

K-series**高效率
硬质合金涂层整体型钻头****KDA**

追求高效率・低成本的平衡性
通用性优质的硬质合金整体型钻头
终于登场！

兼具高效率及高精度的同时
更可对应市场的多种需求
开始新时代的解决方案。



始终专注降本提

高效率 硬质合金涂层整体型钻头

KDA

拉开新时代的序幕！ K-series 诞生

追求高效率·低成本的平衡性、新商品系列终于登场。

充实的产品阵容、可对应多种多样的加工用途。

充实的产品阵容可供选择



Type N

Normal type

无内冷孔的通用型

实现高性价比。使用外冷加工时可选用此型号

产品阵容

3D

5D

φ3~φ16

产品阵容以加工直径的 0.1mm 为单位展开



Type C

with Coolant hole

带内冷孔规格可对应内冷加工

可实现不锈钢等的高效率·稳定加工

产品阵容

3D

5D

φ3~φ16

产品阵容以加工直径的 0.1mm 为单位展开



效不遗余力


K-series
Let your potential shine





特点

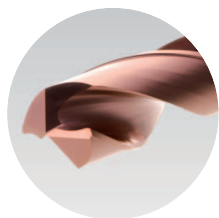
1

追求通用性的设计及产品阵容
可对应多种加工

Type N: 无内冷孔

Type C: 有内冷孔

分别有3D及5D产品阵容



3D/131 型号

5D/131 型号



3D/131 型号

5D/131 型号

特点

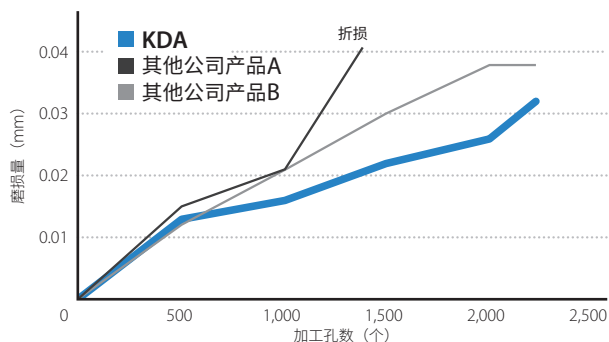
2

实现长寿命加工
高性能涂层

耐磨损性・耐热性能优良

采用铝铬(AlCr)系涂层

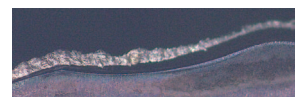
耐磨损性对比 (本公司对比)



切削参数: $V_c=120\text{m/min}$, $f=0.23\text{mm/rev}$, $H=24\text{mm}$, Wet (内冷)
50#钢 BT50 $\phi 6$ (5D) Type C



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其他公司产品B



特点

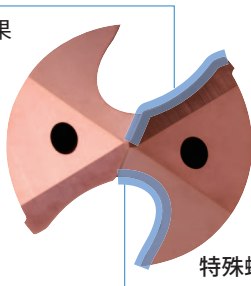
3

特殊形状可实现稳定加工

波型设计的切刃及特殊螺旋槽形状

波型设计的切刃

兼具优良切削效果
与刀尖强度



特殊螺旋槽形状

兼具优质切屑处理性能
与高刚性



KDA

切屑状态 (公司内部测试)

切削参数:
Vc=80m/min, f=0.14mm/rev,
H=24mm, Wet (内冷)
BT50 ø6 (5D) Type C

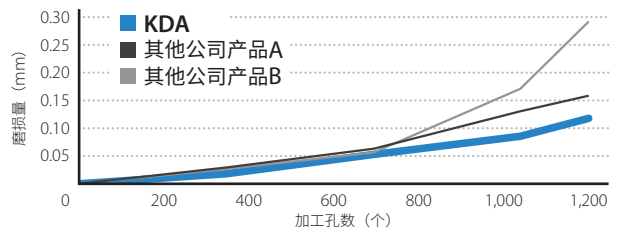
特点

4

可对应多种加工材料

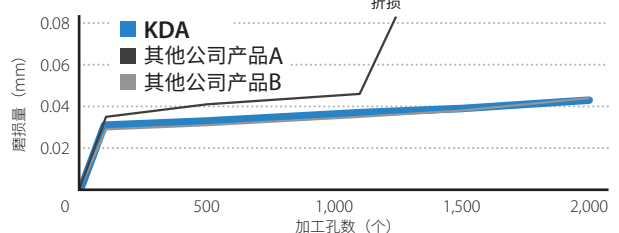
不只是碳钢、模具钢、
不锈钢、铸铁加工等皆可对应

合金钢 43CrMo (32HRC) (本公司对比)

