

KORLOY Indexable New Generation Economical Drill

KED Plus Drill

KORLOY
TECH-NEWS



- 최적의 칩 플루트 설계로 칩 배출공간 확대를 통한 칩 처리성이 우수한 경제형 드릴
- 내 · 외인의 최적화한 형상 및 인선 배열로 안정적 가공실현

고능률 작업이 가능한 경제형 인덱서블 드릴 KED Plus Drill

KED Plus Drill은 경제형 드릴로서 소구경과 대구경의 칩 플루트를 각 규격별 최적의 드릴링이 되도록 설계한 경제형 드릴입니다.

KED Plus Drill 홀더는 칩 형상을 고려하여 소구경($\varnothing 12 - \varnothing 23.5$)에 맞는 절삭유 방식 및 칩 플루트 설계로 칩 처리성이 좋고, 중대구경($\varnothing 24 - \varnothing 60.5$) 영역은 드릴 최적의 설계 및 칩 배출 공간을 대폭 확장하여 깊은 홀 가공에서도 드릴링이 안정되고 표면조도의 품질이 우수하도록 구현하였습니다.

또한 King Drill과 더불어 드릴 인경의 2-5배까지 안정적인 가공을 실현할 수 있도록 내/외인 드릴의 인서트 차별화로 드릴의 센터링 및 밸런스를 최적화하였습니다.

KED Plus Drill 인서트는 범용성이 우수한 PD 칩브레이커, 연질/난삭재 전용 LD 칩브레이커, 알루미늄 가공을 위한 ND 칩브레이커와 같이 3종으로 다양한 가공영역에 적용할 수 있으며, 내인과 외인의 절삭 수명 특성에 맞는 최적의 재종을 적용하여 가공 수명이 우수합니다.



생산 비용 절감

— 뛰어난 성능의 경제형 드릴

안정적 가공

— 내 · 외인 차별화 및 최적의 인선 배열

우수한 칩 처리성 및 면조도

— 피삭재별 다양한 칩브레이커

내치핑성, 내마모성

— 피삭재별 다양한 대응 재종

형번표기법

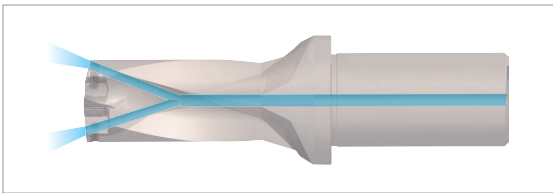
【홀더】

E	4D	-	200	25	-	07	-	P
KING, Economical	절입깊이(L/D) 2D, 3D, 4D, 5D		드릴직경 200: Ø20.0 (소수점 1자리 표기)	상크직경 Ø20, Ø25 Ø32, Ø40		적용인서트 내접원 04, 05, 06, 07, 09, 11, 13, 15, 18		Plus

홀더 특징

- 소구경(Ø12-Ø23.5) 영역에 적합한 절삭유 방식 및 칩 플루트 설계로 칩 처리성 우수
- 중대구경(Ø24-Ø60.5) 영역에 맞는 최적의 설계 및 칩 배출 공간을 대폭 확장하여 깊은 홀 가공에서도 안정적인 드릴링 가공 및 표면조도 우수
- 최적 플루트 형상 적용으로 홀더 강성 강화, 칩 배출성 향상

최적 플루트 시스템 - 2개의 쿨런트 접목



외측 인서트



내측 인서트

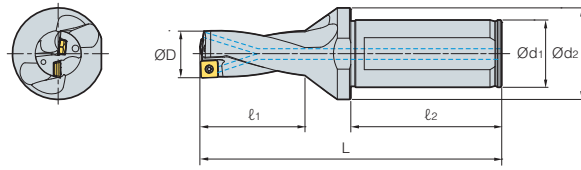


인서트 특징

- 드릴 가공 메카니즘에 맞춘 최적의 인서트 형상 구현
- 내인과 외인의 가공 특성에 맞는 형상과 칩브레이커를 적용하여 칩 처리성이 우수하고 가공 품위가 뛰어남
- 내인과 외인의 절삭 수명 특성에 맞는 최적의 재종을 적용하여 가공 수명 우수

칩브레이커	PD		LD		ND		RD
특징	- 범용 - 중속, 중이송		- 롭칩 발생하는 피삭재 (연강, 스테인레스강)에서 우수한 칩 처리성 - 경절삭(저-중속, 저이송)		- 알루미늄 가공에 적합한 샤프한 인선 적용 - 표면 버핑처리로 칩 흐름 및 내용착성 우수 - 연삭급 공차(E급)		- 내치핑성 강화 - 코너파손이 빈번히 일어나는 가공에서 우수한 성능
내·외인	외인	내인	외인	내인	외인	내인	내인
형상							
재종: 피삭재 계열	NC5330: P, M, K PC3700: P PC5300: P, M, K, S PC6510: K		PC5300: P, M, K, S		PC5335: P, M		H01: N PC5300: P, M, K, S

드릴 및 홀 공차

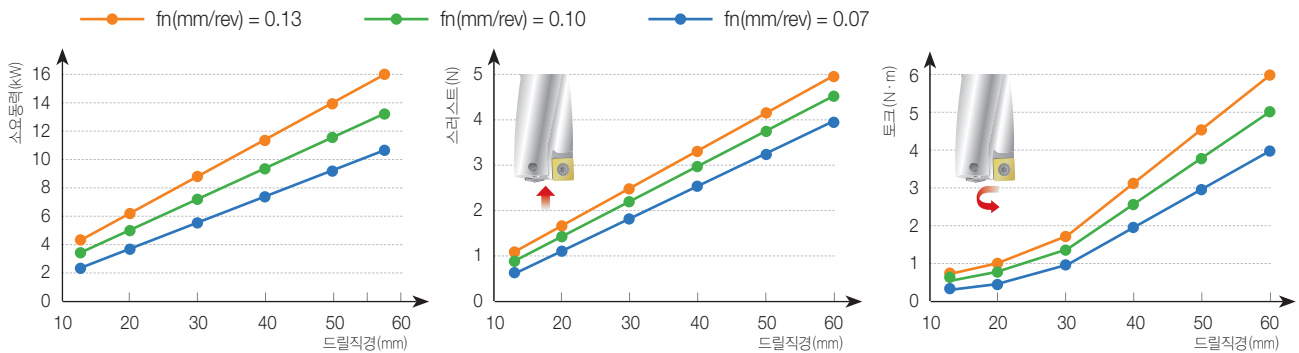


(mm)

