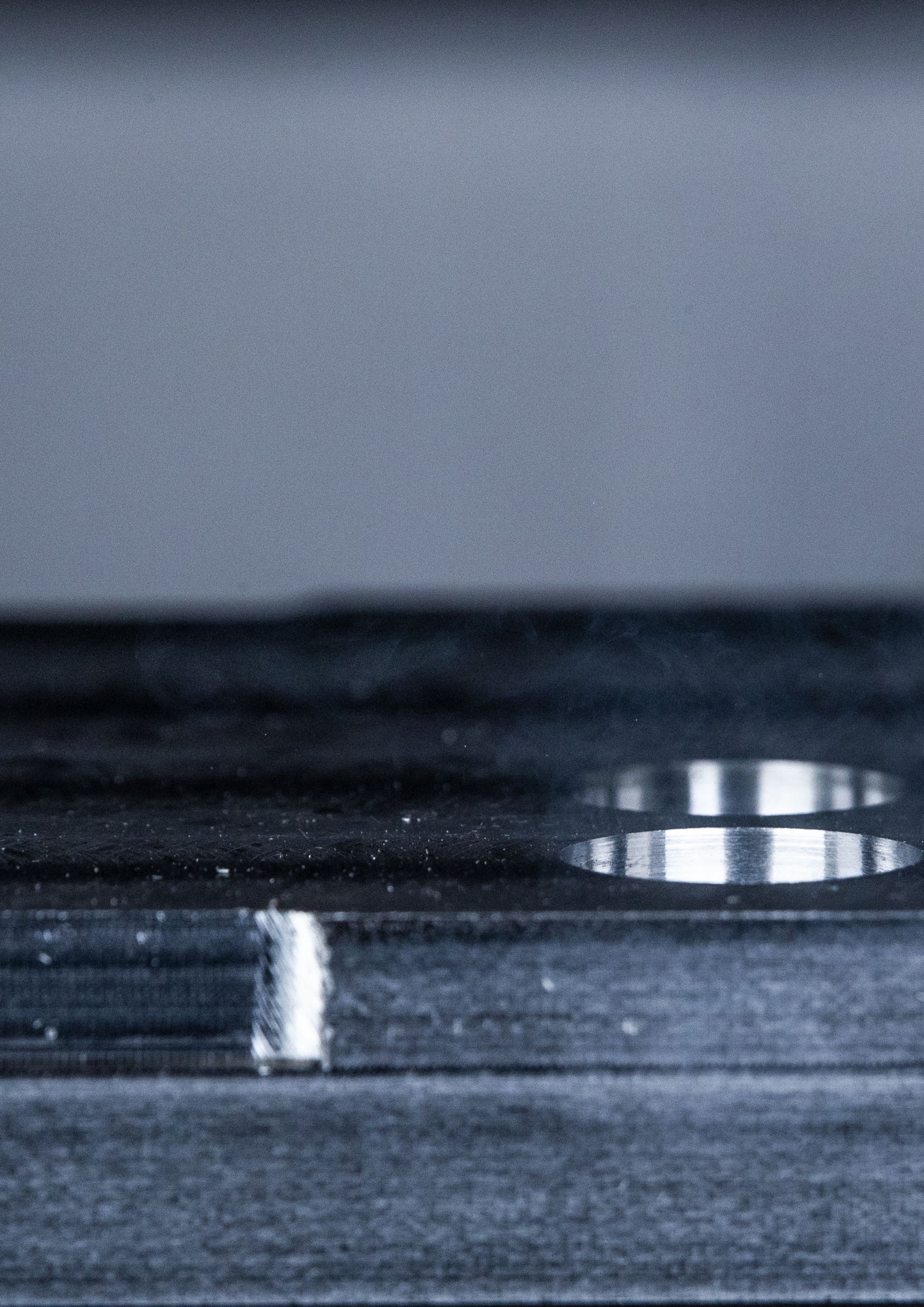
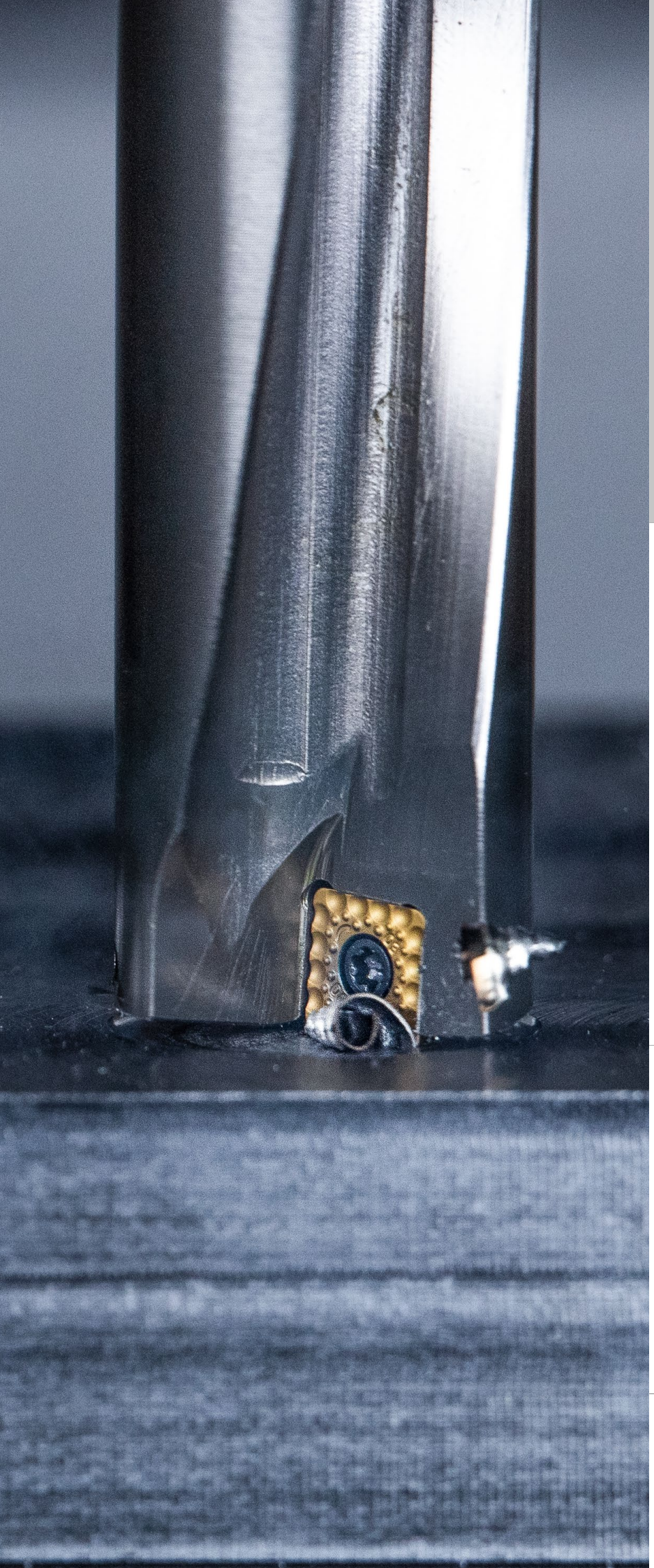




List of contents

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.

Symbol explanation

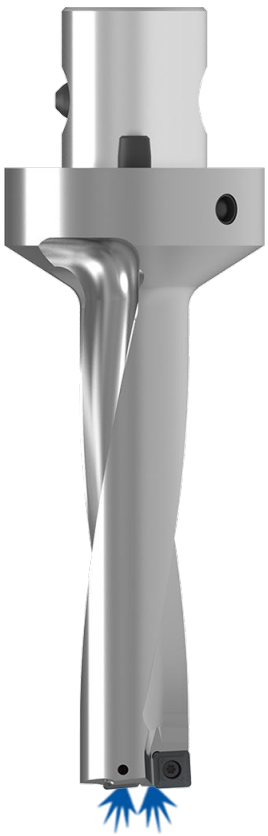
Shank

C

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

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



Coolant supply version

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

Application tips – Torsional vibration dampeners and eccentric adjusting devices

The modular concept of the ABS connection, will allow you to easily and quickly optimize your drilling operation. Two example of this are the torsional dampening devices and the eccentric adjusting devices.

Torsional vibration dampeners change the natural frequency of the drill assembly.
This results in:

- A significant noise reduction
- Considerably longer tool life
- Improved surface finish
- Improved process reliability

Eccentric adapter with ABS connection

Using an eccentric adapter, along with an ABS drill, you can easily vary and adjust the diameter of the hole by +/- 0.25mm (+/- .010").

metric

Additional metric items are available in our Online-Shop at cuttingtools.ceratizit.com and in the metric main catalog.

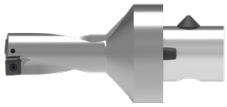
Toolfinder

KUB Pentron

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

Boring depth	Drilling through a cross hole	Stack plate drilling	Drilling on uneven surfaces	Boring	Spot drilling an edge	Spot drilling a convex surface	Spot drilling angled surfaces	Spot drilling a pointed contour	Chain drilling	Spot drilling through a center in the pre-op
4xD	●	●	○	-	●	●	●	●	○	●
5xD	●	○	○	-	●	○	●	○	-	○
4xD	●	●	○	-	●	●	●	●	○	●
5xD	●	○	○	-	●	○	●	○	-	○

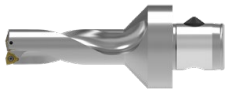
KUB Quatron



- Provides perfect drilling quality even under enormous loads
- For stable machining situations

Boring depth	Drilling through a cross hole	Stack plate drilling	Drilling on uneven surfaces	Boring	Spot drilling an edge	Spot drilling a convex surface	Spot drilling angled surfaces	Spot drilling a pointed contour	Chain drilling	Spot drilling through a center in the pre-op
2xD	●	●	●	○	○	●	●	○	●	●
3xD	●	●	●	○	○	●	●	○	●	●
2xD	●	●	●	○	○	●	●	○	●	●
3xD	●	●	●	○	○	●	●	○	●	●

KUB Trigon



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

Boring depth	Drilling through a cross hole	Stack plate drilling	Drilling on uneven surfaces	Boring	Spot drilling an edge	Spot drilling a convex surface	Spot drilling angled surfaces	Spot drilling a pointed contour	Chain drilling	Spot drilling through a center in the pre-op
2xD	●	-	●	●	○	●	●	○	●	○
3xD	●	-	●	●	○	●	●	○	●	○
4xD	○	-	○	-	-	○	○	-	○	○
2.5xD	●	-	●	●	○	●	●	○	●	○
4xD	○	-	○	-	-	○	○	-	○	○

MaxiDrill 900

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

Boring depth	Drilling through a cross hole	Stack plate drilling	Drilling on uneven surfaces	Boring	Spot drilling an edge	Spot drilling a convex surface	Spot drilling angled surfaces	Spot drilling a pointed contour	Chain drilling	Spot drilling through a center in the pre-op
3xD	●	●	●	○	●	●	●	●	○	●
5xD	●	○	○	○	●	●	●	●	○	●

KUB Centron

- Cost-effective and process-secure drilling
- Hole depths up to 9xD in virtually all materials
- HSS or solid carbide centering tip for optimum positioning accuracy

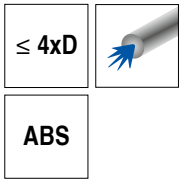
Boring depth	Drilling through a cross hole	Stack plate drilling	Drilling on uneven surfaces	Boring	Spot drilling an edge	Spot drilling a convex surface	Spot drilling angled surfaces	Spot drilling a pointed contour	Chain drilling	Spot drilling through a center in the pre-op
4xD	○	-	●	-	-	○	-	-	○	●
6xD	○	-	●	-	-	○	-	-	○	●
9xD	○	-	●	-	-	○	-	-	○	●

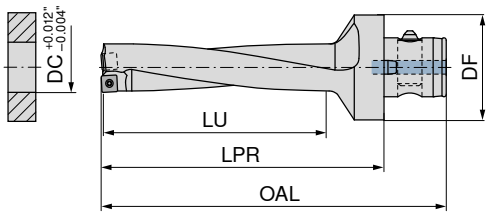
Shank	Diameter Ø	Page No.	Insert type	No. of cutting edges	P Steel	M Stainless steel	K Cast iron	N Non-ferrous metals	S Heat-resistant	H Tempered steel	O Non-metal materials	Page No.
ABS	**0.562 – 1.752**	6+7										
ABS	**0.562 – 1.752**	8+9										
C	**0.562 – 1.750**	10+11	 SOGX	4	●	●	●	●	●	○	○	14+15
C	**0.562 – 1.750**	12+13										
ABS	**0.562 – 2.500**	16+17										
ABS	**0.562 – 2.500**	18+19										
C	**0.562 – 1.750**	20+21	 SOEX	4	●	●	●	●	●	○	○	24+25
C	**0.562 – 1.750**	22+23										
ABS	**0.562 – 3.250**	26+27										
ABS	**0.562 – 3.250**	28+29										
ABS	**0.562 – 1.750**	30	 WOEX	3	●	●	●	○	●	○	○	40+41
C	**0.562 – 3.250**	31–33										
C	**0.562 – 1.750**	34+35										
C	**0.480 – 2.483**	 metric	 SONT	2 4	●	●	●	○	○			 metric
C	**0.480 – 1.614**											
ABS	**0.812 – 2.500**		 WOEX	3	●	●	●	○	●	○	○	40+41
ABS	**0.812 – 2.500**	36–38	KUB Centron – centering tips									
ABS	**0.812 – 2.500**			Ø 5 – 10 mm	●	●	●	●	○		○	39

KUB Pentron – Indexable insert drill

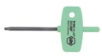
Scope of supply:

Indexable Insert Drill incl. clamping screws





Designation	KOMET no.	DC inch	DF inch	OAL inch	LU inch	LPR inch	Insert	torque moment Nm	10 874 ...	15 874 ...
KUB-P.4D.0562.R.04.ABS50-F	U44 51430	0.562	1.969	4.685	2.362	3.465	SOGX 040204	0,38		**14395**
KUB-P.4D.0593.R.04.ABS50-F	U44 51510	0.593	1.969	4.921	2.520	3.701	SOGX 040204	0,38		**15195**
KUB-P.4D.0625.R.04.ABS50-F	U44 51590	0.625	1.969	4.921	2.520	3.701	SOGX 040204	0,38		**15995**
KUB-P.4D.0656.R.05.ABS50-F	U44 51670	0.656	1.969	5.118	2.677	3.898	SOGX 050204	0,62		**16795**
KUB-P.4D.0687.R.05.ABS50	U44 51750	0.689	1.969	5.276	2.835	4.055	SOGX 050204	0,62	**17595**	
KUB-P.4D.0703.R.05.ABS50-F	U44 51790	0.703	1.969	5.275	2.835	4.055	SOGX 050204	0,62		**17995**
KUB-P.4D.0750.R.06.ABS50-F	U44 51910	0.750	1.969	5.629	3.150	4.409	SOGX 060206	1,01		**19195**
KUB-P.4D.0765.R.06.ABS50-F	U44 51940	0.765	1.969	5.629	3.150	4.409	SOGX 060206	1,01		**19495**
KUB-P.4D.0781.R.06.ABS50-F	U44 51980	0.781	1.969	5.629	3.150	4.409	SOGX 060206	1,01		**19895**
KUB-P.4D.0812.R.07.ABS50-F	U44 52060	0.812	1.969	5.787	3.307	4.567	SOGX 07T208	1,01		**20695**
KUB-P.4D.0828.R.07.ABS50	U44 52100	0.827	1.969	5.787	3.307	4.567	SOGX 07T208	1,01	**21095**	
KUB-P.4D.0875.R.07.ABS50-F	U44 52220	0.875	1.969	6.102	3.622	4.882	SOGX 07T208	1,01		**22295**
KUB-P.4D.0906.R.07.ABS50	U44 52300	0.906	1.969	6.102	3.622	4.882	SOGX 07T208	1,01	**23095**	
KUB-P.4D.0937.R.08.ABS50-F	U44 52380	0.937	1.969	6.259	3.780	5.039	SOGX 080308	1,28		**23895**
KUB-P.4D.0985.R.08.ABS50	U44 52500	0.984	1.969	6.457	3.937	5.236	SOGX 080308	1,28	**25095**	
KUB-P.4D.1000.R.08.ABS50-F	U44 52540	1.000	1.969	6.614	4.094	5.394	SOGX 080308	1,28		**25495**
KUB-P.4D.1031.R.09.ABS50-F	U44 52620	1.031	1.969	6.811	4.252	5.591	SOGX 09T308	2,25		**26295**
KUB-P.4D.1062.R.09.ABS50	U44 52700	1.063	1.969	6.811	4.252	5.591	SOGX 09T308	2,25	**27095**	
KUB-P.4D.1109.R.09.ABS50-F	U44 52820	1.109	1.969	7.165	4.567	5.945	SOGX 09T308	2,25		**28295**
KUB-P.4D.1125.R.09.ABS50-F	U44 52860	1.125	1.969	7.165	4.567	5.945	SOGX 09T308	2,25		**28695**
KUB-P.4D.1156.R.09.ABS50-F	U44 52940	1.156	1.969	7.322	4.724	6.102	SOGX 09T308	2,25		**29495**
KUB-P.4D.1187.R.10.ABS63-F	U44 63020	1.187	2.480	7.913	4.882	6.417	SOGX 100408	2,8		**30196**
KUB-P.4D.1218.R.10.ABS63-F	U44 63090	1.218	2.480	7.913	4.882	6.417	SOGX 100408	2,8		**30996**
KUB-P.4D.1250.R.10.ABS63-F	U44 63180	1.250	2.480	8.071	5.039	6.575	SOGX 100408	2,8		**31896**
KUB-P.4D.1281.R.10.ABS63	U44 63250	1.280	2.480	8.268	5.197	6.772	SOGX 100408	2,8	**32596**	
KUB-P.4D.1312.R.11.ABS63-F	U44 63330	1.312	2.480	8.425	5.354	6.929	SOGX 110408	2,8		**33396**
KUB-P.4D.1328.R.11.ABS63-F	U44 63370	1.328	2.480	8.425	5.354	6.929	SOGX 110408	2,8		**33796**
KUB-P.4D.1375.R.11.ABS63-F	U44 63490	1.375	2.480	8.622	5.512	7.126	SOGX 110408	2,8		**34996**
KUB-P.4D.1437.R.11.ABS63	U44 63650	1.437	2.480	8.976	5.827	7.480	SOGX 110408	2,8	**36596**	
KUB-P.4D.1469.R.12.ABS63-F	U44 63730	1.469	2.480	9.134	5.984	7.638	SOGX 120408	6,25		**37396**
KUB-P.4D.1500.R.12.ABS63-F	U44 63810	1.500	2.480	9.331	6.142	7.835	SOGX 120408	6,25		**38196**
KUB-P.4D.1562.R.12.ABS63-F	U44 63970	1.562	2.480	9.488	6.299	7.992	SOGX 120408	6,25		**39796**
KUB-P.4D.1625.R.12.ABS63-F	U44 64130	1.625	2.480	9.842	6.614	8.346	SOGX 120408	6,25		**41396**
KUB-P.4D.1656.R.13.ABS63-F	U44 64210	1.656	2.480	10.039	6.772	8.543	SOGX 130508	6,25		**42196**
KUB-P.4D.1687.R.13.ABS63-F	U44 64290	1.687	2.480	10.039	6.772	8.543	SOGX 130508	6,25		**42896**
KUB-P.4D.1750.R.13.ABS63	U44 64450	1.752	2.480	10.394	7.087	8.898	SOGX 130508	6,25	**44596**	

		 Key			 Screwdriver		 Clamping screw	
		80 950 ...			**80 950 ...**		**10 950 ...**	
Spare parts DC								
0.562 - 0.625	T05 - IP	**057**					M1,8x3,8 - 05IP	**10100**
0.656 - 0.703				T06 - IP	**123**		M2,0x4,3 - 06IP	**10000**
0.750 - 0.906				T06 - IP	**123**		M2,2x5,5 - 06IP	**10700**
0.937 - 1.000				T08 - IP	**125**		M2,5x6,3 - 08IP	**10800**
1.031 - 1.156				T08 - IP	**125**		M3,0x7,6 - 08IP	**10200**
1.187 - 1.437				T15 - IP	**128**		M3,5x7,5 - 15IP	**10300**
1.469 - 1.752				T20 - IP	**129**		M4,5x10 - 20IP	**10400**

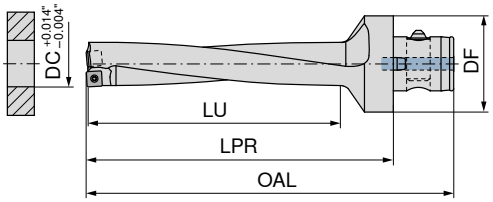
Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

KUB Pentron – Indexable insert drill

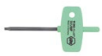
Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 5xD

ABS



Designation	KOMET no.	DC inch	DF inch	OAL inch	LU inch	LPR inch	Insert	torque moment Nm	10 875 ...	15 875 ...
KUB-P.5D.0562.R.04.ABS50-F	U45 51430	0.562	1.969	5.275	2.953	4.055	SOGX 040204	0,38		14395
KUB-P.5D.0593.R.04.ABS50-F	U45 51510	0.593	1.969	5.551	3.150	4.331	SOGX 040204	0,38		15195
KUB-P.5D.0625.R.04.ABS50-F	U45 51590	0.625	1.969	5.551	3.150	4.331	SOGX 040204	0,38		15995
KUB-P.5D.0656.R.05.ABS50-F	U45 51670	0.656	1.969	5.787	3.346	4.567	SOGX 050204	0,62		16795
KUB-P.5D.0687.R.05.ABS50	U45 51750	0.689	1.969	5.984	3.543	4.764	SOGX 050204	0,62	17595	
KUB-P.5D.0703.R.05.ABS50-F	U45 51790	0.703	1.969	5.984	3.543	4.764	SOGX 050204	0,62		17995
KUB-P.5D.0750.R.06.ABS50-F	U45 51910	0.750	1.969	6.417	3.937	5.197	SOGX 060206	1,01		19195
KUB-P.5D.0765.R.06.ABS50-F	U45 51940	0.765	1.969	6.417	3.937	5.197	SOGX 060206	1,01		19495
KUB-P.5D.0781.R.06.ABS50-F	U45 51980	0.781	1.969	6.417	3.937	5.197	SOGX 060206	1,01		19895
KUB-P.5D.0812.R.07.ABS50-F	U45 52060	0.812	1.969	6.614	4.134	5.394	SOGX 07T208	1,01		20695
KUB-P.5D.0828.R.07.ABS50	U45 52100	0.827	1.969	6.614	4.134	5.394	SOGX 07T208	1,01	21095	
KUB-P.5D.0875.R.07.ABS50-F	U45 52220	0.875	1.969	7.007	4.528	5.787	SOGX 07T208	1,01		22295
KUB-P.5D.0906.R.07.ABS50	U45 52300	0.906	1.969	7.008	4.528	5.787	SOGX 07T208	1,01	23095	
KUB-P.5D.0937.R.08.ABS50-F	U45 52380	0.937	1.969	7.204	4.724	5.984	SOGX 080308	1,28		23895
KUB-P.5D.0985.R.08.ABS50	U45 52500	0.984	1.969	7.441	4.921	6.220	SOGX 080308	1,28	25095	
KUB-P.5D.1000.R.08.ABS50-F	U45 52540	1.000	1.969	7.637	5.118	6.417	SOGX 080308	1,28		25495
KUB-P.5D.1031.R.09.ABS50-F	U45 52620	1.031	1.969	7.874	5.315	6.654	SOGX 09T308	2,25		26295
KUB-P.5D.1062.R.09.ABS50	U45 52700	1.063	1.969	7.874	5.315	6.654	SOGX 09T308	2,25	27095	
KUB-P.5D.1109.R.09.ABS50-F	U45 52820	1.109	1.969	8.307	5.709	7.087	SOGX 09T308	2,25		28295
KUB-P.5D.1125.R.09.ABS50-F	U45 52860	1.125	1.969	8.307	5.709	7.087	SOGX 09T308	2,25		28695
KUB-P.5D.1156.R.09.ABS50-F	U45 52940	1.156	1.969	8.503	5.906	7.283	SOGX 09T308	2,25		29495
KUB-P.5D.1187.R.10.ABS63-F	U45 63020	1.187	2.480	9.134	6.102	7.638	SOGX 100408	2,8		30196
KUB-P.5D.1218.R.10.ABS63-F	U45 63090	1.218	2.480	9.134	6.102	7.638	SOGX 100408	2,8		30996
KUB-P.5D.1250.R.10.ABS63-F	U45 63180	1.250	2.480	9.331	6.299	7.835	SOGX 100408	2,8		31896
KUB-P.5D.1281.R.10.ABS63	U45 63250	1.280	2.480	9.567	6.496	8.071	SOGX 100408	2,8	32596	
KUB-P.5D.1312.R.11.ABS63-F	U45 63330	1.312	2.480	9.764	6.693	8.268	SOGX 110408	2,8		33396
KUB-P.5D.1328.R.11.ABS63-F	U45 63370	1.328	2.480	9.764	6.693	8.268	SOGX 110408	2,8		33796
KUB-P.5D.1375.R.11.ABS63-F	U45 63490	1.375	2.480	10.000	6.890	8.504	SOGX 110408	2,8		34996
KUB-P.5D.1437.R.11.ABS63	U45 63650	1.437	2.480	10.433	7.283	8.937	SOGX 110408	2,8	36596	
KUB-P.5D.1469.R.12.ABS63-F	U45 63730	1.469	2.480	10.630	7.480	9.134	SOGX 120408	6,25		37396
KUB-P.5D.1500.R.12.ABS63-F	U45 63810	1.500	2.480	10.866	7.677	9.370	SOGX 120408	6,25		38196
KUB-P.5D.1562.R.12.ABS63-F	U45 63970	1.562	2.480	11.063	7.874	9.567	SOGX 120408	6,25		39796
KUB-P.5D.1625.R.12.ABS63-F	U45 64130	1.625	2.480	11.496	8.268	10.000	SOGX 120408	6,25		41396
KUB-P.5D.1656.R.13.ABS63-F	U45 64210	1.656	2.480	11.732	8.465	10.236	SOGX 130508	6,25		42196
KUB-P.5D.1687.R.13.ABS63-F	U45 64290	1.687	2.480	11.732	8.465	10.236	SOGX 130508	6,25		42896
KUB-P.5D.1750.R.13.ABS63	U45 64450	1.752	2.480	12.165	8.858	10.669	SOGX 130508	6,25	44596	

		 Key			 Screwdriver		 Clamping screw	
		80 950 ...			**80 950 ...**		**10 950 ...**	
Spare parts DC								
0.562 - 0.625	T05 - IP	**057**					M1,8x3,8 - 05IP	**10100**
0.656 - 0.703				T06 - IP	**123**		M2,0x4,3 - 06IP	**10000**
0.750 - 0.906				T06 - IP	**123**		M2,2x5,5 - 06IP	**10700**
0.984 - 1.000				T08 - IP	**125**		M2,5x6,3 - 08IP	**10800**
1.031 - 1.156				T08 - IP	**125**		M3,0x7,6 - 08IP	**10200**
1.187 - 1.437				T15 - IP	**128**		M3,5x7,5 - 15IP	**10300**
1.469 - 1.752				T20 - IP	**129**		M4,5x10 - 20IP	**10400**

Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

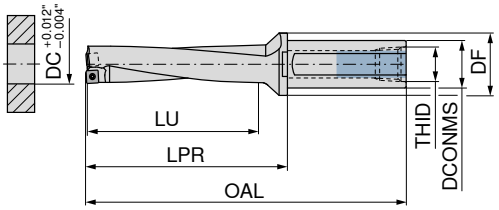
KUB Pentron – Indexable insert drill

Scope of supply:

Indexable Insert Drill incl. clamping screws

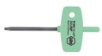
≤ 4xD

C



15 874 ...

