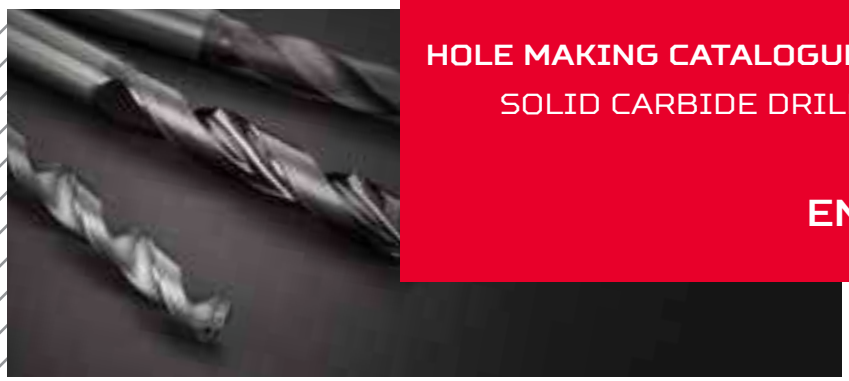
2025

HOLE MAKING CATALOGUE

SOLID CARBIDE DRILL

EN



BEYOND THE MACHINING

www.karcan.com

KARCAN cutting tools

IMAGINATION AND FUNCTIONALITY IS HARMONIZED WITH MATERIALS **AND TOOL COMES TRUE...**

Accuracy, high-efficiency and cost effectiveness come together in **D-Tech** hole making program!

HOLE-MAKING

KARCAN cutting tools

2025
Hole Making
Catalogue


KARCAN
cutting tools

KARCAN
cutting tools

WELCOME TO THE WORLD OF **KARCAN CUTTING TOOLS...**

Who we are?

Founded in 1996 in Eskişehir, Turkey to manufacture carbide cutting tools, we are the first and largest carbide cutting tool manufacturer and one of the top 130 R&D centers in our country. From this aspect, we are the first and the only R&D Center in the cutting tool industry of Turkey.

What we manufacture?

- Carbide Endmills
- Carbide Drill Bits
- Carbide Reamers
- Form Endmills, Drill Bits, Reamers
- Form Carbide, PCD&CBN Inserts
- Micro Tools
- Combined Tools

Which industries we serve?

General Engineering | Mold & Die | Aviation & Aerospace | Defence | Automotive | Medical | Energy | Rail Systems

www.karcan.com

WE ALSO BUILD
THE FUTURE ALONG WITH TODAY

BY AIMING FOR THE EXCELLENCE OF PRODUCTION

Dear Valued Customers and Business Partners,

We, Karcan, as the biggest cutting tools manufacturer of Turkey with our modern machine and measuring park, R&D Center, number of qualified employees, sales figures and export share, owe you all a great debt of gratitude for being with us last 30 years and contributing to our success.

As the leading cutting tools manufacturer in Turkey, we closely follow all the latest developments in machining and materials engineering and bring the latest technologies to your hands. With our strong R&D department, well trained and competent process team, and competent technical sales team, we are your trusted solution partner in machinability of high-tech materials We are not just a cutting tools manufacturer! We create value through our production improvement activities, technical applications and consultancy services and we work hard to help our valued customers gain a competitive edge in “cost per part” in global markets. In this respect, we aim to provide products and services that go “Beyond Machining.”
In 2025, we are launching our second factory which will be the first in our country to write its own unique recipes and will include the future of cutting tool coating technology is HiPIMS. In this field, we have been co-operating with our German business partners who lead the sector globally. We have seen significant increases in our cutting tool performances during widespread trials conducted over three years in our test center and in the customers’ field. Furthermore, in our new factory, we are also implementing robotic manufacturing with 5G technologies, smart factory systems, and digital transformations. This will provide us capacity increase up to a 40%.

We continue our R&D and innovation based growth strategy !

We are expanding our R&D and Test center tenfold in our new factory. In parallel, we are equipping our machine-measuring park with the most advanced technologies in the world. We aim to increase the number of qualified employees working in R&D by 50% within two years.

Our product catalogue showcases the improvements we have achieved through the R&D work, which we carried out in collaboration with the national and international universities, research institutes, local and international customers and the Scientific and Technical Research Council of Turkiye (TUBITAK). we developed our Evo series to further increase the performance of our Eco-Plus series at 45-55 HRC hardness. We designed our 157 series with chip breaker form as an expansion of our 99 series. We breathe into rough milling with our 158 series. Our 222 series is poised to be the best in it’s class with its chatter-free geometry. We challenge to hardness with our 203 Plus and 112 Plus series. As an expansion of our 111 Series, the 111U Plus series has been developed for more precise full slotting operations with tighter diameter and radius tolerances.123 Plus, the new member of Alu-Mac family, is providing perfect chip evacuation with its excellent flute polish.

We have also developed a unique quality range in our micro tool and micro drill lines and succeeded in our R&D endevaours. We have included solutions that compete comfortably with well-known world brands on our website and in this catalog. We strongly recommend our newly added DX Series in the D-Tech hole-making family, specifically designed for long-chipping workpiece materials like ST type, ductile steels such as 1020, 1040, stainless steels, or titanium.

In addition, we have achieved remarkable results with our Meditan series, catering to medical and titanium processing clients. Our innovative design enables exceptionally high cutting speeds and extended tool life simultaneously
We continue to bring innovation to our customers in our country and 28 countries globally, and keep working with great passion in the belief that progress is a never ending process.

Welcome again to the world of Karcan Cutting Tools

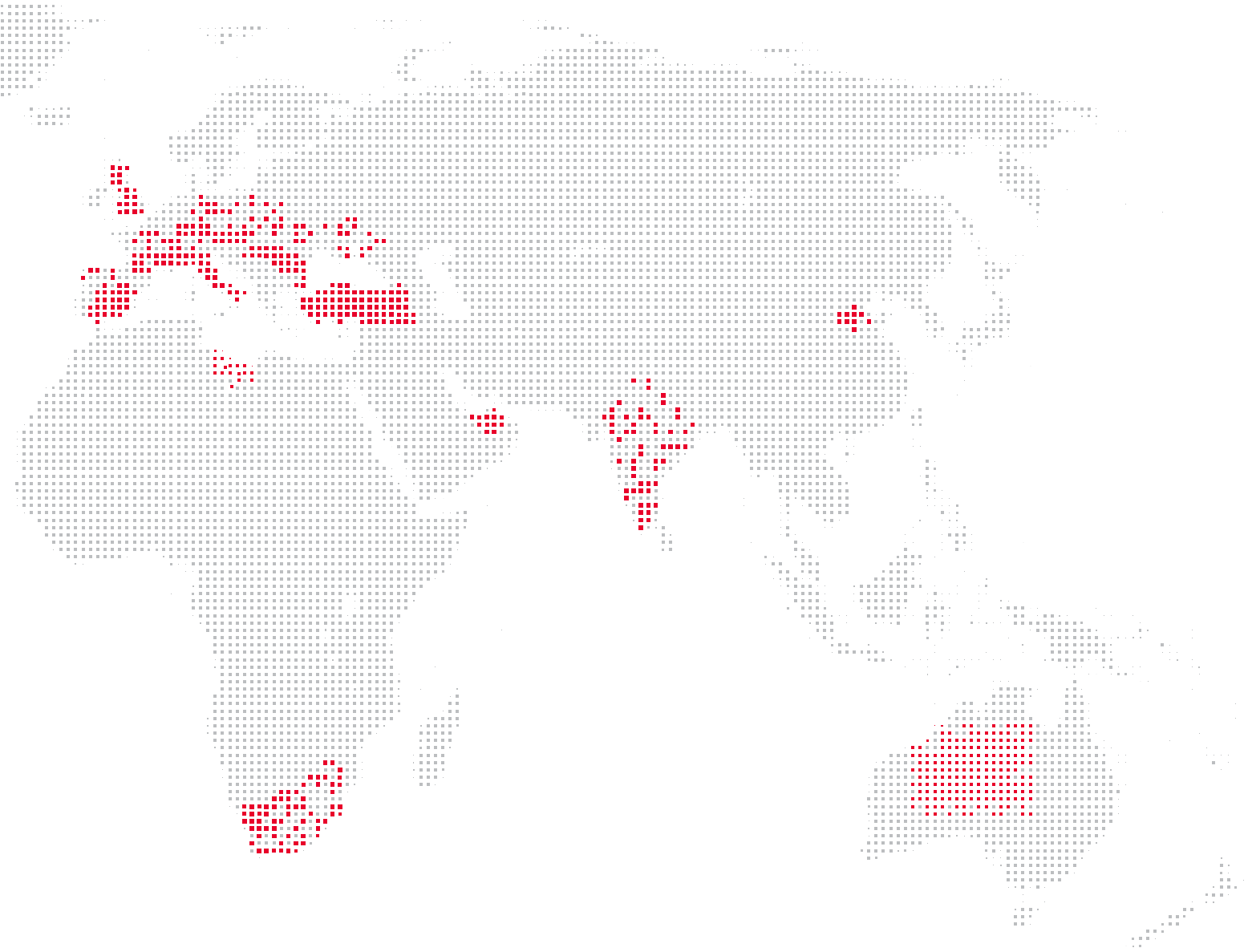
Ümit GEZER
Founder / General Manager

KARCAN
cutting tools

KARCAN EXPORTS TO MORE THAN **32 COUNTRIES** ON **4 CONTINENTS**

WE REACH YOU EASIER THANKS TO OUR GROWING EXPORT NETWORK AND TAKE A PART IN GLOBAL COMPETITION.

GLOBAL VISION




EXPER
To Expand
Tool Life...

KARCAN
cutting tools

FUTURE OF EDGE PREPERATION TECHNOLOGY

The EX-PER technology is developed as a result of exhaustive Karcan R&D studies, ensuring higher performance and improved tool life.

www.karcan.com

WITH THE PARTNERSHIP OF KARCAN, TUBITAK, UNIVERSITY AND INDUSTRY

We developed D-Tech technology that makes a big difference in drilling operations.

We keep providing industrial and innovative solutions with our D-Tech new generation drills;

- Optimal raw material selection for drilling operations, cooperation with globally verified suppliers in this field,
- Single solution for wide range of workpiece matarials with it's original geometry developed by Karcan R&D,
- Increased tool life by Exper edge preparation technology unique to Karcan,
- Globally verified coating optimisation,
- Product development , stress and life tests in Karcan Test Center
- In order to meet the exact requirements of market, we offer the best solution by collecting our academic studies and extensive field tests.

WHY KARCAN?

• A highly skilled and trained R&D, process, application, and technical sales team.
• Benefit from our experience and know-how in various areas; we provide flexible solutions.
• We are price/performance-oriented and provide cost-effective solutions with a sense of constant improvement.
• Capable of competing globally.
• Our well-equipped and modern machine park ensures precision and performance at the highest level.
• A strong franchise and sales network, available 24/7.
• 100% traceability and repeatable processes ensure sustainable quality.
• Karcan Academy and our own test center enable you to understand your tools in detail and choose the most suitable one for your needs.
• Effective stock inventory level.
• Own know-how with qualified labor force and intellectual capitals. Unique.
• Unlimited training opportunities for our customers.
• Specialized in crisis management with emergency action plans, enabling quick responses.
• We closely follow the recent developments in the sector and constantly keep up with the advancing material and machining technology. We are open to innovation and improvement.
• 100% customer-oriented.
• Working with the globally verified suppliers such as machine, equipment, raw material, coating, diamond grinding wheels, filtration and coolant, which are directly related to cutting tool quality.

SELECT THE BEST TOOL

Raw material, geometry, edge preparation and coating in manufacturing cutting tools have a direct effect on tool quality. It is highly recommended that our customers take account of the guidances at our catalogue in order to get the optimum efficiency on our high performance series which are developed after optimising all the parameters. You can also select the suitable tool according to the machinability of the materials or workpieces and operation method by reaching our sales representatives or application team.

Following details are very important in terms of elaboration of suggestions for machining within the shortest time,

1. Workpiece to be machined? (Turbine blade, injector, engine block, brake disc etc.)
2. Material to be machined? (Inconel, titanium, stainless Steel, Steel, Cast Iron iron, in accordance with which of the ISO or DIN standards?)
3. Operation method? (“Side milling” “Shoulder milling” “Slotting” “Ramping” “Plunging”)
4. Material Hardness? Heat-treated?
5. Type of cooling? (Oil, emulsion, air, internal or external coolant, pressure?)
6. Type of Holder? (Shrink, hydrolic, “Collet” “HSK” “BT” “SK” Etc.)
7. Type and power of spindle?
8. Machining method? (Vertical-Horizontal or 5-Axis)
9. Fixing type of worpiece
10. Current tool and parameters in use, if available
11. The problems encountered with the current tool or tool life, if available.

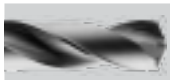
YOU ALREADY HAVE THE ADVANTAGE!

- High performance machining
- Considerable cost reduction per workpiece costs by regarding overheads and depreciation
- Our tools ensure the best possible precision and quality on the workpiece machined.
- Optimal loading for your machines
- Longer tool life and holder life
- Reduced the overall cutting tool costs
- Improved utilisation of your capacity. You don’t have to rush in a new machine investment.

Tools, multi-functionally optimised and standardised, marked with (*) at our catalogue are always available in stock.

Get to know our tools in detail, please watch the videos and animations. You can easily find these documents in our web site, YouTube, Instagram and Linked-in accounts.

Quick Selection Guide

	Model	Internal Coolant	Shank	Coating	Steel	Stainless Steel	Hardened Steel ≤54 HRc	Hardened Steel >54 HRc	Cast Iron	Non Ferrous Material	HRSA	Titanium	Page
K3DF		-	FORM HA DIN 6535	+TiAlN	●	◑	◑	◑	●	○	○	◑	24
K4DF		-	FORM HA DIN 6535	+TiAlN	●	◑	◑	◑	●	○	◑	◑	28
K5DF		-	FORM HA DIN 6535	+TiAlN	●	◑	◑	◑	●	○	○	◑	30
M3DF			FORM HA DIN 6535	+TiAlN	●	◑	◑	◑	●	○	◑	◑	34
M5DF			FORM HA DIN 6535	+TiAlN	●	◑	◑	◑	●	○	○	◑	38
M8DF			FORM HA DIN 6535	+TiAlN	●	◑	◑	◑	●	○	○	◑	42
M12DF			FORM HA DIN 6535	+TiAlN	●	◑	○	○	●	○	○	○	44
M16DF			FORM HA DIN 6535	+TiAlN	●	◑	○	○	●	○	○	○	46
M20DF			FORM HA DIN 6535	+TiAlN	●	◑	○	○	●	○	○	○	48
M25DF			FORM HA DIN 6535	+TiAlN	●	◑	○	○	●	○	○	○	50
KY3DF		-	FORM HA DIN 6535	+TiAlN	●	◑	○	○	●	○	○	●	52
Y5DF			FORM HA DIN 6535	+TiAlN	●	◑	○	○	◑	○	○	◑	54
KDRF		-	FORM HA DIN 6535	+TiAlN	●	◑	○	○	●	◑	◑	●	56
KNS		-	FORM HA DIN 6535	+TiAlN	●	◑	◑	○	●	◑	◑	●	58
KNZ		-	FORM HA DIN 6535	+TiAlN	●	◑	◑	○	●	◑	◑	●	60
PMS		-	FORM HA DIN 6535	+Blank	●	◑	◑	○	●	◑	◑	●	62
MCS		-	FORM HA DIN 6535	+TiAlN	●	◑	◑	○	●	◑	◑	●	64
K3DX		-	FORM HA DIN 6535	+TiAlN	●	◑	○	○	●	○	◑	◑	66
K5DX		-	FORM HA DIN 6535	+TiAlN	●	◑	○	○	●	○	◑	◑	68

Quick Selection Guide

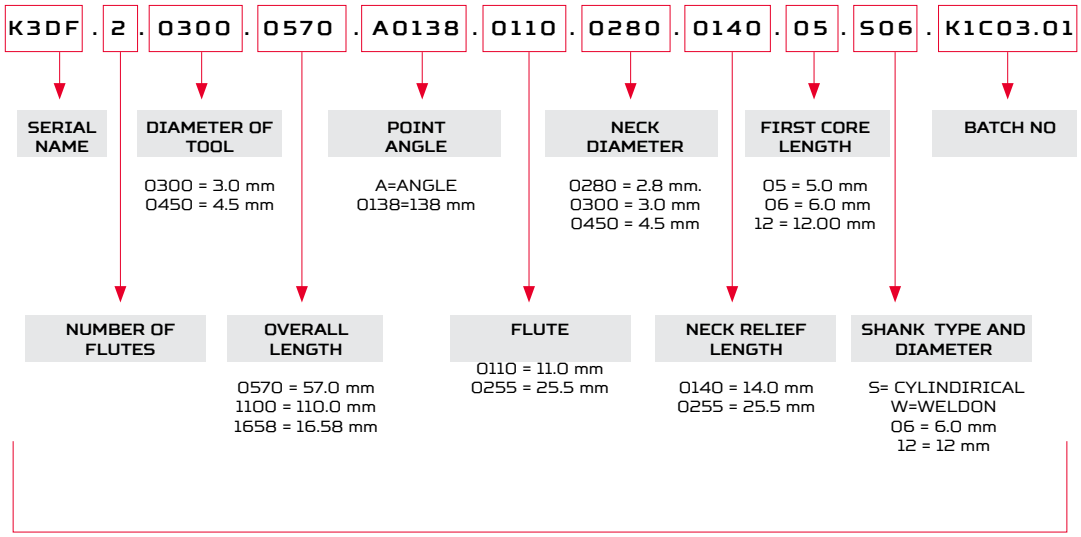
	Model	Internal Coolant	Shank	Coating	Steel	Stainless Steel	Hardened Steel ≤54 HRc	Hardened Steel >54 HRc	Cast Iron	Non Ferrous Material	HRSA	Titanium	Page
M3DX			FORM HA DIN 6535	+TiAlN	●	●	◑	◑	◑	○	●	●	72
M5DX			FORM HA DIN 6535	+TiAlN	●	●	◑	◑	◑	○	●	●	74
TX8DF			FORM HA DIN 6535	+TiAlN	●	○	○	○	●	○	○	○	76
KTX5D			FORM HA DIN 6535	+Blank	○	○	○	○	○	●	○	○	78
KTX8D			FORM HA DIN 6535	+Blank	○	○	○	○	○	●	○	○	80
MEDITAN		-	FORM HA DIN 6535	+TiAlN	◑	●	○	○	◑	○	●	●	82


KARCAN
cutting tools
Columbia

HOLE-MAKING DRILL CONFIGURATION TABLE

YOU CAN READ ALL THE TECHNICAL DETAILS OF A TOOL THAT YOU SELECT WITH JUST ONE SMART CODE!

Our new configuration is now both easier and more practical.



ONE ORDER NO:45100 (EXAMPLE)

2025

Hole Making Catalogue

D-TECH
Hole-Making

- **Optimal raw materials** especially produced for drilling operations
- **Original geometry** fits for wide range of workpiece materials
- **Edge preparation technology** that increases performance and tool life
- Globally verified **coating optimisations**

Let us offer high performance in hole-making by our new generation drills.

K3DF

3D Drill

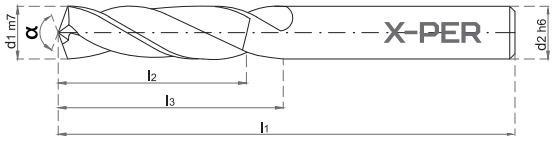
General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech
High Performance
New Product

Thanks to it's brand-new geometry and coating up to **%50** longer tool life at least in comparison with equivalents

Stronger cutting edges by Exper edge preparation technology and up to **%40** better hole surface roughness in comparison with equivalents

Optimal raw material selection for drilling operations to damp vibration and up to **%20** more precision hole diameter in comparison with equivalents



Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
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*	**45102**	K3DF.2.0310.0620.A0138.0180.0310.0200.00.S06A1A05.01	3,1	6	62	18	20
*	**45104**	K3DF.2.0320.0620.A0138.0180.0320.0200.00.S06A1A05.01	3,2	6	62	18	20
*	**45106**	K3DF.2.0330.0620.A0138.0180.0330.0200.00.S06A1A05.01	3,3	6	62	18	20
*	**45108**	K3DF.2.0340.0620.A0138.0180.0340.0200.00.S06A1A05.01	3,4	6	62	18	20
*	**45110**	K3DF.2.0350.0620.A0138.0180.0350.0200.00.S06A1A05.01	3,5	6	62	18	20
*	**45112**	K3DF.2.0360.0620.A0138.0180.0360.0200.00.S06A1A05.01	3,6	6	62	18	20
*	**45114**	K3DF.2.0370.0620.A0138.0180.0370.0200.00.S06A1A05.01	3,7	6	62	18	20
*	**45116**	K3DF.2.0380.0660.A0138.0220.0380.0240.00.S06A1A05.01	3,8	6	66	22	24
*	**45118**	K3DF.2.0390.0660.A0138.0220.0390.0240.00.S06A1A05.01	3,9	6	66	22	24
*	**45120**	K3DF.2.0400.0660.A0138.0220.0400.0240.00.S06A1A05.01	4	6	66	22	24
*	**45122**	K3DF.2.0410.0660.A0138.0220.0410.0240.00.S06A1A05.01	4,1	6	66	22	24
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*	**45132**	K3DF.2.0450.0660.A0138.0220.0450.0240.00.S06A1A05.01	4,5	6	66	22	24
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*	**45136**	K3DF.2.0470.0660.A0138.0220.0470.0240.00.S06A1A05.01	4,7	6	66	22	24
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*	**45140**	K3DF.2.0480.0660.A0138.0260.0480.0280.00.S06A1B02.01	4,8	6	66	26	28
*	**45142**	K3DF.2.0490.0660.A0138.0260.0490.0280.00.S06A1A05.01	4,9	6	66	26	28
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*	**45146**	K3DF.2.0510.0660.A0138.0260.0510.0280.00.S06A1A05.01	5,1	6	66	26	28
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*	**45166**	K3DF.2.0610.0790.A0138.0320.0610.0340.00.S08A1A05.01	6,1	8	79	32	34
*	**45168**	K3DF.2.0620.0790.A0138.0320.0620.0340.00.S08A1A05.01	6,2	8	79	32	34
*	**45170**	K3DF.2.0630.0790.A0138.0320.0630.0340.00.S08A1A05.01	6,3	8	79	32	34
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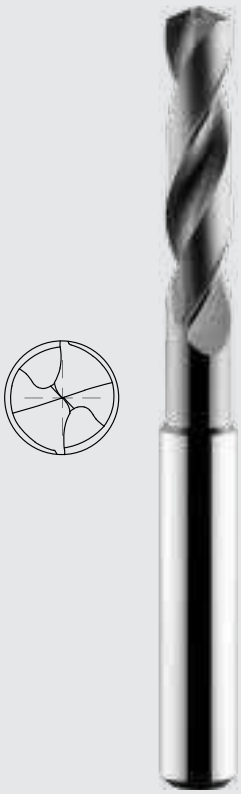
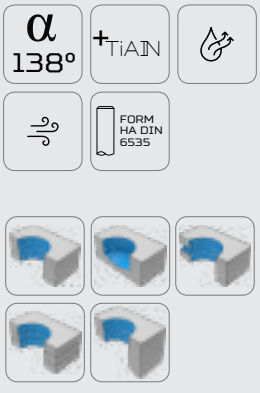
*	**45182**	K3DF.2.0680.0790.A0138.0320.0680.0340.00.S08A1A05.01	6,8	8	79	32	34
*	**45184**	K3DF.2.0690.0790.A0138.0320.0690.0340.00.S08A1A05.01	6,9	8	79	32	34
*	**45186**	K3DF.2.0700.0790.A0138.0320.0700.0340.00.S08A1A05.01	7	8	79	32	34
*	**45188**	K3DF.2.0710.0790.A0138.0380.0710.0410.00.S08A1A05.01	7,1	8	79	38	41
*	**45190**	K3DF.2.0720.0790.A0138.0380.0720.0410.00.S08A1A05.01	7,2	8	79	38	41
*	**45192**	K3DF.2.0730.0790.A0138.0380.0730.0410.00.S08A1A05.01	7,3	8	79	38	41
*	**45194**	K3DF.2.0740.0790.A0138.0380.0740.0410.00.S08A1A05.01	7,4	8	79	38	41
*	**45196**	K3DF.2.0750.0790.A0138.0380.0750.0410.00.S08A1A05.01	7,5	8	79	38	41
	45198	K3DF.2.0760.0790.A0138.0380.0760.0410.00.S08A1A05.01	7,6	8	79	38	41



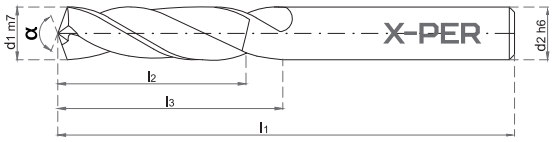


*Marked products are available from stock to deliver fast.

α 138°

+TiAlN

FORM HA DIN 6535



K3DF - 3D Drill

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
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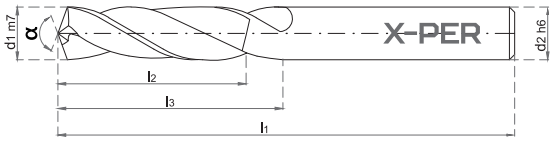
*	**45202**	K3DF.2.0780.0790.A0138.0380.0780.0410.00.S08A1A05.01	7,8	8	79	38	41
*	**45204**	K3DF.2.0790.0790.A0138.0380.0790.0410.00.S08A1A05.01	7,9	8	79	38	41
*	**45206**	K3DF.2.0800.0790.A0138.0380.0800.0410.00.S08A1A05.01	8	8	79	38	41
*	**45208**	K3DF.2.0810.0890.A0138.0430.0810.0470.00.S10A1A05.01	8,1	10	89	43	47
*	**45210**	K3DF.2.0820.0890.A0138.0430.0820.0470.00.S10A1A05.01	8,2	10	89	43	47
*	**45212**	K3DF.2.0830.0890.A0138.0430.0830.0470.00.S10A1A05.01	8,3	10	89	43	47
*	**45214**	K3DF.2.0840.0890.A0138.0430.0840.0470.00.S10A1A05.01	8,4	10	89	43	47
*	**45216**	K3DF.2.0850.0890.A0138.0430.0850.0470.00.S10A1A05.01	8,5	10	89	43	47
*	**45218**	K3DF.2.0860.0890.A0138.0430.0860.0470.00.S10A1A05.01	8,6	10	89	43	47
*	**45220**	K3DF.2.0870.0890.A0138.0430.0870.0470.00.S10A1A05.01	8,7	10	89	43	47
*	**45222**	K3DF.2.0880.0890.A0138.0430.0880.0470.00.S10A1A05.01	8,8	10	89	43	47
*	**45224**	K3DF.2.0890.0890.A0138.0430.0890.0470.00.S10A1A05.01	8,9	10	89	43	47
*	**45226**	K3DF.2.0900.0890.A0138.0430.0900.0470.00.S10A1A05.01	9	10	89	43	47
*	**45228**	K3DF.2.0910.0890.A0138.0430.0910.0470.00.S10A1A05.01	9,1	10	89	43	47
	45230	K3DF.2.0920.0890.A0138.0430.0920.0470.00.S10A1A05.01	9,2	10	89	43	47
*	**45232**	K3DF.2.0925.0890.A0138.0430.0925.0470.00.S10A1A05.01	9,25	10	89	43	47
*	**45234**	K3DF.2.0930.0890.A0138.0430.0930.0470.00.S10A1A05.01	9,3	10	89	43	47
*	**45236**	K3DF.2.0940.0890.A0138.0430.0940.0470.00.S10A1A05.01	9,4	10	89	43	47
*	**45238**	K3DF.2.0950.0890.A0138.0430.0950.0470.00.S10A1A05.01	9,5	10	89	43	47
*	**45240**	K3DF.2.0960.0890.A0138.0430.0960.0470.00.S10A1A05.01	9,6	10	89	43	47
*	**45242**	K3DF.2.0970.0890.A0138.0430.0970.0470.00.S10A1A05.01	9,7	10	89	43	47
*	**45244**	K3DF.2.0980.0890.A0138.0430.0980.0470.00.S10A1A05.01	9,8	10	89	43	47
*	**45246**	K3DF.2.0990.0890.A0138.0430.0990.0470.00.S10A1A05.01	9,9	10	89	43	47
*	**45248**	K3DF.2.1000.0890.A0138.0430.1000.0470.00.S10A1A05.01	10	10	89	43	47
*	**45250**	K3DF.2.1010.1020.A0138.0510.1010.0550.00.S12A1A05.01	10,1	12	102	51	55
*	**45252**	K3DF.2.1020.1020.A0138.0510.1020.0550.00.S12A1A05.01	10,2	12	102	51	55
*	**45254**	K3DF.2.1030.1020.A0138.0510.1030.0550.00.S12A1A05.01	10,3	12	102	51	55
*	**45256**	K3DF.2.1040.1020.A0138.0510.1040.0550.00.S12A1A05.01	10,4	12	102	51	55
*	**45258**	K3DF.2.1050.1020.A0138.0510.1050.0550.00.S12A1A05.01	10,5	12	102	51	55
*	**45260**	K3DF.2.1060.1020.A0138.0510.1060.0550.00.S12A1A05.01	10,6	12	102	51	55
*	**45262**	K3DF.2.1070.1020.A0138.0510.1070.0550.00.S12A1A05.01	10,7	12	102	51	55
*	**45264**	K3DF.2.1080.1020.A0138.0510.1080.0550.00.S12A1A05.01	10,8	12	102	51	55
*	**45266**	K3DF.2.1090.1020.A0138.0510.1090.0550.00.S12A1A05.01	10,9	12	102	51	55
*	**45268**	K3DF.2.1100.1020.A0138.0510.1100.0550.00.S12A1A05.01	11	12	102	51	55
*	**45270**	K3DF.2.1110.1020.A0138.0510.1110.0550.00.S12A1A05.01	11,1	12	102	51	55
*	**45272**	K3DF.2.1120.1020.A0138.0510.1120.0550.00.S12A1A05.01	11,2	12	102	51	55
*	**45274**	K3DF.2.1130.1020.A0138.0510.1130.0550.00.S12A1A05.01	11,3	12	102	51	55
*	**45276**	K3DF.2.1140.1020.A0138.0510.1140.0550.00.S12A1A05.01	11,4	12	102	51	55
*	**45278**	K3DF.2.1150.1020.A0138.0510.1150.0550.00.S12A1A05.01	11,5	12	102	51	55
*	**45280**	K3DF.2.1160.1020.A0138.0510.1160.0550.00.S12A1A05.01	11,6	12	102	51	55
*	**45282**	K3DF.2.1170.1020.A0138.0510.1170.0550.00.S12A1A05.01	11,7	12	102	51	55
*	**45284**	K3DF.2.1180.1020.A0138.0510.1180.0550.00.S12A1A05.01	11,8	12	102	51	55
*	**45286**	K3DF.2.1190.1020.A0138.0510.1190.0550.00.S12A1A05.01	11,9	12	102	51	55
*	**45288**	K3DF.2.1200.1020.A0138.0510.1200.0550.00.S12A1A05.01	12	12	102	51	55
	45290	K3DF.2.1235.1100.A0140.0600.1235.0630.00.S14A1B03.01	12,35	14	110	60	63
*	**45292**	K3DF.2.1250.1070.A0138.0530.1250.0600.00.S14A1A05.01	12,5	14	107	53	60
	45294	K3DF.2.1270.1070.A0138.0530.1270.0600.00.S14A1A05.01	12,7	14	107	53	60
	45296	K3DF.2.1280.1070.A0138.0530.1280.0600.00.S14A1A05.01	12,8	14	107	53	60
	45298	K3DF.2.1290.1070.A0138.0530.1280.0600.00.S14A1A05.01	12,9	14	107	53	60
*	**45300**	K3DF.2.1300.1070.A0138.0530.1300.0600.00.S14A1A05.01	13	14	107	53	60