드릴직경		Ø12-Ø29	Ø30-Ø45	Ø46-Ø60.5
2D-3D	드릴 공차(ØD)	-0.15 ~ 0	-0.15 ~ 0	-0.15 ~ 0
	홀 공차	-0.1 ~ +0.2	-0.1 ~ +0.25	-0.1 ~ +0.28
4D-5D	드릴 공차(ØD)	-0.15 ~ 0	-0.15 ~ 0	-0.15 ~ 0
	홀 공차	-0.05 ~ +0.25	-0.05 ~ +0.3	-0.05 ~ +0.33

절삭소요 동력

- 피삭재 SCM440(240HB)
- 절삭조건 $vc(m/min) = 100$, 내부급유

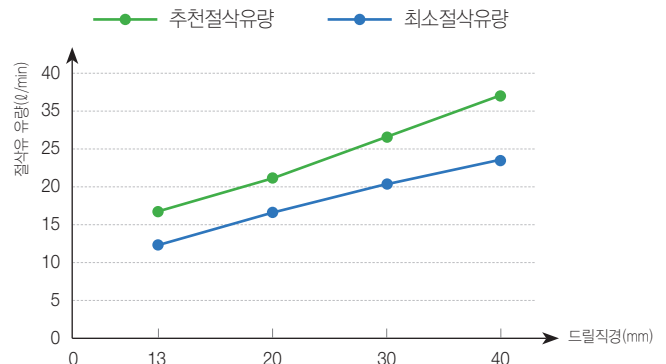


※ 충분한 기계 강성과 동력을 갖춘 설비 기준으로 드릴 가공에 소요되는 절삭력을 표기함

절삭유 유량

- 피삭재 SCM440(240HB)
- 절삭조건 $vc(m/min) = 100$, 내부급유

※ 우측 그래프는 드릴가공의 일반적인 수치를 나타낸 것으로 피삭재와 절삭조건에 따라 조정 필요



절삭평가 사례

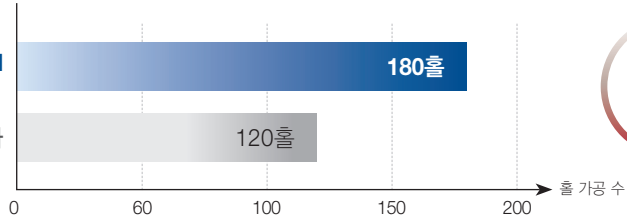
탄소강(SM440)

- 절삭조건 $vc(m/min) = 150$, $fn(mm/rev) = 0.1$, $ap(mm) = 80$ (관통), 습식(wet)
- 공 구 인서트 SPMT060205-PD(PC3700) 홀더 E4D-18025-06-P
XOMT060204-PD(PC5300) (공구직경 = $\varnothing 18mm$)



KED Plus Drill

타사



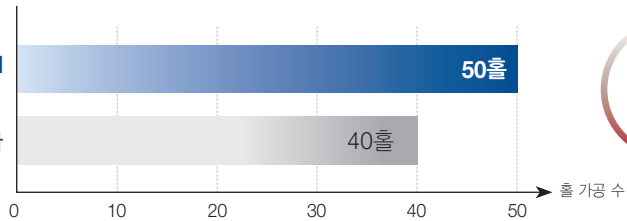
스테인레스강(STS316)

- 절삭조건 $vc(m/min) = 120$, $fn(mm/rev) = 0.06$, $ap(mm) = 42$, 습식(wet)
- 공 구 인서트 SPMT060205-PD(PC5300) 홀더 E3D-18025-06-P
XOMT060204-PD(PC5300) (공구직경 = $\varnothing 18mm$)



KED Plus Drill

타사

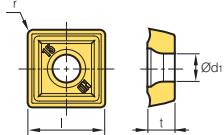
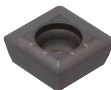
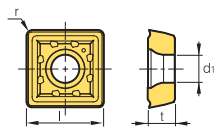
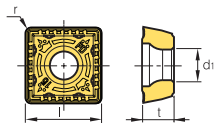
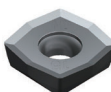
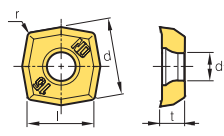


