89	32.0	47	40	1.8
KDA1010X03S120C	●	10.1	12	102	39.8	55	45	1.8
KDA1020X03S120C	●	10.2	12	102	39.7	55	45	1.8
KDA1030X03S120C	●	10.3	12	102	39.5	55	45	1.8
KDA1040X03S120C	●	10.4	12	102	39.4	55	45	1.8
KDA1050X03S120C	●	10.5	12	102	39.2	55	45	1.9
KDA1060X03S120C	●	10.6	12	102	39.1	55	45	1.9
KDA1070X03S120C	●	10.7	12	102	38.9	55	45	1.9
KDA1080X03S120C	●	10.8	12	102	38.8	55	45	1.9
KDA1090X03S120C	●	10.9	12	102	38.6	55	45	1.9
KDA1100X03S120C	●	11	12	102	38.5	55	45	2.0
KDA1110X03S120C	●	11.1	12	102	38.3	55	45	2.0
KDA1120X03S120C	●	11.2	12	102	38.2	55	45	2.0
KDA1130X03S120C	●	11.3	12	102	38.0	55	45	2.0
KDA1140X03S120C	●	11.4	12	102	37.9	55	45	2.0
KDA1150X03S120C	●	11.5	12	102	37.7	55	45	2.0
KDA1160X03S120C	●	11.6	12	102	37.6	55	45	2.1
KDA1170X03S120C	●	11.7	12	102	37.4	55	45	2.1
KDA1180X03S120C	●	11.8	12	102	37.3	55	45	2.1
KDA1190X03S120C	●	11.9	12	102	37.1	55	45	2.1
KDA1200X03S120C	●	12	12	102	37.0	55	45	2.1
KDA1210X03S140C	●	12.1	14	107	41.8	60	45	2.2
KDA1220X03S140C	●	12.2	14	107	41.7	60	45	2.2
KDA1230X03S140C	●	12.3	14	107	41.5	60	45	2.2
KDA1240X03S140C	●	12.4	14	107	41.4	60	45	2.2
KDA1250X03S140C	●	12.5	14	107	41.2	60	45	2.2
KDA1260X03S140C	●	12.6	14	107	41.1	60	45	2.2
KDA1270X03S140C	●	12.7	14	107	40.9	60	45	2.3
KDA1280X03S140C	●	12.8	14	107	40.8	60	45	2.3

Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA1290X03S140C	●	12.9	14	107	40.6	60	45	2.3
KDA1300X03S140C	●	13	14	107	40.5	60	45	2.3
KDA1310X03S140C	●	13.1	14	107	40.3	60	45	2.3
KDA1320X03S140C	●	13.2	14	107	40.2	60	45	2.4
KDA1330X03S140C	●	13.3	14	107	40.0	60	45	2.4
KDA1340X03S140C	●	13.4	14	107	39.9	60	45	2.4
KDA1350X03S140C	●	13.5	14	107	39.7	60	45	2.4
KDA1360X03S140C	●	13.6	14	107	39.6	60	45	2.4
KDA1370X03S140C	●	13.7	14	107	39.4	60	45	2.4
KDA1380X03S140C	●	13.8	14	107	39.3	60	45	2.5
KDA1390X03S140C	●	13.9	14	107	39.1	60	45	2.5
KDA1400X03S140C	●	14	14	107	39.0	60	45	2.5
KDA1410X03S160C	●	14.1	16	115	43.8	65	48	2.5
KDA1420X03S160C	●	14.2	16	115	43.7	65	48	2.5
KDA1430X03S160C	●	14.3	16	115	43.5	65	48	2.6
KDA1440X03S160C	●	14.4	16	115	43.4	65	48	2.6
KDA1450X03S160C	●	14.5	16	115	43.2	65	48	2.6
KDA1460X03S160C	●	14.6	16	115	43.1	65	48	2.6
KDA1470X03S160C	●	14.7	16	115	42.9	65	48	2.6
KDA1480X03S160C	●	14.8	16	115	42.8	65	48	2.6
KDA1490X03S160C	●	14.9	16	115	42.6	65	48	2.7
KDA1500X03S160C	●	15	16	115	42.5	65	48	2.7
KDA1510X03S160C	●	15.1	16	115	42.3	65	48	2.7
KDA1520X03S160C	●	15.2	16	115	42.2	65	48	2.7
KDA1530X03S160C	●	15.3	16	115	42.0	65	48	2.7
KDA1540X03S160C	●	15.4	16	115	41.9	65	48	2.8
KDA1550X03S160C	●	15.5	16	115	41.7	65	48	2.8
KDA1560X03S160C	●	15.6	16	115	41.6	65	48	2.8
KDA1570X03S160C	●	15.7	16	115	41.4	65	48	2.8
KDA1580X03S160C	●	15.8	16	115	41.3	65	48	2.8
KDA1590X03S160C	●	15.9	16	115	41.1	65	48	2.8
KDA1600X03S160C	●	16	16	115	41.0	65	48	2.9