α 138°

+TiAlN

FORM HA DIN 6535



K3DF - 3D Drill

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	45302	K3DF.2.1310.1070.A0138.0530.1310.0600.00.S14A1A05.01	13,1	14	107	53	60
	45304	K3DF.2.1330.1070.A0138.0530.1320.0600.00.S14A1A05.01	13,3	14	107	53	60
*	**45306**	K3DF.2.1350.1070.A0138.0530.1350.0600.00.S14A1A05.01	13,5	14	107	53	60
	45308	K3DF.2.1370.1070.A0138.0530.1370.0600.00.S14A1A05.01	13,7	14	107	53	60
	45310	K3DF.2.1380.1070.A0138.0530.1380.0600.00.S14A1A05.01	13,8	14	107	53	60
	45312	K3DF.2.1395.1100.A0140.0580.1395.0630.00.S14A1B03.01	13,95	14	110	58	63
*	**45314**	K3DF.2.1400.1070.A0138.0530.1400.0600.00.S14A1A05.01	14	14	107	53	60
	45316	K3DF.2.1407.1100.A0140.0580.1407.0630.00.S16B1B03.01	14,07	16	110	58	63
	45318	K3DF.2.1420.1150.A0138.0580.1420.0650.00.S16A1A05.01	14,2	16	115	58	65
*	**45320**	K3DF.2.1450.1150.A0138.0580.1450.0650.00.S16A1A05.01	14,5	16	115	58	65
	45322	K3DF.2.1470.1150.A0138.0580.1470.0650.00.S16A1A05.01	14,7	16	115	58	65
	45324	K3DF.2.1480.1150.A0138.0580.1480.0650.00.S16A1A05.01	14,8	16	115	58	65
	45326	K3DF.2.1500.1150.A0138.0580.1500.0650.00.S16A1A05.01	15	16	115	58	65
	45328	K3DF.2.1525.1150.A0138.0580.1525.0650.00.S16A1A05.01	15,25	16	115	58	65
	45330	K3DF.2.1530.1150.A0138.0580.1530.0650.00.S16A1A05.01	15,3	16	115	58	65
	45332	K3DF.2.1550.1150.A0138.0580.1550.0650.00.S16A1A05.01	15,5	16	115	58	65
	45334	K3DF.2.1570.1150.A0138.0580.1570.0650.00.S16A1A05.01	15,7	16	115	58	65
	45336	K3DF.2.1580.1150.A0138.0580.1580.0650.00.S16A1A05.01	15,8	16	115	58	65
	45338	K3DF.2.1600.1150.A0138.0580.1600.0650.00.S16A1A05.01	16	16	115	58	65
*	**45340**	K3DF.2.1650.1230.A0138.0660.1650.0730.00.S18A1A05.01	16,5	18	123	66	73
	45342	K3DF.2.1680.1230.A0138.0660.1680.0730.00.S18A1A05.01	16,8	18	123	66	73
	45344	K3DF.2.1700.1230.A0138.0660.1700.0730.00.S18A1A05.01	17	18	123	66	73
	45346	K3DF.2.1750.1230.A0138.0660.1750.0730.00.S18A1A05.01	17,5	18	123	66	73
	45348	K3DF.2.1780.1230.A0138.0660.1780.0730.00.S18A1A05.01	17,8	18	123	66	73
	45350	K3DF.2.1800.1230.A0138.0660.1800.0730.00.S18A1A05.01	18	18	123	66	73
	45352	K3DF.2.1850.1310.A0138.0720.1850.0790.00.S20A1A05.01	18,5	20	131	72	79
	45354	K3DF.2.1880.1310.A0138.0720.1880.0790.00.S20A1A05.01	18,8	20	131	72	79
	45356	K3DF.2.1900.1310.A0138.0720.1900.0790.00.S20A1A05.01	19	20	131	72	79
	45358	K3DF.2.1950.1310.A0138.0720.1950.0790.00.S20A1A05.01	19,5	20	131	72	79
	45360	K3DF.2.1980.1310.A0138.0720.1980.0790.00.S20A1A05.01	19,8	20	131	72	79
	45362	K3DF.2.2000.1310.A0138.0720.2000.0790.00.S20A1A05.01	20	20	131	72	79

Cutting Parameters Vc(m/min)		
Non-Alloy Steel	**110-125**	●
Steel	**100-120**	●
Tempered Steel	**100-120**	●
Cold-Work Tool Steel	**70-90**	◑
Hot-Work Tool Steel	**70-90**	◑
AISI 304 - 416 - 420	**55-65**	◑
AISI 316 - 440	**55-65**	◑
17-4 PH 15-5 PH	**50-55**	◑
Chrome-Cobalt Alloy	**50-55**	◑
Duplex F51	**40-50**	◑
Super Duplex F55	**40-50**	◑
Grey Cast Iron	**170-200**	●
Alloy Cast Iron	**130-150**	●
Precision Cast	**110-130**	●
Titanium	**55-65**	◑
Titanium Alloys	**55-65**	◑
≤ 54 HRc	**60-80**	◑
> 54 HRc	**40-55**	◑

Feed Per Revolution (mm/rev)	
Ø	
3	0,03
4	0,045
5	0,85
6	0,17
7	0,19
8	0,21
9	0,23
10	0,25
12	0,27
14	0,29
16	0,31
18	0,33
20	0,35

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

K4DF

4D Drill

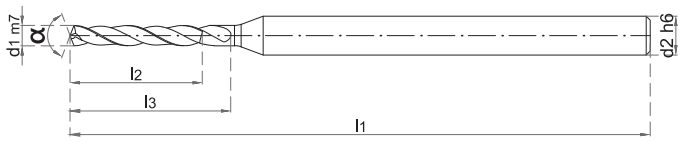
General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech
High Performance
New Product

Thanks to it's brand-new geometry and coating up to **%50** longer tool life at least in comparison with equivalents

Stronger cutting edges by Exper edge preparation technology and up to **%40** better hole surface roughness in comparison with equivalents

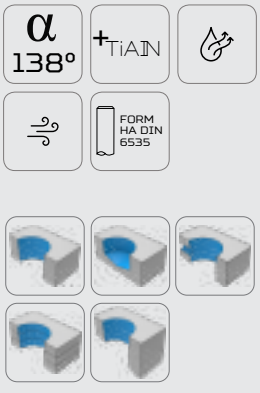
Optimal raw material selection for drilling operations to damp vibration and up to **%20** more precision hole diameter in comparison with equivalents



Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
*	**46100**	K4DF.2.0100.0500.A0138.0060.0100.0075.00.S03A1A06.01	1	3	50	6	7,5
*	**46102**	K4DF.2.0110.0500.A0138.0070.0110.0085.00.S03A1A06.01	1,1	3	50	7	8,5
*	**46104**	K4DF.2.0120.0500.A0138.0070.0120.0085.00.S03A1A06.01	1,2	3	50	7	8,5
*	**46106**	K4DF.2.0130.0500.A0138.0080.0130.0095.00.S03A1A06.01	1,3	3	50	8	9,5
*	**46108**	K4DF.2.0140.0500.A0138.0090.0140.0105.00.S03A1A06.01	1,4	3	50	9	10,5
*	**46110**	K4DF.2.0150.0500.A0138.0090.0150.0105.00.S03A1A06.01	1,5	3	50	9	10,5
*	**46112**	K4DF.2.0160.0500.A0138.0100.0160.0115.00.S03A1A06.01	1,6	3	50	10	11,5
*	**46114**	K4DF.2.0170.0500.A0138.0100.0170.0115.00.S03A1A06.01	1,7	3	50	10	11,5
*	**46116**	K4DF.2.0180.0500.A0138.0100.0180.0115.00.S03A1A06.01	1,8	3	50	10	11,5
*	**46118**	K4DF.2.0190.0500.A0138.0120.0190.0135.00.S03A1A06.01	1,9	3	50	12	13,5
*	**46120**	K4DF.2.0200.0600.A0138.0120.0200.0150.00.S04A1A06.01	2	4	60	12	15
*	**46122**	K4DF.2.0210.0600.A0142.0120.0210.0160.00.S03B1B04.01	2,1	3	60	12	16
*	**46124**	K4DF.2.0210.0600.A0138.0140.0210.0160.00.S04A1A06.01	2,1	4	60	14	16
*	**46126**	K4DF.2.0220.0600.A0138.0140.0220.0160.00.S04A1A06.01	2,2	4	60	14	16
*	**46128**	K4DF.2.0230.0600.A0138.0140.0230.0160.00.S04A1A06.01	2,3	4	60	14	16
*	**46130**	K4DF.2.0240.0600.A0138.0140.0240.0160.00.S04A1A06.01	2,4	4	60	14	16
*	**46132**	K4DF.2.0250.0600.A0138.0160.0250.0180.00.S04A1A06.01	2,5	4	60	16	18
*	**46134**	K4DF.2.0260.0600.A0138.0160.0260.0180.00.S04A1A06.01	2,6	4	60	16	18
*	**46136**	K4DF.2.0270.0600.A0138.0160.0270.0180.00.S04A1A06.01	2,7	4	60	16	18
*	**46138**	K4DF.2.0280.0600.A0138.0170.0280.0190.00.S04A1A06.01	2,8	4	60	17	19
*	**46140**	K4DF.2.0290.0600.A0138.0180.0290.0200.00.S04A1A06.01	2,9	4	60	18	20

Cutting Parameters Vc(m/min)		
Non-Alloy Steel	80-110	●
Steel	70-100	●
Tempered Steel	70-100	●
Cold-Work Tool Steel	60-80	●
Hot-Work Tool Steel	60-80	◑
AISI 304 - 416 - 420	55-65	◑
AISI 316 - 440	55-65	◑
17-4 PH 15-5 PH	50-55	◑
Chrome-Cobalt Alloy	50-55	◑
Duplex F51	40-50	◑
Super Duplex F55	40-50	◑
Grey Cast Iron	150-180	●
Alloy Cast Iron	100-130	●
Precision Cast	80-115	●
Titanium	55-65	◑
Titanium Alloys	55-65	◑
HRSA	20-30	◑
≤ 54 HRc	60-80	◑
> 54 HRc	40-55	◑

Feed Per Revolution (mm/rev)	
Ø	
1	0,025
1,5	0,05
2	0,07
2,5	0,095
2,9	0,12



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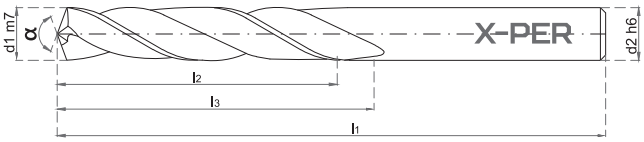
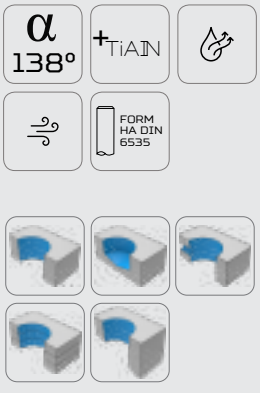


Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	47100	K5DF.2.0220.0500.A0138.0120.0220.0150.00.S04A1A05.01	2,2	4	50	12	15
*	**47102**	K5DF.2.0300.0660.A0138.0270.0300.0280.00.S06A1A05.01	3	6	66	27	28
	47104	K5DF.2.0310.0660.A0138.0270.0310.0280.00.S06A1A05.01	3,1	6	66	27	28
	47106	K5DF.2.0320.0660.A0138.0270.0320.0280.00.S06A1A05.01	3,2	6	66	27	28
*	**47108**	K5DF.2.0330.0660.A0138.0270.0330.0280.00.S06A1A05.01	3,3	6	66	27	28
*	**47110**	K5DF.2.0340.0660.A0138.0270.0340.0280.00.S06A1A05.01	3,4	6	66	27	28
*	**47112**	K5DF.2.0350.0660.A0138.0270.0350.0280.00.S06A1A05.01	3,5	6	66	27	28
*	**47114**	K5DF.2.0360.0660.A0138.0270.0360.0280.00.S06A1A05.01	3,6	6	66	27	28
*	**47116**	K5DF.2.0370.0660.A0138.0270.0370.0280.00.S06A1A05.01	3,7	6	66	27	28
*	**47118**	K5DF.2.0380.0740.A0138.0320.0380.0360.00.S06A1A05.01	3,8	6	74	32	36
*	**47120**	K5DF.2.0390.0740.A0138.0320.0390.0360.00.S06A1A05.01	3,9	6	74	32	36
*	**47122**	K5DF.2.0400.0740.A0120.0320.0400.0450.00.S04A1B03.01	4	4	74	32	45
*	**47124**	K5DF.2.0400.0740.A0138.0320.0400.0360.00.S06A1A05.01	4	6	74	32	36
*	**47126**	K5DF.2.0410.0740.A0138.0320.0410.0360.00.S06A1A05.01	4,1	6	74	32	36
*	**47128**	K5DF.2.0420.0740.A0138.0320.0420.0360.00.S06A1A05.01	4,2	6	74	32	36
	47130	K5DF.2.0430.0740.A0138.0320.0430.0360.00.S06A1A05.01	4,3	6	74	32	36
*	**47132**	K5DF.2.0440.0740.A0138.0320.0440.0360.00.S06A1A05.01	4,4	6	74	32	36
*	**47134**	K5DF.2.0450.0740.A0138.0320.0450.0360.00.S06A1A05.01	4,5	6	74	32	36
*	**47136**	K5DF.2.0460.0740.A0138.0320.0460.0360.00.S06A1A05.01	4,6	6	74	32	36
*	**47138**	K5DF.2.0470.0740.A0138.0320.0470.0360.00.S06A1A05.01	4,7	6	74	32	36
*	**47140**	K5DF.2.0480.0820.A0138.0410.0480.0440.00.S06A1A05.01	4,8	6	82	41	44
*	**47142**	K5DF.2.0490.0820.A0138.0410.0490.0440.00.S06A1A05.01	4,9	6	82	41	44
*	**47144**	K5DF.2.0500.0820.A0138.0410.0500.0440.00.S06A1A05.01	5	6	82	41	44
*	**47146**	K5DF.2.0510.0820.A0138.0410.0510.0440.00.S06A1A05.01	5,1	6	82	41	44
*	**47148**	K5DF.2.0520.0820.A0138.0410.0520.0440.00.S06A1A05.01	5,2	6	82	41	44
*	**47150**	K5DF.2.0530.0820.A0138.0410.0530.0440.00.S06A1A05.01	5,3	6	82	41	44
*	**47152**	K5DF.2.0540.0820.A0138.0410.0540.0440.00.S06A1A05.01	5,4	6	82	41	44
*	**47154**	K5DF.2.0550.0820.A0138.0410.0550.0440.00.S06A1A05.01	5,5	6	82	41	44
*	**47156**	K5DF.2.0560.0820.A0138.0410.0560.0440.00.S06A1A05.01	5,6	6	82	41	44
*	**47158**	K5DF.2.0570.0820.A0138.0410.0570.0440.00.S06A1A05.01	5,7	6	82	41	44
*	**47160**	K5DF.2.0580.0820.A0138.0410.0580.0440.00.S06A1A05.01	5,8	6	82	41	44
*	**47162**	K5DF.2.0590.0820.A0138.0410.0590.0440.00.S06A1A05.01	5,9	6	82	41	44
*	**47164**	K5DF.2.0600.0820.A0138.0410.0600.0440.00.S06A1A05.01	6	6	82	41	44
*	**47166**	K5DF.2.0610.0910.A0138.0500.0610.0530.00.S08A1A05.01	6,1	8	91	50	53
*	**47168**	K5DF.2.0620.0910.A0138.0500.0620.0530.00.S08A1A05.01	6,2	8	91	50	53
*	**47170**	K5DF.2.0630.0910.A0138.0500.0630.0530.00.S08A1A05.01	6,3	8	91	50	53
*	**47172**	K5DF.2.0640.0910.A0138.0500.0640.0530.00.S08A1A05.01	6,4	8	91	50	53
*	**47174**	K5DF.2.0650.0910.A0138.0500.0650.0530.00.S08A1A05.01	6,5	8	91	50	53
*	**47176**	K5DF.2.0660.0910.A0138.0500.0660.0530.00.S08A1A05.01	6,6	8	91	50	53
*	**47178**	K5DF.2.0670.0910.A0138.0500.0670.0530.00.S08A1A05.01	6,7	8	91	50	53
*	**47180**	K5DF.2.0680.0910.A0138.0500.0680.0530.00.S08A1A05.01	6,8	8	91	50	53
*	**47182**	K5DF.2.0690.0910.A0138.0500.0690.0530.00.S08A1A05.01	6,9	8	91	50	53
*	**47184**	K5DF.2.0700.0910.A0138.0500.0700.0530.00.S08A1A05.01	7	8	91	50	53
*	**47186**	K5DF.2.0710.0910.A0138.0500.0710.0530.00.S08A1A05.01	7,1	8	91	50	53
*	**47188**	K5DF.2.0720.0910.A0138.0500.0720.0530.00.S08A1A05.01	7,2	8	91	50	53
*	**47190**	K5DF.2.0730.0910.A0138.0500.0730.0530.00.S08A1A05.01	7,3	8	91	50	53
*	**47192**	K5DF.2.0740.0910.A0138.0500.0740.0530.00.S08A1A05.01	7,4	8	91	50	53
*	**47194**	K5DF.2.0750.0910.A0138.0500.0750.0530.00.S08A1A05.01	7,5	8	91	50	53
*	**47196**	K5DF.2.0760.0910.A0138.0500.0760.0530.00.S08A1A05.01	7,6	8	91	50	53



*Marked products are available from stock to deliver fast.

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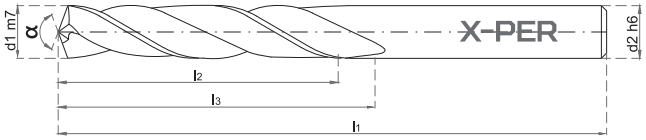

K5DF - 5D Drill

Stock	Order No	Code	d1m7	d2h6	d3	l1	l2	l3
	47198	K5DF.2.0770.0910.A0138.0500.0770.0530.00.S08A1A05.01	7,7	8	7,7	91	50	53
*	**47200**	K5DF.2.0780.0910.A0138.0500.0780.0530.00.S08A1A05.01	7,8	8	7,8	91	50	53
*	**47202**	K5DF.2.0790.0910.A0138.0500.0790.0530.00.S08A1A05.01	7,9	8	7,9	91	50	53
*	**47204**	K5DF.2.0800.0910.A0138.0500.0800.0530.00.S08A1A05.01	8	8	8	91	50	53
*	**47206**	K5DF.2.0810.1030.A0138.0570.0810.0610.00.S10A1A05.01	8,1	10	8,1	103	57	61
*	**47208**	K5DF.2.0820.1030.A0138.0570.0820.0610.00.S10A1A05.01	8,2	10	8,2	103	57	61
*	**47210**	K5DF.2.0830.1030.A0138.0570.0830.0610.00.S10A1A05.01	8,3	10	8,3	103	57	61
*	**47212**	K5DF.2.0840.1030.A0138.0570.0840.0610.00.S10A1A05.01	8,4	10	8,4	103	57	61
*	**47214**	K5DF.2.0850.1030.A0138.0570.0850.0610.00.S10A1A05.01	8,5	10	8,5	103	57	61
*	**47216**	K5DF.2.0860.1030.A0138.0570.0860.0610.00.S10A1A05.01	8,6	10	8,6	103	57	61
*	**47218**	K5DF.2.0870.1030.A0138.0570.0870.0610.00.S10A1A05.01	8,7	10	8,7	103	57	61
*	**47220**	K5DF.2.0880.1030.A0138.0570.0880.0610.00.S10A1A05.01	8,8	10	8,8	103	57	61
*	**47222**	K5DF.2.0890.1030.A0138.0570.0890.0610.00.S10A1A05.01	8,9	10	8,9	103	57	61
*	**47224**	K5DF.2.0900.1030.A0138.0570.0900.0610.00.S10A1A05.01	9	10	9	103	57	61
*	**47226**	K5DF.2.0910.1030.A0138.0570.0910.0610.00.S10A1A05.01	9,1	10	9,1	103	57	61
*	**47228**	K5DF.2.0920.1030.A0138.0570.0920.0610.00.S10A1A05.01	9,2	10	9,2	103	57	61
*	**47230**	K5DF.2.0930.1030.A0138.0570.0930.0610.00.S10A1A05.01	9,3	10	9,3	103	57	61
*	**47232**	K5DF.2.0940.1030.A0138.0570.0940.0610.00.S10A1A05.01	9,4	10	9,4	103	57	61
*	**47234**	K5DF.2.0950.1030.A0138.0570.0950.0610.00.S10A1A05.01	9,5	10	9,5	103	57	61
*	**47236**	K5DF.2.0960.1030.A0138.0570.0960.0610.00.S10A1A05.01	9,6	10	9,6	103	57	61
*	**47238**	K5DF.2.0970.1030.A0138.0570.0970.0610.00.S10A1A05.01	9,7	10	9,7	103	57	61
*	**47240**	K5DF.2.0980.1030.A0138.0570.0980.0610.00.S10A1A05.01	9,8	10	9,8	103	57	61
*	**47242**	K5DF.2.0990.1030.A0138.0570.0990.0610.00.S10A1A05.01	9,9	10	9,9	103	57	61
*	**47244**	K5DF.2.1000.1030.A0138.0570.1000.0610.00.S10A1A05.01	10	10	10	103	57	61
	47246	K5DF.2.1010.1180.A0138.0670.1010.0710.00.S12A1A05.01	10,1	12	10,1	118	67	71
*	**47248**	K5DF.2.1020.1180.A0138.0670.1020.0710.00.S12A1A05.01	10,2	12	10,2	118	67	71
*	**47250**	K5DF.2.1030.1180.A0138.0670.1030.0710.00.S12A1A05.01	10,3	12	10,3	118	67	71
	47252	K5DF.2.1040.1180.A0138.0670.1040.0710.00.S12A1A05.01	10,4	12	10,4	118	67	71
*	**47254**	K5DF.2.1050.1180.A0138.0670.1050.0710.00.S12A1A05.01	10,5	12	10,5	118	67	71
*	**47256**	K5DF.2.1060.1180.A0138.0670.1060.0710.00.S12A1A05.01	10,6	12	10,6	118	67	71
	47258	K5DF.2.1070.1180.A0138.0670.1070.0710.00.S12A1A05.01	10,7	12	10,7	118	67	71
*	**47260**	K5DF.2.1080.1180.A0138.0670.1080.0710.00.S12A1A05.01	10,8	12	10,8	118	67	71
	47262	K5DF.2.1090.1180.A0138.0670.1090.0710.00.S12A1A05.01	10,9	12	10,9	118	67	71
*	**47264**	K5DF.2.1100.1180.A0138.0670.1100.0710.00.S12A1A05.01	11	12	11	118	67	71
	47266	K5DF.2.1110.1180.A0138.0670.1110.0710.00.S12A1A05.01	11,1	12	11,1	118	67	71
*	**47268**	K5DF.2.1120.1180.A0138.0670.1120.0710.00.S12A1A05.01	11,2	12	11,2	118	67	71
	47270	K5DF.2.1130.1180.A0138.0670.1130.0710.00.S12A1A05.01	11,3	12	11,3	118	67	71
	47272	K5DF.2.1140.1180.A0138.0670.1140.0710.00.S12A1A05.01	11,4	12	11,4	118	67	71
*	**47274**	K5DF.2.1150.1180.A0138.0670.1150.0710.00.S12A1A05.01	11,5	12	11,5	118	67	71
	47276	K5DF.2.1160.1180.A0138.0670.1160.0710.00.S12A1A05.01	11,6	12	11,6	118	67	71
	47278	K5DF.2.1170.1180.A0138.0670.1170.0710.00.S12A1A05.01	11,7	12	11,7	118	67	71
	47280	K5DF.2.1180.1180.A0138.0670.1180.0710.00.S12A1A05.01	11,8	12	11,8	118	67	71
	47282	K5DF.2.1190.1180.A0138.0670.1190.0710.00.S12A1A05.01	11,9	12	11,9	118	67	71
*	**47284**	K5DF.2.1200.1180.A0138.0670.1200.0710.00.S12A1A05.01	12	12	12	118	67	71
*	**47286**	K5DF.2.1250.1240.A0138.0700.1250.0770.00.S14A1A05.01	12,5	14	12,5	124	70	77
	47288	K5DF.2.1270.1240.A0138.0700.1270.0770.00.S14A1A05.01	12,7	14	12,7	124	70	77
*	**47290**	K5DF.2.1280.1240.A0138.0700.1280.0770.00.S14A1A05.01	12,8	14	12,8	124	70	77
	47292	K5DF.2.1290.1240.A0138.0700.1290.0770.00.S14A1A05.01	12,9	14	12,9	124	70	77
	47294	K5DF.2.1300.1240.A0138.0700.1300.0770.00.S14A1A05.01	13	14	13	124	70	77
	47296	K5DF.2.1310.1240.A0138.0700.1310.0770.00.S14A1A05.01	13,1	14	13,1	124	70	77
	47298	K5DF.2.1330.1240.A0138.0700.1330.0770.00.S14A1A05.01	13,3	14	13,3	124	70	77

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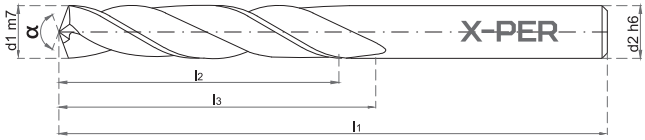
FORM HA DIN 6535



K5DF - 5D Drill

Stock	Order No	Code	d1m7	d2h6	d3	l1	l2	l3
*	**47300**	K5DF.2.1350.1240.A0138.0700.1350.0770.00.S14A1A05.01	13,5	14	13,5	124	70	77
	47302	K5DF.2.1370.1240.A0138.0700.1370.0770.00.S14A1A05.01	13,7	14	13,7	124	70	77
	47304	K5DF.2.1380.1240.A0138.0700.1380.0770.00.S14A1A05.01	13,8	14	13,8	124	70	77
*	**47306**	K5DF.2.1400.1240.A0138.0700.1400.0770.00.S14A1A05.01	14	14	14	124	70	77
	47308	K5DF.2.1420.1330.A0138.0740.1420.0830.00.S16A1A05.01	14,2	16	14,2	133	74	83
*	**47310**	K5DF.2.1450.1330.A0138.0740.1450.0830.00.S16A1A05.01	14,5	16	14,5	133	74	83
	47312	K5DF.2.1470.1330.A0138.0740.1470.0830.00.S16A1A05.01	14,7	16	14,7	133	74	83
	47314	K5DF.2.1480.1330.A0138.0740.1480.0830.00.S16A1A05.01	14,8	16	14,8	133	74	83
	47316	K5DF.2.1500.1330.A0138.0740.1500.0830.00.S16A1A05.01	15	16	15	133	74	83
	47318	K5DF.2.1510.1330.A0138.0740.1510.0830.00.S16A1A05.01	15,1	16	15,1	133	74	83
	47320	K5DF.2.1530.1330.A0138.0740.1530.0830.00.S16A1A05.01	15,3	16	15,3	133	74	83
	47322	K5DF.2.1550.1330.A0138.0740.1550.0830.00.S16A1A05.01	15,5	16	15,5	133	74	83
	47324	K5DF.2.1570.1330.A0138.0740.1570.0830.00.S16A1A05.01	15,7	16	15,7	133	74	83
	47326	K5DF.2.1580.1330.A0138.0740.1580.0830.00.S16A1A05.01	15,8	16	15,8	133	74	83
	47328	K5DF.2.1600.1330.A0138.0740.1600.0830.00.S16A1A05.01	16	16	16	133	74	83
	47330	K5DF.2.1650.1430.A0138.0860.1650.0930.00.S18A1A05.01	16,5	18	16,5	143	86	93
	47332	K5DF.2.1680.1430.A0138.0860.1680.0930.00.S18A1A05.01	16,8	18	16,8	143	86	93
	47334	K5DF.2.1700.1430.A0138.0860.1700.0930.00.S18A1A05.01	17	18	17	143	86	93
	47336	K5DF.2.1750.1430.A0138.0860.1750.0930.00.S18A1A05.01	17,5	18	17,5	143	86	93
	47338	K5DF.2.1780.1430.A0138.0860.1780.0930.00.S18A1A05.01	17,8	18	17,8	143	86	93
	47340	K5DF.2.1800.1430.A0138.0860.1800.0930.00.S18A1A05.01	18	18	18	143	86	93
	47342	K5DF.2.1850.1530.A0138.0920.1850.1010.00.S20A1A05.01	18,5	20	18,5	153	92	101
	47344	K5DF.2.1880.1530.A0138.0920.1880.1010.00.S20A1A05.01	18,8	20	18,8	153	92	101
	47346	K5DF.2.1900.1530.A0138.0920.1900.1010.00.S20A1A05.01	19	20	19	153	92	101
	47348	K5DF.2.1950.1530.A0138.0920.1950.1010.00.S20A1A05.01	19,5	20	19,5	153	92	101
	47350	K5DF.2.1980.1530.A0138.0920.1980.1010.00.S20A1A05.01	19,8	20	19,8	153	92	101
	47352	K5DF.2.2000.1530.A0138.0920.2000.1010.00.S20A1A05.01	20	20	20	153	92	101

Cutting Parameters Vc(m/min)		
Non-Alloy Steel	80-105	●
Steel	80-100	●
Tempered Steel	80-100	●
Cold-Work Tool Steel	60-80	◑
Hot-Work Tool Steel	60-80	◑
AISI 304 - 416 - 420	30-40	◑
AISI 316 - 440	30-40	◑
17-4 PH 15-5 PH	25-30	◑
Chrome-Cobalt Alloy	25-30	◑
Duplex F51	15-25	◑
Super Duplex F55	15-25	◑
Grey Cast Iron	140-170	●
Alloy Cast Iron	100-130	●
Precision Cast	80-110	●
Titanium	30-40	◑
Titanium Alloys	25-30	◑
≤ 54 HRc	60-80	◑
> 54 HRc	40-55	◑

Feed Per Revolution (mm/rev)	
Ø	
3	0,025
4	0,03
5	0,042
6	0,052
7	0,082
8	0,12
9	0,14
10	0,16
12	0,19
14	0,22
16	0,24
18	0,26
20	0,29

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

M3DF

3D Drill With Coolant Holes

General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech
High Performance
New Product

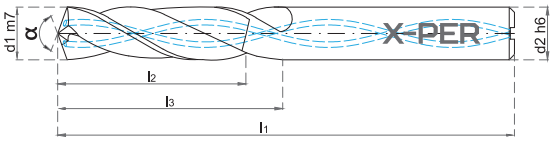
Thanks to it's brand-new geometry and coating up to **%50** longer tool life at least in comparison with equivalents

