

# Indexable Drills

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Indexable Drills

		standard						hole tolerance	standard range		customised solution range					
		P	M	K	N	S	H		diameter range	drilling depth L/D1	diameter range	drilling depth				
													D1 mm min - max		D1 mm min - max	
	<b>DFR™</b> Indexable Drill Body Short-Hole Drilling	●	●	●	●	●	IT9-11	12,5–25	2 x D 3 x D 4 x D	12,5–26	1–5 x D					
	<b>DFS™</b> Indexable Drill Body Short-Hole Drilling	●	●	●	●	●	IT9-11	24–55	2 x D 3 x D 4 x D 5 x D	18–55	1–5 x D					
	<b>DFT™</b> Indexable Drill Body Short-Hole Drilling	●	●	●	●	●	IT9-11	16–83mm	2,5 x D 4 x D	15,8–83	1–5 x D					
	<b>HTS-C</b> Indexable Drilling Tool Deep-Hole Drilling	●	●	●	●	●	IT9-11	20–45	5 x D 8 x D	19,05–45	1–20 x D					
	<b>HTS-R</b> Indexable Drilling Tool Deep-Hole Drilling	●	●	●	●	●	IT9-11	40–55	10 x D	40–55	1–10 x D					
	<b>HTS</b> Indexable Drilling Tool Deep-Hole Drilling	●	●	●	●	●	IT9-11	45–270	10 x D	45–540	1–10 x D					
	<b>S2 S Countersinking</b> Countersinking Tool	●	●	●	●	●	IT9-11	15,1–46,2	1 x D	11,5–150	1–5 x D					

In regard to insert and drill coatings, anything is possible. If a specific insert or drill is not suitable for your workpiece material, please contact our Engineered Solutions Department for an offer about special coatings and edge preparations.

\*Except for L/D 5 x D.

<sup>1)</sup> Other shank styles available as customised solution.

		■ standard capabilities <sup>1)</sup>								■ standard and □ customised solution capabilities								
coolant																		page(s)
	■		■ ■	■					■	■	■	■	■	□	□			J8- J13
	■		■ ■	■	■				■	■	■	■	■*	□	□		□	J15- J22
	■		■ ■	■	■				■	■	■	■	■	□	□			J24- J31
	■		■ ■						■						□			J35- J39
	■			■		■	■	■	■									J51- J54
	■			■		■	■	■	■									J56- J67
	■	■													■	□		J77- J79

Indexable Drills

# Drill Fix™ DFT™

Drill Fix DFT is available in the diameter range 24–82mm as a versatile and reliable tool solution with a large portfolio of lengths, insert geometries, and grades.

Balanced cutting forces, improved chip flute, and coolant-channel design enable high metal removal rates and long tool body life. The trigon-shaped DFT inserts are used for both inboard and outboard inserts and offer the highest centring capabilities and three cutting edges each.

## Features and Benefits

### Productivity and Profitability

- Achieve high hole accuracy with trigon-shaped inboard inserts that offer the highest centring capabilities.
- Use X-offset on turning machines to adjust the drill diameter, eliminating the need for specials in many applications and on machining centres to reach tolerance optimisation.
- Same insert size is used in each pocket reducing inventory costs.

### Versatility

Use Drill Fix DFT as most versatile and reliable indexable drilling tool:

- Diameter range covering 24–82mm.
- 2,5 x D and 4 x D L/D ratios are standard.
- Various shanks available as standard: WD, SSF, and new KM-TS™.
- Trigon-shaped inserts offer three cutting edges.
- Large variety of DFT insert grades and geometries available.
- Apply DFT drills to straight holes, inclined entries and exits, interrupted cuts, and rough or welded entry surfaces.
- Eccentric chuck available as standard.

### Reliability

- Highest centring capabilities due to trigon-shaped insert.
- Same insert can be used as inboard or outboard insert — no risk of mixing up inner and outer inserts.
- Benefit from improved chip flute and coolant-channel design resulting in long tool body life and excellent chip evacuation.

### Customisation

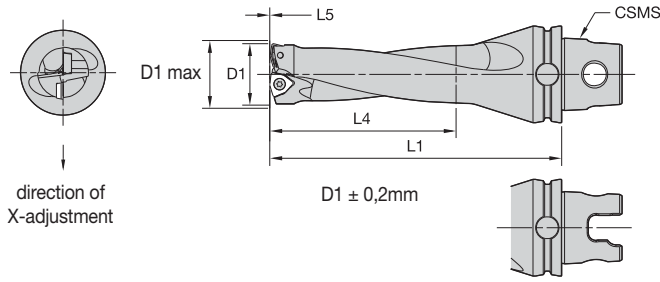
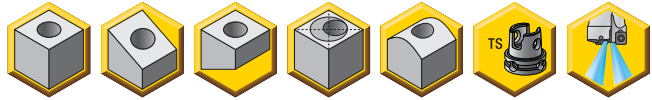
- Intermediate diameters available as semi-standards.
- Engineered solutions available.
- Multistep drills available upon request.
- Stacked material version.