* Drilling depth is an approximate indication of L/D.
Depending on the size, it may be smaller than the listed L/D.

● : Standard Stock

Type C with Coolant Holes 5D



Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0300X05S060C	●	3	6	66	23.5	28	36	0.5
KDA0310X05S060C	●	3.1	6	66	23.3	28	36	0.5
KDA0320X05S060C	●	3.2	6	66	23.2	28	36	0.5
KDA0330X05S060C	●	3.3	6	66	23.0	28	36	0.6
KDA0340X05S060C	●	3.4	6	66	22.9	28	36	0.6
KDA0350X05S060C	●	3.5	6	66	22.7	28	36	0.6
KDA0360X05S060C	●	3.6	6	66	22.6	28	36	0.6
KDA0370X05S060C	●	3.7	6	66	22.4	28	36	0.6
KDA0380X05S060C	●	3.8	6	74	30.3	36	36	0.6
KDA0390X05S060C	●	3.9	6	74	30.1	36	36	0.7
KDA0400X05S060C	●	4	6	74	30.0	36	36	0.7
KDA0410X05S060C	●	4.1	6	74	29.8	36	36	0.7
KDA0420X05S060C	●	4.2	6	74	29.7	36	36	0.7
KDA0430X05S060C	●	4.3	6	74	29.5	36	36	0.7
KDA0440X05S060C	●	4.4	6	74	29.4	36	36	0.8
KDA0450X05S060C	●	4.5	6	74	29.2	36	36	0.8
KDA0460X05S060C	●	4.6	6	74	29.1	36	36	0.8
KDA0470X05S060C	●	4.7	6	74	28.9	36	36	0.8
KDA0480X05S060C	●	4.8	6	82	36.8	44	36	0.8
KDA0490X05S060C	●	4.9	6	82	36.6	44	36	0.8
KDA0500X05S060C	●	5	6	82	36.5	44	36	0.9
KDA0510X05S060C	●	5.1	6	82	36.3	44	36	0.9
KDA0520X05S060C	●	5.2	6	82	36.2	44	36	0.9
KDA0530X05S060C	●	5.3	6	82	36.0	44	36	0.9
KDA0540X05S060C	●	5.4	6	82	35.9	44	36	0.9
KDA0550X05S060C	●	5.5	6	82	35.7	44	36	1.0
KDA0560X05S060C	●	5.6	6	82	35.6	44	36	1.0
KDA0570X05S060C	●	5.7	6	82	35.4	44	36	1.0
KDA0580X05S060C	●	5.8	6	82	35.3	44	36	1.0
KDA0590X05S060C	●	5.9	6	82	35.1	44	36	1.0
KDA0600X05S060C	●	6	6	82	35.0	44	36	1.0
KDA0610X05S080C	●	6.1	8	91	43.8	53	36	1.1
KDA0620X05S080C	●	6.2	8	91	43.7	53	36	1.1

Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0630X05S080C	●	6.3	8	91	43.5	53	36	1.1
KDA0640X05S080C	●	6.4	8	91	43.4	53	36	1.1
KDA0650X05S080C	●	6.5	8	91	43.2	53	36	1.1
KDA0660X05S080C	●	6.6	8	91	43.1	53	36	1.2
KDA0670X05S080C	●	6.7	8	91	42.9	53	36	1.2
KDA0680X05S080C	●	6.8	8	91	42.8	53	36	1.2
KDA0690X05S080C	●	6.9	8	91	42.6	53	36	1.2
KDA0700X05S080C	●	7	8	91	42.5	53	36	1.2
KDA0710X05S080C	●	7.1	8	91	42.3	53	36	1.2
KDA0720X05S080C	●	7.2	8	91	42.2	53	36	1.3
KDA0730X05S080C	●	7.3	8	91	42.0	53	36	1.3
KDA0740X05S080C	●	7.4	8	91	41.9	53	36	1.3
KDA0750X05S080C	●	7.5	8	91	41.7	53	36	1.3
KDA0760X05S080C	●	7.6	8	91	41.6	53	36	1.3
KDA0770X05S080C	●	7.7	8	91	41.4	53	36	1.4
KDA0780X05S080C	●	7.8	8	91	41.3	53	36	1.4
KDA0790X05S080C	●	7.9	8	91	41.1	53	36	1.4
KDA0800X05S080C	●	8	8	91	41.0	53	36	1.4
KDA0810X05S100C	●	8.1	10	103	48.8	61	40	1.4
KDA0820X05S100C	●	8.2	10	103	48.7	61	40	1.4
KDA0830X05S100C	●	8.3	10	103	48.5	61	40	1.5
KDA0840X05S100C	●	8.4	10	103	48.4	61	40	1.5
KDA0850X05S100C	●	8.5	10	103	48.2	61	40	1.5
KDA0860X05S100C	●	8.6	10	103	48.1	61	40	1.5
KDA0870X05S100C	●	8.7	10	103	47.9	61	40	1.5
KDA0880X05S100C	●	8.8	10	103	47.8	61	40	1.6
KDA0890X05S100C	●	8.9	10	103	47.6	61	40	1.6
KDA0900X05S100C	●	9	10	103	47.5	61	40	1.6
KDA0910X05S100C	●	9.1	10	103	47.3	61	40	1.6
KDA0920X05S100C	●	9.2	10	103	47.2	61	40	1.6
KDA0930X05S100C	●	9.3	10	103	47.0	61	40	1.6
KDA0940X05S100C	●	9.4	10	103	46.9	61	40	1.7
KDA0950X05S100C	●	9.5	10	103	46.7	61	40	1.7

Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0960X05S100C	●	9.6	10	103	46.6	61	40	1.7
KDA0970X05S100C	●	9.7	10	103	46.4	61	40	1.7
KDA0980X05S100C	●	9.8	10	103	46.3	61	40	1.7
KDA0990X05S100C	●	9.9	10	103	46.1	61	40	1.8
KDA1000X05S100C	●	10	10	103	46.0	61	40	1.8
KDA1010X05S120C	●	10.1	12	118	55.8	71	45	1.8
KDA1020X05S120C	●	10.2	12	118	55.7	71	45	1.8
KDA1030X05S120C	●	10.3	12	118	55.5	71	45	1.8
KDA1040X05S120C	●	10.4	12	118	55.4	71	45	1.8
KDA1050X05S120C	●	10.5	12	118	55.2	71	45	1.9
KDA1060X05S120C	●	10.6	12	118	55.1	71	45	1.9
KDA1070X05S120C	●	10.7	12	118	54.9	71	45	1.9
KDA1080X05S120C	●	10.8	12	118	54.8	71	45	1.9
KDA1090X05S120C	●	10.9	12	118	54.6	71	45	1.9
KDA1100X05S120C	●	11	12	118	54.5	71	45	2.0
KDA1110X05S120C	●	11.1	12	118	54.3	71	45	2.0
KDA1120X05S120C	●	11.2	12	118	54.2	71	45	2.0
KDA1130X05S120C	●	11.3	12	118	54.0	71	45	2.0
KDA1140X05S120C	●	11.4	12	118	53.9	71	45	2.0
KDA1150X05S120C	●	11.5	12	118	53.7	71	45	2.0
KDA1160X05S120C	●	11.6	12	118	53.6	71	45	2.1
KDA1170X05S120C	●	11.7	12	118	53.4	71	45	2.1
KDA1180X05S120C	●	11.8	12	118	53.3	71	45	2.1
KDA1190X05S120C	●	11.9	12	118	53.1	71	45	2.1
KDA1200X05S120C	●	12	12	118	53.0	71	45	2.1
KDA1210X05S140C	●	12.1	14	124	58.8	77	45	2.2
KDA1220X05S140C	●	12.2	14	124	58.7	77	45	2.2
KDA1230X05S140C	●	12.3	14	124	58.5	77	45	2.2
KDA1240X05S140C	●	12.4	14	124	58.4	77	45	2.2
KDA1250X05S140C	●	12.5	14	124	58.2	77	45	2.2
KDA1260X05S140C	●	12.6	14	124	58.1	77	45	2.2
KDA1270X05S140C	●	12.7	14	124	57.9	77	45	2.3
KDA1280X05S140C	●	12.8	14	124	57.8	77	45	2.3