Stronger cutting edges by Exper edge preparation technology and up to **%40** better hole surface roughness in comparison with equivalents

Optimal raw material selection for drilling operations to damp vibration and up to **%20** more precision hole diameter in comparison with equivalents

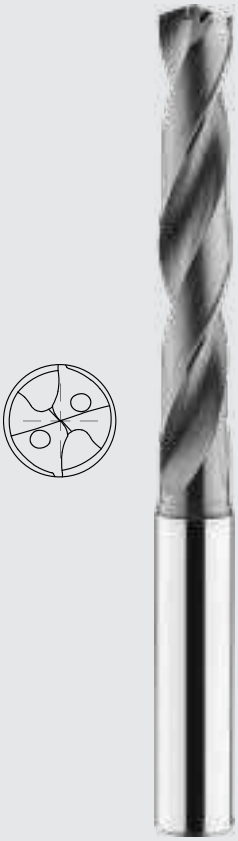
M3DF

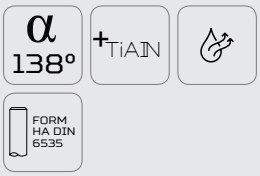
3D Drill With Coolant Holes



Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
*	**69100**	M3DF.2.0200.0500.A0138.0090.0000.0120.00.S04M1A05.01	2	4	50	9	12
*	**69102**	M3DF.2.0210.0550.A0138.0095.0000.0126.00.S04M1A05.01	2,1	4	55	9,5	12,6
*	**69104**	M3DF.2.0215.0580.A0147.0110.0000.0160.00.S03B1C05.01	2,15	3	58	11	16
*	**69106**	M3DF.2.0220.0550.A0138.0099.0000.0132.00.S04M1A05.01	2,2	4	55	9,9	13,2
*	**69108**	M3DF.2.0230.0550.A0138.0104.0000.0138.00.S04M1A05.01	2,3	4	55	10,4	13,8
*	**69110**	M3DF.2.0240.0550.A0138.0108.0000.0144.00.S04M1A05.01	2,4	4	55	10,8	14,4
*	**69112**	M3DF.2.0250.0550.A0138.0113.0000.0150.00.S04M1A05.01	2,5	4	55	11,3	15
*	**69114**	M3DF.2.0260.0550.A0138.0117.0000.0156.00.S04M1A05.01	2,6	4	55	11,7	15,6
*	**69116**	M3DF.2.0270.0550.A0138.0122.0000.0162.00.S04M1A05.01	2,7	4	55	12,2	16,2
*	**69118**	M3DF.2.0280.0550.A0138.0126.0000.0168.00.S04M1A05.01	2,8	4	55	12,6	16,8
*	**69120**	M3DF.2.0290.0550.A0138.0131.0000.0174.00.S04M1A05.01	2,9	4	55	13,1	17,4
*	**69122**	M3DF.2.0300.0620.A0138.0180.0000.0200.00.S06C1A05.01	3	6	62	18	20
*	**69124**	M3DF.2.0310.0620.A0138.0180.0000.0200.00.S06C1A05.01	3,1	6	62	18	20
*	**69126**	M3DF.2.0320.0620.A0138.0180.0000.0200.00.S06C1A05.01	3,2	6	62	18	20
*	**69128**	M3DF.2.0330.0620.A0138.0180.0000.0200.00.S06C1A05.01	3,3	6	62	18	20
*	**69130**	M3DF.2.0340.0620.A0138.0180.0000.0200.00.S06C1A05.01	3,4	6	62	18	20
*	**69132**	M3DF.2.0350.0620.A0138.0180.0000.0200.00.S06C1A05.01	3,5	6	62	18	20
*	**69134**	M3DF.2.0360.0620.A0138.0180.0000.0200.00.S06C1A05.01	3,6	6	62	18	20
*	**69136**	M3DF.2.0370.0620.A0138.0180.0000.0200.00.S06C1A05.01	3,7	6	62	18	20
*	**69138**	M3DF.2.0380.0660.A0138.0220.0000.0240.00.S06A1A05.01	3,8	6	66	22	24
*	**69140**	M3DF.2.0390.0660.A0138.0220.0000.0240.00.S06A1A05.01	3,9	6	66	22	24
*	**69142**	M3DF.2.0400.0660.A0138.0220.0000.0240.00.S06A1A05.01	4	6	66	22	24
*	**69144**	M3DF.2.0410.0660.A0138.0220.0000.0240.00.S06A1A05.01	4,1	6	66	22	24
*	**69146**	M3DF.2.0420.0660.A0138.0220.0000.0240.00.S06A1A05.01	4,2	6	66	22	24
*	**69148**	M3DF.2.0430.0660.A0138.0220.0000.0240.00.S06A1A05.01	4,3	6	66	22	24
*	**69150**	M3DF.2.0440.0660.A0138.0220.0000.0240.00.S06A1A05.01	4,4	6	66	22	24
*	**69152**	M3DF.2.0450.0660.A0138.0220.0000.0240.00.S06A1A05.01	4,5	6	66	22	24
*	**69154**	M3DF.2.0460.0660.A0138.0220.0000.0240.00.S06A1A05.01	4,6	6	66	22	24
*	**69156**	M3DF.2.0470.0660.A0138.0220.0000.0240.00.S06A1A05.01	4,7	6	66	22	24
*	**69158**	M3DF.2.0480.0660.A0138.0260.0000.0280.00.S06A1A05.01	4,8	6	66	26	28
*	**69160**	M3DF.2.0490.0660.A0138.0260.0000.0280.00.S06A1A05.01	4,9	6	66	26	28
*	**69162**	M3DF.2.0500.0660.A0138.0260.0000.0280.00.S06A1A05.01	5	6	66	26	28
*	**69164**	M3DF.2.0510.0660.A0138.0260.0000.0280.00.S06A1A05.01	5,1	6	66	26	28
*	**69166**	M3DF.2.0520.0660.A0145.0260.0000.0280.00.S06A1A05.01	5,2	6	66	26	28
*	**69168**	M3DF.2.0520.0660.A0138.0260.0000.0280.00.S06A1A05.01	5,2	6	66	26	28
*	**69170**	M3DF.2.0530.0660.A0138.0260.0000.0280.00.S06A1A05.01	5,3	6	66	26	28
*	**69172**	M3DF.2.0540.0660.A0138.0260.0000.0280.00.S06A1A05.01	5,4	6	66	26	28
*	**69174**	M3DF.2.0550.0660.A0138.0260.0000.0280.00.S06A1A05.01	5,5	6	66	26	28
*	**69176**	M3DF.2.0560.0660.A0138.0260.0000.0280.00.S06A1A05.01	5,6	6	66	26	28
*	**69178**	M3DF.2.0570.0660.A0138.0260.0000.0280.00.S06A1A05.01	5,7	6	66	26	28
*	**69180**	M3DF.2.0580.0660.A0138.0260.0000.0280.00.S06A1A05.01	5,8	6	66	26	28
*	**69182**	M3DF.2.0590.0660.A0138.0260.0000.0280.00.S06A1A05.01	5,9	6	66	26	28
*	**69184**	M3DF.2.0600.0660.A0138.0260.0000.0280.00.S06A1A05.01	6	6	66	26	28
*	**69186**	M3DF.2.0610.0790.A0138.0320.0000.0340.00.S08A1A05.01	6,1	8	79	32	34
*	**69188**	M3DF.2.0620.0790.A0138.0320.0000.0340.00.S08A1A05.01	6,2	8	79	32	34
*	**69190**	M3DF.2.0630.0790.A0138.0320.0000.0340.00.S08A1A05.01	6,3	8	79	32	34
*	**69192**	M3DF.2.0640.0790.A0138.0320.0000.0340.00.S08A1A05.01	6,4	8	79	32	34
*	**69194**	M3DF.2.0650.0790.A0138.0320.0000.0340.00.S08A1A05.01	6,5	8	79	32	34
*	**69196**	M3DF.2.0660.0790.A0138.0320.0000.0340.00.S08A1A05.01	6,6	8	79	32	34
*	**69198**	M3DF.2.0670.0790.A0138.0320.0000.0340.00.S08A1A05.01	6,7	8	79	32	34
*	**69200**	M3DF.2.0680.0790.A0138.0320.0000.0340.00.S08A1A05.01	6,8	8	79	32	34

*Marked products are available from stock to deliver fast.





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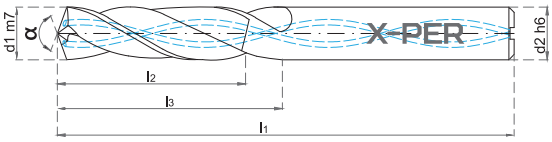
FORM HA DIN 6535



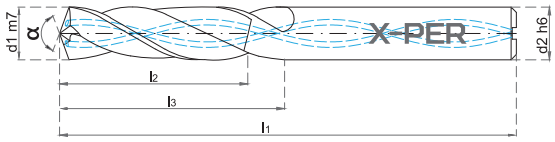
M3DF – 3D Drill With Coolant Holes

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
*	**69202**	M3DF.2.0690.0790.A0138.0320.0000.0340.00.S08A1A05.01	6,9	8	79	32	34
*	**69204**	M3DF.2.0700.0790.A0138.0320.0000.0340.00.S08A1A05.01	7	8	79	32	34
*	**69206**	M3DF.2.0710.0790.A0138.0380.0000.0410.00.S08A1A05.01	7,1	8	79	38	41
*	**69208**	M3DF.2.0720.0790.A0138.0380.0000.0410.00.S08A1A05.01	7,2	8	79	38	41
*	**69210**	M3DF.2.0730.0790.A0138.0380.0000.0410.00.S08A1A05.01	7,3	8	79	38	41
*	**69212**	M3DF.2.0740.0790.A0138.0380.0000.0410.00.S08A1A05.01	7,4	8	79	38	41
*	**69214**	M3DF.2.0750.0790.A0138.0380.0000.0410.00.S08A1A05.01	7,5	8	79	38	41
*	**69216**	M3DF.2.0760.0790.A0138.0380.0000.0410.00.S08A1A05.01	7,6	8	79	38	41
*	**69218**	M3DF.2.0770.0790.A0138.0380.0000.0410.00.S08A1A05.01	7,7	8	79	38	41
*	**69220**	M3DF.2.0780.0790.A0138.0380.0000.0410.00.S08A1A05.01	7,8	8	79	38	41
*	**69222**	M3DF.2.0790.0790.A0138.0380.0000.0410.00.S08A1A05.01	7,9	8	79	38	41
*	**69224**	M3DF.2.0800.0790.A0138.0380.0000.0410.00.S08A1A05.01	8	8	79	38	41
*	**69226**	M3DF.2.0804.0890.A0142.0380.0000.0420.00.S10A1A05.01	8,04	10	89	38	42
*	**69228**	M3DF.2.0810.0890.A0138.0430.0000.0470.00.S10A1A05.01	8,1	10	89	43	47
*	**69230**	M3DF.2.0820.0890.A0138.0430.0000.0470.00.S10A1A05.01	8,2	10	89	43	47
*	**69232**	M3DF.2.0830.0890.A0138.0430.0000.0470.00.S10A1A05.01	8,3	10	89	43	47
*	**69234**	M3DF.2.0840.0890.A0138.0430.0000.0470.00.S10A1A05.01	8,4	10	89	43	47
*	**69236**	M3DF.2.0850.0890.A0138.0430.0000.0470.00.S10A1A05.01	8,5	10	89	43	47
*	**69238**	M3DF.2.0860.0890.A0138.0430.0000.0470.00.S10A1A05.01	8,6	10	89	43	47
*	**69240**	M3DF.2.0870.0890.A0138.0430.0000.0470.00.S10A1A05.01	8,7	10	89	43	47
*	**69242**	M3DF.2.0880.0890.A0138.0430.0000.0470.00.S10A1A05.01	8,8	10	89	43	47
*	**69244**	M3DF.2.0890.0890.A0138.0430.0000.0470.00.S10A1A05.01	8,9	10	89	43	47
*	**69246**	M3DF.2.0900.0890.A0138.0430.0000.0470.00.S10A1A05.01	9	10	89	43	47
*	**69248**	M3DF.2.0910.0890.A0138.0430.0000.0470.00.S10A1A05.01	9,1	10	89	43	47
*	**69250**	M3DF.2.0920.0890.A0138.0430.0000.0470.00.S10A1A05.01	9,2	10	89	43	47
*	**69252**	M3DF.2.0925.0890.A0138.0430.0000.0470.00.S10A1A05.01	9,25	10	89	43	47
*	**69254**	M3DF.2.0930.0890.A0138.0430.0000.0470.00.S10A1A05.01	9,3	10	89	43	47
*	**69256**	M3DF.2.0940.0890.A0138.0430.0000.0470.00.S10A1A05.01	9,4	10	89	43	47
*	**69258**	M3DF.2.0950.0890.A0138.0430.0000.0470.00.S10A1A05.01	9,5	10	89	43	47
*	**69260**	M3DF.2.0960.0890.A0138.0430.0000.0470.00.S10A1A05.01	9,6	10	89	43	47
*	**69262**	M3DF.2.0970.0890.A0138.0430.0000.0470.00.S10A1A05.01	9,7	10	89	43	47
*	**69264**	M3DF.2.0980.0890.A0138.0430.0000.0470.00.S10A1A05.01	9,8	10	89	43	47
*	**69266**	M3DF.2.0990.0890.A0138.0430.0000.0470.00.S10A1A05.01	9,9	10	89	43	47
*	**69268**	M3DF.2.1000.0890.A0138.0430.0000.0470.00.S10A1A05.01	10	10	89	43	47
*	**69270**	M3DF.2.1010.1020.A0138.0510.0000.0550.00.S12A1A05.01	10,1	12	102	51	55
*	**69272**	M3DF.2.1020.1020.A0138.0510.0000.0550.00.S12A1A05.01	10,2	12	102	51	55
*	**69274**	M3DF.2.1030.1020.A0138.0510.0000.0550.00.S12A1A05.01	10,3	12	102	51	55
*	**69276**	M3DF.2.1040.1020.A0138.0510.0000.0550.00.S12A1A05.01	10,4	12	102	51	55
*	**69278**	M3DF.2.1050.1020.A0138.0510.0000.0550.00.S12A1A05.01	10,5	12	102	51	55
*	**69280**	M3DF.2.1060.1020.A0138.0510.0000.0550.00.S12A1A05.01	10,6	12	102	51	55
*	**69282**	M3DF.2.1070.1020.A0138.0510.0000.0550.00.S12A1A05.01	10,7	12	102	51	55
*	**69284**	M3DF.2.1080.1020.A0138.0510.0000.0550.00.S12A1A05.01	10,8	12	102	51	55
	69286	M3DF.2.1090.1020.A0138.0510.0000.0550.00.S12A1A05.01	10,9	12	102	51	55
*	**69288**	M3DF.2.1100.1020.A0138.0510.0000.0550.00.S12A1A05.01	11	12	102	51	55
*	**69290**	M3DF.2.1110.1020.A0138.0510.0000.0550.00.S12A1A05.01	11,1	12	102	51	55
*	**69292**	M3DF.2.1120.1020.A0138.0510.0000.0550.00.S12A1A05.01	11,2	12	102	51	55
*	**69294**	M3DF.2.1130.1020.A0138.0510.0000.0550.00.S12A1A05.01	11,3	12	102	51	55
*	**69296**	M3DF.2.1140.1020.A0138.0510.0000.0550.00.S12A1A05.01	11,4	12	102	51	55
*	**69298**	M3DF.2.1150.1020.A0138.0510.0000.0550.00.S12A1A05.01	11,5	12	102	51	55
*	**69300**	M3DF.2.1160.1020.A0138.0510.0000.0550.00.S12A1A05.01	11,6	12	102	51	55
*	**69302**	M3DF.2.1170.1020.A0138.0510.0000.0550.00.S12A1A05.01	11,7	12	102	51	55
*	**69304**	M3DF.2.1180.1020.A0138.0510.0000.0550.00.S12A1A05.01	11,8	12	102	51	55

α 138°

+TiAlN

FORM HA DIN 6535



M3DF – 3D Drill With Coolant Holes

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
*	**69306**	M3DF.2.1190.1020.A0138.0510.0000.0550.00.S12A1A05.01	11,9	12	102	51	55
*	**69308**	M3DF.2.1200.1020.A0138.0510.0000.0550.00.S12A1A05.01	12	12	102	51	55
*	**69310**	M3DF.2.1230.1070.A0138.0530.0000.0600.00.S14A1A05.01	12,3	14	107	53	60
*	**69312**	M3DF.2.1240.1070.A0138.0530.0000.0600.00.S14A1A05.01	12,4	14	107	53	60
*	**69314**	M3DF.2.1250.1070.A0138.0530.0000.0600.00.S14A1A05.01	12,5	14	107	53	60
*	**69316**	M3DF.2.1270.1070.A0138.0530.0000.0600.00.S14A1A05.01	12,7	14	107	53	60
*	**69318**	M3DF.2.1280.1070.A0138.0530.0000.0600.00.S14A1A05.01	12,8	14	107	53	60
*	**69320**	M3DF.2.1290.1070.A0138.0530.0000.0600.00.S14A1A05.01	12,9	14	107	53	60
*	**69322**	M3DF.2.1300.1070.A0138.0530.0000.0600.00.S14A1A05.01	13	14	107	53	60
*	**69324**	M3DF.2.1330.1070.A0138.0530.0000.0600.00.S14B1A05.01	13,3	14	107	53	60
*	**69326**	M3DF.2.1350.1070.A0138.0530.0000.0600.00.S14B1A05.01	13,5	14	107	53	60
*	**69328**	M3DF.2.1370.1070.A0138.0530.0000.0600.00.S14B1A05.01	13,7	14	107	53	60
*	**69330**	M3DF.2.1380.1070.A0138.0530.0000.0600.00.S14B1A05.01	13,8	14	107	53	60
*	**69332**	M3DF.2.1400.1070.A0140.0530.0000.0600.00.S14B1A05.01	14	14	107	53	60
*	**69334**	M3DF.2.1420.1150.A0138.0580.0000.0650.00.S16A1A05.01	14,2	16	115	58	65
*	**69336**	M3DF.2.1450.1150.A0138.0580.0000.0650.00.S16A1A05.01	14,5	16	115	58	65
*	**69338**	M3DF.2.1470.1150.A0138.0580.0000.0650.00.S16A1A05.01	14,7	16	115	58	65
*	**69340**	M3DF.2.1480.1150.A0140.0580.0000.0650.00.S16A1A05.01	14,8	16	115	58	65
*	**69342**	M3DF.2.1500.1150.A0140.0580.0000.0650.00.S16A1A05.01	15	16	115	58	65
*	**69344**	M3DF.2.1530.1150.A0140.0580.0000.0650.00.S16A1A05.01	15,3	16	115	58	65
*	**69346**	M3DF.2.1550.1150.A0140.0580.0000.0650.00.S16A1A05.01	15,5	16	115	58	65
*	**69348**	M3DF.2.1570.1150.A0140.0580.0000.0650.00.S16A1A05.01	15,7	16	115	58	65
*	**69350**	M3DF.2.1580.1150.A0140.0580.0000.0650.00.S16A1A05.01	15,8	16	115	58	65
*	**69352**	M3DF.2.1600.1150.A0140.0580.0000.0650.00.S16A1A05.01	16	16	115	58	65
*	**69354**	M3DF.2.1650.1230.A0140.0660.0000.0730.00.S18A1A05.01	16,5	18	123	66	73
*	**69356**	M3DF.2.1680.1230.A0140.0660.0000.0730.00.S18A1A05.01	16,8	18	123	66	73
*	**69358**	M3DF.2.1700.1230.A0140.0660.0000.0730.00.S18A1A05.01	17	18	123	66	73
*	**69360**	M3DF.2.1750.1230.A0140.0660.0000.0730.00.S18A1A05.01	17,5	18	123	66	73
*	**69362**	M3DF.2.1780.1230.A0140.0660.0000.0730.00.S18A1A05.01	17,8	18	123	66	73
*	**69364**	M3DF.2.1800.1230.A0140.0660.0000.0730.00.S18A1A05.01	18	18	123	66	73
*	**69366**	M3DF.2.1850.1310.A0140.0720.0000.0790.00.S20A1A05.01	18,5	20	131	72	79
*	**69368**	M3DF.2.1880.1310.A0140.0720.0000.0790.00.S20A1A05.01	18,8	20	131	72	79
*	**69370**	M3DF.2.1950.1310.A0140.0720.0000.0790.00.S20A1A05.01	19,5	20	131	72	79
*	**69372**	M3DF.2.1980.1310.A0140.0720.0000.0790.00.S20A1A05.01	19,8	20	131	72	79
*	**69374**	M3DF.2.2000.1310.A0140.0720.0000.0790.00.S20A1A05.01	20	20	131	72	79

Cutting Parameters Vc(m/min)		
Non-Alloy Steel	120-150	●
Steel	110-140	●
Tempered Steel	110-135	●
Cold-Work Tool Steel	80-110	◑
Hot-Work Tool Steel	80-110	◑
AISI 304 - 416 - 420	55-65	◑
AISI 316 - 440	55-65	◑
17-4 PH 15-5 PH	50-55	◑
Chrome-Cobalt Alloy	50-55	◑
Duplex F51	40-50	◑
Super Duplex F55	40-50	◑
Grey Cast Iron	100-150	●
Alloy Cast Iron	100-150	●
Precision Cast	90-120	●
Titanium	55-65	◑
Titanium Alloys	55-65	◑
HRSA	20-30	◑
≤ 54 HRc	60-80	◑
> 54 HRc	40-55	◑

Feed Per Revolution (mm/rev)	
Ø	
3	0,04
4	0,07
5	0,1
6	0,20
7	0,22
8	0,24
9	0,27
10	0,30
12	0,33
14	0,36
16	0,39
18	0,42
20	0,45

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

M5DF

5D Drill With Coolant Holes

General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech
High Performance
New Product

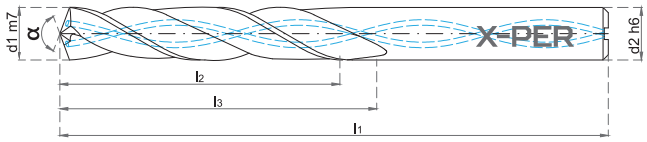
Thanks to it's brand-new geometry and coating up to **%50** longer tool life at least in comparison with equivalents

Stronger cutting edges by Exper edge preparation technology and up to **%40** better hole surface roughness in comparison with equivalents

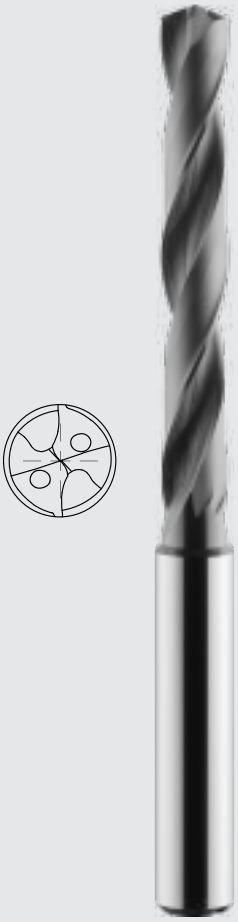
Optimal raw material selection for drilling operations to damp vibration and up to **%20** more precision hole diameter in comparison with equivalents

M5DF

5D Drill With Coolant Holes



Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
*	**70100**	M5DF.2.0238.0680.A0140.0140.0000.0270.00.S03P1B03.01	2,38	3	68	14	27
*	**70102**	M5DF.2.0300.0660.A0138.0270.0000.0280.00.S06C1A05.01	3	6	66	27	28
*	**70104**	M5DF.2.0310.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,1	6	66	27	28
*	**70106**	M5DF.2.0320.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,2	6	66	27	28
*	**70108**	M5DF.2.0325.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,25	6	66	27	28
*	**70110**	M5DF.2.0330.0720.A0140.0290.0000.0320.00.S06A2B03.01	3,3	6	72	29	32
*	**70112**	M5DF.2.0330.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,3	6	66	27	28
*	**70114**	M5DF.2.0340.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,4	6	66	27	28
*	**70116**	M5DF.2.0350.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,5	6	66	27	28
*	**70118**	M5DF.2.0360.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,6	6	66	27	28
*	**70120**	M5DF.2.0370.0660.A0138.0270.0000.0280.00.S06C1A05.01	3,7	6	66	27	28
*	**70122**	M5DF.2.0380.0740.A0138.0320.0000.0360.00.S06C1A05.01	3,8	6	74	32	36
*	**70124**	M5DF.2.0390.0740.A0138.0320.0000.0360.00.S06C1A05.01	3,9	6	74	32	36
*	**70126**	M5DF.2.0400.0740.A0138.0320.0000.0360.00.S06C1A05.01	4	6	74	32	36
*	**70128**	M5DF.2.0410.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,1	6	74	32	36
*	**70130**	M5DF.2.0420.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,2	6	74	32	36
*	**70132**	M5DF.2.0430.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,3	6	74	32	36
*	**70134**	M5DF.2.0440.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,4	6	74	32	36
*	**70136**	M5DF.2.0450.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,5	6	74	32	36
*	**70138**	M5DF.2.0460.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,6	6	74	32	36
*	**70140**	M5DF.2.0470.0740.A0138.0320.0000.0360.00.S06C1A05.01	4,7	6	74	32	36
*	**70142**	M5DF.2.0480.0820.A0138.0410.0000.0440.00.S06A1A05.01	4,8	6	82	41	44
*	**70144**	M5DF.2.0490.0820.A0138.0410.0000.0440.00.S06A1A05.01	4,9	6	82	41	44
*	**70146**	M5DF.2.0500.0820.A0138.0410.0000.0440.00.S06A1A05.01	5	6	82	41	44
*	**70148**	M5DF.2.0510.0820.A0140.0430.0000.0440.00.S06A1B02.01	5,1	6	82	43	44
*	**70150**	M5DF.2.0510.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,1	6	82	41	44
*	**70152**	M5DF.2.0520.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,2	6	82	41	44
*	**70154**	M5DF.2.0530.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,3	6	82	41	44
*	**70156**	M5DF.2.0540.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,4	6	82	41	44
*	**70158**	M5DF.2.0550.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,5	6	82	41	44
*	**70160**	M5DF.2.0560.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,6	6	82	41	44
*	**70162**	M5DF.2.0570.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,7	6	82	41	44
*	**70164**	M5DF.2.0580.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,8	6	82	41	44
*	**70166**	M5DF.2.0590.0820.A0138.0410.0000.0440.00.S06A1A05.01	5,9	6	82	41	44
*	**70168**	M5DF.2.0600.0820.A0138.0410.0000.0440.00.S06C2A05.01	6	6	82	41	44
*	**70170**	M5DF.2.0600.0820.A0138.0410.0000.0440.00.S06A1A05.01	6	6	82	41	44
*	**70172**	M5DF.2.0610.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,1	8	91	50	53
*	**70174**	M5DF.2.0620.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,2	8	91	50	53
*	**70176**	M5DF.2.0630.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,3	8	91	50	53
*	**70178**	M5DF.2.0640.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,4	8	91	50	53
*	**70180**	M5DF.2.0650.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,5	8	91	50	53
*	**70182**	M5DF.2.0660.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,6	8	91	50	53
*	**70184**	M5DF.2.0670.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,7	8	91	50	53
*	**70186**	M5DF.2.0680.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,8	8	91	50	53
*	**70188**	M5DF.2.0690.0910.A0138.0500.0000.0530.00.S08A1A05.01	6,9	8	91	50	53
*	**70190**	M5DF.2.0700.0910.A0138.0500.0000.0530.00.S08A1A05.01	7	8	91	50	53
*	**70192**	M5DF.2.0710.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,1	8	91	50	53
*	**70194**	M5DF.2.0720.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,2	8	91	50	53
*	**70196**	M5DF.2.0730.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,3	8	91	50	53
*	**70198**	M5DF.2.0740.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,4	8	91	50	53



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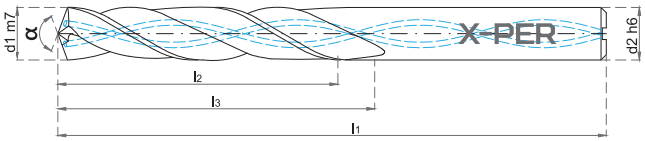

M5DF – 5D Drill With Coolant Holes

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
*	**70200**	M5DF.2.0750.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,5	8	91	50	53
*	**70202**	M5DF.2.0760.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,6	8	91	50	53
*	**70204**	M5DF.2.0770.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,7	8	91	50	53
*	**70206**	M5DF.2.0780.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,8	8	91	50	53
*	**70208**	M5DF.2.0790.0910.A0138.0500.0000.0530.00.S08A1A05.01	7,9	8	91	50	53
*	**70210**	M5DF.2.0800.0910.A0138.0500.0000.0530.00.S08A1A05.01	8	8	91	50	53
*	**70212**	M5DF.2.0810.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,1	10	103	57	61
*	**70214**	M5DF.2.0820.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,2	10	103	57	61
*	**70216**	M5DF.2.0830.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,3	10	103	57	61
*	**70218**	M5DF.2.0840.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,4	10	103	57	61
*	**70220**	M5DF.2.0850.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,5	10	103	57	61
*	**70222**	M5DF.2.0860.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,6	10	103	57	61
*	**70224**	M5DF.2.0870.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,7	10	103	57	61
*	**70226**	M5DF.2.0880.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,8	10	103	57	61
*	**70228**	M5DF.2.0890.1030.A0138.0570.0000.0610.00.S10A1A05.01	8,9	10	103	57	61
*	**70230**	M5DF.2.0900.1030.A0138.0570.0000.0610.00.S10A1A05.01	9	10	103	57	61
*	**70232**	M5DF.2.0910.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,1	10	103	57	61
*	**70234**	M5DF.2.0920.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,2	10	103	57	61
*	**70236**	M5DF.2.0930.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,3	10	103	57	61
*	**70238**	M5DF.2.0940.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,4	10	103	57	61
*	**70240**	M5DF.2.0950.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,5	10	103	57	61
*	**70242**	M5DF.2.0960.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,6	10	103	57	61
*	**70244**	M5DF.2.0970.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,7	10	103	57	61
*	**70246**	M5DF.2.0980.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,8	10	103	57	61
*	**70248**	M5DF.2.0990.1030.A0138.0570.0000.0610.00.S10A1A05.01	9,9	10	103	57	61
*	**70250**	M5DF.2.1000.1030.A0138.0570.0000.0610.00.S10A1A05.01	10	10	103	57	61
*	**70252**	M5DF.2.1000.1100.A0140.0650.0000.0720.00.S10A1A05.01	10	10	110	65	72
*	**70254**	M5DF.2.1010.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,1	12	118	67	71
*	**70256**	M5DF.2.1020.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,2	12	118	67	71
*	**70258**	M5DF.2.1030.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,3	12	118	67	71
*	**70260**	M5DF.2.1040.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,4	12	118	67	71
*	**70262**	M5DF.2.1050.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,5	12	118	67	71
*	**70264**	M5DF.2.1060.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,6	12	118	67	71
*	**70266**	M5DF.2.1070.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,7	12	118	67	71
*	**70268**	M5DF.2.1080.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,8	12	118	67	71
*	**70270**	M5DF.2.1090.1180.A0138.0670.0000.0710.00.S12A1A05.01	10,9	12	118	67	71
*	**70272**	M5DF.2.1100.1180.A0138.0670.0000.0710.00.S12A1A05.01	11	12	118	67	71
*	**70274**	M5DF.2.1110.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,1	12	118	67	71
*	**70276**	M5DF.2.1120.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,2	12	118	67	71
*	**70278**	M5DF.2.1130.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,3	12	118	67	71
*	**70280**	M5DF.2.1140.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,4	12	118	67	71
*	**70282**	M5DF.2.1150.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,5	12	118	67	71
*	**70284**	M5DF.2.1160.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,6	12	118	67	71
*	**70286**	M5DF.2.1170.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,7	12	118	67	71
*	**70288**	M5DF.2.1180.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,8	12	118	67	71
*	**70290**	M5DF.2.1190.1180.A0138.0670.0000.0710.00.S12A1A05.01	11,9	12	118	67	71
*	**70292**	M5DF.2.1200.1180.A0138.0670.0000.0710.00.S12A1A05.01	12	12	118	67	71
*	**70294**	M5DF.2.1230.1240.A0138.0700.0000.0770.00.S14A1A05.01	12,3	14	124	70	77
*	**70296**	M5DF.2.1250.1240.A0138.0700.0000.0770.00.S14A1A05.01	12,5	14	124	70	77
*	**70298**	M5DF.2.1270.1240.A0138.0700.0000.0770.00.S14A1A05.01	12,7	14	124	70	77
*	**70300**	M5DF.2.1280.1240.A0138.0700.0000.0770.00.S14A1A05.01	12,8	14	124	70	77