Designation	KOMET no.	DC inch	DCONMS inch	DF inch	OAL inch	LU inch	LPR inch	THID inch	Insert	torque moment Nm	
KUB-P.4D.0562.R.04.C0750-EF	U44 81430	0.562	0.750	1.180	5.163	2.362	2.913	1/8" NPT	SOGX 040204	0,38	**14309**
KUB-P.4D.0593.R.04.C0750-EF	U44 81510	0.593	0.750	1.180	5.400	2.520	3.150	1/8" NPT	SOGX 040204	0,38	**15109**
KUB-P.4D.0625.R.04.C0750-EF	U44 81590	0.625	0.750	1.180	5.400	2.520	3.150	1/8" NPT	SOGX 040204	0,38	**15909**
KUB-P.4D.0656.R.05.C0750-EF	U44 81670	0.656	0.750	1.180	5.596	2.677	3.346	1/8" NPT	SOGX 050204	0,62	**16709**
KUB-P.4D.0687.R.05.C1000-E	U44 81750	0.687	1.000	1.180	6.754	2.835	3.504	1/8" NPT	SOGX 050204	0,62	**17500**
KUB-P.4D.0703.R.05.C1000-EF	U44 81790	0.703	1.000	1.180	6.754	2.835	3.504	1/8" NPT	SOGX 050204	0,62	**17900**
KUB-P.4D.0750.R.06.C1000-EF	U44 81910	0.750	1.000	1.180	7.108	3.150	3.858	1/8" NPT	SOGX 060206	1,01	**19100**
KUB-P.4D.0765.R.06.C1000-EF	U44 81940	0.765	1.000	1.180	7.108	3.150	3.858	1/8" NPT	SOGX 060206	1,01	**19400**
KUB-P.4D.0781.R.06.C1000-EF	U44 81980	0.781	1.000	1.180	7.108	3.150	3.858	1/8" NPT	SOGX 060206	1,01	**19800**
KUB-P.4D.0812.R.07.C1000-EF	U44 82060	0.812	1.000	1.180	7.305	3.307	4.055	1/8" NPT	SOGX 07T208	1,01	**20600**
KUB-P.4D.0828.R.07.C1000-E	U44 82100	0.828	1.000	1.180	7.305	3.307	4.055	1/8" NPT	SOGX 07T208	1,01	**21000**
KUB-P.4D.0843.R.07.C1000-EF	U44 82140	0.843	1.000	1.180	7.974	3.465	4.724	1/8" NPT	SOGX 07T208	1,01	**21400**
KUB-P.4D.0875.R.07.C1000-EF	U44 82220	0.875	1.000	1.180	7.659	3.622	4.409	1/8" NPT	SOGX 07T208	1,01	**22200**
KUB-P.4D.0906.R.07.C1000-E	U44 82300	0.906	1.000	1.180	7.659	3.622	4.409	1/8" NPT	SOGX 07T208	1,01	**23000**
KUB-P.4D.0937.R.08.C1250-EF	U44 82380	0.937	1.250	1.540	7.817	3.780	4.567	1/8" NPT	SOGX 080308	1,28	**23801**
KUB-P.4D.0985.R.08.C1250-E	U44 82500	0.985	1.250	1.540	8.014	3.937	4.764	1/8" NPT	SOGX 080308	1,28	**25001**
KUB-P.4D.1000.R.08.C1250-EF	U44 82540	1.000	1.250	1.540	8.171	4.094	4.921	1/8" NPT	SOGX 080308	1,28	**25401**
KUB-P.4D.1031.R.09.C1250-EF	U44 82620	1.031	1.250	1.540	8.368	4.252	5.118	1/4" NPT	SOGX 09T308	2,25	**26201**
KUB-P.4D.1062.R.09.C1250-E	U44 82700	1.062	1.250	1.540	8.368	4.252	5.118	1/4" NPT	SOGX 09T308	2,25	**27001**
KUB-P.4D.1109.R.09.C1250-EF	U44 82820	1.109	1.250	1.540	8.722	4.567	5.472	1/4" NPT	SOGX 09T308	2,25	**28201**
KUB-P.4D.1125.R.09.C1250-EF	U44 82860	1.125	1.250	1.540	8.722	4.567	5.472	1/4" NPT	SOGX 09T308	2,25	**28601**
KUB-P.4D.1156.R.09.C1250-EF	U44 82940	1.156	1.250	1.540	8.880	4.724	5.630	1/4" NPT	SOGX 09T308	2,25	**29401**
KUB-P.4D.1187.R.10.C1500-EF	U44 83020	1.187	1.500	1.970	9.577	4.882	5.827	1/4" NPT	SOGX 100408	2,8	**30102**
KUB-P.4D.1218.R.10.C1500-EF	U44 83090	1.218	1.500	1.970	9.577	4.882	5.827	1/4" NPT	SOGX 100408	2,8	**30902**
KUB-P.4D.1250.R.10.C1500-EF	U44 83180	1.250	1.500	1.970	9.734	5.039	5.984	1/4" NPT	SOGX 100408	2,8	**31802**
KUB-P.4D.1281.R.10.C1500-E	U44 83250	1.281	1.500	1.970	9.931	5.197	6.181	1/4" NPT	SOGX 100408	2,8	**32502**
KUB-P.4D.1312.R.11.C1500-EF	U44 83330	1.312	1.500	1.970	10.089	5.354	6.339	1/4" NPT	SOGX 110408	2,8	**33302**
KUB-P.4D.1328.R.11.C1500-EF	U44 83370	1.328	1.500	1.970	10.089	5.354	6.339	1/4" NPT	SOGX 110408	2,8	**33702**
KUB-P.4D.1375.R.11.C1500-EF	U44 83490	1.375	1.500	1.970	10.285	5.512	6.535	1/4" NPT	SOGX 110408	2,8	**34902**
KUB-P.4D.1437.R.11.C1500-E	U44 83650	1.437	1.500	1.970	10.640	5.827	6.890	1/4" NPT	SOGX 110408	2,8	**36502**
KUB-P.4D.1469.R.12.C1500-EF	U44 83730	1.469	1.500	1.970	10.797	5.984	7.047	1/4" NPT	SOGX 120408	6,25	**37302**
KUB-P.4D.1500.R.12.C1500-EF	U44 83810	1.500	1.500	1.970	10.994	6.142	7.244	1/4" NPT	SOGX 120408	6,25	**38102**
KUB-P.4D.1531.R.12.C1500-EF	U44 83890	1.531	1.500	1.970	10.994	6.142	7.244	1/4" NPT	SOGX 120408	6,25	**38902**
KUB-P.4D.1562.R.12.C1500-EF	U44 83970	1.562	1.500	1.970	11.152	6.299	7.402	1/4" NPT	SOGX 120408	6,25	**39702**
KUB-P.4D.1625.R.12.C1500-EF	U44 84130	1.625	1.500	1.970	11.506	6.614	7.756	1/4" NPT	SOGX 120408	6,25	**41302**
KUB-P.4D.1656.R.13.C1500-EF	U44 84210	1.656	1.500	1.970	11.703	6.772	7.953	1/4" NPT	SOGX 130508	6,25	**42102**
KUB-P.4D.1687.R.13.C1500-EF	U44 84290	1.687	1.500	1.970	11.703	6.772	7.953	1/4" NPT	SOGX 130508	6,25	**42802**
KUB-P.4D.1750.R.13.C1500-EF	U44 84450	1.750	1.500	1.970	12.057	7.087	8.307	1/4" NPT	SOGX 130508	6,25	**44502**

		 Key			 Screwdriver		 Clamping screw	
		80 950 ...			**80 950 ...**		**10 950 ...**	
Spare parts DC								
0.562 - 0.625	T05 - IP	**057**					M1,8x3,8 - 05IP	**10100**
0.656 - 0.703				T06 - IP	**123**		M2,0x4,3 - 06IP	**10000**
0.750 - 0.906				T06 - IP	**123**		M2,2x5,5 - 06IP	**10700**
0.937 - 1.000				T08 - IP	**125**		M2,5x6,3 - 08IP	**10800**
1.031 - 1.156				T08 - IP	**125**		M3,0x7,6 - 08IP	**10200**
1.187 - 1.437				T15 - IP	**128**		M3,5x7,5 - 15IP	**10300**
1.469 - 1.750				T20 - IP	**129**		M4,5x10 - 20IP	**10400**

Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

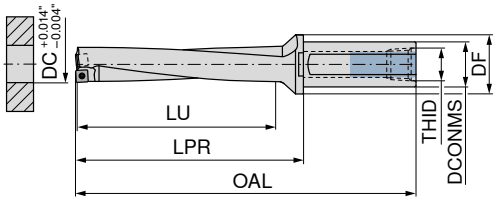
KUB Pentron – Indexable insert drill

Scope of supply:

Indexable Insert Drill incl. clamping screws

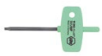
≤ 5xD

C



15 875 ...

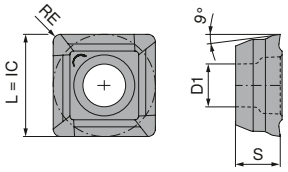
Designation	KOMET no.	DC inch	DCONMS inch	DF inch	OAL inch	LU inch	LPR inch	THID inch	Insert	torque moment Nm	
KUB-P.5D.0562.R.04.C0750-EF	U45 81430	0.562	0.750	1.180	5.754	2.953	3.504	1/8" NPT	SOGX 040204	0,38	14309
KUB-P.5D.0593.R.04.C0750-EF	U45 81510	0.593	0.750	1.180	6.030	3.150	3.780	1/8" NPT	SOGX 040204	0,38	15109
KUB-P.5D.0625.R.04.C0750-EF	U45 81590	0.625	0.750	1.180	6.030	3.150	3.780	1/8" NPT	SOGX 040204	0,38	15909
KUB-P.5D.0656.R.05.C0750-EF	U45 81670	0.656	0.750	1.180	6.266	3.346	4.016	1/8" NPT	SOGX 050204	0,62	16709
KUB-P.5D.0687.R.05.C1000-E	U45 81750	0.687	1.000	1.180	7.463	3.543	4.213	1/8" NPT	SOGX 050204	0,62	17500
KUB-P.5D.0703.R.05.C1000-EF	U45 81790	0.703	1.000	1.180	7.463	3.543	4.213	1/8" NPT	SOGX 050204	0,62	17900
KUB-P.5D.0750.R.06.C1000-EF	U45 81910	0.750	1.000	1.180	7.896	3.937	4.646	1/8" NPT	SOGX 060206	1,01	19100
KUB-P.5D.0765.R.06.C1000-EF	U45 81940	0.765	1.000	1.180	7.896	3.937	4.646	1/8" NPT	SOGX 060206	1,01	19400
KUB-P.5D.0781.R.06.C1000-EF	U45 81980	0.781	1.000	1.180	7.896	3.937	4.646	1/8" NPT	SOGX 060206	1,01	19800
KUB-P.5D.0812.R.07.C1000-EF	U45 82060	0.812	1.000	1.180	8.132	4.134	4.882	1/8" NPT	SOGX 07T208	1,01	20600
KUB-P.5D.0828.R.07.C1000-E	U45 82100	0.828	1.000	1.180	8.132	4.134	4.882	1/8" NPT	SOGX 07T208	1,01	21000
KUB-P.5D.0843.R.07.C1000-EF	U45 82140	0.843	1.000	1.180	8.329	4.331	5.079	1/8" NPT	SOGX 07T208	1,01	21400
KUB-P.5D.0875.R.07.C1000-EF	U45 82220	0.875	1.000	1.180	8.565	4.528	5.315	1/8" NPT	SOGX 07T208	1,01	22200
KUB-P.5D.0906.R.07.C1000-E	U45 82300	0.906	1.000	1.180	8.565	4.528	5.315	1/8" NPT	SOGX 07T208	1,01	23000
KUB-P.5D.0937.R.08.C1250-EF	U45 82380	0.937	1.250	1.540	8.762	4.724	5.512	1/8" NPT	SOGX 080308	1,28	23801
KUB-P.5D.0985.R.08.C1250-E	U45 82500	0.985	1.250	1.540	8.998	4.921	5.748	1/8" NPT	SOGX 080308	1,28	25001
KUB-P.5D.1000.R.08.C1250-EF	U45 82540	1.000	1.250	1.540	9.195	5.118	5.945	1/8" NPT	SOGX 080308	1,28	25401
KUB-P.5D.1031.R.09.C1250-EF	U45 82620	1.031	1.250	1.540	9.431	5.315	6.181	1/4" NPT	SOGX 09T308	2,25	26201
KUB-P.5D.1062.R.09.C1250-E	U45 82700	1.062	1.250	1.540	9.431	5.315	6.181	1/4" NPT	SOGX 09T308	2,25	27001
KUB-P.5D.1109.R.09.C1250-EF	U45 82820	1.109	1.250	1.540	9.864	5.709	6.614	1/4" NPT	SOGX 09T308	2,25	28201
KUB-P.5D.1125.R.09.C1250-EF	U45 82860	1.125	1.250	1.540	9.864	5.709	6.614	1/4" NPT	SOGX 09T308	2,25	28601
KUB-P.5D.1156.R.09.C1250-EF	U45 82940	1.156	1.250	1.540	10.061	5.906	6.811	1/4" NPT	SOGX 09T308	2,25	29401
KUB-P.5D.1187.R.10.C1500-EF	U45 83020	1.187	1.500	1.970	10.797	6.102	7.047	1/4" NPT	SOGX 100408	2,8	30102
KUB-P.5D.1218.R.10.C1500-EF	U45 83090	1.218	1.500	1.970	10.797	6.102	7.047	1/4" NPT	SOGX 100408	2,8	30902
KUB-P.5D.1250.R.10.C1500-EF	U45 83180	1.250	1.500	1.970	10.994	6.299	7.244	1/4" NPT	SOGX 100408	2,8	31802
KUB-P.5D.1281.R.10.C1500-E	U45 83250	1.281	1.500	1.970	11.230	6.496	7.480	1/4" NPT	SOGX 100408	2,8	32502
KUB-P.5D.1312.R.11.C1500-EF	U45 83330	1.312	1.500	1.970	11.427	6.693	7.677	1/4" NPT	SOGX 110408	2,8	33302
KUB-P.5D.1328.R.11.C1500-EF	U45 83370	1.328	1.500	1.970	11.427	6.693	7.677	1/4" NPT	SOGX 110408	2,8	33702
KUB-P.5D.1375.R.11.C1500-EF	U45 83490	1.375	1.500	1.970	11.663	6.890	7.913	1/4" NPT	SOGX 110408	2,8	34902
KUB-P.5D.1437.R.11.C1500-E	U45 83650	1.437	1.500	1.970	12.096	7.283	8.346	1/4" NPT	SOGX 110408	6,25	36502
KUB-P.5D.1469.R.12.C1500-EF	U45 83730	1.469	1.500	1.970	12.293	7.480	8.543	1/4" NPT	SOGX 120408	6,25	37302
KUB-P.5D.1500.R.12.C1500-EF	U45 83810	1.500	1.500	1.970	12.530	7.677	8.780	1/4" NPT	SOGX 120408	6,25	38102
KUB-P.5D.1531.R.12.C1500-EF	U45 83890	1.531	1.500	1.970	12.530	7.677	8.780	1/4" NPT	SOGX 120408	6,25	38902
KUB-P.5D.1562.R.12.C1500-EF	U45 83970	1.562	1.500	1.970	12.726	7.874	8.976	1/4" NPT	SOGX 120408	6,25	39702
KUB-P.5D.1625.R.12.C1500-EF	U45 84130	1.625	1.500	1.970	13.159	8.268	9.409	1/4" NPT	SOGX 120408	6,25	41302
KUB-P.5D.1656.R.13.C1500-EF	U45 84210	1.656	1.500	1.970	13.396	8.465	9.646	1/4" NPT	SOGX 130508	6,25	42102
KUB-P.5D.1687.R.13.C1500-EF	U45 84290	1.687	1.500	1.970	13.396	8.465	9.646	1/4" NPT	SOGX 130508	6,25	42802
KUB-P.5D.1750.R.13.C1500-EF	U45 84450	1.750	1.500	1.970	13.829	8.858	10.079	1/4" NPT	SOGX 130508	6,25	44502

		 Key			 Screwdriver		 Clamping screw	
		80 950 ...			**80 950 ...**		**10 950 ...**	
Spare parts DC								
0.562 - 0.625	T05 - IP	**057**					M1,8x3,8 - 05IP	**10100**
0.656 - 0.703				T06 - IP	**123**		M2,0x4,3 - 06IP	**10000**
0.750 - 0.906				T06 - IP	**123**		M2,2x5,5 - 06IP	**10700**
0.937 - 1.000				T08 - IP	**125**		M2,5x6,3 - 08IP	**10800**
1.031 - 1.156				T08 - IP	**125**		M3,0x7,6 - 08IP	**10200**
1.187 - 1.437				T15 - IP	**128**		M3,5x7,5 - 15IP	**10300**
1.469 - 1.750				T20 - IP	**129**		M4,5x10 - 20IP	**10400**

Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

SOGX

Designation	L inch	IC inch	D1 inch	S inch
SOGX 0402..	0.188	0.188	0.080	0.086
SOGX 0502..	0.216	0.216	0.090	0.094
SOGX 0602..	0.244	0.244	0.102	0.108
SOGX 07T2..	0.279	0.279	0.102	0.116
SOGX 0803..	0.314	0.314	0.112	0.133
SOGX 09T3..	0.350	0.350	0.133	0.153
SOGX 1004..	0.385	0.385	0.161	0.165
SOGX 1104..	0.429	0.429	0.161	0.177
SOGX 1204..	0.472	0.472	0.204	0.188
SOGX 1305..	0.519	0.519	0.204	0.204



SOGX

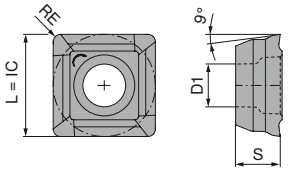
	-01 BK8425	-03 BK8430	NEW -13 BK8425	NEW -32 BK8425	NEW -34 BK8425
					
	SOGX	SOGX	SOGX	SOGX	SOGX
	10 820 ...	10 820 ...	10 820 ...	10 820 ...	10 820 ...

ISO	KOMET no.	RE inch									
040204	W80 10010.048425	0.016	30401								
040204	W80 10030.048430	0.016		00403							
040204	W80 10130.048425	0.016			30413						
040204	W80 10320.048425	0.016					30432				
040204	W80 10340.048425	0.016									30434
050204	W80 12010.048425	0.016	30501								
050204	W80 12030.048430	0.016		00503							
050204	W80 12130.048425	0.016			30513						
050204	W80 12320.048425	0.016					30532				
050204	W80 12340.048425	0.016									30534
060206	W80 18010.068425	0.024	30601								
060206	W80 18030.068430	0.024		00603							
060206	W80 18130.068425	0.024			30613						
060206	W80 18320.068425	0.024					30632				
060206	W80 18340.068425	0.024									30634
07T208	W80 20010.088425	0.031	30701								
07T208	W80 20030.088430	0.031		00703							
07T208	W80 20130.088425	0.031			30713						
07T208	W80 20320.088425	0.031					30732				
07T208	W80 20340.088425	0.031									30734
080308	W80 24010.088425	0.031	30801								
080308	W80 24030.088430	0.031		00803							
080308	W80 24130.088425	0.031			30813						
080308	W80 24320.088425	0.031					30832				
080308	W80 24340.088425	0.031									30834
09T308	W80 28010.088425	0.031	30901								
09T308	W80 28030.088430	0.031		00903							
09T308	W80 28130.088425	0.031			30913						
09T308	W80 28320.088425	0.031					30932				
09T308	W80 28340.088425	0.031									30934
100408	W80 32010.088425	0.031	31001								
100408	W80 32030.088430	0.031		01003							
100408	W80 32130.088425	0.031			31013						
100408	W80 32320.088425	0.031					31032				
100408	W80 32340.088425	0.031									31034
110408	W80 38010.088425	0.031	31101								
110408	W80 38030.088430	0.031		01103							
110408	W80 38130.088425	0.031			31113						
110408	W80 38320.088425	0.031					31132				
110408	W80 38340.088425	0.031									31134
120408	W80 42010.088425	0.031	31201								
120408	W80 42030.088430	0.031		01203							
120408	W80 42130.088425	0.031			31213						
120408	W80 42320.088425	0.031					31232				
120408	W80 42340.088425	0.031									31234
130508	W80 46010.088425	0.031	31301								
130508	W80 46030.088430	0.031		01303							
130508	W80 46130.088425	0.031			31313						
130508	W80 46320.088425	0.031					31332				
130508	W80 46340.088425	0.031									31334
P			●	●	●	●	○				
M			●	●	●	●					
K			●	●	●	●	●				
N			○	○	○	○					
S			●	●	●	●					
H			○	○	○	○					
O											

→ v_c Page 43–45

SOGX

Designation	L inch	IC inch	D1 inch	S inch
SOGX 0402..	0.188	0.188	0.080	0.086
SOGX 0502..	0.216	0.216	0.090	0.094
SOGX 0602..	0.244	0.244	0.102	0.108
SOGX 07T2..	0.279	0.279	0.102	0.116
SOGX 0803..	0.314	0.314	0.112	0.133
SOGX 09T3..	0.350	0.350	0.133	0.153
SOGX 1004..	0.385	0.385	0.161	0.165
SOGX 1104..	0.429	0.429	0.161	0.177
SOGX 1204..	0.472	0.472	0.204	0.188
SOGX 1305..	0.519	0.519	0.204	0.204



SOGX

ISO	KOMET no.	RE inch	-01 BK7935	-01 BK6115	-01 BK6425	-01 BK7710
			SOGX	SOGX	SOGX	SOGX
			10 820 ...	10 820 ...	10 820 ...	10 820 ...
040204	W80 10010.046115	0.016		40401		
040204	W80 10010.046425	0.016			60401	
040204	W80 10010.047710	0.016				90401
040204	W80 10010.047935	0.016	50401			
050204	W80 12010.046115	0.016		40501		
050204	W80 12010.046425	0.016			60501	
050204	W80 12010.047710	0.016				90501
050204	W80 12010.047935	0.016	50501			
060206	W80 18010.066115	0.024		40601		
060206	W80 18010.066425	0.024			60601	
060206	W80 18010.067710	0.024				90601
060206	W80 18010.067935	0.024	50601			
07T208	W80 20010.086115	0.031		40701		
07T208	W80 20010.086425	0.031			60701	
07T208	W80 20010.087710	0.031				90701
07T208	W80 20010.087935	0.031	50701			
080308	W80 24010.086115	0.031		40801		
080308	W80 24010.086425	0.031			60801	
080308	W80 24010.087710	0.031				90801
080308	W80 24010.087935	0.031	50801			
09T308	W80 28010.086115	0.031		40901		
09T308	W80 28010.086425	0.031			60901	
09T308	W80 28010.087710	0.031				90901
09T308	W80 28010.087935	0.031	50901			
100408	W80 32010.086115	0.031		41001		
100408	W80 32010.086425	0.031			61001	
100408	W80 32010.087710	0.031				91001
100408	W80 32010.087935	0.031	51001			
110408	W80 38010.086115	0.031		41101		
110408	W80 38010.086425	0.031			61101	
110408	W80 38010.087710	0.031				91101
110408	W80 38010.087935	0.031	51101			
120408	W80 42010.086115	0.031		41201		
120408	W80 42010.086425	0.031			61201	
120408	W80 42010.087710	0.031				91201
120408	W80 42010.087935	0.031	51201			
130508	W80 46010.086115	0.031		41301		
130508	W80 46010.086425	0.031			61301	
130508	W80 46010.087710	0.031				91301
130508	W80 46010.087935	0.031	51301			
P			●	●	●	
M			●	●	●	
K			●	●	●	
N			○			●
S			●			○
H				○		
O			○			○

→ v_c Page 43–45

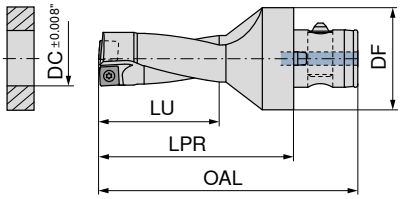
BK6115 -01 is exclusively recommended for use on the peripheral cutting edge!

KUB Quatron – Indexable insert drill

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 2xD

ABS



Designation	KOMET no.	DC inch	DF inch	OAL inch	LU inch	LPR inch	Insert	torque moment Nm	10 879 ...	15 879 ...
KUB-Q.2D.0562.R.05.ABS50-F	U10 71432	0.562	1.969	3.779	1.181	2.559	SOEX 050204	0,62		14395
KUB-Q.2D.0593.R.05.ABS50-F	U10 71510	0.593	1.969	3.858	1.260	2.638	SOEX 050204	0,62		15195
KUB-Q.2D.0625.R.05.ABS50-F	U10 71590	0.625	1.969	3.858	1.260	2.638	SOEX 050204	0,62		15995
KUB-Q.2D.0656.R.05.ABS50-F	U10 71670	0.656	1.969	3.937	1.339	2.717	SOEX 050204	0,62		16795
KUB-Q.2D.0687.R.05.ABS50	U10 71750	0.689	1.969	4.016	1.417	2.795	SOEX 050204	0,62	17595	
KUB-Q.2D.0703.R.06.ABS50-F	U10 71790	0.703	1.969	4.015	1.417	2.795	SOEX 060306	1,01		17995
KUB-Q.2D.0718.R.06.ABS50-F	U10 71820	0.718	1.969	4.094	1.496	2.874	SOEX 060306	1,01		18295
KUB-Q.2D.0750.R.06.ABS50-F	U10 71910	0.750	1.969	4.173	1.575	2.953	SOEX 060306	1,01		19195
KUB-Q.2D.0765.R.06.ABS50-F	U10 71940	0.765	1.969	4.173	1.575	2.953	SOEX 060306	1,01		19495
KUB-Q.2D.0781.R.06.ABS50-F	U10 71980	0.781	1.969	4.173	1.575	2.953	SOEX 060306	1,01		19895
KUB-Q.2D.0812.R.06.ABS50-F	U10 72060	0.812	1.969	4.251	1.654	3.031	SOEX 060306	1,01		20695
KUB-Q.2D.0828.R.06.ABS50	U10 72100	0.827	1.969	4.252	1.654	3.032	SOEX 060306	1,01	21095	
KUB-Q.2D.0843.R.06.ABS50-F	U10 72140	0.843	1.969	4.330	1.732	3.110	SOEX 060306	1,01		21495
KUB-Q.2D.0875.R.07.ABS50-F	U10 72220	0.875	1.969	4.409	1.811	3.189	SOEX 07T308	1,01		22295
KUB-Q.2D.0906.R.07.ABS50	U10 72300	0.906	1.969	4.409	1.811	3.189	SOEX 07T308	1,01	23095	
KUB-Q.2D.0937.R.07.ABS50-F	U10 72380	0.937	1.969	4.488	1.890	3.268	SOEX 07T308	1,01		23895
KUB-Q.2D.0968.R.07.ABS50-F	U10 72460	0.968	1.969	4.566	1.969	3.346	SOEX 07T308	1,01		24695
KUB-Q.2D.0985.R.07.ABS50	U10 72500	0.984	1.969	4.567	1.969	3.346	SOEX 07T308	1,01	25095	
KUB-Q.2D.1000.R.07.ABS50-F	U10 72540	1.000	1.969	4.645	2.047	3.425	SOEX 07T308	1,01		25495
KUB-Q.2D.1031.R.07.ABS50-F	U10 72620	1.031	1.969	4.724	2.126	3.504	SOEX 07T308	1,01		26295
KUB-Q.2D.1062.R.07.ABS50	U10 72700	1.063	1.969	4.724	2.126	3.504	SOEX 07T308	1,01	27095	
KUB-Q.2D.1109.R.09.ABS50-F	U10 72820	1.109	1.969	4.881	2.283	3.661	SOEX 090408	2,25		28295
KUB-Q.2D.1125.R.09.ABS50-F	U10 72860	1.125	1.969	4.881	2.283	3.661	SOEX 090408	2,25		28695
KUB-Q.2D.1156.R.09.ABS50-F	U10 72940	1.156	1.969	4.960	2.323	3.740	SOEX 090408	2,25		29495
KUB-Q.2D.1187.R.09.ABS50-F	U10 73020	1.187	1.969	5.235	2.441	4.015	SOEX 090408	2,25		30195
KUB-Q.2D.1218.R.09.ABS50-F	U10 73090	1.218	1.969	5.236	2.441	4.016	SOEX 090408	2,25		30995
KUB-Q.2D.1250.R.09.ABS50-F	U10 73180	1.250	1.969	4.314	2.520	3.094	SOEX 090408	2,25		31895
KUB-Q.2D.1281.R.09.ABS50-F	U10 73250	1.281	1.969	5.393	2.598	4.173	SOEX 090408	2,25		32595
KUB-Q.2D.1312.R.12.ABS50-F	U10 73330	1.312	1.969	5.471	2.677	4.251	SOEX 120508	6,25		33395
KUB-Q.2D.1328.R.12.ABS50-F	U10 73370	1.328	1.969	5.471	2.677	4.251	SOEX 120508	6,25		33795
KUB-Q.2D.1375.R.12.ABS50-F	U10 73490	1.375	1.969	5.550	2.756	4.330	SOEX 120508	6,25		34995
KUB-Q.2D.1406.R.12.ABS50-F	U10 73570	1.406	1.969	5.629	2.835	4.409	SOEX 120508	6,25		35795
KUB-Q.2D.1437.R.12.ABS50-F	U10 73650	1.437	1.969	6.101	2.913	4.881	SOEX 120508	6,25		36595
KUB-Q.2D.1469.R.12.ABS50-F	U10 73730	1.469	1.969	6.180	2.992	4.960	SOEX 120508	6,25		37395
KUB-Q.2D.1500.R.12.ABS50-F	U10 73810	1.500	1.969	6.259	3.071	5.039	SOEX 120508	6,25		38195
KUB-Q.2D.1531.R.12.ABS50-F	U10 73890	1.531	1.969	6.259	3.071	5.039	SOEX 120508	6,25		38995
KUB-Q.2D.1562.R.12.ABS50-F	U10 73970	1.562	1.969	6.338	3.150	5.118	SOEX 120508	6,25		39795
KUB-Q.2D.1625.R.12.ABS50-F	U10 74130	1.625	1.969	6.495	3.307	5.275	SOEX 120508	6,25		41395
KUB-Q.2D.1656.R.12.ABS50-F	U10 74210	1.656	1.969	6.574	3.386	5.354	SOEX 120508	6,25		42195
KUB-Q.2D.1687.R.12.ABS50-F	U10 74290	1.687	1.969	6.574	3.386	5.354	SOEX 120508	6,25		42895
KUB-Q.2D.1750.R.12.ABS50-F	U10 74450	1.750	1.969	6.653	3.465	5.433	SOEX 120508	6,25		44595

Screwdriver

Clamping screw

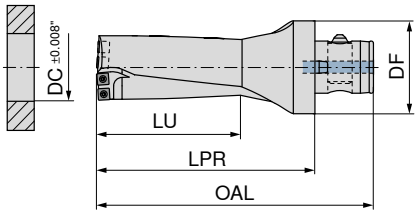
Spare parts DC	80 950 ...	10 950 ...
0.562 - 0.689	123	10000
0.703 - 0.843	123	10700
0.875 - 1.063	125	10800
1.109 - 1.281	128	10300
1.312 - 1.750	129	10400

KUB Quatron – Indexable insert drill

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 2xD

ABS



Designation	KOMET no.	DC inch	DF inch	OAL inch	LU inch	LPR inch	Insert	torque moment Nm	10 879 ...	15 879 ...
KUB-Q.2D.1781.R.07.ABS63-F	U10 84520	1.781	2.480	7.283	3.622	5.787	SOEX 07T308	1,01		**45296**
KUB-Q.2D.1812.R.07.ABS63	U10 84600	1.811	2.480	7.283	3.622	5.787	SOEX 07T308	1,01	**46096**	
KUB-Q.2D.1875.R.07.ABS63-F	U10 84760	1.875	2.480	7.441	3.780	5.945	SOEX 07T308	1,01		**47696**
KUB-Q.2D.1937.R.07.ABS63-F	U10 84920	1.937	2.480	7.598	3.937	6.102	SOEX 07T308	1,01		**49296**
KUB-Q.2D.1975.R.07.ABS63-F	U10 85020	1.975	2.480	7.677	4.016	6.181	SOEX 07T308	1,01		**50296**
KUB-Q.2D.2000.R.07.ABS63-F	U10 85080	2.000	2.480	7.677	4.016	6.181	SOEX 07T308	1,01		**50896**
KUB-Q.2D.2062.R.09.ABS63-F	U10 85240	2.062	2.480	7.835	4.173	6.339	SOEX 090408	2,25		**52496**
KUB-Q.2D.2125.R.09.ABS63	U10 85400	2.126	2.480	7.913	4.252	6.417	SOEX 090408	2,25	**54096**	
KUB-Q.2D.2165.R.09.ABS80	U10 95500	2.165	3.150	8.189	4.331	6.496	SOEX 090408	2,25	**55098**	
KUB-Q.2D.2203.R.09.ABS80	U10 95600	2.205	3.150	8.268	4.409	6.575	SOEX 090408	2,25	**56098**	
KUB-Q.2D.2250.R.09.ABS80-F	U10 95720	2.250	3.150	8.425	4.567	6.732	SOEX 090408	2,25		**57298**
KUB-Q.2D.2281.R.09.ABS80-F	U10 95790	2.281	3.150	8.425	4.567	6.732	SOEX 090408	2,25		**57998**
KUB-Q.2D.2375.R.09.ABS80-F	U10 96030	2.375	3.150	8.662	4.803	6.969	SOEX 090408	2,25		**60398**
KUB-Q.2D.2437.R.09.ABS80-F	U10 96190	2.437	3.150	8.740	4.882	7.047	SOEX 090408	2,25		**61998**
KUB-Q.2D.2500.R.09.ABS80-F	U10 96350	2.500	3.150	8.898	5.039	7.205	SOEX 090408	2,25		**63598**

