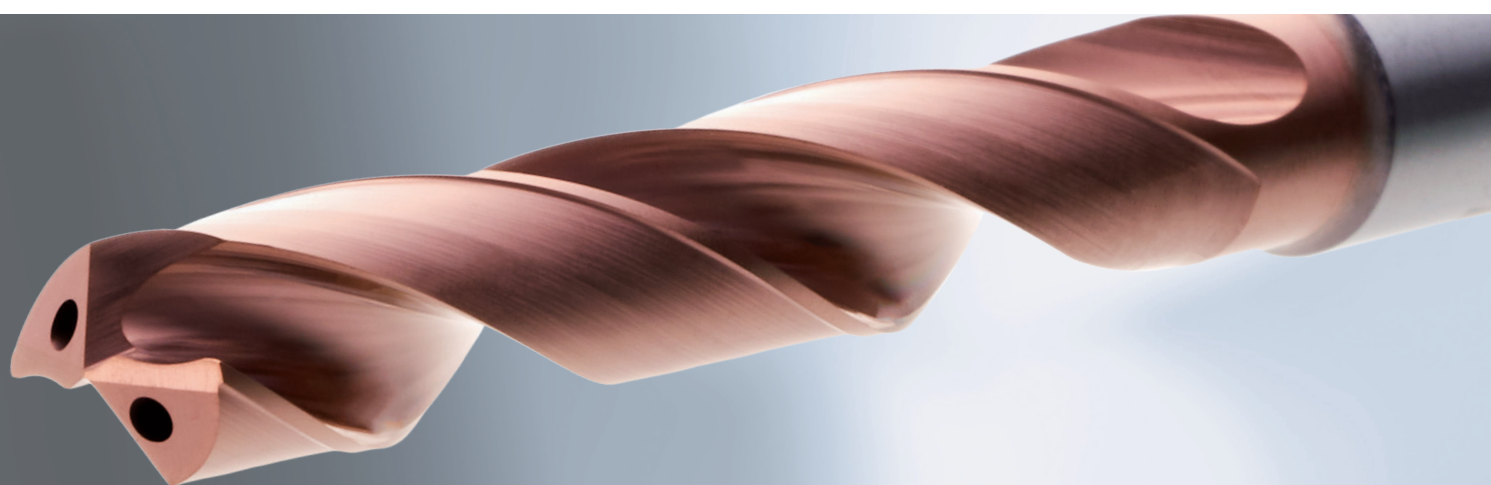




High efficiency coated
solid carbide drill

KDA

KDA



Highly efficient new general purpose solid carbide drill

Cost effective and high-precision design
for a wide variety of machining solutions



Drilling depth 8D Type C is available
Double margin

**KEEPS YOU
AHEAD**



High efficiency coated solid carbide drill

KDA

KDA is for excellent all-around drilling performance.
Large line-up accommodates a wide variety of applications.

Styles available

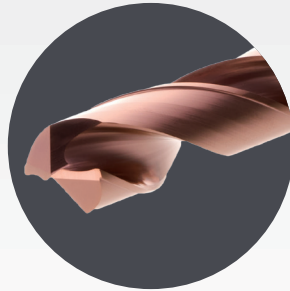


Type N

Normal type

General purpose design without coolant holes.

Economical style for machining with external coolant.



Diameter range

3D

5D

Ø3 – Ø16 mm

Cutting diameters available in 0.1 mm increments.



Type C

Coolant hole

Coolant-through design

Provides higher efficiency and stable machining with stainless steel, etc.



Diameter range

3D

5D

8D

Ø3 – Ø16 mm

Cutting diameters available in 0.1 mm increments.
(8D: 0.5 mm increments for Ø11 mm and above).

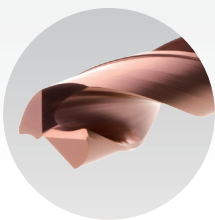
NEW

Features

1

General purpose design and line-up.
Applicable to a wide range of machining applications

Type N: No coolant holes



3D / 131 Items

5D / 131 Items

Type C: With coolant holes



3D / 131 Items

5D / 131 Items

NEW

8D / 91 Items

Double margin



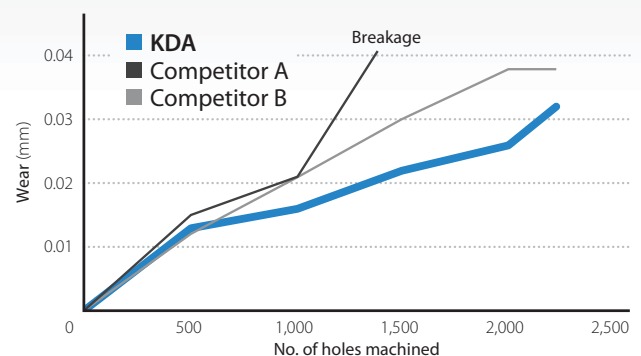
Features

2

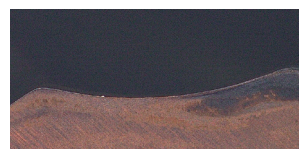
High-performance coating maintains long tool life

Excellent wear and heat resistance
Aluminium Chrome (AlCr) coating

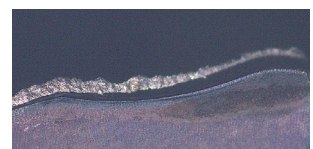
Wear resistance comparison (Internal evaluation)



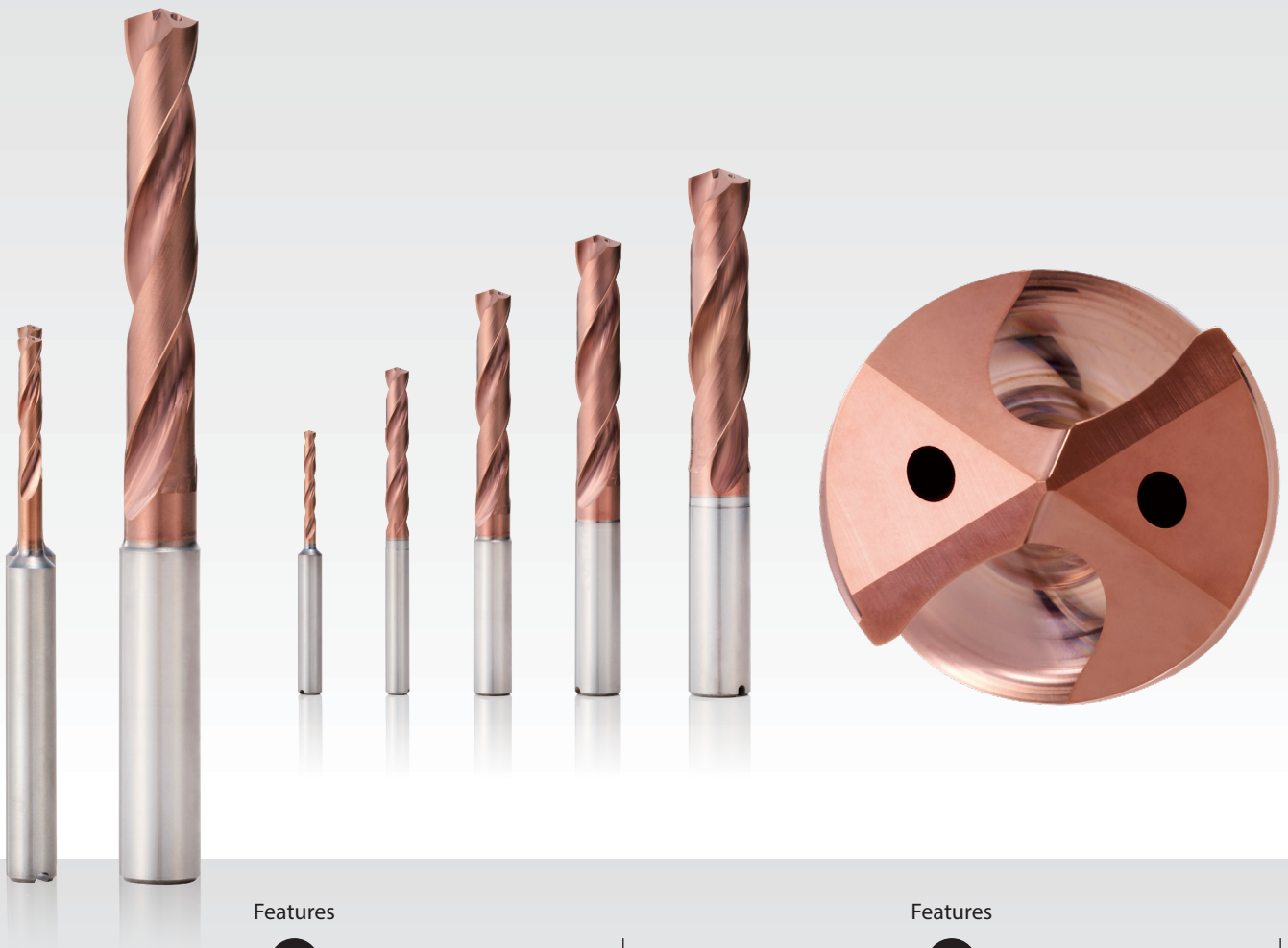
Cutting conditions: $V_c = 120$ m/min., $f = 0.23$ mm/rev, $H = 24$ mm,
Wet (Internal coolant) C50, BT50, Ø6 mm, 5xD, Type C.



