

K3DF

3D Drill

General
Engineering

Mold & Die



Automotive



Defence

Rail
Systems

D-Tech High Performance New Product

Thanks to it's
brand-new geometry
and coating up to

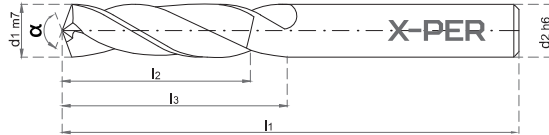
% **50** longer tool life at
least in comparison
with equivalents

Stronger cutting
edges by Exper
edge preparation
technology and up to

% **40** better hole surface
roughness in comparison
with equivalents

Optimal raw material
selection for drilling
operations to damp
vibration and up to

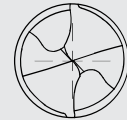
% **20** more precision hole
diameter in comparison
with equivalents

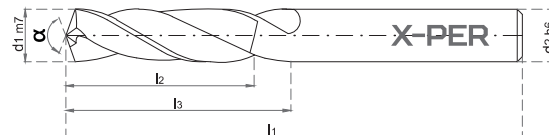


Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
*	45100	K3DF.2.0300.0620.A0138.0180.0300.0200.00.S06A1A05.01	3	6	62	18	20
*	45102	K3DF.2.0310.0620.A0138.0180.0310.0200.00.S06A1A05.01	3,1	6	62	18	20
*	45104	K3DF.2.0320.0620.A0138.0180.0320.0200.00.S06A1A05.01	3,2	6	62	18	20
*	45106	K3DF.2.0330.0620.A0138.0180.0330.0200.00.S06A1A05.01	3,3	6	62	18	20
*	45108	K3DF.2.0340.0620.A0138.0180.0340.0200.00.S06A1A05.01	3,4	6	62	18	20
*	45110	K3DF.2.0350.0620.A0138.0180.0350.0200.00.S06A1A05.01	3,5	6	62	18	20
*	45112	K3DF.2.0360.0620.A0138.0180.0360.0200.00.S06A1A05.01	3,6	6	62	18	20
*	45114	K3DF.2.0370.0620.A0138.0180.0370.0200.00.S06A1A05.01	3,7	6	62	18	20
*	45116	K3DF.2.0380.0660.A0138.0220.0380.0240.00.S06A1A05.01	3,8	6	66	22	24
*	45118	K3DF.2.0390.0660.A0138.0220.0390.0240.00.S06A1A05.01	3,9	6	66	22	24
*	45120	K3DF.2.0400.0660.A0138.0220.0400.0240.00.S06A1A05.01	4	6	66	22	24
*	45122	K3DF.2.0410.0660.A0138.0220.0410.0240.00.S06A1A05.01	4,1	6	66	22	24
*	45124	K3DF.2.0420.0660.A0138.0220.0420.0240.00.S06A1A05.01	4,2	6	66	22	24
*	45126	K3DF.2.0425.0660.A0138.0230.0425.0250.00.S06A1B02.01	4,25	6	66	23	25
*	45128	K3DF.2.0430.0660.A0138.0220.0430.0240.00.S06A1A05.01	4,3	6	66	22	24
*	45130	K3DF.2.0440.0660.A0138.0220.0440.0240.00.S06A1A05.01	4,4	6	66	22	24
*	45132	K3DF.2.0450.0660.A0138.0220.0450.0240.00.S06A1A05.01	4,5	6	66	22	24
*	45134	K3DF.2.0460.0660.A0138.0220.0460.0240.00.S06A1A05.01	4,6	6	66	22	24
*	45136	K3DF.2.0470.0660.A0138.0220.0470.0240.00.S06A1A05.01	4,7	6	66	22	24
*	45138	K3DF.2.0480.0660.A0138.0260.0480.0280.00.S06A1A05.01	4,8	6	66	26	28
