New products for machining technicians

NEW KUB Pentron

- Ø 14–46 mm
- Cyl. shank, ABS, PSC
- 2xD, 3xD, 4xD, 5xD

6–18

NEW KUB 100

- Ø 14–27 mm
- Cyl. shank
- 3xD

27

NEW KUB Trigon

- Ø 14–44 mm
- Combi shank, ABS
- 2xD, 3xD, 4xD

29–34

NEW Indexable inserts for KUB Pentron

BK8425

- Universal PVD grade

BK6115

- Wear resistant
  CVD-coated indexable insert

19

NEW Indexable inserts for KUB Trigon

BK8425

- Universal PVD grade

BK6115

- Wear resistant
  CVD-coated indexable insert

35

Programme Extension

MaxiDrill 900

- Expansion to include intermediate Ø for 4xD and 5xD

20–26

Solid drilling and bore machining

1 HSS drilling
2 Solid carbide drilling
3 Indexable insert drilling
4 Reaming and Countersinking
5 Spindle Tooling

Threading

6 Taps and thread formers
7 Circular and Thread Milling
8 Thread turning

Turning

9 Turning Tools
10 EcoCut
11 Grooving Tools
12 Miniature turning tools

Milling

13 HSS Milling Cutters
14 Solid Carbide milling cutters
15 Milling tools with indexable inserts

Tool Clamping

16 Adapters
17 Accessories

18 Material examples and article no. index

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KOMET \ Performance

Premium quality tools for high performance.

The premium quality tools from the **KOMET Performance** product line have been designed for specific applications and are distinguished by their outstanding performance. If you make high demands on the performance of your production and want to achieve the very best results, we recommend the Premium tools in this product line.

KOMET \ Standard

Quality tools for standard applications.

The quality tools of the **KOMET Standard** product line are high quality, high performance, reliable and enjoy the highest level of trust among our customers worldwide. Tools from this product line are the first choice for many standard applications and guarantee optimal results.

Symbol explanation

Shank

C Cylindrical shank with clamping flat
Guarantees optimum clamping of the tool and can be clamped in every standard adapter

K Drill with combi shank
This drill shank has two clamping flats (DIN 6535HE, DIN 6595) that guarantee pull-out protection and good face contact of the drill. Both Weldon and Whistle Notch adapters can be used.

ABS Drill with ABS connection
The ABS connection from Komet is a modular coupling system for rotating tools and stationary tools, and offers a number of advantages, such as improved force transmission

PSC Drill with polygonal shank
The polygonal shank offers the best rigidity during the transmission of force from the drill to the adapter. The tapered polygonal shape easily absorbs torsional forces and bending forces

Version

Drill with thro' coolant supply
The tried-and-tested thro' coolant system guarantees a reduction in heat at the cutting edges of the tool as well as improved chip removal

Designation		Pages
Adjuster with ABS connection		38

Adapters can be found in → **Chapter 16 Adapters.**

Application tips – eccentric sleeves

Users of rotating tools can now enjoy greater flexibility.
Using the eccentric sleeves, you can vary and adjust the diameter of the hole by +/- 0.3 mm with ease.

Two types of eccentric sleeve are available:
One for use with the new indexable insert drill adapter and one for use with the existing Weldon adapter.
The difference lies solely in the design and position of the slots for the adapter's clamping screws.
There are four sizes per type, which are tailored to the shank diameter.

Eccentric sleeve for indexable insert drill adapter

Eccentric sleeve for Weldon adapter

Designation		Pages
Eccentric sleeves for indexable insert drill adapters		37
Eccentric sleeves for Weldon adapters		37

Toolfinder

● = **Main Application**
○ = Extended application
- = Not possible

KUB Pentron

The specialist for large hole depths

- ▲ The all-rounder for process-secure drilling under a wide variety of conditions
- ▲ Ideal for extreme machining situations

Boring depth	Drilling through a transverse hole	Stack plate drilling	Drilling on uneven surfaces	Drilling	Spot drilling an edge	Spot drilling a convex surface	Spot drilling angled surfaces	Spot drilling a pointed contour	Chain drilling	Drilling through a centre or pre-op
2xD	●	●	●	○	●	●	●	●	●	●
3xD	●	●	●	○	●	●	●	●	●	●
4xD	●	○	○	-	●	●	●	●	○	●
5xD	●	○	○	-	●	○	●	○	-	○
3xD	●	●	●	○	●	●	●	●	●	●
4xD	●	○	○	-	●	●	●	●	○	●
5xD	●	○	○	-	●	○	●	○	-	○
3xD	●	●	●	○	●	●	●	●	●	●

MaxiDrill 900

The specialist for high productivity in rough machining

- ▲ Provides perfect drilling quality even under enormous loads
- ▲ Ideal for large drilling depths: The high feed rates increase productivity
- ▲ For stable machining situations

2xD	●	●	●	○	●	●	●	●	○	●
3xD	●	●	●	○	●	●	●	●	○	●
4xD	●	○	○	○	●	●	●	●	○	●
5xD	●	○	○	○	●	●	●	●	○	●

KUB 100

Ideal for robust machining situations

- ▲ The high performance all-rounder for outstanding productivity and reliability
- ▲ Offers consistent hole quality and a constant diameter across all materials and feed rates

3xD	●	●	●	○	●	●	●	●	●	●

KUB Trigon

The solution for unstable conditions and high accuracy

- ▲ Ideal for machining under unstable conditions
- ▲ Well-suited to machining on less powerful machines
- ▲ The first choice for creating dimensionally accurate holes

2xD	●	-	●	○	○	●	●	○	●	○
3xD	○	-	○	○	○	○	○	○	○	○
4xD	○	-	○	-	-	○	○	-	○	○
2xD	●	-	●	○	○	●	●	○	●	○
3xD	○	-	○	○	○	○	○	○	○	○
4xD	○	-	○	-	-	○	○	-	○	○

MaxiDrill Classic

The drilling tool for universal application

- ▲ Ideal for use on machines with limited power
- ▲ Suitable for use under unstable conditions

2xD	●	-	●	-	-	○	○	-	-	●
3xD	●	-	●	-	-	○	○	-	-	●
4xD	●	-	●	-	-	○	○	-	-	●

Shank	Diameter Ø	KOMET \ Performance	KOMET \ Standard	Insert type		No. of cutting edges	Grade	Steel	Stainless steel	Cast iron	Non ferrous metals	Heat resistant alloys	Hardened materials	KOMET \ Performance
		Pages												Pages
C	14–46	6+7			SOGX	4	-01 BK6115	●		●			○	19
C	14–46	8+9			SOGX	4	-01 BK8425	●	●	●				19
C	14–46	10+11			SOGX	4	-01 BK7935	●	●	○	○	○		🛒
C	14–46	12+13			SOGX	4	-01 BK7710				●	○		🛒
ABS	14–30	14												
ABS	14–30	15												
ABS	14–30	16												
PSC	14–30	17+18												
C	12–63	20+21			SONT	2 / 4	-M30 CTCP420 -M30 DCX1420	●	○	●				28
C	12–63	22+23												
C	12–54	24+25			SONT	2 / 4	-M30 CTPP430 -M30 CCN1430	●	●	○	○	○		28
C	12–41	26												
					SONT	2 / 4	-M30 CTCP420 -M30 DCX1420	●	○	●				28
C	14–27	27												
					SONT	2 / 4	-M30 CTPP430 -M30 CCN1430	●	●	○	○	○		28
K	14–44	29			WOEX	3	-01 BK8425	●	●	●				35
K	14–44	30			WOEX	3	-03 BK8425	●	●	●				35
K	14–35	31			WOEX	3	-13 BK8425	●	●	●				35
ABS	14–44	32			WOEX	3	-01 BK6115	●		●			○	35
ABS	14–44	33			WOEX	3	-01 BK7935	●	●	○	○	○		🛒
ABS	14–44	34			WOEX	3	-01 BK62			●			○	🛒
					WOEX	3	-11 BK77				●	●		🛒
C	14–53		🛒											
C	14–50		🛒											
C	18–50		🛒											

🛒 MaxiDrill Classic and specialised indexable inserts can be found in our online shop at cuttingtools.ceratizit.com

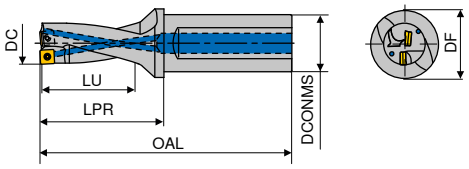
KUB Pentron

Scope of supply:

Indexable Insert Drill incl. clamping screws

≤ 2xD

C



Designation	KOMET no.	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 872 ...
KUB-P.2D.140.R.04-C20	U4201400	14,0	20	30	91	28	41	0,38	SOGX 040204	14001
KUB-P.2D.145.R.04-C20	U4201450	14,5	20	30	94	30	44	0,38	SOGX 040204	14501
KUB-P.2D.150.R.04-C20	U4201500	15,0	20	30	94	30	44	0,38	SOGX 040204	15001
KUB-P.2D.155.R.04-C20	U4201550	15,5	20	30	98	32	48	0,38	SOGX 040204	15501
KUB-P.2D.160.R.04-C20	U4201600	16,0	20	30	98	32	48	0,38	SOGX 040204	16001
KUB-P.2D.165.R.05-C20	U4201650	16,5	20	30	101	34	51	0,62	SOGX 050204	16501
KUB-P.2D.170.R.05-C20	U4201700	17,0	20	30	101	34	51	0,62	SOGX 050204	17001
KUB-P.2D.175.R.05-C25	U4211750	17,5	25	30	109	36	53	0,62	SOGX 050204	17502
KUB-P.2D.180.R.05-C25	U4211800	18,0	25	30	109	36	53	0,62	SOGX 050204	18002
KUB-P.2D.185.R.06-C25	U4211850	18,5	25	30	112	38	56	1,01	SOGX 060206	18502
KUB-P.2D.190.R.06-C25	U4211900	19,0	25	30	112	38	56	1,01	SOGX 060206	19002
KUB-P.2D.195.R.06-C25	U4211950	19,5	25	30	114	40	58	1,01	SOGX 060206	19502
KUB-P.2D.200.R.06-C25	U4212000	20,0	25	30	114	40	58	1,01	SOGX 060206	20002
KUB-P.2D.205.R.07-C25	U4212050	20,5	25	30	117	42	61	1,01	SOGX 07T208	20502
KUB-P.2D.210.R.07-C25	U4212100	21,0	25	30	117	42	61	1,01	SOGX 07T208	21002
KUB-P.2D.215.R.07-C25	U4212150	21,5	25	30	119	44	63	1,01	SOGX 07T208	21502
KUB-P.2D.220.R.07-C25	U4212200	22,0	25	30	119	44	63	1,01	SOGX 07T208	22002
KUB-P.2D.225.R.07-C25	U4212250	22,5	25	30	122	46	66	1,01	SOGX 07T208	22502
KUB-P.2D.230.R.07-C25	U4212300	23,0	25	30	122	46	66	1,01	SOGX 07T208	23002
KUB-P.2D.235.R.08-C32	U4222350	23,5	32	39	128	48	68	1,28	SOGX 080308	23503
KUB-P.2D.240.R.08-C32	U4222400	24,0	32	39	128	48	68	1,28	SOGX 080308	24003
KUB-P.2D.245.R.08-C32	U4222450	24,5	32	39	131	50	71	1,28	SOGX 080308	24503
KUB-P.2D.250.R.08-C32	U4222500	25,0	32	39	131	50	71	1,28	SOGX 080308	25003
KUB-P.2D.255.R.08-C32	U4222550	25,5	32	39	133	52	73	1,28	SOGX 080308	25503
KUB-P.2D.260.R.08-C32	U4222600	26,0	32	39	133	52	73	1,28	SOGX 080308	26003
KUB-P.2D.265.R.09-C32	U4222650	26,5	32	39	136	54	76	2,25	SOGX 09T308	26503
KUB-P.2D.270.R.09-C32	U4222700	27,0	32	39	136	54	76	2,25	SOGX 09T308	27003
KUB-P.2D.275.R.09-C32	U4222750	27,5	32	39	138	56	78	2,25	SOGX 09T308	27503
KUB-P.2D.280.R.09-C32	U4222800	28,0	32	39	138	56	78	2,25	SOGX 09T308	28003
KUB-P.2D.285.R.09-C32	U4222850	28,5	32	39	141	58	81	2,25	SOGX 09T308	28503
KUB-P.2D.290.R.09-C32	U4222900	29,0	32	39	141	58	81	2,25	SOGX 09T308	29003
KUB-P.2D.295.R.09-C32	U4222950	29,5	32	39	143	60	83	2,25	SOGX 09T308	29503
KUB-P.2D.300.R.09-C32	U4223000	30,0	32	39	143	60	83	2,25	SOGX 09T308	30003
KUB-P.2D.310.R.10-C40	U4233100	31,0	40	50	154	62	86	2,8	SOGX 100408	31004
KUB-P.2D.320.R.10-C40	U4233200	32,0	40	50	156	64	88	2,8	SOGX 100408	32004
KUB-P.2D.330.R.10-C40	U4233300	33,0	40	50	159	66	91	2,8	SOGX 100408	33004
KUB-P.2D.340.R.11-C40	U4233400	34,0	40	50	161	68	93	2,8	SOGX 110408	34004
KUB-P.2D.350.R.11-C40	U4233500	35,0	40	50	164	70	96	2,8	SOGX 110408	35004
KUB-P.2D.360.R.11-C40	U4233600	36,0	40	50	166	72	98	2,8	SOGX 110408	36004
KUB-P.2D.370.R.11-C40	U4233700	37,0	40	50	169	74	101	2,8	SOGX 110408	37004
KUB-P.2D.380.R.12-C40	U4233800	38,0	40	50	171	76	103	6,25	SOGX 120408	38004
KUB-P.2D.390.R.12-C40	U4233900	39,0	40	50	174	78	106	6,25	SOGX 120408	39004
KUB-P.2D.400.R.12-C40	U4234000	40,0	40	50	176	80	108	6,25	SOGX 120408	40004
KUB-P.2D.410.R.12-C40	U4234100	41,0	40	50	179	82	111	6,25	SOGX 120408	41004
KUB-P.2D.420.R.12-C40	U4234200	42,0	40	50	181	84	113	6,25	SOGX 120408	42004

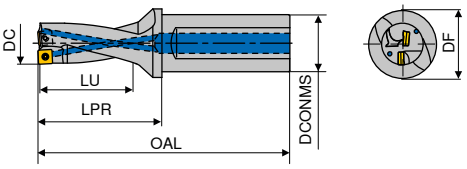
Continued on next page

KUB Pentron

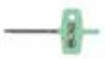
Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 2xD

C



Designation	KOMET no.	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 872 ...
KUB-P.2D.430.R.13-C40	U4234300	43,0	40	50	184	86	116	6,25	SOGX 130508	**43004**
KUB-P.2D.440.R.13-C40	U4234400	44,0	40	50	186	88	118	6,25	SOGX 130508	**44004**
KUB-P.2D.450.R.13-C40	U4234500	45,0	40	50	189	90	121	6,25	SOGX 130508	**45004**
KUB-P.2D.460.R.13-C40	U4234600	46,0	40	50	191	92	123	6,25	SOGX 130508	**46004**


Screwdriver

Key D

Clamping screw

Spare parts DC	Article no. 80 950 ...		Article no. 80 950 ...		Article no. 10 950 ...	
14 - 16	T05 - IP	**057**			M1,8x3,8 - 05IP	**10100**
16,5 - 18			T06 - IP	**123**	M2,0x4,3 - 06IP	**10000**
18,5 - 23			T06 - IP	**123**	M2,2x5,5 - 06IP	**10700**
23,5 - 26			T08 - IP	**125**	M2,5x6,3 - 08IP	**10800**
26,5 - 30			T08 - IP	**125**	M3,0x7,6 - 08IP	**10200**
31 - 37			T15 - IP	**128**	M3,5x7,5 - 15IP	**10300**
38 - 46			T20 - IP	**129**	M4,5x10,0 - 20IP	**10400**

Suitable adapters can be found in → **Chapter 16 Adapters.**

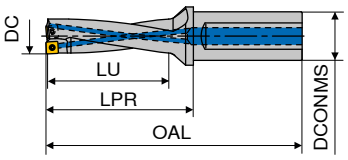
KUB Pentron

Scope of supply:

Indexable Insert Drill incl. clamping screws

≤ 3xD

C



Designation	KOMET no.	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 873 ...
KUB-P.3D.140.R.04-C20	U4301400	14,0	20	30	105	42	55	0,38	SOGX 040204	14001
KUB-P.3D.145.R.04-C20	U4301450	14,5	20	30	109	45	59	0,38	SOGX 040204	14501
KUB-P.3D.150.R.04-C20	U4301500	15,0	20	30	109	45	59	0,38	SOGX 040204	15001
KUB-P.3D.155.R.04-C20	U4301550	15,5	20	30	114	48	64	0,38	SOGX 040204	15501
KUB-P.3D.160.R.04-C20	U4301600	16,0	20	30	114	48	64	0,38	SOGX 040204	16001
KUB-P.3D.165.R.05-C20	U4301650	16,5	20	30	118	51	68	0,62	SOGX 050204	16501
KUB-P.3D.170.R.05-C20	U4301700	17,0	20	30	118	51	68	0,62	SOGX 050204	17001
KUB-P.3D.175.R.05-C25	U4311750	17,5	25	30	127	54	71	0,62	SOGX 050204	17501
KUB-P.3D.180.R.05-C25	U4311800	18,0	25	30	127	54	71	0,62	SOGX 050204	18001
KUB-P.3D.185.R.06-C25	U4311850	18,5	25	30	131	57	75	1,01	SOGX 060206	18501
KUB-P.3D.190.R.06-C25	U4311900	19,0	25	30	131	57	75	1,01	SOGX 060206	19001
KUB-P.3D.195.R.06-C25	U4311950	19,5	25	30	134	60	78	1,01	SOGX 060206	19501
KUB-P.3D.200.R.06-C25	U4312000	20,0	25	30	134	60	78	1,01	SOGX 060206	20001
KUB-P.3D.205.R.07-C25	U4312050	20,5	25	30	138	63	82	1,01	SOGX 07T208	20501
KUB-P.3D.210.R.07-C25	U4312100	21,0	25	30	138	63	82	1,01	SOGX 07T208	21001
KUB-P.3D.215.R.07-C25	U4312150	21,5	25	30	141	66	85	1,01	SOGX 07T208	21501
KUB-P.3D.220.R.07-C25	U4312200	22,0	25	30	141	66	85	1,01	SOGX 07T208	22002
KUB-P.3D.225.R.07-C25	U4312250	22,5	25	30	145	69	89	1,01	SOGX 07T208	22502
KUB-P.3D.230.R.07-C25	U4312300	23,0	25	30	145	69	89	1,01	SOGX 07T208	23002
KUB-P.3D.235.R.08-C32	U4322350	23,5	32	39	152	72	92	1,28	SOGX 080308	23503
KUB-P.3D.240.R.08-C32	U4322400	24,0	32	39	152	72	92	1,28	SOGX 080308	24003
KUB-P.3D.245.R.08-C32	U4322450	24,5	32	39	156	75	96	1,28	SOGX 080308	24503
KUB-P.3D.250.R.08-C32	U4322500	25,0	32	39	156	75	96	1,28	SOGX 080308	25003
KUB-P.3D.255.R.08-C32	U4322550	25,5	32	39	159	78	99	1,28	SOGX 080308	25503
KUB-P.3D.260.R.08-C32	U4322600	26,0	32	39	159	78	99	1,28	SOGX 080308	26003
KUB-P.3D.265.R.09-C32	U4322650	26,5	32	39	163	81	103	2,25	SOGX 09T308	26503
KUB-P.3D.270.R.09-C32	U4322700	27,0	32	39	163	81	103	2,25	SOGX 09T308	27003
KUB-P.3D.275.R.09-C32	U4322750	27,5	32	39	166	84	106	2,25	SOGX 09T308	27503
KUB-P.3D.280.R.09-C32	U4322800	28,0	32	39	166	84	106	2,25	SOGX 09T308	28003
KUB-P.3D.285.R.09-C32	U4322850	28,5	32	39	170	87	110	2,25	SOGX 09T308	28503
KUB-P.3D.290.R.09-C32	U4322900	29,0	32	39	170	87	110	2,25	SOGX 09T308	29003
KUB-P.3D.295.R.09-C32	U4322950	29,5	32	39	173	90	113	2,25	SOGX 09T308	29503
KUB-P.3D.300.R.09-C32	U4323000	30,0	32	39	173	90	113	2,25	SOGX 09T308	30003
KUB-P.3D.310.R.10-C40	U4333100	31,0	40	50	185	93	117	2,8	SOGX 100408	31004
KUB-P.3D.320.R.10-C40	U4333200	32,0	40	50	188	96	120	2,8	SOGX 100408	32004
KUB-P.3D.330.R.10-C40	U4333300	33,0	40	50	192	99	124	2,8	SOGX 100408	33004
KUB-P.3D.340.R.11-C40	U4333400	34,0	40	50	195	102	127	2,8	SOGX 110408	34004
KUB-P.3D.350.R.11-C40	U4333500	35,0	40	50	199	105	131	2,8	SOGX 110408	35004
KUB-P.3D.360.R.11-C40	U4333600	36,0	40	50	202	108	134	2,8	SOGX 110408	36004
KUB-P.3D.370.R.11-C40	U4333700	37,0	40	50	206	111	138	2,8	SOGX 110408	37004
KUB-P.3D.380.R.12-C40	U4333800	38,0	40	50	209	114	141	6,25	SOGX 120408	38004
KUB-P.3D.390.R.12-C40	U4333900	39,0	40	50	213	117	145	6,25	SOGX 120408	39004
KUB-P.3D.400.R.12-C40	U4334000	40,0	40	50	216	120	148	6,25	SOGX 120408	40004
KUB-P.3D.410.R.12-C40	U4334100	41,0	40	50	220	123	152	6,25	SOGX 120408	41004
KUB-P.3D.420.R.12-C40	U4334200	42,0	40	50	223	126	155	6,25	SOGX 120408	42004

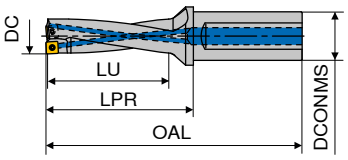
Continued on next page

KUB Pentron

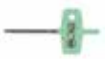
Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 3xD

C



Designation	KOMET no.	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 873 ...
KUB-P.3D.430.R.13-C40	U4334300	43,0	40	50	227	129	159	6,25	SOGX 130508	**43004**
KUB-P.3D.440.R.13-C40	U4334400	44,0	40	50	230	132	162	6,25	SOGX 130508	**44004**
KUB-P.3D.450.R.13-C40	U4334500	45,0	40	50	234	135	166	6,25	SOGX 130508	**45004**
KUB-P.3D.460.R.13-C40	U4334600	46,0	40	50	237	138	169	6,25	SOGX 130508	**46004**


Screwdriver

Key D

Clamping screw

Spare parts DC	Article no. 80 950 ...		Article no. 80 950 ...		Article no. 10 950 ...	
14 - 16	T05 - IP	**057**			M1,8x3,8 - 05IP	**10100**
16,5 - 18			T06 - IP	**123**	M2,0x4,3 - 06IP	**10000**
18,5 - 23			T06 - IP	**123**	M2,2x5,5 - 06IP	**10700**
23,5 - 26			T08 - IP	**125**	M2,5x6,3 - 08IP	**10800**
26,5 - 30			T08 - IP	**125**	M3,0x7,6 - 08IP	**10200**
31 - 37			T15 - IP	**128**	M3,5x7,5 - 15IP	**10300**
38 - 46			T20 - IP	**129**	M4,5x10,0 - 20IP	**10400**

Suitable adapters can be found in → **Chapter 16 Adapters.**

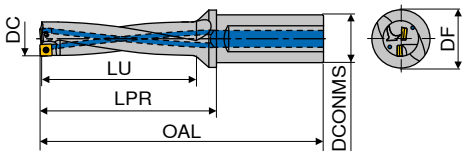
KUB Pentron

Scope of supply:

Indexable Insert Drill incl. clamping screws

≤ 4xD

C



Designation	KOMET no.	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 874 ...
KUB-P.4D.140.R.04-C20	U4401400	14,0	20	30	119	56	69	0,38	SOGX 040204	14001
KUB-P.4D.145.R.04-C20	U4401450	14,5	20	30	124	60	74	0,38	SOGX 040204	14501
KUB-P.4D.150.R.04-C20	U4401500	15,0	20	30	124	60	74	0,38	SOGX 040204	15001
KUB-P.4D.155.R.04-C20	U4401550	15,5	20	30	130	64	80	0,38	SOGX 040204	15501
KUB-P.4D.160.R.04-C20	U4401600	16,0	20	30	130	64	80	0,38	SOGX 040204	16001
KUB-P.4D.165.R.05-C20	U4401650	16,5	20	30	135	68	85	0,62	SOGX 050204	16501
KUB-P.4D.170.R.05-C20	U4401700	17,0	20	30	135	68	85	0,62	SOGX 050204	17001
KUB-P.4D.175.R.05-C25	U4411750	17,5	25	30	145	72	89	0,62	SOGX 050204	17502
KUB-P.4D.180.R.05-C25	U4411800	18,0	25	30	145	72	89	0,62	SOGX 050204	18002
KUB-P.4D.185.R.06-C25	U4411850	18,5	25	30	150	76	94	1,01	SOGX 060206	18502
KUB-P.4D.190.R.06-C25	U4411900	19,0	25	30	150	76	94	1,01	SOGX 060206	19002
KUB-P.4D.195.R.06-C25	U4411950	19,5	25	30	154	80	98	1,01	SOGX 060206	19502
KUB-P.4D.200.R.06-C25	U4412000	20,0	25	30	154	80	98	1,01	SOGX 060206	20002
KUB-P.4D.205.R.07-C25	U4412050	20,5	25	30	159	84	103	1,01	SOGX 07T208	20502
KUB-P.4D.210.R.07-C25	U4412100	21,0	25	30	159	84	103	1,01	SOGX 07T208	21002
KUB-P.4D.215.R.07-C25	U4412150	21,5	25	30	163	88	107	1,01	SOGX 07T208	21502
KUB-P.4D.220.R.07-C25	U4412200	22,0	25	30	163	88	107	1,01	SOGX 07T208	22002
KUB-P.4D.225.R.07-C25	U4412250	22,5	25	30	168	92	112	1,01	SOGX 07T208	22502
KUB-P.4D.230.R.07-C25	U4412300	23,0	25	30	168	92	112	1,01	SOGX 07T208	23002
KUB-P.4D.235.R.08-C32	U4422350	23,5	32	39	176	96	116	1,28	SOGX 080308	23503
KUB-P.4D.240.R.08-C32	U4422400	24,0	32	39	176	96	116	1,28	SOGX 080308	24003
KUB-P.4D.245.R.08-C32	U4422450	24,5	32	39	181	100	121	1,28	SOGX 080308	24503
KUB-P.4D.250.R.08-C32	U4422500	25,0	32	39	181	100	121	1,28	SOGX 080308	25003
KUB-P.4D.255.R.08-C32	U4422550	25,5	32	39	185	104	125	1,28	SOGX 080308	25503
KUB-P.4D.260.R.08-C32	U4422600	26,0	32	39	185	104	125	1,28	SOGX 080308	26003
KUB-P.4D.265.R.09-C32	U4422650	26,5	32	39	190	108	130	2,25	SOGX 09T308	26503
KUB-P.4D.270.R.09-C32	U4422700	27,0	32	39	190	108	130	2,25	SOGX 09T308	27003
KUB-P.4D.275.R.09-C32	U4422750	27,5	32	39	194	112	134	2,25	SOGX 09T308	27503
KUB-P.4D.280.R.09-C32	U4422800	28,0	32	39	194	112	134	2,25	SOGX 09T308	28003
KUB-P.4D.285.R.09-C32	U4422850	28,5	32	39	199	116	139	2,25	SOGX 09T308	28503
KUB-P.4D.290.R.09-C32	U4422900	29,0	32	39	199	116	139	2,25	SOGX 09T308	29003
KUB-P.4D.295.R.09-C32	U4422950	29,5	32	39	203	120	143	2,25	SOGX 09T308	29503
KUB-P.4D.300.R.09-C32	U4423000	30,0	32	39	203	120	143	2,25	SOGX 09T308	30003
KUB-P.4D.310.R.10-C40	U4433100	31,0	40	50	216	124	148	2,8	SOGX 100408	31004
KUB-P.4D.320.R.10-C40	U4433200	32,0	40	50	220	128	152	2,8	SOGX 100408	32004
KUB-P.4D.330.R.10-C40	U4433300	33,0	40	50	225	132	157	2,8	SOGX 100408	33004
KUB-P.4D.340.R.11-C40	U4433400	34,0	40	50	229	136	161	2,8	SOGX 110408	34004
KUB-P.4D.350.R.11-C40	U4433500	35,0	40	50	234	140	166	2,8	SOGX 110408	35004
KUB-P.4D.360.R.11-C40	U4433600	36,0	40	50	238	144	170	2,8	SOGX 110408	36004
KUB-P.4D.370.R.11-C40	U4433700	37,0	40	50	243	148	175	2,8	SOGX 110408	37004
KUB-P.4D.380.R.12-C40	U4433800	38,0	40	50	247	152	179	6,25	SOGX 120408	38004
KUB-P.4D.390.R.12-C40	U4433900	39,0	40	50	252	156	184	6,25	SOGX 120408	39004
KUB-P.4D.400.R.12-C40	U4434000	40,0	40	50	256	160	188	6,25	SOGX 120408	40004
KUB-P.4D.410.R.12-C40	U4434100	41,0	40	50	261	164	193	6,25	SOGX 120408	41004
KUB-P.4D.420.R.12-C40	U4434200	42,0	40	50	265	168	197	6,25	SOGX 120408	42004

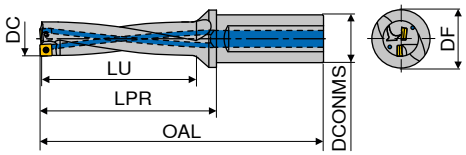
Continued on next page

KUB Pentron

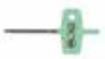
Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 4xD