추천절삭조건

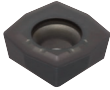
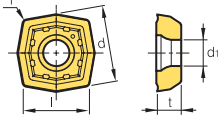
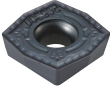
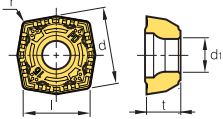
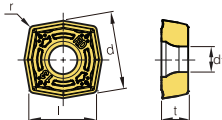
피삭재 구분			인서트			절삭속도 vc(m/min)	이송(절입 깊이 = 2D, 3D, 4D) 드릴직경(mm)에 따른 이송(mm/rev)				
ISO	피삭재 재질	경도(HB)	칩브레이커	재종			Ø12-Ø16	Ø17-Ø23	Ø24-Ø29	Ø30-Ø42	Ø43-Ø60
				내인	외인						
P 탄소강	저탄소강	80-180	LD	PC5335	PC5335	120(60-170)	0.04-0.08	0.04-0.08	0.04-0.08	0.04-0.08	0.04-0.08
			PD/RD	PC5300	PC3700	150(120-180)					
	고탄소강	180-280	PD	PC5300	PC3700	120(90-150)	0.04-0.10	0.04-0.12	0.05-0.16	0.06-0.16	0.06-0.18
					NC5330	150(110-190)	0.04-0.06	0.04-0.07	0.04-0.08	0.04-0.08	0.04-0.08
P 합금강	저합금강	140-260	LD	PC5335	PC5335	120(60-160)	0.06-0.10	0.06-0.10	0.06-0.12	0.06-0.14	0.06-0.14
			PD	PC5300	PC3700	150(120-170)	0.06-0.12	0.06-0.12	0.06-0.14	0.06-0.16	0.06-0.16
					NC5330	180(140-210)	0.06-0.08	0.06-0.08	0.06-0.10	0.06-0.12	0.06-0.12
	저합금 열처리강	200-400	PD	PC5300	PC5300	100(50-150)	0.04-0.10	0.06-0.10	0.06-0.12	0.06-0.14	0.06-0.14
	고합금강	260-320	PD	PC5300	PC3700	100(50-160)	0.05-0.11	0.05-0.11	0.05-0.13	0.05-0.15	0.05-0.15
	고합금 열처리강	300-450	PD	PC5300	PC5300	70(30-120)	0.04-0.08	0.06-0.08	0.06-0.10	0.06-0.12	0.06-0.12
M 스테인레스강	스테인레스강	135-275	LD	PC5335	PC5335	120(80-140)	0.04-0.07	0.04-0.07	0.04-0.07	0.04-0.08	0.04-0.08
			PD	PC5300	PC5300	130(100-160)	0.04-0.07	0.04-0.07	0.04-0.07	0.04-0.08	0.04-0.08
K 주철	회주철	150-230	PD	PC5300	PC6510	190(150-250)	0.04-0.12	0.05-0.14	0.06-0.18	0.10-0.22	0.10-0.26
	덕타일주철	150-230	PD	PC5300	PC6510	130(100-160)	0.04-0.07	0.04-0.08	0.04-0.10	0.05-0.12	0.05-0.12
S 내열강	Ni내열합금	130-400	PD	PC5300	PC5300	50(30-100)	0.04-0.10	0.04-0.10	0.04-0.10	0.04-0.10	0.04-0.10
	Ti내열합금	130-400	LD	PC5335	PC5335	60(40-80)	0.04-0.08	0.04-0.10	0.06-0.12	0.06-0.14	0.06-0.16
			PD	PC5300	PC5300	60(40-80)	0.04-0.08	0.04-0.10	0.06-0.12	0.06-0.14	0.06-0.16
	고경도강	400 이상	PD	PC5300	PC5300	40(20-80)	0.04-0.05	0.04-0.06	0.04-0.08	0.04-0.08	0.04-0.08
N 알루미늄	알루미늄	30-150	ND	H01	H01	300(250-400)	0.05-0.14	0.06-0.16	0.10-0.20	0.10-0.22	0.12-0.25
	동합금	150-160	ND	H01	H01	250(200-300)	0.05-0.14	0.06-0.16	0.10-0.20	0.10-0.22	0.12-0.25

※ 5D 홀더의 최대이송은 2D, 3D, 4D 홀더의 최대 이송(fn) x 70%~80% 적용

※ 단속 가공의 경우 단속부위에서 이송(fn) 30%~50% 감소

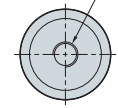
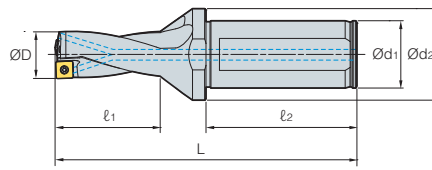
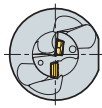
형상	형번	코팅								초경	치수(mm)					형상도면
		NC5330	NCM535	PC3700	PC5335	PC9530	PC6510	PC5300	PC5400		l	d	t	r	d1	
	SPET	040204-ND								●	4.7	-	2.4	0.4	2.3	
		050204-ND								●	5.1	-	2.4	0.4	2.3	
		060205-ND								●	6.2	-	2.5	0.5	2.5	
		07T208-ND								●	7.5	-	2.8	0.7	2.8	
		090308-ND								●	9.2	-	3.3	0.8	3.4	
		11T308-ND								●	11.0	-	4.0	0.8	4.0	
		130410-ND								●	13.0	-	4.5	1.0	4.5	
		15M510-ND								●	15.2	-	5.0	1.0	5.5	
		180510-ND								●	18.2	-	5.5	1.0	6.0	
	SPMT	060205-LD			●						6.2	-	2.5	0.5	2.5	
		07T208-LD			●						7.5	-	2.8	0.7	2.8	
		090308-LD			●						9.2	-	3.3	0.8	3.4	
		11T308-LD			●						11.0	-	4.0	0.8	4.0	
		130410-LD			●						13.0	-	4.5	1.0	4.5	
		15M510-LD			●						15.2	-	5.0	1.0	5.5	
		180510-LD			●						18.2	-	5.5	1.0	6.0	
	SPMT	040204-PD	●	●			●	●			4.7	-	2.4	0.4	2.3	
		050204-PD	●	●	●		●	●			5.1	-	2.4	0.4	2.3	
		060205-PD	●	●	●		●	●			6.2	-	2.5	0.5	2.5	
		07T208-PD	●	●	●		●	●			7.5	-	2.8	0.7	2.8	
		090308-PD	●	●	●		●	●			9.2	-	3.3	0.8	3.4	
		11T308-PD	●	●	●		●	●			11.0	-	4.0	0.8	4.0	
		130410-PD	●	●	●		●	●			13.0	-	4.5	1.0	4.5	
		15M510-PD	●	●	●		●	●			15.2	-	5.0	1.0	5.5	
		180510-PD	●	●	●		●	●			18.2	-	5.5	1.0	6.0	
	XOET	040204-ND								●	4.3	4.9	2.4	0.4	2.3	
		050204-ND								●	4.8	5.4	2.4	0.4	2.3	
		060204-ND								●	5.8	6.6	2.5	0.4	2.5	
		07T205-ND								●	6.9	7.8	2.8	0.5	2.8	
		090305-ND								●	8.4	9.6	3.3	0.5	3.4	
		11T306-ND								●	10.0	11.4	4.0	0.6	4.0	
		130406-ND								●	11.9	13.6	4.5	0.6	4.5	
		15M508-ND								●	13.9	15.9	5.0	0.8	5.5	
		180508-ND								●	16.5	18.9	5.5	0.8	6.0	

