

**KORLOY Indexable New Generation Economical Drill**

# KED Drill



## **Economical and High Efficiency Indexable Drill**

### ■ **For Small Diameter Drilling**

Excellent chip control for small diameters ( $\text{Ø}13\sim\text{Ø}23.5$ ) due to optimized chip flute design

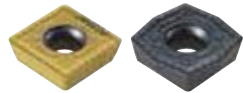
### ■ **For Medium to Large Diameter Drilling**

Smooth chip evacuation and improved surface finish due to wider chip pockets in medium to large diameter ( $\text{Ø}24\sim\text{Ø}60$ ) drilling



# Economical and High Efficiency Indexable Drill

## KED Drill

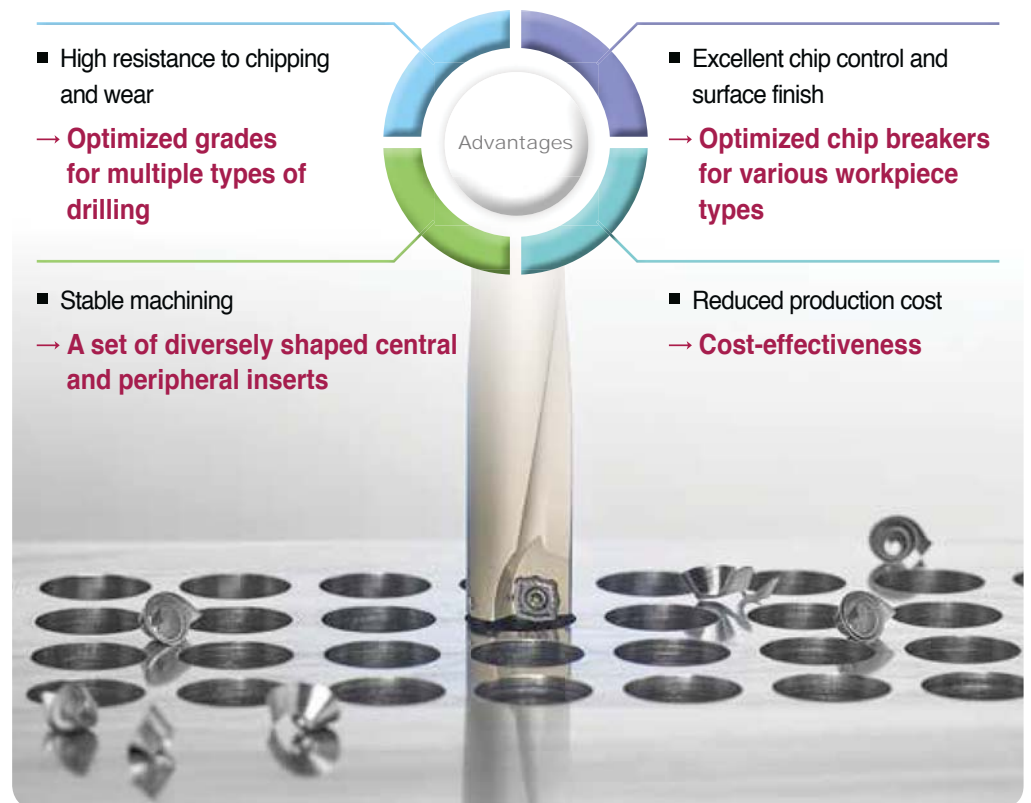


The **KED DRILL** is an economical drill which features optimized chip flutes for each drilling size.

The **KED DRILL holders** for small diameters ( $\varnothing 13\sim\varnothing 23.5$ ) offer excellent chip control due to cutting fluid system and chip flute design. And for medium to large diameters ( $\varnothing 24\sim\varnothing 60$ ), chip pockets were widened to enhance machining stability and surface finish even in deep drilling.

A set of diversely shaped central and peripheral inserts optimize centering and balance. Improved stability enables boring deep holes up to a range of 2 to 5 times the drill diameter (2D~5D).

The **KED DRILL inserts** have three kinds of chip breakers to suit a range of applications: PD for general purpose, LD for mild steel and hard-to-cut materials, and ND for aluminum machining. The optimized grades for the central and peripheral inserts maximize cutting tool life. Thus, higher stability and excellent cutting results in boost of productivity and reduces tool cost.



### ⇒ Code System

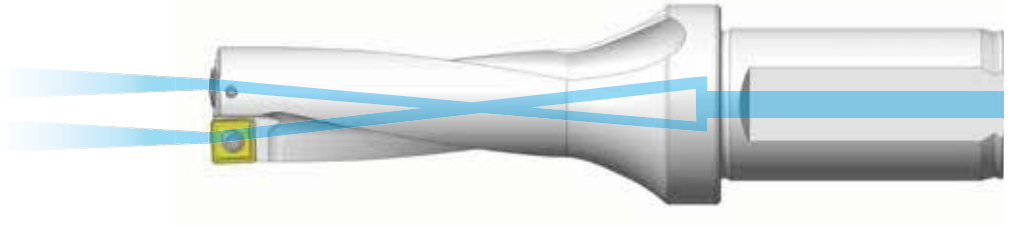
[ Holder ]

