

KDSA-2

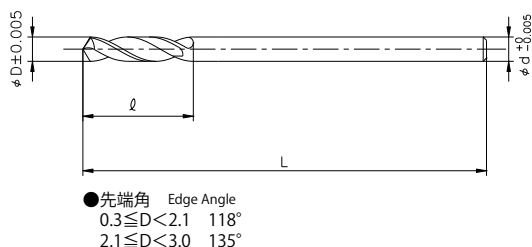
超硬ストレートドリル・TiA ℓ Nコーティング付
Tungsten Carbide straight Drill TiA ℓ N Coating

- TiAlNコーティングを施しました
TiAlN coating is applied
- φ0.3～φ3.0まで0.01とびにラインナップ
Lineup from φ0.3 to φ3.0 in 0.01 increments



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

- 切削条件表はP125に記載
- Cutting conditions are recommended on page 125.



単位[寸法:mm]
Unit [size:mm]

品番 Code No.	刃径 D Flute Diameter	溝長 ℓ Groove length	全長 L Total Length
KDSA-2030	0.3	4	30
KDSA-2031	0.31	4	30
KDSA-2032	0.32	4	30
KDSA-2033	0.33	4	30
KDSA-2034	0.34	4	30
KDSA-2035	0.35	4	30
KDSA-2036	0.36	4	30
KDSA-2037	0.37	4	30
KDSA-2038	0.38	4	30
KDSA-2039	0.39	4	30
KDSA-2040	0.4	5	30
KDSA-2041	0.41	5	30
KDSA-2042	0.42	5	30
KDSA-2043	0.43	5	30
KDSA-2044	0.44	5	30
KDSA-2045	0.45	5	30
KDSA-2046	0.46	5	30
KDSA-2047	0.47	5	30
KDSA-2048	0.48	5	30
KDSA-2049	0.49	5	30
KDSA-2050	0.5	6	30
KDSA-2051	0.51	6	30
KDSA-2052	0.52	6	30
KDSA-2053	0.53	6	30
KDSA-2054	0.54	6	30
KDSA-2055	0.55	6	30
KDSA-2056	0.56	6	30
KDSA-2057	0.57	6	30
KDSA-2058	0.58	6	30
KDSA-2059	0.59	6	30

品番 Code No.	刃径 D Flute Diameter	溝長 ℓ Groove length	全長 L Total Length
KDSA-2060	0.6	6	30
KDSA-2061	0.61	6	30
KDSA-2062	0.62	6	30
KDSA-2063	0.63	6	30
KDSA-2064	0.64	6	30
KDSA-2065	0.65	6	30
KDSA-2066	0.66	6	30
KDSA-2067	0.67	6	30
KDSA-2068	0.68	6	30
KDSA-2069	0.69	6	30
KDSA-2070	0.7	12	40
KDSA-2071	0.71	12	40
KDSA-2072	0.72	12	40
KDSA-2073	0.73	12	40
KDSA-2074	0.74	12	40
KDSA-2075	0.75	12	40
KDSA-2076	0.76	12	40
KDSA-2077	0.77	12	40
KDSA-2078	0.78	12	40
KDSA-2079	0.79	12	40
KDSA-2080	0.8	12	40
KDSA-2081	0.81	12	40
KDSA-2082	0.82	12	40
KDSA-2083	0.83	12	40
KDSA-2084	0.84	12	40
KDSA-2085	0.85	12	40
KDSA-2086	0.86	12	40
KDSA-2087	0.87	12	40
KDSA-2088	0.88	12	40
KDSA-2089	0.89	12	40

KDSA-2

品 番 Code No.	刃径 D Flute Diameter	溝長 ℓ Groove length	全長 L Total Length
KDSA-2090	0.9	12	40
KDSA-2091	0.91	12	40
KDSA-2092	0.92	12	40
KDSA-2093	0.93	12	40
KDSA-2094	0.94	12	40
KDSA-2095	0.95	12	40
KDSA-2096	0.96	12	40
KDSA-2097	0.97	12	40
KDSA-2098	0.98	12	40
KDSA-2099	0.99	12	40
KDSA-2100	1	15	40
KDSA-2101	1.01	15	40
KDSA-2102	1.02	15	40
KDSA-2103	1.03	15	40
KDSA-2104	1.04	15	40
KDSA-2105	1.05	15	40
KDSA-2106	1.06	15	40
KDSA-2107	1.07	15	40
KDSA-2108	1.08	15	40
KDSA-2109	1.09	15	40
KDSA-2110	1.1	15	40
KDSA-2111	1.11	15	40
KDSA-2112	1.12	15	40
KDSA-2113	1.13	15	40
KDSA-2114	1.14	15	40
KDSA-2115	1.15	15	40
KDSA-2116	1.16	15	40
KDSA-2117	1.17	15	40
KDSA-2118	1.18	15	40
KDSA-2119	1.19	15	40
KDSA-2120	1.2	15	40
KDSA-2121	1.21	15	40
KDSA-2122	1.22	15	40
KDSA-2123	1.23	15	40
KDSA-2124	1.24	15	40
KDSA-2125	1.25	15	40
KDSA-2126	1.26	15	40
KDSA-2127	1.27	15	40
KDSA-2128	1.28	15	40
KDSA-2129	1.29	15	40
KDSA-2130	1.3	16	40
KDSA-2131	1.31	16	40
KDSA-2132	1.32	16	40
KDSA-2133	1.33	16	40
KDSA-2134	1.34	16	40
KDSA-2135	1.35	16	40
KDSA-2136	1.36	16	40
KDSA-2137	1.37	16	40