*	45140	K3DF.2.0480.0660.A0138.0260.0480.0280.00.S06A1B02.01	4,8	6	66	26	28
*	45142	K3DF.2.0490.0660.A0138.0260.0490.0280.00.S06A1A05.01	4,9	6	66	26	28
*	45144	K3DF.2.0500.0660.A0138.0260.0500.0280.00.S06A1A05.01	5	6	66	26	28
*	45146	K3DF.2.0510.0660.A0138.0260.0510.0280.00.S06A1A05.01	5,1	6	66	26	28
*	45148	K3DF.2.0520.0660.A0138.0260.0520.0280.00.S06A1A05.01	5,2	6	66	26	28
*	45150	K3DF.2.0530.0660.A0138.0260.0530.0280.00.S06A1A05.01	5,3	6	66	26	28
*	45152	K3DF.2.0540.0660.A0138.0260.0540.0280.00.S06A1A05.01	5,4	6	66	26	28
*	45154	K3DF.2.0550.0660.A0138.0260.0550.0280.00.S06A1A05.01	5,5	6	66	26	28
*	45156	K3DF.2.0560.0660.A0138.0260.0560.0280.00.S06A1A05.01	5,6	6	66	26	28
*	45158	K3DF.2.0570.0660.A0138.0260.0570.0280.00.S06A1A05.01	5,7	6	66	26	28
*	45160	K3DF.2.0580.0660.A0138.0260.0580.0280.00.S06A1A05.01	5,8	6	66	26	28
*	45162	K3DF.2.0590.0660.A0138.0260.0590.0280.00.S06A1A05.01	5,9	6	66	26	28
*	45164	K3DF.2.0600.0660.A0138.0260.0600.0280.00.S06A1A05.01	6	6	66	26	28
*	45166	K3DF.2.0610.0790.A0138.0320.0610.0340.00.S08A1A05.01	6,1	8	79	32	34
*	45168	K3DF.2.0620.0790.A0138.0320.0620.0340.00.S08A1A05.01	6,2	8	79	32	34
*	45170	K3DF.2.0630.0790.A0138.0320.0630.0340.00.S08A1A05.01	6,3	8	79	32	34
*	45172	K3DF.2.0640.0790.A0138.0320.0640.0340.00.S08A1A05.01	6,4	8	79	32	34
*	45174	K3DF.2.0650.0790.A0138.0320.0650.0340.00.S08A1A05.01	6,5	8	79	32	34
*	45176	K3DF.2.0650.0790.A0140.0320.0650.0350.00.S08A1B02.01	6,5	8	79	32	35
*	45178	K3DF.2.0660.0790.A0138.0320.0660.0340.00.S08A1A05.01	6,6	8	79	32	34
*	45180	K3DF.2.0670.0790.A0138.0320.0670.0340.00.S08A1A05.01	6,7	8	79	32	34
*	45182	K3DF.2.0680.0790.A0138.0320.0680.0340.00.S08A1A05.01	6,8	8	79	32	34
*	45184	K3DF.2.0690.0790.A0138.0320.0690.0340.00.S08A1A05.01	6,9	8	79	32	34
*	45186	K3DF.2.0700.0790.A0138.0320.0700.0340.00.S08A1A05.01	7	8	79	32	34
*	45188	K3DF.2.0710.0790.A0138.0380.0710.0410.00.S08A1A05.01	7,1	8	79	38	41
*	45190	K3DF.2.0720.0790.A0138.0380.0720.0410.00.S08A1A05.01	7,2	8	79	38	41
*	45192	K3DF.2.0730.0790.A0138.0380.0730.0410.00.S08A1A05.01	7,3	8	79	38	41
*	45194	K3DF.2.0740.0790.A0138.0380.0740.0410.00.S08A1A05.01	7,4	8	79	38	41
*	45196	K3DF.2.0750.0790.A0138.0380.0750.0410.00.S08A1A05.01	7,5	8	79	38	41
	45198	K3DF.2.0760.0790.A0138.0380.0760.0410.00.S08A1A05.01	7,6	8	79	38	41