<b>E</b>	<b>4D</b>	-	<b>200</b>	<b>25</b>	-	<b>07</b>
<b>KING, Economical</b>	<b>Aspect ratio (L/D)</b> 2D, 3D, 4D, 5D		<b>Drill diameter <math>\varnothing 20.0</math></b>	<b>Shank diameter</b> $\varnothing 20, \varnothing 25$ $\varnothing 32, \varnothing 40$		<b>Inscribed circle of insert</b> 04, 05, 06, 07, 09, 11, 13, 15, 18

## ⇒ Holder Features

- For small diameters (Ø13~Ø23.5) excellent chip control due to the cutting fluid system and chip flute
- For medium to large diameters (Ø24~Ø60) excellent surface finish due to widened chip pockets even in deep drilling

### Optimized flute system - 2 coolant holes applied



A set of diversely shaped central and peripheral chip breakers for excellent chip control and surface finish

#### Central insert



#### Peripheral insert



## ⇒ Insert Features

- **Optimized design of inserts for maximum drilling efficiency**
  - Excellent cutting performance and chip control due to the optimized geometry and chip breaker of both inserts: central and peripheral
  - A set of differently shaped central and peripheral inserts optimize the insert locations in order to maximize cutting tool life

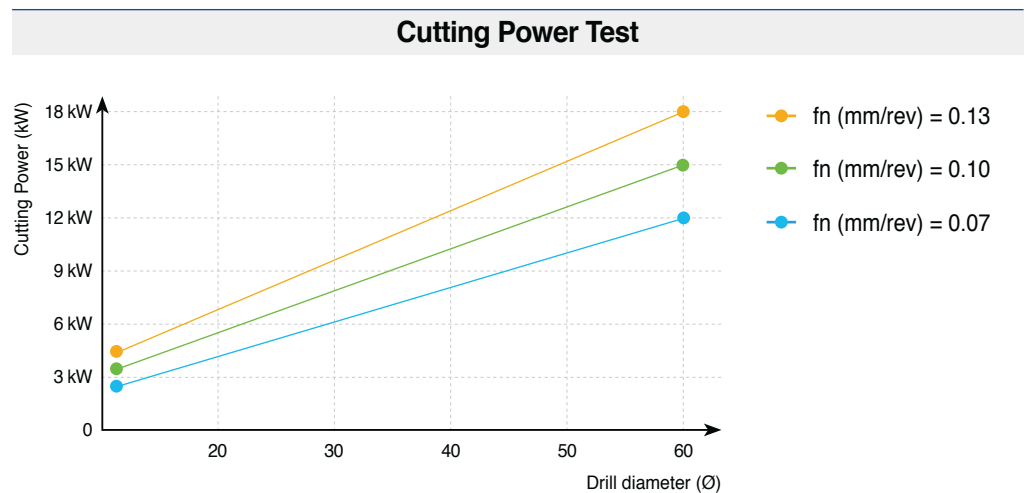
Chip breaker	PD		LD		ND		RD
Features	- Universal - Medium feed and speed		- Superior chip control for machining mild steel and stainless steel - Light cutting (at low-medium speed and low feed)		- Sharp cutting edge for aluminum machining - Insert surface buffed for high quality result		- Improved chipping resistance - Excellent performance in case of frequent fracture and chipping on the cutting edge
Insert	Peripheral insert	Central insert	Peripheral insert	Central insert	Peripheral insert	Central insert	Central insert
Shape							
Grades for workpiece	NC5330: P,M,K PC3500: P PC5300: P,M,K,S PC6510: K		PC5300: P,M,K,S		PC5335: P,M		H01: N PC5300: P,M,K,S

## ⇒ KED Hole Tolerance

Diameter (mm)	2D	3D	4D	5D
Ø13~Ø23.5	-0.10~+0.15	-0.10~+0.18	-0.12~+0.20	-0.12~+0.25
Ø24~Ø42	-0.10~+0.15	-0.12~+0.22	-0.12~+0.25	-0.15~+0.33
Ø43~Ø60	-0.10~+0.20	-0.12~+0.25	-0.15~+0.27	-0.15~+0.40

- The KED drill diameter itself shows (-) tolerance, and the actual hole tolerance follows this table
- The hole tolerance is determined by drill length, workpiece materials, machine stability and cutting conditions

## ⇒ Cutting Power



## ⇒ Performance Evaluation

• The KED DRILL provides the best tool life

### [KED DRILL]

280 holes (28.8 m)  
→ **Normal wear**

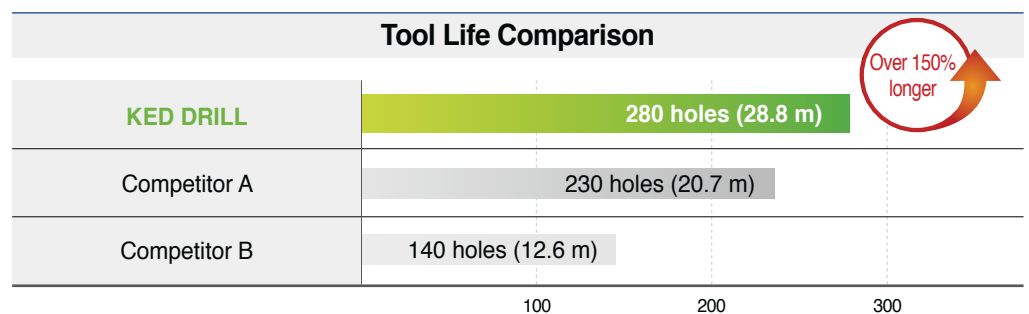
### [Competitor A]

