



KDA

3=4



WINTER PROMOTION

KDA

VERSATILE AND COST EFFECTIVE

Highly versatile drill series in three styles available starting from Ø1 mm with coolant supply. QDA provides good chip control and long tool life.

Purchase 3 drills and get
1 same drill free of charge!

ORDER NOW

General conditions

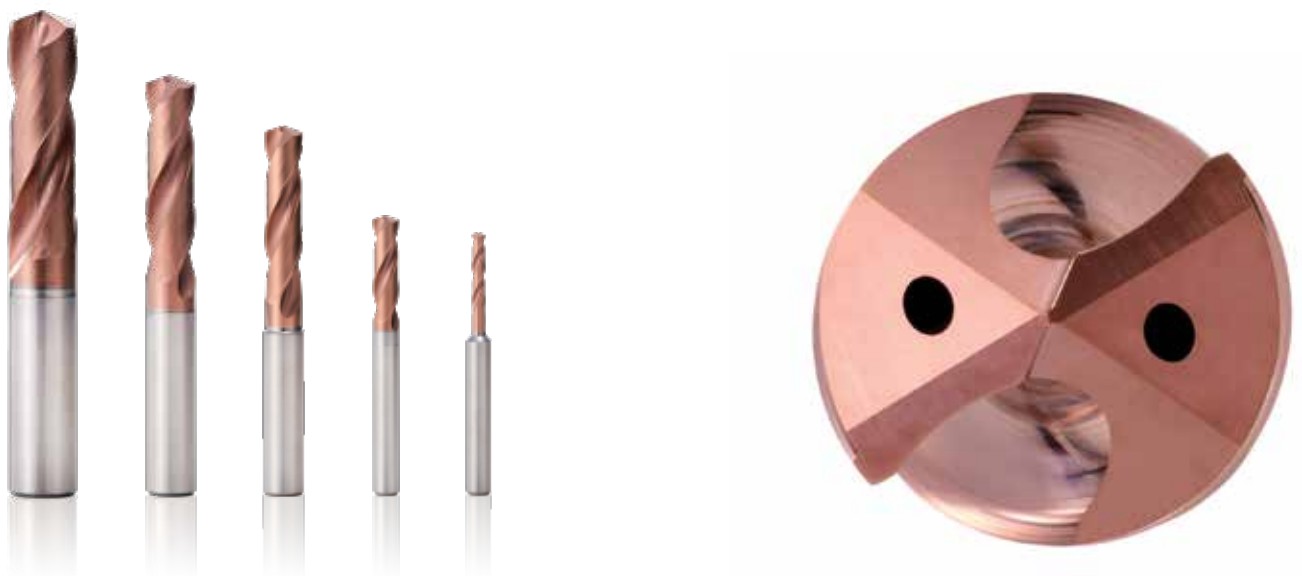
- The promotion is valid from October 2nd 2024 until March 27th 2025.
- Different chipbreakers can be mixed to reach the required insert quantity.
- Orders on schedule, combination with other special offer, cancellation, exchange and return cannot be accepted.
- Errors excepted, with reservation subject to change.

KDA



Highly efficient new general purpose solid carbide drill

High-precision design for a wide variety of machining solutions



New high efficiency coated solid carbide drill

KDA

KDA is for excellent all-around drilling performance.
Large lineup accomodates a wide variety of applications.

Styles available

Type N Normal type

General purpose design without coolant holes
Economical style for machining with external coolant

Diameter
range

3D

5D

ø3~ø16

Cutting diameters available in 0.1 mm increments



Type C with Coolant hole

Coolant-through design
Provides higher efficiency and stable machining with stainless steel, etc.

Diameter
range

3D

5D

ø3~ø16

Cutting diameters available in 0.1 mm increments







1

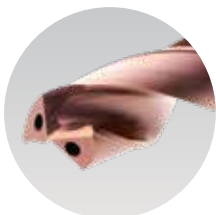
Applicable to a wide range of machining applications

Type N: No coolant holes
 Type C: With coolant holes
 3D and 5D depths available



3D / 131 Items

5D / 131 Items



3D / 131 Items

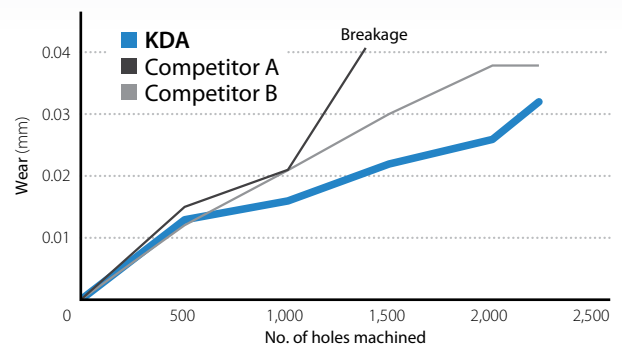
5D / 131 Items

2

High-performance coating maintains long tool life

Excellent wear and heat resistance
 Aluminum Chrome (AlCr) coating

Wear resistance comparison (Internal evaluation)