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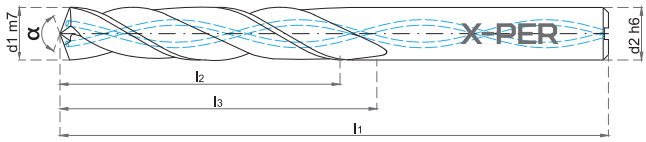
FORM HA DIN 6535



M5DF – 5D Drill With Coolant Holes

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
*	**70302**	M5DF.2.1290.1240.A0138.0700.0000.0770.00.S14A1A05.01	12,9	14	124	70	77
*	**70304**	M5DF.2.1300.1240.A0138.0700.0000.0770.00.S14A1A05.01	13	14	124	70	77
*	**70306**	M5DF.2.1330.1240.A0138.0700.0000.0770.00.S14A1A05.01	13,3	14	124	70	77
*	**70308**	M5DF.2.1350.1240.A0138.0700.0000.0770.00.S14A1A05.01	13,5	14	124	70	77
*	**70310**	M5DF.2.1370.1240.A0138.0700.0000.0770.00.S14A1A05.01	13,7	14	124	70	77
*	**70312**	M5DF.2.1380.1240.A0138.0700.0000.0770.00.S14A1A05.01	13,8	14	124	70	77
*	**70314**	M5DF.2.1400.1240.A0140.0700.0000.0770.00.S14A1A05.01	14	14	124	70	77
*	**70316**	M5DF.2.1420.1330.A0138.0740.0000.0830.00.S16A1A05.01	14,2	16	133	74	83
*	**70318**	M5DF.2.1450.1330.A0138.0740.0000.0830.00.S16A1A05.01	14,5	16	133	74	83
*	**70320**	M5DF.2.1470.1330.A0138.0740.0000.0830.00.S16A1A05.01	14,7	16	133	74	83
*	**70322**	M5DF.2.1480.1330.A0138.0740.0000.0830.00.S16A1A05.01	14,8	16	133	74	83
*	**70324**	M5DF.2.1500.1330.A0140.0740.0000.0830.00.S16A1A05.01	15	16	133	74	83
	70326	M5DF.2.1510.1330.A0140.0740.0000.0830.00.S16A1A05.01	15,1	16	133	74	83
	70328	M5DF.2.1530.1330.A0140.0740.0000.0830.00.S16A1A05.01	15,3	16	133	74	83
	70330	M5DF.2.1550.1330.A0140.0740.0000.0830.00.S16A1A05.01	15,5	16	133	74	83
	70332	M5DF.2.1570.1330.A0140.0740.0000.0830.00.S16A1A05.01	15,7	16	133	74	83
	70334	M5DF.2.1580.1330.A0140.0740.0000.0830.00.S16A1A05.01	15,8	16	133	74	83
	70336	M5DF.2.1600.1330.A0138.0740.0000.0830.00.S16A1A05.01	16	16	133	74	83
	70338	M5DF.2.1650.1430.A0140.0860.0000.0930.00.S18A1A05.01	16,5	18	143	86	93
	70340	M5DF.2.1660.1430.A0140.0860.0000.0930.00.S18A1A05.01	16,6	18	143	86	93
	70342	M5DF.2.1680.1430.A0140.0860.0000.0930.00.S18A1A05.01	16,8	18	143	86	93
*	**70344**	M5DF.2.1700.1430.A0140.0860.0000.0930.00.S18A1A05.01	17	18	143	86	93
	70346	M5DF.2.1730.1430.A0140.0860.0000.0930.00.S18A1A05.01	17,3	18	143	86	93
	70348	M5DF.2.1750.1430.A0140.0860.0000.0930.00.S18A1A05.01	17,5	18	143	86	93
	70350	M5DF.2.1780.1430.A0140.0860.0000.0930.00.S18A1A05.01	17,8	18	143	86	93
	70352	M5DF.2.1800.1430.A0140.0860.0000.0930.00.S18A1A05.01	18	18	143	86	93
	70354	M5DF.2.1850.1530.A0140.0920.0000.1010.00.S20A1A05.01	18,5	20	153	92	101
	70356	M5DF.2.1880.1530.A0140.0920.0000.1010.00.S20A1A05.01	18,8	20	153	92	101
	70358	M5DF.2.1900.1530.A0140.0920.0000.1010.00.S20A1A05.01	19	20	153	92	101
	70360	M5DF.2.1950.1530.A0140.0920.0000.1010.00.S20A1A05.01	19,5	20	153	92	101
	70362	M5DF.2.1980.1530.A0140.0920.0000.1010.00.S20A1A05.01	19,8	20	153	92	101
	70364	M5DF.2.2000.1530.A0140.0920.0000.1010.00.S20A1A05.01	20	20	153	92	101

Cutting Parameters Vc(m/min)		
Non-Alloy Steel	100-130	●
Steel	90-120	●
Tempered Steel	90-120	●
Cold-Work Tool Steel	60-90	◑
Hot-Work Tool Steel	60-90	◑
AISI 304 - 416 - 420	50-55	◑
AISI 316 - 440	50-55	◑
17-4 PH 15-5 PH	40-50	◑
Chrome-Cobalt Alloy	40-50	◑
Duplex F51	30-40	◑
Super Duplex F55	30-40	◑
Grey Cast Iron	170-200	●
Alloy Cast Iron	150-180	●
Precision Cast	110-140	●
Titanium	30-40	◑
Titanium Alloys	25-30	◑
≤ 54 HRc	60-80	◑
> 54 HRc	40-55	◑

Feed Per Revolution (mm/rev)	
Ø	
3	0,045
4	0,07
5	0,1
6	0,170
7	0,187
8	0,204
9	0,230
10	0,255
12	0,281
14	0,306
16	0,332
18	0,357
20	0,383

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

M8DF

8D Drill With Coolant Holes

General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech
High Performance
New Product

Thanks to it's brand-new geometry and coating up to **%50** longer tool life at least in comparison with equivalents

Stronger cutting edges by Exper edge preparation technology and up to **%40** better hole surface roughness in comparison with equivalents

Optimal raw material selection for drilling operations to damp vibration and up to **%20** more precision hole diameter in comparison with equivalents

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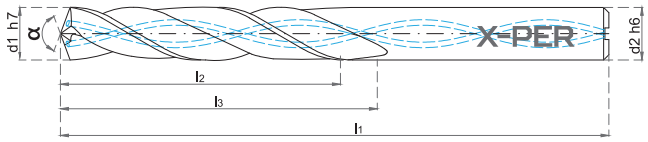
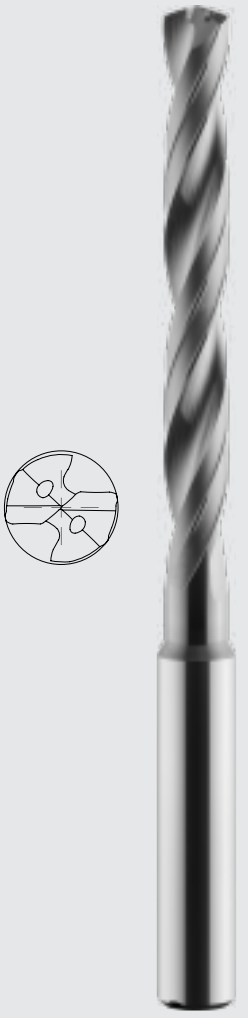


Stock	Order No	Code	d1h7	d2h6	l1	l2	l3
	73100	M8DF.2.0505.0950.A0138.0480.0000.0570.00.S06B2B02.01	5,05	6	95	48	57
	73102	M8DF.2.0520.0950.A0135.0530.0000.0590.00.S06B2A05.01	5,2	6	95	53	59
*	**73104**	M8DF.2.0600.0950.A0140.0530.0000.0570.00.S06B2A05.01	6	6	95	53	57
	73106	M8DF.2.0630.1140.A0140.0640.0000.0760.00.S08B2A05.01	6,3	8	114	64	76
	73108	M8DF.2.0650.1140.A0140.0640.0000.0760.00.S08B2B02.01	6,5	8	114	64	76
*	**73110**	M8DF.2.0680.1140.A0140.0640.0000.0760.00.S08B2A05.01	6,8	8	114	64	76
	73112	M8DF.2.0700.1140.A0135.0640.0000.0760.00.S08A2A05.01	7	8	114	64	76
	73114	M8DF.2.0750.1140.A0140.0640.0000.0760.00.S08B2A05.01	7,5	8	114	64	76
	73116	M8DF.2.0760.1140.A0140.0640.0000.0760.00.S08B2A05.01	7,6	8	114	64	76
	73118	M8DF.2.0780.1140.A0142.0640.0000.0760.00.S08B2C06.01	7,8	8	114	64	76
*	**73120**	M8DF.2.0800.1140.A0140.0640.0000.0760.00.S08B2L01.01	8	8	114	64	76
*	**73122**	M8DF.2.0850.1420.A0135.0800.0000.0950.00.S10B2A05.01	8,5	10	142	80	95
	73124	M8DF.2.0880.1420.A0140.0800.0000.0950.00.S10B2A05.01	8,8	10	142	80	95
	73126	M8DF.2.0900.1420.A0138.0800.0000.0950.00.S10B2B03.01	9	10	142	80	95
	73128	M8DF.2.0950.1420.A0140.0800.0000.0950.00.S10B2L01.01	9,5	10	142	80	95
	73130	M8DF.2.0980.1420.A0135.0800.0000.0950.00.S10B2A05.01	9,8	10	142	80	95
	73132	M8DF.2.0990.1420.A0140.0800.0000.0950.00.S10B2L01.01	9,9	10	142	80	95
*	**73134**	M8DF.2.1000.1420.A0135.0800.0000.0950.00.S10B2B03.01	10	10	142	80	95
*	**73136**	M8DF.2.1020.1620.A0138.0960.0000.1140.00.S12B2L01.01	10,2	12	162	96	114
*	**73138**	M8DF.2.1050.1620.A0135.0960.0000.1140.00.S12B2B03.01	10,5	12	162	96	114
	73140	M8DF.2.1100.1620.A0140.0960.0000.1140.00.S12B2B03.01	11	12	162	96	114
	73142	M8DF.2.1180.1620.A0135.0960.0000.1140.00.S12B2A05.01	11,8	12	162	96	114
*	**73144**	M8DF.2.1200.1620.A0135.0960.0000.1140.00.S12B2B03.01	12	12	162	96	114
*	**73146**	M8DF.2.1250.1780.A0140.1120.0000.1310.00.S14B2C06.01	12,5	14	178	112	131
	73148	M8DF.2.1270.1780.A0140.1120.0000.1310.00.S14B2C06.01	12,7	14	178	112	131
	73150	M8DF.2.1300.1780.A0140.1120.0000.1310.00.S14B2B03.01	13	14	178	112	131
	73152	M8DF.2.1400.1780.A0135.1120.0000.1310.00.S14B2A05.01	14	14	178	112	131
	73154	M8DF.2.1450.2030.A0135.1280.0000.1520.00.S16B2A05.01	14,5	16	203	128	152
	73156	M8DF.2.1500.2030.A0135.1280.0000.1520.00.S16B2A05.01	15	16	203	128	152
	73158	M8DF.2.1550.2030.A0135.1280.0000.1520.00.S16B2A05.01	15,5	16	203	128	152
	73160	M8DF.2.1580.2030.A0135.1280.0000.1520.00.S16B2A05.01	15,8	16	203	128	152
	73162	M8DF.2.1600.2030.A0135.1280.0000.1520.00.S16B2A05.01	16	16	203	128	152
	73164	M8DF.2.1650.2220.A0135.1440.0000.1710.00.S18B2A05.01	16,5	18	222	144	171
	73166	M8DF.2.1700.2220.A0140.1440.0000.1710.00.S18B2C06.01	17	18	222	144	171
	73168	M8DF.2.1750.2220.A0140.1440.0000.1710.00.S18B2C06.01	17,5	18	222	144	171
	73170	M8DF.2.1800.2220.A0140.1440.0000.1710.00.S18B2C06.01	18	18	222	144	171
	73172	M8DF.2.1850.2430.A0140.1600.0000.1900.00.S20B2C06.01	18,5	20	243	160	190
	73174	M8DF.2.1900.2430.A0140.1600.0000.1900.00.S20B2C06.01	19	20	243	160	190
	73176	M8DF.2.1950.2430.A0140.1600.0000.1900.00.S20B2C06.01	19,5	20	243	160	190
	73178	M8DF.2.2000.2430.A0140.1600.0000.1900.00.S20B2C06.01	20	20	243	160	190

Cutting Parameters Vc(m/min)		
Non-Alloy Steel	80-105	●
Steel	70-100	●
Tempered Steel	70-95	●
Cold-Work Tool Steel	50-80	●
Hot-Work Tool Steel	50-80	●
AISI 304 - 416 - 420	50-55	◑
AISI 316 - 440	50-55	◑
17-4 PH 15-5 PH	40-50	◑
Chrome-Cobalt Alloy	40-50	◑
Duplex F51	30-40	◑
Super Duplex F55	30-40	◑
Grey Cast Iron	140-170	●
Alloy Cast Iron	110-140	●
Precision Cast	80-110	●
Titanium	50-70	◑
Titanium Alloys	40-60	◑
≤ 54 HRc	60-80	◑
> 54 HRc	40-55	◑

Feed Per Revolution (mm/rev)	
Ø	
3	0,112
4	0,119
5	0,126
6	0,140
7	0,154
8	0,168
9	0,189
10	0,210
12	0,231
14	0,252
16	0,273
18	0,294
20	0,315



α 135° | +TiAlN

FORM HA DIN 6535

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

M12DF

12D Drill With Coolant Holes

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D-Tech High Performance New Product

'Drills 12XD and above' require pilot hole. You may have the pilot hole by K3DF series. In this catalogue, '3XD' drills have m7 tolerance lines up with '12XD drills and above' have h7 tolerance.

Please do not run in recommended cutting speed and feed rates and never release the internal coolant before the diameter of deep hole drill gets in the pilot hole completely(!) The recommended cutting parameters have to be used after the pilot hole centers the deep hole drill and then drilling operation has to be started when high pressure is on.

Cutting parameters highly depend on external factors such as stabilisation of tools and holders, workpiece and machine type.

The given datas are only feasible cutting parameters should be considered again for each application.

Thanks to it's brand-new geometry and coating up to **%50** longer tool life at least in comparison with equivalents

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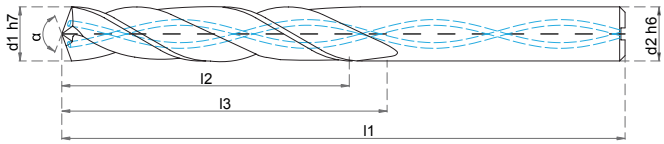
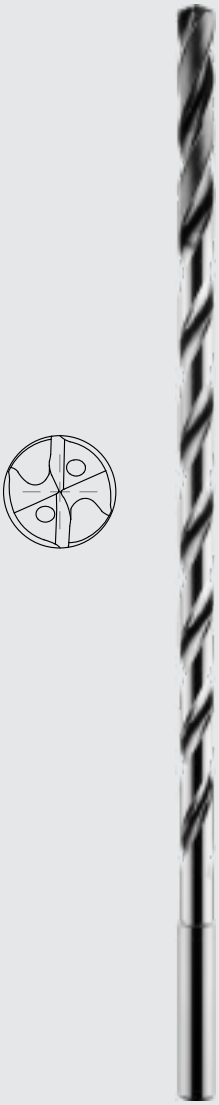
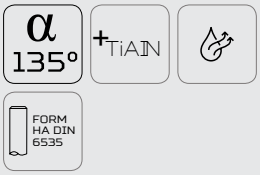


Stock	Order No	Code	d1h7	d2h6	l1	l2	l3
	74100	M12DF.2.0300.0920.A0135.0480.0000.0540.00.S06A2B03.01	3	6	92	48	54
	74102	M12DF.2.0310.0920.A0135.0480.0000.0540.00.S06A2B03.01	3,1	6	92	48	54
	74104	M12DF.2.0320.0920.A0135.0480.0000.0540.00.S06A2B03.01	3,2	6	92	48	54
	74106	M12DF.2.0330.0920.A0135.0480.0000.0540.00.S06A2B03.01	3,3	6	92	48	54
	74108	M12DF.2.0340.0920.A0135.0480.0000.0540.00.S06A2B03.01	3,4	6	92	48	54
	74110	M12DF.2.0350.0920.A0135.0480.0000.0540.00.S06A2B03.01	3,5	6	92	48	54
	74112	M12DF.2.0360.0920.A0135.0480.0000.0540.00.S06A2B03.01	3,6	6	92	48	54
	74114	M12DF.2.0370.0920.A0135.0480.0000.0540.00.S06A2B03.01	3,7	6	92	48	54
	74116	M12DF.2.0380.1020.A0135.0580.0000.0640.00.S06B2A05.01	3,8	6	102	58	64
	74118	M12DF.2.0390.1020.A0135.0580.0000.0640.00.S06B2A05.01	3,9	6	102	58	64
	74120	M12DF.2.0400.1020.A0140.0580.0000.0640.00.S06C2B02.01	4	6	102	58	64
	74122	M12DF.2.0410.1020.A0140.0580.0000.0640.00.S06C2B02.01	4,1	6	102	58	64
	74124	M12DF.2.0420.1020.A0140.0580.0000.0640.00.S06C2B02.01	4,2	6	102	58	64
	74126	M12DF.2.0430.1020.A0140.0580.0000.0640.00.S06C2B02.01	4,3	6	102	58	64
	74128	M12DF.2.0440.1020.A0140.0580.0000.0640.00.S06C2B02.01	4,4	6	102	58	64
	74130	M12DF.2.0450.1020.A0140.0580.0000.0640.00.S06C2B02.01	4,5	6	102	58	64
	74132	M12DF.2.0460.1020.A0140.0580.0000.0640.00.S06C2B02.01	4,6	6	102	58	64
	74134	M12DF.2.0470.1020.A0140.0580.0000.0640.00.S06C2B02.01	4,7	6	102	58	64
	74136	M12DF.2.0480.1160.A0135.0700.0000.0780.00.S06B2B03.01	4,8	6	116	70	78
	74138	M12DF.2.0490.1160.A0135.0700.0000.0780.00.S06B2B03.01	4,9	6	116	70	78
	74140	M12DF.2.0500.1160.A0135.0700.0000.0780.00.S06C2B02.01	5	6	116	70	78
	74142	M12DF.2.0530.1260.A0140.0750.0000.0880.00.S06C2B02.01	5,3	6	126	75	88
	74144	M12DF.2.0550.1160.A0135.0700.0000.0780.00.S06B2B03.01	5,5	6	116	70	78
	74146	M12DF.2.0560.1220.A0140.0840.0000.0750.00.S06C2B02.01	5,6	6	122	84	75
	74148	M12DF.2.0580.1160.A0135.0700.0000.0780.00.S06B2B03.01	5,8	6	116	70	78
	74150	M12DF.2.0600.1160.A0135.0700.0000.0780.00.S06C2B02.01	6	6	116	70	78
	74152	M12DF.2.0630.1460.A0135.0940.0000.1080.00.S08B2B02.01	6,3	8	146	94	108
	74154	M12DF.2.0650.1460.A0135.0940.0000.1080.00.S08B2B02.01	6,5	8	146	94	108
	74156	M12DF.2.0660.1460.A0135.0940.0000.1080.00.S08B2B02.01	6,6	8	146	94	108
	74158	M12DF.2.0680.1460.A0135.0940.0000.1080.00.S08B2B02.01	6,8	8	146	94	108
	74160	M12DF.2.0700.1460.A0135.0940.0000.1080.00.S08B2B02.01	7	8	146	94	108
	74162	M12DF.2.0750.1460.A0135.0940.0000.1080.00.S08B2B02.01	7,5	8	146	94	108
	74164	M12DF.2.0780.1460.A0135.0940.0000.1080.00.S08B2B02.01	7,8	8	146	94	108
	74166	M12DF.2.0800.1460.A0135.0940.0000.1080.00.S08B2B02.01	8	8	146	94	108
	74168	M12DF.2.0820.1620.A0135.1100.0000.1200.00.S10C2B02.01	8,2	10	162	110	120
	74170	M12DF.2.0850.1620.A0135.1100.0000.1200.00.S10C2B02.01	8,5	10	162	110	120
	74172	M12DF.2.0900.1620.A0135.1100.0000.1200.00.S10C2B02.01	9	10	162	110	120
	74174	M12DF.2.0950.1620.A0135.1100.0000.1200.00.S10B2B03.01	9,5	10	162	110	120
	74176	M12DF.2.0980.1620.A0135.1100.0000.1200.00.S10B2B03.01	9,8	10	162	110	120
	74178	M12DF.2.1000.1620.A0135.1100.0000.1200.00.S10B2B03.01	10	10	162	110	120
	74180	M12DF.2.1050.2040.A0135.1420.0000.1560.00.S12B2B03.01	10,5	12	204	142	156
	74182	M12DF.2.1100.2040.A0135.1420.0000.1560.00.S12B2B03.01	11	12	204	142	156
	74184	M12DF.2.1150.2040.A0135.1420.0000.1560.00.S12B2B03.01	11,5	12	204	142	156
	74186	M12DF.2.1200.2040.A0135.1420.0000.1560.00.S12B2B03.01	12	12	204	142	156
	74188	M12DF.2.1300.2300.A0135.1660.0000.1820.00.S14B2B03.01	13	14	230	166	182
	74190	M12DF.2.1400.2300.A0135.1660.0000.1820.00.S14B2B03.01	14	14	230	166	182
	74192	M12DF.2.1500.2600.A0135.1920.0000.2080.00.S16B2B02.01	15	16	260	192	208
	74194	M12DF.2.1600.2600.A0135.1920.0000.2080.00.S16B2B02.01	16	16	260	192	208
	74196	M12DF.2.1800.2850.A0135.2160.0000.2340.00.S16B2B02.01	18	18	285	216	234

Cutting Parameters Vc(m/min)		
Non-Alloy Steel	100	●
Steel	80	●
Tempered Steel	70	●
Cold-Work Tool Steel	40	◑
Hot-Work Tool Steel	40	◑
AISI 304 - 416 - 420	35	◑
AISI 316 - 440	35	◑
17-4 PH 15-5 PH	30	◑
Chrome-Cobalt Alloy	30	◑
Duplex F51	25	◑
Super Duplex F55	25	◑
Grey Cast Iron	70	●
Alloy Cast Iron	60	●
Precision Cast	50	●

Feed Per Revolution (mm/rev)	
Ø	
3-5	0,05-0,19
5-8	0,08-0,25
8-12	0,1-0,32
12-16	0,12-0,38
16-18	0,13-0,42





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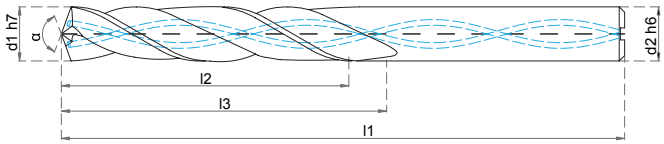


Stock	Order No	Code	d1h7	d2h6	l1	l2	l3
	75100	M16DF.2.0200.0840.A0135.0390.0000.0420.00.S04B2B03.01	2	4	84	39	42
	75102	M16DF.2.0220.0840.A0135.0390.0000.0420.00.S04B2B03.01	2,2	4	84	39	42
	75104	M16DF.2.0230.0840.A0135.0390.0000.0420.00.S04B2B03.01	2,3	4	84	39	42
	75106	M16DF.2.0240.0960.A0135.0500.0000.0540.00.S04B2B03.01	2,4	4	96	50	54
	75108	M16DF.2.0250.0960.A0135.0500.0000.0540.00.S04B2B03.01	2,5	4	96	50	54
	75110	M16DF.2.0270.0960.A0135.0500.0000.0540.00.S04B2B03.01	2,7	4	96	50	54
	75112	M16DF.2.0280.0960.A0135.0500.0000.0540.00.S04B2B03.01	2,8	4	96	50	54
	75114	M16DF.2.0300.1000.A0135.0550.0000.0600.00.S06B2B03.01	3	6	100	55	60
	75116	M16DF.2.0320.1000.A0135.0550.0000.0600.00.S06B2B03.01	3,2	6	100	55	60
	75118	M16DF.2.0330.1000.A0135.0550.0000.0600.00.S06B2B03.01	3,3	6	100	55	60
	75120	M16DF.2.0350.1000.A0135.0550.0000.0600.00.S06B2B03.01	3,5	6	100	55	60
	75122	M16DF.2.0380.1150.A0135.0690.0000.0750.00.S06B2B03.01	3,8	6	115	69	75
	75124	M16DF.2.0400.1150.A0135.0690.0000.0750.00.S06B2B03.01	4	6	115	69	75
	75126	M16DF.2.0420.1150.A0135.0690.0000.0750.00.S06B2B03.01	4,2	6	115	69	75
	75128	M16DF.2.0450.1300.A0135.0830.0000.0900.00.S06B2B03.01	4,5	6	130	83	90
	75130	M16DF.2.0480.1300.A0135.0830.0000.0900.00.S06B2B03.01	4,8	6	130	83	90
	75132	M16DF.2.0500.1300.A0135.0830.0000.0900.00.S06C2B02.01	5	6	130	83	90
	75134	M16DF.2.0550.1500.A0135.0990.0000.1080.00.S06C2B02.01	5,5	6	150	99	108
	75136	M16DF.2.0580.1500.A0135.0990.0000.1080.00.S06C2B02.01	5,8	6	150	99	108
	75138	M16DF.2.0600.1500.A0135.0990.0000.1080.00.S06C2B02.01	6	6	150	99	108
	75140	M16DF.2.0650.1650.A0135.1150.0000.1250.00.S08B2B02.01	6,5	8	165	115	125
	75142	M16DF.2.0680.1650.A0135.1150.0000.1250.00.S08B2B02.01	6,8	8	165	115	125
	75144	M16DF.2.0700.1650.A0135.1150.0000.1250.00.S08B2B02.01	7	8	165	115	125
	75146	M16DF.2.0750.1800.A0135.1280.0000.1400.00.S08B2B02.01	7,5	8	180	128	140
	75148	M16DF.2.0780.1800.A0135.1280.0000.1400.00.S08B2B02.01	7,8	8	180	128	140
	75150	M16DF.2.0800.1800.A0135.1280.0000.1400.00.S08B2B02.01	8	8	180	128	140
	75152	M16DF.2.0850.2050.A0135.1470.0000.1600.00.S10B2B02.01	8,5	10	205	147	160
	75154	M16DF.2.0880.2050.A0135.1470.0000.1600.00.S10B2B02.01	8,8	10	205	147	160
	75156	M16DF.2.0900.2050.A0135.1470.0000.1600.00.S10B2B02.01	9	10	205	147	160
	75158	M16DF.2.0980.2250.A0135.1650.0000.1800.00.S10B2B02.01	9,8	10	225	165	180
	75160	M16DF.2.1000.2250.A0135.1650.0000.1800.00.S10B2B02.01	10	10	225	165	180
	75162	M16DF.2.1020.2400.A0135.1740.0000.1900.00.S12B2B02.01	10,2	12	240	174	190
	75164	M16DF.2.1080.2400.A0135.1740.0000.1900.00.S12B2B02.01	10,8	12	240	174	190
	75166	M16DF.2.1180.2650.A0135.1970.0000.2150.00.S12B2B02.01	11,8	12	265	197	215
	75168	M16DF.2.1200.2650.A0135.1970.0000.2150.00.S12B2B02.01	12	12	265	197	215

Cutting Parameters Vc(m/min)		
Non-Alloy Steel	100	●
Steel	100	●
Tempered Steel	90	●
Cold-Work Tool Steel	75	◑
Hot-Work Tool Steel	55	◑
AISI 304 - 416 - 420	55	◑
AISI 316 - 440	50	◑
17-4 PH 15-5 PH	50	◑
Chrome-Cobalt Alloy	40	◑
Duplex F51	40	◑
Grey Cast Iron	105	●
Alloy Cast Iron	100	●
Precision Cast	100	●

Feed Per Revolution (mm/rev)	
Ø	
2-3	0,05-0,15
3-5	0,08-0,23
5-8	0,08-0,25
8-12	0,1-0,32

α 135° | +TiAlN | FORM HA DIN 6535

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

M20DF

20D Drill With Coolant Holes

General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech High Performance New Product

'Drills 12XD and above' require pilot hole. You may have the pilot hole by K3DF series. In this catalogue, '3XD' drills have m7 tolerance lines up with '12XD drills and above' have h7 tolerance.

Please do not run in recommended cutting speed and feed rates and never release the internal coolant before the diameter of deep hole drill gets in the pilot hole completely(!) The recommended cutting parameters have to be used after the pilot hole centers the deep hole drill and then drilling operation has to be started when high pressure is on.

Cutting parameters highly depend on external factors such as stabilisation of tools and holders, workpiece and machine type.

The given datas are only feasible cutting parameters should be considered again for each application.