230 holes (20.7 m)  
→ Fractures at the cutting edge

### [Competitor B]

140 holes (12.6 m)  
→ Wear and chipping on cutting edge

- Workpiece SCM440
- Cutting conditions  $vc$  (m/min) = 150,  $fn$  (mm/rev) = 0.1, Depth of cut: 80 mm (through hole), wet
- Tools  
Insert SPMT060205-PD (PC3500), XCMT060204-PD (PC5300)  
Holder E4D-18025-06


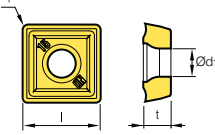

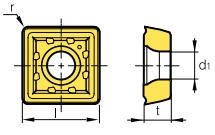
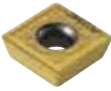
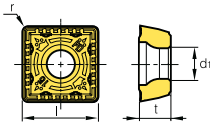

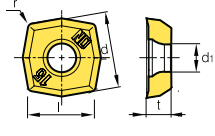


# Recommended Cutting Conditions


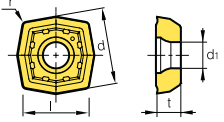

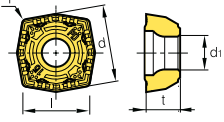

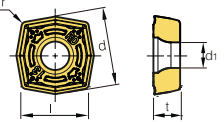
(mm)

Workpiece			Insert			vc (m/min)	Feed (aspect ratio = 2D, 3D, 4D) fn (mm/rev) depending on drill Dia.					
ISO	Workpiece	Hardness (HB)	Chip Breaker	Grade			Ø12~Ø16	Ø17~Ø23	Ø24~Ø29	Ø30~Ø42	Ø43~Ø60	
				Central	Peripheral							
P	Carbon steel	Low carbon steel	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	PC3500	150 (120~180)					
						NC5330	180 (140~220)					
	High carbon steel	180~280	PD	PC5300	PC3500	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	
					LD	PC5335	PC5335	120 (60~160)	0.06~0.10	0.06~0.10	0.06~0.12	0.06~0.14
	Alloy steel	Low alloy steel	140~260	PD	PC5300	PC3500	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
		Heat treated low alloy steel	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
		High alloy steel	260~320	PD	PC5300	PC3500	100 (50~160)	0.05~0.11	0.05~0.11	0.05~0.13	0.05~0.15	0.05~0.15
Heat treated high alloy steel	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	Stainless steel	Stainless steel	135-275	LD	PD5335	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	Cast iron	Gray cast iron	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
		Ductile cast iron	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	Heat resistant super alloy	Ni-heat resisting alloy	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
		Ti-heat resisting alloy	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
High hardened steel	Over 400	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	Non ferrous metal	Alloyed aluminum	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
		Alloyed copper	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

- The Max. feed of 5D holders is 70%~80% of the max. conditions of 2D/3D/4D holders
- In interrupted machining part, reduce 30%~50% of feed from the above machining around interrupted part

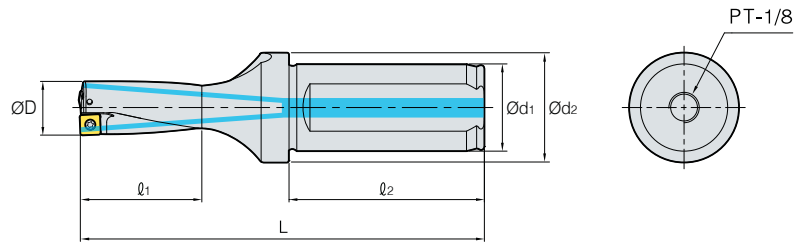
Picture	Designation		Coated							UnCoated	Dimensions (mm)					Figure
			NC5330	NC3500	NC3600	PC9530	PC6510	PC5300	PC5400	H01	l	d	t	r	d <sub>1</sub>	
	SPET	040204-ND								●	4.7	-	2.4	0.4	2.3	
		050204-ND								●	5.1	-	2.4	0.4	2.3	
		060205-ND								●	6.2	-	2.5	0.5	2.5	
		07T208-ND								●	7.5	-	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	

●: Stock item

Picture	Designation	Coated							UnCoated	Dimensions (mm)					Figure	
		NC5330	NC3500	NC3600	PC9530	PC6510	PC5300	PC5400	H01	l	d	t	r	d <sub>1</sub>		
	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	5.0	1.1	5.5	
		180512-RD							●		16.5	18.9	5.5	1.2	6.0	

● : Stock item



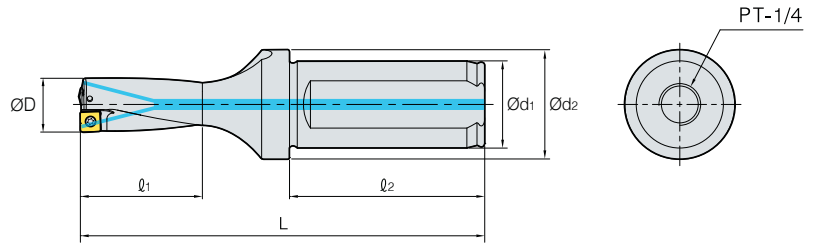


(mm)