Cutting conditions: Vc = 120 m/min, f = 0.23 mm/rev, H = 24 mm, Wet (Internal coolant) C50, BT 50, ø6 mm, 5xD, type C



KDA



Competitor B



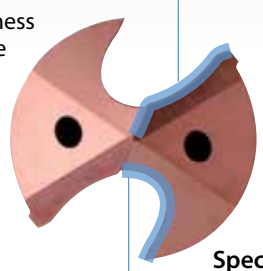
3

Stable machining with unique shape

Curved cutting-edge design and special flute shape

Curved cutting-edge design

Excellent sharpness and cutting edge strength



Special flute shape

Excellent chip control and high rigidity



Chip condition

(Internal evaluation)

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

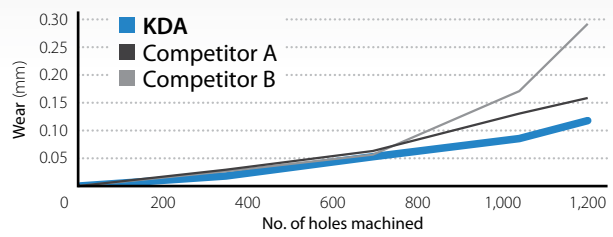
KDA

4

Supports a variety of workpieces

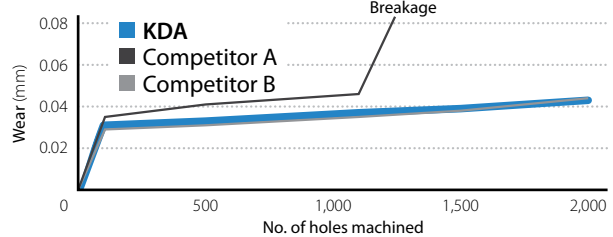
Compatible not only with carbon steel, but also mold steel, stainless steel, cast iron machining, etc.

Alloy steel 42CrMo4 (32 HRC) (Internal evaluation)



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

Stainless steel X5CrNi18-9 (Internal evaluation)



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

Type N No coolant holes

3D

Carbide

140°

22°~32°

h6

m7

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

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

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

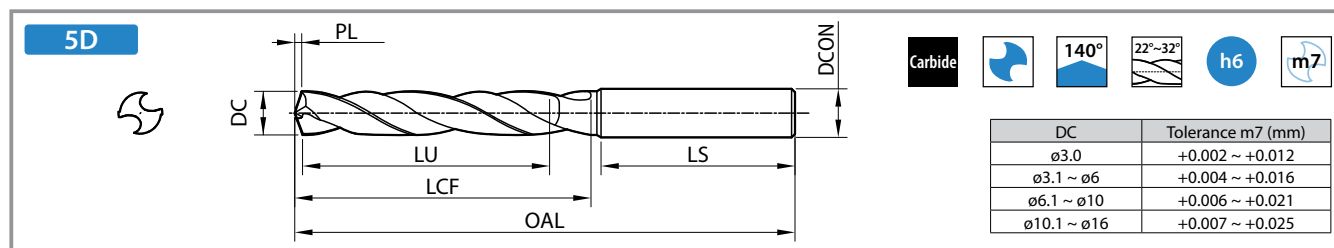
Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0960X03S100N	●	9.6	10	89	32.6	47	40	1.7
KDA0970X03S100N	●	9.7	10	89	32.4	47	40	1.7
KDA0980X03S100N	●	9.8	10	89	32.3	47	40	1.7
KDA0990X03S100N	●	9.9	10	89	32.1	47	40	1.8
KDA1000X03S100N	●	10	10	89	32.0	47	40	1.8
KDA1010X03S120N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