●: 재고 관리 형번

형상	형번	코팅							초경	치수(mm)					형상도면	
		NC5330	NCM535	PC3700	PC5335	PC9530	PC6510	PC5300	PC5400	H01	l	d	t	r		d ₁
	XOMT	060204-LD			●						5.8	6.6	2.5	0.4	2.5	
		07T205-LD			●						6.9	7.8	2.8	0.5	2.8	
		090305-LD			●						8.4	9.6	3.3	0.5	3.4	
		11T306-LD			●						10.0	11.4	4.0	0.6	4.0	
		130406-LD			●						11.9	13.6	4.5	0.6	4.5	
		15M508-LD			●						13.9	15.9	5.0	0.8	5.5	
		180508-LD			●						16.5	18.9	5.5	0.8	6.0	
	XOMT	040204-PD						●			4.3	4.9	2.4	0.4	2.3	
		050204-PD						●			4.8	5.4	2.4	0.4	2.3	
		060204-PD						●			5.8	6.6	2.5	0.4	2.5	
		07T205-PD						●			6.9	7.8	2.8	0.5	2.8	
		090305-PD						●			8.4	9.6	3.3	0.5	3.4	
		11T306-PD						●			10.0	11.4	4.0	0.6	4.0	
		130406-PD						●			11.9	13.6	4.5	0.6	4.5	
		15M508-PD						●			13.9	15.9	5.0	0.8	5.5	
		180508-PD						●			16.5	18.9	5.5	0.8	6.0	
	XOMT	07T207-RD						●			6.9	7.8	2.8	0.7	2.8	
		090308-RD						●			8.4	9.6	3.3	0.8	3.4	
		11T309-RD						●			10.0	11.4	4.0	0.9	4.0	
		130410-RD						●			11.9	13.6	4.5	1.0	4.5	
		15M511-RD						●			13.9	15.9	5	1.1	5.5	
		180512-RD						●			16.5	18.9	5.5	1.2	6.0	

●: 재고 관리 형번

KED Plus Drill (2D)

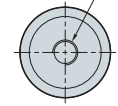
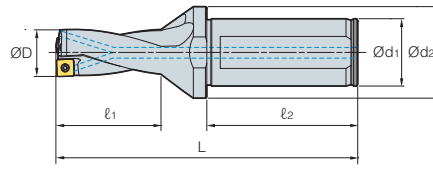
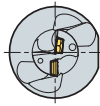


(mm)

형 번	재고	ØD	Ød1	Ød2	l1	l2	L	PT	적용인서트	스크류	렌치
E2D-	12020-04-P	12.0	20	25	27	50	91	1/8	SP□T040204-□□ XO□T040204-□□	FTNA0204	TW06P
	12520-04-P	12.5	20	25	27	50	91				
	13020-04-P	● 13.0	20	25	29	50	93				
	13520-04-P	● 13.5	20	25	29	50	93				
	14020-05-P	● 14.0	20	25	31	50	96				
	14520-05-P	● 14.5	20	25	31	50	96				
	15020-05-P	● 15.0	20	25	33	50	99		SP□T050204-□□ XO□T050204-□□	FTNA0204	TW06P
	15520-05-P	● 15.5	20	25	33	50	99				
	16020-05-P	● 16.0	20	25	35	50	101				
	16525-06-P	● 16.5	25	34	35	56	107				
	17025-06-P	● 17.0	25	34	37	56	109				
	17525-06-P	● 17.5	25	34	37	56	109		SP□T060205-□□ XO□T060204-□□	FTKA02206S	TW07P
	18025-06-P	● 18.0	25	34	39	56	112				
	18525-06-P	● 18.5	25	34	39	56	112				
	19025-06-P	● 19.0	25	34	41	56	114				
	19525-06-P	● 19.5	25	34	41	56	114				
	20025-07-P	● 20.0	25	34	43	56	118		SP□T07T208-□□ XO□T07T205-□□	FTKA02565	TW07S
	20525-07-P	● 20.5	25	34	43	56	118				
	21025-07-P	● 21.0	25	34	45	56	120				
	21525-07-P	● 21.5	25	34	45	56	120				
	22025-07-P	● 22.0	25	34	47	56	122				
	22525-07-P	● 22.5	25	34	47	56	122				
	23025-07-P	● 23.0	25	34	49	56	126	1/4	SP□T090308-□□ XO□T090305-□□	FTKA0307	TW09S
	23525-07-P	● 23.5	25	34	49	56	126				
	24032-09-P	● 24.0	32	44	51	60	133				
	24532-09-P	● 24.5	32	44	51	60	133				
	25032-09-P	● 25.0	32	44	53	60	135				
	25532-09-P	● 25.5	32	44	53	60	135				
	26032-09-P	● 26.0	32	44	55	60	137				
	26532-09-P	● 26.5	32	44	55	60	137				
	27032-09-P	● 27.0	32	44	57	60	140				
	27532-09-P	● 27.5	32	44	57	60	140				
	28032-09-P	● 28.0	32	44	59	60	143				
	28532-09-P	● 28.5	32	44	59	60	143				
	29032-09-P	● 29.0	32	44	61	60	145				
	29532-09-P	● 29.5	32	44	61	60	145				
	30032-11-P	● 30.0	32	44	63	60	150		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	30532-11-P	● 30.5	32	44	63	60	150				
	31032-11-P	● 31.0	32	44	65	60	152				
	31532-11-P	● 31.5	32	44	65	60	152				
	32032-11-P	● 32.0	32	44	67	60	154				
	32532-11-P	● 32.5	32	44	67	60	154				
	33032-11-P	● 33.0	32	44	69	60	157				
	33532-11-P	● 33.5	32	44	69	60	157				
	34032-11-P	● 34.0	32	44	71	60	159				
	34532-11-P	● 34.5	32	44	71	60	159				
	35032-11-P	● 35.0	32	44	73	60	161				
	35532-11-P	● 35.5	32	44	73	60	161				

●: 재고 관리 형번

KED Plus Drill (2D)

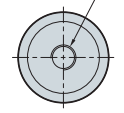
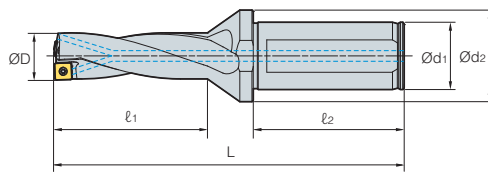
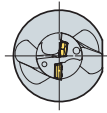


(mm)