Designation	ØD	Ød1	Ød2	l1	l2	L	Insert	Screw	Wrench	
<b>E2D-</b>	13020-04	13.0	20	27	29	50	99	XO□T040204-□□ SP□T040204-□□	FTNA0204	TW06P
	13520-04	13.5	20	27	30	50	100			
	14020-05	14.0	20	27	31	50	101			
	14520-05	14.5	20	27	32	50	102			
	15020-05	15.0	20	30	33	50	103	XO□T050204-□□ SP□T050204-□□	FTNA0204	TW06P
	15520-05	15.5	20	30	34	50	104			
	16020-05	16.0	20	30	35	50	105			
	16525-06	16.5	25	34	36	56	117			
	17025-06	17.0	25	34	37	56	118			
	17525-06	17.5	25	34	38	56	119			
	18025-06	18.0	25	34	39	56	120	XO□T060204-□□ SP□T060205-□□	FTKA02206-E	TW06P
	18525-06	18.5	25	34	40	56	121			
	19025-06	19.0	25	34	41	56	122			
	19525-06	19.5	25	34	42	56	123			
	20025-07	20.0	25	34	43	56	124			
	20525-07	20.5	25	34	44	56	125			
	21025-07	21.0	25	34	45	56	126			
	21525-07	21.5	25	34	46	56	127	XO□T07T205-□□ SP□T07T208-□□	FTKA02565-E	TW08P
	22025-07	22.0	25	34	47	56	128			
	22525-07	22.5	25	34	48	56	129			
	23025-07	23.0	25	34	49	56	130			
	23525-07	23.5	25	34	50	56	131			
	24032-09	24.0	32	42	51	60	141			
	24532-09	24.5	32	42	52	60	142			
	25032-09	25.0	32	42	53	60	143			
	25532-09	25.5	32	42	54	60	144			
	26032-09	26.0	32	42	55	60	145			
	26532-09	26.5	32	42	56	60	146	XO□T090305-□□ SP□T090308-□□	FTKA0307-E	TW08P
27032-09	27.0	32	42	57	60	147				
27532-09	27.5	32	42	58	60	148				
28032-09	28.0	32	42	59	60	149				
28532-09	28.5	32	42	60	60	150				
29032-09	29.0	32	42	61	60	151				
29532-09	29.5	32	44	62	60	152				

※ KED inserts are interchangeable with KING DRILL inserts, but some parts such as screws and wrenches are exclusive to the KED line-up.



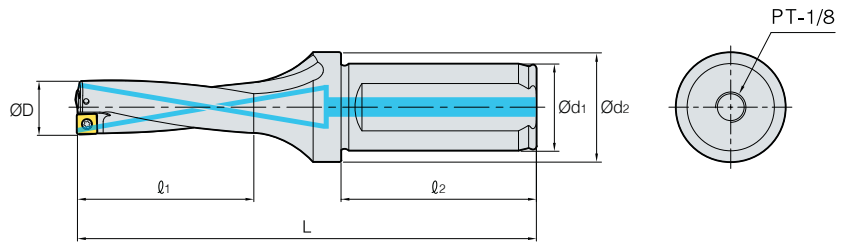


(mm)

Designation	ØD	Ød <sub>1</sub>	Ød <sub>2</sub>	l <sub>1</sub>	l <sub>2</sub>	L	Insert	Screw	Wrench
<b>E2D-</b> 30032-11	30.0	32	44	65	60	155	XO□T11T306-□□ SP□T11T308-□□	FTKA03508-E	TW15P
31032-11	31.0	32	44	67	60	157			
32032-11	32.0	32	44	69	60	159			
33032-11	33.0	32	44	71	60	161			
34032-11	34.0	32	44	73	60	163			
35032-11	35.0	32	44	75	60	165			
36040-13	36.0	40	54	77	70	182	XO□T130406-□□ SP□T130410-□□	FTKA0410-E	TW15P
37040-13	37.0	40	54	79	70	184			
38040-13	38.0	40	54	81	70	186			
39040-13	39.0	40	54	83	70	188			
40040-13	40.0	40	54	85	70	190			
41040-13	41.0	40	54	87	70	192			
42040-13	42.0	40	54	89	70	194	XO□T15M508-□□ SP□T15M510-□□	FTNA0511-E	TW20-100
43040-15	43.0	40	54	91	70	196			
44040-15	44.0	40	58	93	70	198			
45040-15	45.0	40	58	95	70	200			
46040-15	46.0	40	58	97	70	202			
47040-15	47.0	40	58	99	70	204			
48040-15	48.0	40	58	101	70	206	XO□T180508-□□ SP□T180510-□□	FTNA0511-E	TW20-100
49040-15	49.0	40	58	103	70	208			
50040-15	50.0	40	58	105	70	210			
51040-18	51.0	40	58	107	70	212			
52040-18	52.0	40	58	109	70	214			
53040-18	53.0	40	58	111	70	216			
54040-18	54.0	40	58	113	70	218	XO□T180508-□□ SP□T180510-□□	FTNA0511-E	TW20-100
55040-18	55.0	40	64	115	70	220			
56040-18	56.0	40	64	117	70	222			
57040-18	57.0	40	64	119	70	224			
58040-18	58.0	40	64	121	70	226			
59040-18	59.0	40	64	123	70	228			
60040-18	60.0	40	64	125	70	230			

※ KED inserts are interchangeable with KING DRILL inserts, but some parts such as screws and wrenches are exclusive to the KED line-up.