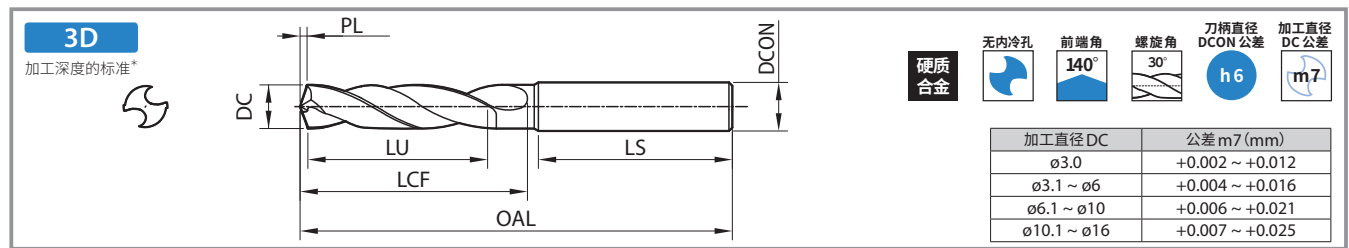


切削参数: Vc=100m/min, f=0.15mm/rev, H=24mm, Wet (内冷)
BT50 ø6 (5D) Type C

不锈钢 0Cr18Ni9 (本公司对比)



切削参数: Vc=80m/min, f=0.14mm/rev, H=24mm, Wet (内冷)
BT50 ø6 (5D) Type C



型号	库存	尺寸 (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

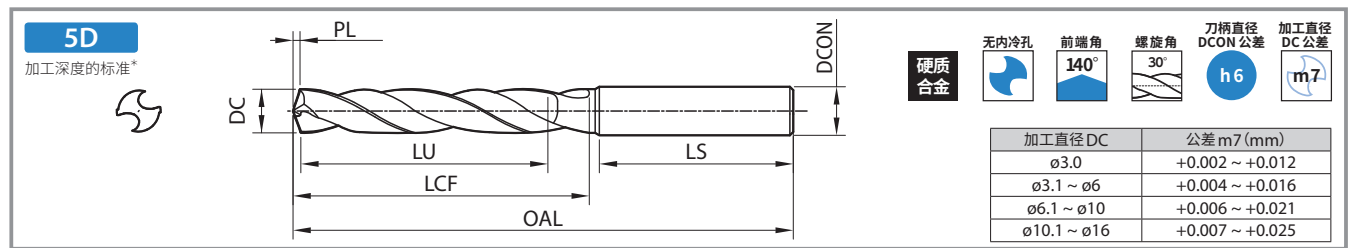
型号	库存	尺寸 (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0630X03S080N	●	6.3	8	79	24.5	34	36	1.1
KDA0640X03S080N	●	6.4	8	79	24.4	34	36	1.1
KDA0650X03S080N	●	6.5	8	79	24.2	34	36	1.1
KDA0660X03S080N	●	6.6	8	79	24.1	34	36	1.2
KDA0670X03S080N	●	6.7	8	79	23.9	34	36	1.2
KDA0680X03S080N	●	6.8	8	79	23.8	34	36	1.2
KDA0690X03S080N	●	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