To learn more, [scan here](#).  
For instructions on how to scan, please see page xxix.



- Drill shipped with insert screws and Torx wrench.
- See page J70 for inserts.



Indexable Drills

■ KM40TS, KM50TS, KM63TS, and KM63XMZ Shanks • 3 x D • Metric

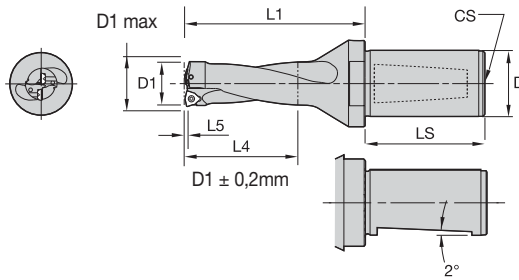
KM40TS		KM50TS		KM63TS		KM63XMZ		D1 mm	D1 max	L1	L4 max	L5	gage insert
KM40TSDFT250R3M	KM50TSDFT250R3M	KM63TSDFT250R3M	KM63XMZDFT250R3YM	25,00	27,00	119,0	75,0	0,9	DFT05T3..				
KM40TSDFT270R3M	KM50TSDFT270R3M	KM63TSDFT270R3M	KM63XMZDFT270R3YM	27,00	29,00	126,0	81,0	1,1	DFT05T3..				
KM40TSDFT290R3M	KM50TSDFT290R3M	KM63TSDFT290R3M	KM63XMZDFT290R3YM	29,00	31,00	133,0	87,0	1,2	DFT05T3..				
KM40TSDFT310R3M	KM50TSDFT310R3M	KM63TSDFT310R3M	KM63XMZDFT310R3YM	31,00	33,00	140,0	93,0	1,3	DFT05T3..				
—	KM50TSDFT330R3M	KM63TSDFT330R3M	KM63XMZDFT330R3YM	33,00	35,00	147,0	99,0	1,3	DFT06T3..				
—	KM50TSDFT350R3M	KM63TSDFT350R3M	KM63XMZDFT350R3YM	35,00	37,00	154,0	105,0	1,5	DFT06T3..				
—	KM50TSDFT380R3M	KM63TSDFT380R3M	KM63XMZDFT380R3YM	38,00	40,00	164,0	114,0	1,7	DFT06T3..				
—	—	KM63TSDFT410R3M	KM63XMZDFT410R3YM	41,00	43,00	175,0	123,0	1,8	DFT0704..				
—	—	KM63TSDFT440R3M	KM63XMZDFT440R3YM	44,00	46,00	185,0	132,0	2,0	DFT0704..				
—	—	KM63TSDFT470R3M	KM63XMZDFT470R3YM	47,00	49,00	196,0	141,0	2,2	DFT0704..				

**WARNING**

During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

gage insert	insert screw	Torx wrench	Torx size
DFT05T3..	191.924	170.024	9
DFT06T3..	191.848	170.025	15
DFT0704..	191.698	170.025	15

- Drill shipped with insert screws and Torx wrench.
- See pages J70 for inserts.