C



Designation	KOMET no.	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 874 ...
KUB-P.4D.430.R.13-C40	U4434300	43,0	40	50	270	172	202	6,25	SOGX 130508	**43004**
KUB-P.4D.440.R.13-C40	U4434400	44,0	40	50	274	176	206	6,25	SOGX 130508	**44004**
KUB-P.4D.450.R.13-C40	U4434500	45,0	40	50	279	180	211	6,25	SOGX 130508	**45004**
KUB-P.4D.460.R.13-C40	U4434600	46,0	40	50	283	184	215	6,25	SOGX 130508	**46004**


Screwdriver

Key D

Clamping screw

Spare parts DC	Article no. 80 950 ...		Article no. 80 950 ...		Article no. 10 950 ...	
14 - 16	T05 - IP	**057**			M1,8x3,8 - 05IP	**10100**
16,5 - 18			T06 - IP	**123**	M2,0x4,3 - 06IP	**10000**
18,5 - 23			T06 - IP	**123**	M2,2x5,5 - 06IP	**10700**
23,5 - 26			T08 - IP	**125**	M2,5x6,3 - 08IP	**10800**
26,5 - 30			T08 - IP	**125**	M3,0x7,6 - 08IP	**10200**
31 - 37			T15 - IP	**128**	M3,5x7,5 - 15IP	**10300**
38 - 46			T20 - IP	**129**	M4,5x10,0 - 20IP	**10400**

Suitable adapters can be found in → **Chapter 16 Adapters.**

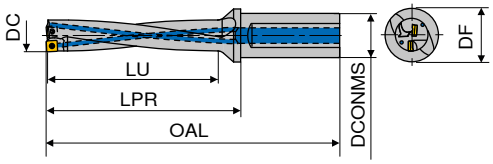
KUB Pentron

Scope of supply:

Indexable Insert Drill incl. clamping screws

≤ 5xD

C



Designation	KOMET no.	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 875 ...
KUB-P.5D.140.R.04-C20	U4501400	14,0	20	30	133	70	83	0,38	SOGX 040204	14001
KUB-P.5D.145.R.04-C20	U4501450	14,5	20	30	139	75	89	0,38	SOGX 040204	14501
KUB-P.5D.150.R.04-C20	U4501500	15,0	20	30	139	75	89	0,38	SOGX 040204	15001
KUB-P.5D.155.R.04-C20	U4501550	15,5	20	30	146	80	96	0,38	SOGX 040204	15501
KUB-P.5D.160.R.04-C20	U4501600	16,0	20	30	146	80	96	0,38	SOGX 040204	16001
KUB-P.5D.165.R.05-C20	U4501650	16,5	20	30	152	85	102	0,62	SOGX 050204	16501
KUB-P.5D.170.R.05-C20	U4501700	17,0	20	30	152	85	102	0,62	SOGX 050204	17001
KUB-P.5D.175.R.05-C25	U4511750	17,5	25	30	163	90	107	0,62	SOGX 050204	17502
KUB-P.5D.180.R.05-C25	U4511800	18,0	25	30	163	90	107	0,62	SOGX 050204	18002
KUB-P.5D.185.R.06-C25	U4511850	18,5	25	30	169	95	113	1,01	SOGX 060206	18502
KUB-P.5D.190.R.06-C25	U4511900	19,0	25	30	169	95	113	1,01	SOGX 060206	19002
KUB-P.5D.195.R.06-C25	U4511950	19,5	25	30	174	100	118	1,01	SOGX 060206	19502
KUB-P.5D.200.R.06-C25	U4512000	20,0	25	30	174	100	118	1,01	SOGX 060206	20002
KUB-P.5D.205.R.07-C25	U4512050	20,5	25	30	180	105	124	1,01	SOGX 07T208	20502
KUB-P.5D.210.R.07-C25	U4512100	21,0	25	30	180	105	124	1,01	SOGX 07T208	21002
KUB-P.5D.215.R.07-C25	U4512150	21,5	25	30	185	110	129	1,01	SOGX 07T208	21502
KUB-P.5D.220.R.07-C25	U4512200	22,0	25	30	185	110	129	1,01	SOGX 07T208	22002
KUB-P.5D.225.R.07-C25	U4512250	22,5	25	30	191	115	135	1,01	SOGX 07T208	22502
KUB-P.5D.230.R.07-C25	U4512300	23,0	25	30	191	115	135	1,01	SOGX 07T208	23002
KUB-P.5D.235.R.08-C32	U4522350	23,5	32	39	200	120	140	1,28	SOGX 080308	23503
KUB-P.5D.240.R.08-C32	U4522400	24,0	32	39	200	120	140	1,28	SOGX 080308	24003
KUB-P.5D.245.R.08-C32	U4522450	24,5	32	39	206	125	146	1,28	SOGX 080308	24503
KUB-P.5D.250.R.08-C32	U4522500	25,0	32	39	206	125	146	1,28	SOGX 080308	25003
KUB-P.5D.255.R.08-C32	U4522550	25,5	32	39	211	130	151	1,28	SOGX 080308	25503
KUB-P.5D.260.R.08-C32	U4522600	26,0	32	39	211	130	151	1,28	SOGX 080308	26003
KUB-P.5D.265.R.09-C32	U4522650	26,5	32	39	217	135	157	2,25	SOGX 09T308	26503
KUB-P.5D.270.R.09-C32	U4522700	27,0	32	39	217	135	157	2,25	SOGX 09T308	27003
KUB-P.5D.275.R.09-C32	U4522750	27,5	32	39	222	140	162	2,25	SOGX 09T308	27503
KUB-P.5D.280.R.09-C32	U4522800	28,0	32	39	222	140	162	2,25	SOGX 09T308	28003
KUB-P.5D.285.R.09-C32	U4522850	28,5	32	39	228	145	168	2,25	SOGX 09T308	28503
KUB-P.5D.290.R.09-C32	U4522900	29,0	32	39	228	145	168	2,25	SOGX 09T308	29003
KUB-P.5D.295.R.09-C32	U4522950	29,5	32	39	233	150	173	2,25	SOGX 09T308	29503
KUB-P.5D.300.R.09-C32	U4523000	30,0	32	39	233	150	173	2,25	SOGX 09T308	30003
KUB-P.5D.310.R.10-C40	U4533100	31,0	40	50	247	155	179	2,8	SOGX 100408	31004
KUB-P.5D.320.R.10-C40	U4533200	32,0	40	50	252	160	184	2,8	SOGX 100408	32004
KUB-P.5D.330.R.10-C40	U4533300	33,0	40	50	258	165	190	2,8	SOGX 100408	33004
KUB-P.5D.340.R.11-C40	U4533400	34,0	40	50	263	170	195	2,8	SOGX 110408	34004
KUB-P.5D.350.R.11-C40	U4533500	35,0	40	50	269	175	201	2,8	SOGX 110408	35004
KUB-P.5D.360.R.11-C40	U4533600	36,0	40	50	274	180	206	2,8	SOGX 110408	36004
KUB-P.5D.370.R.11-C40	U4533700	37,0	40	50	280	185	212	2,8	SOGX 110408	37004
KUB-P.5D.380.R.12-C40	U4533800	38,0	40	50	285	190	217	6,25	SOGX 120408	38004
KUB-P.5D.390.R.12-C40	U4533900	39,0	40	50	291	195	223	6,25	SOGX 120408	39004
KUB-P.5D.400.R.12-C40	U4534000	40,0	40	50	296	200	228	6,25	SOGX 120408	40004
KUB-P.5D.410.R.12-C40	U4534100	41,0	40	50	302	205	234	6,25	SOGX 120408	41004
KUB-P.5D.420.R.12-C40	U4534200	42,0	40	50	307	210	239	6,25	SOGX 120408	42004

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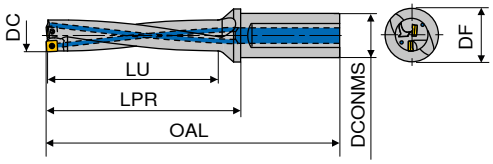
KUB Pentron

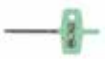
Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 5xD

C



Designation	KOMET no.	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 875 ...
KUB-P.5D.430.R.13-C40	U4534300	43,0	40	50	313	215	245	6,25	SOGX 130508	**43004**
KUB-P.5D.440.R.13-C40	U4534400	44,0	40	50	318	220	250	6,25	SOGX 130508	**44004**
KUB-P.5D.450.R.13-C40	U4534500	45,0	40	50	324	225	256	6,25	SOGX 130508	**45004**
KUB-P.5D.460.R.13-C40	U4534600	46,0	40	50	329	230	261	6,25	SOGX 130508	**46004**


Screwdriver

Key D

Clamping screw

Spare parts DC	Article no. 80 950 ...		Article no. 80 950 ...		Article no. 10 950 ...	
14 - 16	T05 - IP	**057**			M1,8x3,8 - 05IP	**10100**
16,5 - 18			T06 - IP	**123**	M2,0x4,3 - 06IP	**10000**
18,5 - 23			T06 - IP	**123**	M2,2x5,5 - 06IP	**10700**
23,5 - 26			T08 - IP	**125**	M2,5x6,3 - 08IP	**10800**
26,5 - 30			T08 - IP	**125**	M3,0x7,6 - 08IP	**10200**
31 - 37			T15 - IP	**128**	M3,5x7,5 - 15IP	**10300**
38 - 46			T20 - IP	**129**	M4,5x10,0 - 20IP	**10400**

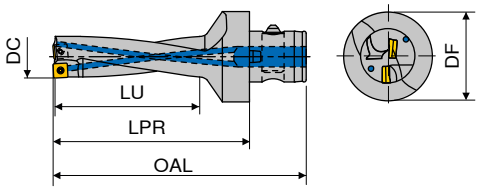
Suitable adapters can be found in → **Chapter 16 Adapters.**

KUB Pentron

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 3xD

ABS



Designation	KOMET no.	DC mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 873 ...
KUB-P.3D.140.R.04-ABS50	U4351400	14,0	50	100	42	69	0,38	SOGX 040204	14095
KUB-P.3D.145.R.04-ABS50	U4351450	14,5	50	104	45	73	0,38	SOGX 040204	14595
KUB-P.3D.150.R.04-ABS50	U4351500	15,0	50	104	45	73	0,38	SOGX 040204	15095
KUB-P.3D.155.R.04-ABS50	U4351550	15,5	50	109	48	78	0,38	SOGX 040204	15595
KUB-P.3D.160.R.04-ABS50	U4351600	16,0	50	109	48	78	0,38	SOGX 040204	16095
KUB-P.3D.165.R.05-ABS50	U4351650	16,5	50	113	51	82	0,62	SOGX 050204	16595
KUB-P.3D.170.R.05-ABS50	U4351700	17,0	50	113	51	82	0,62	SOGX 050204	17095
KUB-P.3D.175.R.05-ABS50	U4351750	17,5	50	116	54	85	0,62	SOGX 050204	17595
KUB-P.3D.180.R.05-ABS50	U4351800	18,0	50	116	54	85	0,62	SOGX 050204	18095
KUB-P.3D.185.R.06-ABS50	U4351850	18,5	50	120	57	89	1,01	SOGX 060206	18595
KUB-P.3D.190.R.06-ABS50	U4351900	19,0	50	120	57	89	1,01	SOGX 060206	19095
KUB-P.3D.195.R.06-ABS50	U4351950	19,5	50	123	60	92	1,01	SOGX 060206	19595
KUB-P.3D.200.R.06-ABS50	U4352000	20,0	50	123	60	92	1,01	SOGX 060206	20095
KUB-P.3D.205.R.07-ABS50	U4352050	20,5	50	126	63	95	1,01	SOGX 07T208	20595
KUB-P.3D.210.R.07-ABS50	U4352100	21,0	50	126	63	95	1,01	SOGX 07T208	21095
KUB-P.3D.215.R.07-ABS50	U4352150	21,5	50	129	66	98	1,01	SOGX 07T208	21595
KUB-P.3D.220.R.07-ABS50	U4352200	22,0	50	129	66	98	1,01	SOGX 07T208	22095
KUB-P.3D.225.R.07-ABS50	U4352250	22,5	50	132	69	101	1,01	SOGX 07T208	22595
KUB-P.3D.230.R.07-ABS50	U4352300	23,0	50	132	69	101	1,01	SOGX 07T208	23095
KUB-P.3D.235.R.08-ABS50	U4352350	23,5	50	135	72	104	1,28	SOGX 080308	23595
KUB-P.3D.240.R.08-ABS50	U4352400	24,0	50	135	72	104	1,28	SOGX 080308	24095
KUB-P.3D.245.R.08-ABS50	U4352450	24,5	50	139	75	108	1,28	SOGX 080308	24595
KUB-P.3D.250.R.08-ABS50	U4352500	25,0	50	139	75	108	1,28	SOGX 080308	25095
KUB-P.3D.255.R.08-ABS50	U4352550	25,5	50	142	78	111	1,28	SOGX 080308	25595
KUB-P.3D.260.R.08-ABS50	U4352600	26,0	50	142	78	111	1,28	SOGX 080308	26095
KUB-P.3D.265.R.09-ABS50	U4352650	26,5	50	146	81	115	2,25	SOGX 09T308	26595
KUB-P.3D.270.R.09-ABS50	U4352700	27,0	50	146	81	115	2,25	SOGX 09T308	27095
KUB-P.3D.275.R.09-ABS50	U4352750	27,5	50	149	84	118	2,25	SOGX 09T308	27595
KUB-P.3D.280.R.09-ABS50	U4352800	28,0	50	149	84	118	2,25	SOGX 09T308	28095
KUB-P.3D.285.R.09-ABS50	U4352850	28,5	50	153	87	122	2,25	SOGX 09T308	28595
KUB-P.3D.290.R.09-ABS50	U4352900	29,0	50	153	87	122	2,25	SOGX 09T308	29095
KUB-P.3D.295.R.09-ABS50	U4352950	29,5	50	156	90	125	2,25	SOGX 09T308	29595
KUB-P.3D.300.R.09-ABS50	U4353000	30,0	50	156	90	125	2,25	SOGX 09T308	30095

Screwdriver

Key D

Clamping screw

Spare parts DC		Article no. 80 950 ...		Article no. 80 950 ...		Article no. 10 950 ...
14 - 16	T05 - IP	057			M1,8x3,8 - 05IP	10100
16,5 - 18			T06 - IP	123	M2,0x4,3 - 06IP	10000
18,5 - 23			T06 - IP	123	M2,2x5,5 - 06IP	10700
23,5 - 26			T08 - IP	125	M2,5x6,3 - 08IP	10800
26,5 - 30			T08 - IP	125	M3,0x7,6 - 08IP	10200

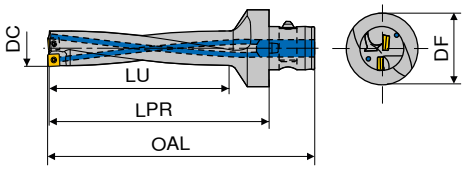
Suitable adapters can be found in → **Chapter 16 Adapters.**

KUB Pentron

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 4xD

ABS



Designation	KOMET no.	DC mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 874 ...
KUB-P.4D.140.R.04-ABS50	U4451400	14,0	50	114	56	83	0,38	SOGX 040204	14095
KUB-P.4D.145.R.04-ABS50	U4451450	14,5	50	119	60	88	0,38	SOGX 040204	14595
KUB-P.4D.150.R.04-ABS50	U4451500	15,0	50	119	60	88	0,38	SOGX 040204	15095
KUB-P.4D.155.R.04-ABS50	U4451550	15,5	50	125	64	94	0,38	SOGX 040204	15595
KUB-P.4D.160.R.04-ABS50	U4451600	16,0	50	125	64	94	0,38	SOGX 040204	16095
KUB-P.4D.165.R.05-ABS50	U4451650	16,5	50	130	68	99	0,62	SOGX 050204	16595
KUB-P.4D.170.R.05-ABS50	U4451700	17,0	50	130	68	99	0,62	SOGX 050204	17095
KUB-P.4D.175.R.05-ABS50	U4451750	17,5	50	134	72	103	0,62	SOGX 050204	17595
KUB-P.4D.180.R.05-ABS50	U4451800	18,0	50	134	72	103	0,62	SOGX 050204	18095
KUB-P.4D.185.R.06-ABS50	U4451850	18,5	50	139	76	108	1,01	SOGX 060206	18595
KUB-P.4D.190.R.06-ABS50	U4451900	19,0	50	139	76	108	1,01	SOGX 060206	19095
KUB-P.4D.195.R.06-ABS50	U4451950	19,5	50	143	80	112	1,01	SOGX 060206	19595
KUB-P.4D.200.R.06-ABS50	U4452000	20,0	50	143	80	112	1,01	SOGX 060206	20095
KUB-P.4D.205.R.07-ABS50	U4452050	20,5	50	147	84	116	1,01	SOGX 07T208	20595
KUB-P.4D.210.R.07-ABS50	U4452100	21,0	50	147	84	116	1,01	SOGX 07T208	21095
KUB-P.4D.215.R.07-ABS50	U4452150	21,5	50	151	88	120	1,01	SOGX 07T208	21595
KUB-P.4D.220.R.07-ABS50	U4452200	22,0	50	151	88	120	1,01	SOGX 07T208	22095
KUB-P.4D.225.R.07-ABS50	U4452250	22,5	50	155	92	124	1,01	SOGX 07T208	22595
KUB-P.4D.230.R.07-ABS50	U4452300	23,0	50	155	92	124	1,01	SOGX 07T208	23095
KUB-P.4D.235.R.08-ABS50	U4452350	23,5	50	159	96	128	1,28	SOGX 080308	23595
KUB-P.4D.240.R.08-ABS50	U4452400	24,0	50	159	96	128	1,28	SOGX 080308	24095
KUB-P.4D.245.R.08-ABS50	U4452450	24,5	50	164	100	133	1,28	SOGX 080308	24595
KUB-P.4D.250.R.08-ABS50	U4452500	25,0	50	164	100	133	1,28	SOGX 080308	25095
KUB-P.4D.255.R.08-ABS50	U4452550	25,5	50	168	104	137	1,28	SOGX 080308	25595
KUB-P.4D.260.R.08-ABS50	U4452600	26,0	50	168	104	137	1,28	SOGX 080308	26095
KUB-P.4D.265.R.09-ABS50	U4452650	26,5	50	173	108	142	2,25	SOGX 09T308	26595
KUB-P.4D.270.R.09-ABS50	U4452700	27,0	50	173	108	142	2,25	SOGX 09T308	27095
KUB-P.4D.275.R.09-ABS50	U4452750	27,5	50	177	112	146	2,25	SOGX 09T308	27595
KUB-P.4D.280.R.09-ABS50	U4452800	28,0	50	177	112	146	2,25	SOGX 09T308	28095
KUB-P.4D.285.R.09-ABS50	U4452850	28,5	50	182	116	151	2,25	SOGX 09T308	28595
KUB-P.4D.290.R.09-ABS50	U4452900	29,0	50	182	116	151	2,25	SOGX 09T308	29095
KUB-P.4D.295.R.09-ABS50	U4452950	29,5	50	186	120	155	2,25	SOGX 09T308	29595
KUB-P.4D.300.R.09-ABS50	U4453000	30,0	50	186	120	155	2,25	SOGX 09T308	30095

Screwdriver

Key D

Clamping screw

Spare parts DC		Article no. 80 950 ...		Article no. 80 950 ...		Article no. 10 950 ...
14 - 16	T05 - IP	057			M1,8x3,8 - 05IP	10100
16,5 - 18			T06 - IP	123	M2,0x4,3 - 06IP	10000
18,5 - 23			T06 - IP	123	M2,2x5,5 - 06IP	10700
23,5 - 26			T08 - IP	125	M2,5x6,3 - 08IP	10800
26,5 - 30			T08 - IP	125	M3,0x7,6 - 08IP	10200

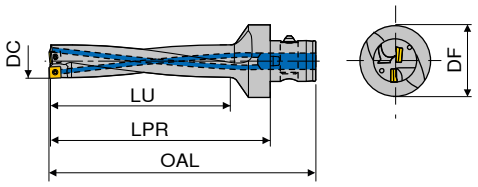
Suitable adapters can be found in → **Chapter 16 Adapters.**

KUB Pentron

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 5xD

ABS



Designation	KOMET no.	DC mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 875 ...
KUB-P.5D.140.R.04-ABS50	U4551400	14,0	50	128	70	97	0,38	SOGX 040204	14095
KUB-P.5D.145.R.04-ABS50	U4551450	14,5	50	134	75	103	0,38	SOGX 040204	14595
KUB-P.5D.150.R.04-ABS50	U4551500	15,0	50	134	75	103	0,38	SOGX 040204	15095
KUB-P.5D.155.R.04-ABS50	U4551550	15,5	50	141	80	110	0,38	SOGX 040204	15595
KUB-P.5D.160.R.04-ABS50	U4551600	16,0	50	141	80	110	0,38	SOGX 040204	16095
KUB-P.5D.165.R.05-ABS50	U4551650	16,5	50	147	85	116	0,62	SOGX 050204	16595
KUB-P.5D.170.R.05-ABS50	U4551700	17,0	50	147	85	116	0,62	SOGX 050204	17095
KUB-P.5D.175.R.05-ABS50	U4551750	17,5	50	152	90	121	0,62	SOGX 050204	17595
KUB-P.5D.180.R.05-ABS50	U4551800	18,0	50	152	90	121	0,62	SOGX 050204	18095
KUB-P.5D.185.R.06-ABS50	U4551850	18,5	50	158	95	127	1,01	SOGX 060206	18595
KUB-P.5D.190.R.06-ABS50	U4551900	19,0	50	158	95	127	1,01	SOGX 060206	19095
KUB-P.5D.195.R.06-ABS50	U4551950	19,5	50	163	100	132	1,01	SOGX 060206	19595
KUB-P.5D.200.R.06-ABS50	U4552000	20,0	50	163	100	132	1,01	SOGX 060206	20095
KUB-P.5D.205.R.07-ABS50	U4552050	20,5	50	168	105	137	1,01	SOGX 07T208	20595
KUB-P.5D.210.R.07-ABS50	U4552100	21,0	50	168	105	137	1,01	SOGX 07T208	21095
KUB-P.5D.215.R.07-ABS50	U4552150	21,5	50	173	110	142	1,01	SOGX 07T208	21595
KUB-P.5D.220.R.07-ABS50	U4552200	22,0	50	173	110	142	1,01	SOGX 07T208	22095
KUB-P.5D.225.R.07-ABS50	U4552250	22,5	50	178	115	147	1,01	SOGX 07T208	22595
KUB-P.5D.230.R.07-ABS50	U4552300	23,0	50	178	115	147	1,01	SOGX 07T208	23095
KUB-P.5D.235.R.08-ABS50	U4552350	23,5	50	183	120	152	1,28	SOGX 080308	23595
KUB-P.5D.240.R.08-ABS50	U4552400	24,0	50	183	120	152	1,28	SOGX 080308	24095
KUB-P.5D.245.R.08-ABS50	U4552450	24,5	50	189	125	158	1,28	SOGX 080308	24595
KUB-P.5D.250.R.08-ABS50	U4552500	25,0	50	189	125	158	1,28	SOGX 080308	25095
KUB-P.5D.255.R.08-ABS50	U4552550	25,5	50	194	130	163	1,28	SOGX 080308	25595
KUB-P.5D.260.R.08-ABS50	U4552600	26,0	50	194	130	163	1,28	SOGX 080308	26095
KUB-P.5D.265.R.09-ABS50	U4552650	26,5	50	200	135	169	2,25	SOGX 09T308	26595
KUB-P.5D.270.R.09-ABS50	U4552700	27,0	50	200	135	169	2,25	SOGX 09T308	27095
KUB-P.5D.275.R.09-ABS50	U4552750	27,5	50	205	140	174	2,25	SOGX 09T308	27595
KUB-P.5D.280.R.09-ABS50	U4552800	28,0	50	205	140	174	2,25	SOGX 09T308	28095
KUB-P.5D.285.R.09-ABS50	U4552850	28,5	50	211	145	180	2,25	SOGX 09T308	28595
KUB-P.5D.290.R.09-ABS50	U4552900	29,0	50	211	145	180	2,25	SOGX 09T308	29095
KUB-P.5D.295.R.09-ABS50	U4552950	29,5	50	216	150	185	2,25	SOGX 09T308	29595
KUB-P.5D.300.R.09-ABS50	U4553000	30,0	50	216	150	185	2,25	SOGX 09T308	30095

Screwdriver

Key D

Clamping screw

Spare parts DC		Article no. 80 950 ...		Article no. 80 950 ...		Article no. 10 950 ...
14 - 16	T05 - IP	057			M1,8x3,8 - 05IP	10100
16,5 - 18			T06 - IP	123	M2,0x4,3 - 06IP	10000
18,5 - 23			T06 - IP	123	M2,2x5,5 - 06IP	10700
23,5 - 26			T08 - IP	125	M2,5x6,3 - 08IP	10800
26,5 - 30			T08 - IP	125	M3,0x7,6 - 08IP	10200

Suitable adapters can be found in → **Chapter 16 Adapters.**

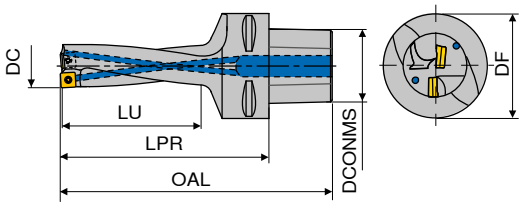
KUB Pentron

Scope of supply:

Indexable Insert Drill incl. clamping screws

≤ 3xD

PSC



Designation	KOMET no.	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 873 ...
KUB-P.3D.140.R.04-PSC50	U4061400	14,0	24,25	50	103	42	73	0,38	SOGX 040204	14055
KUB-P.3D.145.R.04-PSC50	U4061450	14,5	24,25	50	107	45	77	0,38	SOGX 040204	14555
KUB-P.3D.150.R.04-PSC50	U4061500	15,0	24,25	50	107	45	77	0,38	SOGX 040204	15055
KUB-P.3D.155.R.04-PSC50	U4061550	15,5	24,25	50	112	48	82	0,38	SOGX 040204	15555
KUB-P.3D.160.R.04-PSC50	U4061600	16,0	24,25	50	112	48	82	0,38	SOGX 040204	16055
KUB-P.3D.160.R.04-PSC63	U4071600	16,0	30,30	63	124	48	86	0,38	SOGX 040204	16056
KUB-P.3D.165.R.05-PSC50	U4061650	16,5	24,25	50	116	51	86	0,62	SOGX 050204	16555
KUB-P.3D.170.R.05-PSC50	U4061700	17,0	24,25	50	116	51	86	0,62	SOGX 050204	17055
KUB-P.3D.175.R.05-PSC50	U4061750	17,5	24,25	50	119	54	89	0,62	SOGX 050204	17555
KUB-P.3D.180.R.05-PSC50	U4061800	18,0	24,25	50	119	54	89	0,62	SOGX 050204	18055
KUB-P.3D.165.R.05-PSC63	U4071650	16,5	30,30	63	128	51	90	0,62	SOGX 050204	16556
KUB-P.3D.170.R.05-PSC63	U4071700	17,0	30,30	63	128	51	90	0,62	SOGX 050204	17056
KUB-P.3D.175.R.05-PSC63	U4071750	17,5	30,30	63	131	54	93	0,62	SOGX 050204	17556
KUB-P.3D.180.R.05-PSC63	U4071800	18,0	30,30	63	131	54	93	0,62	SOGX 050204	18056
KUB-P.3D.185.R.06-PSC50	U4061850	18,5	24,25	50	123	57	93	1,01	SOGX 060206	18555
KUB-P.3D.190.R.06-PSC50	U4061900	19,0	24,25	50	123	57	93	1,01	SOGX 060206	19055
KUB-P.3D.195.R.06-PSC50	U4061950	19,5	24,25	50	126	60	96	1,01	SOGX 060206	19555
KUB-P.3D.200.R.06-PSC50	U4062000	20,0	24,25	50	126	60	96	1,01	SOGX 060206	20055
KUB-P.3D.185.R.06-PSC63	U4071850	18,5	30,30	63	135	57	97	1,01	SOGX 060206	18556
KUB-P.3D.190.R.06-PSC63	U4071900	19,0	30,30	63	135	57	97	1,01	SOGX 060206	19056
KUB-P.3D.195.R.06-PSC63	U4071950	19,5	30,30	63	138	60	100	1,01	SOGX 060206	19556
KUB-P.3D.200.R.06-PSC63	U4072000	20,0	30,30	63	138	60	100	1,01	SOGX 060206	20056
KUB-P.3D.205.R.07-PSC50	U4062050	20,5	24,25	50	130	63	100	1,01	SOGX 07T208	20555
KUB-P.3D.210.R.07-PSC50	U4062100	21,0	24,25	50	130	63	100	1,01	SOGX 07T208	21055
KUB-P.3D.215.R.07-PSC50	U4062150	21,5	24,25	50	133	66	103	1,01	SOGX 07T208	21555
KUB-P.3D.220.R.07-PSC50	U4062200	22,0	24,25	50	133	66	103	1,01	SOGX 07T208	22055
KUB-P.3D.225.R.07-PSC50	U4062250	22,5	24,25	50	137	69	107	1,01	SOGX 07T208	22555
KUB-P.3D.230.R.07-PSC50	U4062300	23,0	24,25	50	137	69	107	1,01	SOGX 07T208	23055
KUB-P.3D.205.R.07-PSC63	U4072050	20,5	30,30	63	142	63	104	1,01	SOGX 07T208	20556
KUB-P.3D.210.R.07-PSC63	U4072100	21,0	30,30	63	142	63	104	1,01	SOGX 07T208	21056
KUB-P.3D.215.R.07-PSC63	U4072150	21,5	30,30	63	145	66	107	1,01	SOGX 07T208	21556
KUB-P.3D.220.R.07-PSC63	U4072200	22,0	30,30	63	145	66	107	1,01	SOGX 07T208	22056
KUB-P.3D.225.R.07-PSC63	U4072250	22,5	30,30	63	149	69	111	1,01	SOGX 07T208	22556
KUB-P.3D.230.R.07-PSC63	U4072300	23,0	30,30	63	149	69	111	1,01	SOGX 07T208	23056
KUB-P.3D.235.R.08-PSC50	U4062350	23,5	24,25	50	140	72	110	1,28	SOGX 080308	23555
KUB-P.3D.240.R.08-PSC50	U4062400	24,0	24,25	50	140	72	110	1,28	SOGX 080308	24055
KUB-P.3D.245.R.08-PSC50	U4062450	24,5	24,25	50	144	75	114	1,28	SOGX 080308	24555
KUB-P.3D.250.R.08-PSC50	U4062500	25,0	24,25	50	144	75	114	1,28	SOGX 080308	25055
KUB-P.3D.255.R.08-PSC50	U4062550	25,5	24,25	50	147	78	117	1,28	SOGX 080308	25555
KUB-P.3D.260.R.08-PSC50	U4062600	26,0	24,25	50	147	78	117	1,28	SOGX 080308	26055
KUB-P.3D.235.R.08-PSC63	U4072350	23,5	30,30	63	152	72	114	1,28	SOGX 080308	23556
KUB-P.3D.240.R.08-PSC63	U4072400	24,0	30,30	63	152	72	114	1,28	SOGX 080308	24056
KUB-P.3D.245.R.08-PSC63	U4072450	24,5	30,30	63	156	75	118	1,28	SOGX 080308	24556
KUB-P.3D.250.R.08-PSC63	U4072500	25,0	30,30	63	156	75	118	1,28	SOGX 080308	25056
KUB-P.3D.255.R.08-PSC63	U4072550	25,5	30,30	63	159	78	121	1,28	SOGX 080308	25556
KUB-P.3D.260.R.08-PSC63	U4072600	26,0	30,30	63	159	78	121	1,28	SOGX 080308	26056
KUB-P.3D.265.R.09-PSC50	U4062650	26,5	24,25	50	151	81	121	2,25	SOGX 09T308	26555
KUB-P.3D.270.R.09-PSC50	U4062700	27,0	24,25	50	151	81	121	2,25	SOGX 09T308	27055
KUB-P.3D.275.R.09-PSC50	U4062750	27,5	24,25	50	154	84	124	2,25	SOGX 09T308	27555