型号	库存	尺寸(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

型号	库存	尺寸(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

*加工深度L/D的推荐值
根据尺寸有可能比记载的L/D小

●：标准库存



型号	库存	尺寸 (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

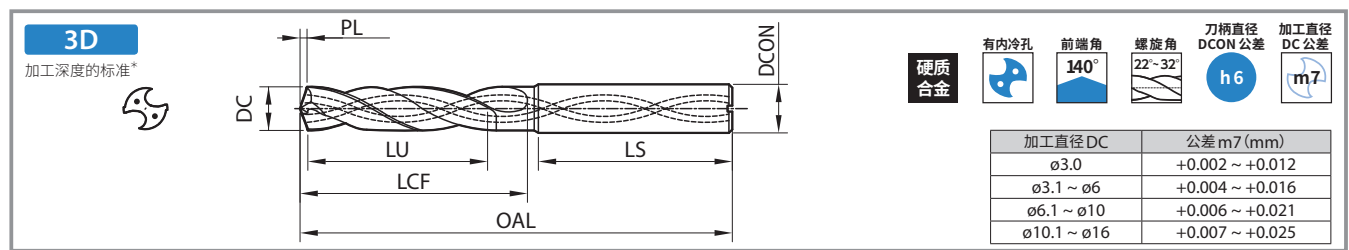
型号	库存	尺寸 (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0630X05S080N	●	6.3	8	91	43.5	53	36	1.1
KDA0640X05S080N	●	6.4	8	91	43.4	53	36	1.1
KDA0650X05S080N	●	6.5	8	91	43.2	53	36	1.1
KDA0660X05S080N	●	6.6	8	91	43.1	53	36	1.2
KDA0670X05S080N	●	6.7	8	91	42.9	53	36	1.2
KDA0680X05S080N	●	6.8	8	91	42.8	53	36	1.2
KDA0690X05S080N	●	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

型号	库存	尺寸(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

型号	库存	尺寸(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

*加工深度L/D的推荐值
根据尺寸有可能比记载的L/D小

●：标准库存



型号	库存	尺寸 (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

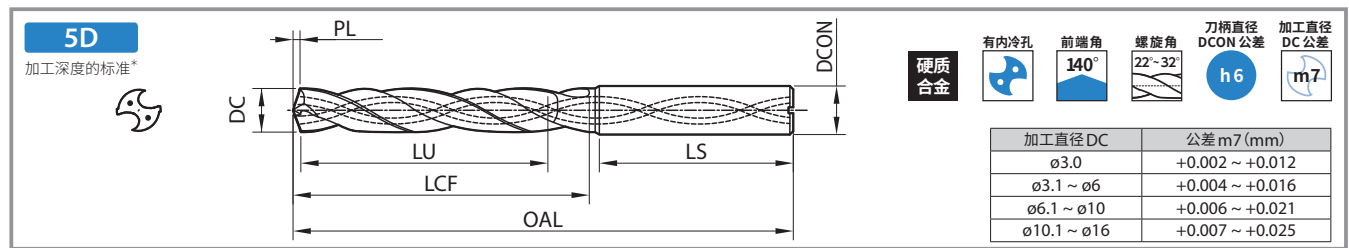
型号	库存	尺寸 (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0630X03S080C	●	6.3	8	79	24.5	34	36	1.1
KDA0640X03S080C	●	6.4	8	79	24.4	34	36	1.1
KDA0650X03S080C	●	6.5	8	79	24.2	34	36	1.1
KDA0660X03S080C	●	6.6	8	79	24.1	34	36	1.2
KDA0670X03S080C	●	6.7	8	79	23.9	34	36	1.2
KDA0680X03S080C	●	6.8	8	79	23.8	34	36	1.2
KDA0690X03S080C	●	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

型号	库存	尺寸(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

型号	库存	尺寸(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

*加工深度L/D的推荐值
根据尺寸有可能比记载的L/D小

●：标准库存



型号	库存	尺寸 (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

型号	库存	尺寸 (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

型号	库存	尺寸(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

型号	库存	尺寸(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

*加工深度L/D的推荐值
根据尺寸有可能比记载的L/D小

●：标准库存

标准切削参数表

K-series 3D 5D

加工材料	切削速度 Vc (m/min)		进给 f (mm/rev)							
	Type N	Type C	ø3	ø4	ø6	ø8	ø10	ø12	ø14	ø16
软钢・低碳钢 (< 125HB)	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
碳钢 (< 25HRC)	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
合金钢・工具钢 (< 35HRC)	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
合金钢・工具钢 (35-48HRC)	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
奥氏体系不锈钢 (130-200HB)	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
高强度奥氏体系不锈钢・不锈钢铸钢 (< 25HRC)	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
奥氏体系铁素体不锈钢 (< 30HRC)	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
灰口铸铁 (< 32HRC)	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
合金铸铁・球墨铸铁 (< 28HRC)	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
高合金铸铁・球墨铸铁 (< 45HRC)	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