# KED Drill-3D

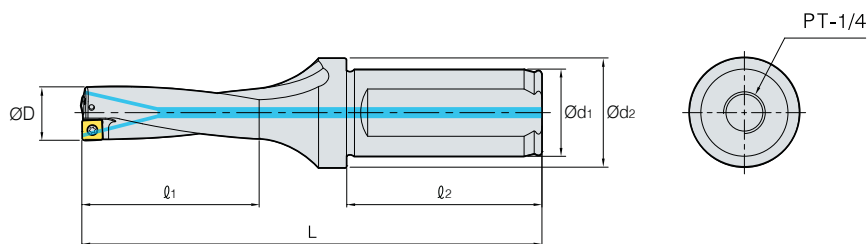


(mm)

Designation	ØD	Ød <sub>1</sub>	Ød <sub>2</sub>	l <sub>1</sub>	l <sub>2</sub>	L	Insert	Screw	Wrench	
<b>E3D-</b>	13020-04	13.0	20	27	42	50	112	XO□T040204-□□ SP□T040204-□□	FTNA0204	TW06P
	13520-04	13.5	20	27	44	50	114			
	14020-05	14.0	20	27	45	50	115			
	14520-05	14.5	20	27	47	50	117			
	15020-05	15.0	20	30	48	50	118	XO□T050204-□□ SP□T050204-□□	FTNA0204	TW06P
	15520-05	15.5	20	30	50	50	120			
	16020-05	16.0	20	30	51	50	121			
	16525-06	16.5	25	34	53	56	134			
	17025-06	17.0	25	34	54	56	135			
	17525-06	17.5	25	34	56	56	137			
	18025-06	18.0	25	34	57	56	138	XO□T060204-□□ SP□T060205-□□	FTKA02206-E	TW06P
	18525-06	18.5	25	34	59	56	140			
	19025-06	19.0	25	34	60	56	141			
	19525-06	19.5	25	34	62	56	143			
	20025-07	20.0	25	34	63	56	144			
	20525-07	20.5	25	34	65	56	146			
	21025-07	21.0	25	34	66	56	147			
	21525-07	21.5	25	34	68	56	149	XO□T7T205-□□ SP□T07T208-□□	FTKA02565-E	TW08P
	22025-07	22.0	25	34	69	56	150			
	22525-07	22.5	25	34	71	56	152			
	23025-07	23.0	25	34	72	56	153			
	23525-07	23.5	25	34	74	56	155			
	24032-09	24.0	32	42	75	60	165			
	24532-09	24.5	32	42	77	60	167			
25032-09	25.0	32	42	78	60	168				
25532-09	25.5	32	42	80	60	170				
26032-09	26.0	32	42	81	60	171				
26532-09	26.5	32	42	83	60	173	XO□T090305-□□ SP□T090308-□□	FTKA0307-E	TW08P	
27032-09	27.0	32	42	84	60	174				
27532-09	27.5	32	42	86	60	176				
28032-09	28.0	32	42	87	60	177				
28532-09	28.5	32	42	89	60	179				
29032-09	29.0	32	42	90	60	180				
29532-09	29.5	32	44	92	60	182				

※ KED inserts are interchangeable with KING DRILL inserts, but some parts such as screws and wrenches are exclusive to the KED line-up.

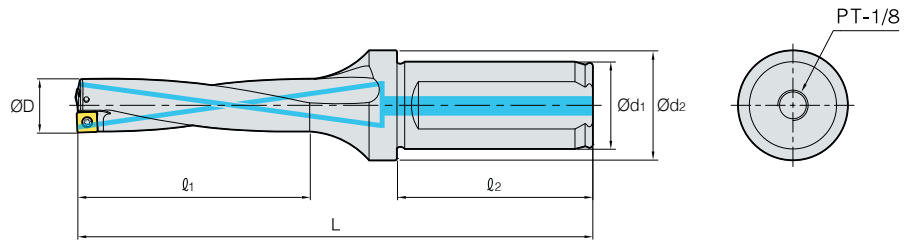
# KED Drill-3D



(mm)