KDA



Competitor B



Features

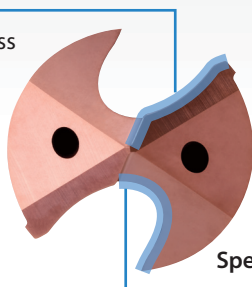
3

Stable machining with unique shape

Curved cutting-edge design and special flute shape

Curved cutting-edge design

Excellent sharpness and cutting edge strength



Special flute shape

Excellent chip control and high rigidity



KDA

Chip condition

(Internal evaluation)

Cutting conditions:
Vc = 80 m/min., f = 0.14 mm/rev,
H = 24 mm, Wet (Internal coolant)
BT50, Ø6 mm (5xD), Type C.

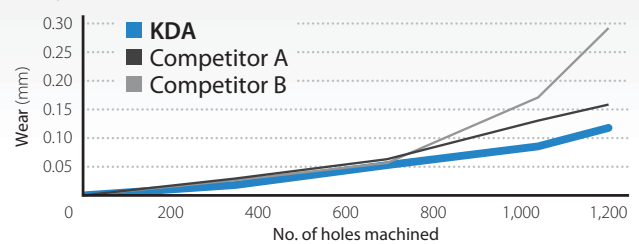
Features

4

Supports a variety of workpieces

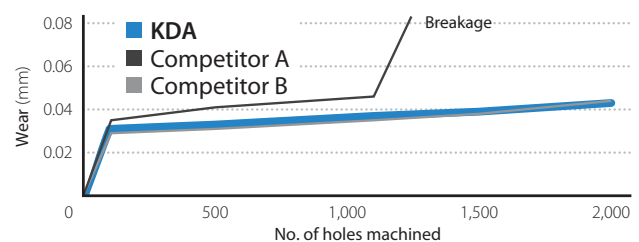
Compatible not only with carbon steel, but also mould steel, stainless steel, cast iron machining, etc.

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

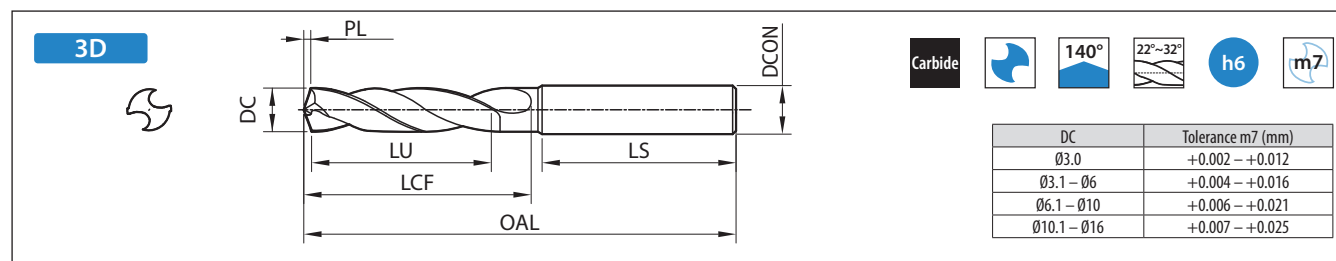


Cutting conditions: Vc = 100 m/min., f = 0.15 mm/rev, H = 24 mm, Wet (Internal coolant), BT50, Ø6 mm, 5xD, Type C.

Stainless steel • X5CrNi18-9 (Internal evaluation)



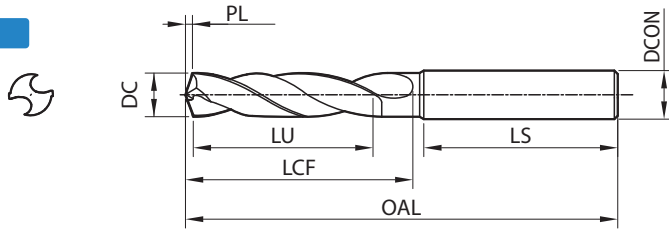
Cutting conditions: Vc = 80 m/min., f = 0.14 mm/rev, H = 24 mm, Wet (Internal coolant), BT50, Ø6 mm, 5xD, Type C.



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

3D



Carbide



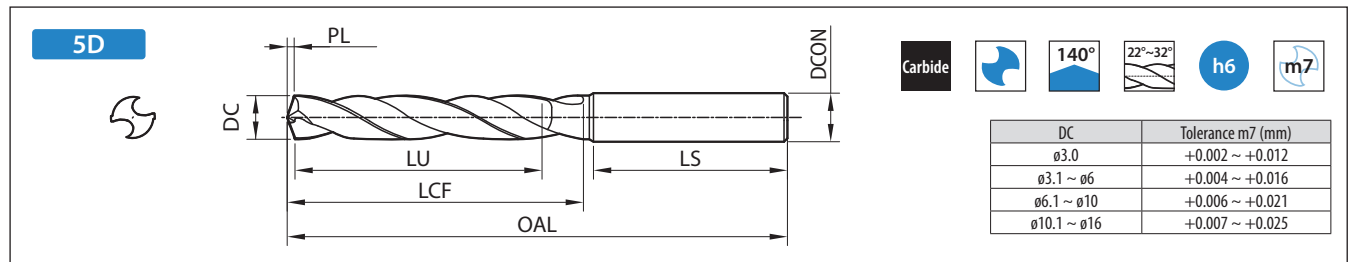
DC	Tolerance m7 (mm)
Ø3.0	+0.002 – +0.012
Ø3.1 – Ø6	+0.004 – +0.016
Ø6.1 – Ø10	+0.006 – +0.021
Ø10.1 – Ø16	+0.007 – +0.025

Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0960X03S100N	●	9.6	10	89	34.3	47	40	1.7
KDA0970X03S100N	●	9.7	10	89	34.1	47	40	1.7
KDA0980X03S100N	●	9.8	10	89	34	47	40	1.7
KDA0990X03S100N	●	9.9	10	89	33.9	47	40	1.8
KDA1000X03S100N	●	10	10	89	33.8	47	40	1.8
KDA1010X03S120N	●	10.1	12	102	41.6	55	45	1.8
KDA1020X03S120N	●	10.2	12	102	41.5	55	45	1.8
KDA1030X03S120N	●	10.3	12	102	41.3	55	45	1.8
KDA1040X03S120N	●	10.4	12	102	41.2	55	45	1.8
KDA1050X03S120N	●	10.5	12	102	41.1	55	45	1.9
KDA1060X03S120N	●	10.6	12	102	41	55	45	1.9
KDA1070X03S120N	●	10.7	12	102	40.8	55	45	1.9
KDA1080X03S120N	●	10.8	12	102	40.7	55	45	1.9
KDA1090X03S120N	●	10.9	12	102	40.5	55	45	1.9
KDA1100X03S120N	●	11	12	102	40.5	55	45	2.0
KDA1110X03S120N	●	11.1	12	102	40.3	55	45	2.0
KDA1120X03S120N	●	11.2	12	102	40.2	55	45	2.0
KDA1130X03S120N	●	11.3	12	102	40	55	45	2.0
KDA1140X03S120N	●	11.4	12	102	39.9	55	45	2.0
KDA1150X03S120N	●	11.5	12	102	39.7	55	45	2.0
KDA1160X03S120N	●	11.6	12	102	39.7	55	45	2.1
KDA1170X03S120N	●	11.7	12	102	39.5	55	45	2.1
KDA1180X03S120N	●	11.8	12	102	39.4	55	45	2.1
KDA1190X03S120N	●	11.9	12	102	39.2	55	45	2.1
KDA1200X03S120N	●	12	12	102	39.1	55	45	2.1
KDA1210X03S140N	●	12.1	14	107	44	60	45	2.2
KDA1220X03S140N	●	12.2	14	107	43.9	60	45	2.2
KDA1230X03S140N	●	12.3	14	107	43.7	60	45	2.2
KDA1240X03S140N	●	12.4	14	107	43.6	60	45	2.2
KDA1250X03S140N	●	12.5	14	107	43.4	60	45	2.2
KDA1260X03S140N	●	12.6	14	107	43.3	60	45	2.2
KDA1270X03S140N	●	12.7	14	107	43.2	60	45	2.3
KDA1280X03S140N	●	12.8	14	107	43.1	60	45	2.3

Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA1290X03S140N	●	12.9	14	107	42.9	60	45	2.3
KDA1300X03S140N	●	13	14	107	42.8	60	45	2.3
KDA1310X03S140N	●	13.1	14	107	42.6	60	45	2.3
KDA1320X03S140N	●	13.2	14	107	42.6	60	45	2.4
KDA1330X03S140N	●	13.3	14	107	42.4	60	45	2.4
KDA1340X03S140N	●	13.4	14	107	42.3	60	45	2.4
KDA1350X03S140N	●	13.5	14	107	42.1	60	45	2.4
KDA1360X03S140N	●	13.6	14	107	42	60	45	2.4
KDA1370X03S140N	●	13.7	14	107	41.8	60	45	2.4
KDA1380X03S140N	●	13.8	14	107	41.8	60	45	2.5
KDA1390X03S140N	●	13.9	14	107	41.6	60	45	2.5
KDA1400X03S140N	●	14	14	107	41.5	60	45	2.5
KDA1410X03S160N	●	14.1	16	115	46.3	65	48	2.5
KDA1420X03S160N	●	14.2	16	115	46.2	65	48	2.5
KDA1430X03S160N	●	14.3	16	115	46.1	65	48	2.6
KDA1440X03S160N	●	14.4	16	115	46	65	48	2.6
KDA1450X03S160N	●	14.5	16	115	45.8	65	48	2.6
KDA1460X03S160N	●	14.6	16	115	45.7	65	48	2.6
KDA1470X03S160N	●	14.7	16	115	45.5	65	48	2.6
KDA1480X03S160N	●	14.8	16	115	45.4	65	48	2.6
KDA1490X03S160N	●	14.9	16	115	45.3	65	48	2.7
KDA1500X03S160N	●	15	16	115	45.2	65	48	2.7
KDA1510X03S160N	●	15.1	16	115	45	65	48	2.7
KDA1520X03S160N	●	15.2	16	115	44.9	65	48	2.7
KDA1530X03S160N	●	15.3	16	115	44.7	65	48	2.7
KDA1540X03S160N	●	15.4	16	115	44.7	65	48	2.8
KDA1550X03S160N	●	15.5	16	115	44.5	65	48	2.8
KDA1560X03S160N	●	15.6	16	115	44.4	65	48	2.8
KDA1570X03S160N	●	15.7	16	115	44.2	65	48	2.8
KDA1580X03S160N	●	15.8	16	115	44.1	65	48	2.8
KDA1590X03S160N	●	15.9	16	115	43.9	65	48	2.8
KDA1600X03S160N	●	16	16	115	43.9	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.

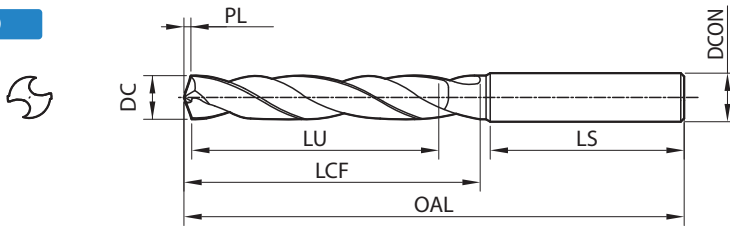
● : Available



Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0300X05S060N	●	3	6	66	24	28	36	0.5
KDA0310X05S060N	●	3.1	6	66	23.8	28	36	0.5
KDA0320X05S060N	●	3.2	6	66	23.7	28	36	0.5
KDA0330X05S060N	●	3.3	6	66	23.6	28	36	0.6
KDA0340X05S060N	●	3.4	6	66	23.5	28	36	0.6
KDA0350X05S060N	●	3.5	6	66	23.3	28	36	0.6
KDA0360X05S060N	●	3.6	6	66	23.2	28	36	0.6
KDA0370X05S060N	●	3.7	6	66	23	28	36	0.6
KDA0380X05S060N	●	3.8	6	74	30.9	36	36	0.6
KDA0390X05S060N	●	3.9	6	74	30.8	36	36	0.7
KDA0400X05S060N	●	4	6	74	30.7	36	36	0.7
KDA0410X05S060N	●	4.1	6	74	30.5	36	36	0.7
KDA0420X05S060N	●	4.2	6	74	30.4	36	36	0.7
KDA0430X05S060N	●	4.3	6	74	30.2	36	36	0.7
KDA0440X05S060N	●	4.4	6	74	30.2	36	36	0.8
KDA0450X05S060N	●	4.5	6	74	30	36	36	0.8
KDA0460X05S060N	●	4.6	6	74	29.9	36	36	0.8
KDA0470X05S060N	●	4.7	6	74	29.7	36	36	0.8
KDA0480X05S060N	●	4.8	6	82	37.6	44	36	0.8
KDA0490X05S060N	●	4.9	6	82	37.4	44	36	0.8
KDA0500X05S060N	●	5	6	82	37.4	44	36	0.9
KDA0510X05S060N	●	5.1	6	82	37.2	44	36	0.9
KDA0520X05S060N	●	5.2	6	82	37.1	44	36	0.9
KDA0530X05S060N	●	5.3	6	82	36.9	44	36	0.9
KDA0540X05S060N	●	5.4	6	82	36.8	44	36	0.9
KDA0550X05S060N	●	5.5	6	82	36.7	44	36	1.0
KDA0560X05S060N	●	5.6	6	82	36.6	44	36	1.0
KDA0570X05S060N	●	5.7	6	82	36.4	44	36	1.0
KDA0580X05S060N	●	5.8	6	82	36.3	44	36	1.0
KDA0590X05S060N	●	5.9	6	82	36.1	44	36	1.0
KDA0600X05S060N	●	6	6	82	36	44	36	1.0
KDA0610X05S080N	●	6.1	8	91	44.9	53	36	1.1
KDA0620X05S080N	●	6.2	8	91	44.8	53	36	1.1

Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0630X05S080N	●	6.3	8	91	44.6	53	36	1.1
KDA0640X05S080N	●	6.4	8	91	44.5	53	36	1.1
KDA0650X05S080N	●	6.5	8	91	44.3	53	36	1.1
KDA0660X05S080N	●	6.6	8	91	44.3	53	36	1.2
KDA0670X05S080N	●	6.7	8	91	44.1	53	36	1.2
KDA0680X05S080N	●	6.8	8	91	44	53	36	1.2
KDA0690X05S080N	●	6.9	8	91	43.8	53	36	1.2
KDA0700X05S080N	●	7	8	91	43.7	53	36	1.2
KDA0710X05S080N	●	7.1	8	91	43.5	53	36	1.2
KDA0720X05S080N	●	7.2	8	91	43.5	53	36	1.3
KDA0730X05S080N	●	7.3	8	91	43.3	53	36	1.3
KDA0740X05S080N	●	7.4	8	91	43.2	53	36	1.3
KDA0750X05S080N	●	7.5	8	91	43	53	36	1.3
KDA0760X05S080N	●	7.6	8	91	42.9	53	36	1.3
KDA0770X05S080N	●	7.7	8	91	42.8	53	36	1.4
KDA0780X05S080N	●	7.8	8	91	42.7	53	36	1.4
KDA0790X05S080N	●	7.9	8	91	42.5	53	36	1.4
KDA0800X05S080N	●	8	8	91	42.4	53	36	1.4
KDA0810X05S100N	●	8.1	10	103	50.2	61	40	1.4
KDA0820X05S100N	●	8.2	10	103	50.1	61	40	1.4
KDA0830X05S100N	●	8.3	10	103	50	61	40	1.5
KDA0840X05S100N	●	8.4	10	103	49.9	61	40	1.5
KDA0850X05S100N	●	8.5	10	103	49.7	61	40	1.5
KDA0860X05S100N	●	8.6	10	103	49.6	61	40	1.5
KDA0870X05S100N	●	8.7	10	103	49.4	61	40	1.5
KDA0880X05S100N	●	8.8	10	103	49.4	61	40	1.6
KDA0890X05S100N	●	8.9	10	103	49.2	61	40	1.6
KDA0900X05S100N	●	9	10	103	49.1	61	40	1.6
KDA0910X05S100N	●	9.1	10	103	48.9	61	40	1.6
KDA0920X05S100N	●	9.2	10	103	48.8	61	40	1.6
KDA0930X05S100N	●	9.3	10	103	48.6	61	40	1.6
KDA0940X05S100N	●	9.4	10	103	48.6	61	40	1.7
KDA0950X05S100N	●	9.5	10	103	48.4	61	40	1.7