Description	Stock	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA1290X05S140C	●	12.9	14	124	57.6	77	45	2.3
KDA1300X05S140C	●	13	14	124	57.5	77	45	2.3
KDA1310X05S140C	●	13.1	14	124	57.3	77	45	2.3
KDA1320X05S140C	●	13.2	14	124	57.2	77	45	2.4
KDA1330X05S140C	●	13.3	14	124	57.0	77	45	2.4
KDA1340X05S140C	●	13.4	14	124	56.9	77	45	2.4
KDA1350X05S140C	●	13.5	14	124	56.7	77	45	2.4
KDA1360X05S140C	●	13.6	14	124	56.6	77	45	2.4
KDA1370X05S140C	●	13.7	14	124	56.4	77	45	2.4
KDA1380X05S140C	●	13.8	14	124	56.3	77	45	2.5
KDA1390X05S140C	●	13.9	14	124	56.1	77	45	2.5
KDA1400X05S140C	●	14	14	124	56.0	77	45	2.5
KDA1410X05S160C	●	14.1	16	133	61.8	83	48	2.5
KDA1420X05S160C	●	14.2	16	133	61.7	83	48	2.5
KDA1430X05S160C	●	14.3	16	133	61.5	83	48	2.6
KDA1440X05S160C	●	14.4	16	133	61.4	83	48	2.6
KDA1450X05S160C	●	14.5	16	133	61.2	83	48	2.6
KDA1460X05S160C	●	14.6	16	133	61.1	83	48	2.6
KDA1470X05S160C	●	14.7	16	133	60.9	83	48	2.6
KDA1480X05S160C	●	14.8	16	133	60.8	83	48	2.6
KDA1490X05S160C	●	14.9	16	133	60.6	83	48	2.7
KDA1500X05S160C	●	15	16	133	60.5	83	48	2.7
KDA1510X05S160C	●	15.1	16	133	60.3	83	48	2.7
KDA1520X05S160C	●	15.2	16	133	60.2	83	48	2.7
KDA1530X05S160C	●	15.3	16	133	60.0	83	48	2.7
KDA1540X05S160C	●	15.4	16	133	59.9	83	48	2.8
KDA1550X05S160C	●	15.5	16	133	59.7	83	48	2.8
KDA1560X05S160C	●	15.6	16	133	59.6	83	48	2.8
KDA1570X05S160C	●	15.7	16	133	59.4	83	48	2.8
KDA1580X05S160C	●	15.8	16	133	59.3	83	48	2.8
KDA1590X05S160C	●	15.9	16	133	59.1	83	48	2.8
KDA1600X05S160C	●	16	16	133	59.0	83	48	2.9

*Drilling depth is an approximate indication of L/D.
Depending on the size, it may be smaller than the listed L/D.