형 번	재고	ØD	Ød1	Ød2	ℓ1	ℓ2	L	PT	적용인서트	스크류	렌치	
E2D-	36040-13-P	●	36.0	40	48	76	70	176	1/4	SP□T130410-□□ XO□T130406-□□	FTKA0410	TW15S
	36540-13-P		36.5	40	48	76	70	176				
	37040-13-P	●	37.0	40	48	78	70	178				
	37540-13-P		37.5	40	48	78	70	178				
	38040-13-P	●	38.0	40	48	80	70	181				
	38540-13-P		38.5	40	48	80	70	181				
	39040-13-P	●	39.0	40	48	82	70	183				
	39540-13-P		39.5	40	48	82	70	183				
	40040-13-P	●	40.0	40	48	84	70	186				
	40540-13-P		40.5	40	48	84	70	186				
	41040-13-P	●	41.0	40	48	86	70	188				
	41540-13-P		41.5	40	48	86	70	188				
	42040-13-P	●	42.0	40	48	88	70	191				
	42540-13-P		42.5	40	48	88	70	191				
	43040-15-P	●	43.0	40	58	91	70	196				
	43540-15-P		43.5	40	58	91	70	196				
	44040-15-P	●	44.0	40	58	93	70	198				
	44540-15-P		44.5	40	58	93	70	198				
	45040-15-P	●	45.0	40	58	95	70	201				
	45540-15-P		45.5	40	58	95	70	201				
	46040-15-P	●	46.0	40	58	97	70	203				
	46540-15-P		46.5	40	58	97	70	203				
	47040-15-P	●	47.0	40	58	99	70	206				
	47540-15-P		47.5	40	58	99	70	206				
	48040-15-P	●	48.0	40	58	101	70	208				
	48540-15-P		48.5	40	58	101	70	208				
	49040-15-P	●	49.0	40	58	103	70	210				
	49540-15-P		49.5	40	58	103	70	210				
	50040-15-P	●	50.0	40	58	105	70	212				
	50540-15-P		50.5	40	58	105	70	212				
	51040-18-P	●	51.0	40	68	108	70	218				
	51540-18-P		51.5	40	68	108	70	218				
	52040-18-P	●	52.0	40	68	110	70	220				
	52540-18-P		52.5	40	68	110	70	220				
	53040-18-P	●	53.0	40	68	112	70	222				
	53540-18-P		53.5	40	68	112	70	222				
	54040-18-P	●	54.0	40	68	114	70	224				
	54540-18-P		54.5	40	68	114	70	224				
	55040-18-P	●	55.0	40	68	116	70	226				
	55540-18-P		55.5	40	68	116	70	226				
	56040-18-P	●	56.0	40	68	118	70	230				
	56540-18-P		56.5	40	68	118	70	230				
	57040-18-P	●	57.0	40	68	121	70	233				
	57540-18-P		57.5	40	68	121	70	233				
	58040-18-P	●	58.0	40	68	124	70	236				
	58540-18-P		58.5	40	68	124	70	236				
	59040-18-P	●	59.0	40	68	127	70	239				
	59540-18-P		59.5	40	68	127	70	239				
	60040-18-P	●	60.0	40	68	130	70	242				
	60540-18-P		60.5	40	68	130	70	242				

● : 재고 관리 형번

KED Plus Drill (3D)

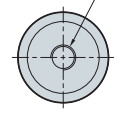
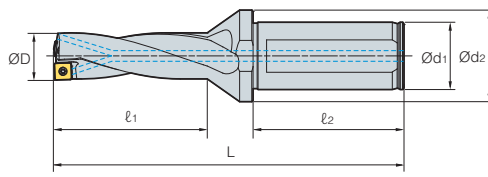
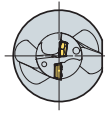


(mm)

형 번	재고	ØD	Ød1	Ød2	l1	l2	L	PT	적용인서트	스크류	렌치
E3D-	12020-04-P	12.0	20	25	39	50	103	1/8	SP□T040204-□□ XO□T040204-□□	FTNA0204	TW06P
	12520-04-P	12.5	20	25	39	50	103				
	13020-04-P	13.0	20	25	42	50	106		SP□T050204-□□ XO□T050204-□□	FTNA0204	TW06P
	13520-04-P	13.5	20	25	42	50	106				
	14020-05-P	14.0	20	25	45	50	110		SP□T060205-□□ XO□T060204-□□	FTKA02206S	TW07P
	14520-05-P	14.5	20	25	45	50	110				
	15020-05-P	15.0	20	25	48	50	114		SP□T07T208-□□ XO□T07T205-□□	FTKA02565	TW07S
	15520-05-P	15.5	20	25	48	50	114				
	16020-05-P	16.0	20	25	51	50	117		SP□T090308-□□ XO□T090305-□□	FTKA0307	TW09S
	16525-06-P	16.5	25	34	51	56	123				
	17025-06-P	17.0	25	34	54	56	126		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	17525-06-P	17.5	25	34	54	56	126				
	18025-06-P	18.0	25	34	57	56	130		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	18525-06-P	18.5	25	34	57	56	130				
	19025-06-P	19.0	25	34	60	56	133		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	19525-06-P	19.5	25	34	60	56	133				
	20025-07-P	20.0	25	34	63	56	138		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	20525-07-P	20.5	25	34	63	56	138				
	21025-07-P	21.0	25	34	66	56	141		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	21525-07-P	21.5	25	34	66	56	141				
	22025-07-P	22.0	25	34	69	56	144		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	22525-07-P	22.5	25	34	69	56	144				
	23025-07-P	23.0	25	34	72	56	149		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	23525-07-P	23.5	25	34	72	56	149				
	24032-09-P	24.0	32	44	75	60	157	1/4	SP□T090308-□□ XO□T090305-□□	FTKA0307	TW09S
	24532-09-P	24.5	32	44	75	60	157				
	25032-09-P	25.0	32	44	78	60	160		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	25532-09-P	25.5	32	44	78	60	160				
	26032-09-P	26.0	32	44	81	60	163		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	26532-09-P	26.5	32	44	81	60	163				
	27032-09-P	27.0	32	44	84	60	167		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	27532-09-P	27.5	32	44	84	60	167				
	28032-09-P	28.0	32	44	87	60	171		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	28532-09-P	28.5	32	44	87	60	171				
	29032-09-P	29.0	32	44	90	60	174		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	29532-09-P	29.5	32	44	90	60	174				
	30032-11-P	30.0	32	44	93	60	180		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	30532-11-P	30.5	32	44	93	60	180				
	31032-11-P	31.0	32	44	96	60	183		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	31532-11-P	31.5	32	44	96	60	183				
	32032-11-P	32.0	32	44	99	60	186		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	32532-11-P	32.5	32	44	99	60	186				
	33032-11-P	33.0	32	44	102	60	190		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	33532-11-P	33.5	32	44	102	60	190				
	34032-11-P	34.0	32	44	105	60	193		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	34532-11-P	34.5	32	44	105	60	193				
	35032-11-P	35.0	32	44	108	60	196		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	35532-11-P	35.5	32	44	108	60	196				