品 番 Code No.	刃径 D Flute Diameter	溝長 ℓ Groove length	全長 L Total Length
KDSA-2138	1.38	16	40
KDSA-2139	1.39	16	40
KDSA-2140	1.4	16	40
KDSA-2141	1.41	16	40
KDSA-2142	1.42	16	40
KDSA-2143	1.43	16	40
KDSA-2144	1.44	16	40
KDSA-2145	1.45	16	40
KDSA-2146	1.46	16	40
KDSA-2147	1.47	16	40
KDSA-2148	1.48	16	40
KDSA-2149	1.49	16	40
KDSA-2150	1.5	16	40
KDSA-2151	1.51	16	40
KDSA-2152	1.52	16	40
KDSA-2153	1.53	16	40
KDSA-2154	1.54	16	40
KDSA-2155	1.55	16	40
KDSA-2156	1.56	16	40
KDSA-2157	1.57	16	40
KDSA-2158	1.58	16	40
KDSA-2159	1.59	16	40
KDSA-2160	1.6	18	40
KDSA-2161	1.61	18	40
KDSA-2162	1.62	18	40
KDSA-2163	1.63	18	40
KDSA-2164	1.64	18	40
KDSA-2165	1.65	18	40
KDSA-2166	1.66	18	40
KDSA-2167	1.67	18	40
KDSA-2168	1.68	18	40
KDSA-2169	1.69	18	40
KDSA-2170	1.7	18	40
KDSA-2171	1.71	18	40
KDSA-2172	1.72	18	40
KDSA-2173	1.73	18	40
KDSA-2174	1.74	18	40
KDSA-2175	1.75	18	40
KDSA-2176	1.76	18	40
KDSA-2177	1.77	18	40
KDSA-2178	1.78	18	40
KDSA-2179	1.79	18	40
KDSA-2180	1.8	18	40
KDSA-2181	1.81	18	40
KDSA-2182	1.82	18	40
KDSA-2183	1.83	18	40
KDSA-2184	1.84	18	40
KDSA-2185	1.85	18	40

KDSA-2

品 番 Code No.	刃径 D Flute Diameter	溝長 ℓ Groove length	全長 L Total Length
KDSA-2186	1.86	18	40
KDSA-2187	1.87	18	40
KDSA-2188	1.88	18	40
KDSA-2189	1.89	18	40
KDSA-2190	1.9	18	40
KDSA-2191	1.91	18	40
KDSA-2192	1.92	18	40
KDSA-2193	1.93	18	40
KDSA-2194	1.94	18	40
KDSA-2195	1.95	18	40
KDSA-2196	1.96	18	40
KDSA-2197	1.97	18	40
KDSA-2198	1.98	18	40
KDSA-2199	1.99	18	40
KDSA-2200	2	18	40
KDSA-2201	2.01	18	40
KDSA-2202	2.02	18	40
KDSA-2203	2.03	18	40
KDSA-2204	2.04	18	40
KDSA-2205	2.05	18	40
KDSA-2206	2.06	18	40
KDSA-2207	2.07	18	40
KDSA-2208	2.08	18	40
KDSA-2209	2.09	18	40
KDSA-2210	2.1	20	45
KDSA-2211	2.11	20	45
KDSA-2212	2.12	20	45
KDSA-2213	2.13	20	45
KDSA-2214	2.14	20	45
KDSA-2215	2.15	20	45
KDSA-2216	2.16	20	45
KDSA-2217	2.17	20	45
KDSA-2218	2.18	20	45
KDSA-2219	2.19	20	45
KDSA-2220	2.2	20	45
KDSA-2221	2.21	20	45
KDSA-2222	2.22	20	45
KDSA-2223	2.23	20	45
KDSA-2224	2.24	20	45
KDSA-2225	2.25	20	45
KDSA-2226	2.26	20	45
KDSA-2227	2.27	20	45
KDSA-2228	2.28	20	45
KDSA-2229	2.29	20	45
KDSA-2230	2.3	20	45
KDSA-2231	2.31	20	45
KDSA-2232	2.32	20	45
KDSA-2233	2.33	20	45