Designation	ØD	Ød <sub>1</sub>	Ød <sub>2</sub>	l <sub>1</sub>	l <sub>2</sub>	L	Insert	Screw	Wrench
<b>E3D-</b>	30032-11	30.0	32	44	95	60	XO□T11T306-□□ SP□T11T308-□□	FTKA03508-E	TW15P
	31032-11	31.0	32	44	98	60			
	32032-11	32.0	32	44	101	60			
	33032-11	33.0	32	44	104	60			
	34032-11	34.0	32	44	107	60			
	35032-11	35.0	32	44	110	60			
	36040-13	36.0	40	54	113	70	XO□T130406-□□ SP□T130410-□□	FTKA0410-E	TW15P
	37040-13	37.0	40	54	116	70			
	38040-13	38.0	40	54	119	70			
	39040-13	39.0	40	54	122	70			
	40040-13	40.0	40	54	125	70			
	41040-13	41.0	40	54	128	70			
	42040-13	42.0	40	54	131	70	XO□T15M508-□□ SP□T15M510-□□	FTNA0511-E	TW20-100
	43040-15	43.0	40	54	134	70			
	44040-15	44.0	40	58	137	70			
	45040-15	45.0	40	58	140	70			
	46040-15	46.0	40	58	143	70			
	47040-15	47.0	40	58	146	70			
	48040-15	48.0	40	58	149	70	XO□T180508-□□ SP□T180510-□□	FTNA0511-E	TW20-100
	49040-15	49.0	40	58	152	70			
	50040-15	50.0	40	58	155	70			
	51040-18	51.0	40	58	158	70			
	52040-18	52.0	40	58	161	70			
	53040-18	53.0	40	58	164	70			
54040-18	54.0	40	58	167	70	XO□T180508-□□ SP□T180510-□□	FTNA0511-E	TW20-100	
55040-18	55.0	40	64	170	70				
56040-18	56.0	40	64	173	70				
57040-18	57.0	40	64	176	70				
58040-18	58.0	40	64	179	70				
59040-18	59.0	40	64	182	70				
60040-18	60.0	40	64	185	70				

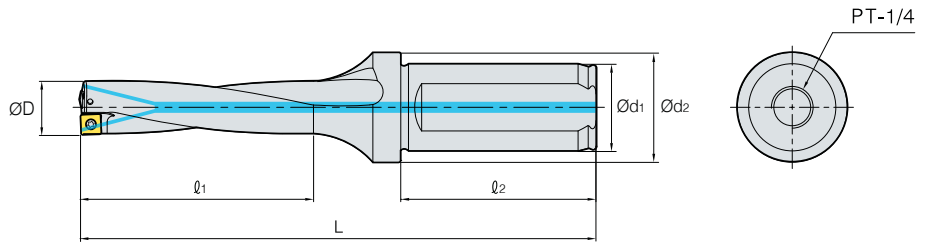
※ KED inserts are interchangeable with KING DRILL inserts, but some parts such as screws and wrenches are exclusive to the KED line-up.



(mm)

Designation	ØD	Ød1	Ød2	l1	l2	L	Insert	Screw	Wrench	
<b>E4D-</b>	13020-04	13.0	20	27	55	50	125	XO□T040204-□□ SP□T040204-□□	FTNA0204	TW06P
	13520-04	13.5	20	27	57	50	127			
	14020-05	14.0	20	27	59	50	129			
	14520-05	14.5	20	27	61	50	131			
	15020-05	15.0	20	30	63	50	133	XO□T050204-□□ SP□T050204-□□	FTNA0204	TW06P
	15520-05	15.5	20	30	65	50	135			
	16020-05	16.0	20	30	67	50	137			
	16525-06	16.5	25	34	69	56	150			
	17025-06	17.0	25	34	71	56	152			
	17525-06	17.5	25	34	73	56	154			
	18025-06	18.0	25	34	75	56	156	XO□T060204-□□ SP□T060205-□□	FTKA02206-E	TW06P
	18525-06	18.5	25	34	77	56	158			
	19025-06	19.0	25	34	79	56	160			
	19525-06	19.5	25	34	81	56	162			
	20025-07	20.0	25	34	83	56	164			
	20525-07	20.5	25	34	85	56	166			
	21025-07	21.0	25	34	87	56	168			
	21525-07	21.5	25	34	89	56	170	XO□T07T205-□□ SP□T07T208-□□	FTKA02565-E	TW08P
	22025-07	22.0	25	34	91	56	172			
	22525-07	22.5	25	34	93	56	174			
	23025-07	23.0	25	34	95	56	176			
	23525-07	23.5	25	34	97	56	178			
	24032-09	24.0	32	42	99	60	189			
	24532-09	24.5	32	42	101	60	191			
	25032-09	25.0	32	42	103	60	193			
	25532-09	25.5	32	42	105	60	195			
	26032-09	26.0	32	42	107	60	197			
	26532-09	26.5	32	42	109	60	199	XO□T090305-□□ SP□T090308-□□	FTKA0307-E	TW08P
27032-09	27.0	32	42	111	60	201				
27532-09	27.5	32	42	113	60	203				
28032-09	28.0	32	42	115	60	205				
28532-09	28.5	32	42	117	60	207				
29032-09	29.0	32	42	119	60	209				
29532-09	29.5	32	44	121	60	211				

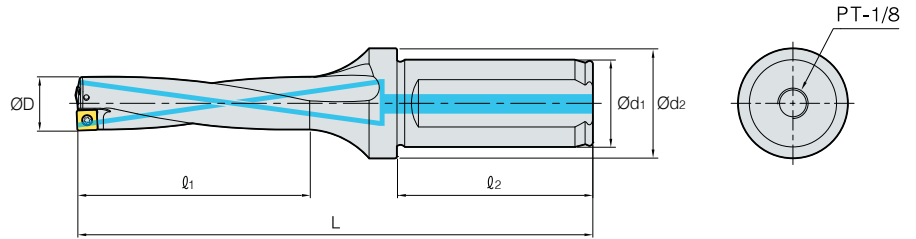
※ KED inserts are interchangeable with KING DRILL inserts, but some parts such as screws and wrenches are exclusive to the KED line-up.