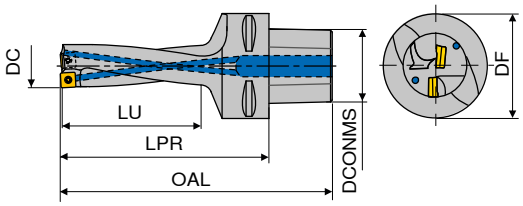
Continued on next page

KUB Pentron

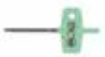
Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 3xD

PSC



Designation	KOMET no.	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 873 ...
KUB-P.3D.280.R.09-PSC50	U4062800	28,0	24,25	50	154	84	124	2,25	SOGX 09T308	28055
KUB-P.3D.285.R.09-PSC50	U4062850	28,5	24,25	50	158	87	128	2,25	SOGX 09T308	28555
KUB-P.3D.290.R.09-PSC50	U4062900	29,0	24,25	50	158	87	128	2,25	SOGX 09T308	29055
KUB-P.3D.295.R.09-PSC50	U4062950	29,5	24,25	50	161	90	131	2,25	SOGX 09T308	29555
KUB-P.3D.300.R.09-PSC50	U4063000	30,0	24,25	50	161	90	131	2,25	SOGX 09T308	30055
KUB-P.3D.265.R.09-PSC63	U4072650	26,5	30,30	63	163	81	125	2,25	SOGX 09T308	26556
KUB-P.3D.270.R.09-PSC63	U4072700	27,0	30,30	63	163	81	125	2,25	SOGX 09T308	27056
KUB-P.3D.275.R.09-PSC63	U4072750	27,5	30,30	63	166	84	128	2,25	SOGX 09T308	27556
KUB-P.3D.280.R.09-PSC63	U4072800	28,0	30,30	63	166	84	128	2,25	SOGX 09T308	28056
KUB-P.3D.285.R.09-PSC63	U4072850	28,5	30,30	63	170	87	132	2,25	SOGX 09T308	28556
KUB-P.3D.290.R.09-PSC63	U4072900	29,0	30,30	63	170	87	132	2,25	SOGX 09T308	29056
KUB-P.3D.295.R.09-PSC63	U4072950	29,5	30,30	63	173	90	135	2,25	SOGX 09T308	29556
KUB-P.3D.300.R.09-PSC63	U4073000	30,0	30,30	63	173	90	135	2,25	SOGX 09T308	30056



Screwdriver

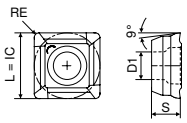
Key D

Clamping screw

Spare parts DC		Article no. 80 950 ...		Article no. 80 950 ...		Article no. 10 950 ...
14 - 16	T05 - IP	057			M1,8x3,8 - 05IP	10100
16,5 - 18			T06 - IP	123	M2,0x4,3 - 06IP	10000
18,5 - 23			T06 - IP	123	M2,2x5,5 - 06IP	10700
23,5 - 26			T08 - IP	125	M2,5x6,3 - 08IP	10800
26,5 - 30			T08 - IP	125	M3,0x7,6 - 08IP	10200

SOGX

Designation	L	IC	D1	S
	mm	mm	mm	mm
SOGX 0402..	4,8	4,8	2,05	2,20
SOGX 0502..	5,5	5,5	2,30	2,40
SOGX 0602..	6,2	6,2	2,60	2,75
SOGX 07T2..	7,1	7,1	2,60	2,97
SOGX 0803..	8,0	8,0	2,85	3,40
SOGX 09T3..	8,9	8,9	3,40	3,90
SOGX 1004..	9,8	9,8	4,10	4,20
SOGX 1104..	10,9	10,9	4,10	4,50
SOGX 1204..	12,0	12,0	5,20	4,80
SOGX 1305..	13,2	13,2	5,20	5,20



3

SOGX

			-01 BK8425	-01 BK6115
			SOGX	SOGX
			NEW Article no. 10 820 ...	NEW Article no. 10 820 ...
ISO	KOMET no.	RE mm		
040204	W8010010.046115	0,4		40401
040204	W8010010.048425	0,4	30401	
050204	W8012010.046115	0,4		40501
050204	W8012010.048425	0,4	30501	
060206	W8018010.066115	0,6		40601
060206	W8018010.068425	0,6	30601	
07T208	W8020010.086115	0,8		40701
07T208	W8020010.088425	0,8	30701	
080308	W8024010.086115	0,8		40801
080308	W8024010.088425	0,8	30801	
09T308	W8028010.086115	0,8		40901
09T308	W8028010.088425	0,8	30901	
100408	W8032010.086115	0,8		41001
100408	W8032010.088425	0,8	31001	
110408	W8038010.086115	0,8		41101
110408	W8038010.088425	0,8	31101	
120408	W8042010.086115	0,8		41201
120408	W8042010.088425	0,8	31201	
130508	W8046010.086115	0,8		41301
130508	W8046010.088425	0,8	31301	
Steel			●	●
Stainless steel			●	
Cast iron			●	●
Non ferrous metals				
Heat resistant alloys				
hardened materials				○

→ v_c/f_z Page 40–42

BK6115 -01 is exclusively recommended for use on the peripheral cutting edge!

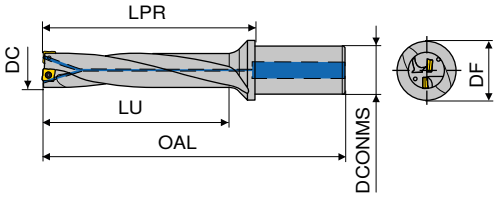
Specialised indexable inserts for machining aluminium or stainless steels (BK7935, BK7710, BK6425) can be found in our online shop at cuttingtools.ceratizit.com

MaxiDrill 900

Scope of supply:
Indexable Insert Drill including clamping screws and key

≤ 2xD

C



Designation	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	Article no. 10 852 ...
MD900.2D.120.R.03-C20	12,0	20	28	90	24	40	0,4	SONT 031804	120
MD900.2D.125.R.03-C20	12,5	20	28	91	25	41	0,4	SONT 031804	125
MD900.2D.130.R.03-C20	13,0	20	28	92	26	42	0,4	SONT 031804	130
MD900.2D.135.R.03-C20	13,5	20	28	93	27	43	0,4	SONT 031804	135
MD900.2D.140.R.04-C20	14,0	20	30	96	28	46	0,7	SONT 042105	140
MD900.2D.145.R.04-C20	14,5	20	30	97	29	47	0,7	SONT 042105	145
MD900.2D.150.R.04-C20	15,0	20	30	98	30	48	0,7	SONT 042105	150
MD900.2D.155.R.04-C20	15,5	20	30	99	31	49	0,7	SONT 042105	155
MD900.2D.160.R.05-C20	16,0	20	30	100	32	50	0,7	SONT 052306	160
MD900.2D.165.R.05-C20	16,5	20	30	101	33	51	0,7	SONT 052306	165
MD900.2D.170.R.05-C20	17,0	20	30	102	34	52	0,7	SONT 052306	170
MD900.2D.175.R.05-C20	17,5	20	30	103	35	53	0,7	SONT 052306	175
MD900.2D.180.R.06-C25	18,0	25	32	111	36	55	1	SONT 062506	180
MD900.2D.185.R.06-C25	18,5	25	32	112	37	56	1	SONT 062506	185
MD900.2D.190.R.06-C25	19,0	25	32	113	38	57	1	SONT 062506	190
MD900.2D.195.R.06-C25	19,5	25	32	114	39	58	1	SONT 062506	195
MD900.2D.200.R.06-C25	20,0	25	32	115	40	59	1	SONT 062506	200
MD900.2D.205.R.06-C25	20,5	25	32	116	41	60	1	SONT 062506	205
MD900.2D.210.R.07-C25	21,0	25	32	118	42	62	1	SONT 072907	210
MD900.2D.220.R.07-C25	22,0	25	32	120	44	64	1	SONT 072907	220
MD900.2D.230.R.07-C25	23,0	25	32	122	46	66	1	SONT 072907	230
MD900.2D.240.R.08-C32	24,0	32	40	132	48	72	1,2	SONT 083308	240
MD900.2D.250.R.08-C32	25,0	32	40	134	50	74	1,2	SONT 083308	250
MD900.2D.260.R.08-C32	26,0	32	40	136	52	76	1,2	SONT 083308	260
MD900.2D.270.R.08-C32	27,0	32	40	138	54	78	1,2	SONT 083308	270
MD900.2D.280.R.09-C32	28,0	32	40	140	56	80	2,2	SONT 093808	280
MD900.2D.290.R.09-C32	29,0	32	40	142	58	82	2,2	SONT 093808	290
MD900.2D.300.R.09-C32	30,0	32	40	144	60	84	2,2	SONT 093808	300
MD900.2D.310.R.09-C32	31,0	32	40	146	62	86	2,2	SONT 093808	310
MD900.2D.320.R.09-C32	32,0	32	40	148	64	88	2,2	SONT 093808	320
MD900.2D.330.R.10-C40	33,0	40	50	163	66	93	3,2	SONT 104408	330
MD900.2D.340.R.10-C40	34,0	40	50	165	68	95	3,2	SONT 104408	340
MD900.2D.350.R.10-C40	35,0	40	50	167	70	97	3,2	SONT 104408	350
MD900.2D.360.R.10-C40	36,0	40	50	169	72	99	3,2	SONT 104408	360
MD900.2D.370.R.12-C40	37,0	40	56	174	74	104	3,2	SONT 124810	370
MD900.2D.380.R.12-C40	38,0	40	56	176	76	106	3,2	SONT 124810	380
MD900.2D.390.R.12-C40	39,0	40	56	178	78	108	3,2	SONT 124810	390
MD900.2D.400.R.12-C40	40,0	40	56	180	80	110	3,2	SONT 124810	400
MD900.2D.410.R.12-C40	41,0	40	56	182	82	112	3,2	SONT 124810	410

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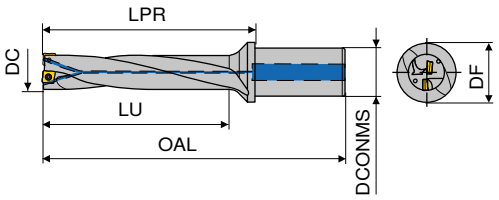
MaxiDrill 900

Scope of supply:
Indexable Insert Drill including clamping screws and key

≤ 2xD

C



Designation	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	Article no. 10 852 ...
MD900.2D.420.R.13-C40	42,0	40	60	187	84	117	5	SONT 135012	**420**
MD900.2D.430.R.13-C40	43,0	40	60	189	86	119	5	SONT 135012	**430**
MD900.2D.440.R.13-C40	44,0	40	60	191	88	121	5	SONT 135012	**440**
MD900.2D.450.R.13-C40	45,0	40	60	193	90	123	5	SONT 135012	**450**
MD900.2D.460.R.13-C40	46,0	40	60	195	92	125	5	SONT 135012	**460**
MD900.2D.470.R.15-C40	47,0	40	60	198	94	128	5	SONT 155312	**470**
MD900.2D.480.R.15-C40	48,0	40	60	200	96	130	5	SONT 155312	**480**
MD900.2D.490.R.15-C40	49,0	40	60	202	98	132	5	SONT 155312	**490**
MD900.2D.500.R.15-C40	50,0	40	60	204	100	134	5	SONT 155312	**500**
MD900.2D.520.R.15-C40	51,0	40	60	206	102	136	5	SONT 155312	**510**
MD900.2D.510.R.15-C40	52,0	40	60	208	104	138	5	SONT 155312	**520**
MD900.2D.530.R.15-C40	53,0	40	60	210	106	140	5	SONT 155312	**530**
MD900.2D.540.R.15-C40	54,0	40	60	212	108	142	5	SONT 155312	**540**
MD900.2D.550.R.17-C40	55,0	40	60	215	110	145	5	SONT 175612	**550**
MD900.2D.560.R.17-C40	56,0	40	60	217	112	147	5	SONT 175612	**560**
MD900.2D.570.R.17-C40	57,0	40	60	219	114	149	5	SONT 175612	**570**
MD900.2D.580.R.17-C40	58,0	40	60	221	116	151	5	SONT 175612	**580**
MD900.2D.590.R.17-C40	59,0	40	60	223	118	153	5	SONT 175612	**590**
MD900.2D.600.R.17-C40	60,0	40	62	225	120	155	5	SONT 175612	**600**
MD900.2D.610.R.17-C40	61,0	40	62	227	122	157	5	SONT 175612	**610**
MD900.2D.620.R.17-C40	62,0	40	64	229	124	159	5	SONT 175612	**620**
MD900.2D.630.R.17-C40	63,0	40	64	231	126	161	5	SONT 175612	**630**

Key D

Clamping screw

Spare parts DC		**Article no. 80 950 ...**		**Article no. 70 950 ...**
12 - 13,5	T06 - IP	**123**	M1,8x3,6 - IP	**862**
14 - 17,5	T06 - IP	**123**	M2x4,3 - IP	**863**
18 - 23	T07 - IP	**124**	M2,2x5 - IP	**856**
24 - 27	T08 - IP	**125**	M2,5x6 - IP	**857**
28 - 32	T09 - IP	**126**	M3x7 - IP	**819**
33 - 41	T15 - IP	**128**	M3,5x8,6 - IP	**859**
42 - 63	T20 - IP	**129**	M4,5x10,5 - IP	**864**

Suitable adapters can be found in → **Chapter 16 Adapters.**

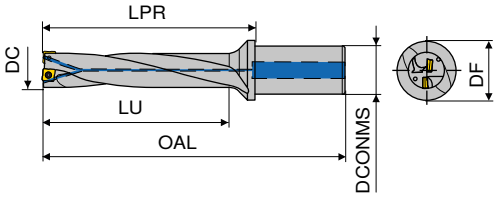
MaxiDrill 900

Scope of supply:

Indexable Insert Drill including clamping screws and key

≤ 3xD

C



Designation	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	Article no. 10 853 ...
MD900.3D.120.R.03-C20	12,0	20	28	102	36,0	52	0,4	SONT 031804	120
MD900.3D.125.R.03-C20	12,5	20	28	104	37,5	54	0,4	SONT 031804	125
MD900.3D.130.R.03-C20	13,0	20	28	105	39,0	55	0,4	SONT 031804	130
MD900.3D.135.R.03-C20	13,5	20	28	107	40,5	57	0,4	SONT 031804	135
MD900.3D.140.R.04-C20	14,0	20	30	109	42,0	59	0,7	SONT 042105	140
MD900.3D.145.R.04-C20	14,5	20	30	111	44,0	61	0,7	SONT 042105	145
MD900.3D.150.R.04-C20	15,0	20	30	112	45,0	62	0,7	SONT 042105	150
MD900.3D.155.R.04-C20	15,5	20	30	114	47,0	64	0,7	SONT 042105	155
MD900.3D.160.R.05-C20	16,0	20	30	115	48,0	65	0,7	SONT 052306	160
MD900.3D.165.R.05-C20	16,5	20	30	117	50,0	67	0,7	SONT 052306	165
MD900.3D.170.R.05-C20	17,0	20	30	118	51,0	68	0,7	SONT 052306	170
MD900.3D.175.R.05-C20	17,5	20	30	120	53,0	70	0,7	SONT 052306	175
MD900.3D.180.R.06-C25	18,0	25	32	128	54,0	72	1	SONT 062506	180
MD900.3D.185.R.06-C25	18,5	25	32	130	56,0	74	1	SONT 062506	185
MD900.3D.190.R.06-C25	19,0	25	32	131	57,0	75	1	SONT 062506	190
MD900.3D.195.R.06-C25	19,5	25	32	133	59,0	77	1	SONT 062506	195
MD900.3D.200.R.06-C25	20,0	25	32	134	60,0	78	1	SONT 062506	200
MD900.3D.205.R.06-C25	20,5	25	32	136	62,0	80	1	SONT 062506	205
MD900.3D.210.R.07-C25	21,0	25	32	138	63,0	82	1	SONT 072907	210
MD900.3D.215.R.07-C25	21,5	25	32	140	65,0	84	1	SONT 072907	215
MD900.3D.220.R.07-C25	22,0	25	32	141	66,0	85	1	SONT 072907	220
MD900.3D.225.R.07-C25	22,5	25	32	143	68,0	87	1	SONT 072907	225
MD900.3D.230.R.07-C25	23,0	25	32	144	69,0	88	1	SONT 072907	230
MD900.3D.235.R.07-C25	23,5	25	32	146	71,0	90	1	SONT 072907	235
MD900.3D.240.R.08-C32	24,0	32	40	155	72,0	95	1,2	SONT 083308	240
MD900.3D.245.R.08-C32	24,5	32	40	157	74,0	97	1,2	SONT 083308	245
MD900.3D.250.R.08-C32	25,0	32	40	158	75,0	98	1,2	SONT 083308	250
MD900.3D.255.R.08-C32	25,5	32	40	160	77,0	100	1,2	SONT 083308	255
MD900.3D.260.R.08-C32	26,0	32	40	161	78,0	101	1,2	SONT 083308	260
MD900.3D.265.R.08-C32	26,5	32	40	163	80,0	103	1,2	SONT 083308	265
MD900.3D.270.R.08-C32	27,0	32	40	164	81,0	104	1,2	SONT 083308	270
MD900.3D.275.R.08-C32	27,5	32	40	166	83,0	106	1,2	SONT 083308	275
MD900.3D.280.R.09-C32	28,0	32	40	167	84,0	107	2,2	SONT 093808	280
MD900.3D.285.R.09-C32	28,5	32	40	169	86,0	109	2,2	SONT 093808	285
MD900.3D.290.R.09-C32	29,0	32	40	170	87,0	110	2,2	SONT 093808	290
MD900.3D.295.R.09-C32	29,5	32	40	172	89,0	112	2,2	SONT 093808	295
MD900.3D.300.R.09-C32	30,0	32	40	173	90,0	113	2,2	SONT 093808	300
MD900.3D.305.R.09-C32	30,5	32	40	175	92,0	115	2,2	SONT 093808	305
MD900.3D.310.R.09-C32	31,0	32	40	176	93,0	116	2,2	SONT 093808	310
MD900.3D.315.R.09-C32	31,5	32	40	178	95,0	118	2,2	SONT 093808	315
MD900.3D.320.R.09-C32	32,0	32	40	179	96,0	119	2,2	SONT 093808	320
MD900.3D.325.R.10-C40	32,5	40	50	192	98,0	124	3,2	SONT 104408	325
MD900.3D.330.R.10-C40	33,0	40	50	193	99,0	125	3,2	SONT 104408	330
MD900.3D.335.R.10-C40	33,5	40	50	195	101,0	127	3,2	SONT 104408	335
MD900.3D.340.R.10-C40	34,0	40	50	196	102,0	128	3,2	SONT 104408	340
MD900.3D.345.R.10-C40	34,5	40	50	198	104,0	130	3,2	SONT 104408	345
MD900.3D.350.R.10-C40	35,0	40	50	199	105,0	131	3,2	SONT 104408	350

Continued on next page

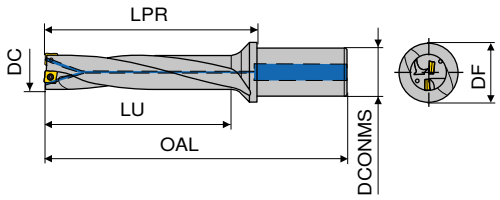
MaxiDrill 900

Scope of supply:

Indexable Insert Drill including clamping screws and key

≤ 3xD

C



3

Designation	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	Article no. 10 853 ...
MD900.3D.355.R.10-C40	35,5	40	50	201	107,0	133	3,2	SONT 104408	355
MD900.3D.360.R.10-C40	36,0	40	50	202	108,0	134	3,2	SONT 104408	360
MD900.3D.365.R.10-C40	36,5	40	50	204	110,0	136	3,2	SONT 104408	365
MD900.3D.370.R.12-C40	37,0	40	56	211	111,0	141	3,2	SONT 124810	370
MD900.3D.380.R.12-C40	38,0	40	56	214	114,0	144	3,2	SONT 124810	380
MD900.3D.390.R.12-C40	39,0	40	56	217	117,0	147	3,2	SONT 124810	390
MD900.3D.400.R.12-C40	40,0	40	56	220	120,0	150	3,2	SONT 124810	400
MD900.3D.410.R.12-C40	41,0	40	56	223	123,0	153	3,2	SONT 124810	410
MD900.3D.420.R.13-C40	42,0	40	60	229	126,0	159	5	SONT 135012	420
MD900.3D.430.R.13-C40	43,0	40	60	232	129,0	162	5	SONT 135012	430
MD900.3D.440.R.13-C40	44,0	40	60	235	132,0	165	5	SONT 135012	440
MD900.3D.450.R.13-C40	45,0	40	60	238	135,0	168	5	SONT 135012	450
MD900.3D.460.R.13-C40	46,0	40	60	241	138,0	171	5	SONT 135012	460
MD900.3D.470.R.15-C40	47,0	40	60	245	141,0	175	5	SONT 155312	470
MD900.3D.480.R.15-C40	48,0	40	60	248	144,0	178	5	SONT 155312	480
MD900.3D.490.R.15-C40	49,0	40	60	251	147,0	181	5	SONT 155312	490
MD900.3D.500.R.15-C40	50,0	40	60	254	150,0	184	5	SONT 155312	500
MD900.3D.510.R.15-C40	51,0	40	60	257	153,0	187	5	SONT 155312	510
MD900.3D.520.R.15-C40	52,0	40	60	260	156,0	190	5	SONT 155312	520
MD900.3D.530.R.15-C40	53,0	40	60	263	159,0	193	5	SONT 155312	530
MD900.3D.540.R.15-C40	54,0	40	60	266	162,0	196	5	SONT 155312	540
MD900.3D.550.R.17-C40	55,0	40	60	270	165,0	200	5	SONT 175612	550
MD900.3D.560.R.17-C40	56,0	40	60	273	168,0	203	5	SONT 175612	560
MD900.3D.570.R.17-C40	57,0	40	60	276	171,0	206	5	SONT 175612	570
MD900.3D.580.R.17-C40	58,0	40	60	279	174,0	209	5	SONT 175612	580
MD900.3D.590.R.17-C40	59,0	40	60	282	177,0	212	5	SONT 175612	590
MD900.3D.600.R.17-C40	60,0	40	62	285	180,0	215	5	SONT 175612	600
MD900.3D.610.R.17-C40	61,0	40	62	288	183,0	218	5	SONT 175612	610
MD900.3D.620.R.17-C40	62,0	40	64	291	186,0	221	5	SONT 175612	620
MD900.3D.630.R.17-C40	63,0	40	64	294	189,0	224	5	SONT 175612	630

Key D

Clamping screw

Spare parts DC	Article no. 80 950 ...		Article no. 70 950 ...	
12 - 13,5	T06 - IP	123	M1,8x3,6 - IP	862
14 - 17,5	T06 - IP	123	M2x4,3 - IP	863
18 - 23,5	T07 - IP	124	M2,2x5 - IP	856
24 - 27,5	T08 - IP	125	M2,5x6 - IP	857
28 - 32	T09 - IP	126	M3x7 - IP	819
32,5 - 41	T15 - IP	128	M3,5x8,6 - IP	859
42 - 63	T20 - IP	129	M4,5x10,5 - IP	864

Suitable adapters can be found in → **Chapter 16 Adapters.**

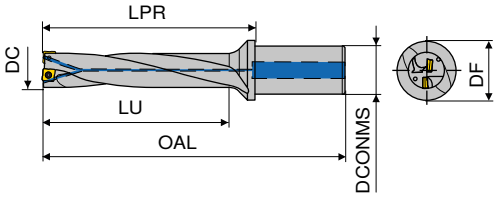
MaxiDrill 900

Scope of supply:

Indexable Insert Drill including clamping screws and key

≤ 4xD

C



Designation	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	Article no. 10 854 ...
MD900.4D.120.R.03-C20	12,0	20	28	114	48	64	0,4	SONT 031804	120
MD900.4D.125.R.03-C20	12,5	20	28	116	50	66	0,4	SONT 031804	125
MD900.4D.130.R.03-C20	13,0	20	28	118	52	68	0,4	SONT 031804	130
MD900.4D.135.R.03-C20	13,5	20	28	120	54	70	0,4	SONT 031804	135
MD900.4D.140.R.04-C20	14,0	20	30	123	56	73	0,7	SONT 042105	140
MD900.4D.145.R.04-C20	14,5	20	30	125	58	75	0,7	SONT 042105	145
MD900.4D.150.R.04-C20	15,0	20	30	127	60	77	0,7	SONT 042105	150
MD900.4D.155.R.04-C20	15,5	20	30	129	62	79	0,7	SONT 042105	155
MD900.4D.160.R.05-C20	16,0	20	30	131	64	81	0,7	SONT 052306	160
MD900.4D.165.R.05-C20	16,5	20	30	133	66	83	0,7	SONT 052306	165
MD900.4D.170.R.05-C20	17,0	20	30	135	68	85	0,7	SONT 052306	170
MD900.4D.175.R.05-C20	17,5	20	30	137	70	87	0,7	SONT 052306	175
MD900.4D.180.R.06-C25	18,0	25	32	146	72	90	1	SONT 062506	180
MD900.4D.185.R.06-C25	18,5	25	32	148	74	92	1	SONT 062506	185
MD900.4D.190.R.06-C25	19,0	25	32	150	76	94	1	SONT 062506	190
MD900.4D.195.R.06-C25	19,5	25	32	152	78	96	1	SONT 062506	195
MD900.4D.200.R.06-C25	20,0	25	32	154	80	98	1	SONT 062506	200
MD900.4D.205.R.06-C25	20,5	25	32	156	82	100	1	SONT 062506	205
MD900.4D.210.R.07-C25	21,0	25	32	159	84	103	1	SONT 072907	210
MD900.4D.220.R.07-C25	22,0	25	32	163	88	107	1	SONT 072907	220
MD900.4D.230.R.07-C25	23,0	25	32	167	92	111	1	SONT 072907	230
MD900.4D.240.R.08-C32	24,0	32	40	179	96	119	1,2	SONT 083308	240
MD900.4D.250.R.08-C32	25,0	32	40	183	100	123	1,2	SONT 083308	250
MD900.4D.260.R.08-C32	26,0	32	40	187	104	127	1,2	SONT 083308	260
MD900.4D.270.R.08-C32	27,0	32	40	191	108	131	1,2	SONT 083308	270
MD900.4D.280.R.09-C32	28,0	32	40	195	112	135	2,2	SONT 093808	280
MD900.4D.290.R.09-C32	29,0	32	40	199	116	139	2,2	SONT 093808	290
MD900.4D.300.R.09-C32	30,0	32	40	203	120	143	2,2	SONT 093808	300
MD900.4D.310.R.09-C32	31,0	32	40	207	124	147	2,2	SONT 093808	310
MD900.4D.320.R.09-C32	32,0	32	40	211	128	151	2,2	SONT 093808	320
MD900.4D.330.R.10-C40	33,0	40	50	228	132	158	3,2	SONT 104408	330
MD900.4D.340.R.10-C40	34,0	40	50	232	136	162	3,2	SONT 104408	340
MD900.4D.350.R.10-C40	35,0	40	50	236	140	166	3,2	SONT 104408	350
MD900.4D.360.R.10-C40	36,0	40	50	240	144	170	3,2	SONT 104408	360
MD900.4D.370.R.12-C40	37,0	40	56	248	148	178	3,2	SONT 124810	370
MD900.4D.380.R.12-C40	38,0	40	56	252	152	182	3,2	SONT 124810	380
MD900.4D.390.R.12-C40	39,0	40	56	256	156	186	3,2	SONT 124810	390
MD900.4D.400.R.12-C40	40,0	40	56	260	160	190	3,2	SONT 124810	400
MD900.4D.410.R.12-C40	41,0	40	56	264	164	194	3,2	SONT 124810	410

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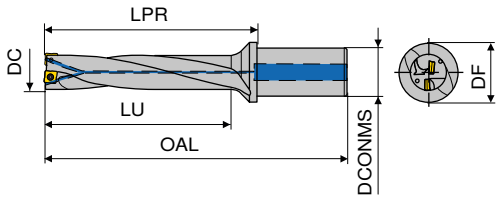
MaxiDrill 900

Scope of supply:
Indexable Insert Drill including clamping screws and key

≤ 4xD

C



Designation	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	Article no. 10 854 ...
MD900.4D.420.R.13-C40	42,0	40	60	271	168	201	5	SONT 135012	420
MD900.4D.430.R.13-C40	43,0	40	60	275	172	205	5	SONT 135012	430
MD900.4D.440.R.13-C40	44,0	40	60	279	176	209	5	SONT 135012	440
MD900.4D.450.R.13-C40	45,0	40	60	283	180	213	5	SONT 135012	450
MD900.4D.460.R.13-C40	46,0	40	60	287	184	217	5	SONT 135012	460
MD900.4D.470.R.15-C40	47,0	40	60	292	188	222	5	SONT 155312	470
MD900.4D.480.R.15-C40	48,0	40	60	296	192	226	5	SONT 155312	480
MD900.4D.490.R.15-C40	49,0	40	60	300	196	230	5	SONT 155312	490
MD900.4D.500.R.15-C40	50,0	40	60	304	200	234	5	SONT 155312	500
MD900.4D.510.R.15-C40	51,0	40	60	308	204	238	5	SONT 155312	510
MD900.4D.520.R.15-C40	52,0	40	60	312	208	242	5	SONT 155312	520
MD900.4D.530.R.15-C40	53,0	40	60	316	212	246	5	SONT 155312	530
MD900.4D.540.R.15-C40	54,0	40	60	320	216	250	5	SONT 155312	540