5D



Carbide



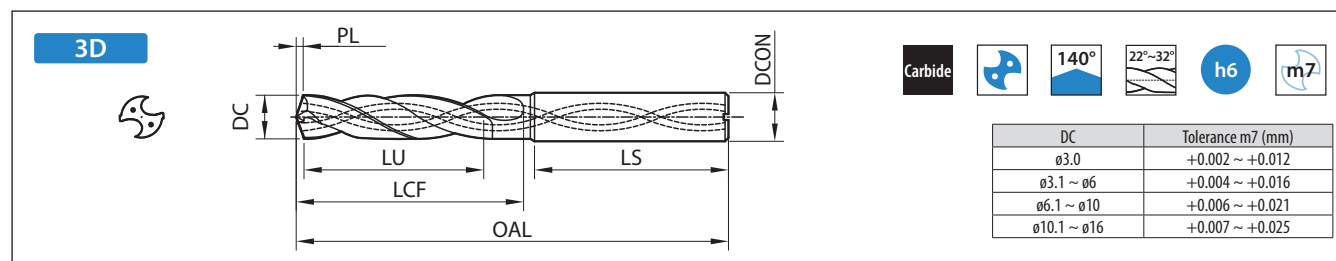
DC	Tolerance m7 (mm)
ø3.0	+0.002 ~ +0.012
ø3.1 ~ ø6	+0.004 ~ +0.016
ø6.1 ~ ø10	+0.006 ~ +0.021
ø10.1 ~ ø16	+0.007 ~ +0.025

Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0960X05S100N	●	9.6	10	103	48.3	61	40	1.7
KDA0970X05S100N	●	9.7	10	103	48.1	61	40	1.7
KDA0980X05S100N	●	9.8	10	103	48	61	40	1.7
KDA0990X05S100N	●	9.9	10	103	47.9	61	40	1.8
KDA1000X05S100N	●	10	10	103	47.8	61	40	1.8
KDA1010X05S120N	●	10.1	12	118	57.6	71	45	1.8
KDA1020X05S120N	●	10.2	12	118	57.5	71	45	1.8
KDA1030X05S120N	●	10.3	12	118	57.3	71	45	1.8
KDA1040X05S120N	●	10.4	12	118	57.2	71	45	1.8
KDA1050X05S120N	●	10.5	12	118	57.1	71	45	1.9
KDA1060X05S120N	●	10.6	12	118	57	71	45	1.9
KDA1070X05S120N	●	10.7	12	118	56.8	71	45	1.9
KDA1080X05S120N	●	10.8	12	118	56.7	71	45	1.9
KDA1090X05S120N	●	10.9	12	118	56.5	71	45	1.9
KDA1100X05S120N	●	11	12	118	56.5	71	45	2.0
KDA1110X05S120N	●	11.1	12	118	56.3	71	45	2.0
KDA1120X05S120N	●	11.2	12	118	56.2	71	45	2.0
KDA1130X05S120N	●	11.3	12	118	56	71	45	2.0
KDA1140X05S120N	●	11.4	12	118	55.9	71	45	2.0
KDA1150X05S120N	●	11.5	12	118	55.7	71	45	2.0
KDA1160X05S120N	●	11.6	12	118	55.7	71	45	2.1
KDA1170X05S120N	●	11.7	12	118	55.5	71	45	2.1
KDA1180X05S120N	●	11.8	12	118	55.4	71	45	2.1
KDA1190X05S120N	●	11.9	12	118	55.2	71	45	2.1
KDA1200X05S120N	●	12	12	118	55.1	71	45	2.1
KDA1210X05S140N	●	12.1	14	124	61	77	45	2.2
KDA1220X05S140N	●	12.2	14	124	60.9	77	45	2.2
KDA1230X05S140N	●	12.3	14	124	60.7	77	45	2.2
KDA1240X05S140N	●	12.4	14	124	60.6	77	45	2.2
KDA1250X05S140N	●	12.5	14	124	60.4	77	45	2.2
KDA1260X05S140N	●	12.6	14	124	60.3	77	45	2.2
KDA1270X05S140N	●	12.7	14	124	60.2	77	45	2.3
KDA1280X05S140N	●	12.8	14	124	60.1	77	45	2.3

Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA1290X05S140N	●	12.9	14	124	59.9	77	45	2.3
KDA1300X05S140N	●	13	14	124	59.8	77	45	2.3
KDA1310X05S140N	●	13.1	14	124	59.6	77	45	2.3
KDA1320X05S140N	●	13.2	14	124	59.6	77	45	2.4
KDA1330X05S140N	●	13.3	14	124	59.4	77	45	2.4
KDA1340X05S140N	●	13.4	14	124	59.3	77	45	2.4
KDA1350X05S140N	●	13.5	14	124	59.1	77	45	2.4
KDA1360X05S140N	●	13.6	14	124	59	77	45	2.4
KDA1370X05S140N	●	13.7	14	124	58.8	77	45	2.4
KDA1380X05S140N	●	13.8	14	124	58.8	77	45	2.5
KDA1390X05S140N	●	13.9	14	124	58.6	77	45	2.5
KDA1400X05S140N	●	14	14	124	58.5	77	45	2.5
KDA1410X05S160N	●	14.1	16	133	64.3	83	48	2.5
KDA1420X05S160N	●	14.2	16	133	64.2	83	48	2.5
KDA1430X05S160N	●	14.3	16	133	64.1	83	48	2.6
KDA1440X05S160N	●	14.4	16	133	64	83	48	2.6
KDA1450X05S160N	●	14.5	16	133	63.8	83	48	2.6
KDA1460X05S160N	●	14.6	16	133	63.7	83	48	2.6
KDA1470X05S160N	●	14.7	16	133	63.5	83	48	2.6
KDA1480X05S160N	●	14.8	16	133	63.4	83	48	2.6
KDA1490X05S160N	●	14.9	16	133	63.3	83	48	2.7
KDA1500X05S160N	●	15	16	133	63.2	83	48	2.7
KDA1510X05S160N	●	15.1	16	133	63	83	48	2.7
KDA1520X05S160N	●	15.2	16	133	62.9	83	48	2.7
KDA1530X05S160N	●	15.3	16	133	62.7	83	48	2.7
KDA1540X05S160N	●	15.4	16	133	62.7	83	48	2.8
KDA1550X05S160N	●	15.5	16	133	62.5	83	48	2.8
KDA1560X05S160N	●	15.6	16	133	62.4	83	48	2.8
KDA1570X05S160N	●	15.7	16	133	62.2	83	48	2.8
KDA1580X05S160N	●	15.8	16	133	62.1	83	48	2.8
KDA1590X05S160N	●	15.9	16	133	61.9	83	48	2.8
KDA1600X05S160N	●	16	16	133	61.9	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.

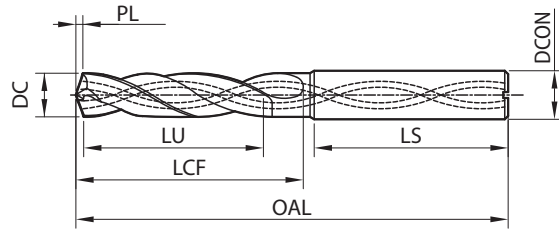
● : Available



Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0300X03S060C	●	3	6	62	16	20	36	0.5
KDA0310X03S060C	●	3.1	6	62	15.8	20	36	0.5
KDA0320X03S060C	●	3.2	6	62	15.7	20	36	0.5
KDA0330X03S060C	●	3.3	6	62	15.6	20	36	0.6
KDA0340X03S060C	●	3.4	6	62	15.5	20	36	0.6
KDA0350X03S060C	●	3.5	6	62	15.3	20	36	0.6
KDA0360X03S060C	●	3.6	6	62	15.2	20	36	0.6
KDA0370X03S060C	●	3.7	6	62	15	20	36	0.6
KDA0380X03S060C	●	3.8	6	66	18.9	24	36	0.6
KDA0390X03S060C	●	3.9	6	66	18.8	24	36	0.7
KDA0400X03S060C	●	4	6	66	18.7	24	36	0.7
KDA0410X03S060C	●	4.1	6	66	18.5	24	36	0.7
KDA0420X03S060C	●	4.2	6	66	18.4	24	36	0.7
KDA0430X03S060C	●	4.3	6	66	18.2	24	36	0.7
KDA0440X03S060C	●	4.4	6	66	18.2	24	36	0.8
KDA0450X03S060C	●	4.5	6	66	18	24	36	0.8
KDA0460X03S060C	●	4.6	6	66	17.9	24	36	0.8
KDA0470X03S060C	●	4.7	6	66	17.7	24	36	0.8
KDA0480X03S060C	●	4.8	6	66	21.6	28	36	0.8
KDA0490X03S060C	●	4.9	6	66	21.4	28	36	0.8
KDA0500X03S060C	●	5	6	66	21.4	28	36	0.9
KDA0510X03S060C	●	5.1	6	66	21.2	28	36	0.9
KDA0520X03S060C	●	5.2	6	66	21.1	28	36	0.9
KDA0530X03S060C	●	5.3	6	66	20.9	28	36	0.9
KDA0540X03S060C	●	5.4	6	66	20.8	28	36	0.9
KDA0550X03S060C	●	5.5	6	66	20.7	28	36	1.0
KDA0560X03S060C	●	5.6	6	66	20.6	28	36	1.0
KDA0570X03S060C	●	5.7	6	66	20.4	28	36	1.0
KDA0580X03S060C	●	5.8	6	66	20.3	28	36	1.0
KDA0590X03S060C	●	5.9	6	66	20.1	28	36	1.0
KDA0600X03S060C	●	6	6	66	20	28	36	1.0
KDA0610X03S080C	●	6.1	8	79	25.9	34	36	1.1
KDA0620X03S080C	●	6.2	8	79	25.8	34	36	1.1

Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0630X03S080C	●	6.3	8	79	25.6	34	36	1.1
KDA0640X03S080C	●	6.4	8	79	25.5	34	36	1.1
KDA0650X03S080C	●	6.5	8	79	25.3	34	36	1.1
KDA0660X03S080C	●	6.6	8	79	25.3	34	36	1.2
KDA0670X03S080C	●	6.7	8	79	25.1	34	36	1.2
KDA0680X03S080C	●	6.8	8	79	25	34	36	1.2
KDA0690X03S080C	●	6.9	8	79	24.8	34	36	1.2
KDA0700X03S080C	●	7	8	79	24.7	34	36	1.2
KDA0710X03S080C	●	7.1	8	79	31.5	41	36	1.2
KDA0720X03S080C	●	7.2	8	79	31.5	41	36	1.3
KDA0730X03S080C	●	7.3	8	79	31.3	41	36	1.3
KDA0740X03S080C	●	7.4	8	79	31.2	41	36	1.3
KDA0750X03S080C	●	7.5	8	79	31	41	36	1.3
KDA0760X03S080C	●	7.6	8	79	30.9	41	36	1.3
KDA0770X03S080C	●	7.7	8	79	30.8	41	36	1.4
KDA0780X03S080C	●	7.8	8	79	30.7	41	36	1.4
KDA0790X03S080C	●	7.9	8	79	30.5	41	36	1.4
KDA0800X03S080C	●	8	8	79	30.4	41	36	1.4
KDA0810X03S100C	●	8.1	10	89	36.2	47	40	1.4
KDA0820X03S100C	●	8.2	10	89	36.1	47	40	1.4
KDA0830X03S100C	●	8.3	10	89	36	47	40	1.5
KDA0840X03S100C	●	8.4	10	89	35.9	47	40	1.5
KDA0850X03S100C	●	8.5	10	89	35.7	47	40	1.5
KDA0860X03S100C	●	8.6	10	89	35.6	47	40	1.5
KDA0870X03S100C	●	8.7	10	89	35.4	47	40	1.5
KDA0880X03S100C	●	8.8	10	89	35.4	47	40	1.6
KDA0890X03S100C	●	8.9	10	89	35.2	47	40	1.6
KDA0900X03S100C	●	9	10	89	35.1	47	40	1.6
KDA0910X03S100C	●	9.1	10	89	34.9	47	40	1.6
KDA0920X03S100C	●	9.2	10	89	34.8	47	40	1.6
KDA0930X03S100C	●	9.3	10	89	34.6	47	40	1.6
KDA0940X03S100C	●	9.4	10	89	34.6	47	40	1.7
KDA0950X03S100C	●	9.5	10	89	34.4	47	40	1.7

3D



Carbide



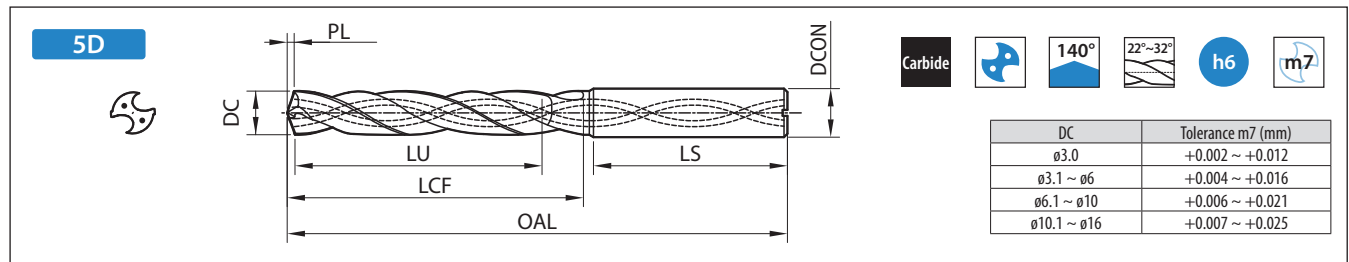
DC	Tolerance m7 (mm)
ø3.0	+0.002 ~ +0.012
ø3.1 ~ ø6	+0.004 ~ +0.016
ø6.1 ~ ø10	+0.006 ~ +0.021
ø10.1 ~ ø16	+0.007 ~ +0.025

Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0960X03S100C	●	9.6	10	89	34.3	47	40	1.7
KDA0970X03S100C	●	9.7	10	89	34.1	47	40	1.7
KDA0980X03S100C	●	9.8	10	89	34	47	40	1.7
KDA0990X03S100C	●	9.9	10	89	33.9	47	40	1.8
KDA1000X03S100C	●	10	10	89	33.8	47	40	1.8
KDA1010X03S120C	●	10.1	12	102	41.6	55	45	1.8
KDA1020X03S120C	●	10.2	12	102	41.5	55	45	1.8
KDA1030X03S120C	●	10.3	12	102	41.3	55	45	1.8
KDA1040X03S120C	●	10.4	12	102	41.2	55	45	1.8
KDA1050X03S120C	●	10.5	12	102	41.1	55	45	1.9
KDA1060X03S120C	●	10.6	12	102	41	55	45	1.9
KDA1070X03S120C	●	10.7	12	102	40.8	55	45	1.9
KDA1080X03S120C	●	10.8	12	102	40.7	55	45	1.9
KDA1090X03S120C	●	10.9	12	102	40.5	55	45	1.9
KDA1100X03S120C	●	11	12	102	40.5	55	45	2.0
KDA1110X03S120C	●	11.1	12	102	40.3	55	45	2.0
KDA1120X03S120C	●	11.2	12	102	40.2	55	45	2.0
KDA1130X03S120C	●	11.3	12	102	40	55	45	2.0
KDA1140X03S120C	●	11.4	12	102	39.9	55	45	2.0
KDA1150X03S120C	●	11.5	12	102	39.7	55	45	2.0
KDA1160X03S120C	●	11.6	12	102	39.7	55	45	2.1
KDA1170X03S120C	●	11.7	12	102	39.5	55	45	2.1
KDA1180X03S120C	●	11.8	12	102	39.4	55	45	2.1
KDA1190X03S120C	●	11.9	12	102	39.2	55	45	2.1
KDA1200X03S120C	●	12	12	102	39.1	55	45	2.1
KDA1210X03S140C	●	12.1	14	107	44	60	45	2.2
KDA1220X03S140C	●	12.2	14	107	43.9	60	45	2.2
KDA1230X03S140C	●	12.3	14	107	43.7	60	45	2.2
KDA1240X03S140C	●	12.4	14	107	43.6	60	45	2.2
KDA1250X03S140C	●	12.5	14	107	43.4	60	45	2.2
KDA1260X03S140C	●	12.6	14	107	43.3	60	45	2.2
KDA1270X03S140C	●	12.7	14	107	43.2	60	45	2.3
KDA1280X03S140C	●	12.8	14	107	43.1	60	45	2.3

Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA1290X03S140C	●	12.9	14	107	42.9	60	45	2.3
KDA1300X03S140C	●	13	14	107	42.8	60	45	2.3
KDA1310X03S140C	●	13.1	14	107	42.6	60	45	2.3
KDA1320X03S140C	●	13.2	14	107	42.6	60	45	2.4
KDA1330X03S140C	●	13.3	14	107	42.4	60	45	2.4
KDA1340X03S140C	●	13.4	14	107	42.3	60	45	2.4
KDA1350X03S140C	●	13.5	14	107	42.1	60	45	2.4
KDA1360X03S140C	●	13.6	14	107	42	60	45	2.4
KDA1370X03S140C	●	13.7	14	107	41.8	60	45	2.4
KDA1380X03S140C	●	13.8	14	107	41.8	60	45	2.5
KDA1390X03S140C	●	13.9	14	107	41.6	60	45	2.5
KDA1400X03S140C	●	14	14	107	41.5	60	45	2.5
KDA1410X03S160C	●	14.1	16	115	46.3	65	48	2.5
KDA1420X03S160C	●	14.2	16	115	46.2	65	48	2.5
KDA1430X03S160C	●	14.3	16	115	46.1	65	48	2.6
KDA1440X03S160C	●	14.4	16	115	46	65	48	2.6
KDA1450X03S160C	●	14.5	16	115	45.8	65	48	2.6
KDA1460X03S160C	●	14.6	16	115	45.7	65	48	2.6
KDA1470X03S160C	●	14.7	16	115	45.5	65	48	2.6
KDA1480X03S160C	●	14.8	16	115	45.4	65	48	2.6
KDA1490X03S160C	●	14.9	16	115	45.3	65	48	2.7
KDA1500X03S160C	●	15	16	115	45.2	65	48	2.7
KDA1510X03S160C	●	15.1	16	115	45	65	48	2.7
KDA1520X03S160C	●	15.2	16	115	44.9	65	48	2.7
KDA1530X03S160C	●	15.3	16	115	44.7	65	48	2.7
KDA1540X03S160C	●	15.4	16	115	44.7	65	48	2.8
KDA1550X03S160C	●	15.5	16	115	44.5	65	48	2.8
KDA1560X03S160C	●	15.6	16	115	44.4	65	48	2.8
KDA1570X03S160C	●	15.7	16	115	44.2	65	48	2.8
KDA1580X03S160C	●	15.8	16	115	44.1	65	48	2.8
KDA1590X03S160C	●	15.9	16	115	43.9	65	48	2.8
KDA1600X03S160C	●	16	16	115	43.9	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.