(mm)

Designation	ØD	Ød <sub>1</sub>	Ød <sub>2</sub>	l <sub>1</sub>	l <sub>2</sub>	L	Insert	Screw	Wrench	
<b>E4D-</b>	30032-11	30.0	32	44	125	60	215	XO□T11T306-□□ SP□T11T308-□□	FTKA03508-E	TW15P
	31032-11	31.0	32	44	129	60	219			
	32032-11	32.0	32	44	133	60	223			
	33032-11	33.0	32	44	137	60	227			
	34032-11	34.0	32	44	141	60	231			
	35032-11	35.0	32	44	145	60	235			
	36040-13	36.0	40	54	149	70	254	XO□T130406-□□ SP□T130410-□□	FTKA0410-E	TW15P
	37040-13	37.0	40	54	153	70	258			
	38040-13	38.0	40	54	157	70	262			
	39040-13	39.0	40	54	161	70	266			
	40040-13	40.0	40	54	165	70	270			
	41040-13	41.0	40	54	169	70	274			
	42040-13	42.0	40	54	173	70	278	XO□T15M508-□□ SP□T15M510-□□	FTNA0511-E	TW20-100
	43040-15	43.0	40	54	177	70	282			
	44040-15	44.0	40	58	181	70	286			
	45040-15	45.0	40	58	185	70	290			
	46040-15	46.0	40	58	189	70	294			
	47040-15	47.0	40	58	193	70	298			
	48040-15	48.0	40	58	197	70	302	XO□T180508-□□ SP□T180510-□□	FTNA0511-E	TW20-100
	49040-15	49.0	40	58	201	70	306			
	50040-15	50.0	40	58	205	70	310			
	51040-18	51.0	40	58	209	70	314			
	52040-18	52.0	40	58	213	70	318			
	53040-18	53.0	40	58	217	70	322			
	54040-18	54.0	40	58	221	70	326	XO□T180508-□□ SP□T180510-□□	FTNA0511-E	TW20-100
	55040-18	55.0	40	64	225	70	330			
	56040-18	56.0	40	64	229	70	334			
	57040-18	57.0	40	64	233	70	338			
	58040-18	58.0	40	64	237	70	342			
	59040-18	59.0	40	64	241	70	346			
60040-18	60.0	40	64	245	70	350				

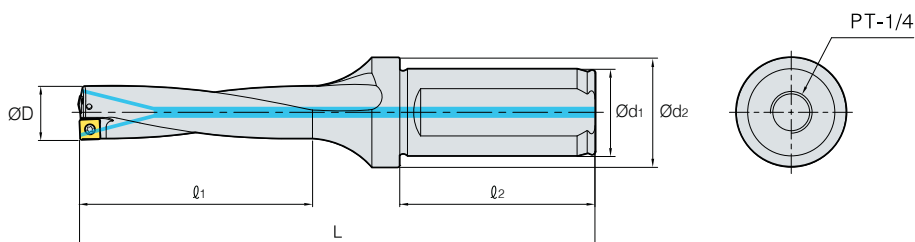
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(mm)

Designation	ØD	Ød <sub>1</sub>	Ød <sub>2</sub>	l <sub>1</sub>	l <sub>2</sub>	L	Insert	Screw	Wrench	
<b>E5D-</b>	13020-04	13.0	20	27	68	50	133	XO□T040204-□□ SP□T040204-□□	FTNA0204	TW06P
	13520-04	13.5	20	27	71	50	136			
	14020-05	14.0	20	27	73	50	138			
	14520-05	14.5	20	27	76	50	141			
	15020-05	15.0	20	30	78	50	143	XO□T050204-□□ SP□T050204-□□	FTNA0204	TW06P
	15520-05	15.5	20	30	81	50	146			
	16020-05	16.0	20	30	83	50	148			
	16525-06	16.5	25	34	86	56	162			
	17025-06	17.0	25	34	88	56	164			
	17525-06	17.5	25	34	91	56	167			
	18025-06	18.0	25	34	93	56	169	XO□T060204-□□ SP□T060205-□□	FTKA02206-E	TW06P
	18525-06	18.5	25	34	96	56	172			
	19025-06	19.0	25	34	98	56	174			
	19525-06	19.5	25	34	101	56	177			
	20025-07	20.0	25	34	103	56	179			
	20525-07	20.5	25	34	106	56	182			
	21025-07	21.0	25	34	108	56	184			
	21525-07	21.5	25	34	111	56	187	XO□T07T205-□□ SP□T07T208-□□	FTKA02565-E	TW08P
	22025-07	22.0	25	34	113	56	189			
	22525-07	22.5	25	34	116	56	192			
	23025-07	23.0	25	34	118	56	194			
	23525-07	23.5	25	34	121	56	197			
	24032-09	24.0	32	42	123	60	208			
	24532-09	24.5	32	42	126	60	211			
25032-09	25.0	32	42	128	60	213				
25532-09	25.5	32	42	131	60	216				
26032-09	26.0	32	42	133	60	218				
26532-09	26.5	32	42	136	60	221	XO□T090305-□□ SP□T090308-□□	FTKA0307-E	TW08P	
27032-09	27.0	32	42	138	60	223				
27532-09	27.5	32	42	141	60	226				
28032-09	28.0	32	42	143	60	228				
28532-09	28.5	32	42	146	60	231				
29032-09	29.0	32	42	148	60	233				
29532-09	29.5	32	44	151	60	236				