**WN/WD Shank • 2,5 x D • Metric**

D			D1					gage insert
32	40	50	mm	D1 max	L1	L4 max	L5	
DFT250R2WD32M	DFT250R2WD40M	—	25,00	27,00	90,0	58,9	0,9	DFT05T3..
DFT260R2WD32M	DFT260R2WD40M	—	26,00	27,00	90,0	59,1	1,1	DFT05T3..
DFT270R2WD32M	DFT270R2WD40M	—	27,00	29,00	100,0	66,1	1,1	DFT05T3..
DFT280R2WD32M	DFT280R2WD40M	—	28,00	29,00	100,0	66,3	1,3	DFT05T3..
DFT290R2WD32M	DFT290R2WD40M	—	29,00	31,00	100,0	66,3	1,3	DFT05T3..
DFT300R2WD32M	DFT300R2WD40M	—	30,00	31,00	115,0	76,4	1,4	DFT05T3..
DFT310R2WD32M	DFT310R2WD40M	—	31,00	33,00	115,0	76,4	1,4	DFT05T3..
DFT320R2WD32M	DFT320R2WD40M	—	32,00	33,00	115,0	76,5	1,5	DFT05T3..
DFT330R2WD32M	DFT330R2WD40M	—	33,00	35,00	115,0	76,4	1,4	DFT06T3..
DFT340R2WD32M	DFT340R2WD40M	—	34,00	35,00	115,0	76,5	1,5	DFT06T3..
DFT350R2WD32M	DFT350R2WD40M	—	35,00	38,00	115,0	76,6	1,6	DFT06T3..
DFT360R2WD32M	DFT360R2WD40M	—	36,00	37,00	115,0	76,8	1,8	DFT06T3..
DFT370R2WD32M	DFT370R2WD40M	—	37,00	38,00	135,0	96,7	1,7	DFT06T3..
DFT380R2WD32M	DFT380R2WD40M	—	38,00	41,00	135,0	96,8	1,8	DFT06T3..
DFT390R2WD32M	DFT390R2WD40M	—	39,00	40,00	135,0	96,9	1,9	DFT06T3..
DFT400R2WD32M	DFT400R2WD40M	—	40,00	41,00	135,0	97,0	2,0	DFT06T3..
DFT410R2WD32M	DFT410R2WD40M	—	41,00	44,00	135,0	96,9	1,9	DFT0704..
DFT420R2WD32M	DFT420R2WD40M	—	42,00	43,00	135,0	96,9	2,0	DFT0704..
DFT430R2WD32M	DFT430R2WD40M	—	43,00	44,00	150,0	112,1	2,1	DFT0704..
DFT440R2WD32M	DFT440R2WD40M	—	44,00	47,00	150,0	112,1	2,1	DFT0704..
—	DFT450R2WD40M	DFT450R2WD50M	45,00	46,00	150,0	112,2	2,2	DFT0704..
—	DFT460R2WD40M	DFT460R2WD50M	46,00	47,00	150,0	112,0	2,3	DFT0704..
—	DFT470R2WD40M	DFT470R2WD50M	47,00	50,00	150,0	111,5	2,4	DFT0704..
—	DFT480R2WD40M	DFT480R2WD50M	48,00	49,00	150,0	111,0	2,4	DFT0704..
—	DFT490R2WD40M	DFT490R2WD50M	49,00	50,00	165,0	117,2	2,2	DFT0905..
—	DFT500R2WD40M	DFT500R2WD50M	50,00	54,00	165,0	117,2	2,2	DFT0905..
—	DFT510R2WD40M	DFT510R2WD50M	51,00	52,00	165,0	117,4	2,5	DFT0905..
—	DFT520R2WD40M	DFT520R2WD50M	52,00	53,00	165,0	117,5	2,6	DFT0905..
—	DFT530R2WD40M	DFT530R2WD50M	53,00	54,00	165,0	117,6	2,6	DFT0905..
—	DFT540R2WD40M	DFT540R2WD50M	54,00	58,00	165,0	117,7	2,7	DFT0905..
—	—	DFT550R2WD50M	55,00	56,00	180,0	125,0	2,7	DFT0905..
—	—	DFT560R2WD50M	56,00	57,00	180,0	125,0	2,8	DFT0905..
—	—	DFT570R2WD50M	57,00	58,00	180,0	125,0	2,9	DFT0905..
—	—	DFT580R2WD50M	58,00	62,00	180,0	125,0	3,0	DFT0905..
—	—	DFT590R2WD50M	59,00	60,00	180,0	125,0	3,0	DFT0905..
—	—	DFT600R2WD50M	60,00	61,00	180,0	125,0	3,1	DFT0905..
—	—	DFT610R2WD50M	61,00	62,00	180,0	125,0	3,2	DFT0905..
—	—	DFT620R2WD50M	62,00	65,00	180,0	125,0	3,2	DFT0905..
—	—	DFT630R2WD50M	63,00	64,00	180,0	125,0	3,3	DFT0905..
—	—	DFT640R2WD50M	64,00	65,00	180,0	125,0	3,4	DFT0905..