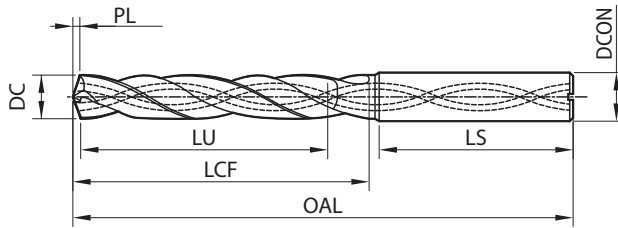
● : Available



Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0300X05S060C	●	3	6	66	24	28	36	0.5
KDA0310X05S060C	●	3.1	6	66	23.8	28	36	0.5
KDA0320X05S060C	●	3.2	6	66	23.7	28	36	0.5
KDA0330X05S060C	●	3.3	6	66	23.6	28	36	0.6
KDA0340X05S060C	●	3.4	6	66	23.5	28	36	0.6
KDA0350X05S060C	●	3.5	6	66	23.3	28	36	0.6
KDA0360X05S060C	●	3.6	6	66	23.2	28	36	0.6
KDA0370X05S060C	●	3.7	6	66	23	28	36	0.6
KDA0380X05S060C	●	3.8	6	74	30.9	36	36	0.6
KDA0390X05S060C	●	3.9	6	74	30.8	36	36	0.7
KDA0400X05S060C	●	4	6	74	30.7	36	36	0.7
KDA0410X05S060C	●	4.1	6	74	30.5	36	36	0.7
KDA0420X05S060C	●	4.2	6	74	30.4	36	36	0.7
KDA0430X05S060C	●	4.3	6	74	30.2	36	36	0.7
KDA0440X05S060C	●	4.4	6	74	30.2	36	36	0.8
KDA0450X05S060C	●	4.5	6	74	30	36	36	0.8
KDA0460X05S060C	●	4.6	6	74	29.9	36	36	0.8
KDA0470X05S060C	●	4.7	6	74	29.7	36	36	0.8
KDA0480X05S060C	●	4.8	6	82	37.6	44	36	0.8
KDA0490X05S060C	●	4.9	6	82	37.4	44	36	0.8
KDA0500X05S060C	●	5	6	82	37.4	44	36	0.9
KDA0510X05S060C	●	5.1	6	82	37.2	44	36	0.9
KDA0520X05S060C	●	5.2	6	82	37.1	44	36	0.9
KDA0530X05S060C	●	5.3	6	82	36.9	44	36	0.9
KDA0540X05S060C	●	5.4	6	82	36.8	44	36	0.9
KDA0550X05S060C	●	5.5	6	82	36.7	44	36	1.0
KDA0560X05S060C	●	5.6	6	82	36.6	44	36	1.0
KDA0570X05S060C	●	5.7	6	82	36.4	44	36	1.0
KDA0580X05S060C	●	5.8	6	82	36.3	44	36	1.0
KDA0590X05S060C	●	5.9	6	82	36.1	44	36	1.0
KDA0600X05S060C	●	6	6	82	36	44	36	1.0
KDA0610X05S080C	●	6.1	8	91	44.9	53	36	1.1
KDA0620X05S080C	●	6.2	8	91	44.8	53	36	1.1

Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0630X05S080C	●	6.3	8	91	44.6	53	36	1.1
KDA0640X05S080C	●	6.4	8	91	44.5	53	36	1.1
KDA0650X05S080C	●	6.5	8	91	44.3	53	36	1.1
KDA0660X05S080C	●	6.6	8	91	44.3	53	36	1.2
KDA0670X05S080C	●	6.7	8	91	44.1	53	36	1.2
KDA0680X05S080C	●	6.8	8	91	44	53	36	1.2
KDA0690X05S080C	●	6.9	8	91	43.8	53	36	1.2
KDA0700X05S080C	●	7	8	91	43.7	53	36	1.2
KDA0710X05S080C	●	7.1	8	91	43.5	53	36	1.2
KDA0720X05S080C	●	7.2	8	91	43.5	53	36	1.3
KDA0730X05S080C	●	7.3	8	91	43.3	53	36	1.3
KDA0740X05S080C	●	7.4	8	91	43.2	53	36	1.3
KDA0750X05S080C	●	7.5	8	91	43	53	36	1.3
KDA0760X05S080C	●	7.6	8	91	42.9	53	36	1.3
KDA0770X05S080C	●	7.7	8	91	42.8	53	36	1.4
KDA0780X05S080C	●	7.8	8	91	42.7	53	36	1.4
KDA0790X05S080C	●	7.9	8	91	42.5	53	36	1.4
KDA0800X05S080C	●	8	8	91	42.4	53	36	1.4
KDA0810X05S100C	●	8.1	10	103	50.2	61	40	1.4
KDA0820X05S100C	●	8.2	10	103	50.1	61	40	1.4
KDA0830X05S100C	●	8.3	10	103	50	61	40	1.5
KDA0840X05S100C	●	8.4	10	103	49.9	61	40	1.5
KDA0850X05S100C	●	8.5	10	103	49.7	61	40	1.5
KDA0860X05S100C	●	8.6	10	103	49.6	61	40	1.5
KDA0870X05S100C	●	8.7	10	103	49.4	61	40	1.5
KDA0880X05S100C	●	8.8	10	103	49.4	61	40	1.6
KDA0890X05S100C	●	8.9	10	103	49.2	61	40	1.6
KDA0900X05S100C	●	9	10	103	49.1	61	40	1.6
KDA0910X05S100C	●	9.1	10	103	48.9	61	40	1.6
KDA0920X05S100C	●	9.2	10	103	48.8	61	40	1.6
KDA0930X05S100C	●	9.3	10	103	48.6	61	40	1.6
KDA0940X05S100C	●	9.4	10	103	48.6	61	40	1.7
KDA0950X05S100C	●	9.5	10	103	48.4	61	40	1.7

5D



Carbide



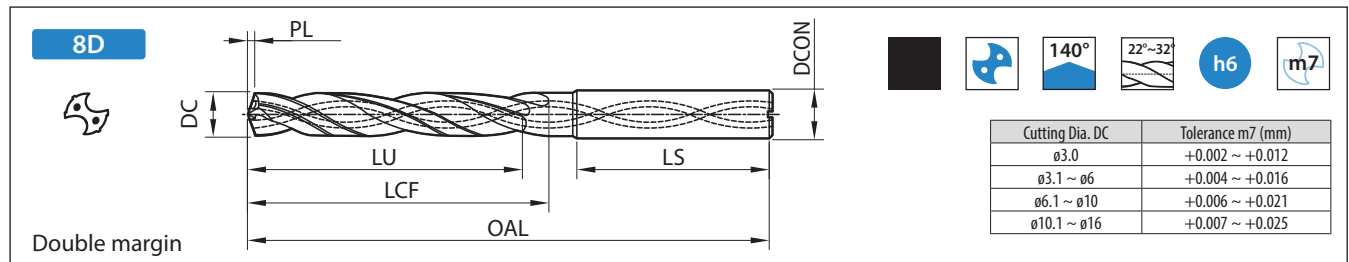
DC	Tolerance m7 (mm)
ø3.0	+0.002 ~ +0.012
ø3.1 ~ ø6	+0.004 ~ +0.016
ø6.1 ~ ø10	+0.006 ~ +0.021
ø10.1 ~ ø16	+0.007 ~ +0.025

Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0960X05S100C	●	9.6	10	103	48.3	61	40	1.7
KDA0970X05S100C	●	9.7	10	103	48.1	61	40	1.7
KDA0980X05S100C	●	9.8	10	103	48	61	40	1.7
KDA0990X05S100C	●	9.9	10	103	47.9	61	40	1.8
KDA1000X05S100C	●	10	10	103	47.8	61	40	1.8
KDA1010X05S120C	●	10.1	12	118	57.6	71	45	1.8
KDA1020X05S120C	●	10.2	12	118	57.5	71	45	1.8
KDA1030X05S120C	●	10.3	12	118	57.3	71	45	1.8
KDA1040X05S120C	●	10.4	12	118	57.2	71	45	1.8
KDA1050X05S120C	●	10.5	12	118	57.1	71	45	1.9
KDA1060X05S120C	●	10.6	12	118	57	71	45	1.9
KDA1070X05S120C	●	10.7	12	118	56.8	71	45	1.9
KDA1080X05S120C	●	10.8	12	118	56.7	71	45	1.9
KDA1090X05S120C	●	10.9	12	118	56.5	71	45	1.9
KDA1100X05S120C	●	11	12	118	56.5	71	45	2.0
KDA1110X05S120C	●	11.1	12	118	56.3	71	45	2.0
KDA1120X05S120C	●	11.2	12	118	56.2	71	45	2.0
KDA1130X05S120C	●	11.3	12	118	56	71	45	2.0
KDA1140X05S120C	●	11.4	12	118	55.9	71	45	2.0
KDA1150X05S120C	●	11.5	12	118	55.7	71	45	2.0
KDA1160X05S120C	●	11.6	12	118	55.7	71	45	2.1
KDA1170X05S120C	●	11.7	12	118	55.5	71	45	2.1
KDA1180X05S120C	●	11.8	12	118	55.4	71	45	2.1
KDA1190X05S120C	●	11.9	12	118	55.2	71	45	2.1
KDA1200X05S120C	●	12	12	118	55.1	71	45	2.1
KDA1210X05S140C	●	12.1	14	124	61	77	45	2.2
KDA1220X05S140C	●	12.2	14	124	60.9	77	45	2.2
KDA1230X05S140C	●	12.3	14	124	60.7	77	45	2.2
KDA1240X05S140C	●	12.4	14	124	60.6	77	45	2.2
KDA1250X05S140C	●	12.5	14	124	60.4	77	45	2.2
KDA1260X05S140C	●	12.6	14	124	60.3	77	45	2.2
KDA1270X05S140C	●	12.7	14	124	60.2	77	45	2.3
KDA1280X05S140C	●	12.8	14	124	60.1	77	45	2.3

Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA1290X05S140C	●	12.9	14	124	59.9	77	45	2.3
KDA1300X05S140C	●	13	14	124	59.8	77	45	2.3
KDA1310X05S140C	●	13.1	14	124	59.6	77	45	2.3
KDA1320X05S140C	●	13.2	14	124	59.6	77	45	2.4
KDA1330X05S140C	●	13.3	14	124	59.4	77	45	2.4
KDA1340X05S140C	●	13.4	14	124	59.3	77	45	2.4
KDA1350X05S140C	●	13.5	14	124	59.1	77	45	2.4
KDA1360X05S140C	●	13.6	14	124	59	77	45	2.4
KDA1370X05S140C	●	13.7	14	124	58.8	77	45	2.4
KDA1380X05S140C	●	13.8	14	124	58.8	77	45	2.5
KDA1390X05S140C	●	13.9	14	124	58.6	77	45	2.5
KDA1400X05S140C	●	14	14	124	58.5	77	45	2.5
KDA1410X05S160C	●	14.1	16	133	64.3	83	48	2.5
KDA1420X05S160C	●	14.2	16	133	64.2	83	48	2.5
KDA1430X05S160C	●	14.3	16	133	64.1	83	48	2.6
KDA1440X05S160C	●	14.4	16	133	64	83	48	2.6
KDA1450X05S160C	●	14.5	16	133	63.8	83	48	2.6
KDA1460X05S160C	●	14.6	16	133	63.7	83	48	2.6
KDA1470X05S160C	●	14.7	16	133	63.5	83	48	2.6
KDA1480X05S160C	●	14.8	16	133	63.4	83	48	2.6
KDA1490X05S160C	●	14.9	16	133	63.3	83	48	2.7
KDA1500X05S160C	●	15	16	133	63.2	83	48	2.7
KDA1510X05S160C	●	15.1	16	133	63	83	48	2.7
KDA1520X05S160C	●	15.2	16	133	62.9	83	48	2.7
KDA1530X05S160C	●	15.3	16	133	62.7	83	48	2.7
KDA1540X05S160C	●	15.4	16	133	62.7	83	48	2.8
KDA1550X05S160C	●	15.5	16	133	62.5	83	48	2.8
KDA1560X05S160C	●	15.6	16	133	62.4	83	48	2.8
KDA1570X05S160C	●	15.7	16	133	62.2	83	48	2.8
KDA1580X05S160C	●	15.8	16	133	62.1	83	48	2.8
KDA1590X05S160C	●	15.9	16	133	61.9	83	48	2.8
KDA1600X05S160C	●	16	16	133	61.9	83	48	2.9

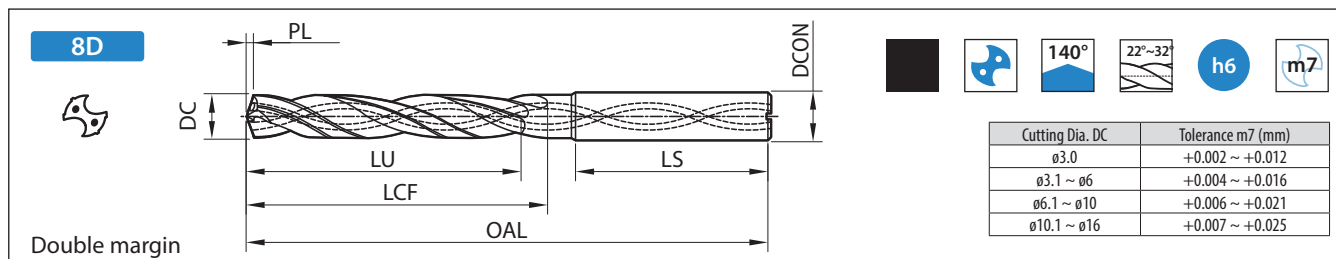
* Drilling depth is an approximate indication of L/D.
Depending on the size, it may be smaller than the listed L/D.

● : Available



Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0300X08S060C	●	3	6	72	30	34	36	0.5
KDA0310X08S060C	●	3.1	6	72	30	34	36	0.6
KDA0320X08S060C	●	3.2	6	72	29.8	34	36	0.6
KDA0330X08S060C	●	3.3	6	72	29.7	34	36	0.6
KDA0340X08S060C	●	3.4	6	72	29.5	34	36	0.6
KDA0350X08S060C	●	3.5	6	72	29.4	34	36	0.6
KDA0360X08S060C	●	3.6	6	72	29.3	34	36	0.7
KDA0370X08S060C	●	3.7	6	72	29.2	34	36	0.7
KDA0380X08S060C	●	3.8	6	81	38	43	36	0.7
KDA0390X08S060C	●	3.9	6	81	37.9	43	36	0.7
KDA0400X08S060C	●	4	6	81	37.7	43	36	0.7
KDA0410X08S060C	●	4.1	6	81	37.6	43	36	0.7
KDA0420X08S060C	●	4.2	6	81	37.5	43	36	0.8
KDA0430X08S060C	●	4.3	6	81	37.4	43	36	0.8
KDA0440X08S060C	●	4.4	6	81	37.2	43	36	0.8
KDA0450X08S060C	●	4.5	6	81	37.1	43	36	0.8
KDA0460X08S060C	●	4.6	6	81	36.9	43	36	0.8
KDA0470X08S060C	●	4.7	6	81	36.9	43	36	0.9
KDA0480X08S060C	●	4.8	6	95	50.7	57	36	0.9
KDA0490X08S060C	●	4.9	6	95	50.6	57	36	0.9
KDA0500X08S060C	●	5	6	95	50.4	57	36	0.9
KDA0510X08S060C	●	5.1	6	95	50.3	57	36	0.9
KDA0520X08S060C	●	5.2	6	95	50.1	57	36	0.9
KDA0530X08S060C	●	5.3	6	95	50.1	57	36	1
KDA0540X08S060C	●	5.4	6	95	49.9	57	36	1
KDA0550X08S060C	●	5.5	6	95	49.8	57	36	1
KDA0560X08S060C	●	5.6	6	95	49.6	57	36	1
KDA0570X08S060C	●	5.7	6	95	49.5	57	36	1
KDA0580X08S060C	●	5.8	6	95	49.4	57	36	1.1
KDA0590X08S060C	●	5.9	6	95	49.3	57	36	1.1
KDA0600X08S060C	●	6	6	95	49.1	57	36	1.1
KDA0610X08S080C	●	6.1	8	114	68	76	36	1.1
KDA0620X08S080C	●	6.2	8	114	67.8	76	36	1.1