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

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

● : Available

Type N No coolant holes



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

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

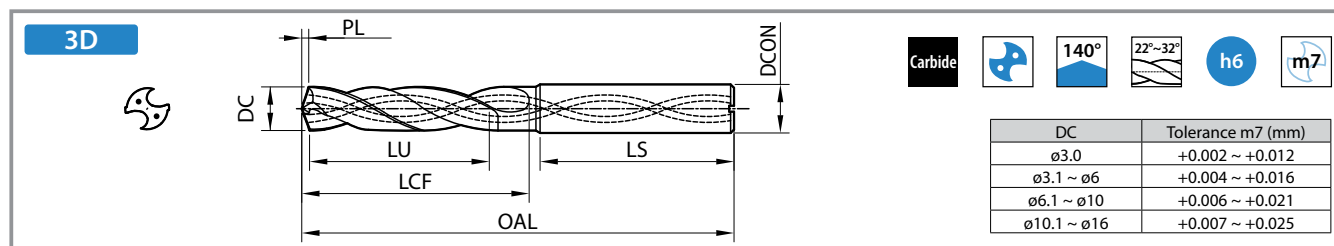
Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0960X05S100N	●	9.6	10	103	46.6	61	40	1.7
KDA0970X05S100N	●	9.7	10	103	46.4	61	40	1.7
KDA0980X05S100N	●	9.8	10	103	46.3	61	40	1.7
KDA0990X05S100N	●	9.9	10	103	46.1	61	40	1.8
KDA1000X05S100N	●	10	10	103	46.0	61	40	1.8
KDA1010X05S120N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

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

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

● : Available

Type C with coolant holes



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

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

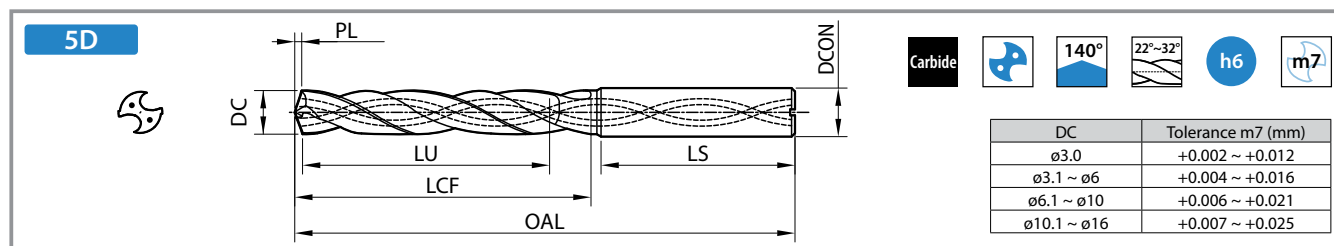
Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0960X03S100C	●	9.6	10	89	32.6	47	40	1.7
KDA0970X03S100C	●	9.7	10	89	32.4	47	40	1.7
KDA0980X03S100C	●	9.8	10	89	32.3	47	40	1.7
KDA0990X03S100C	●	9.9	10	89	32.1	47	40	1.8
KDA1000X03S100C	●	10	10	89	32.0	47	40	1.8
KDA1010X03S120C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

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

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

● : Available

Type C with coolant holes



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

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

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

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

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

● : Available

Icon glossary



Coolant holes



No coolant holes



Cutting-edge angle



Helix angle





Shank dia. DCON tolerance



Cutting dia. DC tolerance

Reference cutting conditions table

KDA **3D** **5D**

Workpiece	Vc (m/min)		f (mm/rev)							
	Type N 	Type C 	ø3	ø4	ø6	ø8	ø10	ø12	ø14	ø16
Mild steel / Low carbon steel (< 125 HB)	50-100	60-140	0.09-0.16	0.11-0.19	0.14-0.23	0.19-0.31	0.23-0.38	0.24-0.41	0.28-0.45	0.30-0.50
Carbon steel (< 25 HRC)	45-90	60-120	0.09-0.16	0.11-0.19	0.14-0.23	0.19-0.31	0.23-0.38	0.24-0.41	0.28-0.45	0.30-0.50
Alloy steel / Tool steel (< 35 HRC)	45-90	50-110	0.09-0.16	0.11-0.19	0.14-0.23	0.19-0.31	0.23-0.38	0.24-0.41	0.28-0.45	0.30-0.50
Alloy steel / Tool steel (35-48 HRC)	40-80	40-90	0.09-0.14	0.10-0.17	0.13-0.22	0.17-0.29	0.21-0.35	0.22-0.37	0.26-0.41	0.28-0.44
Austenitic stainless steel (130-200 HB)	20-40	40-80	0.05-0.10	0.06-0.12	0.07-0.14	0.08-0.18	0.09-0.20	0.10-0.22	0.11-0.24	0.12-0.24
High strength austenitic stainless steel and stainless cast steel (< 25 HRC)	20-40	40-80	0.03-0.08	0.04-0.10	0.05-0.10	0.06-0.12	0.07-0.14	0.08-0.16	0.09-0.18	0.10-0.18
Austenitic-ferritic stainless steel (< 30 HRC)	20-35	30-60	0.03-0.08	0.04-0.10	0.05-0.10	0.06-0.12	0.07-0.14	0.08-0.16	0.09-0.18	0.10-0.18
Gray cast iron (< 32 HRC)	60-100	60-140	0.13-0.20	0.15-0.23	0.17-0.30	0.20-0.35	0.23-0.40	0.25-0.45	0.28-0.48	0.30-0.50
Alloy cast iron / Nodular cast iron (< 28 HRC)	60-100	60-140	0.11-0.18	0.13-0.20	0.15-0.25	0.17-0.32	0.20-0.36	0.22-0.42	0.24-0.45	0.25-0.48
High alloy cast iron and nodular cast iron (< 45 HRC)	60-90	60-100	0.06-0.11	0.08-0.13	0.10-0.16	0.12-0.20	0.14-0.26	0.16-0.28	0.18-0.30	0.20-0.32

