



Stock	Order No	Code	d1H7	d2h6	d3	l1	l2	l3	Z
*	52100	KDRF.6.0400.0750.C0050.0180.0350.0470.00.S06B1B04.01	4	6	3,5	75	18	47	6
*	52102	KDRF.6.0450.0750.C0050.0180.0350.0470.00.S06B1B04.01	4,5	6	3,5	75	18	47	6
*	52104	KDRF.6.0500.0820.C0050.0230.0400.0500.00.S06A1B04.01	5	6	4	82	23	50	6
*	52106	KDRF.6.0550.0930.C0050.0230.0450.0570.00.S06B1B04.01	5,5	6	4,5	93	23	57	6
*	52108	KDRF.6.0600.0930.C0050.0260.0500.0570.00.S06B4B04.01	6	6	5	93	26	57	6
*	52110	KDRF.6.0650.1000.C0050.0260.0550.0650.00.S08B1B04.01	6,5	8	5,5	100	26	65	6
	52112	KDRF.6.0700.1100.C0050.0310.0600.0730.00.S08A1B04.01	7	8	6	110	31	73	6
	52114	KDRF.6.0750.1100.C0050.0310.0650.0770.00.S08A1B04.01	7,5	8	6,5	110	31	77	6
*	52116	KDRF.6.0800.1170.C0050.0330.0700.0810.00.S08A5B04.01	8	8	7	117	33	81	6
*	52118	KDRF.6.0850.1140.C0050.0330.0750.0810.00.S10B1B04.01	8,5	10	7,5	114	33	81	6
	52120	KDRF.6.0900.1250.C0050.0360.0800.0850.00.S10B1B04.01	9	10	8	125	36	85	6
	52122	KDRF.6.0950.1250.C0050.0360.0850.0850.00.S10B1B04.01	9,5	10	8,5	125	36	85	6
*	52124	KDRF.6.1000.1330.C0050.0380.0900.0930.00.S10A5B04.01	10	10	9	133	38	93	6
*	52126	KDRF.6.1050.1400.C0050.0380.0950.0930.00.S12B1B04.01	10,5	12	9,5	140	38	93	6
	52128	KDRF.6.1100.1400.C0050.0410.1000.0970.00.S12B1B04.01	11	12	10	140	41	97	6
*	52130	KDRF.6.1200.1510.C0050.0440.1100.1060.00.S12A5B04.01	12	12	11	151	44	106	6
	52132	KDRF.6.1300.1500.C0050.0440.1200.1060.00.S14B1B04.01	13	14	12	150	44	106	6
	52134	KDRF.6.1400.1600.C0050.0470.1300.1120.00.S14A5B04.01	14	14	13	160	47	112	6
	52136	KDRF.8.1500.1600.C0050.0550.1400.1140.00.S16B1B04.01	15	16	14	160	55	114	8
	52138	KDRF.8.1600.1600.C0050.0550.1500.1140.00.S16A5B04.01	16	16	15	160	55	114	8
	52140	KDRF.8.1800.1820.C0050.0560.1700.1320.00.S18A5B04.01	18	18	17	182	56	132	8
	52142	KDRF.8.2000.1950.C0050.0600.1900.1450.00.S20A5B04.01	20	20	19	195	60	145	8

HOLE-MAKING

KDRF

Reamer



D-TECH KDRF

Cutting Parameters Vc(m/min)			Feed Per Revolution (mm/rev)		
Non-Alloy Steel	20-30	●	Ø		
Steel	15-25	●	4-5,5	0.080	0.095
Tempered Steel	15-20	●	6-7,5	0.100	0.120
Cold-Work Tool Steel	10--15	●	8-9,5	0.125	0.140
Hot-Work Tool Steel	10--15	●	10--12	0.150	0.170
AISI 304 - 416 - 420	15-20	○	13-16	0.180	0.210
AISI 316 - 440	15-20	○	17-20	0.220	0.250
17-4 PH 15-5 PH	15-18	○			
Chrome-Cobalt Alloy	13-17	○			
Duplex F51	12--15	○			
Super Duplex F55	12--15	○			
Grey Cast Iron	20-25	●			
Alloy Cast Iron	20-25	●			
Precision Cast	15-20	●			
Aluminum Alloys	30-50	○			
Copper Alloys	30-50	○			
Magnesium Alloys	30-50	○			
Titanium	10-15	●			
Titanium Alloys	10-15	●			
HRSA	10-15	○			
≤ 54 HRC	15-30	○			
>54 HRC	10-15	○			



● Recommended ○ Acceptable ○ Not Recommended

*Marked products are available from stock to deliver fast.