Key D

Clamping screw

Spare parts DC		Article no. 80 950 ...		Article no. 70 950 ...
12 - 13	T06 - IP	123	M1,8x3,6 - IP	862
14 - 17	T06 - IP	123	M2x4,3 - IP	863
18 - 23	T07 - IP	124	M2,2x5 - IP	856
24 - 27	T08 - IP	125	M2,5x6 - IP	857
28 - 32	T09 - IP	126	M3x7 - IP	819
33 - 41	T15 - IP	128	M3,5x8,6 - IP	859
42 - 54	T20 - IP	129	M4,5x10,5 - IP	864

Suitable adapters can be found in → **Chapter 16 Adapters.**

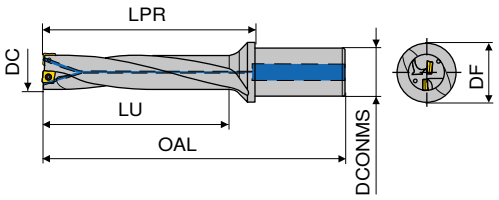
MaxiDrill 900

Scope of supply:

Indexable Insert Drill including clamping screws and key

≤ 5xD

C



Designation	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	Article no. 10 855 ...
MD900.5D.120.R.03-C20	12,0	20	28	126	60,0	76,0	0,4	SONT 031804	120
MD900.5D.125.R.03-C20	12,5	20	28	128	62,5	78,0	0,4	SONT 031804	125
MD900.5D.130.R.03-C20	13,0	20	28	131	65,0	81,0	0,4	SONT 031804	130
MD900.5D.135.R.03-C20	13,5	20	28	132	67,5	82,0	0,4	SONT 031804	135
MD900.5D.140.R.04-C20	14,0	20	30	137	70,0	87,0	0,7	SONT 042105	140
MD900.5D.145.R.04-C20	14,5	20	30	139	72,5	89,0	0,7	SONT 042105	145
MD900.5D.150.R.04-C20	15,0	20	30	142	75,0	92,0	0,7	SONT 042105	150
MD900.5D.155.R.04-C20	15,5	20	30	144	77,5	94,5	0,7	SONT 042105	155
MD900.5D.160.R.05-C20	16,0	20	30	147	80,0	97,0	0,7	SONT 052306	160
MD900.5D.165.R.05-C20	16,5	20	30	149	82,5	99,0	0,7	SONT 052306	165
MD900.5D.170.R.05-C20	17,0	20	30	152	85,0	102,0	0,7	SONT 052306	170
MD900.5D.175.R.05-C20	17,5	20	30	154	87,5	104,0	0,7	SONT 052306	175
MD900.5D.180.R.06-C25	18,0	25	32	164	90,0	108,0	1	SONT 062506	180
MD900.5D.185.R.06-C25	18,5	25	32	166	92,5	110,0	1	SONT 062506	185
MD900.5D.190.R.06-C25	19,0	25	32	169	95,0	113,0	1	SONT 062506	190
MD900.5D.195.R.06-C25	19,5	25	32	171	97,5	115,0	1	SONT 062506	195
MD900.5D.200.R.06-C25	20,0	25	32	174	100,0	118,0	1	SONT 062506	200
MD900.5D.205.R.06-C25	20,5	25	32	175	102,5	119,0	1	SONT 062506	205
MD900.5D.210.R.07-C25	21,0	25	32	180	105,0	124,0	1	SONT 072907	210
MD900.5D.220.R.07-C25	22,0	25	32	184	110,0	128,0	1	SONT 072907	220
MD900.5D.230.R.07-C25	23,0	25	32	189	115,0	133,0	1	SONT 072907	230
MD900.5D.240.R.08-C32	24,0	32	40	203	120,0	143,0	1,2	SONT 083308	240
MD900.5D.250.R.08-C32	25,0	32	40	208	125,0	148,0	1,2	SONT 083308	250
MD900.5D.260.R.08-C32	26,0	32	40	212	130,0	152,0	1,2	SONT 083308	260
MD900.5D.270.R.08-C32	27,0	32	40	217	135,0	157,0	1,2	SONT 083308	270
MD900.5D.280.R.09-C32	28,0	32	40	221	140,0	161,0	2,2	SONT 093808	280
MD900.5D.290.R.09-C32	29,0	32	40	226	145,0	166,0	2,2	SONT 093808	290
MD900.5D.300.R.09-C32	30,0	32	40	230	150,0	170,0	2,2	SONT 093808	300
MD900.5D.310.R.09-C32	31,0	32	40	235	155,0	175,0	2,2	SONT 093808	310
MD900.5D.320.R.09-C32	32,0	32	40	239	160,0	179,0	2,2	SONT 093808	320
MD900.5D.330.R.10-C40	33,0	40	50	259	165,0	191,0	3,2	SONT 104408	330
MD900.5D.340.R.10-C40	34,0	40	50	264	170,0	196,0	3,2	SONT 104408	340
MD900.5D.350.R.10-C40	35,0	40	50	269	175,0	201,0	3,2	SONT 104408	350
MD900.5D.360.R.10-C40	36,0	40	50	274	180,0	206,0	3,2	SONT 104408	360
MD900.5D.370.R.12-C40	37,0	40	56	285	185,0	215,0	3,2	SONT 124810	370
MD900.5D.380.R.12-C40	38,0	40	56	290	190,0	220,0	3,2	SONT 124810	380
MD900.5D.390.R.12-C40	39,0	40	56	295	195,0	225,0	3,2	SONT 124810	390
MD900.5D.400.R.12-C40	40,0	40	56	300	200,0	230,0	3,2	SONT 124810	400
MD900.5D.410.R.12-C40	41,0	40	56	305	205,0	235,0	3,2	SONT 124810	410

Key D

Clamping screw

Spare parts DC		Article no. 80 950 ...		Article no. 70 950 ...
12 - 13	T06 - IP	123	M1,8x3,6 - IP	862
14 - 17	T06 - IP	123	M2x4,3 - IP	863
18 - 23	T07 - IP	124	M2,2x5 - IP	856
24 - 27	T08 - IP	125	M2,5x6 - IP	857
28 - 32	T09 - IP	126	M3x7 - IP	819
33 - 41	T15 - IP	128	M3,5x8,6 - IP	859

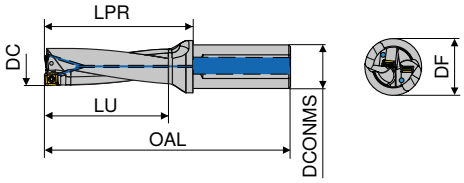
Suitable adapters can be found in → **Chapter 16 Adapters.**

KUB 100

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 3xD

C



Designation	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 881 ...
KUB-100.3D.140.R.04-C20	14,0	20	30	105	42	55	0,7	SONT 042105	99140
KUB-100.3D.150.R.04-C20	15,0	20	30	109	45	59	0,7	SONT 042105	99150
KUB-100.3D.160.R.05-C20	16,0	20	30	114	48	64	0,7	SONT 052306	99160
KUB-100.3D.165.R.05-C20	16,5	20	30	118	51	68	0,7	SONT 052306	99165
KUB-100.3D.170.R.05-C20	17,0	20	30	118	51	68	0,7	SONT 052306	99170
KUB-100.3D.175.R.05-C25	17,5	25	30	127	54	71	0,7	SONT 052306	99175
KUB-100.3D.180.R.06-C25	18,0	25	30	127	54	71	1	SONT 062506	99180
KUB-100.3D.185.R.06-C25	18,5	25	30	131	57	75	1	SONT 062506	99185
KUB-100.3D.190.R.06-C25	19,0	25	30	131	57	75	1	SONT 062506	99190
KUB-100.3D.195.R.06-C25	19,5	25	30	134	60	78	1	SONT 062506	99195
KUB-100.3D.200.R.06-C25	20,0	25	30	134	60	78	1	SONT 062506	99200
KUB-100.3D.210.R.07-C25	21,0	25	30	138	63	82	1	SONT 072907	99210
KUB-100.3D.220.R.07-C25	22,0	25	30	141	66	85	1	SONT 072907	99220
KUB-100.3D.230.R.07-C25	23,0	25	30	145	69	89	1	SONT 072907	99230
KUB-100.3D.240.R.08-C32	24,0	32	39	152	72	92	1,2	SONT 083308	99240
KUB-100.3D.250.R.08-C32	25,0	32	39	156	75	96	1,2	SONT 083308	99250
KUB-100.3D.260.R.08-C32	26,0	32	39	159	78	99	1,2	SONT 083308	99260
KUB-100.3D.270.R.08-C32	27,0	32	39	163	81	103	1,2	SONT 083308	99270

Key D

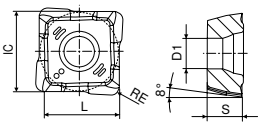
Clamping screw

Spare parts DC	Article no. 80 950 ...		Article no. 70 950 ...	
14 - 17,5	T06 - IP	123	M2x4,3 - IP	863
18 - 23	T07 - IP	124	M2,2x5 - IP	856
24 - 27	T08 - IP	125	M2,5x6 - IP	857

Suitable adapters can be found in → **Chapter 16 Adapters.**

SONT

Designation	IC	D1	L	S
	mm	mm	mm	mm
SONT 0318..	5,4	2,10	3,8	1,80
SONT 0421..	4,6	2,25	4,2	2,10
SONT 0523..	5,3	2,25	4,8	2,30
SONT 0625..	5,9	2,50	5,5	2,50
SONT 0729..	6,5	2,50	6,1	2,90
SONT 0833..	7,7	2,90	7,3	3,30
SONT 0938..	8,9	3,50	8,5	3,80
SONT 1044..	10,1	4,10	9,6	4,40
SONT 1248..	11,6	4,10	11,0	4,80
SONT 1350..	13,0	5,30	12,2	5,00
SONT 1553..	15,2	5,30	14,4	5,30
SONT 1756..	17,5	5,30	16,7	5,60



SONT

	-M30 CTPP430	-M30 CTPP430	-M30 CTCP420	-M30 CTCP420
	-M30 CCN1430	-M30 CCN1430	-M30 DCX1420	-M30 DCX1420
	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN	DRAGONSKIN
	SONT	SONT	SONT	SONT
ISO	RE	Article no. 10 830 ...	Article no. 10 830 ...	Article no. 10 830 ...	Article no. 10 830 ...
	mm				
031804	0,4	103 [1]		703 [1]	
042105	0,5		104		704
052306	0,6		105		705
062506	0,6		106		706
072907	0,7		107		707
083308	0,8		108		708
093808	0,8		109		709
104408	0,8		110		710
124810	1,0		112		712
135012	1,2		113		713
155312	1,2		115		715
175612	1,2		117		717
Steel		●	●	●	●
Stainless steel		●	●	○	○
Cast iron		○	○	●	●
Non ferrous metals		○	○		
Heat resistant alloys		○	○		
hardened materials					

1) two usable cutting edges

→ v_c/f_z Page 43–46

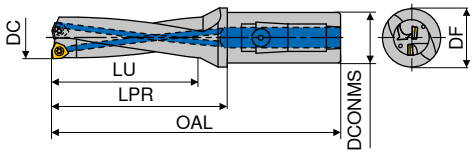
CTCP420 -M30 (DCX1420) is exclusively recommended for use on the peripheral cutting edge!

KUB Trigon

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 2xD

K



Designation	KOMET no.	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 892 ...
KUB-T.2D.140.R.03-K20	V4331404	14	20	30	102	28	52	0,62	WOEX 030204	**14011**
KUB-T.2D.150.R.03-K20	V4331504	15	20	30	104	30	54	0,62	WOEX 030204	**15011**
KUB-T.2D.160.R.03-K20	V4331602	16	20	30	106	32	56	0,62	WOEX 030204	**16011**
KUB-T.2D.170.R.03-K20	V4331702	17	20	30	108	34	58	0,62	WOEX 030204	**17011**
KUB-T.2D.180.R.03-K20	V4331802	18	20	30	110	36	60	0,62	WOEX 030204	**18011**
KUB-T.2D.190.R.03-K20	V4331902	19	20	30	112	38	62	0,62	WOEX 030204	**19011**
KUB-T.2D.200.R.04-K25	V4432002	20	25	30	120	40	64	1,01	WOEX 040304	**20012**
KUB-T.2D.210.R.04-K25	V4432102	21	25	30	122	42	66	1,01	WOEX 040304	**21012**
KUB-T.2D.220.R.04-K25	V4432202	22	25	30	124	44	68	1,01	WOEX 040304	**22012**
KUB-T.2D.230.R.04-K25	V4432302	23	25	30	126	46	70	1,01	WOEX 040304	**23012**
KUB-T.2D.240.R.04-K25	V4432402	24	25	30	128	48	72	1,01	WOEX 040304	**24012**
KUB-T.2D.250.R.05-K32	V4532502	25	32	39	134	50	74	1,28	WOEX 05T304	**25013**
KUB-T.2D.260.R.05-K32	V4532602	26	32	39	136	52	76	1,28	WOEX 05T304	**26013**
KUB-T.2D.270.R.05-K32	V4532702	27	32	39	138	54	78	1,28	WOEX 05T304	**27013**
KUB-T.2D.280.R.05-K32	V4532802	28	32	39	140	56	80	1,28	WOEX 05T304	**28013**
KUB-T.2D.290.R.05-K32	V4532902	29	32	39	142	58	82	1,28	WOEX 05T304	**29013**
KUB-T.2D.300.R.05-K32	V4533002	30	32	39	149	60	89	1,28	WOEX 05T304	**30013**
KUB-T.2D.310.R.05-K32	V4533102	31	32	39	151	62	91	1,28	WOEX 05T304	**31013**
KUB-T.2D.320.R.05-K32	V4533202	32	32	39	153	64	93	1,28	WOEX 05T304	**32013**
KUB-T.2D.330.R.05-K32	V4533302	33	32	39	155	66	95	1,28	WOEX 05T304	**33013**
KUB-T.2D.340.R.05-K32	V4533402	34	32	39	157	68	97	1,28	WOEX 05T304	**34013**
KUB-T.2D.350.R.05-K32	V4533502	35	32	39	159	70	99	1,28	WOEX 05T304	**35013**
KUB-T.2D.360.R.05-K32	V4533602	36	32	39	161	72	101	1,28	WOEX 05T304	**36013**
KUB-T.2D.370.R.06-K32	V4533702	37	32	39	173	74	113	2,8	WOEX 06T304	**37013**
KUB-T.2D.380.R.06-K32	V4533802	38	32	39	175	76	115	2,8	WOEX 06T304	**38013**
KUB-T.2D.390.R.06-K32	V4533902	39	32	39	177	78	117	2,8	WOEX 06T304	**39013**
KUB-T.2D.400.R.06-K32	V4534002	40	32	39	179	80	119	2,8	WOEX 06T304	**40013**
KUB-T.2D.410.R.06-K32	V4534102	41	32	39	181	82	121	2,8	WOEX 06T304	**41013**
KUB-T.2D.420.R.06-K32	V4534202	42	32	39	183	84	123	2,8	WOEX 06T304	**42013**
KUB-T.2D.430.R.06-K32	V4534302	43	32	39	185	86	125	2,8	WOEX 06T304	**43013**
KUB-T.2D.440.R.06-K32	V4534402	44	32	39	187	88	127	2,8	WOEX 06T304	**44013**

Key D

Clamping screw

Spare parts DC	Article no. 80 950 ...		Article no. 10 950 ...	
14 - 19	T06 - IP	**123**	M2,0x4,3 - 06IP	**10000**
20 - 24	T06 - IP	**123**	M2,2x5,5 - 06IP	**10700**
25 - 36	T08 - IP	**125**	M2,5x7,2 - 10IP	**10500**
37 - 44	T10 - IP	**127**	M3,5x7,3 - 10IP	**10600**

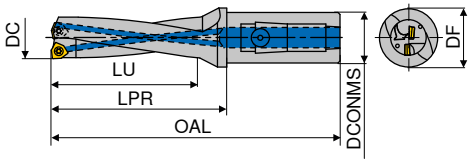
Suitable adapters can be found in → **Chapter 16 Adapters.**

KUB Trigon

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 3xD

K



Designation	KOMET no.	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 893 ...
KUB-T.3D.140.R.03-K20	V4371404	14	20	30	116	42	66	0,62	WOEX 030204	14011
KUB-T.3D.150.R.03-K20	V4371504	15	20	30	119	45	69	0,62	WOEX 030204	15011
KUB-T.3D.160.R.03-K20	V4371602	16	20	30	122	48	72	0,62	WOEX 030204	16011
KUB-T.3D.170.R.03-K20	V4371702	17	20	30	125	51	75	0,62	WOEX 030204	17011
KUB-T.3D.180.R.03-K20	V4371802	18	20	30	128	54	78	0,62	WOEX 030204	18011
KUB-T.3D.190.R.03-K20	V4371902	19	20	30	131	57	81	0,62	WOEX 030204	19011
KUB-T.3D.200.R.04-K25	V4472002	20	25	30	140	60	84	1,01	WOEX 040304	20012
KUB-T.3D.210.R.04-K25	V4472102	21	25	30	143	63	87	1,01	WOEX 040304	21012
KUB-T.3D.220.R.04-K25	V4472202	22	25	30	146	66	90	1,01	WOEX 040304	22012
KUB-T.3D.230.R.04-K25	V4472302	23	25	30	149	69	93	1,01	WOEX 040304	23012
KUB-T.3D.240.R.04-K25	V4472402	24	25	30	152	72	96	1,01	WOEX 040304	24012
KUB-T.3D.250.R.05-K32	V4572502	25	32	39	159	75	99	1,28	WOEX 05T304	25013
KUB-T.3D.260.R.05-K32	V4572602	26	32	39	162	78	102	1,28	WOEX 05T304	26013
KUB-T.3D.270.R.05-K32	V4572702	27	32	39	165	81	105	1,28	WOEX 05T304	27013
KUB-T.3D.280.R.05-K32	V4572802	28	32	39	168	84	108	1,28	WOEX 05T304	28013
KUB-T.3D.290.R.05-K32	V4572902	29	32	39	171	87	111	1,28	WOEX 05T304	29013
KUB-T.3D.300.R.05-K32	V4573002	30	32	39	179	90	119	1,28	WOEX 05T304	30013
KUB-T.3D.310.R.05-K32	V4573102	31	32	39	182	93	122	1,28	WOEX 05T304	31013
KUB-T.3D.320.R.05-K32	V4573202	32	32	39	185	96	125	1,28	WOEX 05T304	32013
KUB-T.3D.330.R.05-K32	V4573302	33	32	39	188	99	128	1,28	WOEX 05T304	33013
KUB-T.3D.340.R.05-K32	V4573402	34	32	39	191	102	131	1,28	WOEX 05T304	34013
KUB-T.3D.350.R.05-K32	V4573502	35	32	39	194	105	134	1,28	WOEX 05T304	35013
KUB-T.3D.360.R.05-K32	V4573602	36	32	39	197	108	137	1,28	WOEX 05T304	36013
KUB-T.3D.370.R.06-K32	V4573702	37	32	39	210	111	150	2,8	WOEX 06T304	37013
KUB-T.3D.380.R.06-K32	V4573802	38	32	39	213	114	153	2,8	WOEX 06T304	38013
KUB-T.3D.390.R.06-K32	V4573902	39	32	39	216	117	156	2,8	WOEX 06T304	39013
KUB-T.3D.400.R.06-K32	V4574002	40	32	39	219	120	159	2,8	WOEX 06T304	40013
KUB-T.3D.410.R.06-K32	V4574102	41	32	39	222	123	162	2,8	WOEX 06T304	41013
KUB-T.3D.420.R.06-K32	V4574202	42	32	39	225	126	165	2,8	WOEX 06T304	42013
KUB-T.3D.430.R.06-K32	V4574302	43	32	39	228	129	168	2,8	WOEX 06T304	43013
KUB-T.3D.440.R.06-K32	V4574402	44	32	39	231	132	171	2,8	WOEX 06T304	44013

Key D

Clamping screw

Spare parts DC	Article no. 80 950 ...		Article no. 10 950 ...	
14 - 19	T06 - IP	123	M2,0x4,3 - 06IP	10000
20 - 24	T06 - IP	123	M2,2x5,5 - 06IP	10700
25 - 36	T08 - IP	125	M2,5x7,2 - 10IP	10500
37 - 44	T10 - IP	127	M3,5x7,3 - 10IP	10600

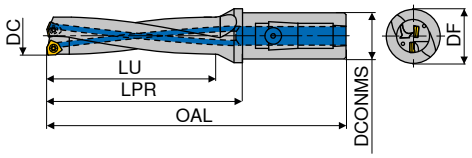
Suitable adapters can be found in → **Chapter 16 Adapters.**

KUB Trigon

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 4xD

K



Designation	KOMET no.	DC mm	DCONMS mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 894 ...
KUB-T.4D.140.R.03-K20	V4391404	14	20	30	130	56	80	0,62	WOEX 030204	**14011**
KUB-T.4D.150.R.03-K20	V4391504	15	20	30	134	60	84	0,62	WOEX 030204	**15011**
KUB-T.4D.160.R.03-K20	V4391602	16	20	30	138	64	88	0,62	WOEX 030204	**16011**
KUB-T.4D.170.R.03-K20	V4391702	17	20	30	142	68	92	0,62	WOEX 030204	**17011**
KUB-T.4D.180.R.03-K20	V4391802	18	20	30	146	72	96	0,62	WOEX 030204	**18011**
KUB-T.4D.190.R.03-K20	V4391902	19	20	30	150	76	100	0,62	WOEX 030204	**19011**
KUB-T.4D.200.R.04-K25	V4492002	20	25	30	160	80	104	1,01	WOEX 040304	**20012**
KUB-T.4D.210.R.04-K25	V4492102	21	25	30	164	84	108	1,01	WOEX 040304	**21012**
KUB-T.4D.220.R.04-K25	V4492202	22	25	30	168	88	112	1,01	WOEX 040304	**22012**
KUB-T.4D.230.R.04-K25	V4492302	23	25	30	172	92	116	1,01	WOEX 040304	**23012**
KUB-T.4D.240.R.04-K25	V4492402	24	25	30	176	96	120	1,01	WOEX 040304	**24012**
KUB-T.4D.250.R.05-K32	V4592502	25	32	39	184	100	124	1,28	WOEX 05T304	**25013**
KUB-T.4D.260.R.05-K32	V4592602	26	32	39	188	104	128	1,28	WOEX 05T304	**26013**
KUB-T.4D.270.R.05-K32	V4592702	27	32	39	192	108	132	1,28	WOEX 05T304	**27013**
KUB-T.4D.280.R.05-K32	V4592802	28	32	39	196	112	136	1,28	WOEX 05T304	**28013**
KUB-T.4D.290.R.05-K32	V4592902	29	32	39	200	116	140	1,28	WOEX 05T304	**29013**
KUB-T.4D.300.R.05-K32	V4593002	30	32	39	209	120	149	1,28	WOEX 05T304	**30013**
KUB-T.4D.310.R.05-K32	V4593102	31	32	39	213	124	153	1,28	WOEX 05T304	**31013**
KUB-T.4D.320.R.05-K32	V4593202	32	32	39	217	128	157	1,28	WOEX 05T304	**32013**
KUB-T.4D.330.R.05-K32	V4593302	33	32	39	221	132	161	1,28	WOEX 05T304	**33013**
KUB-T.4D.340.R.05-K32	V4593402	34	32	39	225	136	165	1,28	WOEX 05T304	**34013**
KUB-T.4D.350.R.05-K32	V4593502	35	32	39	229	140	169	1,28	WOEX 05T304	**35013**

Key D

Clamping screw

Spare parts DC		Article no. 80 950 ...		Article no. 10 950 ...
14 - 19	T06 - IP	**123**	M2,0x4,3 - 06IP	**10000**
20 - 24	T06 - IP	**123**	M2,2x5,5 - 06IP	**10700**
25 - 35	T08 - IP	**125**	M2,5x7,2 - 10IP	**10500**

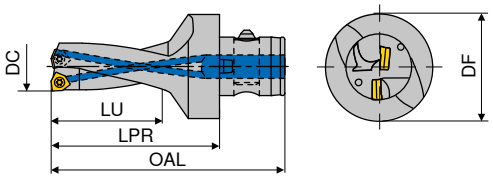
Suitable adapters can be found in → **Chapter 16 Adapters.**

KUB Trigon

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 2xD

ABS



Designation	KOMET no.	DC mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 892 ...
KUB-T.2D.140.R.03-ABS50	V3031403	14	50	94	28	63	0,62	WOEX 030204	14095
KUB-T.2D.150.R.03-ABS50	V3031503	15	50	96	30	65	0,62	WOEX 030204	15095
KUB-T.2D.160.R.03-ABS50	V3031601	16	50	98	32	67	0,62	WOEX 030204	16095
KUB-T.2D.170.R.03-ABS50	V3031701	17	50	100	34	69	0,62	WOEX 030204	17095
KUB-T.2D.180.R.03-ABS50	V3031801	18	50	102	36	71	0,62	WOEX 030204	18095
KUB-T.2D.190.R.03-ABS50	V3031901	19	50	104	38	73	0,62	WOEX 030204	19095
KUB-T.2D.200.R.04-ABS50	V3032001	20	50	106	40	75	1,01	WOEX 040304	20095
KUB-T.2D.210.R.04-ABS50	V3032101	21	50	108	42	77	1,01	WOEX 040304	21095
KUB-T.2D.220.R.04-ABS50	V3032201	22	50	110	44	79	1,01	WOEX 040304	22095
KUB-T.2D.230.R.04-ABS50	V3032301	23	50	112	46	81	1,01	WOEX 040304	23095
KUB-T.2D.240.R.04-ABS50	V3032401	24	50	114	48	83	1,01	WOEX 040304	24095
KUB-T.2D.250.R.05-ABS50	V3032501	25	50	116	50	85	1,28	WOEX 05T304	25095
KUB-T.2D.260.R.05-ABS50	V3032601	26	50	118	52	87	1,28	WOEX 05T304	26095
KUB-T.2D.270.R.05-ABS50	V3032701	27	50	120	54	89	1,28	WOEX 05T304	27095
KUB-T.2D.280.R.05-ABS50	V3032801	28	50	122	56	91	1,28	WOEX 05T304	28095
KUB-T.2D.290.R.05-ABS50	V3032901	29	50	124	58	93	1,28	WOEX 05T304	29095
KUB-T.2D.300.R.05-ABS50	V3033001	30	50	131	60	100	1,28	WOEX 05T304	30095
KUB-T.2D.310.R.05-ABS50	V3033101	31	50	133	62	102	1,28	WOEX 05T304	31095
KUB-T.2D.320.R.05-ABS50	V3033201	32	50	135	64	104	1,28	WOEX 05T304	32095
KUB-T.2D.330.R.05-ABS50	V3033301	33	50	137	66	106	1,28	WOEX 05T304	33095
KUB-T.2D.340.R.05-ABS50	V3033401	34	50	139	68	108	1,28	WOEX 05T304	34095
KUB-T.2D.350.R.05-ABS50	V3033501	35	50	141	70	110	1,28	WOEX 05T304	35095
KUB-T.2D.360.R.05-ABS50	V3033601	36	50	143	72	112	1,28	WOEX 05T304	36095
KUB-T.2D.370.R.06-ABS50	V3033701	37	50	155	74	124	2,8	WOEX 06T304	37095
KUB-T.2D.380.R.06-ABS50	V3033801	38	50	157	76	126	2,8	WOEX 06T304	38095
KUB-T.2D.390.R.06-ABS50	V3033901	39	50	159	78	128	2,8	WOEX 06T304	39095
KUB-T.2D.400.R.06-ABS50	V3034001	40	50	161	80	130	2,8	WOEX 06T304	40095
KUB-T.2D.410.R.06-ABS50	V3034101	41	50	163	82	132	2,8	WOEX 06T304	41095
KUB-T.2D.420.R.06-ABS50	V3034201	42	50	165	84	134	2,8	WOEX 06T304	42095
KUB-T.2D.430.R.06-ABS50	V3034301	43	50	167	86	136	2,8	WOEX 06T304	43095
KUB-T.2D.440.R.06-ABS50	V3034401	44	50	169	88	138	2,8	WOEX 06T304	44095

Key D

Clamping screw

Spare parts DC	Article no. 80 950 ...		Article no. 10 950 ...	
14 - 19	T06 - IP	123	M2,0x4,3 - 06IP	10000
20 - 24	T06 - IP	123	M2,2x5,5 - 06IP	10700
25 - 36	T08 - IP	125	M2,5x7,2 - 10IP	10500
37 - 44	T10 - IP	127	M3,5x7,3 - 10IP	10600

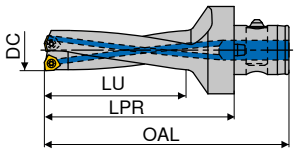
Suitable adapters can be found in → **Chapter 16 Adapters.**