Precautions

1. Make sure the workpiece is fixed firmly to the machine.
Use of precision holders, hydro chucks, and high-quality collet chucks is recommended.
2. Run out of tool should be in range of 0,02 mm by mounting
3. Standard cutting conditions is when water-soluble coolant is applied.
4. If the tool diameter you want to use is not listed in the table, please refer to the closest tool diameter value in the table.
Adjust the cutting parameters according to your working environment in machining.

Description's view

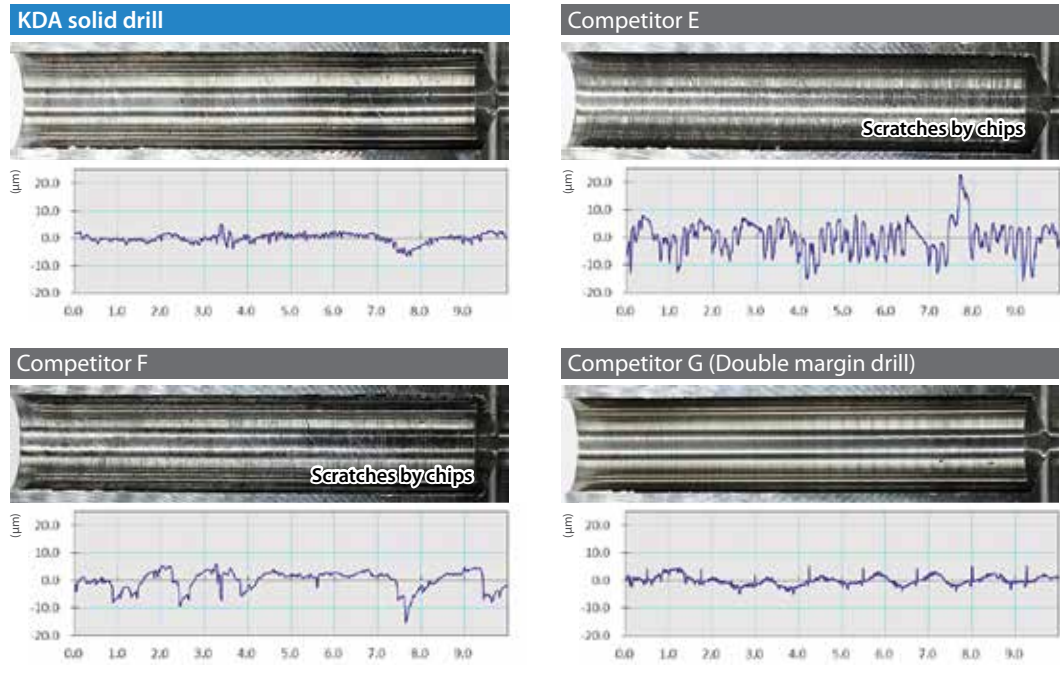
KDA0950X03S100C

KDA	0950	X	03	S100	C
Product name	Cutting dia. DC ø9.5	Drilling depth* (L/D) 03 : 3D 05 : 5D	Shank dia. DCON ø10.0	Type N: No coolant holes C: With coolant holes	