Description	Availability	Dimensions (mm)						
		DC	DCON	OAL	LU	LCF	LS	PL
KDA0630X08S080C	●	6.3	8	114	67.7	76	36	1.1
KDA0640X08S080C	●	6.4	8	114	67.6	76	36	1.2
KDA0650X08S080C	●	6.5	8	114	67.5	76	36	1.2
KDA0660X08S080C	●	6.6	8	114	67.3	76	36	1.2
KDA0670X08S080C	●	6.7	8	114	67.2	76	36	1.2
KDA0680X08S080C	●	6.8	8	114	67	76	36	1.2
KDA0690X08S080C	●	6.9	8	114	67	76	36	1.3
KDA0700X08S080C	●	7	8	114	66.8	76	36	1.3
KDA0710X08S080C	●	7.1	8	114	66.7	76	36	1.3
KDA0720X08S080C	●	7.2	8	114	66.5	76	36	1.3
KDA0730X08S080C	●	7.3	8	114	66.4	76	36	1.3
KDA0740X08S080C	●	7.4	8	114	66.2	76	36	1.3
KDA0750X08S080C	●	7.5	8	114	66.2	76	36	1.4
KDA0760X08S080C	●	7.6	8	114	66	76	36	1.4
KDA0770X08S080C	●	7.7	8	114	65.9	76	36	1.4
KDA0780X08S080C	●	7.8	8	114	65.7	76	36	1.4
KDA0790X08S080C	●	7.9	8	114	65.6	76	36	1.4
KDA0800X08S080C	●	8	8	114	65.5	76	36	1.5
KDA0810X08S100C	●	8.1	10	142	84.4	95	40	1.5
KDA0820X08S100C	●	8.2	10	142	84.2	95	40	1.5
KDA0830X08S100C	●	8.3	10	142	84.1	95	40	1.5
KDA0840X08S100C	●	8.4	10	142	83.9	95	40	1.5
KDA0850X08S100C	●	8.5	10	142	83.8	95	40	1.5
KDA0860X08S100C	●	8.6	10	142	83.7	95	40	1.6
KDA0870X08S100C	●	8.7	10	142	83.6	95	40	1.6
KDA0880X08S100C	●	8.8	10	142	83.4	95	40	1.6
KDA0890X08S100C	●	8.9	10	142	83.3	95	40	1.6
KDA0900X08S100C	●	9	10	142	83.1	95	40	1.6
KDA0910X08S100C	●	9.1	10	142	83.1	95	40	1.7
KDA0920X08S100C	●	9.2	10	142	82.9	95	40	1.7
KDA0930X08S100C	●	9.3	10	142	82.8	95	40	1.7
KDA0940X08S100C	●	9.4	10	142	82.6	95	40	1.7
KDA0950X08S100C	●	9.5	10	142	82.5	95	40	1.7



Reference cutting conditions table

KDA series

3D

5D

8D

Workpiece	Vc (m/min.)		f (mm/rev)							
	Type N 	Type C 	Ø3	Ø4	Ø6	Ø8	Ø10	Ø12	Ø14	Ø16
Mild Steel/Low Carbon Steel S45C/S10C (< 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 S35C/S50C (< 25 HRC)	45-90	60-120	0.09-0.16	0.11-0.19	0.14-0.23	0.19-0.31	0.23-0.38	0.24-0.41	0.28-0.45	0.30-0.50
Alloy Steel/Tool Steel SCM/SCr/SNCM (< 35 HRC)	45-90	50-110	0.09-0.16	0.11-0.19	0.14-0.23	0.19-0.31	0.23-0.38	0.24-0.41	0.28-0.45	0.30-0.50
Alloy Steel/Tool Steel SCM/SCr/SNCM (35-48 HRC)	40-80	40-90	0.09-0.14	0.10-0.17	0.13-0.22	0.17-0.29	0.21-0.35	0.22-0.37	0.26-0.41	0.28-0.44
Austenitic Stainless Steel SUS304 (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 FC250 (< 32 HRC)	60-100	60-140	0.13-0.20	0.15-0.23	0.17-0.30	0.20-0.35	0.23-0.40	0.25-0.45	0.28-0.48	0.30-0.50
Alloy Cast Iron/Nodular Cast Iron FCD450 (< 28 HRC)	60-100	60-140	0.11-0.18	0.13-0.20	0.15-0.25	0.17-0.32	0.20-0.36	0.22-0.42	0.24-0.45	0.25-0.48
High Alloy Cast Iron and Nodular Cast Iron (< 45 HRC)	60-90	60-100	0.06-0.11	0.08-0.13	0.10-0.16	0.12-0.20	0.14-0.26	0.16-0.28	0.18-0.30	0.20-0.32

Precautions

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

Descriptions view

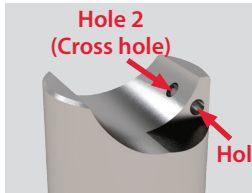
KDA0950X03S100C

KDA	0950	×	03	S100	C
Product name High efficiency Coated solid carbide drill	Cutting diameter DC Ø9.5		Drilling Depth* (L/D) 03: 3×D 05: 5×D 08: 8×D	Shank diameter DCON Ø10.0	Type N: No coolant holes C: With coolant holes

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

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

Type C



Body SCM440

Ø6.9 (5×D) Drilling

Tool life

KDA

2,400 pcs or more / 1 KDA

Competitor C
Competitor D

2,000 pcs / 1 KDA

Cutting conditions:

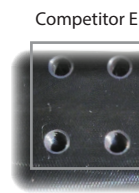
Hole 1: $V_c = 50$ m/min., $f = 0.1$ mm/rev, $H = 25$ mm

Hole 2: $V_c = 40$ m/min., $f = 0.1$ mm/rev, $H = 15$ mm

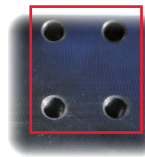
Wet (Internal coolant) Combined cutting machine KDA0690X055080C

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

Type N



KDA



Mould part cold tool steel

Ø5.1 (3×D) Drilling

Hole diameter variation ($H = 7.5$ mm)

KDA

0.022 mm

Competitor E

0.042 mm

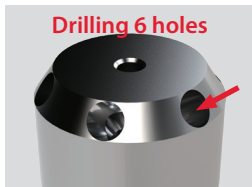
Cutting conditions:

$V_c = 80$ m/min., $f = 0.15$ mm/rev, $H = 15$ mm

Wet (External coolant) BT50 KDA0510X035060N

3 KDA was stable in stainless steel machining, and the tool life was more than 2.3 times longer than the competitor. Machining by competitor was unstable due to sudden fracture.

Type C



Nozzle SUS304

Ø5.5 (3×D) Drilling
(Final drill dia.: Ø6.0)

KDA Cutting edge condition: Good
(After drilling 5,600 holes)



Tool life

KDA

5,600 holes or more / 1 KDA

Competitor F

2,400 holes / 1 KDA

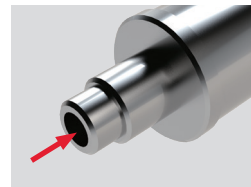
Cutting conditions:

$V_c = 30$ m/min., $f = 0.06$ mm/rev, $H = 9$ mm

Wet (Internal coolant) KDA0550X035060C

4 Achieved stable machining with a tool life of 1.2 times. Competitor's machining was unstable and required two tools per work lot. One KDA was sufficient.

Type N



Shaft SUS630

Ø5.1 (3×D) Drilling

Tool life

KDA

1,000 pcs / 1 KDA

Competitor G

500 – 800 pcs / 1 KDA (Unstable)

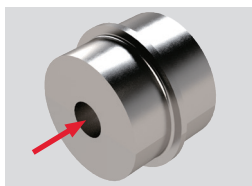
Cutting conditions:

$V_c = 50$ m/min., $f = 0.1$ mm/rev, $H = 10$ mm

Wet (External coolant) KDA0510X035060N

5 KDA was possible to machining well up to the same tool life as the competitor. KDA was able to reduce costs.

Type N



Valve stainless steel

Ø3.5 (3×D) Drilling

Tool life

KDA

2,400 pcs / 1 KDA

Competitor H

2,400 pcs / 1 KDA

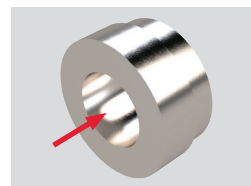
Cutting conditions:

$V_c = 30$ m/min., $f = 0.1$ mm/rev, $H = 10$ mm (3mm Step)

Wet (External coolant) Automatic lathe KDA0350X035060N

6 KDA maintained stable machining. Achieved tool life 1.3 times longer than the competitor.

Type N



Pedestal for tool S45C

Ø11.6 (3×D) Drilling

Tool life

KDA

6,800 pcs / 1 KDA

Competitor I

5,000 pcs / 1 KDA

Cutting conditions:

$V_c = 54$ m/min., $f = 0.22$ mm/rev, $H = 30$ mm

Wet (External coolant) Combined cutting machine KDA1160X035120N

WE KNOW IT'S ALL ABOUT UNDERSTANDING REAL LIFE TO
ENGINEER THE RIGHT SOLUTION, THAT...

***KEEPS YOU
AHEAD***



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