KUB Trigon

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 3xD

ABS



Designation	KOMET no.	DC mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 893 ...
KUB-T.3D.140.R.03-ABS50	V3071403	14	50	108	42	77	0,62	WOEX 030204	14095
KUB-T.3D.150.R.03-ABS50	V3071503	15	50	111	45	80	0,62	WOEX 030204	15095
KUB-T.3D.160.R.03-ABS50	V3071601	16	50	114	48	83	0,62	WOEX 030204	16095
KUB-T.3D.170.R.03-ABS50	V3071701	17	50	117	51	86	0,62	WOEX 030204	17095
KUB-T.3D.180.R.03-ABS50	V3071801	18	50	120	54	89	0,62	WOEX 030204	18095
KUB-T.3D.190.R.03-ABS50	V3071901	19	50	123	57	92	0,62	WOEX 030204	19095
KUB-T.3D.200.R.04-ABS50	V3072001	20	50	126	60	95	1,01	WOEX 040304	20095
KUB-T.3D.210.R.04-ABS50	V3072101	21	50	129	63	98	1,01	WOEX 040304	21095
KUB-T.3D.220.R.04-ABS50	V3072201	22	50	132	66	101	1,01	WOEX 040304	22095
KUB-T.3D.230.R.04-ABS50	V3072301	23	50	135	69	104	1,01	WOEX 040304	23095
KUB-T.3D.240.R.04-ABS50	V3072401	24	50	138	72	107	1,01	WOEX 040304	24095
KUB-T.3D.250.R.05-ABS50	V3072501	25	50	141	75	110	1,28	WOEX 05T304	25095
KUB-T.3D.260.R.05-ABS50	V3072601	26	50	144	78	113	1,28	WOEX 05T304	26095
KUB-T.3D.270.R.05-ABS50	V3072701	27	50	147	81	116	1,28	WOEX 05T304	27095
KUB-T.3D.280.R.05-ABS50	V3072801	28	50	150	84	119	1,28	WOEX 05T304	28095
KUB-T.3D.290.R.05-ABS50	V3072901	29	50	153	87	122	1,28	WOEX 05T304	29095
KUB-T.3D.300.R.05-ABS50	V3073001	30	50	161	90	130	1,28	WOEX 05T304	30095
KUB-T.3D.310.R.05-ABS50	V3073101	31	50	164	93	133	1,28	WOEX 05T304	31095
KUB-T.3D.320.R.05-ABS50	V3073201	32	50	167	96	136	1,28	WOEX 05T304	32095
KUB-T.3D.330.R.05-ABS50	V3073301	33	50	170	99	139	1,28	WOEX 05T304	33095
KUB-T.3D.340.R.05-ABS50	V3073401	34	50	173	102	142	1,28	WOEX 05T304	34095
KUB-T.3D.350.R.05-ABS50	V3073501	35	50	176	105	145	1,28	WOEX 05T304	35095
KUB-T.3D.360.R.05-ABS50	V3073601	36	50	179	108	148	1,28	WOEX 05T304	36095
KUB-T.3D.370.R.06-ABS50	V3073701	37	50	192	111	161	2,8	WOEX 06T304	37095
KUB-T.3D.380.R.06-ABS50	V3073801	38	50	195	114	164	2,8	WOEX 06T304	38095
KUB-T.3D.390.R.06-ABS50	V3073901	39	50	198	117	167	2,8	WOEX 06T304	39095
KUB-T.3D.400.R.06-ABS50	V3074001	40	50	201	120	170	2,8	WOEX 06T304	40095
KUB-T.3D.410.R.06-ABS50	V3074101	41	50	204	123	173	2,8	WOEX 06T304	41095
KUB-T.3D.420.R.06-ABS50	V3074201	42	50	207	126	176	2,8	WOEX 06T304	42095
KUB-T.3D.430.R.06-ABS50	V3074301	43	50	210	129	179	2,8	WOEX 06T304	43095
KUB-T.3D.440.R.06-ABS50	V3074401	44	50	213	132	182	2,8	WOEX 06T304	44095

Key D

Clamping screw

Spare parts DC		Article no. 80 950 ...		Article no. 10 950 ...
14 - 19	T06 - IP	123	M2,0x4,3 - 06IP	10000
20 - 24	T06 - IP	123	M2,2x5,5 - 06IP	10700
25 - 36	T08 - IP	125	M2,5x7,2 - 10IP	10500
37 - 44	T10 - IP	127	M3,5x7,3 - 10IP	10600

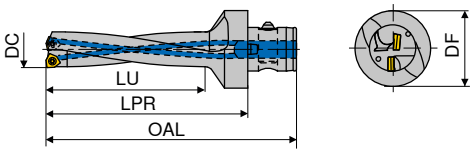
Suitable adapters can be found in → **Chapter 16 Adapters.**

KUB Trigon

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 4xD

ABS



Designation	KOMET no.	DC mm	DF mm	OAL mm	LU mm	LPR mm	torque moment Nm	Insert	NEW Article no. 10 894 ...
KUB-T.4D.140.R.03-ABS50	V3091403	14	50	122	56	91	0,62	WOEX 030204	14095
KUB-T.4D.150.R.03-ABS50	V3091503	15	50	126	60	95	0,62	WOEX 030204	15095
KUB-T.4D.160.R.03-ABS50	V3091601	16	50	130	64	99	0,62	WOEX 030204	16095
KUB-T.4D.170.R.03-ABS50	V3091701	17	50	134	68	103	0,62	WOEX 030204	17095
KUB-T.4D.180.R.03-ABS50	V3091801	18	50	138	72	107	0,62	WOEX 030204	18095
KUB-T.4D.190.R.03-ABS50	V3091901	19	50	142	76	111	0,62	WOEX 030204	19095
KUB-T.4D.200.R.04-ABS50	V3092001	20	50	146	80	115	1,01	WOEX 040304	20095
KUB-T.4D.210.R.04-ABS50	V3092101	21	50	150	84	119	1,01	WOEX 040304	21095
KUB-T.4D.220.R.04-ABS50	V3092201	22	50	154	88	123	1,01	WOEX 040304	22095
KUB-T.4D.230.R.04-ABS50	V3092301	23	50	158	92	127	1,01	WOEX 040304	23095
KUB-T.4D.240.R.04-ABS50	V3092401	24	50	162	96	131	1,01	WOEX 040304	24095
KUB-T.4D.250.R.05-ABS50	V3092501	25	50	166	100	135	1,28	WOEX 05T304	25095
KUB-T.4D.260.R.05-ABS50	V3092601	26	50	170	104	139	1,28	WOEX 05T304	26095
KUB-T.4D.270.R.05-ABS50	V3092701	27	50	174	108	143	1,28	WOEX 05T304	27095
KUB-T.4D.280.R.05-ABS50	V3092801	28	50	178	112	147	1,28	WOEX 05T304	28095
KUB-T.4D.290.R.05-ABS50	V3092901	29	50	182	116	151	1,28	WOEX 05T304	29095
KUB-T.4D.300.R.05-ABS50	V3093001	30	50	191	120	160	1,28	WOEX 05T304	30095
KUB-T.4D.310.R.05-ABS50	V3093101	31	50	195	124	164	1,28	WOEX 05T304	31095
KUB-T.4D.320.R.05-ABS50	V3093201	32	50	199	128	168	1,28	WOEX 05T304	32095
KUB-T.4D.330.R.05-ABS50	V3093301	33	50	203	132	172	1,28	WOEX 05T304	33095
KUB-T.4D.340.R.05-ABS50	V3093401	34	50	207	136	176	1,28	WOEX 05T304	34095
KUB-T.4D.350.R.05-ABS50	V3093501	35	50	211	140	180	1,28	WOEX 05T304	35095
KUB-T.4D.360.R.05-ABS50	V3093601	36	50	215	144	184	1,28	WOEX 05T304	36095
KUB-T.4D.370.R.06-ABS50	V3093701	37	50	229	148	198	2,8	WOEX 06T304	37095
KUB-T.4D.380.R.06-ABS50	V3093801	38	50	233	152	202	2,8	WOEX 06T304	38095
KUB-T.4D.390.R.06-ABS50	V3093901	39	50	237	156	206	2,8	WOEX 06T304	39095
KUB-T.4D.400.R.06-ABS50	V3094001	40	50	241	160	210	2,8	WOEX 06T304	40095
KUB-T.4D.410.R.06-ABS50	V3094101	41	50	245	164	214	2,8	WOEX 06T304	41095
KUB-T.4D.420.R.06-ABS50	V3094201	42	50	249	168	218	2,8	WOEX 06T304	42095
KUB-T.4D.430.R.06-ABS50	V3094301	43	50	253	172	222	2,8	WOEX 06T304	43095
KUB-T.4D.440.R.06-ABS50	V3094401	44	50	257	176	226	2,8	WOEX 06T304	44095

Key D

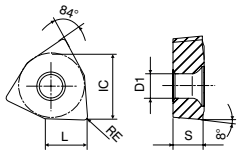
Clamping screw

Spare parts DC		Article no. 80 950 ...		Article no. 10 950 ...
14 - 19	T06 - IP	123	M2,0x4,3 - 06IP	10000
20 - 24	T06 - IP	123	M2,2x5,5 - 06IP	10700
25 - 36	T08 - IP	125	M2,5x7,2 - 10IP	10500
37 - 44	T10 - IP	127	M3,5x7,3 - 10IP	10600

Suitable adapters can be found in → **Chapter 16 Adapters.**

WOEX

Designation	L	IC	S	D1
	mm	mm	mm	mm
WOEX 0302..	3,2	5,00	2,30	2,30
WOEX 0403..	4,1	6,35	3,18	2,55
WOEX 05T3..	5,3	8,00	3,80	2,85
WOEX 06T3..	6,6	10,00	3,80	4,05



WOEX

			-01 BK8425	-03 BK8425	-13 BK8425	-01 BK6115
			WOEX	WOEX	WOEX	WOEX
			NEW	NEW	NEW	NEW
ISO	KOMET no.	RE	Article no. 10 821 ...	Article no. 10 821 ...	Article no. 10 821 ...	Article no. 10 821 ...
		mm				
030204	W2910030.048425	0,4		30303		
030204	W2910130.048425	0,4			30313	
030204	W2910010.048425	0,4	30301			
030204	W2910010.046115	0,4				40301
040304	W2918130.048425	0,4			30413	
040304	W2918030.048425	0,4		30403		
040304	W2918010.048425	0,4	30401			
040304	W2918010.046115	0,4				40401
05T304	W2924130.048425	0,4			30513	
05T304	W2924030.048425	0,4		30503		
05T304	W2924010.048425	0,4	30501			
05T304	W2924010.046115	0,4				40501
06T304	W2934130.048425	0,4			30613	
06T304	W2934030.048425	0,4		30603		
06T304	W2934010.048425	0,4	30601			
06T304	W2934010.046115	0,4				40601
Steel			●	●	●	●
Stainless steel			●	●	●	
Cast iron			●	●	●	●
Non ferrous metals						
Heat resistant alloys						
hardened materials						○

→ v_c/f_z Page 47–50

BK8425 -03 and BK6115 -01 are exclusively recommended for use on the peripheral cutting edge!

Specialised indexable inserts for machining aluminium or stainless steels (BK7935, BK62, BK77) can be found in our online shop at cuttingtools.ceratizit.com

Application tips – eccentric sleeves

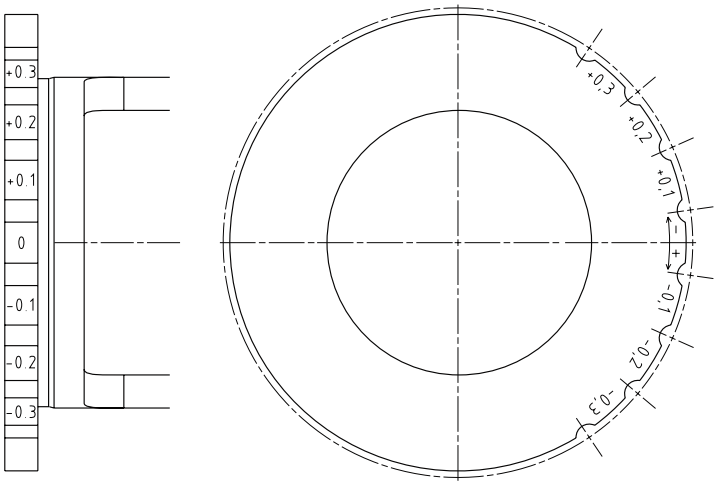
Users of rotating tools can now enjoy greater flexibility.
Using the eccentric sleeves, you can vary and adjust the diameter of the hole by +/- 0.3 mm with ease.

Two types of eccentric sleeve are available:
One for use with the new indexable insert drill adapter and one for use with the existing Weldon adapter.
The difference lies solely in the design and position of the slots for the adapter's clamping screws.
There are four sizes per type, which are tailored to the shank diameter.

Eccentric sleeve for indexable insert drill adapter

Eccentric sleeve for Weldon adapter

A scale is engraved on every eccentric sleeve (radially and on the face),
so that the user can adjust the bore diameter according to requirements.



Side view *End view*

Instructions for use

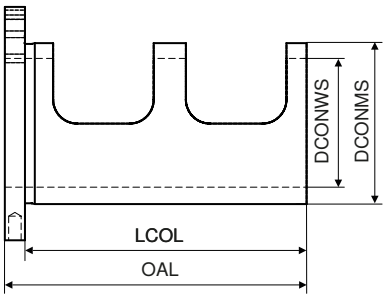
1. Position the sleeve in the respective adapter and insert the indexable insert drill.
2. Set the sleeve to the zero position. → The „0“ must align with the clamping screws on the adapter.
3. Clamp the adapter's clamping screws.
4. Drill.
5. Measure the bore diameter.
6. Loosen the clamping screws.
7. Correct the bore diameter using the sleeve. → Observe the scale on the sleeve. The value must align with the clamping screws on the adapter.
8. Clamp the clamping screws.
9. Drill.

A scale is engraved on every eccentric sleeve (radially and on the face).

Owing to the radial adjustment of the drill axis, the feed rate should be reduced by approx. 30 % for longer drilling tools (4xD and 5xD).

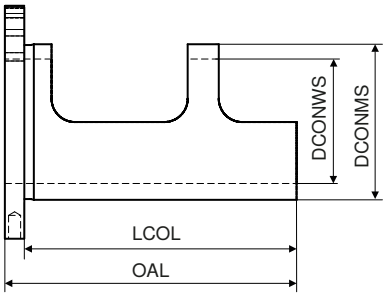
3

Eccentric sleeve – indexable insert drill adapter



Designation	DCONWS	DCONMS	OAL	LCOL	Article no. 10 870 ...
	mm	mm	mm	mm	
EHB.D20.D25	20	25	61	56	**120**
EHB.D25.D32	25	32	65	60	**125**
EHB.D32.D40	32	40	75	70	**132**
EHB.D40.D50	40	50	85	80	**140**

Eccentric sleeve – standard Weldon adapter

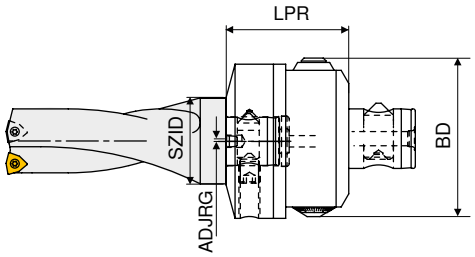


Designation	DCONWS	DCONMS	OAL	LCOL	Article no. 10 871 ...
	mm	mm	mm	mm	
EHW.D20.D25	20	25	61	56	**120**
EHW.D25.D32	25	32	65	60	**125**
EHW.D32.D40	32	40	75	70	**132**
EHW.D40.D50	40	50	85	80	**140**

Application tips for eccentric sleeves can be found on → **Page 36.**

Adjuster with ABS connection

- Precise adjustment using micrometric adjusting spindle
- Max. adjustment range 3 mm on diameter
- Graduation of scale 1 line 0.02 mm on diameter
- Stable clamping of the top section after adjustment using four clamping screws arranged on the face



AD

Adapter	KOMET no.	BD	LPR	ADJRG	SZID	NEW Article no. 84 210 ...
		mm	mm	mm		
ABS 50	M0100001	70	57	1,5	ABS 50	**05097**

Material examples referring to the cutting data tables

	Index	Material	Strength N/mm² / HB / HRC	Material number	Material designation	Material number	Material designation	Material number	Material designation
P	1.1	General construction steel	< 800 N/mm²	1.0402	EN3B				
	1.2	Free cutting steel	< 800 N/mm²	1.0711	EN1A				
	1.3	Hardened steel, non alloyed	< 800 N/mm²	1.0401	EN32C				
	1.4	Alloyed hardened steel	< 1000 N/mm²	1.7325	25 CD4				
	1.5	Tempering steel, unalloyed	< 850 N/mm²	1.5752	EN36	1.0535	EN9		
	1.6	Tempering steel, unalloyed	< 1000 N/mm²	1.6582	EN24				
	1.7	Tempering steel, alloyed	< 800 N/mm²	1.7225	EN19				
	1.8	Tempering steel, alloyed	< 1300 N/mm²	1.8515	EN40B				
	1.9	Steel castings	< 850 N/mm²	0.9650	G-X 260 Cr 27	1.6750	GS-20 NiCrMo 3.7	1.6582	GS-34 CrNiMo 6
	1.10	Nitriding steel	< 1000 N/mm²	1.8509	EN41B				
	1.11	Nitriding steel	< 1200 N/mm²	1.1186	EN8	1.1160	EN14A		
	1.12	Roller bearing steel	< 1200 N/mm²	1.3505	534A99				
	1.13	Spring steel	< 1200 N/mm²		EN45		EN47		EN43
	1.14	High-speed steel	< 1300 N/mm²	1.3343	M2	1.3249	M34		
	1.15	Cold working tool steel	< 1300 N/mm²	1.2379	D2	1.2311	P20		
	1.16	Hot working tool steel	< 1300 N/mm²	1.2344	H13				
M	2.1	Cast steel and sulphured stainless steel	< 850 N/mm²	1.4581	318				
	2.2	Stainless steel, ferritic	< 750 N/mm²	1.4000	403				
	2.3	Stainless steel, martensitic	< 900 N/mm²	1.4057	EN57				
	2.4	Stainless steel, ferritic / martensitic	<1100 N/mm²	1.4028	EN56B				
	2.5	Stainless steel, austenitic / ferritic	< 850 N/mm²	1.4542	17-4PH				
	2.6	Stainless steel, austenitic	< 750 N/mm²	1.4305	303	1.4401	316	1.4301	304
	2.7	Heat resistant steel	< 1100 N/mm²	1.4876	Incoloy 800				
K	3.1	Grey cast iron with lamellar graphite	100–350 N/mm²	0.6015	Grade 150	0.6020	Grade 220	0.6025	Grade 260
	3.2	Grey cast iron with lamellar graphite	300–500 N/mm²	0.6030	Grade 300	0.6035	Grade 350	0.6040	Grade 400
	3.3	Gray cast iron with spheroidal graphite	300–500 N/mm²	0.7040	SG 400-12	0.7043	SG 370-17	0.7050	SG 500-7
	3.4	Gray cast iron with spheroidal graphite	500–900 N/mm²	0.7060	SG 600-3	0.7070	SG 700-2	0.7080	SG 800-2
	3.5	White malleable cast iron	270–450 N/mm²	0.8035	GTW-35	0.8045	GTW-45		
	3.6	White malleable cast iron	500–650 N/mm²	0.8055	GTW-55	0.8065	GTW-65		
	3.7	Black malleable cast iron	300–450 N/mm²	0.8135	GTS-35	0.8145	GTS-45		
	3.8	Black malleable cast iron	500–800 N/mm²	0.8155	GTS-55	0.8170	GTS-70		
N	4.1	Aluminium (non alloyed, low alloyed)	< 350 N/mm²	3.0255	1050 A	3.0275	1070 A	3.0285	1080 A (A8)
	4.2	Aluminium alloys < 0.5 % Si	< 500 N/mm²	3.1325	2017 A (AU4G)	3.4335	7005 (AZ5G)	3.4365	7075 (AZ5GU)
	4.3	Aluminium alloy 0.5–10 % Si	< 400 N/mm²	3.2315	A- G S1	3.2373	A-S9 G	3.2151	A-S 6 U4
	4.4	Aluminium alloys 10–15 % Si	< 400 N/mm²	3.2581	A-S12	3.2583	A-S12 U		
	4.5	Aluminum alloys > 15 % Si	< 400 N/mm²		A-S18	A-S17 U4			
	4.6	Copper (non alloyed, low alloyed)	< 350 N/mm²	2.0040	Cu-c1	2.0060	Cu-a1	2.0090	Cu-b1
	4.7	Copper wrought alloys	< 700 N/mm²	2.1247	Cub2 (Berylium Copper)	2.0855	CuN2S (Nickel Copper)	2.1310	CU-Fe2P
	4.8	Special copper alloys	< 200 HB	2.0916	Cu-A5	2.1525	Cu-S3 M		Ampco 8 (Cu-A6Fe2)
	4.9	Special copper alloys	< 300 HB	2.0978	Cu-Al11 Fe5 Ni5)		Ampco 18 (Cu- A10 Fe3)		
	4.10	Special copper alloys	> 300 HB	2.1247	Cu Be2		Ampco M4		
	4.11	Short-chipping brass, bronze, red bronze	< 600 N/mm²	2.0331	Cu Zn36 Pb1,5	2.0380	Cu Zn39 Pb2 (Ms 56)	2.0410	Cu Zn44 Pb2
	4.12	Long-chipping brass	< 600 N/mm²	2.0335	Cu Zn 36 (Ms63)	2.1293	Cu Cr1 Zr		
	4.13	Thermoplastics		PE	PVC	PS	Polystyrene		Plexiglas
	4.14	Duroplastics		PF	Bakelite		Pertinax		
	4.15	Fibre-reinforced plastics			Carbon Fibre		Fibreglass		Aramid Fibre (Kevlar)
	4.16	Magnesium and magnesium alloys	< 850 N/mm²	3.5812	Mg A7 Z1	3.5662	Mg A9	3.5105	Mg Tr3 Z2 Zn 1
	4.17	Graphite			R8500X		R8650		Technograph 15
	4.18	Tungsten and tungsten alloys			W-Ni Fe (Densimet)		W- Ni Cu (Inermet)		Denal
	4.19	Molybdenum and molybdenum alloys			TZM		MHQ		Mo W
S	5.1	Pure nickel		2.4066	Ni99 (Nickel 200)	2.4068	Lc Ni99 (Nickel 201)		
	5.2	Nickel alloys		1.3912	Fe-Ni36 (Invar)	1.3917	Fe -Ni42 (N42)	1.3922	Fe-Ni48 (N48)
	5.3	Nickel alloys	< 850 N/mm²	2.4375	Ni Cu30 Al (Monel K500)	2.4360	Ni Cu30Fe (Monel 400)	2.4668	
	5.4	Nickel molybdenum alloys		2.4600	Ni Mo30Cr2 (Hastelloy B4)	2.4617	Ni Mo28 (Hastelloy B2)	2.4819	Ni Mo16Cr16 Hastell. C276
	5.5	Nickel-chromium alloys	< 1300 N/mm²	2.4951	Ni Cr20TiAl (Nimonic 80A)	2.4858	Ni Cr21Mo (Inconel 825)	2.4856	Ni Cr22Mo9Nb Inconel 625
	5.6	Cobalt Chrome Alloys	< 1300 N/mm²	2.4964	Co Cr20 W15 Ni10		Co Cr20 Ni16 Mo7		Co Cr28 Mo 6
	5.7	Heat resistant alloys	< 1300 N/mm²	1.4718	Z45 C S 9-3	1.4747	Z80 CSN 20-02	1.4845	Z12 CN 25-20
	5.8	Nickel-cobalt-chromium alloys	< 1400 N/mm²	2.4851	Ni Cr23Fe (Inconel 601)	2.4668	Ni Cr19NbMo (Inconel 718)	2.4602	Ni Cr21Mo14 Hastelloy C22
	5.9	Pure titanium	< 900 N/mm²	3.7025	T35 (Titanium Grade 1)	3.7034	T40 (Titanium Grade 2)	3.7064	T60 (Titanium Grade 4)
	5.10	Titanium alloys	< 700 N/mm²		T-A6-Nb7 (367)		T-A5-Sn2-Mo4-Cr4 (Ti17)		T-A3-V2,5 (Gr18)
	5.11	Titanium alloys	< 1200 N/mm²	3.7165	T-A6-V4 (Ta6V)		T-A4-3V-Mo2-Fe2 (SP700)		T-A5-Sn1-Zr1-V1-Mo (Gr32)
H	6.1		< 45 HRC						
	6.2		46–55 HRC						
	6.3	Tempered steel	56–60 HRC						
	6.4		61–65 HRC						
	6.5		65–70 HRC						

Cutting data standard values for KUB Pentron – 2xD, 3xD

Index	BK6115	BK8425	C, ABS and PSC											
			Ø 14–15,5 mm	Ø 16–17,5 mm	Ø 18–19,5 mm	Ø 20–21,5 mm	Ø 22–23,5 mm	Ø 24–25,5 mm	Ø 26–27,5 mm	Ø 28–30 mm	Ø 31–33 mm	Ø 34–37 mm	Ø 38–42 mm	Ø 43–46 mm
	v_c in m/min		f in mm/rev.											
1.1	250–350	200–320	0,04–0,1	0,04–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12
1.2	250–350	200–320	0,04–0,1	0,04–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12
1.3	250–300	250–300	0,04–0,1	0,04–0,14	0,1–0,15	0,1–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16
1.4	250–300	250–300	0,04–0,1	0,04–0,14	0,1–0,15	0,1–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16
1.5	250–300	250–300	0,04–0,1	0,04–0,14	0,1–0,15	0,1–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16
1.6	200–280	140–220	0,08–0,16	0,08–0,2	0,11–0,2	0,11–0,2	0,13–0,22	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,25	0,14–0,25	0,14–0,25
1.7	200–280	140–220	0,08–0,16	0,08–0,2	0,11–0,2	0,11–0,2	0,13–0,22	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,25	0,14–0,25	0,14–0,25
1.8	200–280	140–220	0,08–0,16	0,08–0,2	0,11–0,2	0,11–0,2	0,13–0,22	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,25	0,14–0,25	0,14–0,25
1.9	250–300	250–300	0,04–0,1	0,04–0,14	0,1–0,15	0,1–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16
1.10	200–280	140–220	0,08–0,16	0,08–0,2	0,11–0,2	0,11–0,2	0,13–0,22	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,25	0,14–0,25	0,14–0,25
1.11	200–280	140–220	0,08–0,16	0,08–0,2	0,11–0,2	0,11–0,2	0,13–0,22	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,25	0,14–0,25	0,14–0,25
1.12	200–280	140–220	0,08–0,16	0,08–0,2	0,11–0,2	0,11–0,2	0,13–0,22	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,25	0,14–0,25	0,14–0,25
1.13	200–280	140–220	0,08–0,16	0,08–0,2	0,11–0,2	0,11–0,2	0,13–0,22	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,25	0,14–0,25	0,14–0,25
1.14	200–280	140–220	0,08–0,16	0,08–0,2	0,11–0,2	0,11–0,2	0,13–0,22	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,24	0,14–0,25	0,14–0,25	0,14–0,25
1.15	170–230	120–200	0,06–0,12	0,06–0,15	0,1–0,15	0,09–0,2	0,12–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22
1.16	170–230	120–200	0,06–0,12	0,06–0,15	0,1–0,15	0,09–0,2	0,12–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22
2.1		150–210	0,06–0,14	0,08–0,14	0,08–0,14	0,08–0,16	0,1–0,18	0,12–0,18	0,12–0,18	0,1–0,18	0,1–0,18	0,1–0,18	0,1–0,18	0,1–0,18
2.2		150–210	0,06–0,14	0,08–0,14	0,08–0,14	0,08–0,16	0,1–0,18	0,12–0,18	0,12–0,18	0,1–0,18	0,1–0,18	0,1–0,18	0,1–0,18	0,1–0,18
2.3		150–210	0,06–0,14	0,08–0,14	0,08–0,14	0,08–0,16	0,1–0,18	0,12–0,18	0,12–0,18	0,1–0,18	0,1–0,18	0,1–0,18	0,1–0,18	0,1–0,18
2.4		120–200	0,06–0,14	0,08–0,14	0,08–0,14	0,08–0,16	0,1–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18
2.5		110–190	0,06–0,11	0,06–0,1	0,06–0,1	0,06–0,13	0,09–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16
2.6		120–200	0,06–0,14	0,08–0,14	0,08–0,14	0,08–0,16	0,1–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18
2.7		110–190	0,06–0,11	0,06–0,1	0,06–0,1	0,06–0,13	0,09–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16
3.1	160–320	140–220	0,08–0,18	0,1–0,18	0,1–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.2	160–320	140–220	0,08–0,18	0,1–0,18	0,1–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.3	120–200	140–220	0,08–0,18	0,12–0,18	0,12–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.4	100–180	120–180	0,08–0,18	0,12–0,18	0,12–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.5	90–150	110–170	0,08–0,18	0,12–0,18	0,12–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.6	90–150	110–170	0,08–0,18	0,12–0,18	0,12–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.7	90–150	110–170	0,08–0,18	0,12–0,18	0,12–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.8	90–150	110–170	0,08–0,18	0,12–0,18	0,12–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
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5.11														
6.1	50–90		0,02–0,06	0,02–0,06	0,02–0,06	0,02–0,06	0,02–0,06	0,02–0,06	0,02–0,06	0,02–0,06	0,02–0,06	0,02–0,06	0,02–0,06	0,02–0,06
6.2	30–50		0,01–0,03	0,01–0,03	0,01–0,03	0,01–0,03	0,01–0,02	0,01–0,02	0,01–0,02	0,01–0,02	0,01–0,02	0,01–0,02	0,01–0,02	0,01–0,02
6.3														
6.4														
6.5														

During the drilling operation on through holes a sharp disk will be produced.
Safety precautions must be observed.
A safety guard has to be provided as protection.

In order to ensure efficient chip evacuation, coolant pressure must be at least 5 bar.
Optimum pressure is > 15 bar.

