

HOLE-MAKING

K4DF

4D 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

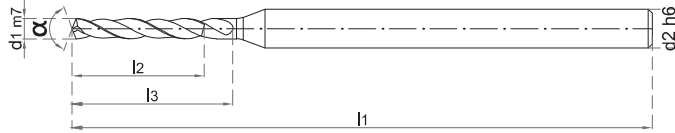
% **40**

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

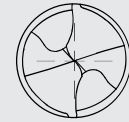


K4DF

4D Drill

D-TECH K4DF

Stock	Order No	Code	d1m7	d2h6	l1	l2	l3
*	46100	K4DF.2.0100.0500.A0138.0060.0100.0075.00.S03A1A06.01	1	3	50	6	7,5
*	46102	K4DF.2.0110.0500.A0138.0070.0110.0085.00.S03A1A06.01	1,1	3	50	7	8,5
*	46104	K4DF.2.0120.0500.A0138.0070.0120.0085.00.S03A1A06.01	1,2	3	50	7	8,5
*	46106	K4DF.2.0130.0500.A0138.0080.0130.0095.00.S03A1A06.01	1,3	3	50	8	9,5
*	46108	K4DF.2.0140.0500.A0138.0090.0140.0105.00.S03A1A06.01	1,4	3	50	9	10,5
*	46110	K4DF.2.0150.0500.A0138.0090.0150.0105.00.S03A1A06.01	1,5	3	50	9	10,5
*	46112	K4DF.2.0160.0500.A0138.0100.0160.0115.00.S03A1A06.01	1,6	3	50	10	11,5
*	46114	K4DF.2.0170.0500.A0138.0100.0170.0115.00.S03A1A06.01	1,7	3	50	10	11,5
*	46116	K4DF.2.0180.0500.A0138.0100.0180.0115.00.S03A1A06.01	1,8	3	50	10	11,5
*	46118	K4DF.2.0190.0500.A0138.0120.0190.0135.00.S03A1A06.01	1,9	3	50	12	13,5
*	46120	K4DF.2.0200.0600.A0138.0120.0200.0150.00.S04A1A06.01	2	4	60	12	15
*	46122	K4DF.2.0210.0600.A0142.0120.0210.0160.00.S03B1B04.01	2,1	3	60	12	16
*	46124	K4DF.2.0210.0600.A0138.0140.0210.0160.00.S04A1A06.01	2,1	4	60	14	16
*	46126	K4DF.2.0220.0600.A0138.0140.0220.0160.00.S04A1A06.01	2,2	4	60	14	16
*	46128	K4DF.2.0230.0600.A0138.0140.0230.0160.00.S04A1A06.01	2,3	4	60	14	16
*	46130	K4DF.2.0240.0600.A0138.0140.0240.0160.00.S04A1A06.01	2,4	4	60	14	16
*	46132	K4DF.2.0250.0600.A0138.0160.0250.0180.00.S04A1A06.01	2,5	4	60	16	18
*	46134	K4DF.2.0260.0600.A0138.0160.0260.0180.00.S04A1A06.01	2,6	4	60	16	18
*	46136	K4DF.2.0270.0600.A0138.0160.0270.0180.00.S04A1A06.01	2,7	4	60	16	18
*	46138	K4DF.2.0280.0600.A0138.0170.0280.0190.00.S04A1A06.01	2,8	4	60	17	19
*	46140	K4DF.2.0290.0600.A0138.0180.0290.0200.00.S04A1A06.01	2,9	4	60	18	20



Cutting Parameters Vc(m/min)

Non-Alloy Steel	80-110	●
Steel	70-100	●
Tempered Steel	70-100	●
Cold-Work Tool Steel	60-80	●
Hot-Work Tool Steel	60-80	○
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	150-180	●
Alloy Cast Iron	100-130	●
Precision Cast	80-115	●
Titanium	55-65	○
Titanium Alloys	55-65	○
HRSA	20-30	○
≤ 54 HRc	60-80	○
> 54 HRc	40-55	○

Feed Per Revolution (mm/rev)

Ø	
1	0,025
1,5	0,05
2	0,07
2,5	0,095
2,9	0,12



● Recommended ○ Acceptable ○ Not Recommended

*Marked products are available from stock to deliver fast.