

KDD-2

超硬段付ドリル (90° 面取刃付) Tungsten Carbide 2 Flutes Step Drill

- 先端径、太径ともネジレ角30°
Twist Angle 30° at both Small Flute Diameter and Large Flute Diameter
- 先端径φ0.5~φ6まで0.05とびにラインナップ
Line-upped φ0.5~φ6 at pitch 0.05



被削材 Workpiece				
一般構造鋼 General Structural Steel	炭素鋼 Carbon Steel	合金鋼・工具鋼 Alloy Steel Tool Steel	ステンレス鋼 Stainless Steel Ceramics	アルミ合金 Aluminum Alloy
○	○	○	○	○

- 切削条件表はP157に記載
- Cutting conditions are recommended on page 157.

単位 [寸法:mm]
Unit [size:mm]

品番 Code No.	刃径 D Flute Diameter	刃長 ℓ1 Flute Length	溝長 ℓ2 Groove length	全長 L Total Length	柄径 d Shank Diameter	適用ネジ Applicable Thread
KDD-205002	0.5	2	8	50	3	—
KDD-205005	0.5	5	12	50	3	—
KDD-205502	0.55	2	8	50	3	—
KDD-205505	0.55	5	12	50	3	—
KDD-206002	0.6	2	8	50	3	—
KDD-206005	0.6	5	12	50	3	—
KDD-206502	0.65	2	8	50	3	—
KDD-206505	0.65	5	12	50	3	—
KDD-207002	0.7	2	8	50	3	—
KDD-207005	0.7	5	12	50	3	—
KDD-207503	0.75	3	10	50	3	M1×0.25
KDD-207506	0.75	6	15	50	3	M1×0.25
KDD-208003	0.8	3	10	50	3	M1×0.2
KDD-208006	0.8	6	15	50	3	M1×0.2
KDD-208503	0.85	3	10	50	3	M1.1×0.25
KDD-208506	0.85	6	15	50	3	M1.1×0.25
KDD-209003	0.9	3	10	50	3	M1.1×0.2
KDD-209006	0.9	6	15	50	3	M1.1×0.2
KDD-209503	0.95	3	10	50	3	M1.2×0.25
KDD-209506	0.95	6	15	50	3	M1.2×0.25
KDD-210003	1	3	10	50	3	M1.2×0.2
KDD-210006	1	6	15	50	3	M1.2×0.2
KDD-210503	1.05	3	10	50	3	
KDD-210506	1.05	6	15	50	3	
KDD-211003	1.1	3	10	50	3	M1.4×0.3
KDD-211006	1.1	6	15	50	3	M1.4×0.3
KDD-211503	1.15	3	10	50	3	
KDD-211506	1.15	6	15	50	3	
KDD-212003	1.2	3	10	50	3	M1.4×0.2
KDD-212006	1.2	6	15	50	3	M1.4×0.2



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KDD-212503	1.25	3	10	50	3	M1.6×0.35
KDD-212506	1.25	6	15	50	3	M1.6×0.35
KDD-213003	1.3	3	10	50	3	
KDD-213006	1.3	6	15	50	3	
KDD-213503	1.35	3	10	50	3	
KDD-213506	1.35	6	15	50	3	
KDD-214003	1.4	3	10	50	3	M1.6×0.2
KDD-214006	1.4	6	15	50	3	M1.7×0.3
KDD-214503	1.45	3	10	50	3	
KDD-214506	1.45	6	15	50	3	
KDD-215003	1.5	3	10	50	3	M1.7×0.2
KDD-215006	1.5	6	15	50	3	M1.7×0.2
KDD-215503	1.55	3	10	50	3	
KDD-215506	1.55	6	15	50	3	
KDD-216005	1.6	5	15	60	4	M1.8×0.2
KDD-216010	1.6	10	20	60	4	M1.8×0.2
KDD-216505	1.65	5	15	60	4	
KDD-216510	1.65	10	20	60	4	
KDD-217005	1.7	5	15	60	4	
KDD-217010	1.7	10	20	60	4	
KDD-217505	1.75	5	15	60	4	M2×0.25
KDD-217510	1.75	10	20	60	4	M2.2×0.45
KDD-218005	1.8	5	15	60	4	
KDD-218010	1.8	10	20	60	4	
KDD-218505	1.85	5	15	60	4	
KDD-218510	1.85	10	20	60	4	
KDD-219005	1.9	5	15	60	4	
KDD-219010	1.9	10	20	60	4	
KDD-219505	1.95	5	15	60	4	M2.2×0.25
KDD-219510	1.95	10	20	60	4	M2.3×0.35