(continued)

(WN/WD Shank • 2,5 x D • Metric continued)

Indexable Drills

		D			D1			gage insert		
		32	40	50	mm	max	L1	L4 max	L5	
—	—	—	—	DFT650R2WD50M	65,00	66,00	180,0	125,0	3,4	DFT0905..
—	—	—	—	DFT660R2WD50M	66,00	69,00	180,0	125,0	3,5	DFT0905..
—	—	—	—	DFT670R2WD50M	67,00	67,00	180,0	125,0	3,5	DFT0905..
—	—	—	—	DFT680R2WD50M	68,00	69,00	180,0	125,0	3,6	DFT0905..
—	—	—	—	DFT690R2WD50M	69,00	73,00	205,0	140,0	3,6	DFT1105..
—	—	—	—	DFT700R2WD50M	70,00	71,00	205,0	140,0	3,6	DFT1105..
—	—	—	—	DFT710R2WD50M	71,00	72,00	205,0	140,0	3,9	DFT1105..
—	—	—	—	DFT720R2WD50M	72,00	73,00	205,0	140,0	3,9	DFT1105..
—	—	—	—	DFT730R2WD50M	73,00	79,00	205,0	140,0	4,0	DFT1105..
—	—	—	—	DFT740R2WD50M	74,00	75,00	205,0	140,0	4,1	DFT1105..
—	—	—	—	DFT750R2WD50M	75,00	76,00	205,0	140,0	4,2	DFT1105..
—	—	—	—	DFT760R2WD50M	76,00	77,00	205,0	140,0	4,2	DFT1105..
—	—	—	—	DFT770R2WD50M	77,00	78,00	205,0	140,0	4,3	DFT1105..
—	—	—	—	DFT780R2WD50M	78,00	79,00	205,0	140,0	4,3	DFT1105..
—	—	—	—	DFT790R2WD50M	79,00	82,00	205,0	140,0	4,4	DFT1105..
—	—	—	—	DFT800R2WD50M	80,00	81,00	205,0	140,0	4,5	DFT1105..
—	—	—	—	DFT810R2WD50M	81,00	82,00	205,0	140,0	4,5	DFT1105..
—	—	—	—	DFT820R2WD50M	82,00	83,00	205,0	140,0	4,5	DFT1105..

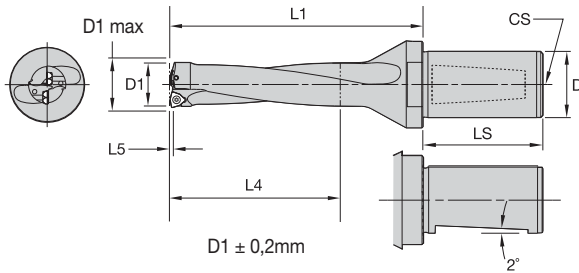
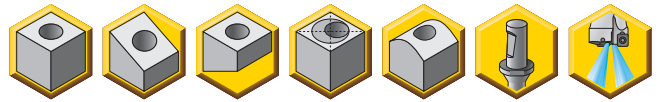
**WARNING**

During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece. When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force. Provide adequate shielding to protect bystanders.

gage insert	insert screw	Torx wrench	Torx size
DFT05T3..	191.924	170.024	9
DFT06T3..	191.848	170.025	15
DFT0704..	191.698	170.025	15
DFT0905..	191.726	170.026	20
DFT1105..	191.375	170.026	20

D	LS	CS
32	58	R 1/4 BSP
40	68	R 1/4 BSP
50	68	R 1/4 BSP

- Drill shipped with insert screws and Torx wrench.
- See page J70 for inserts.



■ WN/WD Shank • 4 x D • Metric

D		D1		L1	L4 max	L5	gage insert
32	40	mm	D1 max				
DFT250R4WD32M	DFT250R4WD40M	25,00	27,00	135,0	100,0	0,8	DFT05T3..
DFT260R4WD32M	DFT260R4WD40M	26,00	27,00	139,0	104,0	0,9	DFT05T3..
DFT270R4WD32M	DFT270R4WD40M	27,00	29,00	143,0	108,0	1,0	DFT05T3..
DFT280R4WD32M	DFT280R4WD40M	28,00	29,00	156,0	112,0	1,1	DFT05T3..
DFT290R4WD32M	DFT290R4WD40M	29,00	31,00	151,0	116,0	1,1	DFT05T3..
DFT300R4WD32M	DFT300R4WD40M	30,00	31,00	160,0	120,0	1,2	DFT05T3..
DFT310R4WD32M	DFT310R4WD40M	31,00	33,00	164,0	124,0	1,3	DFT05T3..
DFT320R4WD32M	DFT320R4WD40M	32,00	33,00	168,0	128,0	1,3	DFT05T3..
—	DFT330R4WD40M	33,00	35,00	177,0	132,0	1,1	DFT06T3..
—	DFT340R4WD40M	34,00	35,00	181,0	136,0	1,3	DFT06T3..
—	DFT350R4WD40M	35,00	38,00	185,0	140,0	1,3	DFT06T3..
—	DFT360R4WD40M	36,00	37,00	189,0	144,0	1,4	DFT06T3..
—	DFT370R4WD40M	37,00	38,00	198,0	148,0	1,5	DFT06T3..
—	DFT380R4WD40M	38,00	41,00	202,0	152,0	1,5	DFT06T3..
—	DFT390R4WD40M	39,00	40,00	206,0	156,0	1,6	DFT06T3..
—	DFT400R4WD40M	40,00	41,00	210,0	160,0	1,7	DFT06T3..
—	DFT410R4WD40M	41,00	44,00	214,0	164,0	1,6	DFT0704..
—	DFT420R4WD40M	42,00	43,00	223,0	168,0	1,7	DFT0704..
—	DFT430R4WD40M	43,00	44,00	227,0	172,0	1,7	DFT0704..
—	DFT440R4WD40M	44,00	47,00	231,0	176,0	1,8	DFT0704..
—	DFT450R4WD40M	45,00	46,00	240,0	180,0	1,9	DFT0704..
—	DFT460R4WD40M	46,00	47,00	244,0	184,0	1,9	DFT0704..
—	DFT470R4WD40M	47,00	50,00	248,0	188,0	2,0	DFT0704..
—	DFT480R4WD40M	48,00	49,00	252,0	192,0	2,0	DFT0704..