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

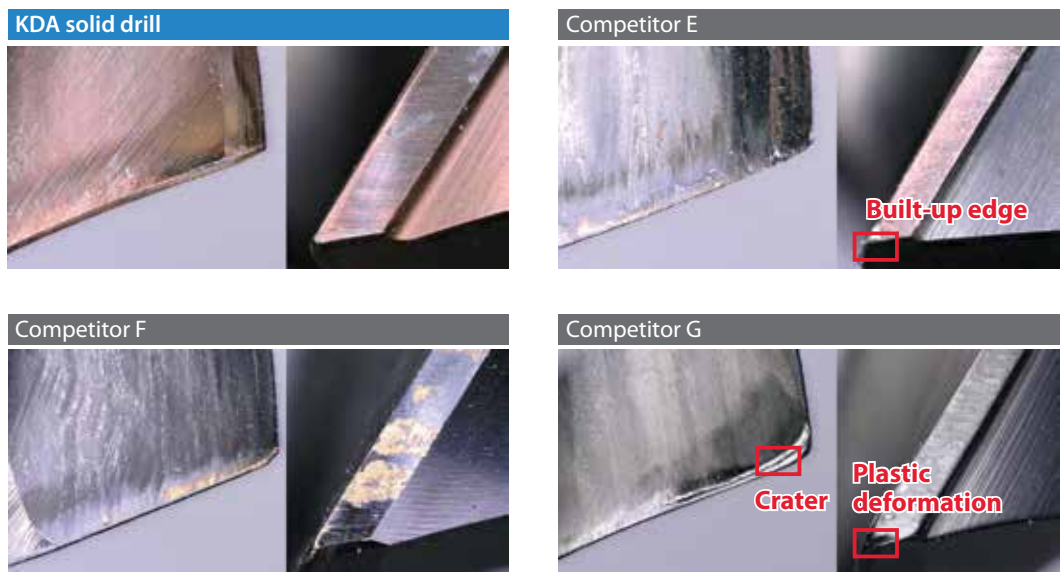
Case studies

Finished surface comparison (Internal evaluation)



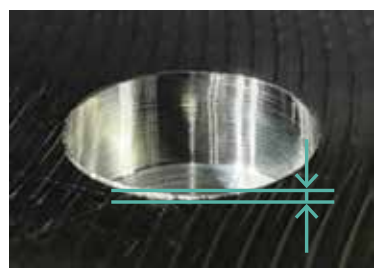
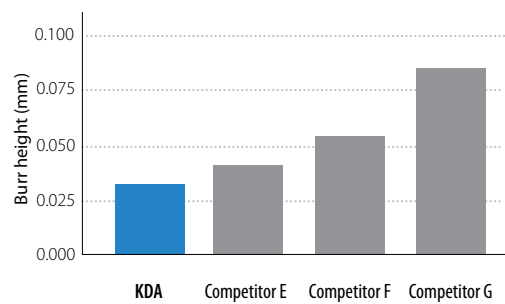
Cutting conditions: ϕ 8.0 mm, 5xD, 42CrMo4, $v_c = 90$ m/min, $f = 0.20$ mm/rev, hole depth = 40 mm, wet (internal supply), 640 holes (36 m / 26 min.)

Corner wear comparison (Internal evaluation)



Cutting conditions: ϕ 8.0 mm, 5xD, 42CrMo4, $v_c = 90$ m/min, $f = 0.20$ mm/rev, hole depth = 40 mm, wet (internal supply), 640 holes (36 m / 26 min.)

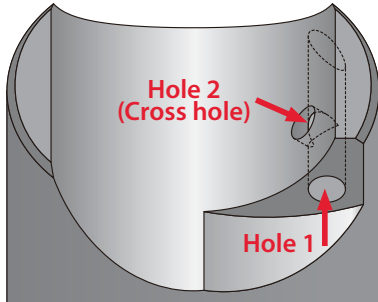
Burr height comparison (Internal evaluation)



Cutting conditions: ϕ 8.0 mm, 5xD, 42CrMo4, $v_c = 90$ m/min, $f = 0.20$ mm/rev, wet (internal supply)

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

Body 42CrMo4
 ø6.9, Drilling



Type C
 KDA0690X05S080C

Tool life

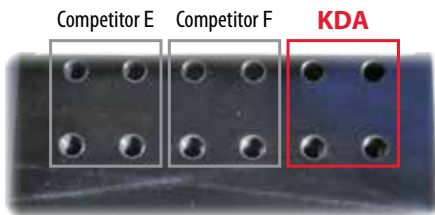
KDA 2,400 pcs or more/tool

Competitor C
 Competitor D 2,000 pcs/tool

Cutting conditions:
 Hole 1: Vc = 50 m/min, f = 0.1 mm/rev, H = 25 mm
 Hole 2: Vc = 40 m/min, f = 0.1 mm/rev, H = 15 mm
 Wet (Internal coolant), Turn-mill center

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

Mold part cold tool steel
 ø5.1, Drilling



Type N
 KDA0510X03S060N

Hole diameter variation (H = 7.5 mm)

KDA 0.022 mm

Competitor E 0.042 mm

Cutting conditions:
 Vc = 80 m/min, f = 0.15 mm/rev, H = 15 mm
 Wet (External coolant), BT50