Cutting data standard values for KUB Pentron – 4xD

Index	BK6115	BK8425	C and ABS											
			Ø 14–15,5 mm	Ø 16–17,5 mm	Ø 18–19,5 mm	Ø 20–21,5 mm	Ø 22–23,5 mm	Ø 24–25,5 mm	Ø 26–27,5 mm	Ø 28–30 mm	Ø 31–33 mm	Ø 34–37 mm	Ø 38–42 mm	Ø 43–46 mm
	v_c in m/min		f in mm/rev.											
1.1	250–350	200–320	0,04–0,08	0,04–0,12	0,06–0,1	0,05–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12
1.2	250–350	200–320	0,04–0,08	0,04–0,12	0,06–0,1	0,05–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12
1.3	250–300	250–300	0,04–0,09	0,04–0,14	0,1–0,15	0,1–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16
1.4	250–300	250–300	0,04–0,09	0,04–0,14	0,1–0,15	0,1–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16
1.5	250–300	250–300	0,04–0,09	0,04–0,14	0,1–0,15	0,1–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16
1.6	200–280	140–220	0,06–0,16	0,08–0,16	0,11–0,16	0,11–0,18	0,13–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22
1.7	200–280	140–220	0,06–0,16	0,08–0,16	0,11–0,16	0,11–0,18	0,13–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22
1.8	200–280	140–220	0,06–0,16	0,08–0,16	0,11–0,16	0,11–0,18	0,13–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22
1.9	250–300	250–300	0,04–0,09	0,04–0,14	0,1–0,15	0,1–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16	0,11–0,16
1.10	200–280	140–220	0,06–0,16	0,08–0,16	0,11–0,16	0,11–0,18	0,13–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22
1.11	200–280	140–220	0,06–0,16	0,08–0,16	0,11–0,16	0,11–0,18	0,13–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22
1.12	200–280	140–220	0,06–0,16	0,08–0,16	0,11–0,16	0,11–0,18	0,13–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22
1.13	200–280	140–220	0,06–0,16	0,08–0,16	0,11–0,16	0,11–0,18	0,13–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22
1.14	200–280	140–220	0,06–0,16	0,08–0,16	0,11–0,16	0,11–0,18	0,13–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22
1.15	170–230	120–200	0,06–0,12	0,06–0,15	0,1–0,15	0,09–0,2	0,12–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22
1.16	170–230	120–200	0,06–0,12	0,06–0,15	0,1–0,15	0,09–0,2	0,12–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,22
2.1		150–210	0,06–0,12	0,08–0,12	0,08–0,12	0,08–0,15	0,1–0,18	0,12–0,18	0,12–0,18	0,1–0,18	0,1–0,18	0,1–0,18	0,1–0,18	0,1–0,18
2.2		150–210	0,06–0,12	0,08–0,12	0,08–0,12	0,08–0,15	0,1–0,18	0,12–0,18	0,12–0,18	0,1–0,18	0,1–0,18	0,1–0,18	0,1–0,18	0,1–0,18
2.3		150–210	0,06–0,12	0,08–0,12	0,08–0,12	0,08–0,15	0,1–0,18	0,12–0,18	0,12–0,18	0,1–0,18	0,1–0,18	0,1–0,18	0,1–0,18	0,1–0,18
2.4		120–200	0,06–0,12	0,08–0,12	0,08–0,12	0,08–0,15	0,1–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18
2.5		110–190	0,06–0,1	0,06–0,1	0,06–0,1	0,06–0,13	0,09–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16
2.6		120–200	0,06–0,12	0,08–0,12	0,08–0,12	0,08–0,15	0,1–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18	0,12–0,18
2.7		110–190	0,06–0,1	0,06–0,1	0,06–0,1	0,06–0,13	0,09–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16
3.1	160–320	140–220	0,08–0,18	0,1–0,18	0,1–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.2	160–320	140–220	0,08–0,18	0,1–0,18	0,1–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.3	120–200	140–220	0,08–0,18	0,12–0,18	0,12–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.4	100–180	120–180	0,08–0,18	0,12–0,18	0,12–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.5	90–150	110–170	0,08–0,18	0,12–0,18	0,12–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.6	90–150	110–170	0,08–0,18	0,12–0,18	0,12–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.7	90–150	110–170	0,08–0,18	0,12–0,18	0,12–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
3.8	90–150	110–170	0,08–0,18	0,12–0,18	0,12–0,18	0,12–0,22	0,14–0,25	0,16–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3	0,2–0,3
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During the drilling operation on through holes a sharp disk will be produced.
Safety precautions must be observed.
A safety guard has to be provided as protection.

In order to ensure efficient chip evacuation, coolant pressure must be at least 5 bar.
Optimum pressure is > 15 bar.

3

Cutting data standard values for KUB Pentron – 5xD

Index	BK6115	BK8425	C and ABS											
			Ø 14–15,5 mm	Ø 16–17,5 mm	Ø 18–19,5 mm	Ø 20–21,5 mm	Ø 22–23,5 mm	Ø 24–25,5 mm	Ø 26–27,5 mm	Ø 28–30 mm	Ø 31–33 mm	Ø 34–37 mm	Ø 38–42 mm	Ø 43–46 mm
	v_c in m/min		f in mm/rev.											
1.1	250–350	200–320	0,04–0,09	0,06–0,1	0,06–0,1	0,05–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,08–0,12	0,08–0,12	0,08–0,12	0,08–0,12	0,08–0,12
1.2	250–350	200–320	0,04–0,09	0,06–0,1	0,06–0,1	0,05–0,12	0,06–0,12	0,06–0,12	0,06–0,12	0,08–0,12	0,08–0,12	0,08–0,12	0,08–0,12	0,08–0,12
1.3	250–300	250–300	0,04–0,1	0,06–0,13	0,08–0,13	0,08–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14
1.4	250–300	250–300	0,04–0,1	0,06–0,13	0,08–0,13	0,08–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14
1.5	250–300	250–300	0,04–0,1	0,06–0,13	0,08–0,13	0,08–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14
1.6	200–280	140–220	0,06–0,12	0,06–0,13	0,08–0,13	0,08–0,18	0,13–0,22	0,14–0,22	0,14–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2
1.7	200–280	140–220	0,06–0,12	0,06–0,13	0,08–0,13	0,08–0,18	0,13–0,22	0,14–0,22	0,14–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2
1.8	200–280	140–220	0,06–0,12	0,06–0,13	0,08–0,13	0,08–0,18	0,13–0,22	0,14–0,22	0,14–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2
1.9	250–300	250–300	0,04–0,1	0,06–0,13	0,08–0,13	0,08–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14	0,09–0,14
1.10	200–280	140–220	0,06–0,12	0,06–0,13	0,08–0,13	0,08–0,18	0,13–0,22	0,14–0,22	0,14–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2
1.11	200–280	140–220	0,06–0,12	0,06–0,13	0,08–0,13	0,08–0,18	0,13–0,22	0,14–0,22	0,14–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2
1.12	200–280	140–220	0,06–0,12	0,06–0,13	0,08–0,13	0,08–0,18	0,13–0,22	0,14–0,22	0,14–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2
1.13	200–280	140–220	0,06–0,12	0,06–0,13	0,08–0,13	0,08–0,18	0,13–0,22	0,14–0,22	0,14–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2
1.14	200–280	140–220	0,06–0,12	0,06–0,13	0,08–0,13	0,08–0,18	0,13–0,22	0,14–0,22	0,14–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,2
1.15	170–230	120–200	0,06–0,12	0,08–0,15	0,09–0,15	0,09–0,2	0,12–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,2	0,14–0,2	0,14–0,2	0,14–0,2
1.16	170–230	120–200	0,06–0,12	0,08–0,15	0,09–0,15	0,09–0,2	0,12–0,22	0,14–0,22	0,14–0,22	0,14–0,22	0,14–0,2	0,14–0,2	0,14–0,2	0,14–0,2
2.1		150–210	0,06–0,1	0,06–0,1	0,06–0,1	0,06–0,13	0,09–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16
2.2		150–210	0,06–0,1	0,06–0,1	0,06–0,1	0,06–0,13	0,09–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16
2.3		150–210	0,06–0,1	0,06–0,1	0,06–0,1	0,06–0,13	0,09–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16	0,1–0,16
2.4		120–200	0,06–0,1	0,06–0,1	0,06–0,1	0,06–0,13	0,09–0,16	0,12–0,16	0,12–0,14	0,08–0,14	0,08–0,14	0,08–0,14	0,08–0,14	0,08–0,14
2.5		110–190	0,06–0,1	0,06–0,1	0,06–0,1	0,06–0,11	0,07–0,14	0,1–0,14	0,1–0,14	0,1–0,14	0,1–0,14	0,1–0,14	0,1–0,14	0,1–0,14
2.6		120–200	0,06–0,1	0,06–0,1	0,06–0,1	0,06–0,13	0,09–0,16	0,12–0,16	0,12–0,14	0,08–0,14	0,08–0,14	0,08–0,14	0,08–0,14	0,08–0,14
2.7		110–190	0,06–0,1	0,06–0,1	0,06–0,1	0,06–0,11	0,07–0,14	0,1–0,14	0,1–0,14	0,1–0,14	0,1–0,14	0,1–0,14	0,1–0,14	0,1–0,14
3.1	160–320	140–220	0,08–0,15	0,08–0,16	0,1–0,16	0,1–0,2	0,12–0,23	0,14–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28
3.2	160–320	140–220	0,08–0,15	0,08–0,16	0,1–0,16	0,1–0,2	0,12–0,23	0,14–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28
3.3	120–200	140–220	0,08–0,15	0,08–0,16	0,1–0,16	0,1–0,2	0,12–0,23	0,14–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28
3.4	100–180	120–180	0,08–0,15	0,08–0,16	0,1–0,16	0,1–0,2	0,12–0,23	0,14–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28
3.5	90–150	110–170	0,08–0,15	0,08–0,16	0,1–0,16	0,1–0,2	0,12–0,23	0,14–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28
3.6	90–150	110–170	0,08–0,15	0,08–0,16	0,1–0,16	0,1–0,2	0,12–0,23	0,14–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28
3.7	90–150	110–170	0,08–0,15	0,08–0,16	0,1–0,16	0,1–0,2	0,12–0,23	0,14–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28
3.8	90–150	110–170	0,08–0,15	0,08–0,16	0,1–0,16	0,1–0,2	0,12–0,23	0,14–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28	0,18–0,28
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During the drilling operation on through holes a sharp disk will be produced.
Safety precautions must be observed.
A safety guard has to be provided as protection.

In order to ensure efficient chip evacuation, coolant pressure must be at least 5 bar.
Optimum pressure is > 15 bar.

Cutting data standard values for MaxiDrill 900 – 2xD

Index	DRAGONSKIN CTCP420 (DCX1420)	DRAGONSKIN CTPP430 (CCN1430)	C Ø 12–15,5 mm	Ø 16–17,5 mm	Ø 18–20,5 mm	Ø 21–23,5 mm	Ø 24–27,5 mm	Ø 28–32 mm	Ø 32,5–36,5 mm	Ø 37–41 mm	Ø 41,5–46 mm	Ø 46,5–63 mm
	v_c in m/min		f in mm/rev.									
1.1	**240–390**	**200–300**	0,04–0,16	0,04–0,17	0,05–0,18	0,06–0,20	0,07–0,22	0,07–0,24	0,07–0,24	0,10–0,25	0,10–0,27	0,10–0,29
1.2	**240–390**	**200–300**	0,04–0,16	0,04–0,17	0,05–0,18	0,06–0,20	0,07–0,22	0,07–0,24	0,07–0,24	0,10–0,25	0,10–0,27	0,10–0,29
1.3	**190–310**	**180–280**	0,04–0,16	0,04–0,17	0,05–0,18	0,06–0,20	0,07–0,22	0,07–0,24	0,07–0,24	0,10–0,25	0,10–0,27	0,10–0,29
1.4	**190–310**	**180–280**	0,04–0,13	0,04–0,14	0,05–0,15	0,05–0,15	0,06–0,17	0,06–0,19	0,06–0,19	0,10–0,21	0,10–0,23	0,10–0,23
1.5	**190–310**	**180–280**	0,04–0,15	0,04–0,15	0,05–0,16	0,05–0,17	0,06–0,19	0,06–0,21	0,06–0,21	0,08–0,22	0,08–0,22	0,09–0,26
1.6	**170–290**	**160–250**	0,04–0,15	0,05–0,16	0,05–0,18	0,06–0,20	0,07–0,22	0,07–0,24	0,07–0,24	0,10–0,25	0,10–0,27	0,10–0,29
1.7	**180–280**	**150–220**	0,04–0,17	0,05–0,18	0,05–0,20	0,06–0,22	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,27	0,10–0,30	0,10–0,32
1.8	**170–280**	**130–200**	0,04–0,15	0,05–0,16	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,25	0,10–0,27	0,10–0,29
1.9	**170–280**	**130–200**	0,04–0,17	0,05–0,18	0,05–0,20	0,06–0,22	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,27	0,10–0,30	0,10–0,32
1.10	**170–280**	**130–200**	0,04–0,15	0,05–0,16	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,08–0,25	0,09–0,27	0,10–0,29
1.11	**170–280**	**130–200**	0,04–0,15	0,05–0,16	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,08–0,25	0,09–0,27	0,10–0,29
1.12	**170–280**	**130–200**	0,04–0,15	0,05–0,16	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,08–0,25	0,09–0,27	0,10–0,29
1.13	**170–280**	**130–200**	0,04–0,16	0,05–0,17	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,25	0,10–0,27	0,10–0,30
1.14	**170–280**	**130–200**	0,04–0,16	0,05–0,17	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,25	0,10–0,27	0,10–0,30
1.15	**120–200**	**100–160**	0,04–0,16	0,05–0,17	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,25	0,10–0,27	0,10–0,30
1.16	**120–200**	**100–160**	0,04–0,16	0,05–0,17	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,25	0,10–0,27	0,10–0,30
2.1	140–230	**100–180**	0,04–0,11	0,04–0,12	0,05–0,15	0,06–0,15	0,06–0,17	0,06–0,19	0,06–0,19	0,10–0,22	0,10–0,22	0,10–0,22
2.2	140–230	**100–180**	0,04–0,11	0,04–0,12	0,05–0,15	0,06–0,15	0,06–0,17	0,06–0,19	0,06–0,19	0,10–0,22	0,10–0,22	0,10–0,22
2.3		**100–180**	0,04–0,12	0,04–0,13	0,05–0,15	0,05–0,16	0,05–0,18	0,06–0,18	0,06–0,18	0,09–0,23	0,10–0,23	0,10–0,23
2.4		**80–140**	0,04–0,12	0,04–0,13	0,05–0,15	0,05–0,16	0,05–0,18	0,06–0,18	0,06–0,18	0,09–0,23	0,10–0,23	0,10–0,23
2.5		**80–140**	0,04–0,10	0,04–0,11	0,05–0,13	0,05–0,14	0,05–0,15	0,05–0,15	0,05–0,16	0,08–0,20	0,08–0,20	0,08–0,20
2.6	140–230	**100–160**	0,04–0,11	0,04–0,12	0,05–0,14	0,05–0,15	0,06–0,15	0,06–0,16	0,06–0,17	0,10–0,22	0,10–0,22	0,10–0,22
2.7		**80–140**	0,04–0,10	0,04–0,11	0,05–0,13	0,05–0,14	0,05–0,15	0,05–0,15	0,05–0,16	0,08–0,20	0,08–0,20	0,08–0,20
3.1	**190–310**	120–200	0,07–0,20	0,07–0,22	0,08–0,24	0,10–0,25	0,1–0,28	0,1–0,28	0,1–0,30	0,10–0,32	0,10–0,32	0,10–0,34
3.2	**170–290**	100–180	0,07–0,19	0,07–0,20	0,08–0,22	0,10–0,24	0,1–0,26	0,1–0,26	0,1–0,28	0,10–0,30	0,10–0,30	0,10–0,32
3.3	**190–310**	120–200	0,07–0,20	0,07–0,20	0,08–0,22	0,10–0,25	0,1–0,28	0,1–0,28	0,1–0,28	0,10–0,30	0,10–0,30	0,10–0,32
3.4	**170–290**	100–180	0,07–0,18	0,07–0,18	0,08–0,20	0,10–0,23	0,1–0,25	0,1–0,25	0,1–0,25	0,10–0,27	0,10–0,27	0,10–0,29
3.5	**140–230**	80–160	0,07–0,19	0,07–0,20	0,08–0,21	0,10–0,25	0,1–0,28	0,1–0,28	0,1–0,30	0,10–0,32	0,10–0,32	0,10–0,34
3.6	**130–210**	70–150	0,07–0,19	0,07–0,20	0,08–0,21	0,10–0,25	0,1–0,28	0,1–0,28	0,1–0,30	0,10–0,32	0,10–0,32	0,10–0,34
3.7	**140–230**	80–160	0,07–0,19	0,07–0,20	0,08–0,21	0,10–0,25	0,1–0,28	0,1–0,28	0,1–0,30	0,10–0,32	0,10–0,32	0,10–0,34
3.8	**130–210**	70–150	0,07–0,19	0,07–0,20	0,08–0,21	0,10–0,25	0,1–0,28	0,1–0,28	0,1–0,30	0,10–0,32	0,10–0,32	0,10–0,34
4.1		150–500	0,06–0,12	0,07–0,14	0,08–0,15	0,10–0,16	0,10–0,16	0,10–0,17	0,10–0,17	0,10–0,18	0,10–0,18	0,10–0,18
4.2		150–450	0,06–0,12	0,07–0,14	0,08–0,15	0,10–0,18	0,10–0,18	0,10–0,19	0,10–0,19	0,10–0,20	0,10–0,20	0,10–0,20
4.3		150–350	0,06–0,12	0,07–0,14	0,08–0,15	0,10–0,18	0,10–0,18	0,10–0,19	0,10–0,19	0,10–0,20	0,10–0,20	0,10–0,20
4.4		150–300	0,06–0,12	0,07–0,14	0,08–0,15	0,10–0,18	0,10–0,18	0,10–0,19	0,10–0,19	0,10–0,20	0,10–0,20	0,10–0,20
4.5												
4.6		150–300	0,06–0,13	0,07–0,16	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,19	0,10–0,19	0,10–0,19
4.7		150–300	0,06–0,13	0,07–0,16	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,19	0,10–0,19	0,10–0,19
4.8		150–300	0,06–0,13	0,07–0,16	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,19	0,10–0,19	0,10–0,19
4.9		150–300	0,06–0,13	0,07–0,16	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,19	0,10–0,19	0,10–0,19
4.10		150–300	0,06–0,13	0,07–0,16	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,19	0,10–0,19	0,10–0,19
4.11		150–300	0,06–0,15	0,07–0,16	0,08–0,18	0,10–0,18	0,10–0,18	0,10–0,20	0,10–0,20	0,10–0,25	0,10–0,25	0,10–0,25
4.12		150–300	0,06–0,15	0,07–0,16	0,08–0,18	0,10–0,18	0,10–0,18	0,10–0,20	0,10–0,20	0,10–0,25	0,10–0,25	0,10–0,25
4.13												
4.14		50–150	0,04–0,09	0,04–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,05–0,12	0,05–0,12	0,05–0,12	0,05–0,12
4.15		50–140	0,06–0,14	0,07–0,14	0,08–0,15	0,10–0,16	0,10–0,16	0,10–0,16	0,10–0,16	0,10–0,18	0,10–0,18	0,10–0,18
4.16												
4.17												
4.18												
4.19												
5.1		20–80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.2		20–80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.3		20–80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.4		20–80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.5		20–80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.6		20–80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.7		20–80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.8		20–80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.9		40–100	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.10		40–80	0,04–0,10	0,04–0,10	0,07–0,10	0,05–0,12	0,06–0,12	0,07–0,15	0,07–0,15	0,08–0,16	0,08–0,16	0,08–0,18
5.11		40–80	0,04–0,10	0,04–0,10	0,07–0,10	0,05–0,12	0,06–0,12	0,07–0,15	0,07–0,15	0,08–0,16	0,08–0,16	0,08–0,18
6.1												
6.2												
6.3												
6.4												
6.5												

During the drilling operation on through holes a sharp disk will be produced.
Safety precautions must be observed.
A safety guard has to be provided as protection.

In order to ensure efficient chip evacuation, coolant pressure must be at least 5 bar.
Optimum pressure is > 15 bar.

Cutting data standard values for MaxiDrill 900 + KUB 100 – 3xD

Index	DRAGONSKIN CTCP420 (DCX1420)	DRAGONSKIN CTPP430 (CCN1430)	C Ø 12–15,5 mm	Ø 16–17,5 mm	Ø 18–20,5 mm	Ø 21–23,5 mm	Ø 24–27,5 mm	Ø 28–32 mm	Ø 32,5–36,5 mm	Ø 37–41 mm	Ø 41,5–46 mm	Ø 46,5–63 mm
	v_c in m/min		f in mm/rev.									
1.1	**240–390**	**200–300**	0,04–0,16	0,04–0,17	0,05–0,18	0,06–0,20	0,07–0,22	0,07–0,24	0,07–0,24	0,10–0,25	0,10–0,27	0,10–0,29
1.2	**240–390**	**200–300**	0,04–0,16	0,04–0,17	0,05–0,18	0,06–0,20	0,07–0,22	0,07–0,24	0,07–0,24	0,10–0,25	0,10–0,27	0,10–0,29
1.3	**190–310**	**180–280**	0,04–0,16	0,04–0,17	0,05–0,18	0,06–0,20	0,07–0,22	0,07–0,24	0,07–0,24	0,10–0,25	0,10–0,27	0,10–0,29
1.4	**190–310**	**180–280**	0,04–0,13	0,04–0,14	0,05–0,15	0,05–0,15	0,06–0,17	0,06–0,19	0,06–0,19	0,10–0,21	0,10–0,23	0,10–0,23
1.5	**190–310**	**180–280**	0,04–0,15	0,04–0,15	0,05–0,16	0,05–0,17	0,06–0,19	0,06–0,21	0,06–0,21	0,08–0,22	0,08–0,22	0,09–0,24
1.6	**170–290**	**160–250**	0,04–0,15	0,05–0,16	0,05–0,18	0,06–0,20	0,07–0,22	0,07–0,24	0,07–0,24	0,10–0,25	0,10–0,27	0,10–0,29
1.7	**180–280**	**150–220**	0,04–0,17	0,05–0,18	0,05–0,20	0,06–0,22	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,27	0,10–0,30	0,10–0,32
1.8	**170–280**	**130–200**	0,04–0,15	0,05–0,16	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,25	0,10–0,27	0,10–0,29
1.9	**170–280**	**130–200**	0,04–0,17	0,05–0,18	0,05–0,20	0,06–0,22	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,27	0,10–0,30	0,10–0,32
1.10	**170–280**	**130–200**	0,04–0,15	0,05–0,16	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,08–0,25	0,09–0,27	0,10–0,29
1.11	**170–280**	**130–200**	0,04–0,15	0,05–0,16	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,08–0,25	0,09–0,27	0,10–0,29
1.12	**170–280**	**130–200**	0,04–0,15	0,05–0,16	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,08–0,25	0,09–0,27	0,10–0,29
1.13	**170–280**	**130–200**	0,04–0,16	0,05–0,17	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,25	0,10–0,27	0,10–0,30
1.14	**170–280**	**130–200**	0,04–0,16	0,05–0,17	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,25	0,10–0,27	0,10–0,30
1.15	**120–200**	**100–160**	0,04–0,16	0,05–0,17	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,25	0,10–0,27	0,10–0,30
1.16	**120–200**	**100–160**	0,04–0,16	0,05–0,17	0,05–0,18	0,06–0,20	0,07–0,23	0,07–0,25	0,07–0,25	0,10–0,25	0,10–0,27	0,10–0,30
2.1	140–230	**100–180**	0,04–0,11	0,04–0,12	0,05–0,15	0,06–0,15	0,06–0,17	0,06–0,19	0,06–0,19	0,10–0,22	0,10–0,22	0,10–0,22
2.2	140–230	**100–180**	0,04–0,11	0,04–0,12	0,05–0,15	0,06–0,15	0,06–0,17	0,06–0,19	0,06–0,19	0,10–0,22	0,10–0,22	0,10–0,22
2.3		**100–180**	0,04–0,12	0,04–0,13	0,05–0,15	0,05–0,16	0,05–0,18	0,06–0,18	0,06–0,18	0,09–0,23	0,10–0,23	0,10–0,23
2.4		**80–140**	0,04–0,12	0,04–0,13	0,05–0,15	0,05–0,16	0,05–0,18	0,06–0,18	0,06–0,18	0,09–0,23	0,10–0,23	0,10–0,23
2.5		**80–140**	0,04–0,10	0,04–0,11	0,05–0,13	0,05–0,14	0,05–0,15	0,05–0,15	0,05–0,16	0,08–0,20	0,08–0,20	0,08–0,20
2.6	140–230	**100–160**	0,04–0,11	0,04–0,12	0,05–0,14	0,05–0,15	0,06–0,15	0,06–0,16	0,06–0,17	0,10–0,22	0,10–0,22	0,10–0,22
2.7		**80–140**	0,04–0,10	0,04–0,11	0,05–0,13	0,05–0,14	0,05–0,15	0,05–0,15	0,05–0,16	0,08–0,20	0,08–0,20	0,08–0,20
3.1	**190–310**	120-200	0,07–0,20	0,07–0,22	0,08–0,24	0,10–0,25	0,1–0,28	0,1–0,28	0,1–0,30	0,10–0,32	0,10–0,32	0,10–0,34
3.2	**170–290**	100-180	0,07–0,19	0,07–0,20	0,08–0,22	0,10–0,24	0,1–0,26	0,1–0,26	0,1–0,28	0,10–0,30	0,10–0,30	0,10–0,32
3.3	**190–310**	120-200	0,07–0,20	0,07–0,20	0,08–0,22	0,10–0,25	0,1–0,28	0,1–0,28	0,1–0,28	0,10–0,30	0,10–0,30	0,10–0,32
3.4	**170–290**	100-180	0,07–0,18	0,07–0,18	0,08–0,20	0,10–0,23	0,1–0,25	0,1–0,25	0,1–0,25	0,10–0,27	0,10–0,27	0,10–0,29
3.5	**140–230**	80-160	0,07–0,19	0,07–0,20	0,08–0,21	0,10–0,25	0,1–0,28	0,1–0,28	0,1–0,30	0,10–0,32	0,10–0,32	0,10–0,34
3.6	**130–210**	70-150	0,07–0,19	0,07–0,20	0,08–0,21	0,10–0,25	0,1–0,28	0,1–0,28	0,1–0,30	0,10–0,32	0,10–0,32	0,10–0,34
3.7	**140–230**	80-160	0,07–0,19	0,07–0,20	0,08–0,21	0,10–0,25	0,1–0,28	0,1–0,28	0,1–0,30	0,10–0,32	0,10–0,32	0,10–0,34
3.8	**130–210**	70-150	0,07–0,19	0,07–0,20	0,08–0,21	0,10–0,25	0,1–0,28	0,1–0,28	0,1–0,30	0,10–0,32	0,10–0,32	0,10–0,34
4.1		150-500	0,06–0,12	0,07–0,14	0,08–0,15	0,10–0,16	0,10–0,16	0,10–0,17	0,10–0,17	0,10–0,18	0,10–0,18	0,10–0,18
4.2		150-450	0,06–0,12	0,07–0,14	0,08–0,15	0,10–0,18	0,10–0,18	0,10–0,19	0,10–0,19	0,10–0,20	0,10–0,20	0,10–0,20
4.3		150-350	0,06–0,12	0,07–0,14	0,08–0,15	0,10–0,18	0,10–0,18	0,10–0,19	0,10–0,19	0,10–0,20	0,10–0,20	0,10–0,20
4.4		150-300	0,06–0,12	0,07–0,14	0,08–0,15	0,10–0,18	0,10–0,18	0,10–0,19	0,10–0,19	0,10–0,20	0,10–0,20	0,10–0,20
4.5												
4.6		150-300	0,06–0,13	0,07–0,16	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,19	0,10–0,19	0,10–0,19
4.7		150-300	0,06–0,13	0,07–0,16	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,19	0,10–0,19	0,10–0,19
4.8		150-300	0,06–0,13	0,07–0,16	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,19	0,10–0,19	0,10–0,19
4.9		150-300	0,06–0,13	0,07–0,16	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,19	0,10–0,19	0,10–0,19
4.10		150-300	0,06–0,13	0,07–0,16	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,19	0,10–0,19	0,10–0,19
4.11		150-300	0,06–0,15	0,07–0,16	0,08–0,18	0,10–0,18	0,10–0,18	0,10–0,20	0,10–0,20	0,10–0,25	0,10–0,25	0,10–0,25
4.12		150-300	0,06–0,15	0,07–0,16	0,08–0,18	0,10–0,18	0,10–0,18	0,10–0,20	0,10–0,20	0,10–0,25	0,10–0,25	0,10–0,25
4.13												
4.14		50-150	0,04–0,09	0,04–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,05–0,12	0,05–0,12	0,05–0,12	0,05–0,12
4.15		50-140	0,06–0,14	0,07–0,14	0,08–0,15	0,10–0,16	0,10–0,16	0,10–0,16	0,10–0,16	0,10–0,18	0,10–0,18	0,10–0,18
4.16												
4.17												
4.18												
4.19												
5.1		20-80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.2		20-80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.3		20-80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.4		20-80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.5		20-80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.6		20-80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.7		20-80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.8		20-80	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.9		40-100	0,03–0,07	0,04–0,08	0,04–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,06–0,15
5.10		40-80	0,04–0,10	0,04–0,10	0,07–0,10	0,05–0,12	0,06–0,12	0,07–0,15	0,07–0,15	0,08–0,16	0,08–0,16	0,08–0,18
5.11		40-80	0,04–0,10	0,04–0,10	0,07–0,10	0,05–0,12	0,06–0,12	0,07–0,15	0,07–0,15	0,08–0,16	0,08–0,16	0,08–0,18
6.1												
6.2												
6.3												
6.4												
6.5												

During the drilling operation on through holes a sharp disk will be produced.
Safety precautions must be observed.
A safety guard has to be provided as protection.

In order to ensure efficient chip evacuation, coolant pressure must be at least 5 bar.
Optimum pressure is > 15 bar.