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KDD-220005	2	5	15	60	4	
KDD-220010	2	10	20	60	4	
KDD-220505	2.05	5	15	60	4	
KDD-220510	2.05	10	20	60	4	
KDD-221006	2.1	6	15	60	4	M2.5×0.45
KDD-221012	2.1	12	20	60	4	M2.5×0.45
KDD-221506	2.15	6	15	60	4	
KDD-221512	2.15	12	20	60	4	
KDD-222006	2.2	6	15	60	4	M2.5×0.35
KDD-222012	2.2	12	20	60	4	M2.6×0.45
KDD-222506	2.25	6	15	60	4	
KDD-222512	2.25	12	20	60	4	
KDD-223006	2.3	6	15	60	4	
KDD-223012	2.3	12	20	60	4	
KDD-223506	2.35	6	15	60	4	
KDD-223512	2.35	12	20	60	4	
KDD-224006	2.4	6	15	60	4	M2.6×0.35
KDD-224012	2.4	12	20	60	4	M2.6×0.35
KDD-224506	2.45	6	15	60	4	
KDD-224512	2.45	12	20	60	4	
KDD-225006	2.5	6	15	70	6	M3×0.5
KDD-225012	2.5	12	20	70	6	M3×0.5
KDD-225506	2.55	6	15	70	6	
KDD-225512	2.55	12	20	70	6	
KDD-226006	2.6	6	15	70	6	
KDD-226012	2.6	12	20	70	6	
KDD-226510	2.65	10	25	70	6	M3×0.35
KDD-226520	2.65	20	35	70	6	M3×0.35
KDD-227010	2.7	10	25	70	6	
KDD-227020	2.7	20	35	70	6	
KDD-227510	2.75	10	25	70	6	
KDD-227520	2.75	20	35	70	6	
KDD-228010	2.8	10	25	70	6	
KDD-228020	2.8	20	35	70	6	
KDD-228510	2.85	10	25	70	6	
KDD-228520	2.85	20	35	70	6	
KDD-229010	2.9	10	25	70	6	
KDD-229020	2.9	20	35	70	6	
KDD-229510	2.95	10	25	70	6	
KDD-229520	2.95	20	35	70	6	
KDD-230010	3	10	25	70	6	M3.5×0.6
KDD-230020	3	20	35	70	6	M3.5×0.6
KDD-230510	3.05	10	25	70	6	
KDD-230520	3.05	20	35	70	6	
KDD-231010	3.1	10	25	70	6	
KDD-231020	3.1	20	35	70	6	
KDD-231510	3.15	10	25	70	6	M3.5×0.35
KDD-231520	3.15	20	35	70	6	M3.5×0.35

品番 Code No.	刃径 D Flute Diameter	刃長 ℓ1 Flute Length	溝長 ℓ2 Groove length	全長 L Total Length	柄径 d Shank Diameter	適用ネジ Applicable Thread
KDD-232010	3.2	10	25	70	6	
KDD-232020	3.2	20	35	70	6	
KDD-232510	3.25	10	25	70	6	
KDD-232520	3.25	20	35	70	6	
KDD-233010	3.3	10	25	70	6	M4×0.7
KDD-233020	3.3	20	35	70	6	M4×0.7
KDD-233510	3.35	10	25	70	6	
KDD-233520	3.35	20	35	70	6	
KDD-234010	3.4	10	25	70	6	
KDD-234020	3.4	20	35	70	6	
KDD-234510	3.45	10	25	70	6	
KDD-234520	3.45	20	35	70	6	
KDD-235010	3.5	10	25	70	6	M4×0.5
KDD-235020	3.5	20	35	70	6	M4×0.5
KDD-235510	3.55	10	25	70	6	
KDD-235520	3.55	20	35	70	6	
KDD-236010	3.6	10	25	70	6	
KDD-236020	3.6	20	35	70	6	
KDD-236510	3.65	10	25	70	6	
KDD-236520	3.65	20	35	70	6	
KDD-237010	3.7	10	25	70	6	
KDD-237020	3.7	20	35	70	6	
KDD-237510	3.75	10	25	70	6	M4.5×0.75
KDD-237520	3.75	20	35	70	6	M4.5×0.75
KDD-238010	3.8	10	25	70	6	
KDD-238020	3.8	20	35	70	6	
KDD-238510	3.85	10	25	70	6	
KDD-238520	3.85	20	35	70	6	
KDD-239010	3.9	10	25	70	6	
KDD-239020	3.9	20	35	70	6	
KDD-239510	3.95	10	25	70	6	
KDD-239520	3.95	20	35	70	6	
KDD-240010	4	10	25	80	8	M4.5×0.5
KDD-240020	4	20	35	80	8	M4.5×0.5
KDD-240510	4.05	10	25	80	8	
KDD-240520	4.05	20	35	80	8	
KDD-241010	4.1	10	25	80	8	M5×0.9
KDD-241020	4.1	20	35	80	8	M5×0.9
KDD-241510	4.15	10	25	80	8	
KDD-241520	4.15	20	35	80	8	
KDD-242010	4.2	10	25	80	8	M5×0.8
KDD-242020	4.2	20	35	80	8	M5×0.8
KDD-242510	4.25	10	25	80	8	
KDD-242520	4.25	20	35	80	8	
KDD-243010	4.3	10	25	80	8	
KDD-243020	4.3	20	35	80	8	
KDD-243510	4.35	10	25	80	8	
KDD-243520	4.35	20	35	80	8	