K3DF

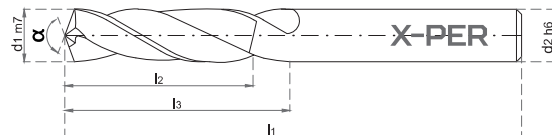
3D Drill





K3DF - 3D Drill

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
*	45200	K3DF.2.0770.0790.A0138.0380.0770.0410.00.S08A1A05.01	7,7	8	79	38	41
*	45202	K3DF.2.0780.0790.A0138.0380.0780.0410.00.S08A1A05.01	7,8	8	79	38	41
*	45204	K3DF.2.0790.0790.A0138.0380.0790.0410.00.S08A1A05.01	7,9	8	79	38	41
*	45206	K3DF.2.0800.0790.A0138.0380.0800.0410.00.S08A1A05.01	8	8	79	38	41
*	45208	K3DF.2.0810.0890.A0138.0430.0810.0470.00.S10A1A05.01	8,1	10	89	43	47
*	45210	K3DF.2.0820.0890.A0138.0430.0820.0470.00.S10A1A05.01	8,2	10	89	43	47
*	45212	K3DF.2.0830.0890.A0138.0430.0830.0470.00.S10A1A05.01	8,3	10	89	43	47
*	45214	K3DF.2.0840.0890.A0138.0430.0840.0470.00.S10A1A05.01	8,4	10	89	43	47
*	45216	K3DF.2.0850.0890.A0138.0430.0850.0470.00.S10A1A05.01	8,5	10	89	43	47
*	45218	K3DF.2.0860.0890.A0138.0430.0860.0470.00.S10A1A05.01	8,6	10	89	43	47
*	45220	K3DF.2.0870.0890.A0138.0430.0870.0470.00.S10A1A05.01	8,7	10	89	43	47
*	45222	K3DF.2.0880.0890.A0138.0430.0880.0470.00.S10A1A05.01	8,8	10	89	43	47
*	45224	K3DF.2.0890.0890.A0138.0430.0890.0470.00.S10A1A05.01	8,9	10	89	43	47
*	45226	K3DF.2.0900.0890.A0138.0430.0900.0470.00.S10A1A05.01	9	10	89	43	47
*	45228	K3DF.2.0910.0890.A0138.0430.0910.0470.00.S10A1A05.01	9,1	10	89	43	47
*	45230	K3DF.2.0920.0890.A0138.0430.0920.0470.00.S10A1A05.01	9,2	10	89	43	47
*	45232	K3DF.2.0925.0890.A0138.0430.0925.0470.00.S10A1A05.01	9,25	10	89	43	47
*	45234	K3DF.2.0930.0890.A0138.0430.0930.0470.00.S10A1A05.01	9,3	10	89	43	47
*	45236	K3DF.2.0940.0890.A0138.0430.0940.0470.00.S10A1A05.01	9,4	10	89	43	47
*	45238	K3DF.2.0950.0890.A0138.0430.0950.0470.00.S10A1A05.01	9,5	10	89	43	47
*	45240	K3DF.2.0960.0890.A0138.0430.0960.0470.00.S10A1A05.01	9,6	10	89	43	47
*	45242	K3DF.2.0970.0890.A0138.0430.0970.0470.00.S10A1A05.01	9,7	10	89	43	47
*	45244	K3DF.2.0980.0890.A0138.0430.0980.0470.00.S10A1A05.01	9,8	10	89	43	47
*	45246	K3DF.2.0990.0890.A0138.0430.0990.0470.00.S10A1A05.01	9,9	10	89	43	47
*	45248	K3DF.2.1000.0890.A0138.0430.1000.0470.00.S10A1A05.01	10	10	89	43	47