Indexable Drills

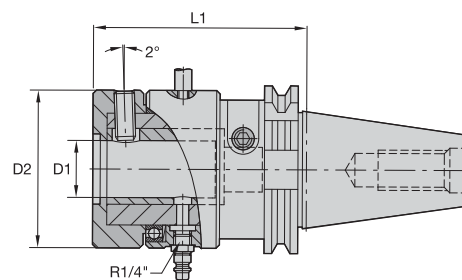
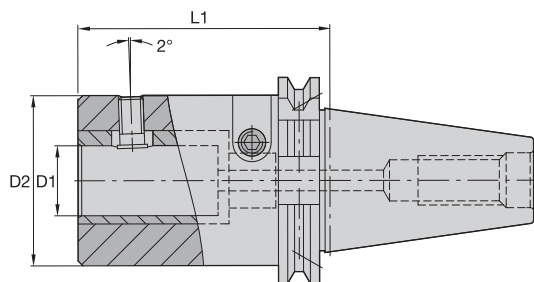
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DFT05T3..	191.924	170.024	9
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D	LS	CS
32	58	R 1/4 BSP
40	68	R 1/4 BSP





Indexable Drills

catalogue number	D1	D2	L1	SK 40		SK 50		coolant ring	kg	lbs
				DIN 69871 A	MAS 403 BT	DIN 69871 A	MAS 403 BT			
BT40BEWD20096M	20,00	63,0	96,0	—	●	—	—	—	3,0	6.6
DV40BEWD20090M	20,00	63,0	96,0	●	—	—	—	—	3,0	6.6
DV50BEWD32108M	32,00	63,0	108,0	—	—	●	—	—	4,3	9.5
DV40RMEWD32108M	32,00	90,0	108,0	●	—	—	—	●	4,0	8.8
BT50BEWD32127M	32,00	63,0	108,0	—	—	—	●	—	4,3	9.5
DV40BEWD32108M	32,00	63,0	108,0	●	—	—	—	—	4,0	8.8
BT40BEWD32114M	32,00	63,0	114,0	—	●	—	—	—	3,4	7.5
BT40RMEWD32114M	32,00	90,0	114,0	—	●	—	—	●	4,0	8.8
DV50RMEWD32108M	32,00	90,0	108,0	—	—	●	—	●	6,9	15.2

NOTE: <sup>1</sup>max: 4800 U/min; Pmax: 20 bar

### ■ With Coolant Ring

D1	clamping screw	adjusting screw	bumper bar	eccentric bushing	dial key
32	192.941	570.850	169.974	536.088	170.236

### ■ Without Coolant Ring

D1	clamping screw	adjusting screw	eccentric bushing	dial key
20	193.203	570.850	536.090	170.236
32	193.204	570.850	536.091	170.236

SAFETY NOTE: Use only the supplied plug-in nipple with nominal breakage point: R 1/4" (6,35mm), catalogue number 191.469.

Intermediate sleeve with dial key included (for coolant ring version, use dial key, bumper bar, and plug-in nipple with predetermined breaking point).