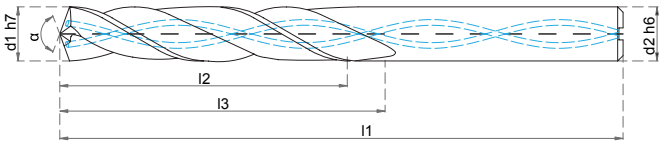
Thanks to it's brand-new geometry and coating up to **%50** longer tool life at least in comparison with equivalents

Stronger cutting edges by Exper edge preparation technology and up to **%40** better hole surface roughness in comparison with equivalents

Optimal raw material selection for drilling operations to damp vibration and up to **%20** more precision hole diameter in comparison with equivalents

M20DF

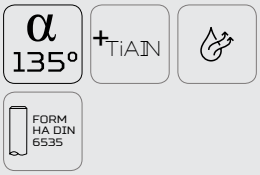
20D Drill With Coolant Holes



Stock	Order No	Code	d1h7	d2h6	l1	l2	l3
	76100	M20DF.2.0200.0920.A0135.0470.0000.0500.00.S04B2B03.01	2	4	92	47	50
	76102	M20DF.2.0220.0920.A0135.0470.0000.0500.00.S04B2B03.01	2,2	4	92	47	50
	76104	M20DF.2.0230.0920.A0135.0470.0000.0500.00.S04B2B03.01	2,3	4	92	47	50
	76106	M20DF.2.0240.1120.A0135.0660.0000.0700.00.S04B2B03.01	2,4	4	112	66	70
	76108	M20DF.2.0250.1120.A0135.0660.0000.0700.00.S04B2B03.01	2,5	4	112	66	70
	76110	M20DF.2.0270.1120.A0135.0660.0000.0700.00.S04B2B03.01	2,7	4	112	66	70
	76112	M20DF.2.0280.1120.A0135.0660.0000.0700.00.S04B2B03.01	2,8	4	112	66	70
	76114	M20DF.2.0300.1200.A0135.0750.0000.0800.00.S06B2B03.01	3	6	120	75	80
	76116	M20DF.2.0320.1200.A0135.0750.0000.0800.00.S06B2B03.01	3,2	6	120	75	80
	76118	M20DF.2.0330.1200.A0135.0750.0000.0800.00.S06B2B03.01	3,3	6	120	75	80
	76120	M20DF.2.0350.1200.A0135.0750.0000.0800.00.S06B2B03.01	3,5	6	120	75	80
	76122	M20DF.2.0380.1300.A0135.0840.0000.0900.00.S06B2B03.01	3,8	6	130	84	90
	76124	M20DF.2.0400.1300.A0135.0840.0000.0900.00.S06B2B03.01	4	6	130	84	90
	76126	M20DF.2.0420.1600.A0135.1030.0000.1100.00.S06B2B03.01	4,2	6	160	103	110
	76128	M20DF.2.0450.1600.A0135.1030.0000.1100.00.S06B2B03.01	4,5	6	160	103	110
	76130	M20DF.2.0480.1600.A0135.1130.0000.1200.00.S06B2B03.01	4,8	6	160	113	120
	76132	M20DF.2.0500.1600.A0135.1130.0000.1200.00.S06B2B03.01	5	6	160	113	120
	76134	M20DF.2.0550.1850.A0135.1310.0000.1400.00.S06B2B03.01	5,5	6	185	131	140
	76136	M20DF.2.0580.1850.A0135.1310.0000.1400.00.S06B2B03.01	5,8	6	185	131	140
	76138	M20DF.2.0600.1850.A0135.1310.0000.1400.00.S06B2B03.01	6	6	185	131	140
	76140	M20DF.2.0650.2100.A0135.1500.0000.1600.00.S08B2B03.01	6,5	8	210	150	160
	76142	M20DF.2.0680.2100.A0135.1500.0000.1600.00.S08B2B03.01	6,8	8	210	150	160
	76144	M20DF.2.0700.2100.A0135.1500.0000.1600.00.S08B2B03.01	7	8	210	150	160
	76146	M20DF.2.0750.2300.A0135.1680.0000.1800.00.S08B2B03.01	7,5	8	230	168	180
	76148	M20DF.2.0780.2300.A0135.1680.0000.1800.00.S08B2B03.01	7,8	8	230	168	180
	76150	M20DF.2.0800.2300.A0135.1680.0000.1800.00.S08B2B03.01	8	8	230	168	180
	76152	M20DF.2.0850.2600.A0135.1820.0000.1950.00.S10B2B03.01	8,5	10	260	182	195
	76154	M20DF.2.0880.2900.A0135.2160.0000.2300.00.S10B2B03.01	8,8	10	290	216	230
	76156	M20DF.2.0900.2900.A0135.2160.0000.2300.00.S10B2B03.01	9	10	290	216	230
	76158	M20DF.2.0980.2900.A0135.2160.0000.2300.00.S10B2B03.01	9,8	10	290	216	230
	76160	M20DF.2.1000.2900.A0135.2160.0000.2300.00.S10B2B03.01	10	10	290	216	230
	76162	M20DF.2.1020.3150.A0135.2510.0000.2680.00.S12B2B03.01	10,2	12	315	251	268
	76164	M20DF.2.1080.3150.A0135.2510.0000.2680.00.S12B2B03.01	10,8	12	315	251	268
	76166	M20DF.2.1180.3150.A0135.2510.0000.2680.00.S12B2B03.01	11,8	12	315	251	268
	76168	M20DF.2.1200.3150.A0135.2510.0000.2680.00.S12B2B03.01	12	12	315	251	268

Cutting Parameters Vc(m/min)		
Unalloyed Steel	95	●
Steel	95	●
Tempered Steel	85	●
Hot Work Tool Steel	70	◑
AISI 304 - 416 - 420	50	◑
AISI 316 - 440	50	◑
17-4 PH 15-5 PH	45	◑
Chrome-Cobalt Alloy	45	◑
Duplex F51	35	◑
Super Duplex F55	35	◑
Gray Cast	100	●
Alloyed Cast	95	●
Precision Cast	95	●

Feed Per Revolution (mm/rev)	
Ø	
2-3	0,05-0,15
3-5	0,08-0,23
5-8	0,12-0,335
8-12	0,15-0,425



●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

M25DF

25D Drill With Coolant Holes

General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech High Performance New Product

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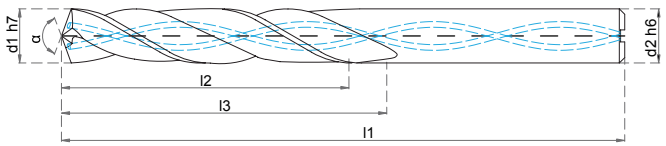
Optimal raw material selection for drilling operations to damp vibration and up to **%20** more precision hole diameter in comparison with equivalents

M25DF

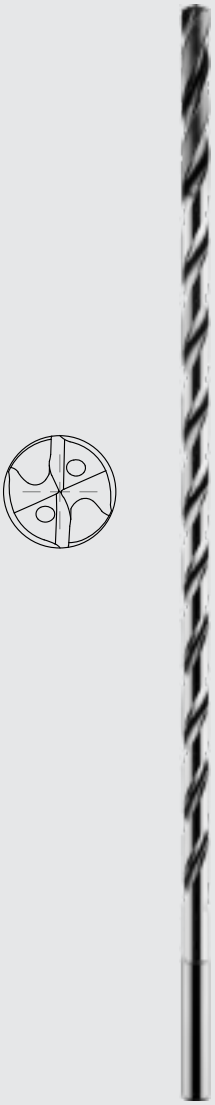
25D Drill With Coolant Holes



Stock	Order No	Code	d1h7	d2h6	l1	l2	l3
	77100	M25DF.2.0200.1040.A0135.0570.0000.0600.00.S04C1B03.01	2	4	104	57	60
	77102	M25DF.2.0220.1040.A0135.0570.0000.0600.00.S04C1B03.01	2,2	4	104	57	60
	77104	M25DF.2.0230.1040.A0135.0570.0000.0600.00.S04C1B03.01	2,3	4	104	57	60
	77106	M25DF.2.0240.1250.A0135.0760.0000.0800.00.S04M1B03.01	2,4	4	125	76	80
	77108	M25DF.2.0250.1250.A0135.0760.0000.0800.00.S04M1B03.01	2,5	4	125	76	80
	77110	M25DF.2.0270.1250.A0135.0760.0000.0800.00.S04M1B03.01	2,7	4	125	76	80
	77112	M25DF.2.0280.1250.A0135.0760.0000.0800.00.S04M1B03.01	2,8	4	125	76	80
	77114	M25DF.2.0300.1350.A0135.0930.0000.0980.00.S06M1B03.01	3	6	135	93	98
	77116	M25DF.2.0320.1350.A0135.0930.0000.0980.00.S06M1B03.01	3,2	6	135	93	98
	77118	M25DF.2.0330.1500.A0135.1050.0000.1100.00.S06M1B03.01	3,3	6	150	105	110
	77120	M25DF.2.0350.1500.A0135.1050.0000.1100.00.S06M1B03.01	3,5	6	150	105	110
	77122	M25DF.2.0380.1600.A0135.1140.0000.1200.00.S06M1B03.01	3,8	6	160	114	120
	77124	M25DF.2.0400.1600.A0135.1140.0000.1200.00.S06M1B03.01	4	6	160	114	120
	77126	M25DF.2.0420.1600.A0135.1140.0000.1200.00.S06M1B03.01	4,2	6	160	114	120
	77128	M25DF.2.0450.1800.A0135.1280.0000.1350.00.S06C2B02.01	4,5	6	180	128	135
	77130	M25DF.2.0480.1800.A0135.1280.0000.1350.00.S06C2B02.01	4,8	6	180	128	135
	77132	M25DF.2.0500.1800.A0135.1280.0000.1350.00.S06C2B02.01	5	6	180	128	135
	77134	M25DF.2.0550.2050.A0135.1590.0000.1680.00.S06C2B02.01	5,5	6	205	159	168
	77136	M25DF.2.0580.2050.A0135.1590.0000.1680.00.S06C2B02.01	5,8	6	205	159	168
	77138	M25DF.2.0600.2050.A0135.1590.0000.1680.00.S06C2B02.01	6	6	205	159	168
	77140	M25DF.2.0650.2400.A0135.1900.0000.2000.00.S08C2B02.01	6,5	8	240	190	200
	77142	M25DF.2.0680.2400.A0135.1900.0000.2000.00.S08C2B02.01	6,8	8	240	190	200
	77144	M25DF.2.0700.2400.A0135.1900.0000.2000.00.S08C2B02.01	7	8	240	190	200
	77146	M25DF.2.0750.2600.A0135.2080.0000.2200.00.S08C2B02.01	7,5	8	260	208	220
	77148	M25DF.2.0780.2600.A0135.2080.0000.2200.00.S08C2B02.01	7,8	8	260	208	220
	77150	M25DF.2.0800.2600.A0135.2080.0000.2200.00.S08C2B02.01	8	8	260	208	220
	77152	M25DF.2.0850.2850.A0135.2270.0000.2400.00.S10C2B02.01	8,5	10	285	227	240
	77154	M25DF.2.0880.3100.A0135.2540.0000.2680.00.S10C2B02.01	8,8	10	310	254	268
	77156	M25DF.2.0900.3100.A0135.2540.0000.2680.00.S10C2B02.01	9	10	310	254	268
	77158	M25DF.2.0980.3100.A0135.2540.0000.2680.00.S10C2B02.01	9,8	10	310	254	268
	77160	M25DF.2.1000.3100.A0135.2540.0000.2680.00.S10C2B02.01	10	10	310	254	268
	77162	M25DF.2.1020.3750.A0135.3080.0000.3250.00.S12C2B02.01	10,2	12	375	308	325
	77164	M25DF.2.1080.3750.A0135.3080.0000.3250.00.S12C2B02.01	10,8	12	375	308	325
	77166	M25DF.2.1180.3750.A0135.3080.0000.3250.00.S12C2B02.01	11,8	12	375	308	325
	77168	M25DF.2.1200.3750.A0135.3080.0000.3250.00.S12C2B02.01	12	12	375	308	325

Cutting Parameters Vc(m/min)		
Non-Alloy Steel	85	●
Steel	85	●
Tempered Steel	75	●
Cold-Work Tool Steel	65	◑
Hot-Work Tool Steel	45	◑
AISI 304 - 416 - 420	45	◑
AISI 316 - 440	40	◑
17-4 PH 15-5 PH	40	◑
Chrome-Cobalt Alloy	30	◑
Duplex F51	30	◑
Grey Cast Iron	90	●
Alloy Cast Iron	85	●
Precision Cast	85	●

Feed Per Revolution (mm/rev)	
Ø	
2-3	0,05-0,15
3-5	0,08-0,23
5-8	0,12-0,335
8-12	0,15-0,425



α 135° | +TiAlN | FORM HA DIN 6535

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

KY3DF

Double Margin 3D Drill

General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech High Performance

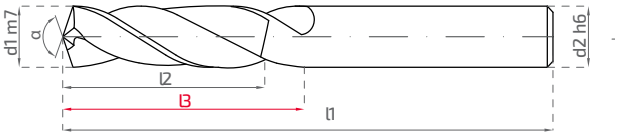
Thanks to it's brand-new geometry and coating up to **%50** longer tool life at least in comparison with equivalents

Stronger cutting edges by Exper edge preparation technology and up to **%40** better hole surface roughness in comparison with equivalents

Optimal raw material and coolant pitch selection without run-out only for drilling operations to damp vibration and up to **%30** more precision hole diameter in comparison with equivalents with it's double margin advantage

KY3DF

Double Margin 3D Drill



Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	51100	KY3DF.2.0490.0660.A0140.0200.0490.0300.00.S06B1B02.01	4,9	6	66	20	30
	51102	KY3DF.2.0800.0790.A0140.0380.0800.0410.00.S08B1B02.01	8	8	79	38	41
	51104	KY3DF.2.1000.0890.A0140.0430.1000.0470.00.S10B1B02.01	10	10	89	43	47
	51106	KY3DF.2.1200.1020.A0140.0510.1200.0550.00.S12B1B02.01	12	12	102	51	55
	51108	KY3DF.2.1400.1070.A0140.0530.1400.0600.00.S14B1B02.01	14	14	107	53	60

Cutting Parameters Vc(m/min)		
Unalloyed Steel	80-120	●
Steel	70-110	●
Tempered Steel	65-100	●
Cold Work Tool Steel	55-70	◑
Hot Work Tool Steel	55-70	◑
AISI 304 - 416 - 420	55-65	◑
AISI 316 - 440	55-65	◑
17-4 PH 15-5 PH	50-55	◑
Chrome-Cobalt Alloy	50-55	◑
Duplex F51	40-50	◑
Super Duplex F55	40-50	◑
Gray Cast	95-110	●
Alloyed Cast	80-95	●
Precision Cast	80-95	●
Graphite	110-130	●
Titanium	50-70	●
Titanium Alloys	40-60	●

Feed Per Revolution (mm/rev)	
Ø	mm/dev
3	0.030
4	0.035
5	0.050
6	0.060
8	0.100
10	0.125
12	0.150
16	0.155
20	0.200

α 140° | +TiAlN | FORM HA DIN 6535

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

Y5DF

5D Drill With Coolant Holes

General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech
High Performance

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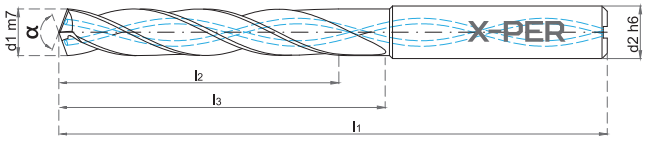
Stronger cutting edges by Exper edge preparation technology and up to **%40** better hole surface roughness in comparison with equivalents

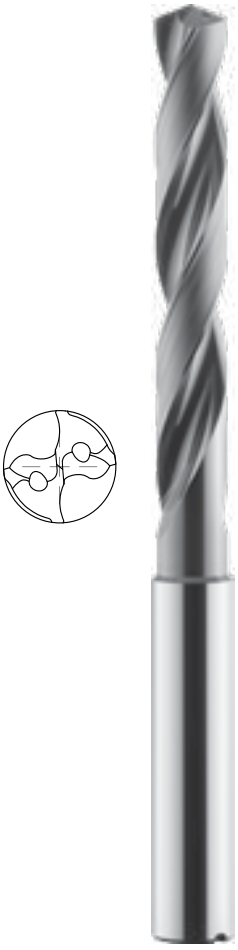
Optimal raw material and coolant pitch selection without run-out only for drilling operations to damp vibration and up to **%30** more precision hole diameter in comparison with equivalents with it's double margin advantage



Y5DF

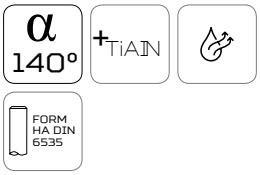
5D Drill With Coolant Holes

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	78100	Y5DF.2.0350.0660.A0140.0270.0000.0280.00.S06N2B02.01	3,5	6	66	27	28
	78102	Y5DF.2.0360.0660.A0140.0270.0000.0280.00.S06B2C06.01	3,6	6	66	27	28
	78104	Y5DF.2.0370.0660.A0140.0270.0000.0280.00.S06B2C06.01	3,7	6	66	27	28
*	**78106**	Y5DF.2.0390.0740.A0138.0320.0000.0360.00.S06C2C06.01	3,9	6	74	32	36
	78108	Y5DF.2.0390.0740.A0142.0320.0000.0360.00.S06B2B02.01	3,9	6	74	32	36
*	**78110**	Y5DF.2.0400.0740.A0142.0320.0000.0360.00.S06C2B02.01	4	6	74	32	36
	78112	Y5DF.2.0400.0950.A0138.0380.0000.0420.00.S06C2C06.01	4	6	95	38	42
	78114	Y5DF.2.0400.0750.A0142.0320.0000.0360.00.S06B2C05.01	4	6	75	32	36
	78116	Y5DF.2.0415.0800.A0140.0370.0000.0400.00.S06B2B02.01	4,15	6	80	37	40
*	**78118**	Y5DF.2.0420.0740.A0140.0320.0000.0360.00.S06B2C06.01	4,2	6	74	32	36
	78120	Y5DF.2.0450.0740.A0140.0320.0000.0360.00.S06B2C06.01	4,5	6	74	32	36
*	**78122**	Y5DF.2.0460.0740.A0140.0320.0000.0360.00.S06B2C06.01	4,6	6	74	32	36
	78124	Y5DF.2.0460.0750.A0142.0330.0000.0380.00.S06B2B02.01	4,6	6	75	33	38
	78126	Y5DF.2.0500.0820.A0140.0410.0000.0440.00.S06B2B02.01	5	6	82	41	44
*	**78128**	Y5DF.2.0510.0820.A0138.0410.0000.0440.00.S06C2B03.01	5,1	6	82	41	44
	78130	Y5DF.2.0550.0820.A0138.0410.0000.0440.00.S06C2B03.01	5,5	6	82	41	44
	78132	Y5DF.2.0600.0820.A0138.0410.0000.0440.00.S06B2B03.01	6	6	82	41	44
	78134	Y5DF.2.0650.0910.A0138.0500.0000.0530.00.S08C2L02.01	6,5	8	91	50	53
*	**78136**	Y5DF.2.0680.0910.A0140.0500.0000.0530.00.S08B1B02.01	6,8	8	91	50	53
*	**78138**	Y5DF.2.0700.0910.A0138.0500.0000.0530.00.S08B1B03.01	7	8	91	50	53
	78140	Y5DF.2.0750.0910.A0138.0500.0000.0530.00.S08B1B02.01	7,5	8	91	50	53
	78142	Y5DF.2.0780.0910.A0138.0500.0000.0530.00.S08B1B02.01	7,8	8	91	50	53
	78144	Y5DF.2.0800.0910.A0138.0500.0000.0530.00.S08B1B02.01	8	8	91	50	53
*	**78146**	Y5DF.2.0850.1030.A0140.0570.0000.0610.00.S10B1B03.01	8,5	10	103	57	61
	78148	Y5DF.2.0880.1030.A0140.0570.0000.0610.00.S10B1C06.01	8,8	10	103	57	61
	78150	Y5DF.2.0890.1030.A0140.0570.0000.0610.00.S10B1C06.01	8,9	10	103	57	61
	78152	Y5DF.2.0900.1030.A0140.0570.0000.0610.00.S10B1B03.01	9	10	103	57	61
	78154	Y5DF.2.0950.1030.A0140.0570.0000.0610.00.S10B1B03.01	9,5	10	103	57	61
	78156	Y5DF.2.0960.1030.A0140.0570.0000.0610.00.S10B1B03.01	9,6	10	103	57	61
	78158	Y5DF.2.0960.1250.A0130.0780.0000.0850.00.S10B2C03.01	9,6	10	125	78	85
*	**78160**	Y5DF.2.1000.1030.A0140.0570.0000.0610.00.S10B1B03.01	10	10	103	57	61
*	**78162**	Y5DF.2.1020.1180.A0140.0670.0000.0710.00.S12B1B03.01	10,2	12	118	67	71
	78164	Y5DF.2.1050.1180.A0140.0670.0000.0710.00.S12B1B03.01	10,5	12	118	67	71
	78166	Y5DF.2.1100.1180.A0140.0670.0000.0710.00.S12B1B03.01	11	12	118	67	71
	78168	Y5DF.2.1200.1180.A0140.0670.0000.0710.00.S12B1B03.01	12	12	118	67	71
*	**78170**	Y5DF.2.1250.1240.A0140.0700.0000.0770.00.S14B2C06.01	12,5	14	124	70	77
	78172	Y5DF.2.1280.1240.A0140.0700.0000.0770.00.S14B2C06.01	12,8	14	124	70	77
	78174	Y5DF.2.1300.1240.A0140.0700.0000.0770.00.S14B2C06.01	13	14	124	70	77
	78176	Y5DF.2.1400.1240.A0140.0700.0000.0770.00.S14B2C06.01	14	14	124	70	77
	78178	Y5DF.2.1450.1330.A0140.0740.0000.0830.00.S16B2C06.01	14,5	16	133	74	83
	78180	Y5DF.2.1500.1330.A0140.0740.0000.0830.00.S16B2C06.01	15	16	133	74	83
	78182	Y5DF.2.1550.1330.A0140.0740.0000.0830.00.S16B2C06.01	15,5	16	133	74	83
	78184	Y5DF.2.1600.1330.A0140.0740.0000.0830.00.S16B2C06.01	16	16	133	74	83
	78186	Y5DF.2.1700.1430.A0140.0860.0000.0930.00.S18B2C06.01	17	18	143	86	93
	78188	Y5DF.2.1750.1430.A0140.0860.0000.0930.00.S18B2C06.01	17,5	18	143	86	93
	78190	Y5DF.2.1800.1430.A0140.0860.0000.0930.00.S18B2C06.01	18	18	143	86	93
	78192	Y5DF.2.1850.1530.A0140.0920.0000.1010.00.S20B2C06.01	18,5	20	153	92	101
	78194	Y5DF.2.1900.1530.A0140.0920.0000.1010.00.S20B2C06.01	19	20	153	92	101
	78196	Y5DF.2.1950.1530.A0140.0920.0000.1010.00.S20B2C06.01	19,5	20	153	92	101
	78198	Y5DF.2.2000.1530.A0140.0920.0000.1010.00.S20B2C06.01	20	20	153	92	101
	78200	Y5DF.2.0300.0660.A0140.0270.0000.0280.00.S20B2C06.01	3	6	66	27	28



Cutting Parameters Vc(m/min)		
Non-Alloy Steel	160-200	●
Steel	140-180	●
Tempered Steel	100-130	●
Cold-Work Tool Steel	100-120	◑
Sıcak İş Takım Çeliği	80-110	◑
AISI 304 - 416 - 420	30-50	◑
AISI 316 - 440	30-50	◑
Grey Cast Iron	140-180	◑
Alloy Cast Iron	140-160	◑
Precision Cast	130-160	◑
Titanium	30-40	◑
Titanium Alloys	25-30	◑

Feed Per Revolution (mm/rev)	
Ø	
3	0,100
4	0,110
5	0,120
6	0,150
8	0,200
10	0,250
12	0,300
16	0,350
20	0,400



●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

KDRF
Reamer

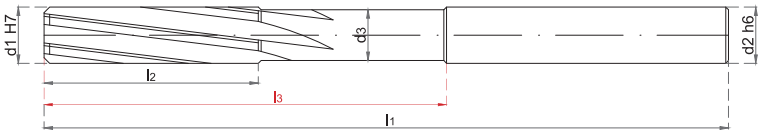
General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech
High Performance

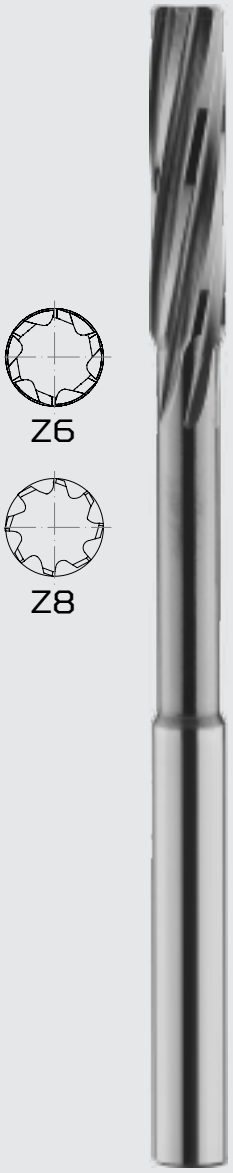
Up to %40 longer tool life at least in comparison with equivalents

- Optimal ultra fine raw material without run-out
- Special coating selection unique to reaming
- High hole precision and smooth surface roughness

KDRF
Reamer



Stock	Order No	Code	d1H7	d2h6	d3	l1	l2	l3	Z
*	**52100**	KDRF.6.0400.0750.C0050.0180.0350.0470.00.S06B1B04.01	4	6	3,5	75	18	47	6
*	**52102**	KDRF.6.0450.0750.C0050.0180.0350.0470.00.S06B1B04.01	4,5	6	3,5	75	18	47	6
*	**52104**	KDRF.6.0500.0820.C0050.0230.0400.0500.00.S06A1B04.01	5	6	4	82	23	50	6
*	**52106**	KDRF.6.0550.0930.C0050.0230.0450.0570.00.S06B1B04.01	5,5	6	4,5	93	23	57	6
*	**52108**	KDRF.6.0600.0930.C0050.0260.0500.0570.00.S06B4B04.01	6	6	5	93	26	57	6
*	**52110**	KDRF.6.0650.1000.C0050.0260.0550.0650.00.S08B1B04.01	6,5	8	5,5	100	26	65	6
	52112	KDRF.6.0700.1100.C0050.0310.0600.0730.00.S08A1B04.01	7	8	6	110	31	73	6
	52114	KDRF.6.0750.1100.C0050.0310.0650.0770.00.S08A1B04.01	7,5	8	6,5	110	31	77	6
*	**52116**	KDRF.6.0800.1170.C0050.0330.0700.0810.00.S08A5B04.01	8	8	7	117	33	81	6
*	**52118**	KDRF.6.0850.1140.C0050.0330.0750.0810.00.S10B1B04.01	8,5	10	7,5	114	33	81	6
	52120	KDRF.6.0900.1250.C0050.0360.0800.0850.00.S10B1B04.01	9	10	8	125	36	85	6
	52122	KDRF.6.0950.1250.C0050.0360.0850.0850.00.S10B1B04.01	9,5	10	8,5	125	36	85	6
*	**52124**	KDRF.6.1000.1330.C0050.0380.0900.0930.00.S10A5B04.01	10	10	9	133	38	93	6
*	**52126**	KDRF.6.1050.1400.C0050.0380.0950.0930.00.S12B1B04.01	10,5	12	9,5	140	38	93	6
	52128	KDRF.6.1100.1400.C0050.0410.1000.0970.00.S12B1B04.01	11	12	10	140	41	97	6
*	**52130**	KDRF.6.1200.1510.C0050.0440.1100.1060.00.S12A5B04.01	12	12	11	151	44	106	6
	52132	KDRF.6.1300.1500.C0050.0440.1200.1060.00.S14B1B04.01	13	14	12	150	44	106	6
	52134	KDRF.6.1400.1600.C0050.0470.1300.1120.00.S14A5B04.01	14	14	13	160	47	112	6
	52136	KDRF.8.1500.1600.C0050.0550.1400.1140.00.S16B1B04.01	15	16	14	160	55	114	8
	52138	KDRF.8.1600.1600.C0050.0550.1500.1140.00.S16A5B04.01	16	16	15	160	55	114	8
	52140	KDRF.8.1800.1820.C0050.0560.1700.1320.00.S18A5B04.01	18	18	17	182	56	132	8
	52142	KDRF.8.2000.1950.C0050.0600.1900.1450.00.S20A5B04.01	20	20	19	195	60	145	8

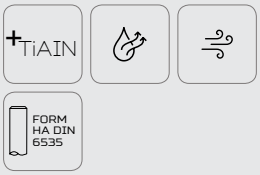


Z6

Z8

Cutting Parameters Vc(m/min)		
Non-Alloy Steel	20-30	●
Steel	15-25	●
Tempered Steel	15-20	●
Cold-Work Tool Steel	10--15	●
Hot-Work Tool Steel	10--15	●
AISI 304 - 416 - 420	15-20	◑
AISI 316 - 440	15-20	◑
17-4 PH 15-5 PH	15-18	◑
Chrome-Cobalt Alloy	13-17	◑
Duplex F51	12--15	◑
Super Duplex F55	12--15	◑
Grey Cast Iron	20-25	●
Alloy Cast Iron	20-25	●
Precision Cast	15-20	●
Aluminum Alloys	30-50	◑
Copper Alloys	30-50	◑
Magnesium Alloys	30-50	◑
Titanium	10-15	●
Titanium Alloys	10-15	●
HRSA	10-15	◑
≤ 54 HRC	15-30	○
>54 HRC	10-15	○

Feed Per Revolution (mm/rev)		
Ø		
4-5,5	0.080	0.095
6-7,5	0.100	0.120
8-9,5	0.125	0.140
10--12	0.150	0.170
13-16	0.180	0.210
17-20	0.220	0.250



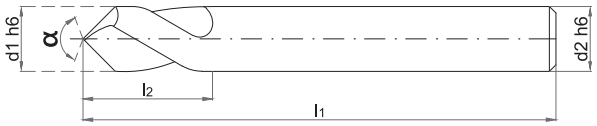
●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

KNS
Center Drill 90°

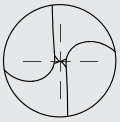
General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech
High Performance



Stock	Order No	Code	d1h6	d2h6	l1	l2
*	**54100**	KNS.2.0300.0390.A0090.0080.0000.0000.00.S03A1Y01.01	3	3	39	8
*	**54102**	KNS.2.0400.0390.A0090.0100.0000.0000.00.S04A1Y01.01	4	4	39	10
*	**54104**	KNS.2.0500.0510.A0090.0130.0000.0000.00.S05A1Y01.01	5	5	51	13
*	**54106**	KNS.2.0600.0500.A0090.0160.0000.0000.00.S06A1Y01.01	6	6	50	16
*	**54108**	KNS.2.0800.0640.A0090.0230.0000.0000.00.S08A1Y01.01	8	8	64	23
*	**54110**	KNS.2.1000.0730.A0090.0240.0000.0000.00.S10A1Y01.01	10	10	73	24
*	**54112**	KNS.2.1200.0740.A0090.0270.0000.0000.00.S12A1Y01.01	12	12	74	27
*	**54114**	KNS.2.1400.0760.A0090.0260.0000.0000.00.S14A1Y01.01	14	14	76	26
*	**54116**	KNS.2.1600.0820.A0090.0300.0000.0000.00.S16A1Y01.01	16	16	82	30
*	**54118**	KNS.2.1800.0930.A0090.0350.0000.0000.00.S18A1Y01.01	18	18	93	35
*	**54120**	KNS.2.2000.1050.A0090.0350.0000.0000.00.S20A1Y01.01	20	20	105	35

	Cutting Parameters Vc(m/min)	
	Steel	●
	Stainless Steel	◑
	Hardened Steel ≤54 HRc	◑
	Hardened Steel >54 HRc	○
	Cast Iron	●
	Non Ferrous Material	◑
	HRSA	◑
	Titanium	●



●Recommended ◑Acceptable ○Not Recommended

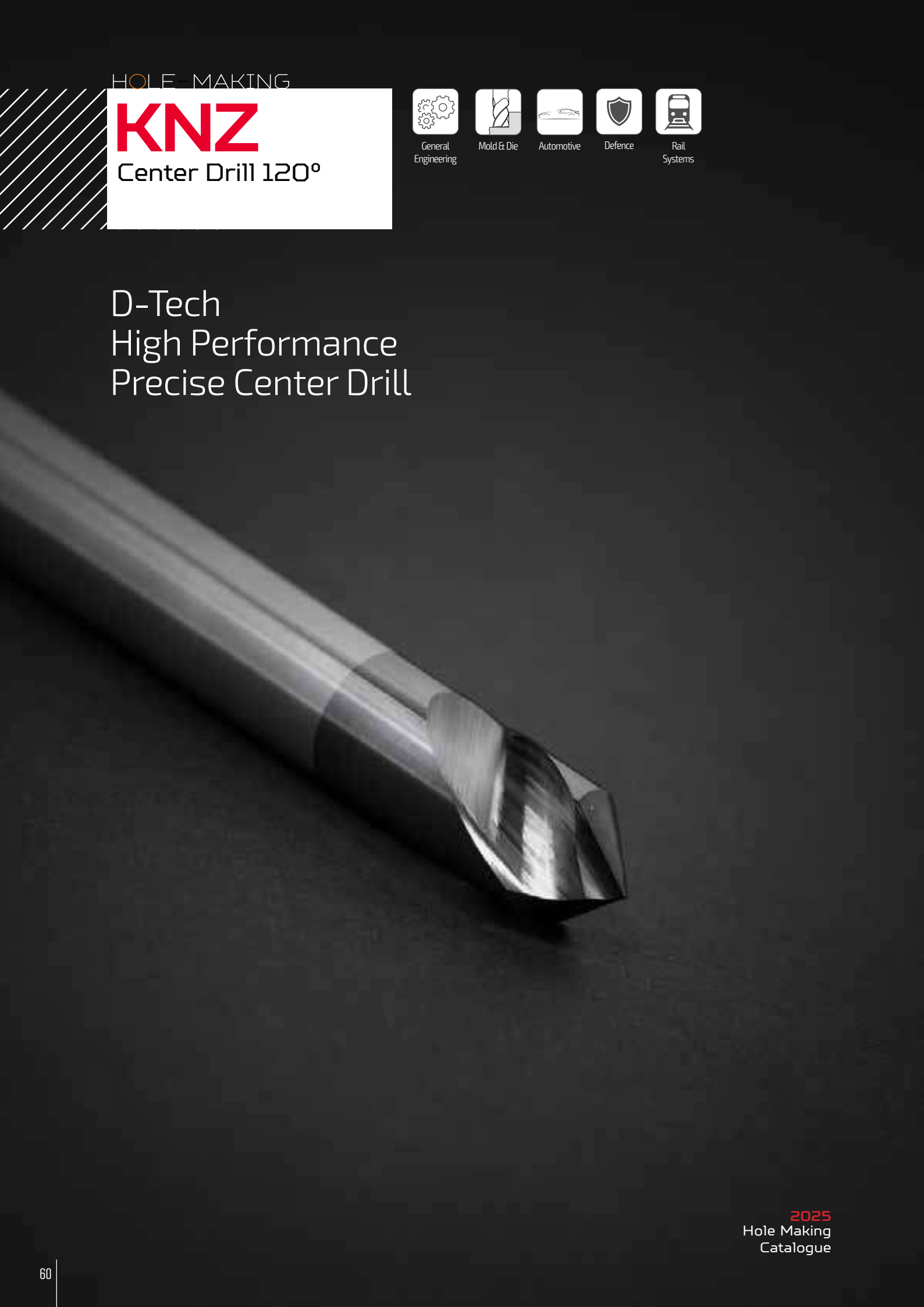
*Marked products are available from stock to deliver fast.