●: 재고 관리 형번

KED Plus Drill (3D)

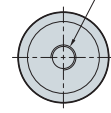
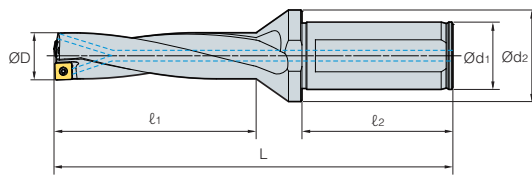
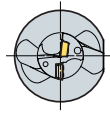


(mm)

형 번	재고	ØD	Ød1	Ød2	l1	l2	L	PT	적용인서트	스크류	렌치
E3D-	●	36.0	40	48	112	70	212		SP□T130410-□□ XO□T130406-□□	FTKA0410	TW15S
36540-13-P		36.5	40	48	112	70	212				
37040-13-P	●	37.0	40	48	115	70	215				
37540-13-P		37.5	40	48	115	70	215				
38040-13-P	●	38.0	40	48	118	70	219				
38540-13-P		38.5	40	48	118	70	219				
39040-13-P	●	39.0	40	48	121	70	222				
39540-13-P		39.5	40	48	121	70	222				
40040-13-P	●	40.0	40	48	124	70	226				
40540-13-P		40.5	40	48	124	70	226				
41040-13-P	●	41.0	40	48	127	70	229				
41540-13-P		41.5	40	48	127	70	229				
42040-13-P	●	42.0	40	48	130	70	233				
42540-13-P		42.5	40	48	130	70	233				
43040-15-P	●	43.0	40	58	134	70	239				
43540-15-P		43.5	40	58	134	70	239		SP□T15M510-□□ XO□T15M508-□□	FTNC04511	TW20S
44040-15-P	●	44.0	40	58	137	70	242				
44540-15-P		44.5	40	58	137	70	242				
45040-15-P	●	45.0	40	58	140	70	246				
45540-15-P		45.5	40	58	140	70	246				
46040-15-P	●	46.0	40	58	143	70	249				
46540-15-P		46.5	40	58	143	70	249				
47040-15-P	●	47.0	40	58	146	70	253				
47540-15-P		47.5	40	58	146	70	253				
48040-15-P	●	48.0	40	58	149	70	256				
48540-15-P		48.5	40	58	149	70	256				
49040-15-P	●	49.0	40	58	152	70	259				
49540-15-P		49.5	40	58	152	70	259				
50040-15-P	●	50.0	40	58	155	70	262				
50540-15-P		50.5	40	58	155	70	262		SP□T180510-□□ XO□T180508-□□	FTNA0511	TW20-100
51040-18-P	●	51.0	40	68	159	70	269				
51540-18-P		51.5	40	68	159	70	269				
52040-18-P	●	52.0	40	68	162	70	272				
52540-18-P		52.5	40	68	162	70	272				
53040-18-P	●	53.0	40	68	165	70	275				
53540-18-P		53.5	40	68	165	70	275				
54040-18-P	●	54.0	40	68	168	70	278				
54540-18-P		54.5	40	68	168	70	278				
55040-18-P	●	55.0	40	68	171	70	281				
55540-18-P		55.5	40	68	171	70	281				
56040-18-P	●	56.0	40	68	174	70	286				
56540-18-P		56.5	40	68	174	70	286				
57040-18-P	●	57.0	40	68	178	70	290				
57540-18-P		57.5	40	68	178	70	290				
58040-18-P	●	58.0	40	68	182	70	294				
58540-18-P		58.5	40	68	182	70	294				
59040-18-P	●	59.0	40	68	186	70	298				
59540-18-P		59.5	40	68	186	70	298				
60040-18-P	●	60.0	40	68	190	70	302				
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●: 재고 관리 형번

KED Plus Drill(4D)

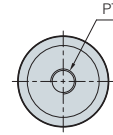
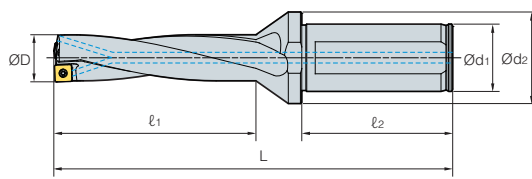
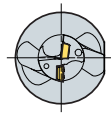


(mm)

형 번	재고	ØD	Ød1	Ød2	l1	l2	L	PT	적용인서트	스크류	렌치
E4D-	12020-04-P	12.0	20	25	51	50	115	1/8	SP□T040204-□□ XO□T040204-□□	FTNA0204	TW06P
	12520-04-P	12.5	20	25	51	50	115				
	13020-04-P	● 13.0	20	25	55	50	119		SP□T050204-□□ XO□T050204-□□	FTNA0204	TW06P
	13520-04-P	● 13.5	20	25	55	50	119				
	14020-05-P	● 14.0	20	25	59	50	124				
	14520-05-P	● 14.5	20	25	59	50	124				
	15020-05-P	● 15.0	20	25	63	50	129				
	15520-05-P	● 15.5	20	25	63	50	129				
	16020-05-P	● 16.0	20	25	67	50	133				
	16525-06-P	● 16.5	25	34	67	56	139		SP□T060205-□□ XO□T060204-□□	FTKA02206S	TW07P
	17025-06-P	● 17.0	25	34	71	56	143				
	17525-06-P	● 17.5	25	34	71	56	143				
	18025-06-P	● 18.0	25	34	75	56	148				
	18525-06-P	● 18.5	25	34	75	56	148		SP□T07T208-□□ XO□T07T205-□□	FTKA02565	TW07S
	19025-06-P	● 19.0	25	34	79	56	152				
	19525-06-P	● 19.5	25	34	79	56	152				
	20025-07-P	● 20.0	25	34	83	56	158				
	20525-07-P	● 20.5	25	34	83	56	158				
	21025-07-P	● 21.0	25	34	87	56	162				
	21525-07-P	● 21.5	25	34	87	56	162				
	22025-07-P	● 22.0	25	34	91	56	166				
	22525-07-P	● 22.5	25	34	91	56	166				
	23025-07-P	● 23.0	25	34	95	56	172				
	23525-07-P	● 23.5	25	34	95	56	172				
	24032-09-P	● 24.0	32	44	99	60	181	1/4	SP□T090308-□□ XO□T090305-□□	FTKA0307	TW09S
	24532-09-P	● 24.5	32	44	99	60	181				
	25032-09-P	● 25.0	32	44	103	60	185				
	25532-09-P	● 25.5	32	44	103	60	185				
	26032-09-P	● 26.0	32	44	107	60	189				
	26532-09-P	● 26.5	32	44	107	60	189				
	27032-09-P	● 27.0	32	44	111	60	194				
	27532-09-P	● 27.5	32	44	111	60	194				
	28032-09-P	● 28.0	32	44	115	60	199				
	28532-09-P	● 28.5	32	44	115	60	199				
	29032-09-P	● 29.0	32	44	119	60	203				
	29532-09-P	● 29.5	32	44	119	60	203				
	30032-11-P	● 30.0	32	44	123	60	210		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	30532-11-P	● 30.5	32	44	123	60	210				
	31032-11-P	● 31.0	32	44	127	60	214				
	31532-11-P	● 31.5	32	44	127	60	214				
	32032-11-P	● 32.0	32	44	131	60	218				
	32532-11-P	● 32.5	32	44	131	60	218				
	33032-11-P	● 33.0	32	44	135	60	223				
	33532-11-P	● 33.5	32	44	135	60	223				
	34032-11-P	● 34.0	32	44	139	60	227				
	34532-11-P	● 34.5	32	44	139	60	227				
	35032-11-P	● 35.0	32	44	143	60	231				
	35532-11-P	● 35.5	32	44	143	60	231				