**DFT™ • Metric**

Material Group	Condition	Pocket Seat	Geometry	Grade	Cutting Speed – vc Range – m/min			Metric						
					min	Starting Value	max	Recommended Feed Rate (f) by Diameter						
								Ø (mm)	DFT03... 16,00 - 24,00	DFT05... 25,00 - 32,00	DFT06... 33,00 - 40,00	DFT07... 41,00 - 48,00	DFT09... 49,00 - 68,00	DFT11... 69,00 - 82,00
P	1	S	O MD	KCU25	310	325	360	mm/r	0,06 - 0,10	0,09 - 0,15	0,11 - 0,18	0,15 - 0,25	0,19 - 0,31	0,19 - 0,31
			I MD	KC7140										
	U	O MD	KCU25	200	215	230	mm/r	0,06 - 0,10	0,09 - 0,15	0,11 - 0,18	0,15 - 0,25	0,19 - 0,31	0,19 - 0,31	
		I MD	KC7140											
	I	O MD	KCU40	130	135	150	mm/r	0,06 - 0,10	0,09 - 0,15	0,11 - 0,18	0,15 - 0,25	0,19 - 0,31	0,19 - 0,31	
		I MD	KC7140											
	2	S	O HP	KCPK10	310	325	360	mm/r	0,06 - 0,10	0,09 - 0,15	0,11 - 0,18	0,15 - 0,25	0,19 - 0,31	0,19 - 0,31
			I HP	KC7140										
	U	O HP	KCU25	200	215	230	mm/r	0,06 - 0,10	0,09 - 0,15	0,11 - 0,18	0,15 - 0,25	0,19 - 0,31	0,19 - 0,31	
		I HP	KC7140											
	I	O HP	KCU40	130	135	150	mm/r	0,06 - 0,10	0,09 - 0,15	0,11 - 0,18	0,15 - 0,25	0,19 - 0,31	0,19 - 0,31	
		I HP	KC7140											
	3	S	O HP	KCPK10	260	285	320	mm/r	0,06 - 0,10	0,09 - 0,15	0,11 - 0,18	0,15 - 0,25	0,19 - 0,31	0,19 - 0,31
			I HP	KC7140										
	U	O HP	KCU25	180	195	220	mm/r	0,06 - 0,10	0,09 - 0,15	0,11 - 0,18	0,15 - 0,25	0,19 - 0,31	0,19 - 0,31	
		I HP	KC7140											
	I	O HP	KCU40	110	120	140	mm/r	0,06 - 0,10	0,09 - 0,15	0,11 - 0,18	0,15 - 0,25	0,19 - 0,31	0,19 - 0,31	
		I HP	KC7140											
	4	S	O HP	KCU25	220	250	300	mm/r	0,06 - 0,10	0,09 - 0,15	0,11 - 0,18	0,15 - 0,25	0,19 - 0,31	0,19 - 0,31
			I HP	KC7140										
	U	O HP	KCU40	150	180	220	mm/r	0,06 - 0,10	0,09 - 0,15	0,11 - 0,18	0,15 - 0,25	0,19 - 0,31	0,19 - 0,31	
		I HP	KC7140											
	I	O HP	KC7140	90	110	140	mm/r	0,06 - 0,10	0,09 - 0,15	0,11 - 0,18	0,15 - 0,25	0,19 - 0,31	0,19 - 0,31	
		I HP	KC7140											
5	S	O HP	KCU25	180	200	220	mm/r	0,05 - 0,10	0,07 - 0,13	0,09 - 0,15	0,11 - 0,18	0,12 - 0,23	0,12 - 0,23	
		I HP	KC7140											
U	O HP	KCU40	120	135	150	mm/r	0,05 - 0,10	0,07 - 0,13	0,09 - 0,15	0,11 - 0,18	0,12 - 0,23	0,12 - 0,23		
	I HP	KC7140												
I	O HP	KC7140	70	85	100	mm/r	0,05 - 0,10	0,07 - 0,13	0,09 - 0,15	0,11 - 0,18	0,12 - 0,23	0,12 - 0,23		
	I HP	KC7140												
6	S	O HP	KCU25	180	200	220	mm/r	0,05 - 0,10	0,07 - 0,13	0,09 - 0,15	0,11 - 0,18	0,12 - 0,23	0,12 - 0,23	
		I HP	KC7140											
U	O HP	KCU40	120	135	150	mm/r	0,05 - 0,10	0,07 - 0,13	0,09 - 0,15	0,11 - 0,18	0,12 - 0,23	0,12 - 0,23		
	I HP	KC7140												
I	O HP	KC7140	70	85	100	mm/r	0,05 - 0,10	0,07 - 0,13	0,09 - 0,15	0,11 - 0,18	0,12 - 0,23	0,12 - 0,23		
	I HP	KC7140												
M	1	S	O MD	KC7140	150	190	230	mm/r	0,05 - 0,09	0,07 - 0,13	0,08 - 0,16	0,10 - 0,18	0,11 - 0,21	0,11 - 0,21
			I MD	KC7140										
	U	O MD	KC7140	100	130	160	mm/r	0,05 - 0,09	0,07 - 0,13	0,08 - 0,16	0,10 - 0,18	0,11 - 0,21	0,11 - 0,21	
		I MD	KC7140											
	I	O MD	KC7140	60	80	100	mm/r	0,05 - 0,09	0,07 - 0,13	0,08 - 0,16	0,10 - 0,18	0,11 - 0,21	0,11 - 0,21	
		I MD	KC7140											
	2	S	O MD	KC7140	150	180	210	mm/r	0,05 - 0,09	0,07 - 0,13	0,08 - 0,16	0,10 - 0,18	0,11 - 0,21	0,11 - 0,21
			I MD	KC7140										
	U	O MD	KC7140	100	130	160	mm/r	0,05 - 0,09	0,07 - 0,13	0,08 - 0,16	0,10 - 0,18	0,11 - 0,21	0,11 - 0,21	
		I MD	KC7140											
	I	O MD	KC7140	60	80	100	mm/r	0,05 - 0,09	0,07 - 0,13	0,08 - 0,16	0,10 - 0,18	0,11 - 0,21	0,11 - 0,21	
		I MD	KC7140											
3	S	O MD	KC7140	100	130	160	mm/r	0,05 - 0,09	0,07 - 0,13	0,08 - 0,16	0,10 - 0,18	0,11 - 0,21	0,11 - 0,21	
		I MD	KC7140											
U	O MD	KC7140	80	110	140	mm/r	0,05 - 0,09	0,07 - 0,13	0,08 - 0,16	0,10 - 0,18	0,11 - 0,21	0,11 - 0,21		
	I MD	KC7140												
I	O MD	KC7140	50	70	90	mm/r	0,05 - 0,09	0,07 - 0,13	0,08 - 0,16	0,10 - 0,18	0,11 - 0,21	0,11 - 0,21		
	I MD	KC7140												