Screwdriver

Clamping screw

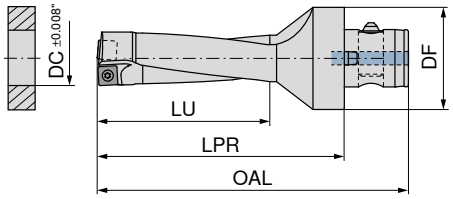
Spare parts DC	80 950 ...	10 950 ...
1.781 - 2.000	**125**	**10800**
2.062 - 2.500	**128**	**10300**

KUB Quatron – Indexable insert drill

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 3xD

ABS



Designation	KOMET no.	DC inch	DF inch	OAL inch	LU inch	LPR inch	Insert	torque moment Nm	10 880 ...	15 880 ...
KUB-Q.3D.0562.R.05.ABS50-F	U11 51432	0.562	1.969	4.370	1.772	3.150	SOEX 050204	0,62		14395
KUB-Q.3D.0593.R.05.ABS50-F	U11 51510	0.593	1.969	4.488	1.890	3.268	SOEX 050204	0,62		15195
KUB-Q.3D.0625.R.05.ABS50-F	U11 51590	0.625	1.969	4.488	1.890	3.268	SOEX 050204	0,62		15995
KUB-Q.3D.0656.R.05.ABS50-F	U11 51670	0.656	1.969	4.606	2.008	3.386	SOEX 050204	0,62		16795
KUB-Q.3D.0687.R.05.ABS50	U11 51750	0.689	1.969	4.724	2.126	3.504	SOEX 050204	0,62	17595	
KUB-Q.3D.0703.R.06.ABS50-F	U11 51790	0.703	1.969	4.724	2.126	3.504	SOEX 060306	1,01		17995
KUB-Q.3D.0718.R.06.ABS50-F	U11 51820	0.718	1.969	4.842	2.244	3.622	SOEX 060306	1,01		18295
KUB-Q.3D.0750.R.06.ABS50-F	U11 51910	0.750	1.969	4.960	2.362	3.740	SOEX 060306	1,01		19195
KUB-Q.3D.0765.R.06.ABS50-F	U11 51940	0.765	1.969	4.960	2.362	3.740	SOEX 060306	1,01		19495
KUB-Q.3D.0781.R.06.ABS50-F	U11 51980	0.781	1.969	4.960	2.362	3.740	SOEX 060306	1,01		19895
KUB-Q.3D.0812.R.06.ABS50-F	U11 52060	0.812	1.969	5.078	2.480	3.858	SOEX 060306	1,01		20695
KUB-Q.3D.0828.R.06.ABS50	U11 52100	0.827	1.969	5.079	2.480	3.858	SOEX 060306	1,01	21095	
KUB-Q.3D.0843.R.06.ABS50-F	U11 52140	0.843	1.969	5.196	2.598	3.976	SOEX 060306	1,01		21495
KUB-Q.3D.0875.R.07.ABS50-F	U11 52220	0.875	1.969	5.314	2.717	4.094	SOEX 07T308	1,01		22295
KUB-Q.3D.0906.R.07.ABS50	U11 52300	0.906	1.969	5.315	2.717	4.094	SOEX 07T308	1,01	23095	
KUB-Q.3D.0937.R.07.ABS50-F	U11 52380	0.937	1.969	5.433	2.835	4.213	SOEX 07T308	1,01		23895
KUB-Q.3D.0968.R.07.ABS50-F	U11 52460	0.968	1.969	5.551	2.953	4.331	SOEX 07T308	1,01		24695
KUB-Q.3D.0985.R.07.ABS50	U11 52500	0.984	1.969	5.551	2.953	4.331	SOEX 07T308	1,01	25095	
KUB-Q.3D.1000.R.07.ABS50-F	U11 52540	1.000	1.969	5.669	3.071	4.449	SOEX 07T308	1,01		25495
KUB-Q.3D.1031.R.07.ABS50-F	U11 52620	1.031	1.969	5.787	3.189	4.567	SOEX 07T308	1,01		26295
KUB-Q.3D.1062.R.07.ABS50	U11 52700	1.063	1.969	5.787	3.189	4.567	SOEX 07T308	1,01	27095	
KUB-Q.3D.1109.R.09.ABS50-F	U11 52820	1.109	1.969	6.023	3.425	4.803	SOEX 090408	2,25		28295
KUB-Q.3D.1125.R.09.ABS50-F	U11 52860	1.125	1.969	6.023	3.425	4.803	SOEX 090408	2,25		28695
KUB-Q.3D.1156.R.09.ABS50-F	U11 52940	1.156	1.969	6.141	3.543	4.921	SOEX 090408	2,25		29495
KUB-Q.3D.1187.R.09.ABS50-F	U11 53020	1.187	1.969	6.456	3.661	5.236	SOEX 090408	2,25		30195
KUB-Q.3D.1218.R.09.ABS50-F	U11 53090	1.218	1.969	6.456	3.661	5.236	SOEX 090408	2,25		30995
KUB-Q.3D.1250.R.09.ABS50-F	U11 53180	1.250	1.969	6.574	3.780	5.354	SOEX 090408	2,25		31895
KUB-Q.3D.1281.R.09.ABS50-F	U11 53250	1.281	1.969	6.692	3.898	5.472	SOEX 090408	2,25		32595
KUB-Q.3D.1312.R.12.ABS50-F	U11 53330	1.312	1.969	6.811	4.016	5.591	SOEX 120508	6,25		33395
KUB-Q.3D.1328.R.12.ABS50-F	U11 53370	1.328	1.969	6.811	4.016	5.591	SOEX 120508	6,25		33795
KUB-Q.3D.1375.R.12.ABS50-F	U11 53490	1.375	1.969	6.929	4.134	5.709	SOEX 120508	6,25		34995
KUB-Q.3D.1406.R.12.ABS50-F	U11 53570	1.406	1.969	7.047	4.252	5.827	SOEX 120508	6,25		35795
KUB-Q.3D.1437.R.12.ABS50-F	U11 53650	1.437	1.969	7.559	4.370	6.339	SOEX 120508	6,25		36595
KUB-Q.3D.1469.R.12.ABS50-F	U11 53730	1.469	1.969	7.677	4.488	6.457	SOEX 120508	6,25		37395
KUB-Q.3D.1500.R.12.ABS50-F	U11 53810	1.500	1.969	7.795	4.606	6.575	SOEX 120508	6,25		38195
KUB-Q.3D.1531.R.12.ABS50-F	U11 53890	1.531	1.969	7.795	4.606	6.575	SOEX 120508	6,25		38995
KUB-Q.3D.1562.R.12.ABS50-F	U11 53970	1.562	1.969	7.913	4.724	6.693	SOEX 120508	6,25		39795
KUB-Q.3D.1625.R.12.ABS50-F	U11 54130	1.625	1.969	8.149	4.961	6.929	SOEX 120508	6,25		41395
KUB-Q.3D.1656.R.12.ABS50-F	U11 54210	1.656	1.969	8.267	5.079	7.047	SOEX 120508	6,25		42195
KUB-Q.3D.1687.R.12.ABS50-F	U11 54290	1.687	1.969	8.267	5.079	7.047	SOEX 120508	6,25		42895
KUB-Q.3D.1750.R.12.ABS50-F	U11 54450	1.750	1.969	8.385	5.197	7.165	SOEX 120508	6,25		44595

Screwdriver

Clamping screw

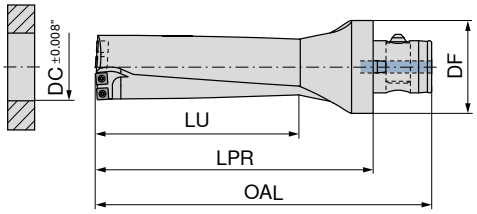
Spare parts DC	80 950 ...	10 950 ...
0.562 - 0.689	123	10000
0.703 - 0.843	123	10700
0.875 - 1.063	125	10800
1.109 - 1.281	128	10300
1.312 - 1.750	129	10400

KUB Quatron – Indexable insert drill

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 3xD

ABS



Designation	KOMET no.	DC inch	DF inch	OAL inch	LU inch	LPR inch	Insert	torque moment Nm	10 880 ...	15 880 ...
KUB-Q.3D.1781.R.07.ABS63-F	U12 34520	1.781	2.480	9.094	5.433	7.598	SOEX 07T308	1,01		45296
KUB-Q.3D.1812.R.07.ABS63	U12 34600	1.811	2.480	9.094	5.433	7.598	SOEX 07T308	1,01	46096	
KUB-Q.3D.1875.R.07.ABS63-F	U12 34760	1.875	2.480	9.331	5.669	7.835	SOEX 07T308	1,01		47696
KUB-Q.3D.1937.R.07.ABS63-F	U12 34920	1.937	2.480	9.567	5.906	8.071	SOEX 07T308	1,01		49296
KUB-Q.3D.1975.R.07.ABS63-F	U12 35020	1.975	2.480	9.685	6.024	8.189	SOEX 07T308	1,01		50296
KUB-Q.3D.2000.R.07.ABS63-F	U12 35080	2.000	2.480	9.685	6.024	8.189	SOEX 07T308	1,01		50896
KUB-Q.3D.2062.R.09.ABS63-F	U12 35240	2.062	2.480	9.921	6.260	8.425	SOEX 090408	2,25		52496
KUB-Q.3D.2125.R.09.ABS63	U12 35400	2.126	2.480	10.039	6.378	8.543	SOEX 090408	2,25	54096	
KUB-Q.3D.2165.R.09.ABS80	U12 45500	2.165	3.150	10.354	6.496	8.661	SOEX 090408	2,25	55098	
KUB-Q.3D.2203.R.09.ABS80	U12 45600	2.205	3.150	10.472	6.614	8.780	SOEX 090408	2,25	56098	
KUB-Q.3D.2250.R.09.ABS80-F	U12 45720	2.250	3.150	10.709	6.850	9.016	SOEX 090408	2,25		57298
KUB-Q.3D.2281.R.09.ABS80-F	U12 45790	2.281	3.150	10.709	6.850	9.016	SOEX 090408	2,25		57998
KUB-Q.3D.2375.R.09.ABS80-F	U12 46030	2.375	3.150	11.063	7.205	9.370	SOEX 090408	2,25		60398
KUB-Q.3D.2437.R.09.ABS80-F	U12 46190	2.437	3.150	11.181	7.323	9.488	SOEX 090408	2,25		61998
KUB-Q.3D.2500.R.09.ABS80-F	U12 46350	2.500	3.150	11.417	7.559	9.724	SOEX 090408	2,25		63598

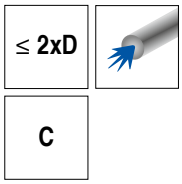
Screwdriver

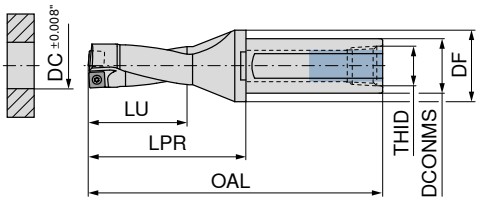
Clamping screw

Spare parts DC	80 950 ...	10 950 ...
1.781 - 2.000	125	10800
2.062 - 2.500	128	10300

KUB Quatron – Indexable insert drill

Scope of supply:
Indexable Insert Drill incl. clamping screws





15 879 ...

Designation	KOMET no.	DC inch	DCONMS inch	DF inch	OAL inch	LU inch	LPR inch	THID inch	Insert	torque moment Nm	
KUB-Q.2D.0562.R.05.C0750-EF	U11 21435	0.562	0.750	1.180	4.376	1.181	2.126	1/8" NPT	SOEX 050204	0,62	14309
KUB-Q.2D.0593.R.05.C0750-EF	U11 21513	0.593	0.750	1.180	4.455	1.260	2.205	1/8" NPT	SOEX 050204	0,62	15109
KUB-Q.2D.0625.R.05.C0750-EF	U11 21593	0.625	0.750	1.180	4.455	1.260	2.205	1/8" NPT	SOEX 050204	0,62	15909
KUB-Q.2D.0656.R.05.C0750-EF	U11 21673	0.656	0.750	1.180	4.534	1.339	2.284	1/8" NPT	SOEX 050204	0,62	16709
KUB-Q.2D.0687.R.05.C0750-E	U11 21753	0.687	0.750	1.180	4.612	1.417	2.362	1/8" NPT	SOEX 050204	0,62	17509
KUB-Q.2D.0703.R.06.C1000-EF	U11 31793	0.703	1.000	1.180	5.612	1.417	2.362	1/8" NPT	SOEX 060306	1,01	17900
KUB-Q.2D.0718.R.06.C1000-EF	U11 31823	0.718	1.000	1.180	5.691	1.496	2.441	1/8" NPT	SOEX 060306	1,01	18200
KUB-Q.2D.0750.R.06.C1000-EF	U11 31913	0.750	1.000	1.180	5.770	1.575	2.520	1/8" NPT	SOEX 060306	1,01	19100
KUB-Q.2D.0765.R.06.C1000-EF	U11 31943	0.765	1.000	1.180	5.770	1.575	2.520	1/8" NPT	SOEX 060306	1,01	19400
KUB-Q.2D.0781.R.06.C1000-EF	U11 31983	0.781	1.000	1.180	5.770	1.575	2.520	1/8" NPT	SOEX 060306	1,01	19800
KUB-Q.2D.0812.R.06.C1000-EF	U11 32063	0.812	1.000	1.180	5.849	1.654	2.599	1/8" NPT	SOEX 060306	1,01	20600
KUB-Q.2D.0828.R.06.C1000-E	U11 32103	0.828	1.000	1.180	5.927	1.732	2.677	1/8" NPT	SOEX 060306	1,01	21000
KUB-Q.2D.0843.R.06.C1000-EF	U11 32143	0.843	1.000	1.180	5.927	1.732	2.677	1/8" NPT	SOEX 060306	1,01	21400
KUB-Q.2D.0875.R.07.C1000-EF	U11 32223	0.875	1.000	1.180	6.006	1.811	2.756	1/8" NPT	SOEX 07T308	1,01	22200
KUB-Q.2D.0906.R.07.C1000-E	U11 32303	0.906	1.000	1.180	6.085	1.890	2.835	1/8" NPT	SOEX 07T308	1,01	23000
KUB-Q.2D.0937.R.07.C1000-EF	U11 32382	0.937	1.000	1.180	6.085	1.890	2.835	1/8" NPT	SOEX 07T308	1,01	23800
KUB-Q.2D.0937.R.07.C1250-EF	U11 42383	0.937	1.250	1.540	6.085	1.890	2.835	1/4" NPT	SOEX 07T308	1,01	23801
KUB-Q.2D.0968.R.07.C1250-EF	U11 42463	0.968	1.250	1.540	6.164	1.969	2.914	1/4" NPT	SOEX 07T308	1,01	24601
KUB-Q.2D.0968.R.07.C1000-EF	U11 32462	0.968	1.000	1.180	6.164	1.969	2.914	1/8" NPT	SOEX 07T308	1,01	24600
KUB-Q.2D.0985.R.07.C1250-E	U11 42503	0.985	1.250	1.540	6.164	1.969	2.914	1/4" NPT	SOEX 07T308	1,01	25001
KUB-Q.2D.0985.R.07.C1000-E	U11 32502	0.985	1.000	1.180	6.164	1.969	2.914	1/8" NPT	SOEX 07T308	1,01	25000
KUB-Q.2D.1000.R.07.C1250-EF	U11 42543	1.000	1.250	1.540	6.242	2.047	2.992	1/4" NPT	SOEX 07T308	1,01	25401
KUB-Q.2D.1000.R.07.C1000-EF	U11 32542	1.000	1.000	1.180	6.242	2.047	2.992	1/8" NPT	SOEX 07T308	1,01	25400
KUB-Q.2D.1031.R.07.C1250-EF	U11 42622	1.031	1.250	1.540	6.321	2.126	3.071	1/4" NPT	SOEX 07T308	1,01	26201
KUB-Q.2D.1062.R.07.C1250-E	U11 42702	1.062	1.250	1.540	6.321	2.126	3.071	1/4" NPT	SOEX 07T308	1,01	27001
KUB-Q.2D.1109.R.09.C1250-EF	U11 42822	1.109	1.250	1.540	6.478	2.283	3.228	1/4" NPT	SOEX 090408	2,25	28201
KUB-Q.2D.1125.R.09.C1250-EF	U11 42862	1.125	1.250	1.540	6.478	2.283	3.228	1/4" NPT	SOEX 090408	2,25	28601
KUB-Q.2D.1156.R.09.C1250-EF	U11 42942	1.156	1.250	1.540	6.557	2.323	3.307	1/4" NPT	SOEX 090408	2,25	29401
KUB-Q.2D.1187.R.09.C1250-EF	U11 43022	1.187	1.250	1.540	6.832	2.441	3.582	1/4" NPT	SOEX 090408	2,25	30101
KUB-Q.2D.1218.R.09.C1250-EF	U11 43092	1.218	1.250	1.540	6.832	2.441	3.582	1/4" NPT	SOEX 090408	2,25	30901
KUB-Q.2D.1250.R.09.C1250-EF	U11 43182	1.250	1.250	1.540	6.911	2.520	3.661	1/4" NPT	SOEX 090408	2,25	31801
KUB-Q.2D.1281.R.09.C1250-E	U11 43252	1.281	1.250	1.540	6.990	2.598	3.740	1/4" NPT	SOEX 090408	2,25	32501
KUB-Q.2D.1312.R.12.C1250-EF	U11 43332	1.312	1.250	1.540	7.068	2.677	3.818	1/4" NPT	SOEX 120508	6,25	33301
KUB-Q.2D.1328.R.12.C1250-EF	U11 43372	1.328	1.250	1.540	7.068	2.677	3.818	1/4" NPT	SOEX 120508	6,25	33701
KUB-Q.2D.1375.R.12.C1250-EF	U11 43492	1.375	1.250	1.540	7.147	2.756	3.897	1/4" NPT	SOEX 120508	6,25	34901
KUB-Q.2D.1406.R.12.C1250-EF	U11 43572	1.406	1.250	1.540	7.226	2.835	3.976	1/4" NPT	SOEX 120508	6,25	35701
KUB-Q.2D.1437.R.12.C1250-E	U11 43652	1.437	1.250	1.540	7.698	2.913	4.448	1/4" NPT	SOEX 120508	6,25	36501
KUB-Q.2D.1469.R.12.C1250-EF	U11 43732	1.469	1.250	1.540	7.777	2.992	4.527	1/4" NPT	SOEX 120508	6,25	37301
KUB-Q.2D.1500.R.12.C1250-EF	U11 43812	1.500	1.250	1.540	7.856	3.071	4.606	1/4" NPT	SOEX 120508	6,25	38101
KUB-Q.2D.1531.R.12.C1250-EF	U11 43892	1.531	1.250	1.540	7.856	3.071	4.606	1/4" NPT	SOEX 120508	6,25	38901
KUB-Q.2D.1562.R.12.C1250-EF	U11 43972	1.562	1.250	1.540	7.935	3.150	4.685	1/4" NPT	SOEX 120508	6,25	39701
KUB-Q.2D.1625.R.12.C1250-EF	U11 44132	1.625	1.250	1.540	8.092	3.307	4.842	1/4" NPT	SOEX 120508	6,25	41301
KUB-Q.2D.1656.R.12.C1250-EF	U11 44212	1.656	1.250	1.540	8.171	3.386	4.921	1/4" NPT	SOEX 120508	6,25	42101
KUB-Q.2D.1687.R.12.C1250-EF	U11 44292	1.687	1.250	1.540	8.171	3.386	4.921	1/4" NPT	SOEX 120508	6,25	42801
KUB-Q.2D.1750.R.12.C1250-EF	U11 44452	1.750	1.250	1.540	8.250	3.465	5.000	1/4" NPT	SOEX 120508	6,25	44501

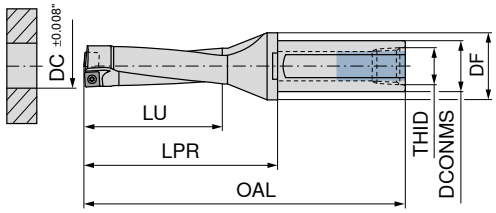
	 Screwdriver	 Clamping screw
	80 950 ...	**10 950 ...**
Spare parts DC		
0.562 - 0.687	**123**	**10000**
0.703	**129**	**10400**
0.718 - 0.843	**123**	**10700**
0.875 - 1.062	**125**	**10800**
1.109 - 1.281	**128**	**10300**
1.312 - 1.750	**129**	**10400**

KUB Quatron – Indexable insert drill

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 3xD

C



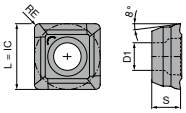
15 880 ...

Designation	KOMET no.	DC inch	DCONMS inch	DF inch	OAL inch	LU inch	LPR inch	THID inch	Insert	torque moment Nm	
KUB-Q.3D.0562.R.05.C0750-EF	U12 01434	0.562	0.750	1.180	4.967	1.772	2.717	1/8" NPT	SOEX 050204	0,62	14309
KUB-Q.3D.0593.R.05.C0750-EF	U12 01512	0.593	0.750	1.180	5.085	1.890	2.835	1/8" NPT	SOEX 050204	0,62	15109
KUB-Q.3D.0625.R.05.C0750-EF	U12 01592	0.625	0.750	1.180	5.085	1.890	2.835	1/8" NPT	SOEX 050204	0,62	15909
KUB-Q.3D.0656.R.05.C0750-EF	U12 01672	0.656	0.750	1.180	5.203	2.008	2.953	1/8" NPT	SOEX 050204	0,62	16709
KUB-Q.3D.0687.R.05.C0750-E	U12 01752	0.687	0.750	1.180	5.321	2.126	3.071	1/8" NPT	SOEX 050204	0,62	17509
KUB-Q.3D.0703.R.06.C1000-EF	U12 11792	0.703	1.000	1.180	6.321	2.126	3.071	1/8" NPT	SOEX 060306	1,01	17900
KUB-Q.3D.0718.R.06.C1000-EF	U12 11822	0.718	1.000	1.180	6.439	2.244	3.189	1/8" NPT	SOEX 060306	1,01	18200
KUB-Q.3D.0750.R.06.C1000-EF	U12 11912	0.750	1.000	1.180	6.557	2.362	3.307	1/8" NPT	SOEX 060306	1,01	19100
KUB-Q.3D.0765.R.06.C1000-EF	U12 11942	0.765	1.000	1.180	6.557	2.362	3.307	1/8" NPT	SOEX 060306	1,01	19400
KUB-Q.3D.0781.R.06.C1000-EF	U12 11982	0.781	1.000	1.180	6.557	2.362	3.307	1/8" NPT	SOEX 060306	1,01	19800
KUB-Q.3D.0812.R.06.C1000-EF	U12 12062	0.812	1.000	1.180	6.675	2.480	3.425	1/8" NPT	SOEX 060306	1,01	20600
KUB-Q.3D.0828.R.06.C1000-E	U12 12102	0.828	1.000	1.180	6.793	2.598	3.543	1/8" NPT	SOEX 060306	1,01	21000
KUB-Q.3D.0843.R.06.C1000-EF	U12 12142	0.843	1.000	1.180	6.793	2.598	3.543	1/8" NPT	SOEX 060306	1,01	21400
KUB-Q.3D.0875.R.07.C1000-EF	U12 12222	0.875	1.000	1.180	6.912	2.717	3.662	1/8" NPT	SOEX 07T308	1,01	22200
KUB-Q.3D.0906.R.07.C1000-E	U12 12302	0.906	1.000	1.180	7.030	2.835	3.780	1/8" NPT	SOEX 07T308	1,01	23000
KUB-Q.3D.0937.R.07.C1000-EF	U12 12382	0.937	1.000	1.180	7.030	2.835	3.780	1/8" NPT	SOEX 07T308	1,01	23800
KUB-Q.3D.0937.R.07.C1250-EF	U12 22382	0.937	1.250	1.540	7.030	2.835	3.780	1/4" NPT	SOEX 07T308	1,01	23801
KUB-Q.3D.0968.R.07.C1000-EF	U12 12462	0.968	1.000	1.180	7.148	2.953	3.898	1/8" NPT	SOEX 07T308	1,01	24600
KUB-Q.3D.0968.R.07.C1250-EF	U12 22462	0.968	1.250	1.540	7.148	2.953	3.898	1/4" NPT	SOEX 07T308	1,01	24601
KUB-Q.3D.0985.R.07.C1250-E	U12 22502	0.985	1.250	1.540	7.266	3.071	4.016	1/4" NPT	SOEX 07T308	1,01	25001
KUB-Q.3D.0985.R.07.C1000-E	U12 12502	0.985	1.000	1.180	7.148	2.953	3.898	1/8" NPT	SOEX 07T308	1,01	25000
KUB-Q.3D.1000.R.07.C1250-EF	U12 22542	1.000	1.250	1.540	7.266	3.071	4.016	1/4" NPT	SOEX 07T308	1,01	25401
KUB-Q.3D.1000.R.07.C1000-EF	U12 12542	1.000	1.000	1.180	7.266	3.071	4.016	1/8" NPT	SOEX 07T308	1,01	25400
KUB-Q.3D.1031.R.07.C1250-EF	U12 22622	1.031	1.250	1.540	7.384	3.189	4.134	1/4" NPT	SOEX 07T308	1,01	26201
KUB-Q.3D.1062.R.07.C1250-E	U12 22702	1.062	1.250	1.540	7.384	3.189	4.134	1/4" NPT	SOEX 07T308	1,01	27001
KUB-Q.3D.1109.R.09.C1250-EF	U12 22822	1.109	1.250	1.540	7.620	3.425	4.370	1/4" NPT	SOEX 090408	6,25	28201
KUB-Q.3D.1125.R.09.C1250-EF	U12 22862	1.125	1.250	1.540	7.620	3.425	4.370	1/4" NPT	SOEX 090408	6,25	28601
KUB-Q.3D.1156.R.09.C1250-EF	U12 22942	1.156	1.250	1.540	7.738	3.543	4.488	1/4" NPT	SOEX 090408	6,25	29401
KUB-Q.3D.1187.R.09.C1250-EF	U12 23022	1.187	1.250	1.540	8.053	3.661	4.803	1/4" NPT	SOEX 090408	6,25	30101
KUB-Q.3D.1218.R.09.C1250-EF	U12 23092	1.218	1.250	1.540	8.053	3.661	4.803	1/4" NPT	SOEX 090408	6,25	30901
KUB-Q.3D.1250.R.09.C1250-EF	U12 23182	1.250	1.250	1.540	8.171	3.780	4.921	1/4" NPT	SOEX 090408	6,25	31801
KUB-Q.3D.1281.R.09.C1250-E	U12 23252	1.281	1.250	1.540	8.289	3.898	5.039	1/4" NPT	SOEX 090408	6,25	32501
KUB-Q.3D.1312.R.12.C1250-EF	U12 23332	1.312	1.250	1.540	8.407	4.016	5.157	1/4" NPT	SOEX 120508	6,25	33301
KUB-Q.3D.1328.R.12.C1250-EF	U12 23372	1.328	1.250	1.540	8.407	4.016	5.157	1/4" NPT	SOEX 120508	6,25	33701
KUB-Q.3D.1375.R.12.C1250-EF	U12 23492	1.375	1.250	1.540	8.526	4.134	5.276	1/4" NPT	SOEX 120508	6,25	34901
KUB-Q.3D.1406.R.12.C1250-EF	U12 23572	1.406	1.250	1.540	8.644	4.252	5.394	1/4" NPT	SOEX 120508	6,25	35701
KUB-Q.3D.1437.R.12.C1250-E	U12 23652	1.437	1.250	1.540	9.156	4.370	5.906	1/4" NPT	SOEX 120508	6,25	36501
KUB-Q.3D.1469.R.12.C1250-EF	U12 23732	1.469	1.250	1.540	9.274	4.488	6.024	1/4" NPT	SOEX 120508	6,25	37301
KUB-Q.3D.1500.R.12.C1250-EF	U12 23812	1.500	1.250	1.540	9.392	4.606	6.142	1/4" NPT	SOEX 120508	6,25	38101
KUB-Q.3D.1531.R.12.C1250-EF	U12 23892	1.531	1.250	1.540	9.392	4.606	6.142	1/4" NPT	SOEX 120508	6,25	38901
KUB-Q.3D.1562.R.12.C1250-EF	U12 23972	1.562	1.250	1.540	9.510	4.724	6.260	1/4" NPT	SOEX 120508	6,25	39701
KUB-Q.3D.1625.R.12.C1250-EF	U12 24132	1.625	1.250	1.540	9.746	4.961	6.496	1/4" NPT	SOEX 120508	6,25	41301
KUB-Q.3D.1656.R.12.C1250-EF	U12 24212	1.656	1.250	1.540	9.864	5.079	6.614	1/4" NPT	SOEX 120508	6,25	42101
KUB-Q.3D.1687.R.12.C1250-EF	U12 24292	1.687	1.250	1.540	9.864	5.079	6.614	1/4" NPT	SOEX 120508	6,25	42801
KUB-Q.3D.1750.R.12.C1250-EF	U12 24452	1.750	1.250	1.540	9.982	5.197	6.732	1/4" NPT	SOEX 120508	6,25	44501

	 Screwdriver	 Clamping screw
	80 950 ...	**10 950 ...**
Spare parts DC		
0.562 - 0.687	**123**	**10000**
0.703 - 0.843	**123**	**10700**
0.875 - 1.062	**125**	**10800**
1.109 - 1.281	**128**	**10300**
1.312 - 1.750	**129**	**10400**

SOEX

Designation	L inch	IC inch	D1 inch	S inch
SOEX 0502..	0.218	0.218	0.090	0.093
SOEX 0603..	0.250	0.250	0.104	0.125
SOEX 07T3..	0.312	0.312	0.112	0.140
SOEX 0904..	0.374	0.374	0.161	0.172
SOEX 1205..	0.500	0.500	0.204	0.203



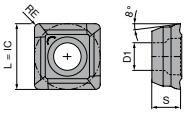
SOEX

			NEW	NEW	NEW	NEW	NEW
			-01 BK8425	-13 BK8425	-03 BK8430	-01 BK6115	-01 BK6420
							
			SOEX	SOEX	SOEX	SOEX	SOEX
			10 822 ...	10 822 ...	10 822 ...	10 822 ...	10 822 ...
ISO	KOMET no.	RE inch					
050204	W83 13000.016115	0.016				40501	
050204	W83 13010.046420	0.016					45501
050204	W83 13010.048425	0.016	30501				
050204	W83 13030.048430	0.016			00503		
050204	W83 13130.048425	0.016		30513			
060306	W83 18000.096115	0.024				40601	
060306	W83 18010.066420	0.024					45601
060306	W83 18010.068425	0.024	30601				
060306	W83 18030.068430	0.024			00603		
060306	W83 18130.068425	0.024		30613			
07T308	W83 23000.016115	0.031				40701	
07T308	W83 23010.086420	0.031					45701
07T308	W83 23010.088425	0.031	30701				
07T308	W83 23030.088430	0.031			00703		
07T308	W83 23130.088425	0.031		30713			
090408	W83 32000.156115	0.031				40901	
090408	W83 32010.086420	0.031					45901
090408	W83 32010.088425	0.031	30901				
090408	W83 32030.088430	0.031			00903		
090408	W83 32130.088425	0.031		30913			
120508	W83 44000.186115	0.031				41201	
120508	W83 44010.086420	0.031					46201
120508	W83 44010.088425	0.031	31201				
120508	W83 44030.088430	0.031			01203		
120508	W83 44130.088425	0.031		31213			
P			●	●	●	●	●
M			●	●	●	●	●
K			●	●	●	●	○
N			○	○	○		
S			●	●	●		
H			○	○	○	○	
O							

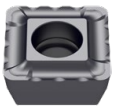
→ v_c Page 46–47

SOEX

Designation	L inch	IC inch	D1 inch	S inch
SOEX 0502..	0.218	0.218	0.090	0.093
SOEX 0603..	0.250	0.250	0.104	0.125
SOEX 07T3..	0.312	0.312	0.112	0.140
SOEX 0904..	0.374	0.374	0.161	0.172
SOEX 1205..	0.500	0.500	0.204	0.203



SOEX

	NEW	NEW	NEW	NEW	NEW
	-01 BK7615	-01 BK7935	-21 BK7935	-13 BK7935	-21 BK7710
					
	SOEX	SOEX	SOEX	SOEX	SOEX
	10 822 ...	10 822 ...	10 822 ...	10 822 ...	10 822 ...