● : Standard Stock

Reference Cutting Conditions Table

K-series **3D** **5D**

Workpiece	Vc (m/min)		f (mm/rev)							
	Type N 	Type C 	ø3	ø4	ø6	ø8	ø10	ø12	ø14	ø16
Mild Steel/Low Carbon Steel SS 400/S 10 C (< 125 HB)	50-100	60-140	0.09-0.16	0.11-0.19	0.14-0.23	0.19-0.31	0.23-0.38	0.24-0.41	0.28-0.45	0.30-0.50
Carbon Steel S 35C/S 50C (< 25 HRC)	45-90	60-120	0.09-0.16	0.11-0.19	0.14-0.23	0.19-0.31	0.23-0.38	0.24-0.41	0.28-0.45	0.30-0.50
Alloy Steel/Tool Steel SCM/SCr/SNCM (< 35 HRC)	45-90	50-110	0.09-0.16	0.11-0.19	0.14-0.23	0.19-0.31	0.23-0.38	0.24-0.41	0.28-0.45	0.30-0.50
Alloy Steel/Tool Steel SCM/SCr/SNCM (35 -48 HRC)	40-80	40-90	0.09-0.14	0.10-0.17	0.13-0.22	0.17-0.29	0.21-0.35	0.22-0.37	0.26-0.41	0.28-0.44
Austenitic Stainless Steel SUS 304 (130 -200 HB)	20-40	40-80	0.05-0.10	0.06-0.12	0.07-0.14	0.08-0.18	0.09-0.20	0.10-0.22	0.11-0.24	0.12-0.24
High Strength Austenitic Stainless Steel and Stainless Cast Steel (< 25 HRC)	20-40	40-80	0.03-0.08	0.04-0.10	0.05-0.10	0.06-0.12	0.07-0.14	0.08-0.16	0.09-0.18	0.10-0.18
Austenitic-ferritic Stainless Steel (< 30 HRC)	20-35	30-60	0.03-0.08	0.04-0.10	0.05-0.10	0.06-0.12	0.07-0.14	0.08-0.16	0.09-0.18	0.10-0.18
Gray Cast Iron FC 250 (< 32 HRC)	60-100	60-140	0.13-0.20	0.15-0.23	0.17-0.30	0.20-0.35	0.23-0.40	0.25-0.45	0.28-0.48	0.30-0.50
Alloy Cast Iron/Nodular Cast Iron FCD450 (< 28 HRC)	60-100	60-140	0.11-0.18	0.13-0.20	0.15-0.25	0.17-0.32	0.20-0.36	0.22-0.42	0.24-0.45	0.25-0.48
High Alloy Cast Iron and Nodular Cast Iron (< 45 HRC)	60-90	60-100	0.06-0.11	0.08-0.13	0.10-0.16	0.12-0.20	0.14-0.26	0.16-0.28	0.18-0.30	0.20-0.32

Precautions

1. Make sure the workpiece is fixed firmly to the machine.
Use of precision holders, hydro chucks, and high-quality collet chucks is recommended.
2. Use a drill with a run-out of less than 0.02 mm when mounting.
3. Standard cutting conditions is when water-soluble coolant is applied.
4. If the tool diameter you want to use is not listed in the table, please refer to the closest tool diameter value in the table.
Adjust the cutting parameters according to your working environment in Machining.

Description's view

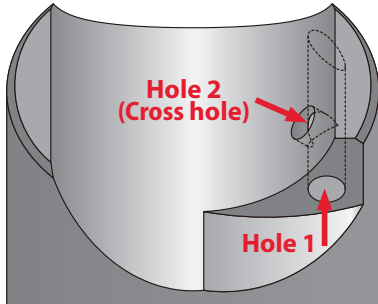
KDA0950X03S100C

KDA	0950	X	03	S100	C
Product Name High Efficiency Coated Solid Carbide Drill	Cutting Dia. DC ø9.5	Drilling Depth* (L/D) 03 : 3D 05 : 5D	Shank Dia. DCON ø10.0	Type N: No Coolant Holes C: With Coolant Holes	

* Drilling depth is an approximate indication of L/D and depends on the size.
Depending on the size, the size may be smaller than the L/D indicated. Check the dimension table.

The KDA extends 20% longer than the current set life.
 The condition of the cutting edge was good, and the wear of the shoulder was less than competitor.

Body SCM 440
 ø6.9, Drilling



Type C
 KDA0690X05S080C

Tool life

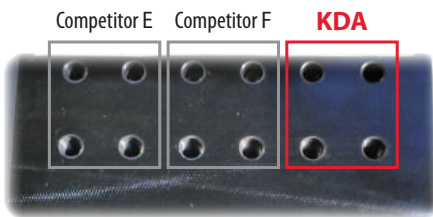
KDA 2,400 pcs or more/1KDA

Competitor C
 Competitor D 2,000 pcs/1KDA

Cutting Conditions:
 Hole 1: Vc = 50 m/min, f = 0.1 mm/rev, H = 25 mm
 Hole 2: Vc = 40 m/min, f = 0.1 mm/rev, H = 15 mm
 Wet (Internal coolant) Combined cutting machine

KDA showed less variation in hole diameter compared to competitor and achieved high efficiency machining. Machining sound was quiet and chip condition was good.

Mold Part Cold Tool Steel
 ø5.1, Drilling



Type N
 KDA0510X03S060N

Hole diameter variation (H = 7.5 mm)

KDA 0.022 mm

Competitor E 0.042 mm

Cutting Conditions:
 Vc = 80 m/min, f = 0.15 mm/rev, H = 15 mm
 Wet (External coolant) BT 50





KYOCERA Asia Pacific Cutting Tool Official Media Lineup



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