Cutting data for MaxiDrill 900 indexable insert drill – 4xD

Index	DRAGONSKIN CTCP420 (DCX1420)	DRAGONSKIN CTPP430 (CCN1430)	C									
			Ø 12–15,5 mm	Ø 16–17,5 mm	Ø 18–20 mm	Ø 21–23 mm	Ø 24–27 mm	Ø 28–32 mm	Ø 33–36 mm	Ø 37–41 mm	Ø 41,5–46 mm	Ø 46,5–54 mm
	v_c in m/min		f in mm/rev.									
1.1	**240–390**	**200–300**	0,04–0,14	0,04–0,15	0,05–0,16	0,06–0,18	0,07–0,20	0,07–0,22	0,07–0,22	0,07–0,23	0,07–0,23	0,08–0,25
1.2	**240–390**	**200–300**	0,04–0,14	0,04–0,15	0,05–0,16	0,06–0,18	0,07–0,20	0,07–0,22	0,07–0,22	0,07–0,23	0,07–0,23	0,08–0,25
1.3	**190–310**	**180–280**	0,04–0,14	0,04–0,15	0,05–0,16	0,06–0,18	0,07–0,20	0,07–0,22	0,07–0,22	0,07–0,23	0,07–0,23	0,08–0,25
1.4	**190–310**	**180–280**	0,04–0,11	0,04–0,12	0,05–0,12	0,05–0,13	0,06–0,15	0,06–0,17	0,06–0,17	0,06–0,17	0,06–0,17	0,07–0,17
1.5	**190–310**	**180–280**	0,04–0,13	0,04–0,14	0,05–0,14	0,05–0,15	0,06–0,17	0,06–0,19	0,06–0,19	0,06–0,20	0,06–0,20	0,07–0,22
1.6	**170–290**	**160–250**	0,04–0,14	0,04–0,15	0,05–0,16	0,06–0,18	0,07–0,20	0,07–0,22	0,07–0,22	0,07–0,23	0,07–0,23	0,08–0,25
1.7	**180–280**	**150–220**	0,04–0,17	0,04–0,18	0,05–0,18	0,06–0,20	0,07–0,20	0,07–0,23	0,07–0,23	0,07–0,24	0,07–0,24	0,08–0,26
1.8	**170–280**	**130–200**	0,04–0,14	0,04–0,15	0,05–0,15	0,06–0,17	0,07–0,20	0,07–0,23	0,07–0,23	0,07–0,23	0,07–0,23	0,08–0,25
1.9	**170–280**	**130–200**	0,04–0,17	0,04–0,18	0,05–0,18	0,06–0,20	0,07–0,20	0,07–0,23	0,07–0,23	0,07–0,24	0,07–0,24	0,08–0,26
1.10	**170–280**	**130–200**	0,04–0,14	0,04–0,15	0,05–0,15	0,06–0,17	0,07–0,20	0,07–0,23	0,07–0,23	0,07–0,23	0,07–0,23	0,08–0,25
1.11	**170–280**	**130–200**	0,04–0,14	0,04–0,15	0,05–0,15	0,06–0,17	0,07–0,20	0,07–0,23	0,07–0,23	0,07–0,23	0,07–0,23	0,08–0,25
1.12	**170–280**	**130–200**	0,04–0,14	0,04–0,15	0,05–0,15	0,06–0,17	0,07–0,20	0,07–0,23	0,07–0,23	0,07–0,23	0,07–0,23	0,08–0,25
1.13	**170–280**	**130–200**	0,04–0,14	0,04–0,15	0,05–0,15	0,06–0,17	0,07–0,20	0,07–0,23	0,07–0,23	0,07–0,23	0,07–0,23	0,08–0,25
1.14	**170–280**	**130–200**	0,04–0,14	0,04–0,15	0,05–0,15	0,06–0,18	0,07–0,20	0,07–0,23	0,07–0,23	0,07–0,23	0,07–0,23	0,08–0,25
1.15	**120–200**	**100–160**	0,04–0,14	0,04–0,15	0,05–0,15	0,06–0,18	0,07–0,20	0,07–0,23	0,07–0,23	0,07–0,23	0,07–0,23	0,08–0,25
1.16	**120–200**	**100–160**	0,04–0,14	0,04–0,15	0,05–0,15	0,06–0,18	0,07–0,20	0,07–0,23	0,07–0,23	0,07–0,23	0,07–0,23	0,08–0,25
2.1	140–230	**100–180**	0,04–0,10	0,04–0,10	0,05–0,12	0,06–0,12	0,06–0,15	0,06–0,17	0,06–0,17	0,08–0,20	0,08–0,20	0,08–0,20
2.2	140–230	**100–180**	0,04–0,10	0,04–0,10	0,05–0,12	0,06–0,12	0,06–0,15	0,06–0,17	0,06–0,17	0,08–0,20	0,08–0,20	0,08–0,20
2.3		**100–180**	0,04–0,12	0,04–0,12	0,05–0,15	0,05–0,16	0,05–0,18	0,06–0,16	0,06–0,16	0,08–0,22	0,08–0,22	0,08–0,22
2.4		**80–140**	0,04–0,12	0,04–0,12	0,05–0,15	0,05–0,16	0,05–0,18	0,06–0,16	0,06–0,16	0,08–0,22	0,08–0,22	0,08–0,22
2.5		**80–140**	0,04–0,10	0,04–0,10	0,05–0,10	0,05–0,12	0,05–0,13	0,05–0,13	0,05–0,13	0,07–0,16	0,07–0,16	0,07–0,16
2.6	140–230	**100–160**	0,04–0,10	0,04–0,10	0,05–0,12	0,05–0,13	0,06–0,13	0,06–0,14	0,06–0,14	0,08–0,20	0,08–0,20	0,08–0,20
2.7		**80–140**	0,04–0,10	0,04–0,10	0,05–0,10	0,05–0,12	0,05–0,13	0,05–0,13	0,05–0,13	0,07–0,16	0,07–0,16	0,07–0,16
3.1	**190–310**	120-200	0,07–0,18	0,07–0,20	0,08–0,22	0,10–0,24	0,1–0,25	0,1–0,25	0,1–0,28	0,10–0,30	0,10–0,30	0,10–0,30
3.2	**170–290**	100-180	0,07–0,17	0,07–0,18	0,08–0,20	0,10–0,22	0,1–0,25	0,1–0,25	0,1–0,27	0,10–0,29	0,10–0,29	0,10–0,29
3.3	**190–310**	120-200	0,07–0,18	0,07–0,18	0,08–0,20	0,10–0,24	0,1–0,26	0,1–0,26	0,1–0,26	0,10–0,28	0,10–0,28	0,10–0,28
3.4	**170–290**	100-180	0,07–0,17	0,07–0,18	0,08–0,18	0,10–0,22	0,1–0,22	0,1–0,22	0,1–0,23	0,10–0,25	0,10–0,25	0,10–0,25
3.5	**140–230**	80-160	0,07–0,17	0,07–0,18	0,08–0,18	0,10–0,22	0,1–0,25	0,1–0,25	0,1–0,28	0,10–0,30	0,10–0,30	0,10–0,30
3.6	**130–210**	70-150	0,07–0,17	0,07–0,18	0,08–0,18	0,10–0,22	0,1–0,25	0,1–0,25	0,1–0,28	0,10–0,30	0,10–0,30	0,10–0,30
3.7	**140–230**	80-160	0,07–0,17	0,07–0,18	0,08–0,18	0,10–0,22	0,1–0,25	0,1–0,25	0,1–0,28	0,10–0,30	0,10–0,30	0,10–0,30
3.8	**130–210**	70-150	0,07–0,17	0,07–0,18	0,08–0,18	0,10–0,22	0,1–0,25	0,1–0,25	0,1–0,28	0,10–0,30	0,10–0,30	0,10–0,30
4.1		150-500	0,06–0,12	0,07–0,14	0,08–0,15	0,10–0,16	0,10–0,16	0,10–0,17	0,10–0,17	0,10–0,17	0,10–0,17	0,10–0,17
4.2		150-450	0,06–0,12	0,07–0,14	0,08–0,15	0,10–0,18	0,10–0,18	0,10–0,19	0,10–0,19	0,10–0,20	0,10–0,20	0,10–0,20
4.3		150-350	0,06–0,12	0,07–0,14	0,08–0,15	0,10–0,18	0,10–0,18	0,10–0,19	0,10–0,19	0,10–0,20	0,10–0,20	0,10–0,20
4.4		150-300	0,06–0,12	0,07–0,14	0,08–0,15	0,10–0,18	0,10–0,18	0,10–0,19	0,10–0,19	0,10–0,20	0,10–0,20	0,10–0,20
4.5												
4.6		150-300	0,06–0,13	0,07–0,14	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,18	0,10–0,18	0,10–0,18
4.7		150-300	0,06–0,13	0,07–0,14	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,18	0,10–0,18	0,10–0,18
4.8		150-300	0,06–0,13	0,07–0,14	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,18	0,10–0,18	0,10–0,18
4.9		150-300	0,06–0,13	0,07–0,14	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,18	0,10–0,18	0,10–0,18
4.10		150-300	0,06–0,13	0,07–0,14	0,08–0,15	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,18	0,10–0,18	0,10–0,18
4.11		150-300	0,06–0,15	0,07–0,16	0,08–0,18	0,10–0,18	0,10–0,18	0,10–0,20	0,10–0,20	0,10–0,22	0,10–0,22	0,10–0,22
4.12		150-300	0,06–0,15	0,07–0,16	0,08–0,18	0,10–0,18	0,10–0,18	0,10–0,20	0,10–0,20	0,10–0,22	0,10–0,22	0,10–0,22
4.13												
4.14		50-150	0,04–0,09	0,04–0,10	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,05–0,12	0,05–0,12	0,05–0,12
4.15		50-140	0,06–0,14	0,07–0,14	0,08–0,14	0,10–0,15	0,10–0,16	0,10–0,16	0,10–0,16	0,10–0,18	0,10–0,18	0,10–0,18
4.16												
4.17												
4.18												
4.19												
5.1		20-80	0,03–0,07	0,04–0,07	0,04–0,07	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,05–0,10
5.2		20-80	0,03–0,07	0,04–0,07	0,04–0,07	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,05–0,10
5.3		20-80	0,03–0,07	0,04–0,07	0,04–0,07	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,05–0,10
5.4		20-80	0,03–0,07	0,04–0,07	0,04–0,07	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,05–0,10
5.5		20-80	0,03–0,07	0,04–0,07	0,04–0,07	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,05–0,10
5.6		20-80	0,03–0,07	0,04–0,07	0,04–0,07	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,05–0,10
5.7		20-80	0,03–0,07	0,04–0,07	0,04–0,07	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,05–0,10
5.8		20-80	0,03–0,07	0,04–0,07	0,04–0,07	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,05–0,10
5.9		40-100	0,03–0,07	0,04–0,07	0,04–0,07	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,05–0,10
5.10		40-80	0,04–0,10	0,04–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,06–0,15	0,07–0,15	0,07–0,15	0,07–0,15	0,07–0,15
5.11		40-80	0,04–0,10	0,04–0,10	0,05–0,10	0,05–0,12	0,05–0,12	0,06–0,15	0,07–0,15	0,07–0,15	0,07–0,15	0,07–0,15
6.1												
6.2												
6.3												
6.4												
6.5												

During the drilling operation on through holes a sharp disk will be produced.
Safety precautions must be observed.
A safety guard has to be provided as protection.

In order to ensure efficient chip evacuation, coolant pressure must be at least 5 bar.
Optimum pressure is > 15 bar.

3

Cutting data standard values for MaxiDrill 900 – 5xD

	DRAGONSKIN	DRAGONSKIN	C							
Index	CTCP420 (DCX1420)	CTPP430 (CCN1430)	Ø 12–15,5 mm	Ø 16–17,5 mm	Ø 18–20 mm	Ø 21–23 mm	Ø 24–27 mm	Ø 28–32 mm	Ø 33–36 mm	Ø 37–41 mm
	v_c in m/min		f in mm/rev.							
1.1	**240–390**	**200–300**	0,04–0,12	0,04–0,12	0,05–0,12	0,05–0,15	0,07–0,17	0,08–0,19	0,08–0,19	0,10–0,23
1.2	**240–390**	**200–300**	0,04–0,12	0,04–0,12	0,05–0,12	0,05–0,15	0,07–0,17	0,08–0,19	0,08–0,19	0,10–0,23
1.3	**190–310**	**180–280**	0,04–0,12	0,04–0,12	0,05–0,12	0,05–0,15	0,07–0,17	0,08–0,19	0,08–0,19	0,10–0,23
1.4	**190–310**	**180–280**	0,04–0,09	0,04–0,09	0,04–0,08	0,04–0,10	0,06–0,12	0,06–0,14	0,06–0,14	0,08–0,17
1.5	**190–310**	**180–280**	0,04–0,10	0,04–0,10	0,05–0,10	0,05–0,12	0,06–0,14	0,06–0,16	0,06–0,16	0,08–0,20
1.6	**170–290**	**160–250**	0,04–0,10	0,04–0,12	0,05–0,12	0,05–0,15	0,07–0,17	0,08–0,19	0,08–0,19	0,10–0,23
1.7	**180–280**	**150–220**	0,04–0,15	0,04–0,15	0,05–0,15	0,05–0,17	0,07–0,18	0,08–0,20	0,08–0,20	0,10–0,25
1.8	**170–280**	**130–200**	0,04–0,13	0,04–0,14	0,05–0,13	0,05–0,15	0,07–0,17	0,08–0,19	0,08–0,19	0,10–0,23
1.9	**170–280**	**130–200**	0,04–0,15	0,04–0,16	0,05–0,15	0,05–0,17	0,07–0,18	0,08–0,20	0,08–0,20	0,10–0,25
1.10	**170–280**	**130–200**	0,04–0,12	0,04–0,13	0,05–0,13	0,05–0,15	0,07–0,17	0,08–0,19	0,08–0,19	0,10–0,25
1.11	**170–280**	**130–200**	0,04–0,12	0,04–0,13	0,05–0,13	0,05–0,15	0,07–0,17	0,08–0,19	0,08–0,19	0,10–0,25
1.12	**170–280**	**130–200**	0,04–0,12	0,04–0,13	0,05–0,13	0,05–0,15	0,07–0,17	0,08–0,19	0,08–0,19	0,10–0,25
1.13	**170–280**	**130–200**	0,04–0,12	0,04–0,13	0,05–0,13	0,05–0,15	0,07–0,17	0,08–0,19	0,08–0,19	0,10–0,25
1.14	**170–280**	**130–200**	0,04–0,12	0,04–0,13	0,05–0,13	0,05–0,15	0,07–0,17	0,08–0,19	0,08–0,19	0,10–0,25
1.15	**120–200**	**100–160**	0,04–0,12	0,04–0,13	0,05–0,13	0,05–0,15	0,07–0,17	0,08–0,19	0,08–0,19	0,10–0,25
1.16	**120–200**	**100–160**	0,04–0,12	0,04–0,13	0,05–0,13	0,05–0,15	0,07–0,17	0,08–0,19	0,08–0,19	0,10–0,25
2.1	140–230	**100–180**	0,04–0,09	0,04–0,09	0,04–0,08	0,04–0,10	0,06–0,12	0,07–0,15	0,07–0,15	0,08–0,18
2.2	140–230	**100–180**	0,04–0,09	0,04–0,09	0,04–0,08	0,04–0,10	0,06–0,12	0,07–0,15	0,07–0,15	0,08–0,18
2.3		**100–180**	0,04–0,11	0,04–0,11	0,04–0,13	0,05–0,15	0,05–0,16	0,06–0,16	0,06–0,16	0,08–0,20
2.4		**80–140**	0,04–0,11	0,04–0,11	0,04–0,13	0,05–0,15	0,05–0,16	0,06–0,16	0,06–0,16	0,08–0,20
2.5		**80–140**	0,04–0,08	0,04–0,08	0,04–0,09	0,05–0,11	0,05–0,12	0,05–0,12	0,05–0,12	0,08–0,15
2.6	140–230	**100–160**	0,04–0,09	0,04–0,09	0,04–0,09	0,05–0,11	0,05–0,12	0,05–0,12	0,05–0,12	0,08–0,16
2.7		**80–140**	0,04–0,08	0,04–0,08	0,04–0,09	0,05–0,11	0,05–0,12	0,05–0,12	0,05–0,12	0,08–0,15
3.1	**190–310**	120–200	0,07–0,18	0,07–0,20	0,08–0,22	0,10–0,23	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25
3.2	**170–290**	100–180	0,07–0,17	0,07–0,18	0,08–0,18	0,10–0,20	0,10–0,22	0,10–0,22	0,10–0,22	0,10–0,22
3.3	**190–310**	120–200	0,07–0,18	0,07–0,18	0,08–0,18	0,10–0,23	0,10–0,25	0,10–0,25	0,10–0,25	0,10–0,25
3.4	**170–290**	100–180	0,07–0,17	0,07–0,18	0,08–0,16	0,10–0,20	0,10–0,22	0,10–0,22	0,10–0,22	0,10–0,22
3.5	**140–230**	80–160	0,07–0,17	0,07–0,18	0,08–0,16	0,10–0,20	0,10–0,22	0,10–0,22	0,10–0,22	0,10–0,22
3.6	**130–210**	70–150	0,07–0,17	0,07–0,18	0,08–0,16	0,10–0,20	0,10–0,22	0,10–0,22	0,10–0,22	0,10–0,22
3.7	**140–230**	80–160	0,07–0,17	0,07–0,18	0,08–0,16	0,10–0,20	0,10–0,22	0,10–0,22	0,10–0,22	0,10–0,22
3.8	**130–210**	70–150	0,07–0,17	0,07–0,18	0,08–0,16	0,10–0,20	0,10–0,22	0,10–0,22	0,10–0,22	0,10–0,22
4.1		150–500	0,06–0,12	0,07–0,14	0,08–0,15	0,10–0,16	0,10–0,16	0,10–0,17	0,10–0,17	0,10–0,17
4.2		150–450	0,06–0,12	0,07–0,14	0,08–0,14	0,10–0,18	0,10–0,18	0,10–0,19	0,10–0,19	0,10–0,19
4.3		150–350	0,06–0,12	0,07–0,14	0,08–0,14	0,10–0,18	0,10–0,18	0,10–0,19	0,10–0,19	0,10–0,19
4.4		150–300	0,06–0,12	0,07–0,14	0,08–0,14	0,10–0,18	0,10–0,18	0,10–0,19	0,10–0,19	0,10–0,19
4.5										
4.6		150–300	0,06–0,13	0,07–0,14	0,08–0,14	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,17
4.7		150–300	0,06–0,13	0,07–0,14	0,08–0,14	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,17
4.8		150–300	0,06–0,13	0,07–0,14	0,08–0,14	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,17
4.9		150–300	0,06–0,13	0,07–0,14	0,08–0,14	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,17
4.10		150–300	0,06–0,13	0,07–0,14	0,08–0,14	0,10–0,15	0,10–0,15	0,10–0,17	0,10–0,17	0,10–0,17
4.11		150–300	0,06–0,15	0,07–0,16	0,08–0,16	0,10–0,18	0,10–0,18	0,10–0,20	0,10–0,20	0,10–0,20
4.12		150–300	0,06–0,15	0,07–0,16	0,08–0,16	0,10–0,18	0,10–0,18	0,10–0,20	0,10–0,20	0,10–0,20
4.13										
4.14		50–150	0,04–0,09	0,04–0,10	0,04–0,08	0,05–0,10	0,05–0,10	0,05–0,10	0,05–0,10	0,05–0,10
4.15		50–140	0,06–0,14	0,07–0,14	0,08–0,14	0,10–0,15	0,10–0,15	0,10–0,15	0,10–0,15	0,10–0,15
4.16										
4.17										
4.18										
4.19										
5.1		20–80	0,03–0,06	0,04–0,06	0,04–0,06	0,04–0,06	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,09
5.2		20–80	0,03–0,06	0,04–0,06	0,04–0,06	0,04–0,06	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,09
5.3		20–80	0,03–0,06	0,04–0,06	0,04–0,06	0,04–0,06	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,09
5.4		20–80	0,03–0,06	0,04–0,06	0,04–0,06	0,04–0,06	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,09
5.5		20–80	0,03–0,06	0,04–0,06	0,04–0,06	0,04–0,06	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,09
5.6		20–80	0,03–0,06	0,04–0,06	0,04–0,06	0,04–0,06	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,09
5.7		20–80	0,03–0,06	0,04–0,06	0,04–0,06	0,04–0,06	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,09
5.8		20–80	0,03–0,06	0,04–0,06	0,04–0,06	0,04–0,06	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,09
5.9		40–100	0,03–0,06	0,04–0,06	0,04–0,06	0,04–0,06	0,04–0,07	0,05–0,08	0,05–0,08	0,05–0,09
5.10		40–80	0,04–0,08	0,04–0,08	0,04–0,08	0,05–0,11	0,05–0,11	0,06–0,12	0,07–0,12	0,07–0,12
5.11		40–80	0,04–0,08	0,04–0,08	0,04–0,08	0,05–0,11	0,05–0,11	0,06–0,12	0,07–0,12	0,07–0,12
6.1										
6.2										
6.3										
6.4										
6.5										

During the drilling operation on through holes a sharp disk will be produced.
Safety precautions must be observed.
A safety guard has to be provided as protection.

In order to ensure efficient chip evacuation, coolant pressure must be at least 5 bar.
Optimum pressure is > 15 bar.

Cutting data standard values KUB Trigon – 2xD

Index	BK6115	BK8425	K and ABS Ø 14–16 mm	Ø 17–19 mm	Ø 20–24 mm	Ø 25–29 mm	Ø 30–36 mm	Ø 37–40 mm	Ø 41–44 mm
	v_c in m/min		f in mm/rev.						
1.1	250–350	200–320	0,04–0,08	0,04–0,1	0,04–0,1	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12
1.2	250–350	200–320	0,04–0,08	0,04–0,1	0,04–0,1	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12
1.3	250–300	250–300	0,04–0,06	0,04–0,08	0,06–0,12	0,07–0,14	0,07–0,14	0,07–0,14	0,08–0,16
1.4	250–300	250–300	0,04–0,06	0,04–0,08	0,06–0,12	0,07–0,14	0,07–0,14	0,07–0,14	0,08–0,16
1.5	250–300	250–300	0,04–0,06	0,04–0,08	0,06–0,12	0,07–0,14	0,07–0,14	0,07–0,14	0,08–0,16
1.6	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.7	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.8	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.9	250–300	250–300	0,04–0,06	0,04–0,08	0,06–0,12	0,07–0,14	0,07–0,14	0,07–0,14	0,08–0,16
1.10	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.11	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.12	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.13	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.14	70–110	50–90	0,03–0,05	0,03–0,06	0,04–0,08	0,06–0,1	0,07–0,1	0,08–0,12	0,08–0,12
1.15	170–230	120–200	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,12	0,08–0,12	0,08–0,12	0,08–0,14
1.16	170–230	120–200	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,12	0,08–0,12	0,08–0,12	0,08–0,14
2.1		150–210	0,04–0,06	0,04–0,08	0,06–0,1	0,08–0,14	0,08–0,14	0,08–0,14	0,08–0,14
2.2		150–210	0,04–0,06	0,04–0,08	0,06–0,1	0,08–0,14	0,08–0,14	0,08–0,14	0,08–0,14
2.3		150–210	0,04–0,06	0,04–0,08	0,06–0,1	0,08–0,14	0,08–0,14	0,08–0,14	0,08–0,14
2.4		120–200	0,04–0,06	0,04–0,06	0,06–0,08	0,08–0,12	0,08–0,12	0,08–0,12	0,08–0,14
2.5		110–190	0,04–0,06	0,04–0,06	0,06–0,08	0,08–0,12	0,08–0,12	0,08–0,12	0,08–0,12
2.6		120–200	0,04–0,06	0,04–0,06	0,06–0,08	0,08–0,12	0,08–0,12	0,08–0,12	0,08–0,14
2.7		110–190	0,04–0,06	0,04–0,06	0,06–0,08	0,08–0,12	0,08–0,12	0,08–0,12	0,08–0,12
3.1	160–320	140–220	0,06–0,1	0,06–0,12	0,08–0,14	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,25
3.2	160–320	140–220	0,06–0,1	0,06–0,12	0,08–0,14	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,25
3.3	120–200	140–220	0,06–0,08	0,06–0,1	0,08–0,14	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,25
3.4	100–180	120–180	0,06–0,08	0,06–0,1	0,08–0,14	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,25
3.5	90–150	110–170	0,06–0,1	0,06–0,12	0,08–0,16	0,1–0,25	0,1–0,25	0,1–0,25	0,1–0,25
3.6	90–150	110–170	0,06–0,1	0,06–0,12	0,08–0,16	0,1–0,25	0,1–0,25	0,1–0,25	0,1–0,25
3.7	90–150	110–170	0,06–0,1	0,06–0,12	0,08–0,16	0,1–0,25	0,1–0,25	0,1–0,25	0,1–0,25
3.8	90–150	110–170	0,06–0,1	0,06–0,12	0,08–0,16	0,1–0,25	0,1–0,25	0,1–0,25	0,1–0,25
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5.11									
6.1	50–90		0,03–0,05	0,03–0,05	0,04–0,08	0,06–0,1	0,06–0,1	0,08–0,12	0,08–0,12
6.2	30–50		0,03–0,05	0,03–0,05	0,04–0,08	0,06–0,1	0,06–0,1	0,06–0,1	0,06–0,1
6.3									
6.4									
6.5									

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Cutting data standard values KUB Trigon – 3xD

Index	BK6115	BK8425	K and ABS Ø 14–16 mm	Ø 17–19 mm	Ø 20–24 mm	Ø 25–29 mm	Ø 30–36 mm	Ø 37–40 mm	Ø 41–44 mm
	v_c in m/min		f in mm/rev.						
1.1	250–350	200–320	0,04–0,08	0,04–0,1	0,04–0,1	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12
1.2	250–350	200–320	0,04–0,08	0,04–0,1	0,04–0,1	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,12
1.3	250–300	250–300	0,04–0,06	0,04–0,08	0,06–0,12	0,07–0,14	0,07–0,14	0,07–0,14	0,08–0,16
1.4	250–300	250–300	0,04–0,06	0,04–0,08	0,06–0,12	0,07–0,14	0,07–0,14	0,07–0,14	0,08–0,16
1.5	250–300	250–300	0,04–0,06	0,04–0,08	0,06–0,12	0,07–0,14	0,07–0,14	0,07–0,14	0,08–0,16
1.6	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.7	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.8	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.9	250–300	250–300	0,04–0,06	0,04–0,08	0,06–0,12	0,07–0,14	0,07–0,14	0,07–0,14	0,08–0,16
1.10	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.11	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.12	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.13	200–280	140–220	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,14	0,08–0,16	0,08–0,16	0,08–0,16
1.14	70–110	50–90	0,03–0,05	0,03–0,06	0,04–0,08	0,06–0,1	0,07–0,1	0,08–0,12	0,08–0,12
1.15	170–230	120–200	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,12	0,08–0,12	0,08–0,12	0,08–0,14
1.16	170–230	120–200	0,04–0,06	0,04–0,08	0,06–0,1	0,07–0,12	0,08–0,12	0,08–0,12	0,08–0,14
2.1		150–210	0,04–0,06	0,04–0,08	0,06–0,1	0,08–0,14	0,08–0,14	0,08–0,14	0,08–0,14
2.2		150–210	0,04–0,06	0,04–0,08	0,06–0,1	0,08–0,14	0,08–0,14	0,08–0,14	0,08–0,14
2.3		150–210	0,04–0,06	0,04–0,08	0,06–0,1	0,08–0,14	0,08–0,14	0,08–0,14	0,08–0,14
2.4		120–200	0,04–0,06	0,04–0,06	0,06–0,08	0,08–0,12	0,08–0,12	0,08–0,12	0,08–0,14
2.5		110–190	0,04–0,06	0,04–0,06	0,06–0,08	0,08–0,12	0,08–0,12	0,08–0,12	0,08–0,12
2.6		120–200	0,04–0,06	0,04–0,06	0,06–0,08	0,08–0,12	0,08–0,12	0,08–0,12	0,08–0,14
2.7		110–190	0,04–0,06	0,04–0,06	0,06–0,08	0,08–0,12	0,08–0,12	0,08–0,12	0,08–0,12
3.1	160–320	140–220	0,06–0,1	0,06–0,12	0,08–0,14	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,25
3.2	160–320	140–220	0,06–0,1	0,06–0,12	0,08–0,14	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,25
3.3	120–200	140–220	0,06–0,08	0,06–0,1	0,08–0,14	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,25
3.4	100–180	120–180	0,06–0,08	0,06–0,1	0,08–0,14	0,1–0,2	0,1–0,2	0,1–0,2	0,1–0,25
3.5	90–150	110–170	0,06–0,1	0,06–0,12	0,08–0,16	0,1–0,25	0,1–0,25	0,1–0,25	0,1–0,25
3.6	90–150	110–170	0,06–0,1	0,06–0,12	0,08–0,16	0,1–0,25	0,1–0,25	0,1–0,25	0,1–0,25
3.7	90–150	110–170	0,06–0,1	0,06–0,12	0,08–0,16	0,1–0,25	0,1–0,25	0,1–0,25	0,1–0,25
3.8	90–150	110–170	0,06–0,1	0,06–0,12	0,08–0,16	0,1–0,25	0,1–0,25	0,1–0,25	0,1–0,25
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6.1	50–90		0,03–0,05	0,03–0,05	0,04–0,08	0,06–0,1	0,06–0,1	0,08–0,12	0,08–0,12
6.2	30–50		0,03–0,05	0,03–0,05	0,04–0,08	0,06–0,1	0,06–0,1	0,06–0,1	0,06–0,1
6.3									
6.4									
6.5									

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Cutting data standard values KUB Trigon – 4xD

Index	BK6115	BK8425	K				
			Ø 14–16 mm	Ø 17–19 mm	Ø 20–24 mm	Ø 25–29 mm	Ø 30–35 mm
	v_c in m/min		f in mm/rev.				
1.1	250–350	200–320	0,04–0,06	0,04–0,08	0,04–0,08	0,05–0,1	0,05–0,1
1.2	250–350	200–320	0,04–0,06	0,04–0,08	0,04–0,08	0,05–0,1	0,05–0,1
1.3	250–300	250–300	0,02–0,04	0,04–0,06	0,04–0,1	0,06–0,12	0,06–0,12
1.4	250–300	250–300	0,02–0,04	0,04–0,06	0,04–0,1	0,06–0,12	0,06–0,12
1.5	250–300	250–300	0,02–0,04	0,04–0,06	0,04–0,1	0,06–0,12	0,06–0,12
1.6	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14
1.7	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14
1.8	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14
1.9	250–300	250–300	0,02–0,04	0,04–0,06	0,04–0,1	0,06–0,12	0,06–0,12
1.10	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14
1.11	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14
1.12	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14
1.13	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14
1.14	70–110	50–90	0,02–0,04	0,03–0,04	0,04–0,06	0,04–0,08	0,04–0,1
1.15	170–230	120–200	0,02–0,04	0,04–0,06	0,06–0,08	0,05–0,1	0,05–0,1
1.16	170–230	120–200	0,02–0,04	0,04–0,06	0,06–0,08	0,05–0,1	0,05–0,1
2.1		150–210	0,02–0,04	0,04–0,06	0,04–0,08	0,06–0,12	0,06–0,12
2.2		150–210	0,02–0,04	0,04–0,06	0,04–0,08	0,06–0,12	0,06–0,12
2.3		150–210	0,02–0,04	0,04–0,06	0,04–0,08	0,06–0,12	0,06–0,12
2.4		120–200	0,02–0,04	0,02–0,04	0,04–0,06	0,06–0,1	0,06–0,1
2.5		110–190	0,02–0,04	0,02–0,04	0,04–0,06	0,06–0,1	0,06–0,1
2.6		120–200	0,02–0,04	0,02–0,04	0,04–0,06	0,06–0,1	0,06–0,1
2.7		110–190	0,02–0,04	0,02–0,04	0,04–0,06	0,06–0,1	0,06–0,1
3.1	160–320	140–220	0,06–0,08	0,06–0,1	0,06–0,12	0,08–0,18	0,08–0,18
3.2	160–320	140–220	0,06–0,08	0,06–0,1	0,06–0,12	0,08–0,18	0,08–0,18
3.3	120–200	140–220	0,04–0,06	0,06–0,08	0,06–0,12	0,08–0,18	0,08–0,18
3.4	100–180	120–180	0,04–0,06	0,06–0,08	0,06–0,12	0,08–0,18	0,08–0,18
3.5	90–150	110–170	0,06–0,08	0,06–0,1	0,08–0,14	0,1–0,23	0,1–0,23
3.6	90–150	110–170	0,06–0,08	0,06–0,1	0,08–0,14	0,1–0,23	0,1–0,23
3.7	90–150	110–170	0,06–0,08	0,06–0,1	0,08–0,14	0,1–0,23	0,1–0,23
3.8	90–150	110–170	0,06–0,08	0,06–0,1	0,08–0,14	0,1–0,23	0,1–0,23
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During the drilling operation on through holes a sharp disk will be produced.
Safety precautions must be observed.
A safety guard has to be provided as protection.