●: 재고 관리 형번

KED Plus Drill(4D)

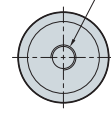
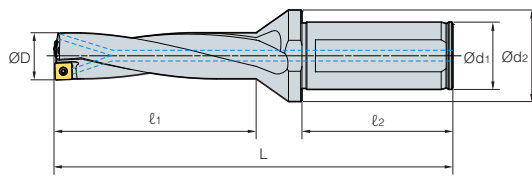
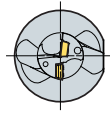


(mm)

형 번	재고	ØD	Ød1	Ød2	l1	l2	L	PT	적용인서트	스크류	렌치
E4D-	36040-13-P	●	36.0	40	48	148	70	248	SP□T130410-□□ XO□T130406-□□	FTKA0410	TW15S
	36540-13-P		36.5	40	48	148	70	248			
	37040-13-P	●	37.0	40	48	152	70	252			
	37540-13-P		37.5	40	48	152	70	252			
	38040-13-P	●	38.0	40	48	156	70	257			
	38540-13-P		38.5	40	48	156	70	257			
	39040-13-P	●	39.0	40	48	160	70	261			
	39540-13-P		39.5	40	48	160	70	261			
	40040-13-P	●	40.0	40	48	164	70	266			
	40540-13-P		40.5	40	48	164	70	266			
	41040-13-P	●	41.0	40	48	168	70	270			
	41540-13-P		41.5	40	48	168	70	270			
	42040-13-P	●	42.0	40	48	172	70	275			
	42540-13-P		42.5	40	48	172	70	275			
	43040-15-P	●	43.0	40	58	177	70	282			
	43540-15-P		43.5	40	58	177	70	282			
	44040-15-P	●	44.0	40	58	181	70	286			
	44540-15-P		44.5	40	58	181	70	286			
	45040-15-P	●	45.0	40	58	185	70	291			
	45540-15-P		45.5	40	58	185	70	291			
	46040-15-P	●	46.0	40	58	189	70	295	SP□T15M510-□□ XO□T15M508-□□	FTNC04511	TW20S
	46540-15-P		46.5	40	58	189	70	295			
	47040-15-P	●	47.0	40	58	193	70	300			
	47540-15-P		47.5	40	58	193	70	300			
	48040-15-P	●	48.0	40	58	197	70	304			
	48540-15-P		48.5	40	58	197	70	304			
	49040-15-P	●	49.0	40	58	201	70	308			
	49540-15-P		49.5	40	58	201	70	308			
	50040-15-P	●	50.0	40	58	205	70	312			
	50540-15-P		50.5	40	58	205	70	312			
	51040-18-P	●	51.0	40	68	210	70	320	SP□T180510-□□ XO□T180508-□□	FTNA0511	TW20-100
	51540-18-P		51.5	40	68	210	70	320			
	52040-18-P	●	52.0	40	68	214	70	324			
	52540-18-P		52.5	40	68	214	70	324			
	53040-18-P	●	53.0	40	68	218	70	328			
	53540-18-P		53.5	40	68	218	70	328			
	54040-18-P	●	54.0	40	68	222	70	332			
	54540-18-P		54.5	40	68	222	70	332			
	55040-18-P	●	55.0	40	68	226	70	336			
	55540-18-P		55.5	40	68	226	70	336			
	56040-18-P	●	56.0	40	68	230	70	342			
	56540-18-P		56.5	40	68	230	70	342			
	57040-18-P	●	57.0	40	68	235	70	347			
	57540-18-P		57.5	40	68	235	70	347			
	58040-18-P	●	58.0	40	68	240	70	352			
	58540-18-P		58.5	40	68	240	70	352			
	59040-18-P	●	59.0	40	68	245	70	357			
	59540-18-P		59.5	40	68	245	70	357			
	60040-18-P	●	60.0	40	68	250	70	362			
	60540-18-P		60.5	40	68	250	70	362			

●: 재고 관리 형번

KED Plus Drill (5D)

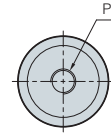
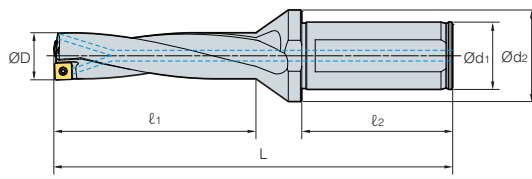
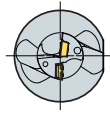


(mm)