品 番 Code No.	刃径 D Flute Diameter	溝長 ℓ Groove length	全長 L Total Length
KDSA-2234	2.34	20	45
KDSA-2235	2.35	20	45
KDSA-2236	2.36	20	45
KDSA-2237	2.37	20	45
KDSA-2238	2.38	20	45
KDSA-2239	2.39	20	45
KDSA-2240	2.4	20	45
KDSA-2241	2.41	20	45
KDSA-2242	2.42	20	45
KDSA-2243	2.43	20	45
KDSA-2244	2.44	20	45
KDSA-2245	2.45	20	45
KDSA-2246	2.46	20	45
KDSA-2247	2.47	20	45
KDSA-2248	2.48	20	45
KDSA-2249	2.49	20	45
KDSA-2250	2.5	20	45
KDSA-2251	2.51	20	45
KDSA-2252	2.52	20	45
KDSA-2253	2.53	20	45
KDSA-2254	2.54	20	45
KDSA-2255	2.55	20	45
KDSA-2256	2.56	20	45
KDSA-2257	2.57	20	45
KDSA-2258	2.58	20	45
KDSA-2259	2.59	20	45
KDSA-2260	2.6	20	45
KDSA-2261	2.61	20	45
KDSA-2262	2.62	20	45
KDSA-2263	2.63	20	45
KDSA-2264	2.64	20	45
KDSA-2265	2.65	20	45
KDSA-2266	2.66	20	45
KDSA-2267	2.67	20	45
KDSA-2268	2.68	20	45
KDSA-2269	2.69	20	45
KDSA-2270	2.7	20	45
KDSA-2271	2.71	20	45
KDSA-2272	2.72	20	45
KDSA-2273	2.73	20	45
KDSA-2274	2.74	20	45
KDSA-2275	2.75	20	45
KDSA-2276	2.76	20	45
KDSA-2277	2.77	20	45
KDSA-2278	2.78	20	45
KDSA-2279	2.79	20	45
KDSA-2280	2.8	20	45
KDSA-2281	2.81	20	45

超硬ドリル

Carbide Drill

KDSA-2

[illegible][illegible]

KDSA-2、KDS-2、KDSL-2 KDS-F、KDSL-F、KDS-90、KDSL-90

切削条件参考

Referential Cutting Conditions

- TiA ℓ Nコーティング付のKDSA-2は下記条件の20%～30%アップを推奨いたします。
KDSA-2 with TiA ℓ N coating shall be recommended to increase 20%～30% on the following conditions
- KDS-F・KDSL-Fは下記条件の20%減の送り速度を奨励いたします。
KDS-F and KDSL-F are encouraged to reduce the feed rate by 20% of the following 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
0.3～0.49	10～20	0.005～0.01	5～15	0.003～0.008	3～6	0.001	10～30	0.01～0.04
0.5～0.99	15～30	0.01 ～0.02	8～25	0.005～0.013	7～15	0.001～0.003	15～40	0.02～0.06
1.0～1.99	20～40	0.02 ～0.04	10～30	0.01 ～0.02	10～25	0.003～0.015	20～50	0.04～0.1
2.0～3.0	25～45	0.04 ～0.08	15～30	0.02 ～0.035	13～30	0.01 ～0.025	25～60	0.08～0.2
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.			

KDL-2、KDLL-2 KDL-F、KDLL-F、KDL-90、KDLL-90

切削条件参考

Referential Cutting Conditions

- KDL-F・KDLL-Fは下記条件の20%減の送り速度を奨励いたします。
KDL-F and KDLL-F are encouraged to reduce the feed rate by 20% of the following 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
0.3～0.49	9～15	0.003	8～14	0.002	5～8	0.0005～0.001	10～30	0.01～0.04
0.5～0.99	15～30	0.008～0.017	12～25	0.005～0.013	9～15	0.001 ～0.003	15～40	0.02～0.06
1.0～1.99	20～45	0.02 ～0.04	15～35	0.01 ～0.018	10～25	0.005 ～0.015	20～50	0.04～0.1
2.0～3.0	25～55	0.05 ～0.07	17～28	0.02 ～0.035	13～30	0.02 ～0.03	25～60	0.08～0.2
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.			