KNZ

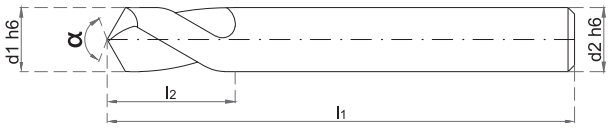
Center Drill 120°

General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech
High Performance
Precise Center Drill

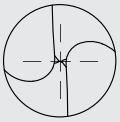


KNZ
Center Drill 120°



Stock	Order No	Code	d1h6	d2h6	l1	l2
	55100	KNZ.2.0300.0390.A0120.0080.0000.0000.00.S03A1Y01.01	3	3	39	8
	55102	KNZ.2.0400.0390.A0120.0100.0000.0000.00.S04A1Y01.01	4	4	39	10
	55104	KNZ.2.0500.0510.A0120.0130.0000.0000.00.S05A1Y01.01	5	5	51	13
	55106	KNZ.2.0600.0500.A0120.0150.0000.0000.00.S06A1Y01.01	6	6	50	15
	55108	KNZ.2.0800.0640.A0120.0230.0000.0000.00.S08A1Y01.01	8	8	64	23
	55110	KNZ.2.1000.0730.A0120.0250.0000.0000.00.S10A1Y01.01	10	10	73	25
	55112	KNZ.2.1200.0740.A0120.0250.0000.0000.00.S12A1Y01.01	12	12	74	25
	55114	KNZ.2.1400.0760.A0120.0260.0000.0000.00.S14A1Y01.01	14	14	76	26
	55116	KNZ.2.1600.0820.A0120.0300.0000.0000.00.S16A1Y01.01	16	16	82	30
	55118	KNZ.2.1800.0930.A0120.0350.0000.0000.00.S18A1Y01.01	18	18	93	35
	55120	KNZ.2.2000.1050.A0120.0350.0000.0000.00.S20A1Y01.01	20	20	105	35

Cutting Parameters Vc(m/min)	
Steel	●
Stainless Steel	◑
Hardened Steel ≤54 HRc	◑
Hardened Steel >54 HRc	○
Cast Iron	●
Non Ferrous Material	◑
HRSA	◑
Titanium	●



α 120° | ≤40 HRc | +TiAlN

FORM HA DIN 6535

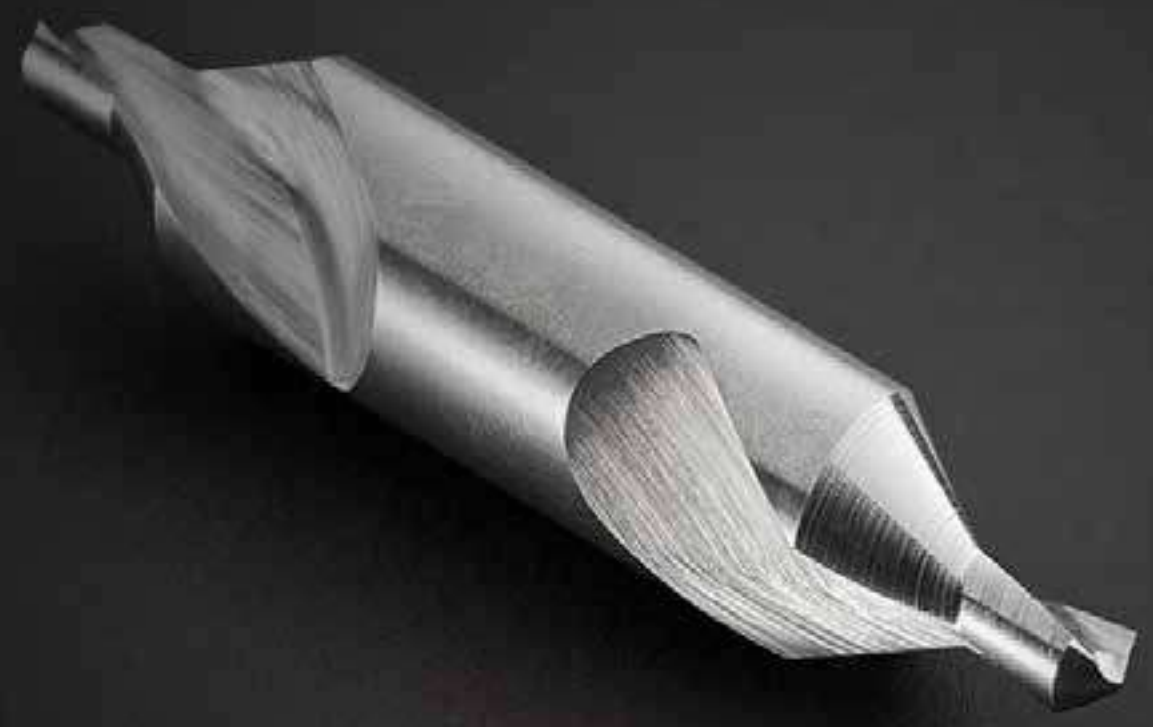
●Recommended ◑Acceptable ○Not Recommended

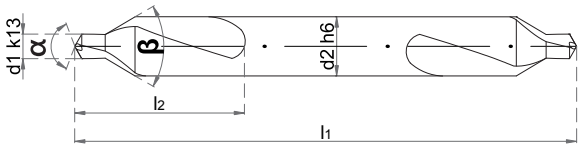
*Marked products are available from stock to deliver fast.

PMS
Center Drill

General Engineering | Mold & Die | Automotive | Defence | Rail Systems

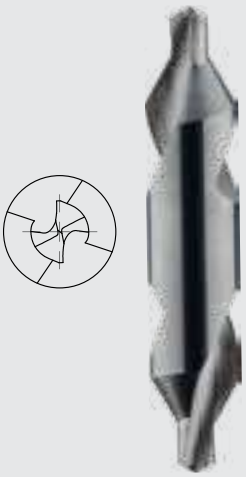
D-Tech
High Performance
Precise Center Drill





Stock	Order No	Code	d1k13	d2h6	l1	l2
	53100	PMS.2.0100.0390.A0120.0020.0000.0000.00.S03A1Y01.01	1	3	39	2
*	**53102**	PMS.2.0125.0390.A0120.0020.0000.0000.00.S03A1Y01.01	1,25	3	39	2
	53104	PMS.2.0160.0390.A0120.0024.0000.0000.00.S04A1Y01.01	1,6	4	39	2,4
*	**53106**	PMS.2.0200.0510.A0120.0029.0000.0000.00.S05A1Y01.01	2	5	51	2,9
*	**53108**	PMS.2.0250.0500.A0120.0036.0000.0000.00.S06A1Y01.01	2,5	6	50	3,6
	53110	PMS.2.0300.0500.A0120.0044.0000.0000.00.S08A1Y01.01	3	8	50	4,4
*	**53112**	PMS.2.0315.0500.A0120.0044.0000.0000.00.S08A1Y01.01	3,15	8	50	4,4
	53114	PMS.2.0350.0500.A0120.0044.0000.0000.00.S08A1Y01.01	3,5	8	50	4,4
	53116	PMS.2.0400.0730.A0120.0056.0000.0000.00.S10A1Y01.01	4	10	73	5,6
	53118	PMS.2.0500.0820.A0120.0069.0000.0000.00.S12A1Y01.01	5	12	82	6,9
*	**53120**	PMS.2.0630.0930.A0120.0086.0000.0000.00.S16A1Y01.01	6,3	16	93	8,6

Cutting Parameters Vc(m/min)	
Steel	●
Stainless Steel	◑
Hardened Steel ≤54 HRc	◑
Hardened Steel >54 HRc	○
Cast Iron	●
Non Ferrous Material	◑
HRSA	◑
Titanium	●



α 120° β 60° ≤40 HRc

FORM HA DIN 6535

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

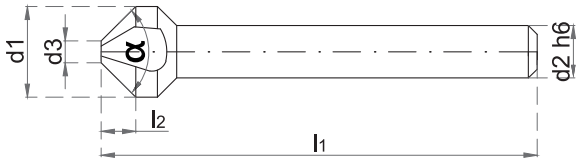
MCS
Countersink Convex

General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech
High Performance

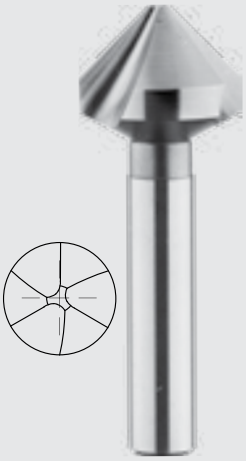
%100 stock

MCS
Countersink
Convex



Stock	Order No.	Code	d1h9	d2h6	d3	l1	l2
	41100	MCS.3.0630.0350.A090.0021.0200.0000.00.S06A3A05.01	6,3	6	2	35	2,1
*	**41102**	MCS.3.0830.0400.A090.0031.0200.0000.00.S06A3A05.01	8,3	6	2	40	3,1
*	**41104**	MCS.3.1040.0460.A090.0039.0250.0000.00.S06A3A05.01	10,4	6	2,5	46	3,9
*	**41106**	MCS.3.1240.0560.A090.0048.0280.0000.00.S08A3A05.01	12,4	8	2,8	56	4,8
	41108	MCS.3.1500.0600.A090.0059.0320.0000.00.S10A3A05.01	15	10	3,2	60	5,9
*	**41110**	MCS.3.1650.0600.A090.0066.0320.0000.00.S10A3A05.01	16,5	10	3,2	60	6,6
*	**41112**	MCS.3.2050.0630.A090.0085.0350.0000.00.S10A3A05.01	20,5	10	3,5	63	8,5
*	**41114**	MCS.3.2500.0670.A090.0106.0380.0000.00.S10A3A05.01	25	10	3,8	67	10,6

Steel	●
Stainless Steel	◑
Hardened Steel ≤54 HRc	◑
Hardened Steel >54 HRc	○
Cast Iron	●
Non Ferrous Material	◑
HRSA	◑
Titanium	●



α 90° | ≤48 HRc | +TiAlN

FORM HA DIN 6535

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

K3DX

3D Drill

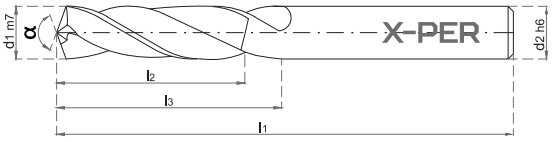
General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech Long-Chip Fighter

High Performance In Ductile and Long-Chipping Workpiece Materials

Perfect Chip Evacuation and Much Longer Tool Life Thanks To Special Chip Breaker Geometry On Cutting Edge and New Generation Coating.

Our DX Series Is Highly Recommended To Use On Ductile Steels Like ST Type, 1020 or 1040, Stainless Steels and Titanium Which Are Long-Chipping Workpiece Materials.



Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	48100	K3DX.2.0300.0620.A0138.0180.0300.0200.00.S06B1A05.01	3	6	62	18	20
	48102	K3DX.2.0330.0620.A0138.0180.0330.0200.00.S06B1A05.01	3,3	6	62	18	20
	48104	K3DX.2.0340.0620.A0138.0180.0340.0200.00.S06B1A05.01	3,4	6	62	18	20
	48106	K3DX.2.0370.0620.A0138.0180.0370.0200.00.S06B1A05.01	3,7	6	62	18	20
	48108	K3DX.2.0380.0660.A0138.0220.0380.0240.00.S06B1A05.01	3,8	6	66	22	24
	48110	K3DX.2.0400.0660.A0138.0220.0400.0240.00.S06B1A05.01	4	6	66	22	24
	48112	K3DX.2.0410.0660.A0138.0220.0410.0240.00.S06B1A05.01	4,1	6	66	22	24
	48114	K3DX.2.0420.0660.A0138.0220.0420.0240.00.S06B1A05.01	4,2	6	66	22	24
	48116	K3DX.2.0450.0660.A0138.0220.0450.0240.00.S06B1A05.01	4,5	6	66	22	24
	48118	K3DX.2.0460.0660.A0138.0220.0460.0240.00.S06B1A05.01	4,6	6	66	22	24
	48120	K3DX.2.0470.0660.A0138.0220.0470.0240.00.S06B1A05.01	4,7	6	66	22	24
	48122	K3DX.2.0480.0660.A0138.0260.0480.0280.00.S06B1A05.01	4,8	6	66	26	28
	48124	K3DX.2.0500.0660.A0138.0260.0480.0280.00.S06B1A05.01	5	6	66	26	28
	48126	K3DX.2.0520.0660.A0138.0260.0480.0280.00.S06B1A05.01	5,2	6	66	26	28
	48128	K3DX.2.0550.0660.A0138.0260.0480.0280.00.S06B1A05.01	5,5	6	66	26	28
	48130	K3DX.2.0580.0660.A0138.0260.0480.0280.00.S06B1A05.01	5,8	6	66	26	28
	48132	K3DX.2.0600.0660.A0138.0260.0480.0280.00.S06B1A05.01	6	6	66	26	28
	48134	K3DX.2.0630.0790.A0138.0320.0630.0340.00.S08B1A05.01	6,3	8	79	32	34
	48136	K3DX.2.0660.0790.A0138.0320.0660.0340.00.S08B1A05.01	6,6	8	79	32	34
	48138	K3DX.2.0680.0790.A0138.0320.0680.0340.00.S08B1A05.01	6,8	8	79	32	34
	48140	K3DX.2.0690.0790.A0138.0320.0690.0340.00.S08B1A05.01	6,9	8	79	32	34
	48142	K3DX.2.0700.0790.A0138.0320.0700.0340.00.S08B1A05.01	7	8	79	32	34
	48144	K3DX.2.0730.0790.A0138.0380.0730.0410.00.S08B1A05.01	7,3	8	79	38	41
	48146	K3DX.2.0780.0790.A0138.0380.0780.0410.00.S08B1A05.01	7,8	8	79	38	41
	48148	K3DX.2.0800.0790.A0138.0380.0800.0410.00.S08B1A05.01	8	8	79	38	41
	48150	K3DX.2.0820.0890.A0138.0430.0820.0470.00.S10B1A05.01	8,2	10	89	43	47
	48152	K3DX.2.0850.0890.A0138.0430.0850.0470.00.S10B1A05.01	8,5	10	89	43	47
	48154	K3DX.2.0880.0890.A0138.0430.0880.0470.00.S10B1A05.01	8,8	10	89	43	47
	48156	K3DX.2.0900.0890.A0138.0430.0900.0470.00.S10B1A05.01	9	10	89	43	47
	48158	K3DX.2.0910.0890.A0138.0430.0910.0470.00.S10B1A05.01	9,1	10	89	43	47
	48160	K3DX.2.0930.0890.A0138.0430.0930.0470.00.S10B1A05.01	9,3	10	89	43	47
	48162	K3DX.2.0950.0890.A0138.0430.0950.0470.00.S10B1A05.01	9,5	10	89	43	47
	48164	K3DX.2.0980.0890.A0138.0430.0980.0470.00.S10B1A05.01	9,8	10	89	43	47
	48166	K3DX.2.1000.0890.A0138.0430.1000.0470.00.S10B1A05.01	10	10	89	43	47
	48168	K3DX.2.1020.1020.A0138.0510.1020.0550.00.S12B1A05.01	10,2	12	102	51	55
	48170	K3DX.2.1050.1020.A0138.0510.1050.0550.00.S12B1A05.01	10,5	12	102	51	55
	48172	K3DX.2.1080.1020.A0138.0510.1080.0550.00.S12B1A05.01	10,8	12	102	51	55
	48174	K3DX.2.1090.1020.A0138.0510.1090.0550.00.S12B1A05.01	10,9	12	102	51	55
	48176	K3DX.2.1100.1020.A0138.0510.1100.0550.00.S12B1A05.01	11	12	102	51	55
	48178	K3DX.2.1110.1020.A0138.0510.1110.0550.00.S12B1A05.01	11,1	12	102	51	55
	48180	K3DX.2.1130.1020.A0138.0510.1130.0550.00.S12B1A05.01	11,3	12	102	51	55
	48182	K3DX.2.1150.1020.A0138.0510.1150.0550.00.S12B1A05.01	11,5	12	102	51	55
	48184	K3DX.2.1180.1020.A0138.0510.1180.0550.00.S12B1A05.01	11,8	12	102	51	55
	48186	K3DX.2.1200.1020.A0138.0510.1200.0550.00.S12B1A05.01	12	12	102	51	55
	48188	K3DX.2.1220.1070.A0138.0530.1220.0600.00.S14B1A05.01	12,2	14	107	53	60
	48190	K3DX.2.1250.1070.A0138.0530.1250.0600.00.S14B1A05.01	12,5	14	107	53	60
	48192	K3DX.2.1280.1070.A0138.0530.1280.0600.00.S14B1A05.01	12,8	14	107	53	60
	48194	K3DX.2.1300.1070.A0138.0530.1300.0600.00.S14B1A05.01	13	14	107	53	60
	48196	K3DX.2.1350.1070.A0138.0530.1350.0600.00.S14B1A05.01	13,5	14	107	53	60
	48198	K3DX.2.1380.1070.A0138.0530.1380.0600.00.S14B1A05.01	13,8	14	107	53	60
	48200	K3DX.2.1400.1070.A0138.0530.1400.0600.00.S14B1A05.01	14	14	107	53	60
	48202	K3DX.2.1430.1150.A0138.0580.1430.0650.00.S16B1A05.01	14,3	16	115	58	65
	48204	K3DX.2.1450.1150.A0138.0580.1450.0650.00.S16B1A05.01	14,5	16	115	58	65
	48206	K3DX.2.1500.1150.A0138.0580.1500.0650.00.S16B1A05.01	15	16	115	58	65
	48208	K3DX.2.1550.1150.A0138.0580.1550.0650.00.S16B1A05.01	15,5	16	115	58	65
	48210	K3DX.2.1600.1150.A0138.0580.1600.0650.00.S16B1A05.01	16	16	115	58	65

Cutting Parameters Vc(m/min)		
Unalloyed steel	80-120	●
Steel	70-110	●
Tempered Steel	65-100	●
Cold Work Tool Steel	55-70	◑
Hot Work Tool Steel	55-70	◑
AISI 304 - 416 - 420	55-65	◑
AISI 316 - 440	55-65	◑
17-4 PH 15-5 PH	50-55	◑
Chrome-Cobalt Alloy	50-55	◑
Duplex F51	40-50	◑
Super Duplex F55	40-50	◑
Gray Cast	95-110	●
Alloyed Cast	80-95	●
Precision Cast	80-95	●
Graphite	110-130	◑
Titanium	50-70	◑
Titanium Alloys	40-60	◑

Feed Per Revolution (mm/rev)	
Ø	mm/dev
3	0.030
4	0.035
5	0.050
6	0.060
8	0.100
10	0.125
12	0.150
16	0.155
20	0.200

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K5DX

5D Drill

General Engineering | Mold & Die | Automotive | Defence | Rail Systems

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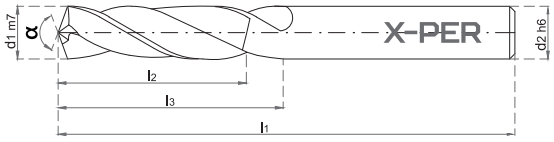
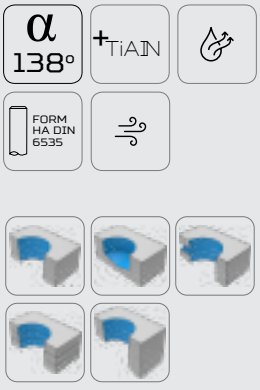


Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	49100	K5DX.2.0300.0660.A0138.0270.0300.0280.00.S06B1A05.01	3	6	66	27	28
	49102	K5DX.2.0310.0660.A0138.0270.0310.0280.00.S06B1A05.01	3,1	6	66	27	28
	49104	K5DX.2.0320.0660.A0138.0270.0320.0280.00.S06B1A05.01	3,2	6	66	27	28
	49106	K5DX.2.0330.0660.A0138.0270.0330.0280.00.S06B1A05.01	3,3	6	66	27	28
	49108	K5DX.2.0340.0660.A0138.0270.0340.0280.00.S06B1A05.01	3,4	6	66	27	28
	49110	K5DX.2.0350.0660.A0138.0270.0350.0280.00.S06B1A05.01	3,5	6	66	27	28
	49112	K5DX.2.0360.0660.A0138.0270.0360.0280.00.S06B1A05.01	3,6	6	66	27	28
	49114	K5DX.2.0370.0660.A0138.0270.0370.0280.00.S06B1A05.01	3,7	6	66	27	28
	49116	K5DX.2.0380.0740.A0138.0320.0380.0360.00.S06B1A05.01	3,8	6	74	32	36
	49118	K5DX.2.0390.0740.A0138.0320.0390.0360.00.S06B1A05.01	3,9	6	74	32	36
	49120	K5DX.2.0400.0740.A0138.0320.0400.0360.00.S06B1A05.01	4	6	74	32	36
	49122	K5DX.2.0410.0740.A0138.0320.0410.0360.00.S06B1A05.01	4,1	6	74	32	36
	49124	K5DX.2.0420.0740.A0138.0320.0420.0360.00.S06B1A05.01	4,2	6	74	32	36
	49126	K5DX.2.0430.0740.A0138.0320.0430.0360.00.S06B1A05.01	4,3	6	74	32	36
	49128	K5DX.2.0440.0740.A0138.0320.0440.0360.00.S06B1A05.01	4,4	6	74	32	36
	49130	K5DX.2.0450.0740.A0138.0320.0450.0360.00.S06B1A05.01	4,5	6	74	32	36
	49132	K5DX.2.0460.0740.A0138.0320.0460.0360.00.S06B1A05.01	4,6	6	74	32	36
	49134	K5DX.2.0470.0740.A0138.0320.0470.0360.00.S06B1A05.01	4,7	6	74	32	36
	49136	K5DX.2.0480.0820.A0138.0410.0480.0440.00.S06B1A05.01	4,8	6	82	41	44
	49138	K5DX.2.0490.0820.A0138.0410.0490.0440.00.S06B1A05.01	4,9	6	82	41	44
	49140	K5DX.2.0500.0820.A0138.0410.0400.0440.00.S06B1A05.01	5	6	82	41	44
	49142	K5DX.2.0510.0820.A0138.0410.0510.0440.00.S06B1A05.01	5,1	6	82	41	44
	49144	K5DX.2.0520.0820.A0138.0410.0520.0440.00.S06B1A05.01	5,2	6	82	41	44
	49146	K5DX.2.0530.0820.A0138.0410.0530.0440.00.S06B1A05.01	5,3	6	82	41	44
	49148	K5DX.2.0540.0820.A0138.0410.0540.0440.00.S06B1A05.01	5,4	6	82	41	44
	49150	K5DX.2.0550.0820.A0138.0410.0550.0440.00.S06B1A05.01	5,5	6	82	41	44
	49152	K5DX.2.0560.0820.A0138.0410.0560.0440.00.S06B1A05.01	5,6	6	82	41	44
	49154	K5DX.2.0570.0820.A0138.0410.0570.0440.00.S06B1A05.01	5,7	6	82	41	44
	49156	K5DX.2.0580.0820.A0138.0410.0580.0440.00.S06B1A05.01	5,8	6	82	41	44
	49158	K5DX.2.0590.0820.A0138.0410.0590.0440.00.S06B1A05.01	5,9	6	82	41	44
	49160	K5DX.2.0600.0820.A0138.0410.0600.0440.00.S06B1A05.01	6	6	82	41	44
	49162	K5DX.2.0610.0910.A0138.0500.0610.0530.00.S08B1A05.01	6,1	8	91	50	53
	49164	K5DX.2.0620.0910.A0138.0500.0620.0530.00.S08B1A05.01	6,2	8	91	50	53
	49166	K5DX.2.0630.0910.A0138.0500.0630.0530.00.S08B1A05.01	6,3	8	91	50	53
	49168	K5DX.2.0640.0910.A0138.0500.0640.0530.00.S08B1A05.01	6,4	8	91	50	53
	49170	K5DX.2.0650.0910.A0138.0500.0650.0530.00.S08B1A05.01	6,5	8	91	50	53
	49172	K5DX.2.0660.0910.A0138.0500.0660.0530.00.S08B1A05.01	6,6	8	91	50	53
	49174	K5DX.2.0670.0910.A0138.0500.0670.0530.00.S08B1A05.01	6,7	8	91	50	53
	49176	K5DX.2.0680.0910.A0138.0500.0680.0530.00.S08B1A05.01	6,8	8	91	50	53
	49178	K5DX.2.0690.0910.A0138.0500.0690.0530.00.S08B1A05.01	6,9	8	91	50	53
	49180	K5DX.2.0700.0910.A0138.0500.0700.0530.00.S08B1A05.01	7	8	91	50	53
	49182	K5DX.2.0710.0910.A0138.0500.0710.0530.00.S08B1A05.01	7,1	8	91	50	53
	49184	K5DX.2.0720.0910.A0138.0500.0720.0530.00.S08B1A05.01	7,2	8	91	50	53
	49186	K5DX.2.0730.0910.A0138.0500.0730.0530.00.S08B1A05.01	7,3	8	91	50	53
	49188	K5DX.2.0740.0910.A0138.0500.0740.0530.00.S08B1A05.01	7,4	8	91	50	53
	49190	K5DX.2.0750.0910.A0138.0500.0750.0530.00.S08B1A05.01	7,5	8	91	50	53
	49192	K5DX.2.0760.0910.A0138.0500.0760.0530.00.S08B1A05.01	7,6	8	91	50	53
	49194	K5DX.2.0770.0910.A0138.0500.0770.0530.00.S08B1A05.01	7,7	8	91	50	53
	49196	K5DX.2.0780.0910.A0138.0500.0780.0530.00.S08B1A05.01	7,8	8	91	50	53
	49198	K5DX.2.0790.0910.A0138.0500.0790.0530.00.S08B1A05.01	7,9	8	91	50	53

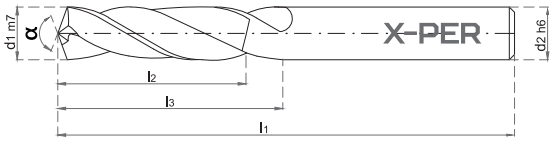


*Marked products are available from stock to deliver fast.