- 注意
- 1. 请确认工件已确实地固定在设备上
推荐使用精密刀杆、液压卡盘和高质量筒夹卡盘
 - 2. 安装时请确保钻头的跳动在0.02mm以下
 - 3. 标准切削参数为使用水溶性切削油时的数值
 - 4. 使用工具直径不在表中时，请参考表中最接近的工具直径的数据
请根据加工中的实际作业环境对切削参数进行调整

型号的确认方法

例：KDA0950X03S100C

KDA	0950	X	03	S100	C
产品名 高效率 硬质合金涂层 整体型钻头	加工直径 DC ø9.5	加工深度* (L/D) 03 : 3D 05 : 5D	刀柄直径 DCON ø10.0	Type N : 无内冷孔 C : 有内冷孔	

*加工深度为L/D的推荐值，根据尺寸有所不同。
有时可能会比记载的L/D小，此时请确认尺寸表。

- 1 KDA在加工现有设定寿命的120%后，台阶部位的磨损量仍然比其他公司产品的少，刀尖状态依然良好

Type C



阀体 42CrMo
ø6.9 (5D) 开孔

加工数量

KDA

2,400 个以上/根

其他公司产品C
其他公司产品D

2,000 个/根

切削参数：

孔1：Vc = 50 m/min, f = 0.1 mm/rev, H = 25 mm

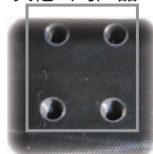
孔2：Vc = 40 m/min, f = 0.1 mm/rev, H = 15 mm

Wet (内冷) 车铣复合 KDA0690X05S080C

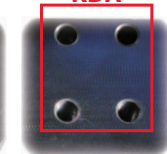
- 2 与其他公司产品相比，KDA的加工偏差小、可实现高精度加工
加工时安静且切屑状态良好

Type N

其他公司产品E



KDA



模具零件 冷轧工具钢
ø5.1 (3D) 开孔

孔径偏差 (H=7.5mm 位置)

KDA

0.022 mm

其他公司产品E

0.042 mm

切削参数：

Vc = 80 m/min, f = 0.15 mm/rev, H = 15 mm

Wet (外冷) BT50 KDA0510X03S060N

- 3 KDA在加工不锈钢时可实现2.3倍以上寿命的稳定加工
其他公司产品会发生突发性崩损不稳定

Type C



6孔加工

喷嘴 0Cr18Ni9
ø5.5 (3D) 开孔
(后工程精加工至ø6.0)

KDA刀尖状态：良好
(加工5,600个孔后)



加工数量

KDA

5,600 孔以上/根

其他公司产品F

2,400 孔/根

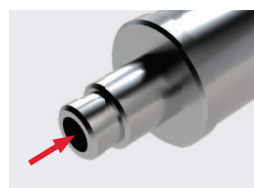
切削参数：

Vc = 30 m/min, f = 0.06 mm/rev, H = 9 mm

Wet (内冷) KDA0550X03S060C

- 4 KDA可实现1.2倍寿命的稳定加工
其他公司产品加工不稳定、加工1批工件需要2根刀具
KDA用1根刀具即可对应

Type N



轴 0Cr17Ni4CuNb
ø5.1 (3D) 开孔

加工数量

KDA

1,000 个/根

其他公司产品G

500~800 个/根 (不稳定)

切削参数：

Vc = 50 m/min, f = 0.1 mm/rev, H = 10 mm

Wet (外冷) KDA0510X03S060N

- 5 KDA在达到其他公司产品相同设定寿命为止都可良好地加工实现成本削减

Type N



阀 不锈钢
ø3.5 (3D) 开孔

加工数量

KDA

2,400 个/根

其他公司产品H

2,400 个/根

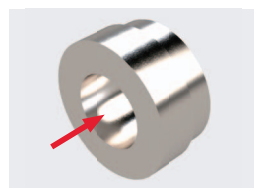
切削参数：

Vc = 30 m/min, f = 0.1 mm/rev, H = 10 mm (3mm 台阶)

Wet (外冷) 自动车床 KDA0350X03S060N

- 6 KDA可良好地加工
与其他公司产品相比寿命达到1.3倍以上

Type N



底座 45
ø11.6 (3D) 开孔

加工数量

KDA

6,800 个/根

其他公司产品I

5,000 个/根

切削参数：

Vc = 54 m/min, f = 0.22 mm/rev, H = 30 mm

Wet (外冷) 车铣复合 KDA1160X03S120N



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