Condition: S = Stable cutting conditions; U = Unstable cutting conditions; I = Interrupted cutting conditions  
 Pocket seat: I = Inboard insert; O = Outboard insert



### DFT™ • Metric

Indexable Drills

Material Group	Condition	Pocket Seat	Geometry	Grade	Cutting Speed – vc Range – m/min			Metric						
					min	Starting Value	max	Recommended Feed Rate (f) by Diameter						
								Ø (mm)	DFT03... 16,00 - 24,00	DFT05... 25,00 - 32,00	DFT06... 33,00 - 40,00	DFT07... 41,00 - 48,00	DFT09... 49,00 - 68,00	DFT11... 69,00 - 82,00
K	1	S	O HP	KCPK10	200	<b>240</b>	300	mm/r	0,07 - 0,13	0,10 - 0,18	0,14 - 0,26	0,18 - 0,33	0,21 - 0,39	0,21 - 0,39
			I HP	KCU40										
		U	O HP	KCU25	120	<b>155</b>	200	mm/r	0,07 - 0,13	0,10 - 0,18	0,14 - 0,26	0,18 - 0,33	0,21 - 0,39	0,21 - 0,39
			I HP	KCU40										
	2	S	O HP	KCPK10	180	<b>220</b>	260	mm/r	0,07 - 0,13	0,10 - 0,18	0,14 - 0,26	0,18 - 0,33	0,21 - 0,39	0,21 - 0,39
			I HP	KCU40										
		U	O HP	KCU25	110	<b>140</b>	170	mm/r	0,07 - 0,13	0,10 - 0,18	0,14 - 0,26	0,18 - 0,33	0,21 - 0,39	0,21 - 0,39
			I HP	KC7140										
	3	S	O HP	KCPK10	180	<b>220</b>	260	mm/r	0,07 - 0,13	0,10 - 0,18	0,14 - 0,26	0,18 - 0,33	0,21 - 0,39	0,21 - 0,39
			I HP	KCU40										
		U	O HP	KCU25	110	<b>140</b>	170	mm/r	0,07 - 0,13	0,10 - 0,18	0,14 - 0,26	0,18 - 0,33	0,21 - 0,39	0,21 - 0,39
			I HP	KC7140										
N	1	S	O ST	KD1425	400	<b>600</b>	800	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18
			I ST	KD1425										
		U	O HP	KCU40	300	<b>400</b>	500	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18
			I HP	KCU40										
	2	S	O ST	KD1425	375	<b>550</b>	775	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18
			I ST	KD1425										
		U	O HP	KCU40	250	<b>350</b>	450	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18
			I HP	KCU40										
	3	S	O ST	KD1425	350	<b>500</b>	650	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18
			I ST	KD1425										
		U	O HP	KCU40	250	<b>350</b>	450	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18
			I HP	KCU40										
	4	S	O ST	KD1425	400	<b>600</b>	800	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18
			I ST	KD1425										
		U	O HP	KCU40	250	<b>350</b>	450	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18
			I HP	KCU40										
	5	S	O ST	KD1425	400	<b>600</b>	800	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18
			I ST	KD1425										
		U	O HP	KCU40	250	<b>350</b>	450	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18
			I HP	KCU40										
5	S	O ST	KD1425	400	<b>600</b>	800	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18	
		I ST	KD1425											
	U	O HP	KCU40	250	<b>350</b>	450	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18	
		I HP	KCU40											
5	S	O ST	KD1425	400	<b>600</b>	800	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18	
		I ST	KD1425											
	U	O HP	KCU40	250	<b>350</b>	450	mm/r	0,05 - 0,07	0,07 - 0,09	0,10 - 0,14	0,12 - 0,16	0,14 - 0,18	0,14 - 0,18	
		I HP	KCU40											