ISO	KOMET no.	RE inch									
050204	W83 13010.047615	0.016	05501								
050204	W83 13010.047935	0.016		50501							
050204	W83 13130.047935	0.016							50513		
050204	W83 13210.047710	0.016									90521
050204	W83 13210.047935	0.016				50521					
060306	W83 18010.067615	0.024	05601								
060306	W83 18010.067935	0.024		50601							
060306	W83 18130.067935	0.024							50613		
060306	W83 18210.067710	0.024									90621
060306	W83 18210.067935	0.024				51621					
07T308	W83 23010.087615	0.031	05701								
07T308	W83 23010.087935	0.031		50701							
07T308	W83 23130.087935	0.031							50713		
07T308	W83 23210.087710	0.031									90721
07T308	W83 23210.087935	0.031				50721					
090408	W83 32010.087615	0.031	05901								
090408	W83 32010.087935	0.031		50901							
090408	W83 32130.087935	0.031							50913		
090408	W83 32210.087710	0.031									90921
090408	W83 32210.087935	0.031				50921					
120508	W83 44010.087615	0.031	06201								
120508	W83 44010.087935	0.031		51201							
120508	W83 44130.087935	0.031							51213		
120508	W83 44210.087710	0.031									91221
120508	W83 44210.087935	0.031				51221					
P				●		●			●		
M				●		●			●		
K			●	●		●			●		
N				○		○			○		●
S				●		●			●		○
H											
O				○		○			○		○

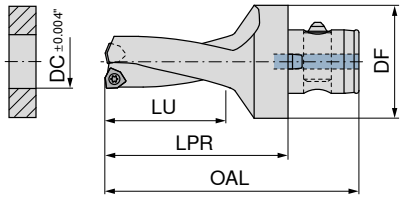
→ v_c Page 46–47

KUB Trigon – Indexable insert drill

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 2xD

ABS



NEW

15 892 ...

Designation	KOMET no.	DC inch	DF inch	OAL inch	LU inch	LPR inch	Insert	torque moment Nm	
KUB-T-U.2D.0562.R.03.ABS50-F	V40 11430	0.562	1.969	3.780	1.181	2.559	WOEX 030204	0,62	14395
KUB-T-U.2D.0593.R.03.ABS50-F	V40 11510	0.593	1.969	3.858	1.260	2.638	WOEX 030204	0,62	15195
KUB-T-U.2D.0625.R.03.ABS50-F	V40 11590	0.625	1.969	3.858	1.260	2.638	WOEX 030204	0,62	15995
KUB-T-U.2D.0687.R.03.ABS50-F	V40 11750	0.687	1.969	4.016	1.417	2.795	WOEX 030204	0,62	17595
KUB-T-U.2D.0703.R.03.ABS50-F	V40 11790	0.703	1.969	4.016	1.417	2.559	WOEX 030204	0,62	17995
KUB-T-U.2D.0750.R.03.ABS50-F	V40 11910	0.750	1.969	4.173	1.575	2.638	WOEX 030204	0,62	19195
KUB-T-U.2D.0781.R.03.ABS50-F	V40 11980	0.781	1.969	4.173	1.575	2.638	WOEX 030204	0,62	19895
KUB-T-U.2D.0812.R.04.ABS50-F	V40 12060	0.812	1.969	4.252	1.654	2.795	WOEX 040304	1,01	20695
KUB-T-U.2D.0828.R.04.ABS50-F	V40 12100	0.828	1.969	4.252	1.654	2.795	WOEX 040304	1,01	21095
KUB-T-U.2D.0875.R.04.ABS50-F	V40 12220	0.875	1.969	4.409	1.811	2.953	WOEX 040304	1,01	22295
KUB-T-U.2D.0937.R.04.ABS50-F	V40 12380	0.937	1.969	4.488	1.890	2.953	WOEX 040304	1,01	23895
KUB-T-U.2D.1000.R.05.ABS50-F	V40 12540	1.000	1.969	4.646	2.047	3.031	WOEX 05T304	1,28	25495
KUB-T-U.2D.1031.R.05.ABS50-F	V40 12620	1.031	1.969	4.724	2.126	3.031	WOEX 05T304	1,28	26295
KUB-T-U.2D.1062.R.05.ABS50-F	V40 12700	1.062	1.969	4.724	2.126	3.189	WOEX 05T304	1,28	27095
KUB-T-U.2D.1109.R.05.ABS50-F	V40 12820	1.109	1.969	4.882	2.283	3.268	WOEX 05T304	1,28	28295
KUB-T-U.2D.1125.R.05.ABS50-F	V40 12860	1.125	1.969	4.882	2.283	3.425	WOEX 05T304	1,28	28695
KUB-T-U.2D.1156.R.05.ABS50-F	V40 12940	1.156	1.969	4.961	2.362	3.504	WOEX 05T304	1,28	29495
KUB-T-U.2D.1187.R.05.ABS50-F	V40 13010	1.187	1.969	5.236	2.441	3.504	WOEX 05T304	1,28	30195
KUB-T-U.2D.1218.R.05.ABS50-F	V40 13090	1.218	1.969	5.236	2.441	3.661	WOEX 05T304	1,28	30995
KUB-T-U.2D.1250.R.05.ABS50-F	V40 13180	1.250	1.969	5.315	2.520	3.661	WOEX 05T304	1,28	31895
KUB-T-U.2D.1281.R.05.ABS50-F	V40 13250	1.281	1.969	5.394	2.598	3.740	WOEX 05T304	1,28	32595
KUB-T-U.2D.1312.R.05.ABS50-F	V40 13330	1.312	1.969	5.472	2.677	4.016	WOEX 05T304	1,28	33395
KUB-T-U.2D.1328.R.05.ABS50-F	V40 13370	1.328	1.969	5.472	2.677	4.016	WOEX 05T304	1,28	33795
KUB-T-U.2D.1375.R.05.ABS50-F	V40 13490	1.375	1.969	5.551	2.756	4.094	WOEX 05T304	1,28	34995
KUB-T-U.2D.1406.R.05.ABS50-F	V40 13570	1.406	1.969	5.630	2.835	4.173	WOEX 05T304	1,28	35795
KUB-T-U.2D.1437.R.05.ABS50-F	V40 13650	1.437	1.969	6.102	2.913	4.252	WOEX 05T304	1,28	36595
KUB-T-U.2D.1469.R.06.ABS50-F	V40 13730	1.469	1.969	6.181	2.992	4.252	WOEX 06T304	2,8	37395
KUB-T-U.2D.1500.R.06.ABS50-F	V40 13810	1.500	1.969	6.260	3.071	4.331	WOEX 06T304	2,8	38195
KUB-T-U.2D.1531.R.06.ABS50-F	V40 13890	1.531	1.969	6.260	3.071	4.409	WOEX 06T304	2,8	38995
KUB-T-U.2D.1562.R.06.ABS50-F	V40 13970	1.562	1.969	6.339	3.150	4.882	WOEX 06T304	2,8	39795
KUB-T-U.2D.1625.R.06.ABS50-F	V40 14130	1.625	1.969	6.496	3.307	4.961	WOEX 06T304	2,8	41395
KUB-T-U.2D.1656.R.06.ABS50-F	V40 14210	1.656	1.969	6.575	3.386	5.039	WOEX 06T304	2,8	42195
KUB-T-U.2D.1687.R.06.ABS50-F	V40 14280	1.687	1.969	6.575	3.386	5.039	WOEX 06T304	2,8	42895
KUB-T-U.2D.1750.R.06.ABS50-F	V40 14450	1.750	1.969	6.689	3.500	5.118	WOEX 06T304	2,8	44595

Screwdriver

80 950 ...

Clamping screw

10 950 ...

Spare parts DC		
0.562 - 0.781	123	10000
0.812 - 0.937	123	10700
1.000 - 1.437	125	10500
1.469 - 1.750	127	10600

Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

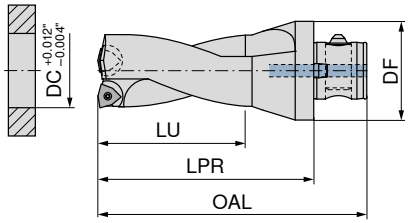
KUB Trigon – Indexable insert drill

Scope of supply:

with indexable insert (10 897 ...) incl. fixing screw, cylindrical pin and clamping screw
with indexable insert (10 898 ...) incl. fixing screw, cylindrical pin and clamping screw

≤ 2xD

ABS



Designation	KOMET no.	DC inch	DF inch	OAL inch	LU inch	LPR inch	Insert	torque moment Nm	10 892 ...	15 892 ...
KUB-T.2D.1781.R.08.ABS63-F	V13 34520	1.781	2.480	7.224	3.562	5.728	WOEX 080404	4,3		45296
KUB-T.2D.1812.R.08.ABS63	V13 34600	1.811	2.480	7.283	3.622	5.787	WOEX 080404	4,3	46096	
KUB-T.2D.1875.R.08.ABS63-F	V13 34760	1.875	2.480	7.412	3.750	5.916	WOEX 080404	4,3		47696
KUB-T.2D.1937.R.08.ABS63-F	V13 34920	1.937	2.480	7.536	3.874	6.040	WOEX 080404	4,3		49296
KUB-T.2D.1975.R.08.ABS63-F	V13 35020	1.975	2.480	7.612	3.950	6.116	WOEX 080404	4,3		50296
KUB-T.2D.2000.R.08.ABS63-F	V13 35080	2.000	2.480	7.662	4.000	6.166	WOEX 080404	4,3		50896
KUB-T.2D.2062.R.08.ABS63-F	V13 35240	2.062	2.480	7.786	4.124	6.290	WOEX 080404	4,3		52496
KUB-T.2D.2125.R.08.ABS63	V13 35400	2.126	2.480	7.913	4.252	6.417	WOEX 080404	4,3	54096	
KUB-T.2D.2165.R.10.ABS80	V14 35500	2.165	3.150	8.189	4.331	6.496	WOEX 100504	4,3	55098	
KUB-T.2D.2203.R.10.ABS80	V14 35600	2.205	3.150	8.268	4.409	6.575	WOEX 100504	4,3	56098	
KUB-T.2D.2250.R.10.ABS80-F	V14 35720	2.250	3.150	8.359	4.500	6.666	WOEX 100504	4,3		57298
KUB-T.2D.2281.R.10.ABS80-F	V14 35790	2.281	3.150	8.421	4.562	6.728	WOEX 100504	4,3		57998
KUB-T.2D.2375.R.10.ABS80-F	V14 36030	2.375	3.150	8.609	4.750	6.916	WOEX 100504	4,3		60398
KUB-T.2D.2437.R.10.ABS80-F	V14 36190	2.437	3.150	8.733	4.874	7.040	WOEX 100504	4,3		61998
KUB-T.2D.2500.R.10.ABS80-F	V14 36350	2.500	3.150	8.859	5.000	7.166	WOEX 100504	4,3		63598
KUB-T.2D.2593.R.10.ABS80-F	V14 36590	2.593	3.150	9.045	5.186	7.352	WOEX 100504	4,3		65998
KUB-T.2D.2625.R.10.ABS80-F	V14 36670	2.625	3.150	9.109	5.250	7.416	WOEX 100504	4,3		66798
KUB-T.2D.2656.R.10.ABS80-F	V14 36750	2.656	3.150	9.171	5.312	7.478	WOEX 100504	4,3		67598
KUB-T.2D.2750.R.12.ABS80-F	V14 36990	2.750	3.150	9.753	5.500	8.060	WOEX 120608	6,25		69998
KUB-T.2D.2875.R.12.ABS80	V14 37300	2.874	3.150	10.000	5.748	8.307	WOEX 120608	6,25	73098	
KUB-T.2D.3000.R.12.ABS80-F	V14 37620	3.000	3.150	10.253	6.000	8.560	WOEX 120608	6,25		76298
KUB-T.2D.3250.R.12.ABS80-F	V14 38260	3.250	3.150	10.753	6.500	9.060	WOEX 120608	6,25		82698

Spare parts DC	 Cylindrical pin 10 950 ...	 Indexable insert, internal 10 897 ...	 Indexable insert, external 10 898 ...	 Screwdriver 80 950 ...	 Clamping screw 10 950 ...	 Fixing screw 10 950 ...
1.781 - 2.126	17200	14800	14800	120	12700	17000
2.165 - 2.656	17200	25300	25300	120	12700	17000
2.750 - 3.250	17300	36000	36000	121	17400	17100

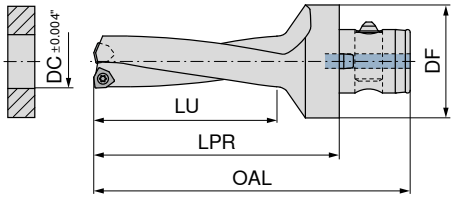
Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

KUB Trigon – Indexable insert drill

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 3xD

ABS



NEW

15 893 ...

Designation	KOMET no.	DC inch	DF inch	OAL inch	LU inch	LPR inch	Insert	torque moment Nm	
KUB-T-U.3D.0562.R.03.ABS50-F	V40 21430	0.562	1.969	4.370	1.772	5.276	WOEX 030204	0,62	14395
KUB-T-U.3D.0593.R.03.ABS50-F	V40 21510	0.593	1.969	4.488	1.890	5.354	WOEX 030204	0,62	15195
KUB-T-U.3D.0625.R.03.ABS50-F	V40 21590	0.625	1.969	4.488	1.890	5.354	WOEX 030204	0,62	15995
KUB-T-U.3D.0656.R.03.ABS50-F	V40 21670	0.656	1.969	4.606	2.008	5.469	WOEX 030204	0,62	16795
KUB-T-U.3D.0687.R.03.ABS50-F	V40 21750	0.687	1.969	4.724	2.126	3.150	WOEX 030204	0,62	17595
KUB-T-U.3D.0703.R.03.ABS50-F	V40 21790	0.703	1.969	4.724	2.126	3.268	WOEX 030204	0,62	17995
KUB-T-U.3D.0750.R.03.ABS50-F	V40 21910	0.750	1.969	4.961	2.362	3.268	WOEX 030204	0,62	19195
KUB-T-U.3D.0765.R.03.ABS50-F	V40 21940	0.765	1.969	4.961	2.362	3.386	WOEX 030204	0,62	19495
KUB-T-U.3D.0781.R.03.ABS50-F	V40 21980	0.781	1.969	4.961	2.362	3.504	WOEX 030204	0,62	19895
KUB-T-U.3D.0812.R.04.ABS50-F	V40 22060	0.812	1.969	5.079	2.480	3.504	WOEX 040304	1,01	20695
KUB-T-U.3D.0828.R.04.ABS50-F	V40 22100	0.828	1.969	5.079	2.480	3.740	WOEX 040304	1,01	21095
KUB-T-U.3D.0875.R.04.ABS50-F	V40 22220	0.875	1.969	5.315	2.717	3.740	WOEX 040304	1,01	22295
KUB-T-U.3D.0937.R.04.ABS50-F	V40 22380	0.937	1.969	5.433	2.835	3.740	WOEX 040304	1,01	23895
KUB-T-U.3D.0985.R.04.ABS50-F	V40 22500	0.985	1.969	5.551	2.953	3.858	WOEX 040304	1,01	25095
KUB-T-U.3D.1000.R.05.ABS50-F	V40 22540	1.000	1.969	5.669	3.071	3.858	WOEX 05T304	1,28	25495
KUB-T-U.3D.1031.R.05.ABS50-F	V40 22620	1.031	1.969	5.787	3.189	4.094	WOEX 05T304	1,28	26295
KUB-T-U.3D.1062.R.05.ABS50-F	V40 22700	1.062	1.969	5.787	3.189	4.213	WOEX 05T304	1,28	27095
KUB-T-U.3D.1109.R.05.ABS50-F	V40 22820	1.109	1.969	6.024	3.425	4.331	WOEX 05T304	1,28	28295
KUB-T-U.3D.1125.R.05.ABS50-F	V40 22860	1.125	1.969	6.024	3.425	4.449	WOEX 05T304	1,28	28695
KUB-T-U.3D.1156.R.05.ABS50-F	V40 22940	1.156	1.969	6.142	3.543	4.567	WOEX 05T304	1,28	29495
KUB-T-U.3D.1187.R.05.ABS50-F	V40 23010	1.187	1.969	6.457	3.661	4.567	WOEX 05T304	1,28	30195
KUB-T-U.3D.1218.R.05.ABS50-F	V40 23090	1.218	1.969	6.457	3.661	4.803	WOEX 05T304	1,28	30995
KUB-T-U.3D.1250.R.05.ABS50-F	V40 23180	1.250	1.969	6.575	3.780	4.803	WOEX 05T304	1,28	31895
KUB-T-U.3D.1281.R.05.ABS50-F	V40 23250	1.281	1.969	6.693	3.898	4.921	WOEX 05T304	1,28	32595
KUB-T-U.3D.1312.R.05.ABS50-F	V40 23330	1.312	1.969	6.811	4.016	5.236	WOEX 05T304	1,28	33395
KUB-T-U.3D.1328.R.05.ABS50-F	V40 23370	1.328	1.969	6.811	4.016	5.236	WOEX 05T304	1,28	33795
KUB-T-U.3D.1375.R.05.ABS50-F	V40 23490	1.375	1.969	6.929	4.134	5.354	WOEX 05T304	1,28	34995
KUB-T-U.3D.1406.R.05.ABS50-F	V40 23570	1.406	1.969	7.047	4.252	5.472	WOEX 05T304	1,28	35795
KUB-T-U.3D.1437.R.05.ABS50-F	V40 23650	1.437	1.969	7.559	4.370	5.591	WOEX 05T304	1,28	36595
KUB-T-U.3D.1469.R.06.ABS50-F	V40 23730	1.469	1.969	7.677	4.488	5.591	WOEX 06T304	2,8	37395
KUB-T-U.3D.1500.R.06.ABS50-F	V40 23810	1.500	1.969	7.795	4.606	5.709	WOEX 06T304	2,8	38195
KUB-T-U.3D.1531.R.06.ABS50-F	V40 23890	1.531	1.969	7.795	4.606	5.827	WOEX 06T304	2,8	38995
KUB-T-U.3D.1562.R.06.ABS50-F	V40 23970	1.562	1.969	7.913	4.724	6.339	WOEX 06T304	2,8	39795
KUB-T-U.3D.1625.R.06.ABS50-F	V40 24130	1.625	1.969	8.150	4.961	6.457	WOEX 06T304	2,8	41395
KUB-T-U.3D.1656.R.06.ABS50-F	V40 24210	1.656	1.969	8.268	5.079	6.575	WOEX 06T304	2,8	42195
KUB-T-U.3D.1687.R.06.ABS50-F	V40 24280	1.687	1.969	8.268	5.079	6.575	WOEX 06T304	2,8	42895
KUB-T-U.3D.1750.R.06.ABS50-F	V40 24450	1.750	1.969	8.439	5.250	6.693	WOEX 06T304	2,8	44595

Screwdriver

80 950 ...

Clamping screw

10 950 ...

Spare parts DC		
0.562 - 0.781	123	10000
0.812 - 0.985	123	10700
1.000 - 1.437	125	10500
1.469 - 1.750	127	10600

Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

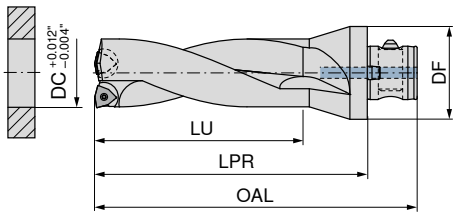
KUB Trigon – Indexable insert drill

▲ Tightening torque refers to clamping screw

Scope of supply:

with indexable insert (10 897 ...) incl. fixing screw, cylindrical pin and clamping screw
with indexable insert (10 898 ...) incl. fixing screw, cylindrical pin and clamping screw

≤ 3xD



ABS

Designation	KOMET no.	DC inch	DF inch	OAL inch	LU inch	LPR inch	Insert	torque moment Nm	10 893 ...	15 893 ...
KUB-T.3D.1781.R.08.ABS63-F	V13 74520	1.781	2.480	9.005	5.343	7.509	WOEX 080404	4,3		45296
KUB-T.3D.1812.R.08.ABS63	V13 74600	1.811	2.480	9.094	5.433	7.598	WOEX 080404	4,3	46096	
KUB-T.3D.1875.R.08.ABS63-F	V13 74760	1.875	2.480	9.287	5.625	7.791	WOEX 080404	4,3		47696
KUB-T.3D.1937.R.08.ABS63-F	V13 74920	1.937	2.480	9.473	5.811	7.977	WOEX 080404	4,3		49296
KUB-T.3D.1975.R.08.ABS63-F	V13 75020	1.975	2.480	9.587	5.925	8.091	WOEX 080404	4,3		50296
KUB-T.3D.2000.R.08.ABS63-F	V13 75080	2.000	2.480	9.662	6.000	8.166	WOEX 080404	4,3		50896
KUB-T.3D.2062.R.08.ABS63-F	V13 75240	2.062	2.480	10.028	6.186	8.532	WOEX 080404	4,3		52496
KUB-T.3D.2125.R.08.ABS63	V13 75400	2.126	2.480	10.039	6.378	8.543	WOEX 080404	4,3	54096	
KUB-T.3D.2165.R.10.ABS80	V14 75500	2.165	3.150	10.354	6.496	8.661	WOEX 100504	4,3	55098	
KUB-T.3D.2203.R.10.ABS80	V14 75600	2.205	3.150	10.472	6.614	8.780	WOEX 100504	4,3	56098	
KUB-T.3D.2250.R.10.ABS80-F	V14 75720	2.250	3.150	10.609	6.750	8.916	WOEX 100504	4,3		57298
KUB-T.3D.2281.R.10.ABS80-F	V14 75790	2.281	3.150	10.702	6.843	9.009	WOEX 100504	4,3		57998
KUB-T.3D.2375.R.10.ABS80-F	V14 76030	2.375	3.150	10.984	7.125	9.291	WOEX 100504	4,3		60398
KUB-T.3D.2437.R.10.ABS80-F	V14 76190	2.437	3.150	11.170	7.311	9.477	WOEX 100504	4,3		61998
KUB-T.3D.2500.R.10.ABS80-F	V14 76350	2.500	3.150	11.359	7.500	9.666	WOEX 100504	4,3		63598
KUB-T.3D.2593.R.10.ABS80-F	V14 76590	2.593	3.150	11.638	7.779	9.945	WOEX 100504	4,3		65998
KUB-T.3D.2625.R.10.ABS80-F	V14 76670	2.625	3.150	11.734	7.875	10.041	WOEX 100504	4,3		66798
KUB-T.3D.2656.R.10.ABS80-F	V14 76750	2.656	3.150	11.827	7.968	10.134	WOEX 100504	4,3		67598
KUB-T.3D.2750.R.12.ABS80-F	V14 76990	2.750	3.150	12.503	8.250	10.810	WOEX 120608	6,25		69998
KUB-T.3D.2875.R.12.ABS80	V14 77300	2.874	3.150	12.874	8.622	11.181	WOEX 120608	6,25	73098	
KUB-T.3D.3000.R.12.ABS80-F	V14 77620	3.000	3.150	13.253	9.000	11.560	WOEX 120608	6,25		76298
KUB-T.3D.3250.R.12.ABS80-F	V14 78260	3.250	3.150	14.003	9.750	12.310	WOEX 120608	6,25		82698

Spare parts DC	Cylindrical pin 10 950 ...	Indexable insert, internal 10 897 ...	Indexable insert, external 10 898 ...	Screwdriver 80 950 ...	Clamping screw 10 950 ...	Fixing screw 10 950 ...
1.781 - 2.126	17200	14800	14800	120	12700	17000
2.165 - 2.656	17200	25300	25300	120	12700	17000
2.750 - 3.250	17300	36000	36000	121	17400	17100

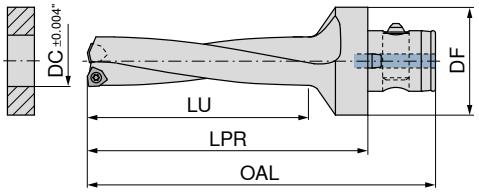
Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

KUB Trigon – Indexable insert drill

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 4xD

ABS



Designation	KOMET no.	DC inch	DF inch	OAL inch	LU inch	LPR inch	Insert	torque moment Nm	10 894 ...	15 894 ...
KUB-T.4D.0562.R.03.ABS50-F	V30 91431	0.562	1.969	4.955	2.358	3.735	WOEX 030204	0,62		14395
KUB-T.4D.0593.R.03.ABS50-F	V30 91511	0.593	1.969	5.112	2.514	3.892	WOEX 030204	0,62		15195
KUB-T.4D.0625.R.03.ABS50-F	V30 91591	0.625	1.969	5.114	2.516	3.894	WOEX 030204	0,62		15995
KUB-T.4D.0656.R.03.ABS50-F	V30 91671	0.656	1.969	5.269	2.671	4.049	WOEX 030204	0,62		16795
KUB-T.4D.0687.R.03.ABS50-F	V30 91751	0.687	1.969	5.425	2.827	4.205	WOEX 030204	0,62		17595
KUB-T.4D.0703.R.03.ABS50-F	V30 91791	0.703	1.969	5.425	2.828	4.205	WOEX 030204	0,62		17995
KUB-T.4D.0750.R.03.ABS50-F	V30 91911	0.750	1.969	5.740	3.142	4.520	WOEX 030204	0,62		19195
KUB-T.4D.0765.R.03.ABS50-F	V30 91941	0.765	1.969	5.752	3.154	4.532	WOEX 030204	0,62		19495
KUB-T.4D.0781.R.03.ABS50-F	V30 91981	0.781	1.969	5.753	3.155	4.533	WOEX 030204	0,62		19895
KUB-T.4D.0812.R.04.ABS50-F	V30 92061	0.812	1.969	5.909	3.311	4.689	WOEX 040304	1,01		20695
KUB-T.4D.0828.R.04.ABS50	V30 92101	0.827	1.969	5.906	3.307	4.685	WOEX 040304	1,01	21095	
KUB-T.4D.0875.R.04.ABS50-F	V30 92221	0.875	1.969	6.224	3.626	5.004	WOEX 040304	1,01		22295
KUB-T.4D.0937.R.04.ABS50-F	V30 92381	0.937	1.969	6.377	3.779	5.157	WOEX 040304	1,01		23895
KUB-T.4D.0985.R.05.ABS50	V30 92501	0.984	1.969	6.535	3.937	5.315	WOEX 05T304	1,28	25095	
KUB-T.4D.1000.R.05.ABS50-F	V30 92541	1.000	1.969	6.692	4.094	5.472	WOEX 05T304	1,28		25495
KUB-T.4D.1031.R.05.ABS50-F	V30 92621	1.031	1.969	6.848	4.250	5.628	WOEX 05T304	1,28		26295
KUB-T.4D.1062.R.05.ABS50	V30 92701	1.063	1.969	6.850	4.252	5.630	WOEX 05T304	1,28	27095	
KUB-T.4D.1109.R.05.ABS50-F	V30 92821	1.109	1.969	7.160	4.562	5.940	WOEX 05T304	1,28		28295
KUB-T.4D.1125.R.05.ABS50-F	V30 92861	1.125	1.969	7.161	4.563	5.941	WOEX 05T304	1,28		28695
KUB-T.4D.1156.R.05.ABS50-F	V30 92941	1.156	1.969	7.316	4.718	6.096	WOEX 05T304	1,28		29495
KUB-T.4D.1187.R.05.ABS50-F	V30 93021	1.187	1.969	7.685	4.874	6.465	WOEX 05T304	1,28		30195
KUB-T.4D.1218.R.05.ABS50-F	V30 93091	1.218	1.969	7.699	4.888	6.479	WOEX 05T304	1,28		30995
KUB-T.4D.1250.R.05.ABS50-F	V30 93181	1.250	1.969	7.842	5.031	6.622	WOEX 05T304	1,28		31895
KUB-T.4D.1281.R.05.ABS50-F	V30 93251	1.281	1.969	8.014	5.203	6.794	WOEX 05T304	1,28		32595
KUB-T.4D.1312.R.05.ABS50-F	V30 93331	1.312	1.969	8.161	5.350	6.941	WOEX 05T304	1,28		33395
KUB-T.4D.1328.R.05.ABS50-F	V30 93371	1.328	1.969	8.170	5.359	6.950	WOEX 05T304	1,28		33795
KUB-T.4D.1375.R.05.ABS50-F	V30 93491	1.375	1.969	8.327	5.516	7.107	WOEX 05T304	1,28		34995
KUB-T.4D.1406.R.05.ABS50-F	V30 93571	1.406	1.969	8.482	5.671	7.262	WOEX 05T304	1,28		35795
KUB-T.4D.1437.R.05.ABS50-F	V30 93651	1.437	1.969	8.638	5.827	7.418	WOEX 05T304	1,28		36595
KUB-T.4D.1469.R.06.ABS50-F	V30 93731	1.469	1.969	9.175	5.986	7.955	WOEX 06T304	2,8		37395
KUB-T.4D.1500.R.06.ABS50-F	V30 93811	1.500	1.969	9.331	6.142	8.111	WOEX 06T304	2,8		38195
KUB-T.4D.1531.R.06.ABS50-F	V30 93891	1.531	1.969	9.329	6.140	8.109	WOEX 06T304	2,8		38995
KUB-T.4D.1562.R.06.ABS50-F	V30 93971	1.562	1.969	9.484	6.295	8.264	WOEX 06T304	2,8		39795
KUB-T.4D.1625.R.06.ABS50-F	V30 94131	1.625	1.969	9.799	6.610	8.579	WOEX 06T304	2,8		41395
KUB-T.4D.1656.R.06.ABS50-F	V30 94211	1.656	1.969	9.955	6.766	8.735	WOEX 06T304	2,8		42195
KUB-T.4D.1687.R.06.ABS50-F	V30 94291	1.687	1.969	9.953	6.764	8.733	WOEX 06T304	2,8		42895
KUB-T.4D.1750.R.06.ABS50-F	V30 94451	1.750	1.969	10.268	7.079	9.048	WOEX 06T304	2,8		44595

Screwdriver

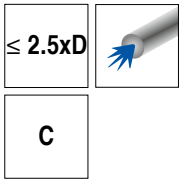
Clamping screw

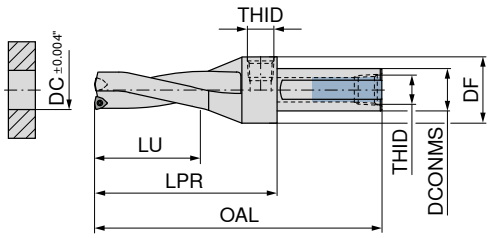
Spare parts DC	80 950 ...	10 950 ...
0.562 - 0.781	123	10000
0.812 - 0.937	123	10700
0.984 - 1.437	125	10500
1.469 - 1.750	127	10600

Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

KUB Trigon – Indexable insert drill

Scope of supply:
Indexable Insert Drill incl. clamping screws





Designation	KOMET no.	DC inch	DCONMS inch	DF inch	OAL inch	LU inch	LPR inch	THID inch	Insert	torque moment Nm	15 896 ...
KUB-T.2,5D.0562.R.03.C0750-EF	V57 41432	0.562	0.750	1.130	5.125	1.405	2.875	1/8" NPT	WOEX 030204	0,62	**14309**
KUB-T.2,5D.0593.R.03.C0750-EF	V57 41510	0.593	0.750	1.130	5.125	1.483	2.875	1/8" NPT	WOEX 030204	0,62	**15109**
KUB-T.2,5D.0625.R.03.C0750-EF	V57 41590	0.625	0.750	1.130	5.125	1.563	2.875	1/8" NPT	WOEX 030204	0,62	**15909**
KUB-T.2,5D.0687.R.03.C0750-E	V57 41750	0.687	0.750	1.130	5.375	1.718	3.125	1/8" NPT	WOEX 030204	0,62	**17509**
KUB-T.2,5D.0703.R.03.C0750-EF	V57 41790	0.703	0.750	1.130	5.375	1.758	3.125	1/8" NPT	WOEX 030204	0,62	**17909**
KUB-T.2,5D.0750.R.03.C0750-EF	V57 41910	0.750	0.750	1.130	5.375	1.875	3.125	1/8" NPT	WOEX 030204	0,62	**19109**


Screwdriver

80 950 ...