*	45250	K3DF.2.1010.1020.A0138.0510.1010.0550.00.S12A1A05.01	10,1	12	102	51	55
*	45252	K3DF.2.1020.1020.A0138.0510.1020.0550.00.S12A1A05.01	10,2	12	102	51	55
*	45254	K3DF.2.1030.1020.A0138.0510.1030.0550.00.S12A1A05.01	10,3	12	102	51	55
*	45256	K3DF.2.1040.1020.A0138.0510.1040.0550.00.S12A1A05.01	10,4	12	102	51	55
*	45258	K3DF.2.1050.1020.A0138.0510.1050.0550.00.S12A1A05.01	10,5	12	102	51	55
*	45260	K3DF.2.1060.1020.A0138.0510.1060.0550.00.S12A1A05.01	10,6	12	102	51	55
*	45262	K3DF.2.1070.1020.A0138.0510.1070.0550.00.S12A1A05.01	10,7	12	102	51	55
*	45264	K3DF.2.1080.1020.A0138.0510.1080.0550.00.S12A1A05.01	10,8	12	102	51	55
*	45266	K3DF.2.1090.1020.A0138.0510.1090.0550.00.S12A1A05.01	10,9	12	102	51	55
*	45268	K3DF.2.1100.1020.A0138.0510.1100.0550.00.S12A1A05.01	11	12	102	51	55
*	45270	K3DF.2.1110.1020.A0138.0510.1110.0550.00.S12A1A05.01	11,1	12	102	51	55
*	45272	K3DF.2.1120.1020.A0138.0510.1120.0550.00.S12A1A05.01	11,2	12	102	51	55
*	45274	K3DF.2.1130.1020.A0138.0510.1130.0550.00.S12A1A05.01	11,3	12	102	51	55
*	45276	K3DF.2.1140.1020.A0138.0510.1140.0550.00.S12A1A05.01	11,4	12	102	51	55
*	45278	K3DF.2.1150.1020.A0138.0510.1150.0550.00.S12A1A05.01	11,5	12	102	51	55
*	45280	K3DF.2.1160.1020.A0138.0510.1160.0550.00.S12A1A05.01	11,6	12	102	51	55
*	45282	K3DF.2.1170.1020.A0138.0510.1170.0550.00.S12A1A05.01	11,7	12	102	51	55
*	45284	K3DF.2.1180.1020.A0138.0510.1180.0550.00.S12A1A05.01	11,8	12	102	51	55
*	45286	K3DF.2.1190.1020.A0138.0510.1190.0550.00.S12A1A05.01	11,9	12	102	51	55
*	45288	K3DF.2.1200.1020.A0138.0510.1200.0550.00.S12A1A05.01	12	12	102	51	55
*	45290	K3DF.2.1235.1100.A0140.0600.1235.0630.00.S14A1B03.01	12,35	14	110	60	63
*	45292	K3DF.2.1250.1070.A0138.0530.1250.0600.00.S14A1A05.01	12,5	14	107	53	60
*	45294	K3DF.2.1270.1070.A0138.0530.1270.0600.00.S14A1A05.01	12,7	14	107	53	60
*	45296	K3DF.2.1280.1070.A0138.0530.1280.0600.00.S14A1A05.01	12,8	14	107	53	60
*	45298	K3DF.2.1290.1070.A0138.0530.1280.0600.00.S14A1A05.01	12,9	14	107	53	60
*	45300	K3DF.2.1300.1070.A0138.0530.1300.0600.00.S14A1A05.01	13	14	107	53	60