α 138°

+TiAlN

FORM HA DIN 6535



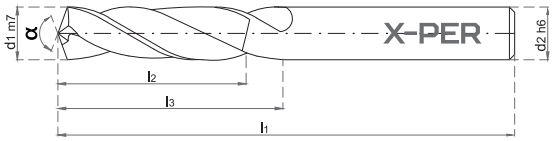
K5DX – 5D Drill

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	49200	K5DX.2.0800.0910.A0138.0500.0800.0530.00.S08B1A05.01	8	8	91	50	53
	49202	K5DX.2.0810.1030.A0138.0570.0810.0610.00.S10B1A05.01	8,1	10	103	57	61
	49204	K5DX.2.0820.1030.A0138.0570.0820.0610.00.S10B1A05.01	8,2	10	103	57	61
	49206	K5DX.2.0840.1030.A0138.0570.0840.0610.00.S10B1A05.01	8,4	10	103	57	61
	49208	K5DX.2.0850.1030.A0138.0570.0850.0610.00.S10B1A05.01	8,5	10	103	57	61
	49210	K5DX.2.0860.1030.A0138.0570.0860.0610.00.S10B1A05.01	8,6	10	103	57	61
	49212	K5DX.2.0880.1030.A0138.0570.0880.0610.00.S10B1A05.01	8,8	10	103	57	61
	49214	K5DX.2.0890.1030.A0138.0570.0890.0610.00.S10B1A05.01	8,9	10	103	57	61
	49216	K5DX.2.0900.1030.A0138.0570.0900.0610.00.S10B1A05.01	9	10	103	57	61
	49218	K5DX.2.0910.1030.A0138.0570.0910.0610.00.S10B1A05.01	9,1	10	103	57	61
	49220	K5DX.2.0920.1030.A0138.0570.0920.0610.00.S10B1A05.01	9,2	10	103	57	61
	49222	K5DX.2.0930.1030.A0138.0570.0930.0610.00.S10B1A05.01	9,3	10	103	57	61
	49224	K5DX.2.0940.1030.A0138.0570.0940.0610.00.S10B1A05.01	9,4	10	103	57	61
	49226	K5DX.2.0950.1030.A0138.0570.0950.0610.00.S10B1A05.01	9,5	10	103	57	61
	49228	K5DX.2.0960.1030.A0138.0570.0960.0610.00.S10B1A05.01	9,6	10	103	57	61
	49230	K5DX.2.0970.1030.A0138.0570.0970.0610.00.S10B1A05.01	9,7	10	103	57	61
	49232	K5DX.2.0980.1030.A0138.0570.0980.0610.00.S10B1A05.01	9,8	10	103	57	61
	49234	K5DX.2.0990.1030.A0138.0570.0990.0610.00.S10B1A05.01	9,9	10	103	57	61
	49236	K5DX.2.1000.1030.A0138.0570.1000.0610.00.S10B1A05.01	10	10	103	57	61
	49238	K5DX.2.1010.1180.A0138.0670.1010.0710.00.S12B1A05.01	10,1	12	118	67	71
	49240	K5DX.2.1020.1180.A0138.0670.1020.0710.00.S12B1A05.01	10,2	12	118	67	71
	49242	K5DX.2.1030.1180.A0138.0670.1030.0710.00.S12B1A05.01	10,3	12	118	67	71
	49244	K5DX.2.1040.1180.A0138.0670.1040.0710.00.S12B1A05.01	10,4	12	118	67	71
	49246	K5DX.2.1050.1180.A0138.0670.1050.0710.00.S12B1A05.01	10,5	12	118	67	71
	49248	K5DX.2.1060.1180.A0138.0670.1060.0710.00.S12B1A05.01	10,6	12	118	67	71
	49250	K5DX.2.1070.1180.A0138.0670.1070.0710.00.S12B1A05.01	10,7	12	118	67	71
	49252	K5DX.2.1080.1180.A0138.0670.1070.0710.00.S12B1A05.01	10,8	12	118	67	71
	49254	K5DX.2.1090.1180.A0138.0670.1090.0710.00.S12B1A05.01	10,9	12	118	67	71
	49256	K5DX.2.1100.1180.A0138.0670.1100.0710.00.S12B1A05.01	11	12	118	67	71
	49258	K5DX.2.1110.1180.A0138.0670.1110.0710.00.S12B1A05.01	11,1	12	118	67	71
	49260	K5DX.2.1120.1180.A0138.0670.1120.0710.00.S12B1A05.01	11,2	12	118	67	71
	49262	K5DX.2.1130.1180.A0138.0670.1130.0710.00.S12B1A05.01	11,3	12	118	67	71
	49264	K5DX.2.1140.1180.A0138.0670.1140.0710.00.S12B1A05.01	11,4	12	118	67	71
	49266	K5DX.2.1150.1180.A0138.0670.1150.0710.00.S12B1A05.01	11,5	12	118	67	71
	49268	K5DX.2.1160.1180.A0138.0670.1160.0710.00.S12B1A05.01	11,6	12	118	67	71
	49270	K5DX.2.1170.1180.A0138.0670.1170.0710.00.S12B1A05.01	11,7	12	118	67	71
	49272	K5DX.2.1180.1180.A0138.0670.1180.0710.00.S12B1A05.01	11,8	12	118	67	71
	49274	K5DX.2.1190.1180.A0138.0670.1190.0710.00.S12B1A05.01	11,9	12	118	67	71
	49276	K5DX.2.1200.1180.A0138.0670.1190.0710.00.S12B1A05.01	12	12	118	67	71
	49278	K5DX.2.1210.1240.A0138.0700.1210.0770.00.S14B1A05.01	12,1	14	124	70	77
	49280	K5DX.2.1220.1240.A0138.0700.1220.0770.00.S14B1A05.01	12,2	14	124	70	77
	49282	K5DX.2.1230.1240.A0138.0700.1230.0770.00.S14B1A05.01	12,3	14	124	70	77
	49284	K5DX.2.1240.1240.A0138.0700.1240.0770.00.S14B1A05.01	12,4	14	124	70	77
	49286	K5DX.2.1250.1240.A0138.0700.1250.0770.00.S14B1A05.01	12,5	14	124	70	77
	49288	K5DX.2.1260.1240.A0138.0700.1260.0770.00.S14B1A05.01	12,6	14	124	70	77
	49290	K5DX.2.1270.1240.A0138.0700.1270.0770.00.S14B1A05.01	12,7	14	124	70	77
	49292	K5DX.2.1280.1240.A0138.0700.1280.0770.00.S14B1A05.01	12,8	14	124	70	77
	49294	K5DX.2.1290.1240.A0138.0700.1290.0770.00.S14B1A05.01	12,9	14	124	70	77
	49296	K5DX.2.1300.1240.A0138.0700.1300.0770.00.S14B1A05.01	13	14	124	70	77
	49298	K5DX.2.1310.1240.A0138.0700.1310.0770.00.S14B1A05.01	13,1	14	124	70	77

α 138°

+TiAlN

FORM HA DIN 6535



K5DX - 5D Drill

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	49300	K5DX.2.1330.1240.A0138.0700.1330.0770.00.S14B1A05.01	13,3	14	124	70	77
	49302	K5DX.2.1340.1240.A0138.0700.1340.0770.00.S14B1A05.01	13,4	14	124	70	77
	49304	K5DX.2.1350.1240.A0138.0700.1350.0770.00.S14B1A05.01	13,5	14	124	70	77
	49306	K5DX.2.1360.1240.A0138.0700.1360.0770.00.S14B1A05.01	13,6	14	124	70	77
	49308	K5DX.2.1370.1240.A0138.0700.1370.0770.00.S14B1A05.01	13,7	14	124	70	77
	49310	K5DX.2.1380.1240.A0138.0700.1380.0770.00.S14B1A05.01	13,8	14	124	70	77
	49312	K5DX.2.1390.1240.A0138.0700.1390.0770.00.S14B1A05.01	13,9	14	124	70	77
	49314	K5DX.2.1400.1240.A0138.0700.1400.0770.00.S14B1A05.01	14	14	124	70	77
	49316	K5DX.2.1410.1330.A0138.0740.1410.0830.00.S16B1A05.01	14,1	16	133	74	83
	49318	K5DX.2.1420.1330.A0138.0740.1420.0830.00.S16B1A05.01	14,2	16	133	74	83
	49320	K5DX.2.1430.1330.A0138.0740.1430.0830.00.S16B1A05.01	14,3	16	133	74	83
	49322	K5DX.2.1440.1330.A0138.0740.1440.0830.00.S16B1A05.01	14,4	16	133	74	83
	49324	K5DX.2.1450.1330.A0138.0740.1450.0830.00.S16B1A05.01	14,5	16	133	74	83
	49326	K5DX.2.1500.1330.A0138.0740.1500.0830.00.S16B1A05.01	15	16	133	74	83
	49328	K5DX.2.1550.1330.A0138.0740.1550.0830.00.S16B1A05.01	15,5	16	133	74	83
	49330	K5DX.2.1600.1330.A0138.0740.1600.0830.00.S16B1A05.01	16	16	133	74	83

Cutting Parameters Vc(m/min)		
Unalloyed Steel	**65-80**	●
Steel	**55-70**	●
Tempered Steel	**50-65**	●
Cold Work Tool Steel	**40-55**	◑
Hot Work Tool Steel	**40-55**	◑
AISI 304 - 416 - 420	**30-40**	◑
AISI 316 - 440	**30-40**	◑
17-4 PH 15-5 PH	**25-30**	◑
Chrome-Cobalt Alloy	**25-30**	◑
Duplex F51	**15-25**	◑
Super Duplex F55	**15-25**	◑
Gray Cast	**80-95**	●
Alloyed Cast	**65-80**	●
Precision Cast	**65-80**	●
Graphite	**95-110**	◑
Titanium	**30-40**	◑
Titanium Alloys	**25-30**	◑

Feed Per Revolution (mm/rev)	
Ø	mm/dev
3	0.025
4	0.030
5	0.042
6	0.052
8	0.092
10	0.115
12	0.135
16	0.155
20	0.175
14	0,29
16	0,31
18	0,33
20	0,35

*Marked products are available from stock to deliver fast.

●Recommended ◑Acceptable ○Not Recommended

M3DX

3D Drill
With Coolant Holes

General Engineering | Mold & Die | Automotive | Defence | Rail Systems

D-Tech Long-Chip Fighter

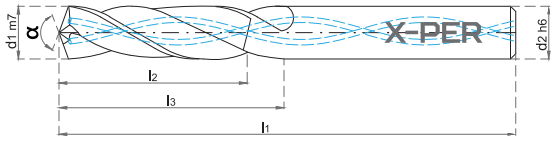
High Performance In Ductile and Long-Chipping Workpiece Materials

Perfect Chip Evacuation and Much Longer Tool Life Thanks To Special Chip Breaker Geometry On Cutting Edge and New Generation Coating.

Our DX Series Is Highly Recommended To Use On Ductile Steels Like ST Type, 1020 or 1040, Stainless Steels and Titanium Which Are Long-Chipping Workpiece Materials.

M3DX

3D Drill
With Coolant Holes



Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	71100	M3DX.2.0300.0620.A0138.0180.0000.0200.00.S06B1A05.01	3	6	62	18	20
	71102	M3DX.2.0330.0620.A0138.0180.0000.0200.00.S06B1A05.01	3,3	6	62	18	20
	71104	M3DX.2.0340.0620.A0138.0180.0000.0200.00.S06B1A05.01	3,4	6	62	18	20
	71106	M3DX.2.0370.0620.A0138.0180.0000.0200.00.S06B1A05.01	3,7	6	62	18	20
	71108	M3DX.2.0380.0660.A0138.0220.0000.0240.00.S06B1A05.01	3,8	6	66	22	24
	71110	M3DX.2.0400.0660.A0138.0220.0000.0240.00.S06B1A05.01	4	6	66	22	24
	71112	M3DX.2.0410.0660.A0138.0220.0000.0240.00.S06B1A05.01	4,1	6	66	22	24
	71114	M3DX.2.0420.0660.A0138.0220.0000.0240.00.S06B1A05.01	4,2	6	66	22	24
	71116	M3DX.2.0450.0660.A0138.0220.0000.0240.00.S06B1A05.01	4,5	6	66	22	24
	71118	M3DX.2.0460.0660.A0138.0220.0000.0240.00.S06B1A05.01	4,6	6	66	22	24
	71120	M3DX.2.0470.0660.A0138.0220.0000.0240.00.S06B1A05.01	4,7	6	66	22	24
	71122	M3DX.2.0480.0660.A0138.0260.0000.0280.00.S06B1A05.01	4,8	6	66	26	28
	71124	M3DX.2.0500.0660.A0138.0260.0000.0280.00.S06B1A05.01	5	6	66	26	28
	71126	M3DX.2.0520.0660.A0138.0260.0000.0280.00.S06B1A05.01	5,2	6	66	26	28
	71128	M3DX.2.0550.0660.A0138.0260.0000.0280.00.S06B1A05.01	5,5	6	66	26	28
	71130	M3DX.2.0580.0660.A0138.0260.0000.0280.00.S06B1A05.01	5,8	6	66	26	28
	71132	M3DX.2.0600.0660.A0138.0260.0000.0280.00.S06B1A05.01	6	6	66	26	28
	71134	M3DX.2.0630.0790.A0138.0320.0000.0340.00.S08B1A05.01	6,3	8	79	32	34
	71136	M3DX.2.0660.0790.A0138.0320.0000.0340.00.S08B1A05.01	6,6	8	79	32	34
	71138	M3DX.2.0680.0790.A0138.0320.0000.0340.00.S08B1A05.01	6,8	8	79	32	34
	71140	M3DX.2.0690.0790.A0138.0320.0000.0340.00.S08B1A05.01	6,9	8	79	32	34
	71142	M3DX.2.0700.0790.A0138.0320.0000.0340.00.S08B1A05.01	7	8	79	32	34
	71144	M3DX.2.0730.0790.A0138.0380.0000.0410.00.S08B1A05.01	7,3	8	79	38	41
	71146	M3DX.2.0780.0790.A0138.0380.0000.0410.00.S08B1A05.01	7,8	8	79	38	41
	71148	M3DX.2.0800.0790.A0138.0380.0000.0410.00.S08B1A05.01	8	8	79	38	41
	71150	M3DX.2.0820.0890.A0138.0430.0000.0470.00.S10B1A05.01	8,2	10	89	43	47
	71152	M3DX.2.0850.0890.A0138.0430.0000.0470.00.S10B1A05.01	8,5	10	89	43	47
	71154	M3DX.2.0860.0890.A0138.0430.0000.0470.00.S10B1A05.01	8,6	10	89	43	47
	71156	M3DX.2.0880.0890.A0138.0430.0000.0470.00.S10B1A05.01	8,8	10	89	43	47
	71158	M3DX.2.0900.0890.A0138.0430.0000.0470.00.S10B1A05.01	9	10	89	43	47
	71160	M3DX.2.0930.0890.A0138.0430.0000.0470.00.S10B1A05.01	9,3	10	89	43	47
	71162	M3DX.2.0950.0890.A0138.0430.0000.0470.00.S10B1A05.01	9,5	10	89	43	47
	71164	M3DX.2.0980.0890.A0138.0430.0000.0470.00.S10B1A05.01	9,8	10	89	43	47
	71166	M3DX.2.1000.0890.A0138.0430.0000.0470.00.S10B1A05.01	10	10	89	43	47
	71168	M3DX.2.1020.1020.A0138.0510.0000.0550.00.S12B1A05.01	10,2	12	102	51	55
	71170	M3DX.2.1050.1020.A0138.0510.0000.0550.00.S12B1A05.01	10,5	12	102	51	55
	71172	M3DX.2.1080.1020.A0138.0510.0000.0550.00.S12B1A05.01	10,8	12	102	51	55
	71174	M3DX.2.1090.1020.A0138.0510.0000.0550.00.S12B1A05.01	10,9	12	102	51	55
	71176	M3DX.2.1100.1020.A0138.0510.0000.0550.00.S12B1A05.01	11	12	102	51	55
	71178	M3DX.2.1130.1020.A0138.0510.0000.0550.00.S12B1A05.01	11,3	12	102	51	55
	71180	M3DX.2.1150.1020.A0138.0510.0000.0550.00.S12B1A05.01	11,5	12	102	51	55
	71182	M3DX.2.1180.1020.A0138.0510.0000.0550.00.S12B1A05.01	11,8	12	102	51	55
	71184	M3DX.2.1200.1020.A0138.0510.0000.0550.00.S12B1A05.01	12	12	102	51	55
	71186	M3DX.2.1220.1070.A0138.0510.0000.0550.00.S14B1A05.01	12,2	14	107	51	55
	71188	M3DX.2.1250.1070.A0138.0530.0000.0600.00.S14B1A05.01	12,5	14	107	53	60
	71190	M3DX.2.1280.1070.A0138.0530.0000.0600.00.S14B1A05.01	12,8	14	107	53	60
	71192	M3DX.2.1300.1070.A0138.0530.0000.0600.00.S14B1A05.01	13	14	107	53	60
	71194	M3DX.2.1350.1070.A0138.0530.0000.0600.00.S14B1A05.01	13,5	14	107	53	60
	71196	M3DX.2.1380.1070.A0138.0530.0000.0600.00.S14B1A05.01	13,8	14	107	53	60
	71198	M3DX.2.1400.1070.A0138.0530.0000.0600.00.S14B1A05.01	14	14	107	53	60
	71200	M3DX.2.1430.1150.A0138.0580.0000.0650.00.S16B1A05.01	14,3	16	115	58	65
	71202	M3DX.2.1450.1150.A0138.0580.0000.0650.00.S16B1A05.01	14,5	16	115	58	65
	71204	M3DX.2.1500.1150.A0138.0580.0000.0650.00.S16B1A05.01	15	16	115	58	65
	71206	M3DX.2.1550.1150.A0138.0580.0000.0650.00.S16B1A05.01	15,5	16	115	58	65
	71208	M3DX.2.1600.1150.A0138.0580.0000.0650.00.S16B1A05.01	16	16	115	58	65

Cutting Parameters Vc(m/min)		
Unalloyed steel	**80-95**	●
Steel	**70-90**	●
Tempered Steel	**65-80**	●
Cold Work Tool Steel	**55-70**	●
Hot Work Tool Steel	**55-70**	●
AISI 304 - 416 - 420	**50-55**	●
AISI 316 - 440	**50-55**	◑
17-4 PH 15-5 PH	**40-50**	◑
Chrome-Cobalt Alloy	**40-50**	◑
Duplex F51	**30-40**	●
Super Duplex F55	**30-40**	●
Gray Cast	**100-120**	◑
Alloyed Cast	**80-95**	◑
Precision Cast	**70-90**	●
Graphite	**120-130**	●
Titanium	**30-40**	●
Titanium Alloys	**25-30**	●
HRSA	**30-40**	●
≤ 54 HRC	**75-110**	◑
>54 HRC	**40-55**	◑

Feed Per Revolution (mm/rev)	
Ø	mm/dev
3	0.022
4	0.030
5	0.035
6	0.052
8	0.090
10	0.115
12	0.135
16	0.150
20	0.175

*Marked products are available from stock to deliver fast.

M5DX

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Perfect Chip Evacuation and Much Longer Tool Life Thanks To Special Chip Breaker Geometry On Cutting Edge and New Generation Coating.

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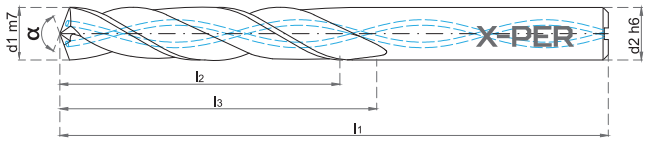

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	72100	M5DX.2.0300.0660.A0138.0270.0000.0280.00.S06B1A05.01	3	6	66	27	28
	72102	M5DX.2.0310.0660.A0138.0270.0000.0280.00.S06B1A05.01	3,1	6	66	27	28
	72104	M5DX.2.0320.0660.A0138.0270.0000.0280.00.S06B1A05.01	3,2	6	66	27	28
	72106	M5DX.2.0330.0660.A0138.0270.0000.0280.00.S06B1A05.01	3,3	6	66	27	28
	72108	M5DX.2.0340.0660.A0138.0270.0000.0280.00.S06B1A05.01	3,4	6	66	27	28
	72110	M5DX.2.0350.0660.A0138.0270.0000.0280.00.S06B1A05.01	3,5	6	66	27	28
	72112	M5DX.2.0360.0660.A0138.0270.0000.0280.00.S06B1A05.01	3,6	6	66	27	28
	72114	M5DX.2.0370.0660.A0138.0270.0000.0280.00.S06B1A05.01	3,7	6	66	27	28
	72116	M5DX.2.0380.0740.A0138.0320.0000.0360.00.S06B1A05.01	3,8	6	74	32	36
	72118	M5DX.2.0390.0740.A0138.0320.0000.0360.00.S06B1A05.01	3,9	6	74	32	36
	72120	M5DX.2.0400.0740.A0138.0320.0000.0360.00.S06B1A05.01	4	6	74	32	36
	72122	M5DX.2.0410.0740.A0138.0320.0000.0360.00.S06B1A05.01	4,1	6	74	32	36
	72124	M5DX.2.0420.0740.A0138.0320.0000.0360.00.S06B1A05.01	4,2	6	74	32	36
	72126	M5DX.2.0430.0740.A0138.0320.0000.0360.00.S06B1A05.01	4,3	6	74	32	36
	72128	M5DX.2.0440.0740.A0138.0320.0000.0360.00.S06B1A05.01	4,4	6	74	32	36
	72130	M5DX.2.0450.0740.A0138.0320.0000.0360.00.S06B1A05.01	4,5	6	74	32	36
	72132	M5DX.2.0460.0740.A0138.0320.0000.0360.00.S06B1A05.01	4,6	6	74	32	36
	72134	M5DX.2.0470.0740.A0138.0320.0000.0360.00.S06B1A05.01	4,7	6	74	32	36
	72136	M5DX.2.0480.0820.A0138.0410.0000.0440.00.S06B1A05.01	4,8	6	82	41	44
	72138	M5DX.2.0490.0820.A0138.0410.0000.0440.00.S06B1A05.01	4,9	6	82	41	44
	72140	M5DX.2.0500.0820.A0138.0410.0000.0440.00.S06B1A05.01	5	6	82	41	44
	72142	M5DX.2.0510.0820.A0138.0410.0000.0440.00.S06B1A05.01	5,1	6	82	41	44
	72144	M5DX.2.0520.0820.A0138.0410.0000.0440.00.S06B1A05.01	5,2	6	82	41	44
	72146	M5DX.2.0530.0820.A0138.0410.0000.0440.00.S06B1A05.01	5,3	6	82	41	44
	72148	M5DX.2.0540.0820.A0138.0410.0000.0440.00.S06B1A05.01	5,4	6	82	41	44
	72150	M5DX.2.0550.0820.A0138.0410.0000.0440.00.S06B1A05.01	5,5	6	82	41	44
	72152	M5DX.2.0560.0820.A0138.0410.0000.0440.00.S06B1A05.01	5,6	6	82	41	44
	72154	M5DX.2.0570.0820.A0138.0410.0000.0440.00.S06B1A05.01	5,7	6	82	41	44
	72156	M5DX.2.0580.0820.A0138.0410.0000.0440.00.S06B1A05.01	5,8	6	82	41	44
	72158	M5DX.2.0590.0820.A0138.0410.0000.0440.00.S06B1A05.01	5,9	6	82	41	44
	72160	M5DX.2.0600.0820.A0138.0410.0000.0440.00.S06B1A05.01	6	6	82	41	44
	72162	M5DX.2.0630.0910.A0138.0500.0000.0530.00.S08B1A05.01	6,3	8	91	50	53
	72164	M5DX.2.0660.0910.A0138.0500.0000.0530.00.S08B1A05.01	6,6	8	91	50	53
	72166	M5DX.2.0680.0910.A0138.0500.0000.0530.00.S08B1A05.01	6,8	8	91	50	53
	72168	M5DX.2.0690.0910.A0138.0500.0000.0530.00.S08B1A05.01	6,9	8	91	50	53
	72170	M5DX.2.0700.0910.A0138.0500.0000.0530.00.S08B1A05.01	7	8	91	50	53
	72172	M5DX.2.0730.0910.A0138.0500.0000.0530.00.S08B1A05.01	7,3	8	91	50	53
	72174	M5DX.2.0780.0910.A0138.0500.0000.0530.00.S08B1A05.01	7,8	8	91	50	53
	72176	M5DX.2.0800.0910.A0138.0500.0000.0530.00.S08B1A05.01	8	8	91	50	53
	72178	M5DX.2.0810.1030.A0138.0570.0000.0610.00.S10B1A05.01	8,1	10	103	57	61
	72180	M5DX.2.0820.1030.A0138.0570.0000.0610.00.S10B1A05.01	8,2	10	103	57	61
	72182	M5DX.2.0850.1030.A0138.0570.0000.0610.00.S10B1A05.01	8,5	10	103	57	61
	72184	M5DX.2.0880.1030.A0138.0570.0000.0610.00.S10B1A05.01	8,8	10	103	57	61
	72186	M5DX.2.0900.1030.A0138.0570.0000.0610.00.S10B1A05.01	9	10	103	57	61
	72188	M5DX.2.0930.1030.A0138.0570.0000.0610.00.S10B1A05.01	9,3	10	103	57	61
	72190	M5DX.2.0950.1030.A0138.0570.0000.0610.00.S10B1A05.01	9,5	10	103	57	61
	72192	M5DX.2.0980.1030.A0138.0570.0000.0610.00.S10B1A05.01	9,8	10	103	57	61
	72194	M5DX.2.1000.1030.A0138.0570.0000.0610.00.S10B1A05.01	10	10	103	57	61
	72196	M5DX.2.1020.1180.A0138.0670.0000.0710.00.S12B1A05.01	10,2	12	118	67	71
	72198	M5DX.2.1050.1180.A0138.0670.0000.0710.00.S12B1A05.01	10,5	12	118	67	71
	72200	M5DX.2.1080.1180.A0138.0670.0000.0710.00.S12B1A05.01	10,8	12	118	67	71
	72202	M5DX.2.1090.1180.A0138.0670.0000.0710.00.S12B1A05.01	10,9	12	118	67	71
	72204	M5DX.2.1100.1180.A0138.0670.0000.0710.00.S12B1A05.01	11	12	118	67	71
	72206	M5DX.2.1130.1180.A0138.0670.0000.0710.00.S12B1A05.01	11,3	12	118	67	71
	72208	M5DX.2.1150.1180.A0138.0670.0000.0710.00.S12B1A05.01	11,5	12	118	67	71
	72210	M5DX.2.1180.1180.A0138.0670.0000.0710.00.S12B1A05.01	11,8	12	118	67	71
	72212	M5DX.2.1200.1180.A0138.0670.0000.0710.00.S12B1A05.01	12	12	118	67	71
	72214	M5DX.2.1220.1240.A0138.0700.0000.0770.00.S14B1A05.01	12,2	14	124	70	77
	72216	M5DX.2.1250.1240.A0138.0700.0000.0770.00.S14B1A05.01	12,5	14	124	70	77
	72218	M5DX.2.1280.1240.A0138.0700.0000.0770.00.S14B1A05.01	12,8	14	124	70	77
	72220	M5DX.2.1300.1240.A0138.0700.0000.0770.00.S14B1A05.01	13	14	124	70	77
	72222	M5DX.2.1350.1240.A0138.0700.0000.0770.00.S14B1A05.01	13,5	14	124	70	77
	72224	M5DX.2.1380.1240.A0138.0700.0000.0770.00.S14B1A05.01	13,8	14	124	70	77
	72226	M5DX.2.1400.1240.A0138.0700.0000.0770.00.S14B1A05.01	14	14	124	70	77
	72228	M5DX.2.1430.1330.A0138.0740.0000.0830.00.S16B1A05.01	14,3	16	133	74	83
	72230	M5DX.2.1450.1330.A0138.0740.0000.0830.00.S16B1A05.01	14,5	16	133	74	83
	72232	M5DX.2.1500.1330.A0138.0740.0000.0830.00.S16B1A05.01	15	16	133	74	83
	72234	M5DX.2.1550.1330.A0138.0740.0000.0830.00.S16B1A05.01	15,5	16	133	74	83
	72236	M5DX.2.1600.1330.A0138.0740.0000.0830.00.S16B1A05.01	16	16	133	74	83
	72238	M5DX.2.1800.1430.A0140.0860.0000.0930.00.S18B2A05.01	18	18	143	86	93
	72240	M5DX.2.1850.1530.A0140.0770.0000.1010.00.S20B2A05.01	18,5	20	153	77	101

α 138°

+TiAlN

FORM HA DIN 6535

D-TECH | M5DX

Cutting Parameters Vc(m/min)		
Unalloyed steel	80-95	●
Steel	70-90	●
Tempered Steel	65-80	●
Cold Work Tool Steel	55-70	●
Hot Work Tool Steel	55-70	●

AISI 304 - 416 - 420	50-55	●
AISI 316 - 440	50-55	◑
17-4 PH 15-5 PH	40-50	◑
Chrome-Cobalt Alloy	40-50	◑
Duplex F51	30-40	●
Super Duplex F55	30-40	●
Gray Cast	100-120	◑

Alloyed Cast	80-95	◑
Precision Cast	70-90	●
Graphite	120-130	●
Titanium	30-40	●
Titanium Alloys	25-30	●
HRSA	30-40	●
≤ 54 HRC	75-110	◑
>54 HRC	40-55	◑

Feed Per Revolution (mm/rev)			
Ø	mm/dev	8	0.090
3	0.022	10	0.115
4	0.030	12	0.135
5	0.035	16	0.150
6	0.052	20	0.175

*Marked products are available from stock to deliver fast.