Clamping screw

10 950 ...

Spare parts DC	123	10000
0.562 - 0.750		

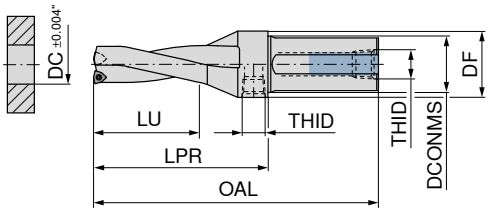
Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

KUB Trigon – Indexable insert drill

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 2.5xD

C



15 896 ...

Designation	KOMET no.	DC inch	DCONMS inch	DF inch	OAL inch	LU inch	LPR inch	THID inch	Insert	torque moment Nm	
KUB-T.2,5D.0562.R.03.C1250-EF	V57 51434	0.562	1.250	1.575	6.125	1.405	2.875	1/8" NPT	WOEX 030204	0,62	14301
KUB-T.2,5D.0593.R.03.C1250-EF	V57 51512	0.593	1.250	1.575	6.125	1.483	2.875	1/8" NPT	WOEX 030204	0,62	15101
KUB-T.2,5D.0625.R.03.C1250-EF	V57 51592	0.625	1.250	1.575	6.125	1.563	2.875	1/8" NPT	WOEX 030204	0,62	15901
KUB-T.2,5D.0656.R.03.C1250-EF	V57 51672	0.656	1.250	1.575	6.375	1.718	3.125	1/8" NPT	WOEX 030204	0,62	16701
KUB-T.2,5D.0687.R.03.C1250-E	V57 51752	0.687	1.250	1.575	6.375	1.718	3.125	1/8" NPT	WOEX 030204	0,62	17501
KUB-T.2,5D.0703.R.03.C1250-EF	V57 51792	0.703	1.250	1.575	6.375	1.758	3.125	1/8" NPT	WOEX 030204	0,62	17901
KUB-T.2,5D.0750.R.03.C1250-EF	V57 51912	0.750	1.250	1.575	6.375	1.625	3.125	1/8" NPT	WOEX 030204	0,62	19101
KUB-T.2,5D.0765.R.03.C1250-EF	V57 51942	0.765	1.250	1.575	6.375	1.625	3.125	1/8" NPT	WOEX 030204	0,62	19401
KUB-T.2,5D.0781.R.03.C1250-EF	V57 51982	0.781	1.250	1.575	6.375	1.625	3.125	1/8" NPT	WOEX 030204	0,62	19801
KUB-T.2,5D.0812.R.04.C1250-EF	V57 52062	0.812	1.250	1.575	6.375	1.625	3.125	1/8" NPT	WOEX 040304	1,01	20601
KUB-T.2,5D.0828.R.04.C1250-E	V57 52102	0.828	1.250	1.575	6.875	2.000	3.625	1/8" NPT	WOEX 040304	1,01	21001
KUB-T.2,5D.0843.R.04.C1250-EF	V57 52142	0.843	1.250	1.575	6.875	2.000	3.625	1/8" NPT	WOEX 040304	1,01	21401
KUB-T.2,5D.0875.R.04.C1250-EF	V57 52222	0.875	1.250	1.575	6.875	2.000	3.625	1/8" NPT	WOEX 040304	1,01	22201
KUB-T.2,5D.0906.R.04.C1250-E	V57 52302	0.906	1.250	1.575	6.875	2.000	3.625	1/8" NPT	WOEX 040304	1,01	23001
KUB-T.2,5D.0937.R.04.C1250-EF	V57 52382	0.937	1.250	1.575	6.875	2.000	3.625	1/8" NPT	WOEX 040304	1,01	23801
KUB-T.2,5D.0985.R.05.C1250-E	V57 52502	0.985	1.250	1.575	6.875	2.000	3.625	1/8" NPT	WOEX 05T304	1,28	25001
KUB-T.2,5D.1000.R.05.C1250-EF	V57 52542	1.000	1.250	1.575	6.875	2.000	3.625	1/8" NPT	WOEX 05T304	1,28	25401
KUB-T.2,5D.1031.R.05.C1250-EF	V57 52622	1.031	1.250	1.575	7.562	2.750	4.312	1/8" NPT	WOEX 05T304	1,28	26201
KUB-T.2,5D.1062.R.05.C1250-E	V57 52702	1.062	1.250	1.575	7.562	2.750	4.312	1/8" NPT	WOEX 05T304	1,28	27001
KUB-T.2,5D.1109.R.05.C1250-EF	V57 52822	1.109	1.250	1.575	7.562	2.750	4.312	1/8" NPT	WOEX 05T304	1,28	28201
KUB-T.2,5D.1125.R.05.C1250-EF	V57 52862	1.125	1.250	1.575	7.562	2.750	4.312	1/8" NPT	WOEX 05T304	1,28	28601
KUB-T.2,5D.1156.R.05.C1250-EF	V57 52942	1.156	1.250	1.575	8.250	3.250	5.000	1/8" NPT	WOEX 05T304	1,28	29401
KUB-T.2,5D.1187.R.05.C1250-EF	V57 53022	1.187	1.250	1.575	8.250	3.250	5.000	1/8" NPT	WOEX 05T304	1,28	30101
KUB-T.2,5D.1218.R.05.C1250-EF	V57 53092	1.218	1.250	1.575	8.250	3.250	5.000	1/8" NPT	WOEX 05T304	1,28	30901
KUB-T.2,5D.1250.R.05.C1250-EF	V57 53182	1.250	1.250	1.575	8.250	3.250	5.000	1/8" NPT	WOEX 05T304	1,28	31801
KUB-T.2,5D.1281.R.05.C1250-E	V57 53252	1.281	1.250	1.575	8.250	3.250	5.000	1/8" NPT	WOEX 05T304	1,28	32501
KUB-T.2,5D.1312.R.05.C1250-EF	V57 53332	1.312	1.250	1.575	8.250	3.250	5.000	1/8" NPT	WOEX 05T304	1,28	33301
KUB-T.2,5D.1328.R.05.C1250-EF	V57 53372	1.328	1.250	1.575	8.250	3.250	5.000	1/8" NPT	WOEX 05T304	1,28	33701
KUB-T.2,5D.1375.R.05.C1250-EF	V57 53492	1.375	1.250	1.575	8.250	3.250	5.000	1/8" NPT	WOEX 05T304	1,28	34901
KUB-T.2,5D.1406.R.05.C1250-EF	V57 53572	1.406	1.250	1.575	8.250	3.250	5.000	1/8" NPT	WOEX 05T304	1,28	35701
KUB-T.2,5D.1437.R.05.C1250-E	V57 53652	1.437	1.250	1.575	8.250	3.250	5.000	1/8" NPT	WOEX 05T304	1,28	36501
KUB-T.2,5D.1469.R.06.C1250-EF	V57 53732	1.469	1.250	1.575	8.368	3.500	5.118	1/8" NPT	WOEX 06T304	2,8	37301
KUB-T.2,5D.1500.R.06.C1250-EF	V57 53812	1.500	1.250	1.575	8.368	3.500	5.118	1/8" NPT	WOEX 06T304	2,8	38101
KUB-T.2,5D.1531.R.06.C1250-EF	V57 53892	1.531	1.250	1.575	8.368	3.500	5.118	1/8" NPT	WOEX 06T304	2,8	38911
KUB-T.2,5D.1562.R.06.C1250-EF	V57 53972	1.562	1.250	1.575	8.368	3.500	5.118	1/8" NPT	WOEX 06T304	2,8	39701
KUB-T.2,5D.1625.R.06.C1250-EF	V57 54132	1.625	1.250	1.575	8.368	3.500	5.118	1/8" NPT	WOEX 06T304	2,8	41301
KUB-T.2,5D.1656.R.06.C1500-EF	V57 54212	1.656	1.500	1.970	10.709	4.000	5.709	1/4" NPT	WOEX 06T304	2,8	42102
KUB-T.2,5D.1687.R.06.C1500-EF	V57 54262	1.687	1.500	1.970	10.709	4.000	5.709	1/4" NPT	WOEX 06T304	2,8	42802
KUB-T.2,5D.1750.R.06.C1500-EF	V57 54452	1.750	1.500	1.970	10.709	4.000	5.709	1/4" NPT	WOEX 06T304	2,8	44502


Screwdriver

80 950 ...


Clamping screw

10 950 ...

Spare parts DC		
0.562 - 0.781	123	10000
0.812 - 0.937	123	10700
0.985 - 1.437	125	10500
1.469 - 1.750	127	10600

Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

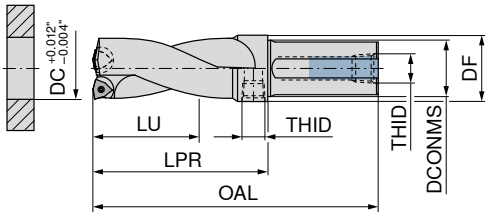
KUB Trigon – Indexable insert drill

Scope of supply:

with indexable insert (10 897 ...) incl. fixing screw, cylindrical pin and clamping screw
with indexable insert (10 898 ...) incl. fixing screw, cylindrical pin and clamping screw

≤ 2.5xD

C



Designation	KOMET no.	DC inch	DCONMS inch	DF inch	OAL inch	LU inch	LPR inch	THID inch	Insert	torque moment Nm	15 896 ...
KUB-T.2,5D.1812.R.08.C1500-E	V57 34602	1.812	1.500	1.969	10.709	4.000	5.709	1/4" NPT	WOEX 080404	4,3	46002
KUB-T.2,5D.1875.R.08.C1500-EF	V57 34762	1.875	1.500	1.969	10.709	4.000	5.709	1/4" NPT	WOEX 080404	4,3	47602
KUB-T.2,5D.1937.R.08.C1500-EF	V57 34922	1.937	1.500	1.969	11.890	5.000	6.890	1/4" NPT	WOEX 080404	4,3	49202
KUB-T.2,5D.2000.R.08.C1500-EF	V57 35082	2.000	1.500	1.969	11.890	5.000	6.890	1/4" NPT	WOEX 080404	4,3	50802
KUB-T.2,5D.2125.R.08.C1500-E	V57 35402	2.125	1.500	2.067	11.890	5.000	6.890	1/4" NPT	WOEX 080404	4,3	54002
KUB-T.2,5D.2250.R.10.C2000-EF	V57 35722	2.250	2.000	2.362	11.890	5.000	6.890	1/4" NPT	WOEX 100504	4,3	57204
KUB-T.2,5D.2375.R.10.C2000-EF	V57 36032	2.375	2.000	2.362	11.890	5.000	6.890	1/4" NPT	WOEX 100504	4,3	60304
KUB-T.2,5D.2500.R.10.C2000-EF	V57 36352	2.500	2.000	2.492	11.890	5.000	6.890	1/4" NPT	WOEX 100504	4,3	63504
KUB-T.2,5D.2750.R.12.C2000-EF	V57 36992	2.750	2.000	2.657	13.268	6.000	8.267	1/4" NPT	WOEX 120608	6,25	69904
KUB-T.2,5D.3000.R.12.C2000-EF	V57 37622	3.000	2.000	2.933	13.268	6.000	8.267	1/4" NPT	WOEX 120608	6,25	76204
KUB-T.2,5D.3250.R.12.C2000-EF	V57 38262	3.250	2.000	3.130	13.268	6.000	8.267	1/4" NPT	WOEX 120608	6,25	82604

Spare parts DC	 Cylindrical pin	 Indexable insert, internal	 Indexable insert, external	Screwdriver	 Clamping screw	 Fixing screw
	10 950 ...	10 897 ...	10 898 ...	80 950 ...	10 950 ...	10 950 ...
1.812 - 2.125	17200	14800	14800	120	12700	17000
2.250 - 2.500	17200	25300	25300	120	12700	17000
2.750 - 3.250	17300	36000	36000	121	17400	17100

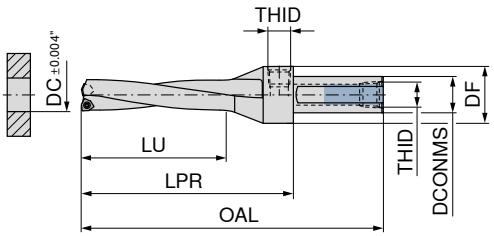
Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

KUB Trigon – Indexable insert drill

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 4xD

C



Designation	KOMET no.	DC inch	DCONMS inch	DF inch	OAL inch	LU inch	LPR inch	THID inch	Insert	torque moment Nm	15 894 ...
KUB-T.4D.0562.R.03.C0750-EF	V57 61432	0.562	0.750	1.130	5.875	2.248	3.625	1/8" NPT	WOEX 030204	0,62	**14309**
KUB-T.4D.0593.R.03.C0750-EF	V57 61510	0.593	0.750	1.130	6.000	2.372	3.750	1/8" NPT	WOEX 030204	0,62	**15109**
KUB-T.4D.0625.R.03.C0750-EF	V57 61590	0.625	0.750	1.130	6.128	2.500	3.878	1/8" NPT	WOEX 030204	0,62	**15909**
KUB-T.4D.0687.R.03.C0750-E	V57 61750	0.687	0.750	1.130	6.376	2.748	4.126	1/8" NPT	WOEX 030204	0,62	**17509**
KUB-T.4D.0703.R.03.C0750-EF	V57 61790	0.703	0.750	1.130	6.439	2.812	4.189	1/8" NPT	WOEX 030204	0,62	**17909**
KUB-T.4D.0750.R.03.C0750-EF	V57 61910	0.750	0.750	1.130	6.628	3.000	4.378	1/8" NPT	WOEX 030204	0,62	**19109**

Screwdriver

80 950 ...

Clamping screw

10 950 ...

Spare parts DC		
0.562 - 0.750	**123**	**10000**

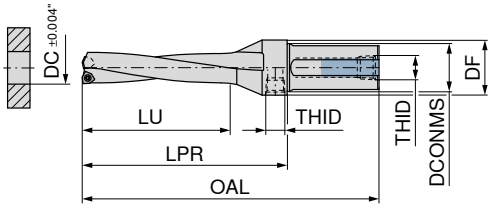
Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

KUB Trigon – Indexable insert drill

Scope of supply:
Indexable Insert Drill incl. clamping screws

≤ 4xD

C



15 894 ...

Designation	KOMET no.	DC inch	DCONMS inch	DF inch	OAL inch	LU inch	LPR inch	THID inch	Insert	torque moment Nm	
KUB-T.4D.0562.R.03.C1250-EF	V57 71434	0.562	1.250	1.575	6.875	2.248	3.625	1/8" NPT	WOEX 030204	0,62	14301
KUB-T.4D.0593.R.03.C1250-EF	V57 71512	0.593	1.250	1.575	7.000	2.372	3.750	1/8" NPT	WOEX 030204	0,62	15101
KUB-T.4D.0625.R.03.C1250-EF	V57 71592	0.625	1.250	1.575	7.128	2.500	3.878	1/8" NPT	WOEX 030204	0,62	15901
KUB-T.4D.0656.R.03.C1250-EF	V57 71672	0.656	1.250	1.575	7.252	2.624	4.002	1/8" NPT	WOEX 030204	0,62	16701
KUB-T.4D.0687.R.03.C1250-E	V57 71752	0.687	1.250	1.575	7.376	2.748	4.126	1/8" NPT	WOEX 030204	0,62	17501
KUB-T.4D.0703.R.03.C1250-EF	V57 71792	0.703	1.250	1.575	7.439	2.812	4.189	1/8" NPT	WOEX 030204	0,62	17901
KUB-T.4D.0750.R.03.C1250-EF	V57 71912	0.750	1.250	1.575	7.628	3.000	4.378	1/8" NPT	WOEX 030204	0,62	19101
KUB-T.4D.0765.R.03.C1250-EF	V57 71942	0.765	1.250	1.575	7.688	3.060	4.438	1/8" NPT	WOEX 030204	0,62	19401
KUB-T.4D.0781.R.03.C1250-EF	V57 71982	0.781	1.250	1.575	7.752	3.124	4.502	1/8" NPT	WOEX 030204	0,62	19801
KUB-T.4D.0812.R.04.C1250-EF	V57 72062	0.812	1.250	1.575	7.876	3.248	4.626	1/8" NPT	WOEX 040304	1,01	20601
KUB-T.4D.0828.R.04.C1250-E	V57 72102	0.828	1.250	1.575	7.940	3.312	4.690	1/8" NPT	WOEX 040304	1,01	21001
KUB-T.4D.0843.R.04.C1250-EF	V57 72142	0.843	1.250	1.575	8.000	3.372	4.750	1/8" NPT	WOEX 040304	1,01	21401
KUB-T.4D.0875.R.04.C1250-EF	V57 72222	0.875	1.250	1.575	8.128	3.500	4.878	1/8" NPT	WOEX 040304	1,01	22201
KUB-T.4D.0906.R.04.C1250-E	V57 72302	0.906	1.250	1.575	8.252	3.624	5.002	1/8" NPT	WOEX 040304	1,01	23001
KUB-T.4D.0937.R.04.C1250-EF	V57 72382	0.937	1.250	1.575	8.376	3.748	5.126	1/8" NPT	WOEX 040304	1,01	23801
KUB-T.4D.0985.R.05.C1250-E	V57 72502	0.985	1.250	1.575	8.568	3.940	5.318	1/8" NPT	WOEX 05T304	1,28	25001
KUB-T.4D.1000.R.05.C1250-EF	V57 72542	1.000	1.250	1.575	8.628	4.000	5.378	1/8" NPT	WOEX 05T304	1,28	25401
KUB-T.4D.1031.R.05.C1250-EF	V57 72622	1.031	1.250	1.575	8.752	4.124	5.502	1/8" NPT	WOEX 05T304	1,28	26201
KUB-T.4D.1062.R.05.C1250-E	V57 72702	1.062	1.250	1.575	8.876	4.248	5.626	1/8" NPT	WOEX 05T304	1,28	27001
KUB-T.4D.1109.R.05.C1250-EF	V57 72822	1.109	1.250	1.575	9.064	4.436	5.814	1/8" NPT	WOEX 05T304	1,28	28201
KUB-T.4D.1125.R.05.C1250-EF	V57 72862	1.125	1.250	1.575	9.128	4.500	5.878	1/8" NPT	WOEX 05T304	1,28	28601
KUB-T.4D.1156.R.05.C1250-EF	V57 72942	1.156	1.250	1.575	9.252	4.624	6.002	1/8" NPT	WOEX 05T304	1,28	29401
KUB-T.4D.1187.R.05.C1250-EF	V57 73022	1.187	1.250	1.575	9.589	4.748	6.339	1/8" NPT	WOEX 05T304	1,28	30101
KUB-T.4D.1218.R.05.C1250-EF	V57 73092	1.218	1.250	1.575	9.713	4.872	6.463	1/8" NPT	WOEX 05T304	1,28	30901
KUB-T.4D.1250.R.05.C1250-EF	V57 73182	1.250	1.250	1.575	9.841	5.000	6.591	1/8" NPT	WOEX 05T304	1,28	31801
KUB-T.4D.1281.R.05.C1250-E	V57 73252	1.281	1.250	1.575	9.965	5.124	6.715	1/8" NPT	WOEX 05T304	1,28	32501
KUB-T.4D.1312.R.05.C1250-EF	V57 73332	1.312	1.250	1.575	10.089	5.248	6.839	1/8" NPT	WOEX 05T304	1,28	33301
KUB-T.4D.1328.R.05.C1250-EF	V57 73372	1.328	1.250	1.575	10.137	5.312	6.887	1/8" NPT	WOEX 05T304	1,28	33701
KUB-T.4D.1375.R.05.C1250-EF	V57 73492	1.375	1.250	1.575	10.341	5.500	7.091	1/8" NPT	WOEX 05T304	1,28	34901
KUB-T.4D.1406.R.05.C1250-EF	V57 73572	1.406	1.250	1.575	10.449	5.624	7.199	1/8" NPT	WOEX 05T304	1,28	35701
KUB-T.4D.1437.R.05.C1250-E	V57 73652	1.437	1.250	1.575	10.589	5.748	7.339	1/8" NPT	WOEX 05T304	1,28	36501
KUB-T.4D.1469.R.06.C1250-EF	V57 73732	1.469	1.250	1.575	11.095	5.876	7.845	1/8" NPT	WOEX 06T304	2,8	37301
KUB-T.4D.1500.R.06.C1250-EF	V57 73812	1.500	1.250	1.575	11.219	6.000	7.969	1/8" NPT	WOEX 06T304	2,8	38101
KUB-T.4D.1531.R.06.C1250-EF	V57 73892	1.531	1.250	1.575	11.343	6.124	8.093	1/8" NPT	WOEX 06T304	2,8	38901
KUB-T.4D.1562.R.06.C1250-EF	V57 73972	1.562	1.250	1.575	11.467	6.248	8.217	1/8" NPT	WOEX 06T304	2,8	39701
KUB-T.4D.1625.R.06.C1250-EF	V57 74132	1.625	1.250	1.575	11.719	6.500	8.469	1/8" NPT	WOEX 06T304	2,8	41301
KUB-T.4D.1656.R.06.C1500-EF	V57 74212	1.656	1.500	1.970	13.593	6.624	8.593	1/4" NPT	WOEX 06T304	2,8	42102
KUB-T.4D.1687.R.06.C1500-EF	V57 74292	1.687	1.500	1.970	13.717	6.748	8.717	1/4" NPT	WOEX 06T304	2,8	42802
KUB-T.4D.1750.R.06.C1500-EF	V57 74452	1.750	1.500	1.970	13.969	7.000	8.969	1/4" NPT	WOEX 06T304	2,8	44502


Screwdriver

80 950 ...


Clamping screw

10 950 ...

Spare parts DC		
0.562 - 0.781	123	10000
0.812 - 0.937	123	10700
0.985 - 1.437	125	10500
1.469 - 1.750	127	10600

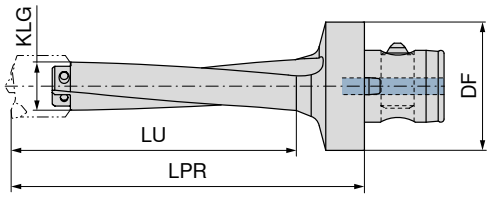
Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

KUB Centron – basic element

▲ KLG = Coupling Size

≤ 4xD

ABS

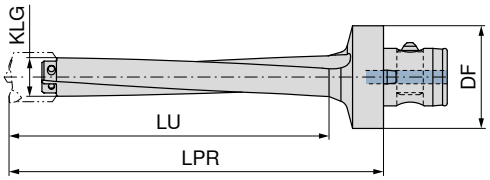


10 864 ...

Designation	KOMET no.	DF inch	LU inch	LPR inch	KLG	
KUB-C.GH.4D.190-ABS50	V47 20201	1.969	4.449	5.709	19	19095
KUB-C.GH.4D.250-ABS50	V47 20261	1.969	5.118	6.299	25	25095
KUB-C.GH.4D.320-ABS50	V47 20331	1.969	6.299	7.677	32	32095
KUB-C.GH.4D.385-ABS63	V47 20401	2.480	7.283	9.252	38,5	38596
KUB-C.GH.4D.445-ABS80	V47 20461	3.150	8.465	11.024	44,5	44598
KUB-C.GH.4D.535-ABS80	V47 20551	3.150	10.236	12.795	53,5	53598

≤ 6xD

ABS

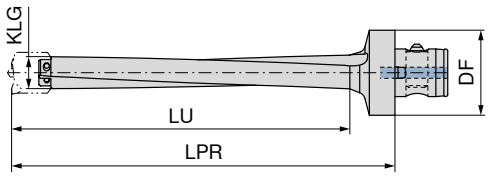


10 866 ...

Designation	KOMET no.	DF inch	LU inch	LPR inch	KLG	
KUB-C.GH.6D.190-ABS50	V47 40201	1.969	5.906	7.283	19	19095
KUB-C.GH.6D.250-ABS50	V47 40261	1.969	6.890	8.268	25	25095
KUB-C.GH.6D.320-ABS50	V47 40331	1.969	8.465	10.039	32	32095
KUB-C.GH.6D.385-ABS63	V47 40401	2.480	10.236	12.205	38,5	38596
KUB-C.GH.6D.445-ABS80	V47 40461	3.150	12.205	14.764	44,5	44598
KUB-C.GH.6D.535-ABS80	V47 40551	3.150	14.567	17.126	53,5	53598

≤ 9xD

ABS



10 869 ...

Designation	KOMET no.	DF inch	LU inch	LPR inch	KLG	
KUB-C.GH.9D.190-ABS50	V47 60201	1.969	7.874	9.252	19	19095
KUB-C.GH.9D.250-ABS50	V47 60261	1.969	9.055	10.236	25	25095
KUB-C.GH.9D.320-ABS50	V47 60331	1.969	11.417	12.992	32	32095
KUB-C.GH.9D.385-ABS63	V47 60401	2.480	13.386	15.354	38,5	38596
KUB-C.GH.9D.445-ABS80	V47 60461	3.150	16.339	18.898	44,5	44598
KUB-C.GH.9D.535-ABS80	V47 60551	3.150	19.488	22.047	53,5	53598

For correct assembly, please observe the operating instructions provided.

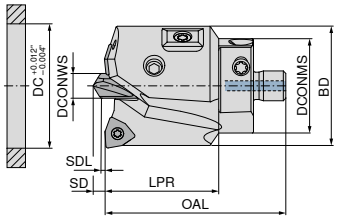
Matching holders can be found in our Online-Shop at cuttingtools.ceratizit.com and in the metric clamping technology catalog

KUB Centron – drill head Ø 0.812–2.500 Inch

- The pre-assembled drill head is ready to use
- The indexable inserts and centering tip must be professionally assembled
- Tightening torque refers to the clamping screw of the indexable inserts
- KLG = Coupling size

Scope of supply:

- Drill head incl. screws, guide pads and shim set
- Order centering tip and indexable inserts separately



NEW

15 860 ...