K3DF - 3D Drill

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
	45302	K3DF.2.1310.1070.A0138.0530.1310.0600.00.S14A1A05.01	13,1	14	107	53	60
	45304	K3DF.2.1330.1070.A0138.0530.1320.0600.00.S14A1A05.01	13,3	14	107	53	60
*	45306	K3DF.2.1350.1070.A0138.0530.1350.0600.00.S14A1A05.01	13,5	14	107	53	60
	45308	K3DF.2.1370.1070.A0138.0530.1370.0600.00.S14A1A05.01	13,7	14	107	53	60
	45310	K3DF.2.1380.1070.A0138.0530.1380.0600.00.S14A1A05.01	13,8	14	107	53	60
	45312	K3DF.2.1395.1100.A0140.0580.1395.0630.00.S14A1B03.01	13,95	14	110	58	63
*	45314	K3DF.2.1400.1070.A0138.0530.1400.0600.00.S14A1A05.01	14	14	107	53	60
	45316	K3DF.2.1407.1100.A0140.0580.1407.0630.00.S16B1B03.01	14,07	16	110	58	63
	45318	K3DF.2.1420.1150.A0138.0580.1420.0650.00.S16A1A05.01	14,2	16	115	58	65
*	45320	K3DF.2.1450.1150.A0138.0580.1450.0650.00.S16A1A05.01	14,5	16	115	58	65
	45322	K3DF.2.1470.1150.A0138.0580.1470.0650.00.S16A1A05.01	14,7	16	115	58	65
	45324	K3DF.2.1480.1150.A0138.0580.1480.0650.00.S16A1A05.01	14,8	16	115	58	65
	45326	K3DF.2.1500.1150.A0138.0580.1500.0650.00.S16A1A05.01	15	16	115	58	65
	45328	K3DF.2.1525.1150.A0138.0580.1525.0650.00.S16A1A05.01	15,25	16	115	58	65
	45330	K3DF.2.1530.1150.A0138.0580.1530.0650.00.S16A1A05.01	15,3	16	115	58	65
	45332	K3DF.2.1550.1150.A0138.0580.1550.0650.00.S16A1A05.01	15,5	16	115	58	65
	45334	K3DF.2.1570.1150.A0138.0580.1570.0650.00.S16A1A05.01	15,7	16	115	58	65
	45336	K3DF.2.1580.1150.A0138.0580.1580.0650.00.S16A1A05.01	15,8	16	115	58	65
	45338	K3DF.2.1600.1150.A0138.0580.1600.0650.00.S16A1A05.01	16	16	115	58	65
*	45340	K3DF.2.1650.1230.A0138.0660.1650.0730.00.S18A1A05.01	16,5	18	123	66	73
	45342	K3DF.2.1680.1230.A0138.0660.1680.0730.00.S18A1A05.01	16,8	18	123	66	73
	45344	K3DF.2.1700.1230.A0138.0660.1700.0730.00.S18A1A05.01	17	18	123	66	73
	45346	K3DF.2.1750.1230.A0138.0660.1750.0730.00.S18A1A05.01	17,5	18	123	66	73
	45348	K3DF.2.1780.1230.A0138.0660.1780.0730.00.S18A1A05.01	17,8	18	123	66	73
	45350	K3DF.2.1800.1230.A0138.0660.1800.0730.00.S18A1A05.01	18	18	123	66	73
	45352	K3DF.2.1850.1310.A0138.0720.1850.0790.00.S20A1A05.01	18,5	20	131	72	79
	45354	K3DF.2.1880.1310.A0138.0720.1880.0790.00.S20A1A05.01	18,8	20	131	72	79
	45356	K3DF.2.1900.1310.A0138.0720.1900.0790.00.S20A1A05.01	19	20	131	72	79
	45358	K3DF.2.1950.1310.A0138.0720.1950.0790.00.S20A1A05.01	19,5	20	131	72	79
	45360	K3DF.2.1980.1310.A0138.0720.1980.0790.00.S20A1A05.01	19,8	20	131	72	79
	45362	K3DF.2.2000.1310.A0138.0720.2000.0790.00.S20A1A05.01	20	20	131	72	79

Cutting Parameters Vc(m/min)

Non-Alloy Steel	110-125	●
Steel	100-120	●
Tempered Steel	100-120	●
Cold-Work Tool Steel	70-90	○
Hot-Work Tool Steel	70-90	○
AISI 304 - 416 - 420	55-65	○
AISI 316 - 440	55-65	○
17-4 PH 15-5 PH	50-55	○
Chrome-Cobalt Alloy	50-55	○
Duplex F51	40-50	○
Super Duplex F55	40-50	○
Grey Cast Iron	170-200	●
Alloy Cast Iron	130-150	●
Precision Cast	110-130	●
Titanium	55-65	○
Titanium Alloys	55-65	○
≤ 54 HRC	60-80	○
> 54 HRC	40-55	○

Feed Per Revolution (mm/rev)

Ø	
3	0,03
4	0,045
5	0,85
6	0,17
7	0,19
8	0,21
9	0,23
10	0,25
12	0,27
14	0,29
16	0,31
18	0,33
20	0,35