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KDD-244010	4.4	10	25	80	8	
KDD-244020	4.4	20	35	80	8	
KDD-244510	4.45	10	25	80	8	
KDD-244520	4.45	20	35	80	8	
KDD-245010	4.5	10	25	80	8	M5×0.5
KDD-245020	4.5	20	35	80	8	M5×0.5
KDD-245510	4.55	10	25	80	8	
KDD-245520	4.55	20	35	80	8	
KDD-246010	4.6	10	25	80	8	M5.5×0.9
KDD-246020	4.6	20	35	80	8	M5.5×0.9
KDD-246510	4.65	10	25	80	8	
KDD-246520	4.65	20	35	80	8	
KDD-247010	4.7	10	25	80	8	
KDD-247020	4.7	20	35	80	8	
KDD-247510	4.75	10	25	80	8	M5.5×0.75
KDD-247520	4.75	20	35	80	8	M5.5×0.75
KDD-248010	4.8	10	25	80	8	
KDD-248020	4.8	20	35	80	8	
KDD-248510	4.85	10	25	80	8	
KDD-248520	4.85	20	35	80	8	
KDD-249010	4.9	10	25	80	8	
KDD-249020	4.9	20	35	80	8	
KDD-249510	4.95	10	25	80	8	
KDD-249520	4.95	20	35	80	8	
KDD-250015	5	15	30	80	8	M5.5×0.5
KDD-250025	5	25	40	80	8	M6×1
KDD-250515	5.05	15	30	80	8	
KDD-250525	5.05	25	40	80	8	
KDD-251015	5.1	15	30	80	8	
KDD-251025	5.1	25	40	80	8	
KDD-251515	5.15	15	30	80	8	
KDD-251525	5.15	25	40	80	8	
KDD-252015	5.2	15	30	80	8	
KDD-252025	5.2	25	40	80	8	
KDD-252515	5.25	15	30	80	8	M6×0.75
KDD-252525	5.25	25	40	80	8	M6×0.75
KDD-253015	5.3	15	30	80	8	
KDD-253025	5.3	25	40	80	8	
KDD-253515	5.35	15	30	80	8	
KDD-253525	5.35	25	40	80	8	
KDD-254015	5.4	15	30	80	8	
KDD-254025	5.4	25	40	80	8	
KDD-254515	5.45	15	30	80	8	
KDD-254525	5.45	25	40	80	8	
KDD-255015	5.5	15	30	80	8	M6×0.5
KDD-255025	5.5	25	40	80	8	M6×0.5
KDD-255515	5.55	15	30	80	8	
KDD-255525	5.55	25	40	80	8	

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切削条件参考 Referential Cutting Conditions

被削材 Workpiece	炭素鋼・一般構造用鋼 Carbon Steel・ General Structural Steel SS・S55C		合金鋼・工具鋼 Alloy Steel・Tool Steel SCM・SKT・SKS・SKD		ステンレス鋼 Stainless Steel SUS303,SUS304,SUS416		アルミニウム合金 Aluminum Alloy ADC・AC	
刃 径 Flute Diameter mm	切削速度 Cutting Speed m/min	送り速度 Feed mm/rev	切削速度 Cutting Speed m/min	送り速度 Feed mm/rev	切削速度 Cutting Speed m/min	送り速度 Feed mm/rev	切削速度 Cutting Speed m/min	送り速度 Feed mm/rev
0.5～0.95	15～30	0.01～0.02	10～20	0.007～0.015	6～15	0.001～0.005	40～60	0.06～0.15
1.0～1.95	25～40	0.02～0.04	10～20	0.01 ～0.02	10～20	0.005～0.02	60～80	0.1 ～0.2
2.0～2.95	25～40	0.04～0.06	15～25	0.02 ～0.04	20～30	0.01 ～0.03	60～80	0.1 ～0.2
3.0～3.95	30～40	0.06～0.08	20～30	0.04 ～0.06	20～30	0.03 ～0.05	60～80	0.1 ～0.2
4.0～4.95	30～40	0.08～0.1	20～30	0.05 ～0.08	20～30	0.04 ～0.06	60～80	0.1 ～0.2
5.0～6.0	30～45	0.1 ～0.12	20～30	0.05 ～0.1	20～30	0.05 ～0.1	80～100	0.2 ～0.3
備 考 Remarks	・ 工具取付時の振れを最小に抑えてください。 ・ 切削油を使用して下さい。 ・ Minimize Run out on fixing tool. ・ Use Cutting Oil.							