Designation	KOMET no.	DC inch	OAL inch	LPR inch	SD inch	BD inch	SDL inch	DCONMS inch	DCONWS inch	KLG	torque moment Nm	Insert	
KUB-C.BK.0812.R.03.19-F	V46 52060	0.812	1.440	0.910	0.089	0.768	0.039	0.748	0.197	19	0,62	WOEX 030204	**20600**
KUB-C.BK.0875.R.03.19-F	V46 52220	0.875	1.440	0.910	0.089	0.835	0.039	0.748	0.197	19	0,62	WOEX 030204	**22200**
KUB-C.BK.1000.R.03.19-F	V46 52540	1.000	1.440	0.910	0.089	0.961	0.039	0.748	0.197	19	0,62	WOEX 030204	**25400**
KUB-C.BK.1125.R.04.25-F	V46 52860	1.125	1.500	0.910	0.104	1.083	0.043	0.984	0.236	25	1,01	WOEX 040304	**28600**
KUB-C.BK.1250.R.04.25-F	V46 53180	1.250	1.500	0.910	0.104	1.211	0.043	0.984	0.236	25	1,01	WOEX 040304	**31800**
KUB-C.BK.1375.R.05.32-F	V46 53490	1.375	1.540	0.910	0.104	1.335	0.043	1.260	0.236	32	1,28	WOEX 05T304	**34900**
KUB-C.BK.1500.R.05.32-F	V46 53810	1.500	1.540	0.910	0.104	1.461	0.043	1.260	0.236	32	1,28	WOEX 05T304	**38100**
KUB-C.BK.1625.R.05.38,5-F	V46 54130	1.625	1.700	0.980	0.133	1.567	0.049	1.516	0.315	38,5	1,28	WOEX 05T304	**41300**
KUB-C.BK.1750.R.05.38,5-F	V46 54450	1.750	1.700	0.980	0.133	1.689	0.049	1.516	0.315	38,5	1,28	WOEX 05T304	**44500**
KUB-C.BK.1875.R.06.44,5-F	V46 54760	1.875	1.850	0.980	0.152	1.815	0.049	1.752	0.394	44,5	2,8	WOEX 06T304	**47600**
KUB-C.BK.2000.R.06.44,5-F	V46 55080	2.000	1.850	0.980	0.152	1.941	0.049	1.752	0.394	44,5	2,8	WOEX 06T304	**50800**
KUB-C.BK.2250.R.08.53,5-F	V46 55720	2.250	2.050	1.180	0.152	2.193	0.049	2.106	0.394	53,5	6,25	WOEX 080404	**57200**
KUB-C.BK.2375.R.08.53,5-F	V46 56030	2.375	2.050	1.180	0.152	2.315	0.049	2.106	0.394	53,5	6,25	WOEX 080404	**60300**
KUB-C.BK.2500.R.08.53,5-F	V46 56350	2.500	2.050	1.180	0.150	2.441	0.049	2.106	0.394	53,5	6,25	WOEX 080404	**63500**


Guide pad clamping screw


Indexable insert clamping screw

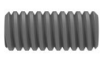

Guide pad


Shim set

10 950 ... | 10 950 ... | 10 950 ... | 10 950 ...

Spare parts DC						
0.812 - 1.000	M2,5x4,2 - 8IP - 1,28Nm	**11900**	M2,0x4,3 - 06IP	**10000**	**14600**	**15200**
1.125 - 1.250	M2,5x4,5 - 8IP - 1,28Nm	**11700**	M2,2x5,5 - 06IP	**10700**	**14700**	**15200**
1.375 - 1.750	M2,5x4,5 - 8IP - 1,28Nm	**11700**	M2,5x7,2 - 08IP	**10500**	**14800**	**15200**
1.875 - 2.000	M3,5x5,0 - 8IP - 2,25Nm	**11800**	M3,5x7,3 - 10IP	**10600**	**15000**	**15300**
2.250 - 2.500	M3,5x5,0 - 8IP - 2,25Nm	**11800**	M4,5x9 - 15IP	**12700**	**15100**	**15300**

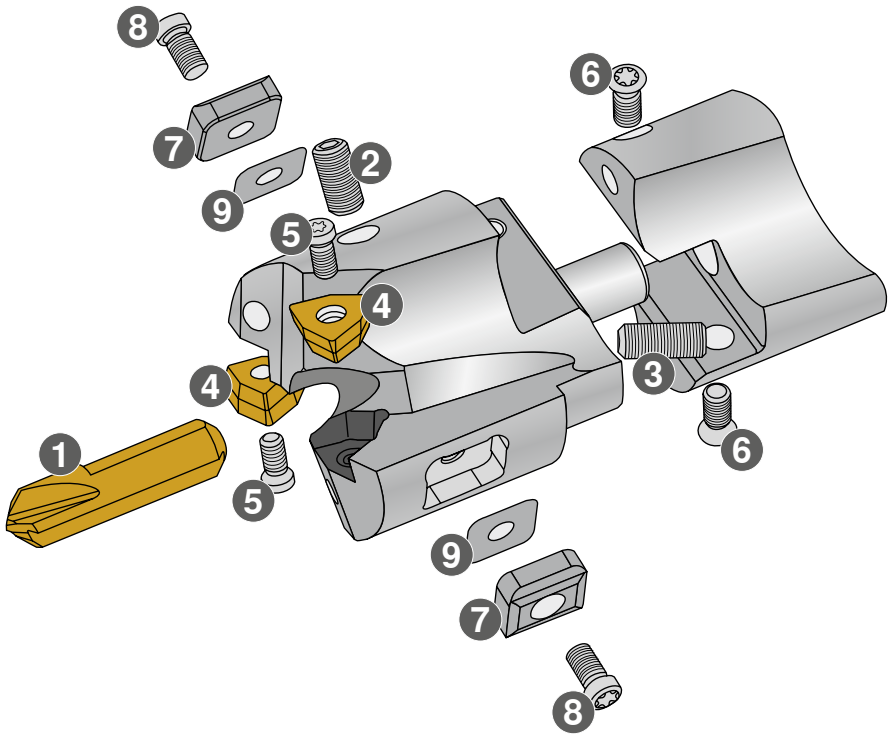

Basic element clamping screw


Centering tip clamping screw

10 950 ... | 10 950 ...

Spare parts DC				
0.812 - 1.000	M2,5x6,4 - 08IP - 1,28Nm	**12400**	M4x6 - SW2 - 1,5Nm	**12800**
1.125 - 1.250	M3x7,4 - 08IP - 2,25Nm	**12500**	M5x10 - SW2,5 - 2,5Nm	**13000**
1.375 - 1.750	M4x8,9 - 15IP - 4,3Nm	**12000**	M5x12 - SW2,5 - 2,5Nm	**13100**
1.875 - 2.000	M5x11,5 - 20IP - 6,25Nm	**12100**	M8x16 - SW4 - 8Nm	**13300**
2.250 - 2.500	M5,5x14 - 20IP - 6,25Nm	**12200**	M8x16 - SW4 - 8Nm	**13300**

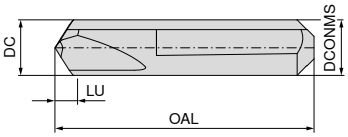
Exploded drawing of the drill head Ø 0.812–2.500 inch

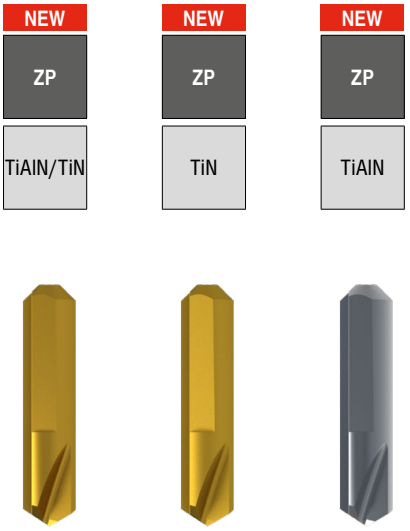


1 Centering tip
2 Clamping screw for centering tip
3 Adjusting screw for centering tip
4 Indexable Insert
5 Clamping screw for indexable insert
6 Clamping screw for basic element
7 Guide pad
8 Clamping screw for guide pad
9 Shim set for aligning the guide pads

For correct assembly, please observe the operating instructions provided.

KUB Centron – centering tip





DC inch	KOMET no.	OAL inch	LU inch	DCONMS inch	120° Solid carbide 10 863 ...		120° HSS 10 862 ...		120° HSS 10 862 ...	
0.197	V95 10012.0089	0.846	0.089	0.197				**00500**		
0.197	V95 10012.0090	0.846	0.089	0.197						**10500**
0.197	V95 10310.8450	0.846	0.089	0.197		**20500**				
0.236	V95 10022.0089	0.906	0.104	0.236				**00600**		
0.236	V95 10022.0090	0.906	0.104	0.236						**10600**
0.236	V95 10320.8450	0.906	0.104	0.236		**20600**				
0.315	V95 10032.0089	1.063	0.133	0.315				**00800**		
0.315	V95 10032.0090	1.063	0.133	0.315						**10800**
0.315	V95 10330.8450	1.063	0.133	0.315		**20800**				
0.394	V95 10042.0089	1.102	0.152	0.394				**01000**		
0.394	V95 10042.0090	1.102	0.152	0.394						**11000**
0.394	V95 10340.8450	1.102	0.152	0.394		**21000**				
P					●		●			
M					●					●
K					●					●
N					●		●			
S					○					●
H										
O					○		○			

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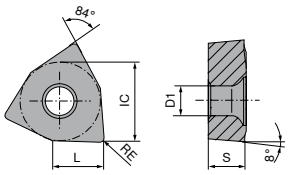
The cutting data of the KUB Centron depends on the centering tip and not on the indexable inserts. Please select the cutting data of the centering tip.

For correct assembly, please observe the operating instructions provided.

Article No. 10 863 ... is only suitable up to drilling depth 6xD.

WOEX

Designation	L inch	IC inch	S inch	D1 inch
WOEW 0201..	0.106	0.156	0.062	0.090
WOEX 0302..	0.125	0.196	0.090	0.090
WOEX 0403..	0.161	0.250	0.125	0.100
WOEX 05T3..	0.208	0.314	0.149	0.112
WOEX 06T3..	0.259	0.393	0.149	0.159
WOEX 0804..	0.311	0.472	0.188	0.192
WOEX 0804..	0.311	0.472	0.188	0.194
WOEX 1005..	0.389	0.590	0.208	0.192
WOEX 1206..	0.456	0.692	0.236	0.236



WOEX

	-01 BK8425	-03 BK8425	-13 BK8425	-01 BK7935	-01 BK6115
					
	WOEX	WOEX	WOEX	WOEX	WOEX
	10 821 ...	10 821 ...	10 821 ...	10 821 ...	10 821 ...
ISO	KOMET no.	RE inch								
030204	W29 10130.048425	0.016					30313			
030204	W29 10010.046115	0.016								40301
030204	W29 10010.047935	0.016						50301		
030204	W29 10030.048425	0.016		30303						
030204	W29 10010.048425	0.016	30301							
040304	W29 18130.048425	0.016					30413			
040304	W29 18010.046115	0.016								40401
040304	W29 18010.047935	0.016						50401		
040304	W29 18030.048425	0.016		30403						
040304	W29 18010.048425	0.016	30401							
05T304	W29 24130.048425	0.016					30513			
05T304	W29 24010.046115	0.016								40501
05T304	W29 24010.047935	0.016						50501		
05T304	W29 24030.048425	0.016		30503						
05T304	W29 24010.048425	0.016	30501							
06T304	W29 34130.048425	0.016					30613			
06T304	W29 34010.046115	0.016								40601
06T304	W29 34010.047935	0.016						50601		
06T304	W29 34030.048425	0.016		30603						
06T304	W29 34010.048425	0.016	30601							
080404	W29 42130.048425	0.016					30813			
080404	W29 42010.046115	0.016								40801
080404	W29 42010.048425	0.016	30801							
100504	W29 50130.048425	0.016					31013			
100504	W29 50010.046115	0.016								41001
100504	W29 50010.048425	0.016	31001							
100508	W29 50010.088425	0.031	39001							
120608	W29 58130.088425	0.031					38213			
120608	W29 58010.086115	0.031								41201
P			●	●	●	●	●			
M			●	●	●	●	●			
K			●	●	●	●	●			
N			○	○	○	○				
S						●				
H			○	○	○		○			
O										

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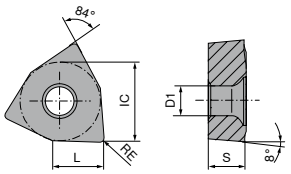
BK8425 -03 and BK6115 -01 are exclusively recommended for use on the peripheral cutting edge!

WOEX

Designation	L inch	IC inch	S inch	D1 inch
WOEX 0302..	0.125	0.196	0.090	0.090
WOEX 0403..	0.161	0.250	0.125	0.100
WOEX 05T3..	0.208	0.314	0.149	0.112
WOEX 06T3..	0.259	0.393	0.149	0.159
WOEX 0804..	0.311	0.472	0.188	0.194



WOEX

			-01 BK7615	-01 BK62	-11 BK77	-13 BK79
						
			WOEX	WOEX	WOEX	WOEX
			10 821 ...	**10 821 ...**	**10 821 ...**	**10 821 ...**
ISO	KOMET no.	RE inch				
030204	W29 10010.0462	0.016		**20301**		
030204	W29 10130.0479	0.016				**15313**
030204	W29 10110.0477	0.016			**80311**	
030204	W29 10010.047615	0.016	**05301**			
040304	W29 18010.0462	0.016		**20401**		
040304	W29 18130.0479	0.016				**15413**
040304	W29 18110.0477	0.016			**80411**	
040304	W29 18010.047615	0.016	**05401**			
05T304	W29 24010.0462	0.016		**20501**		
05T304	W29 24130.0479	0.016				**15513**
05T304	W29 24110.0477	0.016			**80511**	
05T304	W29 24010.047615	0.016	**05501**			
06T304	W29 34010.0462	0.016		**20601**		
06T304	W29 34130.0479	0.016				**15613**
06T304	W29 34110.0477	0.016			**80611**	
06T304	W29 34010.047615	0.016	**05601**			
080404	W29 42010.0462	0.016		**20801**		
080404	W29 42130.0479	0.016				**15813**
080404	W29 42110.0477	0.016			**80811**	
080404	W29 42010.047615	0.016	**05801**			
100504	W29 50010.0462	0.016		**21001**		
100504	W29 50130.0479	0.016				**16013**
100504	W29 50110.0477	0.016			**81011**	
100508	W29 50010.087615	0.031	**08001**			
120608	W29 58010.087615	0.031	**08201**			
120608	W29 58130.0879	0.031				**16213**
120608	W29 58010.0862	0.031		**28201**		
P						●
M						●
K			●	●		●
N						○
S					●	
H				○	○	
O					○	

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Material examples for cutting data tables

	Material sub-group	Index	Composition / Structure / Heat treatment		Tensile strength lbf/in²* / HB / HRC	Material number	Material designation	Material number	Material designation
P	Unalloyed steel	P.1.1	< 0.15 % C	Annealed	60900 lbf/in² / 125 HB	1.0401	1015	1.0301	1010
		P.1.2	< 0.45 % C	Annealed	92800 lbf/in² / 190 HB	1.1191	1045	1.0737	12L14
		P.1.3		Tempered	121800 lbf/in² / 250 HB	1.1191	1045	1.0503	1043
		P.1.4	< 0.75 % C	Annealed	132000 lbf/in² / 270 HB	1.1223	1060	1.0535	1055
		P.1.5		Tempered	146500 lbf/in² / 300 HB	1.1223	1060	1.1274	1095
	Low-alloy steel	P.2.1		Annealed	88500 lbf/in² / 180 HB	1.7131	5115	1.6523	8620
		P.2.2		Tempered	134900 lbf/in² / 275 HB	1.7131	5115	1.6582	4340
		P.2.3		Tempered	146500 lbf/in² / 300 HB	1.7225	4142	1.7131	5115
		P.2.4		Tempered	174000 lbf/in² / 375 HB	1.7225	4142	17223	4140
	High-alloy steel and high-alloy tool steel	P.3.1		Annealed	98600 lbf/in² / 200 HB	1.4021	420	1.2379	D2
		P.3.2		Hardened and tempered	159500 lbf/in² / 300 HB	1.2343	H11	1.3343	M2
		P.3.3		Hardened and tempered	188500 lbf/in² / 400 HB	1.2343	H11	1.2363	A2
	Stainless steel	P.4.1	Ferritic / martensitic	Annealed	98600 lbf/in² / 200 HB	1.4016	430	1.4125	440C
		P.4.2	Martensitic	Tempered	117500 lbf/in² / 250 HB	1.4112	S44003	1.4021	420
M	Stainless steel	M.1.1	Austenitic / austenitic-ferritic	Quenched	88500 lbf/in² / 200 HB	1.4301	304	1.4401	316
		M.2.1	Austenitic	Tempered	300 HB	1.4841	314	1.4568	17-7 PH
		M.3.1	Austenitic / ferritic (Duplex)		113100 lbf/in² / 230 HB	1.4462	S32205	1.4410	S32750
K	Grey cast iron	K.1.1	Pearlitic / ferritic		88500 lbf/in² / 180 HB	0.6010	A48-20B	0.6025	A48-40 B
		K.1.2	Pearlitic (martensitic)		127600 lbf/in² / 260 HB	0.6030	A48-45B	0.6040	A48-60 B
	Spherulitic graphite cast iron	K.2.1	Ferritic		78300 lbf/in² / 160 HB	0.7040	60-40-18	0.7050	65-45-12
		K.2.2	Pearlitic		122600 lbf/in² / 250 HB	0.7070	100-70-03	0.7660	A439 Type D2
	Malleable iron	K.3.1	Ferritic		63800 lbf/in² / 130 HB	0.8035	GTW-35-04		
		K.3.2	Pearlitic		113100 lbf/in² / 230 HB	0.8170	70003		
N	Aluminium wrought alloy	N.1.1	Non-hardenable		60 HB	3.0255	A91060	3.0255	A91060
		N.1.2	Hardenable		49300 lbf/in² / 100 HB	3.1355	2024	3.1355	2024
	Cast aluminium alloy	N.2.1	≤ 12 % Si, non-hardenable		36300 lbf/in² / 75 HB	3.2581	A04130 / A413-0	3.2581	A04130 / A413-0
		N.2.2	≤ 12 % Si, hardenable		43500 lbf/in² / 90 HB	3.2134	G-AlSi5Cu1Mg		
		N.2.3	> 12 % Si, non-hardenable		63800 lbf/in² / 130 HB		G-AlSi17Cu4Mg		
	Copper and copper alloys (bronze/brass)	N.3.1	Free-machining alloys, PB > 1 %		54400 lbf/in² / 110 HB	2.0380	CuZn39Pb2 (Ms58)	2.0380	C37700
		N.3.2	CuZn, CuSnZn		43500 lbf/in² / 90 HB	2.0331	CuZn15	2.0331	C34000
		N.3.3	CuSn, lead-free copper and electrolytic copper		49300 lbf/in² / 100 HB	2.0060	E-Cu57		
	Magnesium alloys	N.4.1	Magnesium and magnesium alloys		70 HB	3.5612	MgAl6Zn		
S	Heat-resistant alloys	S.1.1	Fe - basis	Annealed	98600 lbf/in² / 200 HB	1.4864	X12NiCrSi 36-16	1.4864	330
		S.1.2			137800 lbf/in² / 280 HB	1.4980	X6NiCrTiMoVB25-15-2	1.4980	S66286
		S.2.1	Ni or Co basis	Annealed	121800 lbf/in² / 250 HB	2.4856	Inconel 625	2.4812	Hastelloy C
		S.2.2			171100 lbf/in² / 350 HB	2.4952	Nimonic 80A	2.4668	Inconel 718
		S.2.3		Cast	156600 lbf/in² / 320 HB	2.4674	Nimocast PK24	2.4670	Nimocast 713
	Titanium alloys	S.3.1	Pure titanium		5800 lbf/in²	3.7025	Ti99,8		
		S.3.2	Alpha + beta alloys		152300 lbf/in²	3.7165	TiAl6V4		
		S.3.3	Beta alloys		203100 lbf/in² / 410 HB	Ti555.3	Ti-5Al-5V-5Mo-3Cr		
H	Hardened steel	H.1.1		Hardened and tempered	46-55 HRC				
		H.1.2		Hardened and tempered	56-60 HRC				
		H.1.3		Hardened and tempered	61-65 HRC				
		H.1.4		Hardened and tempered	66-70 HRC				
	Chilled iron	H.2.1		Cast	400 HB				
	Hardened cast iron	H.3.1		Hardened and tempered	55 HRC				
O	Non-metal materials	O.1.1	Plastics, duroplastic		≤ 21800 lbf/in²				
		O.1.2	Plastics, thermoplastic		≤ 14500 lbf/in²				
		O.2.1	Aramid fibre-reinforced		≤ 145000 lbf/in²				
		O.2.2	Glass/carbon-fibre reinforced		≤ 145000 lbf/in²				
		O.3.1	Graphite						

*** Tensile Strength at Rupture (Rm)**

Cutting data standard values for SOGX indexable inserts

	SOGX 10 820 ...						
Index	-01 / -13 / -32 BK8425	-03 BK8430	-34 BK8425	-01 BK7935	-01 BK6115	-01 BK6425	-01 BK7710
	v_c in ft/min						
P.1.1	**850**	**850**		**820**	**980**	**1050**	
P.1.2	**850**	**850**	850	**720**	**980**	**1050**	
P.1.3	**890**	**890**		**890**	**890**	**920**	
P.1.4	**820**	**820**		**820**	**820**	**820**	
P.1.5	**890**	**890**	890	**660**	**980**	**950**	
P.2.1	**890**	**890**		**890**	**890**	**920**	
P.2.2	**850**	**850**		**850**	**850**	**890**	
P.2.3	**590**	**590**	590	**520**	**790**	**850**	
P.2.4	**490**	**490**	490	**430**	**660**	**690**	
P.3.1	**520**	**520**	520	**460**	**660**	**720**	
P.3.2	**430**	**430**	430	**390**	**520**	**590**	
P.3.3	**390**	**390**	390	**360**	**460**	**520**	
P.4.1	**590**	**590**		**490**	**720**	**790**	
P.4.2	**430**	**430**		**390**	**520**	**590**	
M.1.1	**490**	**490**		**520**	**720**	**660**	
M.2.1	**490**	**490**		**520**	**720**	**660**	
M.3.1	**460**	**460**		**490**	**660**	**590**	
K.1.1	**520**	**520**	**520**	**490**	**790**	**660**	
K.1.2	**390**	**390**	**390**	**390**	**590**	**490**	
K.2.1	**520**	**520**	**520**	**490**	**520**	**520**	
K.2.2	**330**	**330**	**330**	**300**	**330**	**330**	
K.3.1	**390**	**390**	**390**	**360**	**390**	**390**	
K.3.2	**330**	**330**	**330**	**300**	**330**	**330**	
N.1.1	1310	1310		1310			**1640**
N.1.2	1310	1310		1310			**1640**
N.2.1	820	820		820			**920**
N.2.2	820	820		820			**920**
N.2.3	750	750		750			**820**
N.3.1	660	660		660			**820**
N.3.2	720	720		720			**920**
N.3.3	1080	1080		1080			**1280**
N.4.1	660	660		660			**820**
S.1.1	**200**	**200**		**200**			
S.1.2	**160**	**160**		**160**			
S.2.1	**200**	**200**		**200**			
S.2.2	**160**	**160**		**160**			
S.2.3	**100**	**100**		**100**			
S.3.1	**330**	**330**		**330**			330
S.3.2	**260**	**260**		**260**			260
S.3.3	**160**	**160**		**160**			160
H.1.1	330	330			330		
H.1.2	260	260			260		
H.1.3	160	160			160		
H.1.4							
H.2.1	330	330			330		
H.3.1	260	260			260		
O.1.1				330			330
O.1.2				330			330
O.2.1							
O.2.2				330			330
O.3.1				330			330

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	ABS / C 10 874 ... / 15 874 ...											
	Ø 0.562–0.625 inch	Ø 0.656–0.703 inch	Ø 0.750–0.781 inch	Ø 0.812–0.828 inch	Ø 0.875–0.937 inch	Ø 0.985–1.000 inch	Ø 1.031–1.062 inch	Ø 1.109–1.218 inch	Ø 1.250–1.328 inch	Ø 1.375–1.469 inch	Ø 1.500–1.687 inch	Ø 1.750 inch
	f in inch/rev.											
P.1.1	0.002	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
P.1.2	0.003	0.005	0.005	0.006	0.006	0.006	0.007	0.007	0.007	0.007	0.007	0.007
P.1.3	0.002	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
P.1.4	0.002	0.004	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
P.1.5	0.003	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
P.2.1	0.002	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
P.2.2	0.002	0.004	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
P.2.3	0.003	0.006	0.006	0.006	0.006	0.007	0.007	0.007	0.007	0.007	0.007	0.007
P.2.4	0.002	0.004	0.004	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006
P.3.1	0.003	0.005	0.005	0.006	0.006	0.007	0.007	0.007	0.007	0.007	0.007	0.007
P.3.2	0.002	0.004	0.004	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006
P.3.3	0.002	0.003	0.003	0.004	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005
P.4.1	0.004	0.005	0.005	0.007	0.007	0.008	0.008	0.008	0.008	0.008	0.008	0.008
P.4.2	0.002	0.004	0.004	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006
M.1.1	0.003	0.004	0.004	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
M.2.1	0.003	0.003	0.003	0.004	0.004	0.006	0.006	0.006	0.006	0.006	0.006	0.006
M.3.1	0.003	0.003	0.003	0.004	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005
K.1.1	0.005	0.006	0.006	0.007	0.007	0.009	0.010	0.010	0.010	0.010	0.010	0.010
K.1.2	0.004	0.004	0.004	0.004	0.004	0.008	0.008	0.008	0.008	0.008	0.008	0.008
K.2.1	0.005	0.006	0.006	0.007	0.007	0.009	0.010	0.010	0.010	0.010	0.010	0.010
K.2.2	0.004	0.005	0.005	0.006	0.006	0.007	0.008	0.008	0.008	0.008	0.008	0.008
K.3.1	0.005	0.006	0.006	0.007	0.007	0.009	0.010	0.010	0.010	0.010	0.010	0.010
K.3.2	0.004	0.005	0.005	0.006	0.006	0.007	0.008	0.008	0.008	0.008	0.008	0.008
N.1.1	0.004	0.004	0.004	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
N.1.2	0.004	0.004	0.004	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
N.2.1	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
N.2.2	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
N.2.3	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
N.3.1	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
N.3.2	0.004	0.005	0.006	0.006	0.007	0.007	0.007	0.007	0.007	0.007	0.007	0.007
N.3.3	0.004	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
N.4.1	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
S.1.1	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
S.1.2	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
S.2.1	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
S.2.2	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
S.2.3	0.001	0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002
S.3.1	0.002	0.002	0.002	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.004
S.3.2	0.002	0.002	0.002	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.004
S.3.3	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.1.1	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.1.2	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.1.3	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.1.4												
H.2.1	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.3.1	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
O.1.1	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
O.1.2	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
O.2.1												
O.2.2	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003
O.3.1	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004

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 – 5xD

Index	ABS / C 10 875 ... / 15 875 ... Ø 0.562–0.625 inch	Ø 0.656–0.703 inch	Ø 0.750–0.781 inch	Ø 0.812–0.828 inch	Ø 0.875–0.937 inch	Ø 0.985–1.000 inch	Ø 1.031–1.062 inch	Ø 1.109–1.218 inch	Ø 1.250–1.328 inch	Ø 1.375–1.469 inch	Ø 1.500–1.687 inch	Ø 1.750 inch
	f in inch/rev.											
P.1.1	0.002	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
P.1.2	0.003	0.004	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006
P.1.3	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
P.1.4	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
P.1.5	0.003	0.004	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006
P.2.1	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
P.2.2	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
P.2.3	0.003	0.004	0.004	0.006	0.007	0.007	0.006	0.006	0.006	0.006	0.006	0.006
P.2.4	0.002	0.003	0.003	0.005	0.006	0.006	0.005	0.005	0.005	0.005	0.005	0.005
P.3.1	0.003	0.005	0.005	0.006	0.006	0.007	0.007	0.007	0.007	0.007	0.007	0.007
P.3.2	0.002	0.004	0.004	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006
P.3.3	0.002	0.003	0.003	0.004	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005
P.4.1	0.004	0.005	0.005	0.007	0.007	0.008	0.008	0.008	0.008	0.008	0.008	0.008
P.4.2	0.002	0.004	0.004	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006
M.1.1	0.003	0.003	0.003	0.004	0.004	0.006	0.004	0.004	0.004	0.004	0.004	0.004
M.2.1	0.003	0.003	0.003	0.004	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005
M.3.1	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004
K.1.1	0.004	0.005	0.005	0.006	0.006	0.008	0.009	0.009	0.009	0.009	0.009	0.009
K.1.2	0.003	0.004	0.004	0.005	0.005	0.006	0.007	0.007	0.007	0.007	0.007	0.007
K.2.1	0.004	0.005	0.005	0.006	0.006	0.008	0.009	0.009	0.009	0.009	0.009	0.009
K.2.2	0.003	0.004	0.004	0.005	0.005	0.006	0.007	0.007	0.007	0.007	0.007	0.007
K.3.1	0.004	0.005	0.005	0.006	0.006	0.008	0.009	0.009	0.009	0.009	0.009	0.009
K.3.2	0.003	0.004	0.004	0.005	0.005	0.006	0.007	0.007	0.007	0.007	0.007	0.007
N.1.1	0.004	0.004	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
N.1.2	0.004	0.004	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
N.2.1	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
N.2.2	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
N.2.3	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
N.3.1	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
N.3.2	0.004	0.006	0.006	0.006	0.007	0.007	0.007	0.007	0.007	0.007	0.007	0.007
N.3.3	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
N.4.1	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
S.1.1	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
S.1.2	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
S.2.1	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
S.2.2	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
S.2.3	0.001	0.001	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002
S.3.1	0.002	0.002	0.002	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.004
S.3.2	0.002	0.002	0.002	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.004
S.3.3	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.1.1	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.1.2	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.1.3	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.1.4												
H.2.1	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.3.1	0.001	0.001	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
O.1.1	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
O.1.2	0.003	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
O.2.1												
O.2.2	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003
O.3.1	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004

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 SOEX indexable inserts

Index	SOEX 10 822 ...					
	BK8425	BK7935	BK6115	BK7710	BK6420	BK7615
	v_c in ft/min					
P.1.1	**850**	**820**	**980**		**980**	
P.1.2	**850**	**720**	**980**		**980**	
P.1.3	**890**	**890**	**890**		**890**	
P.1.4	**820**	**820**	**820**		**820**	
P.1.5	**890**	**660**	**980**		**890**	
P.2.1	**890**	**890**	**890**		**890**	
P.2.2	**850**	**850**	**850**		**850**	
P.2.3	**590**	**520**	**790**		**790**	
P.2.4	**490**	**430**	**660**		**620**	
P.3.1	**520**	**460**	**660**		**660**	
P.3.2	**430**	**390**	**520**		**520**	
P.3.3	**390**	**360**	**460**		**460**	
P.4.1	**590**	**490**	**720**		**720**	
P.4.2	**430**	**390**	**520**		**520**	
M.1.1	**490**	**520**	**720**		**720**	
M.2.1	**490**	**520**	**720**		**720**	
M.3.1	**460**	**490**	**660**		**660**	
K.1.1	**520**	**490**	**790**		660	**850**
K.1.2	**390**	**390**	**590**		490	**520**
K.2.1	**520**	**490**	**520**		520	**590**
K.2.2	**330**	**300**	**330**		330	**390**
K.3.1	**390**	**360**	**390**		390	**460**
K.3.2	**330**	**300**	**330**		330	**390**
N.1.1	1310	1310		**1640**		
N.1.2	1310	1310		**1640**		
N.2.1	820	820		**920**		
N.2.2	820	820		**920**		
N.2.3	750	750		**820**		
N.3.1	660	660		**820**		
N.3.2	720	720		**920**		
N.3.3	1080	1080		**1280**		
N.4.1	660	660		**820**		
S.1.1	**200**	**200**				
S.1.2	**160**	**160**				
S.2.1	**200**	**200**				
S.2.2	**160**	**160**				
S.2.3	**100**	**100**				
S.3.1	**330**	**330**		330		
S.3.2	**260**	**260**		260		
S.3.3	**160**	**160**		160		
H.1.1	330		330			
H.1.2	260		260			
H.1.3	160		160			
H.1.4						
H.2.1	330		330			
H.3.1	260		260			
O.1.1		330		330		
O.1.2		330		330		
O.2.1						
O.2.2		330		330		
O.3.1		330		330		