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(mm)

Designation	ØD	Ød1	Ød2	l1	l2	L	Insert	Screw	Wrench	
<b>E5D-</b>	30032-11	30.0	32	44	155	60	240	XO□T11T306-□□ SP□T11T308-□□	FTKA03508-E	TW15P
	31032-11	31.0	32	44	160	60	245			
	32032-11	32.0	32	44	165	60	250			
	33032-11	33.0	32	44	170	60	255			
	34032-11	34.0	32	44	175	60	260			
	35032-11	35.0	32	44	180	60	265			
	36040-13	36.0	40	54	185	70	285	XO□T130406-□□ SP□T130410-□□	FTKA0410-E	TW15P
	37040-13	37.0	40	54	190	70	290			
	38040-13	38.0	40	54	195	70	295			
	39040-13	39.0	40	54	200	70	300			
	40040-13	40.0	40	54	205	70	305			
	41040-13	41.0	40	54	210	70	310			
	42040-13	42.0	40	54	215	70	315	XO□T15M508-□□ SP□T15M510-□□	FTNA0511-E	TW20-100
	43040-15	43.0	40	54	220	70	320			
	44040-15	44.0	40	58	225	70	325			
	45040-15	45.0	40	58	230	70	330			
	46040-15	46.0	40	58	235	70	335			
	47040-15	47.0	40	58	240	70	340			
	48040-15	48.0	40	58	245	70	345	XO□T180508-□□ SP□T180510-□□	FTNA0511-E	TW20-100
	49040-15	49.0	40	58	250	70	350			
	50040-15	50.0	40	58	255	70	355			
	51040-18	51.0	40	58	260	70	360			
	52040-18	52.0	40	58	265	70	365			
	53040-18	53.0	40	58	270	70	370			
54040-18	54.0	40	58	275	70	375	XO□T180508-□□ SP□T180510-□□	FTNA0511-E	TW20-100	
55040-18	55.0	40	64	280	70	380				
56040-18	56.0	40	64	285	70	385				
57040-18	57.0	40	64	290	70	390				
58040-18	58.0	40	64	295	70	395				
59040-18	59.0	40	64	300	70	400				
60040-18	60.0	40	64	305	70	405				

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***www.korloy.com***



Holystar B/D, 1350, Nambusunhwan-ro, Geumcheon-gu, Seoul, 08536, Korea  
Tel : +82-2-522-3181 Fax : +82-2-522-3184, +82-2-3474-4744 Web : [www.korloy.com](http://www.korloy.com) E-mail : [export@korloy.com](mailto:export@korloy.com)

### **KORLOY AMERICA**

620 Maple Avenue, Torrance, CA 90503, USA  
Tel : +1-310-782-3800 Toll Free : +1-888-711-0001 Fax : +1-310-782-3885  
[www.korloyamerica.com](http://www.korloyamerica.com) E-mail : [sales@korloy.us](mailto:sales@korloy.us)

### **KORLOY INDIA**

Plot NO.415, Sector 8, IMT Manesar, Gurgaon 122051, Haryana, INDIA  
Tel : +91-124-4391790 Fax : +91-124-4050032  
[www.korloyindia.com](http://www.korloyindia.com) E-mail : [sales.kip@korloy.com](mailto:sales.kip@korloy.com)

### **KORLOY VIETNAM**

No. 133 Le Loi street, Hoa Phu ward, Thu Dau Mot city,  
Binh Duong proviende, Vietnam  
Tel : +86-532-86959880

### **KORLOY FACTORY QINGDAO**

Ground Dongjing Road 56 District Free Trade Zone. Qingdao, China  
Tel : +86-532-86959880 Fax : +86-532-86760651  
E-mail : [kycpjh@korloy.com](mailto:kycpjh@korloy.com)

### **KORLOY EUROPE**

Gablonzer Str. 25-27, 61440 Oberursel, Germany  
Tel : +49-6171-277-83-0 Fax : +49-6171-277-83-59  
[www.korloyeurope.com](http://www.korloyeurope.com) E-mail : [sales@korloyeurope.com](mailto:sales@korloyeurope.com)

### **KORLOY BRASIL**

Av. Aruana 280, conj.12, WLC, Alphaville, Barueri,  
CEP06460-010, SP, Brasil  
Tel : +55-11-4193-3810 E-mail : [vendas@korloy.com](mailto:vendas@korloy.com)

### **KORLOY FACTORY INDIA**

Plot No. 415, Sector 8, IMT Manesar, Gurgaon 122051, Haryana, India  
Tel : +91-124-4391790 Fax : +91-124-4050032  
[www.korloyindia.com](http://www.korloyindia.com) E-mail : [kimindia@korloy.com](mailto:kimindia@korloy.com)