

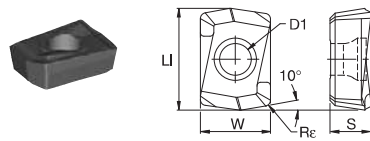
■ HTS DFT™ • Inch

Indexable Drills

Inch												
Material Group	Condition	Pocket Seat	Geometry	Grade	Cutting Speed – vc			Recommended Feed Rate (f) by Diameter				
					Range – SFM			Ø	DFT03... 1.77–2.17"	DFT05... 2.17–3.07"	DFT06... 3.07–5.51"	DFT07... 5.51–10.63"
					min	Starting Value	max					
K	1	S	O HP	KCPK10	309	561	750	IPR	.004–.008	.005–.011	.006–.012	.007–.013
			I HP	KCPK10								
		U	O HP	KCU25	211	384	510	IPR	.004–.008	.005–.011	.006–.012	.007–.013
			I HP	KCU25								
	2	S	O HP	KCPK10	309	533	750	IPR	.004–.008	.005–.011	.006–.012	.007–.013
			I HP	KCPK10								
		U	O HP	KCU25	211	365	510	IPR	.004–.008	.005–.011	.006–.012	.007–.013
			I HP	KCU25								
	3	S	O HP	KCPK10	294	480	712	IPR	.004–.008	.005–.011	.006–.012	.007–.013
			I HP	KCPK10								
		U	O HP	KCU25	195	328	473	IPR	.004–.008	.005–.011	.006–.012	.007–.013
			I HP	KCU25								
N	1	S	O ST	KD1425	504	787	1176	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I ST	KD1425								
		U	O HP	KC7140	336	525	784	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I HP	KC7140								
	2	S	O ST	KD1425	504	732	1176	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I ST	KD1425								
		U	O HP	KCU40	336	488	784	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I HP	KCU40								
	3	S	O ST	KD1425	504	677	1176	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I ST	KD1425								
		U	O HP	KCU40	336	451	784	IPR	.002–.004	.004–.007	.005–.008	.006–.010
			I HP	KCU40								
4	S	O ST	KD1425	504	732	1176	IPR	.002–.004	.004–.007	.005–.008	.006–.010	
		I ST	KD1425									
	U	O LD	KC7140	336	488	784	IPR	.002–.004	.004–.007	.005–.008	.006–.010	
		I LD	KC7140									
5	S	O ST	KD1425	368	722	858	IPR	.002–.004	.004–.007	.005–.008	.006–.010	
		I ST	KD1425									
	U	O HP	KC7140	235	459	549	IPR	.002–.004	.004–.007	.005–.008	.006–.010	
		I HP	KC7140									
S	1	S	O HP	KC7140	80	131	160	IPR	.002–.003	.002–.003	.003–.004	.003–.004
			I HP	KC7140								
		U	O HP	KC7140	60	98	120	IPR	.002–.003	.002–.003	.003–.004	.003–.004
			I HP	KC7140								
	2	S	O HP	KC7140	82	115	158	IPR	.002–.003	.002–.003	.003–.004	.003–.004
			I HP	KC7140								
		U	O HP	KC7140	58	82	112	IPR	.002–.003	.002–.003	.003–.004	.003–.004
			I HP	KC7140								
	3	S	O HP	KC7140	46	66	90	IPR	.002–.003	.002–.003	.003–.004	.003–.004
			I HP	KC7140								

Condition: S = Stable cutting conditions;
 U = Unstable cutting conditions;
 I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
 O = Outboard insert

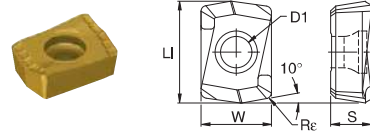


DFR-GD

catalog number	LI		W		D1		S		Re		KCPK10	KCU25	KCU40	KC7140
	mm	in	mm	in	mm	in	mm	in	mm	in				
DFR020204GD	7,12	.280	4,90	.193	2,30	.091	2,79	.110	0,40	.016	●	●	●	●
DFR030204GD	8,71	.343	6,00	.236	2,50	.098	2,88	.113	0,40	.016	●	●	●	●
DFR040304GD	10,76	.424	7,38	.291	2,85	.112	3,79	.149	0,40	.016	●	●	●	●

● first choice
○ alternate choice

P	●	●	●	●
M	○	○	○	○
K	●	●	○	○
N	○	○	○	○
S	○	○	●	●
H	○	○	○	○

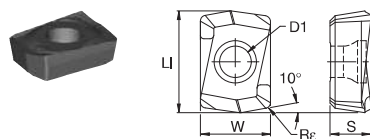


DFR-MD

catalog number	LI		W		D1		S		Re		KCU25	KCU40	KC7140
	mm	in	mm	in	mm	in	mm	in	mm	in			
DFR020204MD	7,12	.280	4,90	.193	2,30	.091	2,79	.110	0,40	.016	●	●	●
DFR030204MD	8,71	.343	6,00	.236	2,50	.098	2,88	.113	0,40	.016	●	●	●
DFR040304D28MD	10,76	.424	7,26	.286	2,85	.112	3,79	.149	0,40	.016	-	-	●
DFR040304MD	10,76	.424	7,38	.291	2,85	.112	3,79	.149	0,40	.016	●	●	●

● first choice
○ alternate choice

P	●	●	●	●
M	○	○	○	○
K	○	○	○	○
N	○	○	○	○
S	○	○	○	○
H	○	○	○	○



DFR-LD

catalog number	LI		W		D1		S		Re		KCPK10	KCU25	KCU40	KC7140
	mm	in	mm	in	mm	in	mm	in	mm	in				
DFR020204LD	7,12	.280	4,90	.193	2,30	.091	2,79	.110	0,40	.016	●	●	●	●
DFR030204LD	8,71	.343	6,00	.236	2,50	.098	2,86	.113	0,40	.016	●	●	●	●
DFR040304LD	10,76	.424	7,38	.291	2,85	.112	3,76	.148	0,40	.016	●	●	●	●

● first choice
○ alternate choice

P	○	○	○	○
M	○	○	○	○
K	○	○	○	○
N	○	○	○	○
S	○	○	○	○
H	○	○	○	○

Indexable Drills