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 Quatron – 2xD, 3xD

Index	ABS / C 10 879 ... / 15 879 ... / 10 880 ... / 15 880 ...									
	Ø 0.562–0.656 inch	Ø 0.687–0.781 inch	Ø 0.812–0.968 inch	Ø 0.985–1.156 inch	Ø1.187–1.437 inch	Ø1.469–1.562 inch	Ø1.625–1.750 inch	Ø1.781–1.812 inch	Ø1.875–2.062 inch	Ø2.125–2.500 inch
	f in inch/rev.									
P.1.1	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
P.1.2	0.006	0.006	0.007	0.010	0.012	0.012	0.010	0.010	0.010	0.010
P.1.3	0.005	0.006	0.008	0.008	0.010	0.010	0.008	0.008	0.008	0.008
P.1.4	0.004	0.005	0.007	0.007	0.009	0.009	0.007	0.007	0.007	0.007
P.1.5	0.005	0.006	0.007	0.009	0.011	0.011	0.009	0.009	0.009	0.009
P.2.1	0.005	0.006	0.008	0.008	0.010	0.010	0.008	0.008	0.008	0.008
P.2.2	0.004	0.005	0.007	0.007	0.009	0.009	0.007	0.007	0.007	0.007
P.2.3	0.006	0.006	0.008	0.008	0.010	0.010	0.008	0.008	0.008	0.008
P.2.4	0.005	0.006	0.007	0.007	0.009	0.009	0.007	0.007	0.007	0.007
P.3.1	0.004	0.005	0.005	0.007	0.008	0.008	0.007	0.007	0.007	0.007
P.3.2	0.003	0.004	0.004	0.006	0.007	0.007	0.006	0.006	0.006	0.006
P.3.3	0.007	0.004	0.004	0.006	0.006	0.006	0.006	0.006	0.006	0.006
P.4.1	0.004	0.005	0.005	0.008	0.009	0.009	0.008	0.008	0.008	0.008
P.4.2	0.003	0.004	0.004	0.006	0.007	0.007	0.006	0.006	0.006	0.006
M.1.1	0.003	0.003	0.005	0.006	0.007	0.007	0.006	0.006	0.006	0.006
M.2.1	0.002	0.003	0.005	0.005	0.006	0.005	0.005	0.005	0.005	0.005
M.3.1	0.002	0.003	0.004	0.004	0.005	0.004	0.004	0.004	0.004	0.004
K.1.1	0.006	0.006	0.010	0.012	0.012	0.012	0.012	0.012	0.012	0.012
K.1.2	0.005	0.005	0.008	0.010	0.010	0.010	0.010	0.010	0.010	0.010
K.2.1	0.006	0.006	0.008	0.008	0.010	0.010	0.008	0.008	0.008	0.008
K.2.2	0.005	0.006	0.008	0.008	0.009	0.009	0.008	0.008	0.008	0.008
K.3.1	0.006	0.006	0.009	0.009	0.010	0.010	0.009	0.009	0.009	0.009
K.3.2	0.005	0.006	0.008	0.008	0.009	0.009	0.008	0.008	0.008	0.008
N.1.1	0.003	0.003	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005
N.1.2	0.003	0.003	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005
N.2.1	0.004	0.005	0.006	0.006	0.008	0.008	0.006	0.006	0.006	0.006
N.2.2	0.004	0.005	0.006	0.006	0.008	0.008	0.006	0.006	0.006	0.006
N.2.3	0.004	0.004	0.006	0.006	0.007	0.007	0.006	0.006	0.006	0.006
N.3.1	0.005	0.006	0.010	0.010	0.010	0.010	0.010	0.010	0.008	0.008
N.3.2	0.005	0.006	0.010	0.010	0.010	0.010	0.010	0.010	0.009	0.009
N.3.3	0.003	0.003	0.004	0.005	0.006	0.006	0.005	0.005	0.005	0.005
N.4.1	0.005	0.006	0.010	0.010	0.010	0.010	0.010	0.010	0.008	0.008
S.1.1	0.002	0.003	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005
S.1.2	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004
S.2.1	0.002	0.003	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005
S.2.2	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004
S.2.3	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
S.3.1	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
S.3.2	0.002	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004
S.3.3	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.1.1	0.002	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
H.1.2	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003
H.1.3	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.1.4										
H.2.1	0.002	0.002	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
H.3.1	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003
O.1.1	0.003	0.003	0.004	0.005	0.006	0.006	0.005	0.005	0.005	0.005
O.1.2	0.003	0.003	0.004	0.005	0.006	0.006	0.005	0.005	0.005	0.005
O.2.1										
O.2.2	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
O.3.1	0.003	0.003	0.004	0.005	0.006	0.006	0.005	0.005	0.005	0.005

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 WOEX indexable inserts

Index	WOEX 10 821 ...						
	BK8425	BK7935	BK6115	BK7615	BK62	BK77	BK79
	v_c in ft/min						
P.1.1	**850**	**820**	**980**				**850**
P.1.2	**850**	**720**	**980**				**850**
P.1.3	**890**	**890**	**890**				**890**
P.1.4	**790**	**790**	**820**				**790**
P.1.5	**750**	**660**	**890**				**750**
P.2.1	**890**	**890**	**890**				**890**
P.2.2	**850**	**850**	**850**				**850**
P.2.3	**590**	**520**	**790**				**590**
P.2.4	**490**	**430**	**620**				**490**
P.3.1	**520**	**460**	**660**				**520**
P.3.2	**430**	**360**	**520**				**430**
P.3.3	**390**	**330**	**460**				**390**
P.4.1	**590**	**520**	**720**				**590**
P.4.2	**430**	**360**	**520**				**430**
M.1.1	**490**	**520**	**720**				**490**
M.2.1	**490**	**520**	**720**				**490**
M.3.1	**430**	**490**	**660**				**430**
K.1.1	**520**	**490**	**790**	**850**	**790**		**520**
K.1.2	**390**	**360**	**460**	**520**	**460**		**390**
K.2.1	**520**	**490**	**520**	**590**	**520**		**520**
K.2.2	**330**	**300**	**330**	**390**	**330**		**330**
K.3.1	**390**	**360**	**390**	**460**	**390**		**390**
K.3.2	**330**	**300**	**330**	**390**	**330**		**330**
N.1.1	1310	1310					1310
N.1.2	1310	1310					1310
N.2.1	820	820					820
N.2.2	820	820					820
N.2.3	750	750					750
N.3.1	660	660					660
N.3.2	720	720					720
N.3.3	1080	1080					1080
N.4.1	660	660					660
S.1.1		**160**				**160**	
S.1.2		**130**				**130**	
S.2.1		**160**				**160**	
S.2.2		**130**				**130**	
S.2.3		**100**				**100**	
S.3.1		**230**				**230**	
S.3.2		**200**				**200**	
S.3.3		**130**				**130**	
H.1.1	330		330		330	130	
H.1.2	260		260		260	100	
H.1.3	160		160		160	70	
H.1.4							
H.2.1	330		330		330	130	
H.3.1	260		260		260	100	
O.1.1						330	
O.1.2						330	
O.2.1							
O.2.2						330	
O.3.1						330	

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 Trigon – 2xD

	ABS 15 892 ...												
Index	Ø 0.562–0.625 inch	Ø 0.687–0.781 inch	Ø 0.812–0.937 inch	Ø 0.985–1.156 inch	Ø 1.187–1.437 inch	Ø 1.469–1.562 inch	Ø 1.625–1.750 inch	Ø 1.781–1.812 inch	Ø 1.875–2.062 inch	Ø 2.125–2.500 inch	Ø 2.593–2.656 inch	Ø 2.750–2.875 inch	Ø 3.000–3.250 inch
	f in inch/rev.												
P.1.1	0.003	0.004	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
P.1.2	0.003	0.004	0.005	0.006	0.006	0.006	0.007	0.008	0.008	0.010	0.010	0.010	0.010
P.1.3	0.002	0.003	0.005	0.006	0.006	0.006	0.006	0.006	0.007	0.008	0.010	0.010	0.010
P.1.4	0.002	0.003	0.004	0.005	0.005	0.005	0.006	0.005	0.006	0.007	0.009	0.009	0.009
P.1.5	0.003	0.004	0.004	0.005	0.006	0.006	0.006	0.007	0.008	0.009	0.009	0.009	0.009
P.2.1	0.002	0.003	0.005	0.006	0.006	0.006	0.006	0.006	0.007	0.008	0.010	0.010	0.010
P.2.2	0.002	0.003	0.004	0.005	0.005	0.005	0.006	0.005	0.006	0.007	0.009	0.009	0.009
P.2.3	0.002	0.003	0.004	0.006	0.006	0.006	0.006	0.006	0.006	0.007	0.008	0.008	0.008
P.2.4	0.002	0.002	0.003	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.007	0.007	0.007
P.3.1	0.002	0.003	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006
P.3.2	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.005	0.006	0.006	0.006	0.006	0.006
P.3.3	0.002	0.002	0.003	0.003	0.003	0.003	0.004	0.004	0.005	0.005	0.005	0.005	0.005
P.4.1	0.003	0.004	0.004	0.005	0.005	0.005	0.006	0.006	0.007	0.007	0.007	0.007	0.007
P.4.2	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.005	0.006	0.006	0.006	0.006	0.006
M.1.1	0.002	0.002	0.003	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006
M.2.1	0.002	0.002	0.003	0.005	0.005	0.005	0.005	0.005	0.005	0.006	0.006	0.006	0.006
M.3.1	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.006	0.006	0.006	0.006
K.1.1	0.004	0.005	0.006	0.008	0.008	0.008	0.010	0.010	0.010	0.012	0.012	0.012	0.012
K.1.2	0.003	0.003	0.004	0.006	0.006	0.006	0.007	0.007	0.007	0.008	0.010	0.010	0.010
K.2.1	0.003	0.004	0.006	0.008	0.008	0.008	0.010	0.010	0.010	0.012	0.012	0.012	0.012
K.2.2	0.003	0.004	0.005	0.008	0.005	0.005	0.006	0.009	0.009	0.010	0.010	0.010	0.010
K.3.1	0.004	0.005	0.006	0.010	0.006	0.006	0.007	0.010	0.010	0.012	0.012	0.012	0.012
K.3.2	0.003	0.004	0.005	0.008	0.005	0.005	0.006	0.009	0.009	0.010	0.010	0.010	0.010
N.1.1	0.002	0.003	0.003	0.004	0.004	0.005	0.005	0.005	0.005	0.006	0.006	0.006	0.006
N.1.2	0.002	0.003	0.003	0.004	0.004	0.005	0.005	0.005	0.005	0.006	0.006	0.006	0.006
N.2.1	0.004	0.005	0.006	0.007	0.007	0.008	0.008	0.007	0.008	0.008	0.008	0.008	0.008
N.2.2	0.004	0.005	0.006	0.007	0.007	0.008	0.008	0.007	0.008	0.008	0.008	0.008	0.008
N.2.3	0.004	0.004	0.005	0.006	0.006	0.007	0.007	0.006	0.007	0.007	0.007	0.007	0.007
N.3.1	0.002	0.003	0.005	0.006	0.006	0.007	0.008	0.008	0.008	0.010	0.010	0.010	0.010
N.3.2	0.002	0.004	0.005	0.007	0.007	0.008	0.009	0.009	0.009	0.010	0.010	0.010	0.010
N.3.3	0.002	0.003	0.003	0.004	0.004	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006
N.4.1	0.002	0.003	0.005	0.006	0.006	0.007	0.008	0.008	0.008	0.010	0.010	0.010	0.010
S.1.1	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.005	0.005	0.005	0.005
S.1.2	0.001	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004
S.2.1	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.005	0.005	0.005	0.005
S.2.2	0.001	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004
S.2.3	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
S.3.1	0.003	0.004	0.004	0.005	0.004	0.005	0.005	0.004	0.004	0.005	0.005	0.006	0.006
S.3.2	0.002	0.003	0.004	0.005	0.004	0.005	0.005	0.004	0.004	0.005	0.005	0.006	0.006
S.3.3	0.002	0.002	0.002	0.003	0.002	0.003	0.003	0.002	0.002	0.003	0.003	0.003	0.003
H.1.1	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003
H.1.2	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003
H.1.3	0.002	0.002	0.002	0.002	0.002	0.002	0.002						
H.1.4													
H.2.1	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.3.1	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
O.1.1	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
O.1.2	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
O.2.1													
O.2.2	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003
O.3.1	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004

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 Trigon – 2.5xD

	C 15 896 ...									
Index	Ø 0.562–0.625 inch	Ø 0.687–0.781 inch	Ø 0.812–0.937 inch	Ø 0.985–1.156 inch	Ø 1.187–1.437 inch	Ø 1.469–1.562 inch	Ø 1.625–1.750 inch	Ø 1.812–2.000 inch	Ø 2.125–2.500 inch	Ø 2.750–3.250 inch
	f in inch/rev.									
P.1.1	0.003	0.004	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005
P.1.2	0.003	0.004	0.005	0.006	0.006	0.006	0.007	0.008	0.010	0.010
P.1.3	0.002	0.003	0.005	0.006	0.006	0.006	0.006	0.007	0.008	0.010
P.1.4	0.002	0.003	0.004	0.005	0.005	0.005	0.006	0.006	0.007	0.009
P.1.5	0.003	0.004	0.004	0.005	0.006	0.006	0.006	0.008	0.009	0.009
P.2.1	0.002	0.003	0.005	0.006	0.006	0.006	0.006	0.007	0.008	0.010
P.2.2	0.002	0.003	0.004	0.005	0.005	0.005	0.006	0.006	0.007	0.009
P.2.3	0.002	0.003	0.004	0.006	0.006	0.006	0.006	0.006	0.007	0.008
P.2.4	0.002	0.002	0.003	0.004	0.005	0.005	0.005	0.006	0.006	0.007
P.3.1	0.002	0.003	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006
P.3.2	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.006	0.006	0.006
P.3.3	0.002	0.002	0.003	0.003	0.003	0.003	0.004	0.005	0.005	0.005
P.4.1	0.003	0.004	0.004	0.005	0.005	0.005	0.006	0.007	0.007	0.007
P.4.2	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.006	0.006	0.006
M.1.1	0.002	0.002	0.003	0.005	0.005	0.005	0.006	0.006	0.006	0.006
M.2.1	0.002	0.002	0.003	0.005	0.005	0.005	0.005	0.005	0.006	0.006
M.3.1	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.006	0.006
K.1.1	0.004	0.005	0.006	0.008	0.008	0.008	0.010	0.010	0.012	0.012
K.1.2	0.003	0.003	0.004	0.006	0.006	0.006	0.007	0.007	0.008	0.010
K.2.1	0.003	0.004	0.006	0.008	0.008	0.008	0.010	0.010	0.012	0.012
K.2.2	0.003	0.004	0.005	0.008	0.005	0.005	0.006	0.009	0.010	0.010
K.3.1	0.004	0.005	0.006	0.010	0.006	0.006	0.007	0.010	0.012	0.012
K.3.2	0.003	0.004	0.005	0.008	0.005	0.005	0.006	0.009	0.010	0.010
N.1.1	0.002	0.003	0.003	0.004	0.004	0.005	0.005	0.005	0.006	0.006
N.1.2	0.002	0.003	0.003	0.004	0.004	0.005	0.005	0.005	0.006	0.006
N.2.1	0.004	0.005	0.006	0.007	0.007	0.008	0.008	0.008	0.008	0.008
N.2.2	0.004	0.005	0.006	0.007	0.007	0.008	0.008	0.008	0.008	0.008
N.2.3	0.004	0.004	0.005	0.006	0.006	0.007	0.007	0.007	0.007	0.007
N.3.1	0.002	0.003	0.005	0.006	0.006	0.007	0.008	0.008	0.010	0.010
N.3.2	0.002	0.004	0.005	0.007	0.007	0.008	0.009	0.009	0.010	0.010
N.3.3	0.002	0.003	0.003	0.004	0.004	0.004	0.005	0.005	0.006	0.006
N.4.1	0.002	0.003	0.005	0.006	0.006	0.007	0.008	0.008	0.010	0.010
S.1.1	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.005	0.005
S.1.2	0.001	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.004	0.004
S.2.1	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.005	0.005
S.2.2	0.001	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.004	0.004
S.2.3	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
S.3.1	0.003	0.004	0.004	0.005	0.004	0.005	0.005	0.004	0.005	0.006
S.3.2	0.002	0.003	0.004	0.005	0.004	0.005	0.005	0.004	0.005	0.006
S.3.3	0.002	0.002	0.002	0.003	0.002	0.003	0.003	0.002	0.003	0.003
H.1.1	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003	0.003	0.003
H.1.2	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.003
H.1.3	0.002	0.002	0.002	0.002	0.002	0.002	0.002			
H.1.4										
H.2.1	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
H.3.1	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
O.1.1	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
O.1.2	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
O.2.1										
O.2.2	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.003
O.3.1	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004

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 Trigon – 3xD

	ABS 10 893 ... / 15 893 ...												
Index	Ø 0.562–0.656 inch	Ø 0.687–0.781 inch	Ø 0.812–0.937 inch	Ø 0.985–1.156 inch	Ø1.187–1.437 inch	Ø1.469–1.562 inch	Ø1.625–1.750 inch	Ø1.781–1.812 inch	Ø1.875–2.062 inch	Ø2.125–2.500 inch	Ø2.593–2.656 inch	Ø2.750–2.875 inch	Ø3.000–3.250 inch
	f in inch/rev.												
P.1.1	0.003	0.004	0.004	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005
P.1.2	0.003	0.004	0.005	0.006	0.006	0.006	0.008	0.008	0.008	0.010	0.010	0.010	0.010
P.1.3	0.002	0.003	0.005	0.006	0.006	0.006	0.006	0.006	0.007	0.008	0.010	0.010	0.010
P.1.4	0.002	0.003	0.004	0.005	0.005	0.005	0.006	0.005	0.006	0.007	0.009	0.009	0.009
P.1.5	0.003	0.004	0.004	0.005	0.006	0.006	0.007	0.007	0.008	0.009	0.009	0.009	0.009
P.2.1	0.002	0.003	0.005	0.006	0.006	0.006	0.006	0.006	0.007	0.008	0.010	0.010	0.010
P.2.2	0.002	0.003	0.004	0.005	0.005	0.005	0.006	0.005	0.006	0.007	0.009	0.009	0.009
P.2.3	0.002	0.003	0.004	0.006	0.006	0.006	0.006	0.006	0.006	0.007	0.008	0.008	0.008
P.2.4	0.002	0.002	0.003	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.007	0.007	0.007
P.3.1	0.002	0.003	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006
P.3.2	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.005	0.006	0.006	0.006	0.006	0.006
P.3.3	0.002	0.002	0.003	0.003	0.003	0.003	0.004	0.004	0.005	0.005	0.005	0.005	0.005
P.4.1	0.003	0.004	0.004	0.005	0.005	0.005	0.006	0.006	0.007	0.007	0.007	0.007	0.007
P.4.2	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.005	0.006	0.006	0.006	0.006	0.006
M.1.1	0.002	0.002	0.003	0.005	0.005	0.005	0.006	0.006	0.006	0.006	0.006	0.006	0.006
M.2.1	0.002	0.002	0.003	0.005	0.005	0.005	0.005	0.005	0.005	0.006	0.006	0.006	0.006
M.3.1	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.006	0.006	0.006	0.006
K.1.1	0.004	0.005	0.006	0.008	0.008	0.008	0.010	0.010	0.010	0.012	0.012	0.012	0.012
K.1.2	0.003	0.003	0.004	0.006	0.006	0.006	0.007	0.007	0.007	0.008	0.010	0.010	0.010
K.2.1	0.003	0.004	0.006	0.008	0.008	0.008	0.010	0.010	0.010	0.012	0.012	0.012	0.012
K.2.2	0.003	0.004	0.005	0.008	0.008	0.008	0.008	0.009	0.009	0.010	0.010	0.010	0.010
K.3.1	0.004	0.005	0.006	0.010	0.010	0.010	0.010	0.010	0.010	0.012	0.012	0.012	0.012
K.3.2	0.003	0.004	0.005	0.008	0.008	0.008	0.008	0.009	0.009	0.010	0.010	0.010	0.010
N.1.1	0.002	0.003	0.003	0.004	0.004	0.005	0.005	0.005	0.005	0.006	0.006	0.006	0.006
N.1.2	0.002	0.003	0.003	0.004	0.004	0.005	0.005	0.005	0.005	0.006	0.006	0.006	0.006
N.2.1	0.004	0.005	0.006	0.007	0.007	0.008	0.008	0.007	0.008	0.008	0.008	0.008	0.008
N.2.2	0.004	0.005	0.006	0.007	0.007	0.008	0.008	0.007	0.008	0.008	0.008	0.008	0.008
N.2.3	0.004	0.004	0.005	0.006	0.006	0.007	0.007	0.006	0.007	0.007	0.007	0.007	0.007
N.3.1	0.002	0.003	0.005	0.006	0.006	0.007	0.008	0.008	0.008	0.010	0.010	0.010	0.010
N.3.2	0.002	0.004	0.005	0.007	0.007	0.008	0.009	0.009	0.009	0.010	0.010	0.010	0.010
N.3.3	0.002	0.004	0.004	0.004	0.004	0.004	0.005	0.005	0.005	0.006	0.006	0.006	0.006
N.4.1	0.002	0.003	0.005	0.006	0.006	0.007	0.008	0.008	0.008	0.010	0.010	0.010	0.010
S.1.1	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.005	0.005	0.005	0.005
S.1.2	0.001	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004
S.2.1	0.002	0.002	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.005	0.005	0.005	0.005
S.2.2	0.001	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.004	0.004	0.004	0.004
S.2.3	0.001	0.001	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002	0.002
S.3.1	0.003	0.004	0.004	0.005	0.004	0.005	0.005	0.004	0.004	0.005	0.005	0.006	0.006
S.3.2	0.002	0.003	0.004	0.005	0.004	0.005	0.005	0.004	0.004	0.005	0.005	0.006	0.006
S.3.3	0.002	0.002	0.002	0.003	0.002	0.003	0.003	0.002	0.002	0.003	0.003	0.003	0.003
H.1.1	0.002	0.003	0.003	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003
H.1.2	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.003	0.003
H.1.3	0.001	0.002	0.002	0.002	0.002	0.002	0.002						
H.1.4													
H.2.1	0.002	0.003	0.003	0.004	0.004	0.004	0.004	0.002	0.002	0.002	0.002	0.002	0.002
H.3.1	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.002	0.002	0.002	0.002	0.002	0.002
O.1.1	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
O.1.2	0.003	0.003	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004
O.2.1													
O.2.2	0.002	0.002	0.002	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003
O.3.1	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004

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 Trigon – 4xD

Index	ABS 10 894 ... / 15 894 ...						
	Ø 0.562–0.656 inch	Ø 0.687–0.781 inch	Ø 0.812–0.937 inch	Ø 0.985–1.156 inch	Ø1.187–1.437 inch	Ø1.469–1.562 inch	Ø1.625–1.750 inch
	f in inch/rev.						
P.1.1	0.002	0.003	0.003	0.004	0.004	0.004	0.004
P.1.2	0.002	0.003	0.004	0.005	0.006	0.006	0.007
P.1.3	0.002	0.002	0.004	0.005	0.005	0.005	0.006
P.1.4	0.002	0.002	0.004	0.004	0.004	0.004	0.005
P.1.5	0.002	0.003	0.004	0.004	0.005	0.005	0.006
P.2.1	0.002	0.002	0.004	0.005	0.005	0.005	0.006
P.2.2	0.002	0.002	0.004	0.004	0.004	0.004	0.005
P.2.3	0.002	0.002	0.003	0.005	0.006	0.006	0.006
P.2.4	0.001	0.002	0.002	0.004	0.004	0.004	0.004
P.3.1	0.002	0.002	0.003	0.004	0.004	0.004	0.005
P.3.2	0.001	0.002	0.002	0.003	0.003	0.003	0.004
P.3.3	0.001	0.002	0.002	0.003	0.003	0.003	0.003
P.4.1	0.002	0.003	0.004	0.004	0.004	0.004	0.005
P.4.2	0.001	0.002	0.002	0.003	0.003	0.003	0.004
M.1.1	0.002	0.002	0.002	0.004	0.004	0.004	0.005
M.2.1	0.002	0.002	0.002	0.004	0.004	0.004	0.004
M.3.1	0.002	0.002	0.002	0.004	0.004	0.004	0.004
K.1.1	0.003	0.004	0.005	0.007	0.007	0.007	0.009
K.1.2	0.002	0.002	0.003	0.005	0.005	0.006	0.006
K.2.1	0.002	0.003	0.005	0.007	0.007	0.007	0.009
K.2.2	0.002	0.003	0.004	0.007	0.007	0.007	0.007
K.3.1	0.003	0.004	0.006	0.009	0.009	0.009	0.009
K.3.2	0.002	0.003	0.004	0.007	0.007	0.007	0.007
N.1.1	0.001	0.002	0.002	0.003	0.003	0.004	0.004
N.1.2	0.001	0.002	0.002	0.003	0.003	0.004	0.004
N.2.1	0.003	0.004	0.005	0.006	0.006	0.007	0.007
N.2.2	0.003	0.004	0.005	0.006	0.006	0.007	0.007
N.2.3	0.003	0.004	0.004	0.006	0.006	0.006	0.006
N.3.1	0.001	0.002	0.004	0.006	0.006	0.006	0.007
N.3.2	0.001	0.003	0.004	0.006	0.006	0.007	0.008
N.3.3	0.001	0.002	0.002	0.003	0.003	0.003	0.004
N.4.1	0.001	0.002	0.004	0.006	0.006	0.006	0.007
S.1.1	0.001	0.002	0.002	0.003	0.003	0.003	0.003
S.1.2	0.001	0.001	0.002	0.002	0.002	0.002	0.002
S.2.1	0.001	0.002	0.002	0.003	0.003	0.003	0.003
S.2.2	0.001	0.001	0.002	0.002	0.002	0.002	0.002
S.2.3	0.000	0.001	0.001	0.002	0.002	0.002	0.002
S.3.1	0.002	0.003	0.004	0.004	0.004	0.004	0.004
S.3.2	0.002	0.002	0.003	0.004	0.003	0.004	0.004
S.3.3	0.001	0.002	0.002	0.002	0.002	0.002	0.002
H.1.1	0.001	0.002	0.002	0.003	0.003	0.003	0.003
H.1.2	0.001	0.002	0.002	0.002	0.002	0.002	0.002
H.1.3	0.001	0.001	0.001	0.002	0.002	0.002	0.002
H.1.4							
H.2.1	0.001	0.002	0.002	0.003	0.003	0.003	0.003
H.3.1	0.001	0.002	0.002	0.002	0.002	0.002	0.002
O.1.1	0.003	0.003	0.004	0.004	0.004	0.004	0.004
O.1.2	0.003	0.003	0.004	0.004	0.004	0.004	0.004
O.2.1							
O.2.2	0.002	0.002	0.002	0.003	0.003	0.003	0.003
O.3.1	0.004	0.004	0.004	0.004	0.004	0.004	0.004

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 Trigon – 4xD

	C 15 894 ...						
Index	Ø 0.562–0.656 inch	Ø 0.687–0.781 inch	Ø 0.812–0.937 inch	Ø 0.985–1.156 inch	Ø1.187–1.437 inch	Ø1.469–1.562 inch	Ø1.625–1.750 inch
	f in inch/rev.						
P.1.1	0.002	0.003	0.003	0.004	0.004	0.004	0.004
P.1.2	0.002	0.003	0.004	0.005	0.006	0.006	0.007
P.1.3	0.002	0.002	0.004	0.005	0.005	0.005	0.006
P.1.4	0.002	0.002	0.004	0.004	0.004	0.004	0.005
P.1.5	0.002	0.003	0.004	0.004	0.005	0.005	0.006
P.2.1	0.002	0.002	0.004	0.005	0.005	0.005	0.006
P.2.2	0.002	0.002	0.004	0.004	0.004	0.004	0.005
P.2.3	0.002	0.002	0.003	0.005	0.006	0.006	0.006
P.2.4	0.001	0.002	0.002	0.004	0.004	0.004	0.004
P.3.1	0.002	0.002	0.003	0.004	0.004	0.004	0.005
P.3.2	0.001	0.002	0.002	0.003	0.004	0.003	0.004
P.3.3	0.001	0.002	0.002	0.003	0.003	0.003	0.003
P.4.1	0.002	0.003	0.004	0.004	0.005	0.004	0.005
P.4.2	0.001	0.002	0.002	0.003	0.004	0.003	0.004
M.1.1	0.002	0.002	0.002	0.004	0.004	0.004	0.005
M.2.1	0.002	0.002	0.002	0.004	0.004	0.004	0.004
M.3.1	0.002	0.002	0.002	0.004	0.004	0.004	0.004
K.1.1	0.003	0.004	0.005	0.007	0.007	0.007	0.009
K.1.2	0.002	0.002	0.003	0.005	0.005	0.006	0.006
K.2.1	0.002	0.003	0.005	0.007	0.007	0.007	0.009
K.2.2	0.002	0.003	0.004	0.007	0.007	0.007	0.007
K.3.1	0.003	0.004	0.006	0.009	0.009	0.009	0.009
K.3.2	0.002	0.003	0.004	0.007	0.007	0.007	0.007
N.1.1	0.001	0.002	0.002	0.003	0.004	0.004	0.004
N.1.2	0.001	0.002	0.002	0.003	0.004	0.004	0.004
N.2.1	0.003	0.004	0.005	0.006	0.007	0.007	0.007
N.2.2	0.003	0.004	0.005	0.006	0.007	0.007	0.007
N.2.3	0.003	0.004	0.004	0.006	0.006	0.006	0.006
N.3.1	0.002	0.002	0.004	0.006	0.006	0.006	0.007
N.3.2	0.002	0.003	0.004	0.006	0.007	0.007	0.008
N.3.3	0.001	0.003	0.003	0.004	0.004	0.003	0.004
N.4.1	0.002	0.002	0.004	0.006	0.006	0.006	0.007
S.1.1	0.001	0.002	0.003	0.003	0.004	0.003	0.003
S.1.2	0.001	0.002	0.002	0.002	0.003	0.002	0.002
S.2.1	0.001	0.002	0.003	0.003	0.004	0.003	0.003
S.2.2	0.001	0.002	0.002	0.002	0.003	0.002	0.002
S.2.3	0.001	0.001	0.002	0.002	0.002	0.002	0.002
S.3.1	0.002	0.003	0.004	0.004	0.004	0.004	0.004
S.3.2	0.002	0.002	0.003	0.004	0.004	0.004	0.004
S.3.3	0.001	0.002	0.002	0.002	0.002	0.002	0.002
H.1.1	0.001	0.002	0.002	0.003	0.003	0.003	0.003
H.1.2	0.001	0.002	0.002	0.002	0.002	0.002	0.002
H.1.3	0.001	0.001	0.001	0.002	0.002	0.002	0.002
H.1.4							
H.2.1	0.001	0.002	0.002	0.003	0.003	0.003	0.003
H.3.1	0.001	0.002	0.002	0.002	0.002	0.002	0.002
O.1.1	0.003	0.003	0.004	0.004	0.004	0.004	0.004
O.1.2	0.003	0.003	0.004	0.004	0.004	0.004	0.004
O.2.1							
O.2.2	0.002	0.002	0.002	0.003	0.003	0.003	0.003
O.3.1	0.004	0.004	0.004	0.004	0.004	0.004	0.004