형 번	재고	ØD	Ød1	Ød2	l1	l2	L	PT	적용인서트	스크류	렌치
E5D-	12020-04-P	12.0	20	25	63	50	127	1/8	SP□T040204-□□ XO□T040204-□□	FTNA0204	TW06P
	12520-04-P	12.5	20	25	63	50	127				
	13020-04-P	13.0	20	25	68	50	132		SP□T050204-□□ XO□T050204-□□	FTNA0204	TW06P
	13520-04-P	13.5	20	25	68	50	132				
	14020-05-P	14.0	20	25	73	50	138		SP□T060205-□□ XO□T060204-□□	FTKA02206S	TW07P
	14520-05-P	14.5	20	25	73	50	138				
	15020-05-P	15.0	20	25	78	50	144		SP□T07T208-□□ XO□T07T205-□□	FTKA02565	TW07S
	15520-05-P	15.5	20	25	78	50	144				
	16020-05-P	16.0	20	25	83	50	149		SP□T090308-□□ XO□T090305-□□	FTKA0307	TW09S
	16525-06-P	16.5	25	34	83	56	155				
	17025-06-P	17.0	25	34	88	56	160		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	17525-06-P	17.5	25	34	88	56	160				
	18025-06-P	18.0	25	34	93	56	166		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	18525-06-P	18.5	25	34	93	56	166				
	19025-06-P	19.0	25	34	98	56	171		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	19525-06-P	19.5	25	34	98	56	171				
	20025-07-P	20.0	25	34	103	56	178		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	20525-07-P	20.5	25	34	103	56	178				
	21025-07-P	21.0	25	34	108	56	183		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	21525-07-P	21.5	25	34	108	56	183				
	22025-07-P	22.0	25	34	113	56	188		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	22525-07-P	22.5	25	34	113	56	188				
	23025-07-P	23.0	25	34	118	56	195		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	23525-07-P	23.5	25	34	118	56	195				
	24032-09-P	24.0	32	44	123	60	205	1/4	SP□T090308-□□ XO□T090305-□□	FTKA0307	TW09S
	24532-09-P	24.5	32	44	123	60	205				
	25032-09-P	25.0	32	44	128	60	210		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	25532-09-P	25.5	32	44	128	60	210				
	26032-09-P	26.0	32	44	133	60	215		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	26532-09-P	26.5	32	44	133	60	215				
	27032-09-P	27.0	32	44	138	60	221		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	27532-09-P	27.5	32	44	138	60	221				
	28032-09-P	28.0	32	44	143	60	227		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	28532-09-P	28.5	32	44	143	60	227				
	29032-09-P	29.0	32	44	148	60	232		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	29532-09-P	29.5	32	44	148	60	232				
	30032-11-P	30.0	32	44	153	60	240		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	30532-11-P	30.5	32	44	153	60	240				
	31032-11-P	31.0	32	44	158	60	245		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	31532-11-P	31.5	32	44	158	60	245				
	32032-11-P	32.0	32	44	163	60	250		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	32532-11-P	32.5	32	44	163	60	250				
	33032-11-P	33.0	32	44	168	60	256		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	33532-11-P	33.5	32	44	168	60	256				
	34032-11-P	34.0	32	44	173	60	261		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	34532-11-P	34.5	32	44	173	60	261				
	35032-11-P	35.0	32	44	178	60	266		SP□T11T308-□□ XO□T11T306-□□	FTKA03508	TW15S
	35532-11-P	35.5	32	44	178	60	266				

●: 재고 관리 형번

KED Plus Drill (5D)



(mm)

형 번	재고	ØD	Ød1	Ød2	ℓ1	ℓ2	L	PT	적용인서트	스크류	렌치	
E5D-	36040-13-P	●	36.0	40	48	184	70	284	1/4	SP□T130410-□□ XO□T130406-□□	FTKA0410	TW15S
	36540-13-P		36.5	40	48	184	70	284				
	37040-13-P	●	37.0	40	48	189	70	289				
	37540-13-P		37.5	40	48	189	70	289				
	38040-13-P	●	38.0	40	48	194	70	295				
	38540-13-P		38.5	40	48	194	70	295				
	39040-13-P	●	39.0	40	48	199	70	300				
	39540-13-P		39.5	40	48	199	70	300				
	40040-13-P	●	40.0	40	48	204	70	306				
	40540-13-P		40.5	40	48	204	70	306				
	41040-13-P	●	41.0	40	48	209	70	311				
	41540-13-P		41.5	40	48	209	70	311				
	42040-13-P	●	42.0	40	48	214	70	317				
	42540-13-P		42.5	40	48	214	70	317				
	43040-15-P	●	43.0	40	58	220	70	325				
	43540-15-P		43.5	40	58	221	70	326				
	44040-15-P	●	44.0	40	58	225	70	330				
	44540-15-P		44.5	40	58	225	70	330				
	45040-15-P	●	45.0	40	58	230	70	336				
	45540-15-P		45.5	40	58	230	70	336				
	46040-15-P	●	46.0	40	58	235	70	341				
	46540-15-P		46.5	40	58	235	70	341				
	47040-15-P	●	47.0	40	58	240	70	347				
	47540-15-P		47.5	40	58	240	70	347				
	48040-15-P	●	48.0	40	58	245	70	352				
	48540-15-P		48.5	40	58	245	70	352				
	49040-15-P	●	49.0	40	58	250	70	357				
	49540-15-P		49.5	40	58	250	70	357				
	50040-15-P	●	50.0	40	58	255	70	362				
	50540-15-P		50.5	40	58	255	70	362				
	51040-18-P	●	51.0	40	68	261	70	371				
	51540-18-P		51.5	40	68	261	70	371				
	52040-18-P	●	52.0	40	68	266	70	376				
	52540-18-P		52.5	40	68	266	70	376				
	53040-18-P	●	53.0	40	68	271	70	381				
	53540-18-P		53.5	40	68	271	70	381				
	54040-18-P	●	54.0	40	68	276	70	386				
	54540-18-P		54.5	40	68	276	70	386				
	55040-18-P	●	55.0	40	68	281	70	391				
	55540-18-P		55.5	40	68	281	70	391				
	56040-18-P	●	56.0	40	68	286	70	398				
	56540-18-P		56.5	40	68	286	70	398				
	57040-18-P	●	57.0	40	68	292	70	404				
	57540-18-P		57.5	40	68	292	70	404				
	58040-18-P	●	58.0	40	68	298	70	410				
	58540-18-P		58.5	40	68	298	70	410				
	59040-18-P	●	59.0	40	68	304	70	416				
	59540-18-P		59.5	40	68	304	70	416				
	60040-18-P	●	60.0	40	68	310	70	422				
	60540-18-P		60.5	40	68	310	70	422				

●: 재고 관리 형번

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