TX8DF

8D TX Drill
With Coolant Holes

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D-Tech
High Performance

Thanks to it's brand-new geometry and coating up to **%40** longer tool life at least in comparison with equivalents

Stronger cutting edges by Exper edge preparation technology and up to **%45** better hole surface roughness in comparison with equivalents

Optimal raw material selection for drilling operations to damp vibration and up to **%25** more precision hole diameter in comparison with equivalents

TX8DF

8D TX Drill
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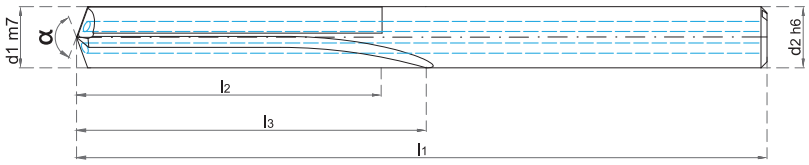

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	67100	TX8DF.2.0600.0950.A0140.0480.0600.0570.00.S06A1B03.01	6	6	95	48	57
	67102	TX8DF.2.0680.1140.A0140.0640.0800.0760.00.S08A1B03.01	6,8	8	114	64	76
	67104	TX8DF.2.0700.1140.A0140.0640.0700.0760.00.S08A1B03.01	7	8	114	64	76
	67106	TX8DF.2.0750.1140.A0140.0640.0750.0760.00.S08A1B03.01	7,5	8	114	64	76
	67108	TX8DF.2.0780.1140.A0140.0640.0780.0760.00.S08A1B03.01	7,8	8	114	64	76
	67110	TX8DF.2.0800.1140.A0140.0640.0800.0760.00.S08A1B03.01	8	8	114	64	76
	67112	TX8DF.2.0850.1420.A0140.0800.0850.0950.00.S10A1B03.01	8,5	10	142	80	95
	67114	TX8DF.2.0880.1420.A0140.0800.0880.0950.00.S10A1B03.01	8,8	10	142	80	95
	67116	TX8DF.2.0900.1420.A0140.0800.0900.0950.00.S10A1B03.01	9	10	142	80	95
	67118	TX8DF.2.0950.1420.A0140.0800.0950.0950.00.S10A1B03.01	9,5	10	142	80	95
	67120	TX8DF.2.1000.1420.A0140.0800.1000.0950.00.S10A1B03.01	10	10	142	80	95
	67122	TX8DF.2.1020.1620.A0140.0960.1020.1140.00.S12A1B03.01	10,2	12	162	96	114
	67124	TX8DF.2.1050.1620.A0140.0960.1050.1140.00.S12A1B03.01	10,5	12	162	96	114
	67126	TX8DF.2.1100.1620.A0140.0960.1100.1140.00.S12A1B03.01	11	12	162	96	114
	67128	TX8DF.2.1200.1620.A0140.0960.1200.1140.00.S12A1B03.01	12	12	162	96	114
	67130	TX8DF.2.1250.1780.A0140.1100.1250.1330.00.S14A1B03.01	12,5	14	178	110	133
	67132	TX8DF.2.1280.1780.A0140.1100.1280.1330.00.S14A1B03.01	12,8	14	178	110	133
	67134	TX8DF.2.1300.1780.A0140.1100.1300.1330.00.S14A1B03.01	13	14	178	110	133
	67136	TX8DF.2.1350.1780.A0140.1100.1350.1310.00.S14A1B03.01	13,5	14	178	110	131
	67138	TX8DF.2.1400.1780.A0140.1100.1400.1310.00.S14A1B03.01	14	14	178	110	131
	67140	TX8DF.2.1450.2030.A0140.1280.1450.1520.00.S16A1B03.01	14,5	16	203	128	152
	67142	TX8DF.2.1500.2030.A0140.1280.1500.1520.00.S16A1B03.01	15	16	203	128	152
	67144	TX8DF.2.1550.2030.A0140.1280.1550.1520.00.S16A1B03.01	15,5	16	203	128	152
	67146	TX8DF.2.1600.2030.A0140.1280.1600.1520.00.S16A1B03.01	16	16	203	128	152
	67148	TX8DF.2.1700.2220.A0140.1440.1700.1710.00.S18A1B03.01	17	18	222	144	171
	67150	TX8DF.2.1750.2220.A0140.1440.1750.1710.00.S18A1B03.01	17,5	18	222	144	171
	67152	TX8DF.2.1800.2220.A0140.1440.1800.1710.00.S18A1B03.01	18	18	222	144	171
	67154	TX8DF.2.1850.2430.A0140.1600.1850.1900.00.S20A1B03.01	18,5	20	243	160	190
	67156	TX8DF.2.1900.2430.A0140.1600.1900.1900.00.S20A1B03.01	19	20	243	160	190
	67158	TX8DF.2.1950.2430.A0140.1600.1950.1900.00.S20A1B03.01	19,5	20	243	160	190
	67160	TX8DF.2.2000.2430.A0140.1600.2000.1900.00.S20A1B03.01	20	20	243	160	190

Cutting Parameters Vc(m/min)		
Non-Alloy Steel	160-200	●
Steel	140-160	●
Tempered Steel	120-140	●
Cold-Work Tool Steel	100-120	◑
Hot-Work Tool Steel	100-120	◑
Grey Cast Iron	160-200	●
Alloy Cast Iron	160-200	●
Precision Cast	120-160	●

Feed Per Revolution (mm/rev)	
Ø	
3	0,08
4	0,110
5	0,140
6	0,170
8	0,190
10	0,210
12	0,240
16	0,270
20	0,290

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

KTX5D

5D TX Drill
With Coolant Holes

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D-Tech
High Performance

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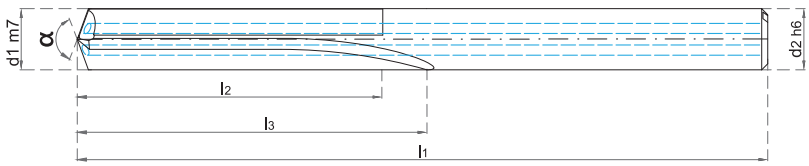
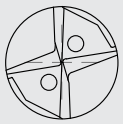
With Coolant Holes



Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	79100	KTX5D.2.0500.0820.A0130.0350.0000.0440.00.S06B1Y01.01	5	6	82	35	44
	79102	KTX5D.2.0510.0820.A0130.0350.0000.0440.00.S06B1Y01.01	5,1	6	82	35	44
	79104	KTX5D.2.0520.0820.A0130.0350.0000.0440.00.S06B1Y01.01	5,2	6	82	35	44
	79106	KTX5D.2.0550.0820.A0130.0350.0000.0440.00.S06B1Y01.01	5,5	6	82	35	44
	79108	KTX5D.2.0600.0820.A0130.0350.0000.0440.00.S06B1Y01.01	6	6	82	35	44
	79110	KTX5D.2.0650.0910.A0130.0430.0000.0530.00.S08B1Y01.01	6,5	8	91	43	53
	79112	KTX5D.2.0680.0910.A0130.0430.0000.0530.00.S08B1Y01.01	6,8	8	91	43	53
	79114	KTX5D.2.0700.0910.A0130.0430.0000.0530.00.S08B1Y01.01	7	8	91	43	53
	79116	KTX5D.2.0750.0910.A0130.0430.0000.0530.00.S08B1Y01.01	7,5	8	91	43	53
	79118	KTX5D.2.0780.0910.A0130.0430.0000.0530.00.S08B1Y01.01	7,8	8	91	43	53
	79120	KTX5D.2.0800.0910.A0130.0430.0000.0530.00.S08B1Y01.01	8	8	91	43	53
	79122	KTX5D.2.0840.1030.A0130.0490.0000.0610.00.S10B1Y01.01	8,4	10	103	49	61
	79124	KTX5D.2.0850.1030.A0130.0490.0000.0610.00.S10B1Y01.01	8,5	10	103	49	61
	79126	KTX5D.2.0880.1030.A0130.0490.0000.0610.00.S10B1Y01.01	8,8	10	103	49	61
	79128	KTX5D.2.0900.1030.A0130.0490.0000.0610.00.S10B1Y01.01	9	10	103	49	61
	79130	KTX5D.2.0950.1030.A0130.0490.0000.0610.00.S10B1Y01.01	9,5	10	103	49	61
	79132	KTX5D.2.1000.1030.A0130.0490.0000.0610.00.S10B1Y01.01	10	10	103	49	61
	79134	KTX5D.2.1020.1180.A0130.0560.0000.0710.00.S12B1Y01.01	10,2	12	118	56	71
	79136	KTX5D.2.1050.1180.A0130.0560.0000.0710.00.S12B1Y01.01	10,5	12	118	56	71
	79138	KTX5D.2.1100.1180.A0130.0560.0000.0710.00.S12B1Y01.01	11	12	118	56	71
	79140	KTX5D.2.1200.1180.A0130.0560.0000.0710.00.S12B1Y01.01	12	12	118	56	71
	79142	KTX5D.2.1250.1240.A0130.0600.0000.0770.00.S14B1Y01.01	12,5	14	124	60	77
	79144	KTX5D.2.1280.1240.A0130.0600.0000.0770.00.S14B1Y01.01	12,8	14	124	60	77
	79146	KTX5D.2.1300.1240.A0130.0600.0000.0770.00.S14B1Y01.01	13	14	124	60	77
	79148	KTX5D.2.1400.1240.A0130.0600.0000.0770.00.S14B1Y01.01	14	14	124	60	77
	79150	KTX5D.2.1450.1330.A0130.0630.0000.0830.00.S16B1Y01.01	14,5	16	133	63	83
	79152	KTX5D.2.1500.1330.A0130.0740.0000.0830.00.S16B1Y01.01	15	16	133	74	83
	79154	KTX5D.2.1550.1330.A0130.0630.0000.0830.00.S16B1Y01.01	15,5	16	133	63	83
	79156	KTX5D.2.1600.1330.A0130.0630.0000.0830.00.S16B1Y01.01	16	16	133	63	83
	79158	KTX5D.2.1700.1430.A0130.0710.0000.0930.00.S18B1Y01.01	17	18	143	71	93
	79160	KTX5D.2.1750.1430.A0130.0710.0000.0930.00.S18B1Y01.01	17,5	18	143	71	93
	79162	KTX5D.2.1800.1430.A0130.0710.0000.0930.00.S18B1Y01.01	18	18	143	71	93
	79164	KTX5D.2.1850.1530.A0130.0770.0000.1010.00.S20B1Y01.01	18,5	20	153	77	101
	79166	KTX5D.2.1900.1530.A0130.0770.0000.1010.00.S20B1Y01.01	19	20	153	77	101
	79168	KTX5D.2.1950.1530.A0130.0770.0000.1010.00.S20B1Y01.01	19,5	20	153	77	101
	79170	KTX5D.2.2000.1530.A0130.0770.0000.1010.00.S20B1Y01.01	20	20	153	77	101



Cutting Parameters Vc(m/min)		
Aluminum Alloy	125-175	●
Copper Alloy	125-175	●
Magnesium Alloy	125-175	●

Feed Per Revolution (mm/rev)	
Ø	
6	0,144
8	0,160
10	0,176
12	0,192
16	0,224
20	0,248

*Marked products are available from stock to deliver fast.

●Recommended ◑Acceptable ○Not Recommended

KTX8D

8D TX Drill
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High Performance

new product

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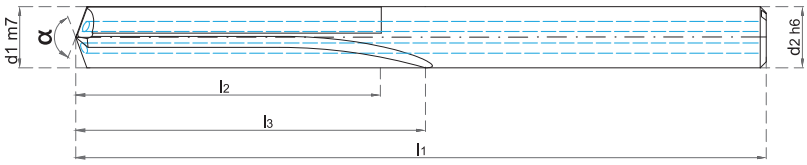
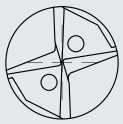


Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	80100	KTX8D.2.0600.0950.A0130.0480.0000.0570.00.S06B1Y01.01	6	6	95	48	57
	80102	KTX8D.2.0680.1140.A0130.0640.0000.0760.00.S08B1Y01.01	6,8	8	114	64	76
	80104	KTX8D.2.0700.1140.A0130.0640.0000.0760.00.S08B1Y01.01	7	8	114	64	76
	80106	KTX8D.2.0750.1140.A0130.0640.0000.0760.00.S08B1Y01.01	7,5	8	114	64	76
	80108	KTX8D.2.0780.1140.A0130.0640.0000.0760.00.S08B1Y01.01	7,8	8	114	64	76
	80110	KTX8D.2.0800.1140.A0130.0640.0000.0760.00.S08B1Y01.01	8	8	114	64	76
	80112	KTX8D.2.0880.1420.A0130.0800.0000.0950.00.S10B1Y01.01	8,8	10	142	80	95
	80114	KTX8D.2.0900.1420.A0130.0800.0000.0950.00.S10B1Y01.01	9	10	142	80	95
	80116	KTX8D.2.0950.1420.A0130.0800.0000.0950.00.S10B1Y01.01	9,5	10	142	80	95
	80118	KTX8D.2.1000.1420.A0130.0800.0000.0950.00.S10B1Y01.01	10	10	142	80	95
	80120	KTX8D.2.1020.1620.A0130.0960.0000.1140.00.S12B1Y01.01	10,2	12	162	96	114
	80122	KTX8D.2.1100.1620.A0130.0960.0000.1140.00.S12B1Y01.01	11	12	162	96	114
	80124	KTX8D.2.1200.1620.A0130.0960.0000.1140.00.S12B1Y01.01	12	12	162	96	114
	80126	KTX8D.2.1250.1780.A0130.1100.0000.1310.00.S14B1Y01.01	12,5	14	178	110	131
	80128	KTX8D.2.1280.1780.A0130.1100.0000.1310.00.S14B1Y01.01	12,8	14	178	110	131
	80130	KTX8D.2.1300.1780.A0130.1100.0000.1310.00.S14B1Y01.01	13	14	178	110	131
	80132	KTX8D.2.1400.1780.A0130.1100.0000.1310.00.S14B1Y01.01	14	14	178	110	131
	80134	KTX8D.2.1450.2030.A0130.1280.0000.1520.00.S16B1Y01.01	14,5	16	203	128	152
	80136	KTX8D.2.1500.2030.A0130.1280.0000.1520.00.S16B1Y01.01	15	16	203	128	152
	80138	KTX8D.2.1550.2030.A0130.1280.0000.1520.00.S16B1Y01.01	15,5	16	203	128	152
	80140	KTX8D.2.1600.2030.A0130.1280.0000.1520.00.S16B1Y01.01	16	16	203	128	152
	80142	KTX8D.2.1700.2220.A0130.1440.0000.1710.00.S18B1Y01.01	17	18	222	144	171
	80144	KTX8D.2.1750.2220.A0130.1440.0000.1710.00.S18B1Y01.01	17,5	18	222	144	171
	80146	KTX8D.2.1800.2220.A0130.1440.0000.1710.00.S18B1Y01.01	18	18	222	144	171
	80148	KTX8D.2.1850.2430.A0130.1600.0000.1900.00.S20B1Y01.01	18,5	20	243	160	190
	80150	KTX8D.2.1900.2430.A0130.1600.0000.1900.00.S20B1Y01.01	19	20	243	160	190
	80152	KTX8D.2.1950.2430.A0130.1600.0000.1900.00.S20B1Y01.01	19,5	20	243	160	190
	80154	KTX8D.2.2000.2430.A0130.1600.0000.1900.00.S20B1Y01.01	20	20	243	160	190



Cutting Parameters Vc(m/min)		
Aluminum Alloy	125-175	●
Copper Alloy	125-175	●
Magnesium Alloy	125-175	●

Feed Per Revolution (mm/rev)	
Ø	
6	0,144
8	0,160
10	0,176
12	0,192
16	0,224
20	0,248

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

MEDITAN

High Performance Drilling

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New Crazy and Wild Member of Karcan Hole Making Series

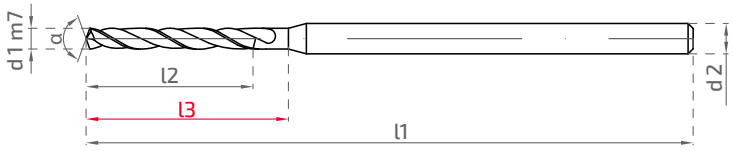
Karcan Proudly Presents…
Meditan By D-Tech Hole Making Technologies

new product

Extreme Cutting Speeds and Long Lasting Tool Life.

As Well As General Steels, Stainless Steels and Cast Irons, Meditan Offers Extremely High Performance In A Large Scale Of The Most Challenging Workpiece Materials To Machine Are Heat Resistant Superalloys (HRSAs) and Titanium Alloys. Classified As ISO-S Materials or Simply S-Materials.

2025
Hole Making
Catalogue



Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	50100	MED.2.0130.0600.A0140.0100.0130.0135.00.S03C1B04.01	1,3	3	60	10	13,5
	50102	MED.2.0150.0600.A0140.0160.0150.0185.00.S03C1B04.01	1,5	3	60	16	18,5
	50104	MED.2.0165.0600.A0140.0125.0165.0160.00.S03C1B04.01	1,65	3	60	12,5	16
	50106	MED.2.0165.0600.A0140.0190.0165.0220.00.S03C1B04.01	1,65	3	60	19	22
	50108	MED.2.0205.0600.A0140.0165.0205.0200.00.S03C1B04.01	2,05	3	60	16,5	20
	50110	MED.2.0205.0600.A0140.0220.0205.0260.00.S03C1B04.01	2,05	3	60	22	26
	50112	MED.2.0245.0600.A0140.0195.0245.0235.00.S03C1B04.01	2,45	3	60	19,5	23,5
	50114	MED.2.0245.0600.A0140.0280.0245.0310.00.S03C1B04.01	2,45	3	60	28	31

Cutting Parameters Vc(m/min)		
Unalloyed Steel	80-180	◑
Steel	75-160	◑
Tempered Steel	75-150	○
Cold Work Tool Steel	60-120	○
Hot Work Tool Steel	60-120	○
AISI 304 - 416 - 420	40-80	●
AISI 316 - 440	40-80	●
17-4 PH 15-5 PH	35-65	●
Cobalt-Chrome alloys	30-50	●
Duplex F51	30-50	●
Gray Cast	90-150	◑
Alloyed Cast	90-130	◑
Precision Cast	90-120	◑
Grafit	95-110	○
Titanium	40-70	●
Titanium Alloys	40-70	●

Feed Per Revolution (mm/rev)	
Ø	mm/dev
1,3-1,5	0,022
1,5-1,7	0,029
1,7-2,1	0,039
2,1-2,45	0,052
2,45-3	0,068
17-20	0.220

α 140° | +TiAlN | FORM HA DIN 6535

D-TECH | KTX8D

●Recommended ◑Acceptable ○Not Recommended

*Marked products are available from stock to deliver fast.

Drilling Formulas and Definitions

Cutting speed, [vc] m/min

$$V_C = \frac{D_C x \pi x n}{1000}$$

Spindle speed, [n] rpm

$$n = \frac{V_C x 1000}{\pi x D_c}$$

Penetration rate, [vf] m/min

$$V_f = f_n x\, n$$

Feed per revolution, [fn] mm/rev

$$f_n = \frac{V_f}{n}$$

Metal removal rate, [Q] cm³/min

$$Q = \frac{D_C x f_n x V_C}{4}$$

Net power, [pc] kW

$$P_C = \frac{f_n x V_C x D_C x k_C}{240 x 10^3}$$

Torque, Ibf Nm

$$M_C = \frac{P_C x 30 x 10^3}{\pi_x n}$$

Spesific cutting force, [kc] N/mm²

$$k_c = k_{c1} x (f_z x \sin k_\Gamma)^{-m_c} x \left(1 - \frac{y_0}{100}\right)$$

Feed force, [Ff] N

$$F_f \approx 0.5 x k_C x \frac{D_C}{2} x f_n x \sin K_r$$

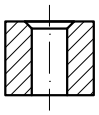
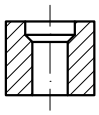
Machining time, [Tc] min

$$T = \frac{\mathrm{Im}}{v_f}$$

Special Tools

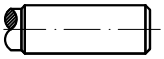
SOLID CARBIDE STEP TWIST DRILL

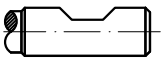
Solid Carbide
Step Twist Drill

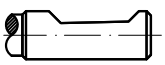
Machining Type	Material To be Machined		Machine Information			
☐  ☐ 	☐ Unalloyed Steel	☐ Aluminium Sl>%10	Machine Brand			
	☐ Cast Steel	☐ Aluminium Sl<%10	Machine Type			
Type	☐ Alloyed Steel	☐ Copper	Machine Power (kW)			
☐ Throught Bore ☐ Blind Bore	☐ Inox	☐ Brass	Max. Speed (RPM)			
Machining Method	☐ Stainless/Aside Dayanıklı	☐ Bronz	Working Plane	☐ Vert.	☐ Horiz.	☐ 5 Axis
☐ Dry ☐ Wet ☐ Min.Lubr.	☐ Gray Cast	☐ Titanium Alloys	Working Type	☐ Work Piece Turning	☐ Cutting Tool Turning	
Coolant Supply	☐ Alloyed Cast	☐ Nickel Alloys	Internal Coolant	☐ Yes ☐ No	Pressure	
☐ Ext.  ☐ Int. 	☐ Sfrero Cast	☐ Cold Cast Iron	Spindle Type			
	☐ Forged Steel	☐ Hardened Steel	Holder Type			
			Axis the Tool Operates			
			Coolant			
			☐ Oil	☐ Boron Oil		

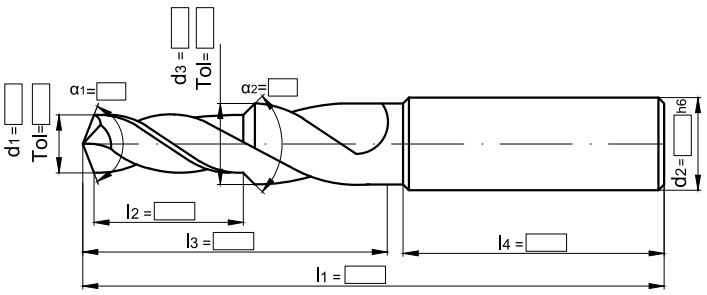
Hardness (HRc, HB, etc.)	Surface Quality Demanded	Additional Features and Notes
Tensile Strenght (N/mm²)	**Cutting Direction(If not stated we will assume RH.)**	
	☐ L.H. ☐ R.H.	
Standard No	**Coating**	

Shank Form

HA(DIN 6535) ☐ 

HB(DIN 6535) ☐ 

HE(DIN 6535) ☐ 



Note		Phn-Fax	
Company Name		E-mail	
Authorized Person		Date and Sign	
Address			

Note: Work area details should be drawn roughly, if possible it is recommended that the technical drawing should be provided among with the form

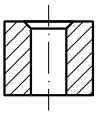
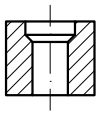
Head Office / Factory / R&D Center
O.S.B 20. Cadde No : 31 TR26110
Eskisehir/Turkey
+90 222 228 10 40

Special Tools

SOLID MULTI STEP CARBIDE TWIST DRILL

Solid Carbide
Step Twist Drill

KARCAN cutting tools

Machining Type	Material To be Machined		Machine Information	
☐  ☐ 	☐ Unalloyed Steel	☐ Aluminium SI>%10	Machine Brand	
	☐ Cast Steel	☐ Aluminium SI<%10	Machine Type	
	☐ Alloyed Steel	☐ Copper	Machine Power (kW)	
	☐ Inox	☐ Brass	Max. Speed (RPM)	
	☐ Stainless/Aside Dayanıklı	☐ Bronz	Working Plane	☐ Vert. ☐ Horiz. ☐ 5 Axis
	☐ Gray Cast	☐ Titanium Alloys	Working Type	☐ Work Piece Turning ☐ Cutting Tool Turning
	☐ Alloyed Cast	☐ Nickel Alloys	Internal Coolant	☐ Yes ☐ No Pressure
	☐ Sfrero Cast	☐ Cold Cast Iron	Spindle Type	
	☐ Forged Steel	☐ Hardened Steel	Holder Type	
			Axis the Tool Operates	
			Coolant	
			☐ Oil	☐ Boron Oil

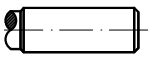
Type	Machining Method	Coolant Supply
☐ Throught Bore ☐ Blind Bore	☐ Dry ☐ Wet ☐ Min.Lubr.	☐ Ext.  ☐ Int. 

Hardness (HRc, HB, etc.)	Surface Quality Demanded	Additional Features and Notes

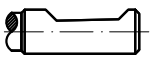
Tensile Strenght (N/mm²)	Cutting Direction(If not stated we will assume RH.)
	☐ L.H. ☐ R.H.

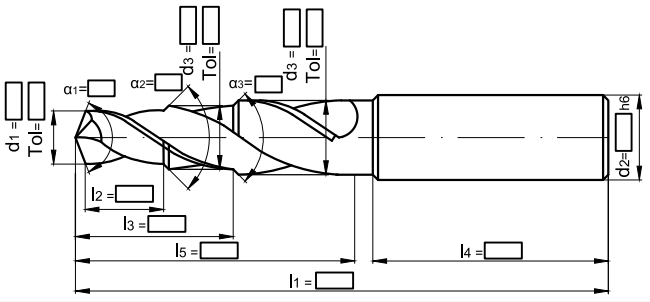
Standard No	Coating

Shank Form

HA(DIN 6535) ☐ 

HB(DIN 6535) ☐ 

HE(DIN 6535) ☐ 



Note		Phn-Fax	
Company Name		E-mail	
Authorized Person		Date and Sign	
Address			

Note: Work area details should be drawn roughly, if possible it is recommended that the technical drawing should be provided among with the form

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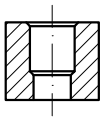
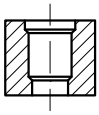
KARCAN cutting tools

Special Tools

SOLID CARBIDE STEP TX DRILL

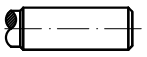
Solid Carbide
Step Twist Drill

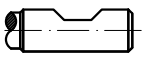
KARCAN cutting tools

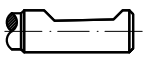
Machining Type	Material To be Machined		Machine Information	
☐  ☐ 	☐ Unalloyed Steel	☐ Aluminium SI>%10	Machine Brand	
Type	☐ Cast Steel	☐ Aluminium SI<%10	Machine Type	
☐ Throught Bore ☐ Blind Bore	☐ Alloyed Steel	☐ Copper	Machine Power (kW)	
Machining Method	☐ Inox	☐ Brass	Max. Speed (RPM)	
☐ Dry ☐ Wet ☐ Min.Lubr.	☐ Stainless/Aside Dayanıklı	☐ Bronz	Working Plane	☐ Vert. ☐ Horiz. ☐ 5 Axis
Coolant Supply	☐ Gray Cast	☐ Titanium Alloys	Working Type	☐ Work Piece Turning ☐ Cutting Tool Turning
☐ Ext.  ☐ Int. 	☐ Alloyed Cast	☐ Nickel Alloys	Internal Coolant	☐ Yes ☐ No Pressure
	☐ Sfrero Cast	☐ Cold Cast Iron	Spindle Type	
	☐ Forged Steel	☐ Hardened Steel	Holder Type	
			Axis the Tool Operates	
			Coolant	
			☐ Oil	☐ Boron Oil

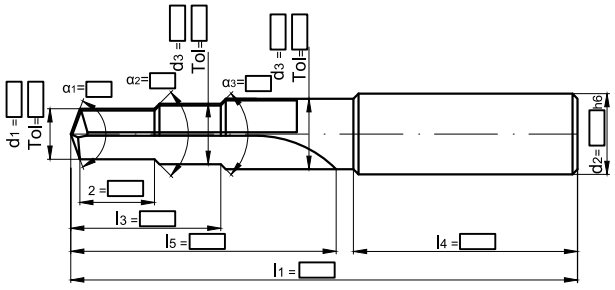
Hardness (HRc, HB, etc.)	Surface Quality Demanded	Additional Features and Notes
Tensile Strenght (N/mm²)	**Cutting Direction(If not stated we will assume RH.)**	
	☐ L.H. ☐ R.H.	
Standard No	**Coating**	

Shank Form

HA(DIN 6535) ☐ 

HB(DIN 6535) ☐ 

HE(DIN 6535) ☐ 



Note		Phn-Fax	
Company Name		E-mail	
Authorized Person		Date and Sign	
Address			

Note: Work area details should be drawn roughly, if possible it is recommended that the technical drawing should be provided among with the form

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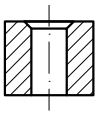
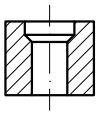
KARCAN cutting tools

Special Tools

SOLID CARBIDE STEP TX DRILL

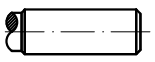
Solid Carbide
Step Twist Drill

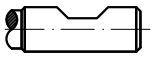
KARCAN cutting tools

Machining Type	Material To be Machined		Machine Information	
☐  ☐ 	☐ Unalloyed Steel	☐ Aluminium SI>%10	Machine Brand	
	☐ Cast Steel	☐ Aluminium SI<%10	Machine Type	
	☐ Alloyed Steel	☐ Copper	Machine Power (kW)	
	☐ Inox	☐ Brass	Max. Speed (RPM)	
	☐ Stainless/Aside Dayanıklı	☐ Bronz	Working Plane	☐ Vert. ☐ Horiz. ☐ 5 Axis
	☐ Gray Cast	☐ Titanium Alloys	Working Type	☐ Work Piece Turning ☐ Cutting Tool Turning
	☐ Alloyed Cast	☐ Nickel Alloys	Internal Coolant	☐ Yes ☐ No Pressure
	☐ Sfrero Cast	☐ Cold Cast Iron	Spindle Type	
	☐ Forged Steel	☐ Hardened Steel	Holder Type	
			Axis the Tool Operates	
			Coolant	
			☐ Oil	☐ Boron Oil
Type				
☐ Throught Bore ☐ Blind Bore				
Machining Method				
☐ Dry ☐ Wet ☐ Min.Lubr.				
Coolant Supply				
☐ Ext.  ☐ Int. 				

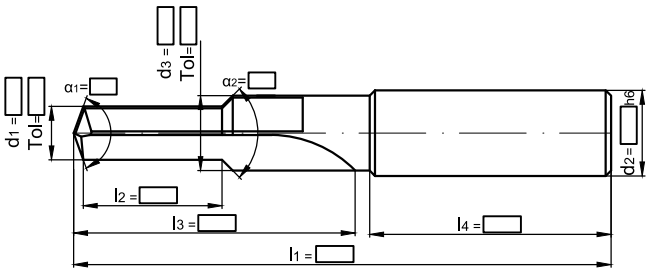
Hardness (HRc, HB, etc.)	Surface Quality Demanded	Additional Features and Notes
Tensile Strenght (N/mm²)	**Cutting Direction(If not stated we will assume RH.)**	
	☐ L.H. ☐ R.H.	
Standard No	**Coating**	

Shank Form

HA(DIN 6535) ☐ 

HB(DIN 6535) ☐ 

HE(DIN 6535) ☐ 



Note		Phn-Fax	
Company Name		E-mail	
Authorized Person		Date and Sign	
Address			

Note: Work area details should be drawn roughly, if possible it is recommended that the technical drawing should be provided among with the form

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KARCAN cutting tools

Special Tools

SOLID CARBIDE REAMER

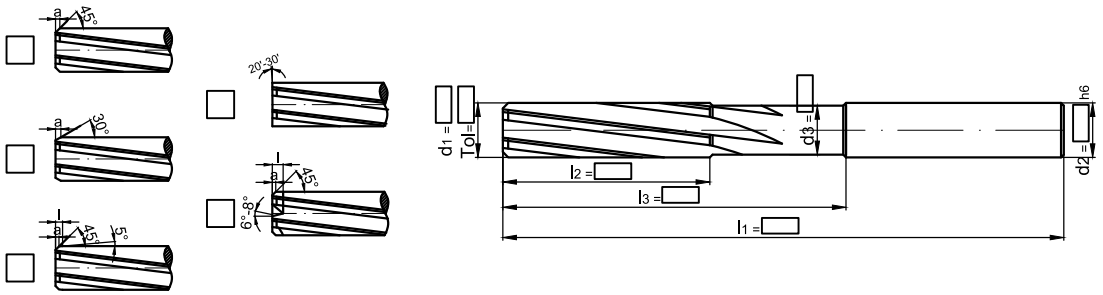
Solid Carbide
Step Twist Drill

KARCAN cutting tools

Type	Material To be Machined		Machine Information	
☐ Throught Bore ☐ Blind Bore	☐ Unalloyed Steel	☐ Aluminium SI>%10	Machine Brand	
Machining Method	☐ Cast Steel	☐ Aluminium SI<%10	Machine Type	
☐ Dry ☐ Wet ☐ Min.Lubr.	☐ Alloyed Steel	☐ Copper	Machine Power (kW)	
Coolant Supply	☐ Inox	☐ Brass	Max. Speed (RPM)	
☐ Ext.  ☐ Int.  ☐ Ext. 	☐ Stainless/Aside Dayanıklı	☐ Bronz	Working Plane	☐ Vert. ☐ Horiz. ☐ 5 Axis
	☐ Gray Cast	☐ Titanium Alloys	Working Type	☐ Work Piece Turning ☐ Cutting Tool Turning
	☐ Alloyed Cast	☐ Nickel Alloys	Internal Coolant	☐ Yes ☐ No Pressure
	☐ Sfrero Cast	☐ Cold Cast Iron	Spindle Type	
	☐ Forged Steel	☐ Hardened Steel	Holder Type	
			Axis the Tool Operates	
			Coolant	
			☐ Oil	☐ Boron Oil

Hardness (HRc, HB, etc.)	Surface Quality Demanded	Additional Features and Notes
Tensile Strenght (N/mm²)	**Cutting Direction(If not stated we will assume RH.)**	
	☐ L.H. ☐ R.H.	
Standard No	**Coating**	

Shank Form



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KARCAN cutting tools

Karcan reserves the right to revise or alter all items and technical specifications in this catalogue without prior notice.

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The cutting parameters and feed rates stated in this catalogue are recommended values; Karcan does not bear any responsibility for machine and equipment breakdowns.

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