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 Centron

Index	Drill head diameter											
	Ø 0.812–1.000 inch				Ø 1.125–1.250 inch				Ø 1.375–1.750 inch			
	f	Centering tip v_c			f	Centering tip v_c			f	Centering tip v_c		
	inch/rev.	10 863 ... (TiN/TiAlN)	10 862 ... (TiN)	10 862 ... (TiAlN)	inch/rev.	10 863 ... (TiN/TiAlN)	10 862 ... (TiN)	10 862 ... (TiAlN)	inch/rev.	10 863 ... (TiN/TiAlN)	10 862 ... (TiN)	10 862 ... (TiAlN)
P.1.1	0.003	820	520		0.003	820	520		0.004	820	520	
P.1.2	0.005	820	520		0.006	820	520		0.006	820	520	
P.1.3	0.004	660	520		0.005	660	520		0.005	660	520	
P.1.4	0.004	590	520		0.004	590	520		0.004	590	520	
P.1.5	0.004	750	520		0.005	750	520		0.005	750	520	
P.2.1	0.004	660	520		0.005	660	520		0.005	660	520	
P.2.2	0.004	620	490		0.004	620	490		0.004	620	490	
P.2.3	0.005	590	460		0.006	590	460		0.006	590	460	
P.2.4	0.004	490	390		0.005	490	390		0.005	490	390	
P.3.1	0.003	520	390		0.004	520	390		0.004	520	390	
P.3.2	0.002	460	330		0.003	460	330		0.003	460	330	
P.3.3	0.003	430	300		0.003	430	300		0.003	430	300	
P.4.1	0.004	590	430		0.004	590	430		0.004	590	430	
P.4.2	0.002	460	330		0.003	460	330		0.003	460	330	
M.1.1	0.004	520		230	0.005	520		230	0.005	520		230
M.2.1	0.003	390		230	0.004	390		230	0.004	390		230
M.3.1	0.003	360		200	0.003	360		200	0.003	360		200
K.1.1	0.006	660		330	0.006	660		330	0.006	660		330
K.1.2	0.005	520		330	0.006	520		330	0.006	520		330
K.2.1	0.005	520		330	0.006	520		330	0.006	520		330
K.2.2	0.004	330		260	0.005	330		260	0.005	330		260
K.3.1	0.005	390		330	0.006	390		330	0.006	390		330
K.3.2	0.004	330		260	0.005	330		260	0.005	330		260
N.1.1	0.003	1150	1150		0.003	1150	1150		0.004	1150	1150	
N.1.2	0.003	1150	1150		0.003	1150	1150		0.004	1150	1150	
N.2.1	0.004	820	820		0.005	820	820		0.006	820	820	
N.2.2	0.004	820	820		0.005	820	820		0.006	820	820	
N.2.3	0.004	750	750		0.004	750	750		0.006	750	750	
N.3.1	0.006	660	660		0.006	660	660		0.007	660	660	
N.3.2	0.006	720	720		0.007	720	720		0.008	720	720	
N.3.3	0.004	820	820		0.004	820	820		0.006	820	820	
N.4.1	0.006	660	660		0.006	660	660		0.007	660	660	
S.1.1	0.002	160		80	0.002	160		80	0.002	160		80
S.1.2	0.001	130		70	0.002	130		70	0.002	130		70
S.2.1	0.002	160		80	0.002	160		80	0.002	160		80
S.2.2	0.001	130		70	0.002	130		70	0.002	130		70
S.2.3	0.001	100		70	0.002	100		70	0.002	100		70
S.3.1	0.002	260		160	0.003	260		160	0.003	260		160
S.3.2	0.002	260		130	0.002	260		130	0.002	260		130
S.3.3	0.001	160		100	0.002	160		100	0.002	160		100
H.1.1												
H.1.2												
H.1.3												
H.1.4												
H.2.1												
H.3.1												
O.1.1	0.003	330	330		0.004	330	330		0.004	330	330	
O.1.2	0.003	330	330		0.004	330	330		0.004	330	330	
O.2.1												
O.2.2	0.003	160	100		0.004	160	100		0.004	160	100	
O.3.1	0.003	330	330		0.004	330	330		0.004	330	330	

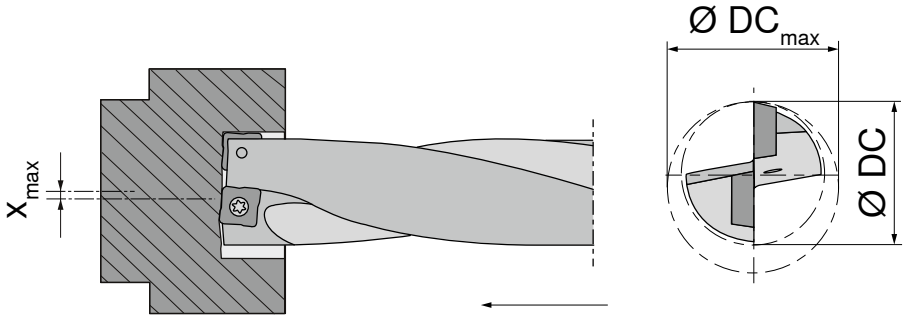
During the drilling operation on through holes a sharp disk will be produced. Safety precautions must be observed. A safety guard has to be provided as protection.

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

Index	Drill head diameter							
	Ø 1.875–2.000 inch				Ø 2.250–2.500 inch			
	f	Centering tip v_c			f	Centering tip v_c		
	inch/rev.	10 863 ... (TiN/TiAlN)	10 862 ... (TiN)	10 862 ... (TiAlN)	inch/rev.	10 863 ... (TiN/TiAlN)	10 862 ... (TiN)	10 862 ... (TiAlN)
P.1.1	0.004	820	520		0.004	820	520	
P.1.2	0.006	820	520		0.006	820	520	
P.1.3	0.005	660	520		0.006	660	520	
P.1.4	0.004	590	520		0.005	590	520	
P.1.5	0.005	750	520		0.006	750	520	
P.2.1	0.005	660	520		0.006	660	520	
P.2.2	0.004	620	490		0.005	620	490	
P.2.3	0.006	590	460		0.006	590	460	
P.2.4	0.005	490	390		0.005	490	390	
P.3.1	0.004	520	390		0.005	520	390	
P.3.2	0.003	460	330		0.004	460	330	
P.3.3	0.003	430	300		0.004	430	300	
P.4.1	0.004	590	430		0.006	590	430	
P.4.2	0.003	460	330		0.004	460	330	
M.1.1	0.005	520		230	0.005	520		230
M.2.1	0.004	390		230	0.004	390		230
M.3.1	0.003	360		200	0.003	360		200
K.1.1	0.006	660		330	0.006	660		330
K.1.2	0.006	520		330	0.006	520		330
K.2.1	0.006	520		330	0.006	520		330
K.2.2	0.005	330		260	0.005	330		260
K.3.1	0.006	390		330	0.006	390		330
K.3.2	0.005	330		260	0.005	330		260
N.1.1	0.004	1150	1150		0.004	1150	1150	
N.1.2	0.004	1150	1150		0.004	1150	1150	
N.2.1	0.006	820	820		0.006	820	820	
N.2.2	0.006	820	820		0.006	820	820	
N.2.3	0.006	750	750		0.006	750	750	
N.3.1	0.007	660	660		0.007	660	660	
N.3.2	0.008	720	720		0.008	720	720	
N.3.3	0.006	820	820		0.006	820	820	
N.4.1	0.007	660	660		0.007	660	660	
S.1.1	0.002	160		80	0.002	160		80
S.1.2	0.002	130		70	0.002	130		70
S.2.1	0.002	160		80	0.002	160		80
S.2.2	0.002	130		70	0.002	130		70
S.2.3	0.002	100		70	0.002	100		70
S.3.1	0.003	260		160	0.003	260		160
S.3.2	0.002	260		130	0.002	260		130
S.3.3	0.002	160		100	0.002	160		100
H.1.1								
H.1.2								
H.1.3								
H.1.4								
H.2.1								
H.3.1								
O.1.1	0.004	330	330		0.004	330	330	
O.1.2	0.004	330	330		0.004	330	330	
O.2.1								
O.2.2	0.004	160	100		0.004	160	100	
O.3.1	0.004	330	330		0.004	330	330	

The cutting data of the KUB Centron depends on the centering tip and not on the indexable inserts. Please select the cutting data of the centering tip.

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

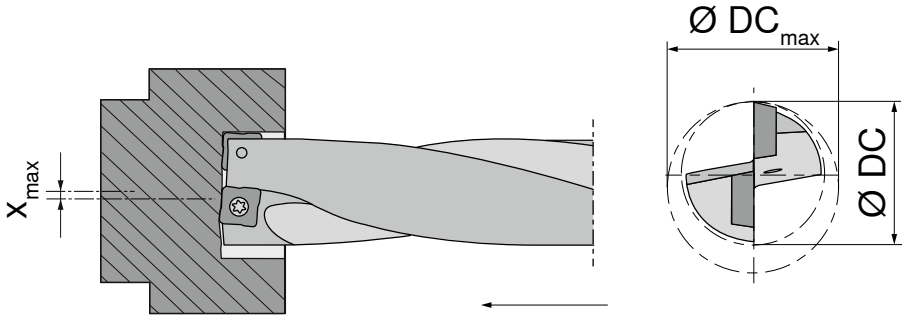


At max. offset X_{max} the hole will be:
$DC_{max} = DC + 2X_{max}$
e.g. for DC = 0.750", X_{max} = 0.010":
DC_{max} = DC + 0.020" = 0.770"

Ø DC inch	Insert size	X_{max} inch	Ø DC_{max} inch
0.562	SOGX 04....	0.010	0.582
0.593		0.010	0.613
0.625		0.010	0.645
0.656	SOGX 05....	0.010	0.676
0.687		0.010	0.707
0.703		0.010	0.723
0.750	SOGX 06....	0.010	0.770
0.765		0.010	0.785
0.781		0.010	0.801
0.812	SOGX 07....	0.010	0.832
0.828		0.010	0.848
0.843		0.010	0.863
0.875		0.010	0.895
0.906		0.010	0.926
0.937	SOGX 08....	0.010	0.957
0.985		0.010	1.005
1.000		0.010	1.020
1.031	SOGX 09....	0.010	1.051
1.062		0.010	1.082
1.109		0.010	1.129
1.125		0.010	1.145
1.156		0.010	1.176
1.187	SOGX 10....	0.010	1.207
1.218		0.010	1.238
1.250		0.010	1.270
1.281		0.010	1.301
1.312	SOGX 11....	0.010	1.332
1.328		0.010	1.348
1.375		0.010	1.395
1.437		0.010	1.457
1.469	SOGX 12....	0.010	1.489
1.500		0.010	1.520
1.531		0.010	1.551
1.562		0.010	1.582
1.625		0.010	1.645
1.656	SOGX 13....	0.010	1.676
1.687		0.010	1.707
1.750		0.010	1.770

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

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



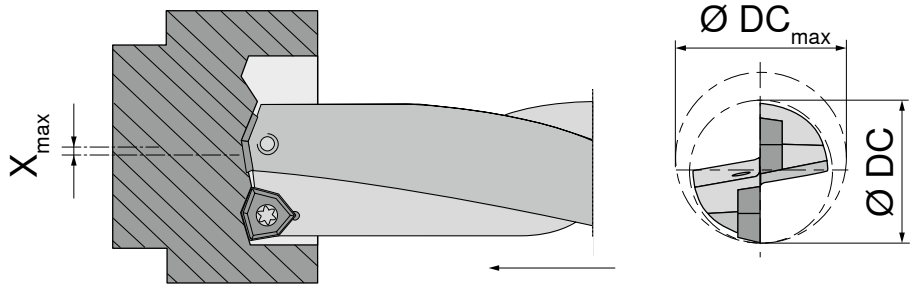
At max. offset X_{max} the hole will be:
$DC_{max} = DC + 2X_{max}$
e.g. for DC = 0.750", X_{max} = 0.010":
DC_{max} = DC + 0.020" = 0.770"

Ø DC inch	Insert size	X_{max} inch	Ø DC_{max} inch
0.562	SOEX 05....	0.010	0.582
0.593		0.010	0.613
0.625		0.010	0.645
0.656		0.010	0.676
0.687		0.010	0.707
0.703	SOEX 06....	0.010	0.723
0.718		0.010	0.738
0.750		0.010	0.770
0.765		0.010	0.785
0.781		0.010	0.801
0.812		0.010	0.832
0.828		0.010	0.848
0.843		0.010	0.863
0.875	SOEX 07....	0.010	0.895
0.906		0.010	0.926
0.937		0.010	0.957
0.968		0.010	0.988
0.985		0.010	1.005
1.000		0.010	1.020
1.031		0.010	1.051
1.062		0.010	1.082
1.109	SOEX 09....	0.010	1.129
1.125		0.010	1.145
1.156		0.010	1.176
1.187		0.010	1.207
1.218		0.010	1.238
1.250		0.010	1.270
1.281		0.010	1.301

Ø DC inch	Insert size	X_{max} inch	Ø DC_{max} inch
1.312	SOEX 12....	0.010	1.332
1.328		0.010	1.348
1.375		0.010	1.395
1.406		0.010	1.426
1.437		0.010	1.457
1.469		0.010	1.489
1.500		0.010	1.520
1.531		0.010	1.551
1.562		0.010	1.582
1.625		0.010	1.645
1.656		0.010	1.676
1.687		0.010	1.707
1.750		0.010	1.770
1.781	SOEX 07....	0.010	1.801
1.812		0.010	1.832
1.875		0.010	1.895
1.937		0.010	1.957
1.975		0.010	1.995
2.000		0.010	2.020
2.062	SOEX 09....	0.010	2.082
2.125		0.010	2.145
2.165		0.010	2.185
2.203		0.010	2.223
2.250		0.010	2.270
2.281		0.010	2.301
2.375		0.010	2.395
2.437		0.010	2.457
2.500			2.520

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

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



At max. offset X_{max} the hole will be:
$DC_{max} = DC + 2X_{max}$
e.g. for DC = 0.750", X_{max} = 0.020":
DC_{max} = DC + 0.040" = 0.790"

Ø DC inch	Insert size	X_{max} inch	Ø DC_{max} inch
0.562	WOEX 03....	0.020	0.602
0.593		0.020	0.633
0.625		0.020	0.665
0.656		0.020	0.696
0.687		0.020	0.727
0.703		0.020	0.743
0.750		0.020	0.790
0.765		0.020	0.805
0.781		0.020	0.821
0.812	WOEX 04....	0.020	0.852
0.828		0.020	0.868
0.843		0.020	0.883
0.875		0.020	0.915
0.906		0.020	0.946
0.937		0.020	0.977
0.985	WOEX 05....	0.020	1.025
1.000		0.020	1.040
1.031		0.040	1.111
1.062		0.040	1.142
1.109		0.060	1.229
1.125		0.065	1.254
1.156		0.060	1.276
1.187		0.050	1.287
1.218		0.050	1.318
1.250		0.041	1.331
1.281		0.040	1.361
1.312		0.040	1.392
1.328		0.040	1.408
1.375		0.020	1.415
1.406		0.020	1.446
1.437		0.020	1.477

Ø DC inch	Insert size	X_{max} inch	Ø DC_{max} inch
1.469	WOEX 06....	0.060	1.589
1.500		0.060	1.620
1.531		0.060	1.651
1.562		0.060	1.682
1.625		0.060	1.745
1.656		0.060	1.776
1.687		0.043	1.773
1.750		0.011	1.772
1.781	WOEX 08....	0.058	1.897
1.812		0.059	1.929
1.875		0.059	1.992
1.937		0.059	2.055
1.975		0.059	2.093
2.000		0.059	2.118
2.062		0.049	2.160
2.125		0.023	2.171
2.165	WOEX 10....	0.059	2.283
2.203		0.059	2.321
2.250		0.058	2.366
2.281		0.058	2.397
2.375		0.027	2.429
2.437		0.059	2.555
2.500		0.065	2.630
2.593		0.059	2.711
2.625		0.058	2.740
2.656		0.059	2.774
2.750	WOEX 12....	0.058	2.866
2.875		0.059	2.992
3.000		0.059	3.118
3.250		0.018	3.285

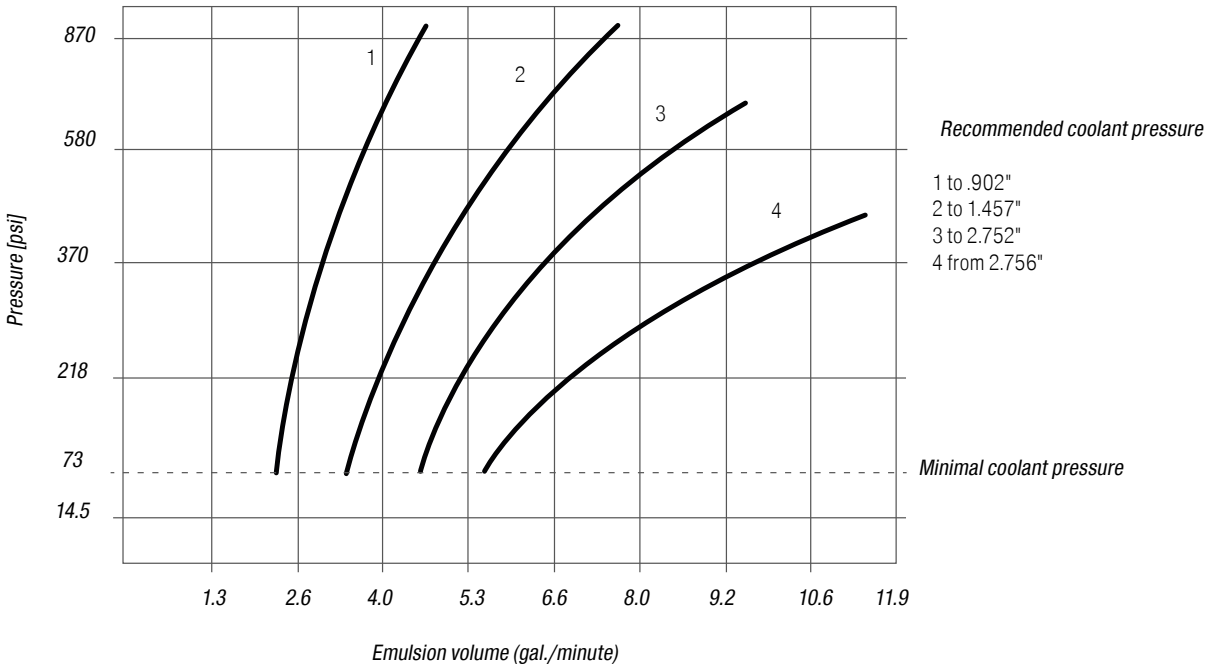
The maximum radial X-offset affects the cutting force balance of the drill, therefore, the use of lower feed rates is recommended!

Coding example indexable insert drilling

System		Length		Bore diameter		Direction of rotation		Insert size		Machine connection and size
KUB-P	.	4D	.	0750	.	R	.	06	–	ABS 50
KUB-Q	.	3D	.	1375	.	R	.	12	–	ABS 50
KUB-T	.	2.5D	.	1125	.	R	.	05	–	C1250
KUB-C.GH	.	4D	.	320		R			–	ABS 50

KUB-P = KUB Pentron	0750 = 0.750“	R = right	ABS50 = ABS adapter size 50
KUB-Q = KUB Quatron	1375 = 1.375“	R = right	ABS50 = ABS adapter size 50
KUB-T = KUB Trigon	1125 = 1.125“	R = right	C1250 = Cylindrical shank with clamping flat Ø1.250"
KUB-C.GH = KUB Centron Basic Element	320 = KLG 32	R = right	ABS50 = ABS adapter size 50

Recommended coolant pressure and coolant flow

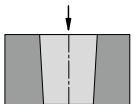


Indexable insert drilling – problems / possible causes / solutions

Rotating and stationary application

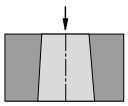
Short service life / types of wear of indexable inserts

- ▲ 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



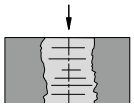
Hole tapers in

- ▲ 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



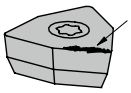
Hole tapers out

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



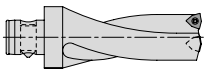
Poor surface quality

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



Built-up edge

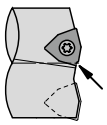
- ▲ Cutting speed too low → increase cutting speed
- ▲ Indexable insert too negative → use positive geometry
- ▲ Unsuitable coating → select the correct coating



Friction marks on the tool body

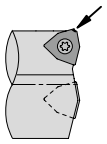
- ▲ Drill diameter too small → check the setting
- ▲ Chip evacuation problems → optimize the cutting parameters, check the geometry of the indexable insert
- ▲ Cutting radius too large → use the correct cutting radius

Stationary application



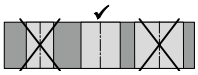
Edge breakage on the inner cutting edge

- ▲ Center 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

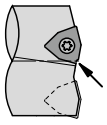
- ▲ Feed too high → reduce feed
- ▲ Interrupted cut → switch to a tougher grade of indexable insert
- ▲ Cutting radius too small → use an indexable insert with a larger cutting radius



Hole too small / too large with adjustable tools

- ▲ 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

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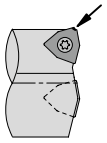

Edge breakage on the outer cutting edge

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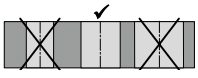
- ▲ Interrupted cut → switch to a tougher grade of indexable insert
- ▲ Cutting radius too small → use an indexable insert with a larger cutting radius

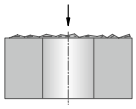


Hole too small / too large when using adjustable tools

- ▲ Incorrect cutting radius used → use the correct cutting radius
- ▲ Incorrect adjustment setting → set the tool to the correct diameter
- ▲ Increase cutting fluid supply

KUB Centron – notes on drilling technology

1.



Center drill entering on uneven surfaces (casting surfaces)

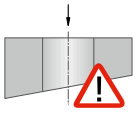
- Generally possible
- Reduce feed during drill entry

2.

Center drill entering on angled surfaces

- The entering drilling location must be spot faced in advance
- Avoid chips jamming on the drill shank

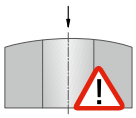
3.



Angled drill exit

- Possible under certain conditions
- If necessary, reduce feed
- Drilling angle max. 3°

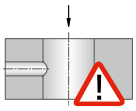
4.



Center drill entering on convex surfaces

- Centered drilling possible with reduced feed
- If the drill entry location is outside the center of the radius, spot facing is required

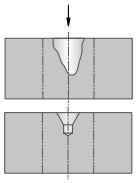
5.



Drilling through a cross hole

- During the interruption, reduce the feed rate by 1/2
- Cross hole max. 1/3 of the bore diameter
- Off center cross hole not possible

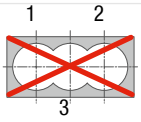
6.



Center drill entering on pre-op or large center drilled hole

- Possible under certain conditions
- If necessary, reduce feed
- In the case of a large center, facing is required in advance
- If necessary, adjust the set length of the center drill. The center drill must be engaged before the inserts begin to cut.

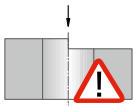
7.



Drilling a cavity

- Not possible

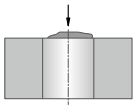
8.



Center drill entering on an edge

- Not possible with tools longer than 4xD
- Preparation required due to undefined center drill entry location (spot facing, face milling)
- Then continue as described under Point 1

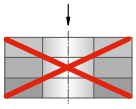
9.



Center drill entering on a forging/welding/casting seam

- Reduce feed during drill entry
- If necessary, face surface before drilling

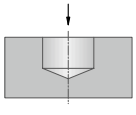
10.



Drilling through stacks

- Not possible

11.



Blind hole

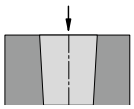
- Possible
- Set guide pads .020" below actual ⌀

KUB Centron – problems / possible causes / solutions

Rotating and stationary application

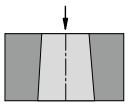
Short service life / types of wear of indexable inserts

- ▲ Cutting speed too high → select the correct cutting speed
- ▲ Grade 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



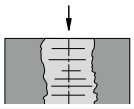
Hole tapers in

- ▲ 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 positive cutting edge geometry
- ▲ Axial adjustment of the centering tip not optimal → adjust according to the setting sheet in the operating instructions



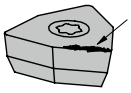
Hole tapers out

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



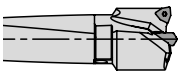
Poor surface quality

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



Built-up edge

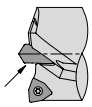
- ▲ Cutting speed too low → increase cutting speed
- ▲ Indexable insert too negative → use positive geometry
- ▲ Unsuitable coating → select the correct coating



Friction marks on the tool body

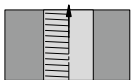
- ▲ Drill diameter too small → check the setting
- ▲ Chip evacuation problems → optimize the cutting parameters, check the geometry of the indexable insert
- ▲ Cutting radius too large → use the correct cutting radius
- ▲ Chips stuck on the guide pads, broken guide pads, the guide pads do not have to be used for base elements of < 6xD

Stationary application



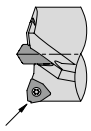
Significant wear on one side of the centering tip

- ▲ Tool not centered → tool turret/adapter may have moved → recalibrate the machine



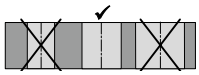
Single-sided retract marks

- ▲ Tool not centered → tool turret/adapter may have moved → recalibrate the machine



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



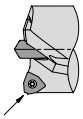
Hole too small / too large with adjustable tools

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

Rotating application

Significant wear on one side of the centering tip

- ▲ Insufficient guiding → check length adjustment of the centering tip



Edge breakage on the outer cutting edge

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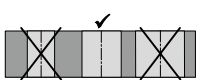
- ▲ Cutting radius too small → use an indexable insert with a larger cutting radius



Hole too small / too large with adjustable tools

- ▲ Incorrect cutting radius used → use the correct cutting radius
- ▲ Incorrect adjustment setting → set the tool to the correct diameter

Grades Overview

CTPP430
- Carbide, TiAlN-coated
- ISO | **P30** | **M25** | S25 | K30 | N25
- The universal high-performance grade for steel, austenitic steel and heat-resistant alloys.

CTPP420
- Carbide, TiCN-Al_2O_3-coated
- ISO | **P20** | **K20**
- The wear-resistant solution for steel and cast iron materials at high cutting speeds.

BK7710
- Carbide, TiB_2-coated
- ISO | **N10** | S10 | O10
- The wear-resistant grade with optimum cutting characteristics to prevent built-up edge formation for machining aluminium and titanium alloys.

BK6425
- Carbide, TiCN-Al_2O_3-TiN-coated
- ISO | **P25 I M15** | **K20**
- The extremely wear-resistant grade for machining all steel and stainless materials.

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.

BK79
- Carbide, TiAlN-coated
- ISO | **P40** | **M35** | **K25** | N30
- Universally applicable grade with high wear-resistance
- low to medium cutting speed for roughing and finishing as well as interrupted cut

BK8425
- Carbide, TiAlN/TiN-coated
- ISO | **P25** | **M25** | **K25** | N25 | **S25** | H25
- Universally applicable grade with increased wear resistance thanks to the innovative PVD coating in a multilayer design.

BK8430
- Carbide, TiAlN/TiN-coated
- ISO | **P25** | **M25 I K25** | N25 | **S25** | H25
- Fine-grain grade with high wear resistance
- Extreme edge stability and maximum wear resistance in the middle and top speed range

BK6115
- Carbide, TiCN-TiN-Al_2O_3-coated
- ISO | **P20** | **M20** | **K20** | H20
- High-quality, surface-treated coating for machining cast iron materials under normal to stable conditions and high cutting speeds.

BK7935
- Carbide, AlTiN-coated
- ISO | **P35** | **M30** | **K30** | N30 | **S30** | O30
- The tough carbide grade for machining stainless steel and acid-resistant steels as well as special alloys.

BK77
- Carbide, TiN-coated
- ISO | **S10** | H10 | O10
- The wear-resistant carbide grade for machining aluminum alloys, superalloys and plastics at medium cutting speeds.

BK7615
- Carbide, TiCN-Al_2O_3-coated
- ISO | **K15**
- Highly productive grade with extreme edge stability for wet and dry machining of all cast iron 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
- WOEX BK8425 -03: Can only be used for the peripheral insert
- SOGX BK8425 -03: Suitable for the center and 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
- The dome-shaped chip breaker results in more controlled breaking of the chips
- Can be used for center and periphery
- Suitable for unstable machining conditions due to the low cutting forces

-21
- Soft cutting geometry that reduces cutting forces
- High positive chip breaker

-32
- For the machining of steel and cast iron materials
- Minimised burr formation when entering and exiting the hole
- Reliable separation of disc-shaped residual material when the drill exits the hole

-34
- High-feed geometry
- Extremely sturdy indexable insert
- Designed specially for steel and cast iron materials

Application