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Pocket seat: I = Inboard insert; O = Outboard insert

■ DFT™ • Metric

Material Group	Condition	Pocket Seat	Geometry	Grade	Cutting Speed – vc Range – m/min		Metric								
							Recommended Feed Rate (f) by Diameter								
					min	Starting Value	max	Ø (mm)	DFT03... 16,00 - 24,00	DFT05... 25,00 - 32,00	DFT06... 33,00 - 40,00	DFT07... 41,00 - 48,00	DFT09... 49,00 - 68,00	DFT11... 69,00 - 82,00	
S	1	S	O	HP	KCU40	60	<b>70</b>	75	mm/r	0,03 - 0,05	0,04 - 0,06	0,05 - 0,08	0,06 - 0,10	0,08 - 0,13	0,08 - 0,13
			I	HP	KCU40										
	U	O	HP	KCU40	40	<b>50</b>	60	mm/r	0,03 - 0,05	0,04 - 0,06	0,05 - 0,08	0,06 - 0,10	0,08 - 0,13	0,08 - 0,13	
		I	HP	KC7140											
	I	O	MD	KC7140	25	<b>30</b>	40	mm/r	0,03 - 0,05	0,04 - 0,06	0,05 - 0,08	0,06 - 0,10	0,08 - 0,13	0,08 - 0,13	
		I	MD	KC7140											
	2	S	O	HP	KCU40	50	<b>60</b>	70	mm/r	0,03 - 0,05	0,04 - 0,06	0,05 - 0,08	0,06 - 0,10	0,08 - 0,13	0,08 - 0,13
			I	HP	KCU40										
		U	O	HP	KCU40	30	<b>40</b>	50	mm/r	0,03 - 0,05	0,04 - 0,06	0,05 - 0,08	0,06 - 0,10	0,08 - 0,13	0,08 - 0,13
			I	HP	KC7140										
	3	S	O	HP	KCU40	70	<b>80</b>	90	mm/r	0,04 - 0,06	0,05 - 0,08	0,06 - 0,10	0,06 - 0,10	0,09 - 0,15	0,09 - 0,15
			I	HP	KCU40										
U		O	HP	KCU40	50	<b>60</b>	70	mm/r	0,04 - 0,06	0,05 - 0,08	0,06 - 0,10	0,06 - 0,10	0,09 - 0,15	0,09 - 0,15	
		I	HP	KC7140											
4	S	O	HP	KCU40	70	<b>80</b>	90	mm/r	0,04 - 0,06	0,05 - 0,08	0,06 - 0,10	0,06 - 0,10	0,09 - 0,15	0,09 - 0,15	
		I	HP	KCU40											
	U	O	HP	KCU40	50	<b>60</b>	70	mm/r	0,04 - 0,06	0,05 - 0,08	0,06 - 0,10	0,06 - 0,10	0,09 - 0,15	0,09 - 0,15	
		I	HP	KC7140											
I	O	MD	KC7140	30	<b>40</b>	50	mm/r	0,04 - 0,06	0,05 - 0,08	0,06 - 0,10	0,06 - 0,10	0,09 - 0,15	0,09 - 0,15		
	I	MD	KC7140												

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