In order to ensure efficient chip evacuation, coolant pressure must be at least 5 bar.
Optimum pressure is > 15 bar.

Cutting data standard values KUB Trigon – 4xD

Index	BK6115	BK8425	ABS Ø 14–16 mm	ABS Ø 17–19 mm	ABS Ø 20–24 mm	ABS Ø 25–29 mm	ABS Ø 30–36 mm	ABS Ø 37–40 mm	ABS Ø 41–44 mm
	v_c in m/min		f in mm/rev.						
1.1	250–350	200–320	0,04–0,06	0,04–0,08	0,04–0,08	0,05–0,1	0,05–0,1	0,05–0,1	0,05–0,1
1.2	250–350	200–320	0,04–0,06	0,04–0,08	0,04–0,08	0,05–0,1	0,05–0,1	0,05–0,1	0,05–0,1
1.3	250–300	250–300	0,02–0,04	0,04–0,06	0,04–0,1	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,14
1.4	250–300	250–300	0,02–0,04	0,04–0,06	0,04–0,1	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,14
1.5	250–300	250–300	0,02–0,04	0,04–0,06	0,04–0,1	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,14
1.6	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14	0,06–0,14	0,06–0,14
1.7	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14	0,06–0,14	0,06–0,14
1.8	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14	0,06–0,14	0,06–0,14
1.9	250–300	250–300	0,02–0,04	0,04–0,06	0,04–0,1	0,06–0,12	0,06–0,12	0,06–0,12	0,06–0,14
1.10	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14	0,06–0,14	0,06–0,14
1.11	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14	0,06–0,14	0,06–0,14
1.12	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14	0,06–0,14	0,06–0,14
1.13	200–280	140–220	0,02–0,04	0,04–0,06	0,06–0,08	0,06–0,12	0,06–0,14	0,06–0,14	0,06–0,14
1.14	70–110	50–90	0,02–0,04	0,03–0,04	0,04–0,06	0,04–0,08	0,04–0,1	0,05–0,12	0,05–0,12
1.15	170–230	120–200	0,02–0,04	0,04–0,06	0,06–0,08	0,05–0,1	0,05–0,1	0,05–0,1	0,05–0,12
1.16	170–230	120–200	0,02–0,04	0,04–0,06	0,06–0,08	0,05–0,1	0,05–0,1	0,05–0,1	0,05–0,12
2.1		150–210	0,02–0,04	0,04–0,06	0,04–0,08	0,06–0,12	0,06–0,12	0,06–0,12	0,08–0,12
2.2		150–210	0,02–0,04	0,04–0,06	0,04–0,08	0,06–0,12	0,06–0,12	0,06–0,12	0,08–0,12
2.3		150–210	0,02–0,04	0,04–0,06	0,04–0,08	0,06–0,12	0,06–0,12	0,06–0,12	0,08–0,12
2.4		120–200	0,02–0,04	0,04–0,06	0,04–0,06	0,06–0,1	0,06–0,1	0,06–0,1	0,08–0,12
2.5		110–190	0,02–0,04	0,04–0,06	0,04–0,06	0,06–0,1	0,06–0,1	0,06–0,1	0,08–0,1
2.6		120–200	0,02–0,04	0,04–0,06	0,04–0,06	0,06–0,1	0,06–0,1	0,06–0,1	0,08–0,12
2.7		110–190	0,02–0,04	0,04–0,06	0,04–0,06	0,06–0,1	0,06–0,1	0,06–0,1	0,08–0,1
3.1	160–320	140–220	0,06–0,08	0,06–0,1	0,06–0,12	0,08–0,18	0,08–0,18	0,08–0,18	0,1–0,23
3.2	160–320	140–220	0,06–0,08	0,06–0,1	0,06–0,12	0,08–0,18	0,08–0,18	0,08–0,18	0,1–0,23
3.3	120–200	140–220	0,04–0,06	0,06–0,08	0,06–0,12	0,08–0,18	0,08–0,18	0,08–0,18	0,1–0,23
3.4	100–180	120–180	0,04–0,06	0,06–0,08	0,06–0,12	0,08–0,18	0,08–0,18	0,08–0,18	0,1–0,23
3.5	90–150	110–170	0,06–0,08	0,06–0,1	0,08–0,14	0,1–0,23	0,1–0,23	0,1–0,23	0,1–0,23
3.6	90–150	110–170	0,06–0,08	0,06–0,1	0,08–0,14	0,1–0,23	0,1–0,23	0,1–0,23	0,1–0,23
3.7	90–150	110–170	0,06–0,08	0,06–0,1	0,08–0,14	0,1–0,23	0,1–0,23	0,1–0,23	0,1–0,23
3.8	90–150	110–170	0,06–0,08	0,06–0,1	0,08–0,14	0,1–0,23	0,1–0,23	0,1–0,23	0,1–0,23
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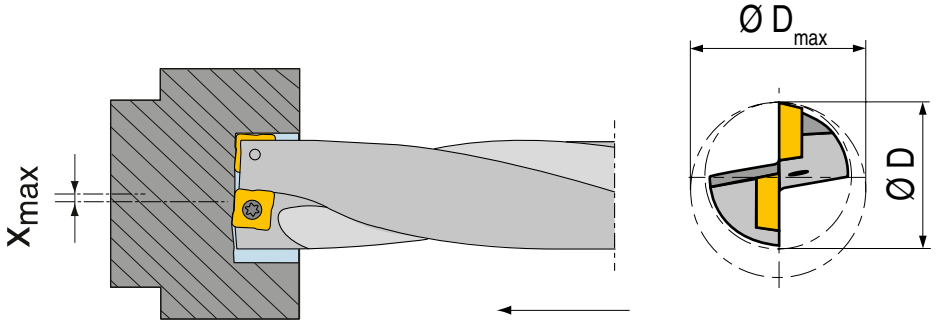
During the drilling operation on through holes a sharp disk will be produced.
Safety precautions must be observed.
A safety guard has to be provided as protection.

In order to ensure efficient chip evacuation,
coolant pressure must be at least 5 bar.
Optimum pressure is > 15 bar.

Maximum adjustment range (X) during solid drilling / from the centre for stationary applications – KUB Pentron



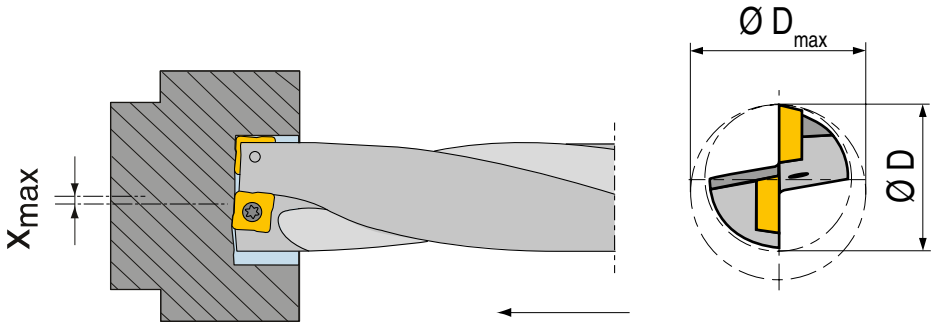
At max. offset X_{max} the hole will be:
$D_{max} = D + 2X_{max}$
e.g. for D = 20.0 mm, X_{max} = 0.20 mm:
$D_{max} = D + 0.4 = 20.4$ mm

Ø D mm	Insert Size	X_{max} mm	Ø D_{max} mm
14	SOGX 04....	0,25	14,5
14,5		0,25	15,0
15,0		0,25	15,5
15,5		0,25	16,0
16,0		0,25	16,5
16,5	SOGX 05....	0,25	17,0
17,0		0,25	17,5
17,5		0,25	18,0
18,0		0,25	18,5
18,5	SOGX 06....	0,25	19,0
19,0		0,25	19,5
19,5		0,25	20,0
20,0		0,25	20,5
20,5	SOGX 07....	0,25	21,0
21,0		0,25	21,5
21,5		0,25	22,0
22,0		0,25	22,5
22,5		0,25	23,0
23,0		0,25	23,5
23,5	SOGX 08....	0,25	24,0
24,0		0,25	24,5
24,5		0,25	25,0
25,0		0,25	25,5
25,5		0,25	26,0
26,0		0,25	26,5
26,5	SOGX 09....	0,25	27,0
27,0		0,25	27,5
27,5		0,25	28,0
28,0		0,25	28,5
28,5		0,25	29,0
29,0		0,25	29,5
29,5		0,25	30,0
30,0		0,25	30,5
31,0	SOGX 10....	0,25	31,5
32,0		0,25	32,5
33,0		0,25	33,5

Ø D mm	Insert Size	X_{max} mm	Ø D_{max} mm
34,0	SOGX 11....	0,25	34,5
35,0		0,25	35,5
36,0		0,25	36,5
37,0		0,25	37,5
38,0	SOGX 12....	0,25	38,5
39,0		0,25	39,5
40,0		0,25	40,5
41,0		0,25	41,5
42,0		0,25	42,5
43,0	SOGX 13....	0,25	43,5
44,0		0,25	44,5
45,0		0,25	45,5
46,0		0,25	46,5

The maximum radial X-offset affects the cutting force balance of the drill, therefore, the use of lower feed rates is recommended!

Maximum off set (X) for drilling into full material / with stationary applications – MaxiDrill 900 + KUB 100



At max. offset X_{max} the hole will be:
$D_{max} = D + 2X_{max}$
e.g. for D = 20.0 mm, X_{max} = 0.20 mm:
$D_{max} = D + 0.4 = 20.4$ mm

Ø D mm	Insert Size	X_{max} mm	Ø D_{max} mm
12,0	SONT 03....	0,50	13,0
12,5		0,40	13,3
13,0		0,35	13,7
13,5		0,30	14,1
14,0	SONT 04....	0,35	14,7
14,5		0,25	15,0
15,0		0,20	15,4
15,5		0,15	15,8
16,0	SONT 05....	0,40	16,8
16,5		0,35	17,2
17,0		0,30	17,6
17,5		0,25	18,0
18,0	SONT 06....	0,50	19,0
18,5		0,40	19,3
19,0		0,35	19,7
19,5		0,25	20,0
20,0		0,20	20,4
20,5		0,15	20,8
21,0	SONT 07....	0,35	21,7
21,5		0,30	22,1
22,0		0,25	22,5
22,5		0,15	22,8
23,0		0,15	23,3
23,5		0,10	23,7
24,0	SONT 08....	0,65	25,3
24,5		0,55	25,6
25,0		0,55	26,1
25,5		0,40	26,3
26,0		0,35	26,7
26,5		0,30	27,1
27,0		0,25	27,5
27,5		0,15	27,8
28,0	SONT 09....	0,90	29,8
28,5		0,80	30,1
29,0		0,75	30,5
29,5		0,70	30,9
30,0		0,60	31,2
30,5		0,55	31,6
31,0		0,45	31,9
31,5		0,40	32,3
32,0		0,30	32,6

Ø D mm	Insert Size	X_{max} mm	Ø D_{max} mm
32,5	SONT 10....	0,80	34,1
33,0		0,80	34,6
33,5		0,65	34,8
34,0		0,60	35,2
34,5		0,50	35,5
35,0		0,45	35,9
35,5		0,35	36,2
36,0		0,35	36,7
36,5		0,20	36,9
37,0	SONT 12....	1,00	39,0
38,0		0,85	39,7
39,0		0,70	40,4
40,0		0,50	41,0
41,0		0,35	41,7
42,0	SONT 13....	0,95	43,9
43,0		0,80	44,6
44,0		0,60	45,2
45,0		0,45	45,9
46,0		0,30	46,6
47,0	SONT 15....	1,80	50,6
48,0		1,65	51,3
49,0		1,50	52,0
50,0		1,35	52,7
51,0		1,15	53,3
52,0		0,95	53,9
53,0		0,80	54,6
54,0		0,60	55,2
55,0	SONT 17....	2,10	59,2
56,0		1,90	59,8
57,0		1,75	60,5
58,0		1,55	61,1
59,0		1,35	61,7
60,0		1,15	62,3
61,0		1,00	63,0
62,0		0,85	63,7
63,0		0,65	64,3

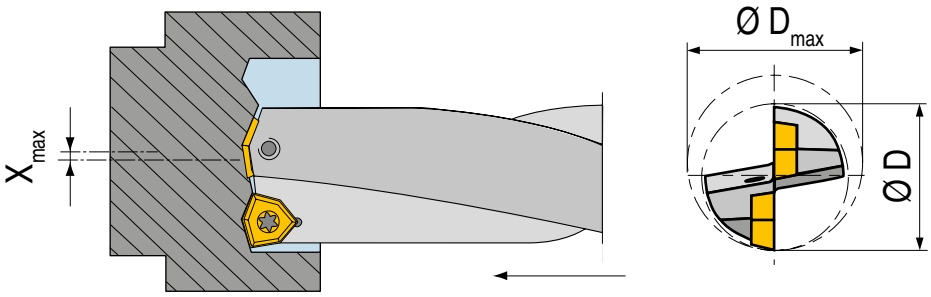
The maximum radial X-offset affects the cutting force balance of the drill, therefore, the use of lower feed rates is recommended!

Technical data for turning – MaxiDrill 900

Insert Size	$a_{p\,max.}$ in mm	f in mm/rev.
SONT 03	0,40–1,50	0,08–0,22
SONT 04	0,40–1,80	0,09–0,27
SONT 05	0,60–2,40	0,10–0,30
SONT 06	0,60–2,80	0,11–0,34
SONT 07	0,60–3,40	0,13–0,38
SONT 08	0,70–4,20	0,15–0,41

Insert Size	$a_{p\,max.}$ in mm	f in mm/rev.
SONT 09	0,70–4,50	0,16–0,42
SONT 10	0,70–4,80	0,17–0,44
SONT 12	0,90–5,50	0,18–0,45
SONT 13	1,00–6,00	0,20–0,45
SONT 15	1,20–6,40	0,21–0,46
SONT 17	1,20–6,70	0,21–0,47

Maximum adjustment range (X) during solid drilling / from the centre for stationary applications – KUB Trigon



At max. offset X_{max} the hole will be:
$D_{max} = D + 2X_{max}$
e.g. for D = 20.0 mm, X_{max} = 0.20 mm:
$D_{max} = D + 0.4 = 20.4$ mm

Ø D mm	Insert Size	X_{max} mm	Ø D_{max} mm
14,0	WOEX 03....	0,5	15,0
15,0		0,5	16,0
16,0		0,5	17,0
17,0		0,5	18,0
18,0		0,5	19,0
19,0		0,5	20,0
20,0	WOEX 04....	0,5	21,0
21,0		0,5	22,0
22,0		0,5	23,0
23,0		0,5	24,0
24,0		0,5	25,0
25,0	WOEX 05....	0,5	26,0
26,0		1,0	28,0
27,0		1,5	30,0
28,0		1,5	31,0
29,0		1,5	32,0
30,0		1,25	32,5
31,0		1,25	33,5
32,0		1,0	34,0
33,0		0,5	34,0
34,0		0,5	35,0
35,0		0,5	36,0
36,0		0,5	37,0

Ø D mm	Insert Size	X_{max} mm	Ø D_{max} mm
37	WOEX 06....	1,5	40,0
38		1,5	41,0
39		1,5	42,0
40		1,5	43,0
41		1,5	44,0
42		1,5	45,0
43		1,0	45,0
44		0,5	45,0

The maximum radial X-offset affects the cutting force balance of the drill, therefore, the use of lower feed rates is recommended!

Coding example indexable insert drilling

System	Length	Bore diameter	Direction of rotation	Insert size	Machine connection and size
MD-900	4D	240	R	08	C 32
KUB-T	2D	350	R	05	K 32
KUB-P	3D	215	R	07	ABS 50
KUB-P	3D	290	R	04	PSC 63
KUB-100	3D	300	R	07	C 25

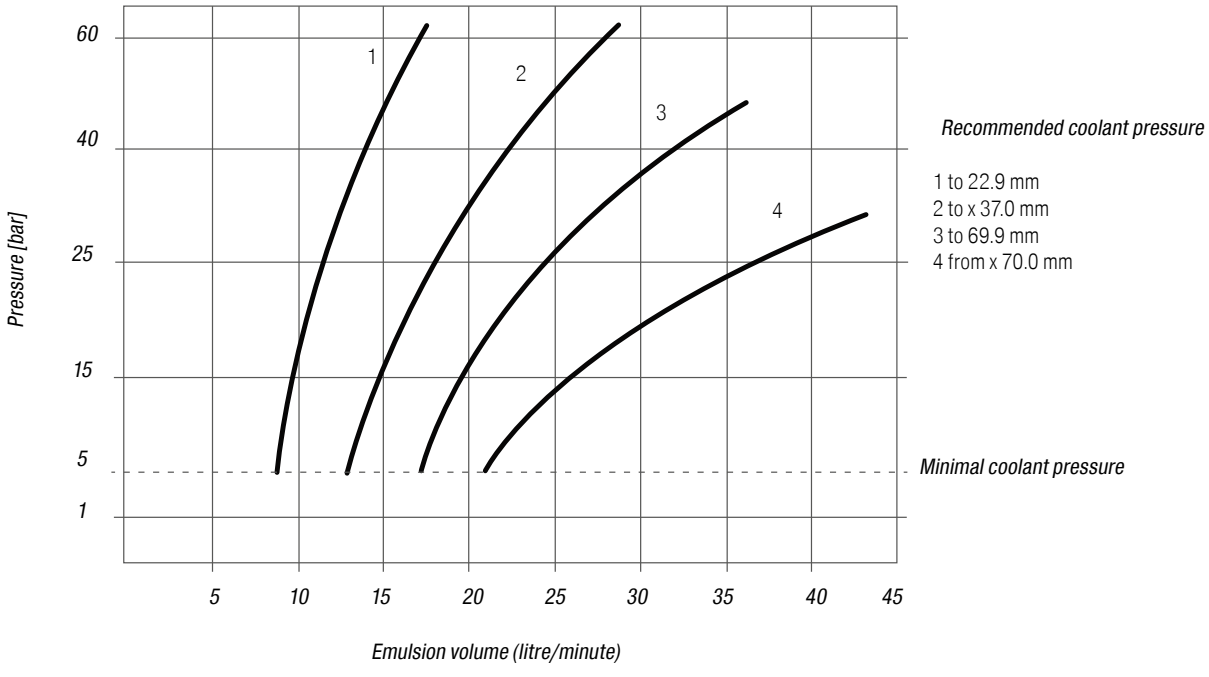
- MD-900 = MaxiDrill 900
- KUB-P = KUB Pentron
- KUB-T = KUB Trigon
- KUB-100 = KUB 100

- 240 = 24.0 mm
- 350 = 35.0 mm
- 215 = 21.5 mm
- 290 = 29,0 mm
- 300 = 30,0 mm

- R = right

- C32 = Cylindrical shank Ø 32.0 mm
- K32 = Cylindrical shank with combi clamping flat Ø 32.0 mm
- ABS50 = ABS adapter size 50
- PSC63 = PSC adapter shank size 63
- C25 = Cylindrical Shank Ø 25.0 mm

Recommended coolant pressure and coolant flow

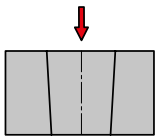


Problems / possible causes / solutions

Rotating and stationary application

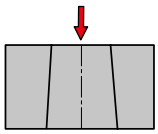
Short service life / types of wear of indexable inserts

- Cutting speed too high → select the correct cutting speed
- Insert grade selection has too little wear resistance → select a wear resistant grade
- Tool overhang too large → if possible, use a shorter tool
- Damaged insert seat → check tool, replace if necessary
- Clamping device stability too low → increase stability



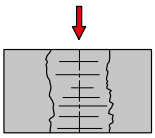
Hole tapers in

- Chip jam on the outer cutting edge → use a different chip breakage geometry, increase the feed if necessary
- Material very soft → increase the cutting speed, reduce the feed
- Use a positive cutting edge geometry



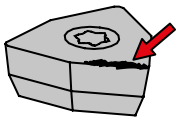
Hole tapers out

- Chip jam on the inner cutting edge → use a different chip breakage geometry, increase the feed if necessary



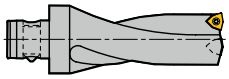
Poor surface quality

- Poor chip evacuation → optimise the cutting parameters: Increase the cutting speed, reduce the feed



Built-up edge

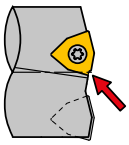
- Cutting speed too low → increase cutting speed
- Indexable insert too negative → use positive geometry
- Unsuitable coating → select the correct coating



Friction marks on the tool shank

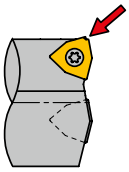
- Bore diameter too small → check the setting
- Chip evacuation problems → optimise the cutting parameters, check the geometry of the indexable insert
- Cutting radius too high → use the correct cutting radius

Stationary application



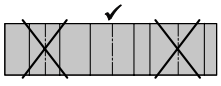
Edge breakage on the inner cutting edge

- Centre height of the tool too high/too low → adjust tool turret/adapter if necessary → Recalibrate the machine
- Indexable insert grades interchanged → use correct indexable insert
- Feed too high → reduce feed
- Indexable insert grade too brittle → use a tougher indexable insert grade
- Incorrect indexable insert geometry → if necessary use a geometry with a chamfered cutting edge



Edge breakage on the outer cutting edge

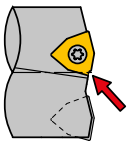
- Feed too high → reduce feed
- Interrupted cut → switch to a tougher grade of indexable insert
- Cutting radius too small → use an indexable insert with a larger cutting radius



Hole too small / too large

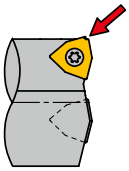
- Machine is not in the X-0 position → move axis to correct position
- Machine axis has been moved → recalibrate the machine

Rotating application



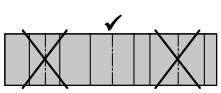
Edge breakage on the inner cutting edge

- Indexable insert grades interchanged → use correct indexable insert
- Feed too high → reduce feed
- Indexable insert grade too brittle → use a tougher indexable insert grade
- Incorrect indexable insert geometry → if necessary use a geometry with a chamfered cutting edge



Edge breakage on the outer cutting edge

- Feed too high → reduce feed
- Interrupted cut → switch to a tougher grade of indexable insert
- Cutting radius too small → use an indexable insert with a larger cutting radius



Hole too small / too large when using adjustable tools

- Incorrect cutting radius used → use the correct cutting radius
- Incorrect setting → use the correct tool setting
- Increase cutting fluid supply

Grades Overview

CTPP430
CCN1430

- Carbide, TiAlN-coated
- ISO | **P30** | **M25** | S25 | K30 | N25
- The universal high-performance grade for steel, austenitic steel and heat-resistant alloys

BK8425

- Carbide, TiAlN/TiN-coated
- ISO | **P25** | **M25** | **K25**
- Universally applicable grade with increased wear resistance thanks to the innovative PVD coating in a multilayer design

CTCP420
DCX1420

- Carbide, TiCN-Al_2O_3-coated
- ISO | **P20** | **K20** | M20
- The wear-resistant solution for steel and cast iron materials at high cutting speeds

BK6115

- Carbide, TiCN-TiN-Al_2O_3-coated
- ISO | **P20** | **K20** | H20
- High-quality, surface-treated coating for machining cast iron materials under normal to stable conditions and high cutting speeds

BK7710

- Carbide, TiB_2-coated
- ISO | **N10** | S10
- The wear-resistant grade with optimum cutting characteristics to prevent built-up edge formation for machining aluminium and titanium alloys

BK7935

- Carbide, AlTiN-coated
- ISO | **P35** | **M30** | S30 | K30| N30
- The tough carbide grade for machining stainless steel and acid-resistant steels as well as special alloys

BK6425

- Carbide, TiCN-Al_2O_3-TiN-coated
- ISO | **P25 | M15**| K20
- The extremely wear-resistant grade for machining all steel and stainless materials

BK77

- Carbide, TiN-coated
- ISO | **S10** | **N10**
- The wear-resistant carbide grade for machining aluminum alloys, superalloys and plastics at medium cutting speeds

BK62

- Carbide, TiN-TiCN-Al_2O_3-coated
- ISO | **K15** | H15
- Special carbide grade for machining cast iron materials at high cutting speeds
  Not suitable for machining aluminium materials

Chip breakers

-01

- Universal geometry suitable for a wide range of materials
- Can be used for the center and peripheral insert

-03

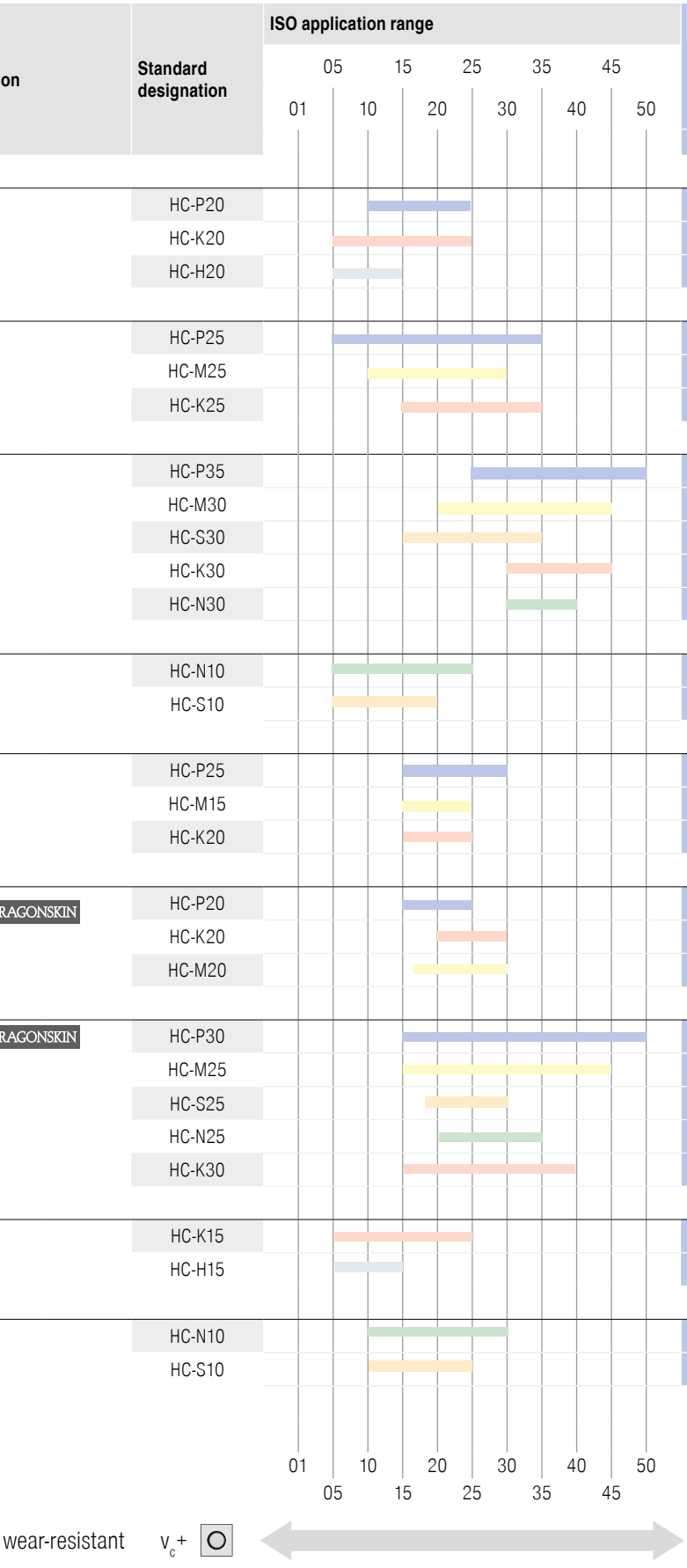
- Geometry for chip breaking problems with excellent chip control at low feed rates
- Can only be used for the peripheral insert
- Main application in low alloyed and stainless steels

-11

- Highly positive, minimally rounded chip breaker
- For soft cutting use
- Main application in aluminum

-13

- Very positive geometry for low alloy, stainless and acid-resistant steels
- Can be used for the center and peripheral insert
- Due to the low cutting forces well suited to unstable conditions

Application

Grade designation	Standard designation	Steel P	Stainless steel M	Cast iron K	Non ferrous metals N	Heat resistant alloys S	Hardened materials H
BK6115	HC-P20	●					
	HC-K20			●			
	HC-H20						○
BK8425	HC-P25	●					
	HC-M25		●				
	HC-K25			●			
BK7935	HC-P35	●					
	HC-M30		●				
	HC-S30					○	
	HC-K30			○			
	HC-N30				○		
BK7710	HC-N10				●		
	HC-S10					○	
BK6425	HC-P25	●					
	HC-M15		●				
	HC-K20			○			
CTCP420 (DCX1420) DRAGONSKIN	HC-P20	●					
	HC-K20			●			
	HC-M20		○				
CTPP430 (CCN1430) DRAGONSKIN	HC-P30	●					
	HC-M25		●				
	HC-S25					○	
	HC-N25				○		
	HC-K30			○			
BK62	HC-K15			●			
	HC-H15						○
BK77	HC-N10				●		
	HC-S10					●