

KORLOY *Strong*
PROMO 2021

TPDB

3D, 5D & 8D Drills

FREE DRILL BODY

- With the Purchase of 3 tips (3D & 5D only)
- With the Purchase of 5 tips (8D only)

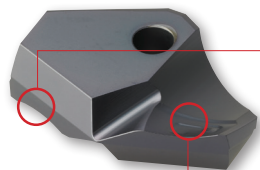
OR

BUY2 GET1 FREE

- Buy 2 Drill Bodies, Get the Third Body Free

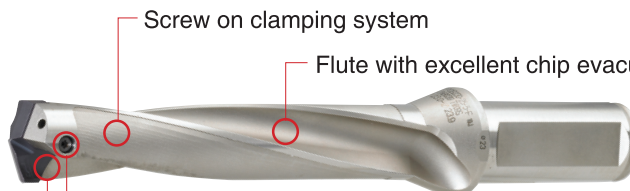


● Features



Cutting edge with low cutting resistance

Improved chip control due to chip breaker



Screw on clamping system

Flute with excellent chip evacuation

Superior rigidity and wear resistance of holder

Auto-centering system

- * (End-user) Drop-shipment ONLY
- * Limited to US or Korea Stock Drills and Inserts
- * Limited to 6 Free Drill Bodies

Indexable Drill for High Precision and High Efficiency

- Excellent Surface Finish
- Screw-on Clamping System
- High Precision Clamping System
- For Combined Precision and Productivity



 **KORLOY AMERICA**

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Promotion Validity :
From January 1st ~ June 30th

High Precision and High Productivity Indexable Drill

TPDB Top Sold Piercing Drill Blade

- **High precision clamping system** - High precision grinding and superior clamping precision with auto-centering system
- **Holder with excellent durability** - Holder with high rigidity and superb wear resistance due to special surface treatment
- **Sharp cutting edge** - Improved chip evacuation, low cutting load, longer tool life with ultra-fine substrate and exclusive coating layer
- **Screw on clamping system** - Easy clamping system of TPDB insert

Recommended Cutting Condition

Workpiece				Grade	vc	Depth of cut = 3D~5D Feed rate (ipr) per drill dia. (inch)		
ISO	Workpiece	HB	sfm		Ø0.3937~Ø0.6260	Ø0.6300~Ø0.9803	Ø0.9843~Ø1.1772	
P	Carbon steel	Low carbon steel	80~120	PC5300, PC5335	365 (265~464)	0.0059~0.0118	0.0079~0.0138	0.0098~0.0157
		High carbon steel	180~280	PC5300, PC5335	332 (232~431)	0.0059~0.0118	0.0079~0.0138	0.0098~0.0157
	Alloy steel	Low alloy steel	140~260	PC5300	365 (265~464)	0.0071~0.0138	0.0091~0.015	0.0110~0.0169
		Low pre-hardened steel	200~400	PC5300	249 (166~332)	0.0071~0.0138	0.0091~0.015	0.0110~0.0169
		High alloy steel	260~320	PC5300	232 (166~298)	0.0071~0.0118	0.0079~0.0138	0.0098~0.0157
		High pre-hardened steel	300~450	PC5300	199 (133~265)	0.0071~0.0118	0.0079~0.0138	0.0098~0.0157
M	Stainless steel	Austenite series	135~275	PC5300	166 (99~232)	0.0051~0.0098	0.0059~0.0118	0.0067~0.0130
		Ferrite series Martensite series	13~275	PC5300	182 (133~232)	0.0051~0.0098	0.0059~0.0118	0.0067~0.0130
K	Cast iron	Gray cast iron	150~230	PC5300	365 (265~464)	0.0071~0.0138	0.0079~0.0157	0.0098~0.0177
		Ductile cast iron	160~260	PC5300	332 (232~431)	0.0071~00.0138	0.0079~0.0157	0.0098~0.0177
S	Heat resisting steel	Ni-heat resisting alloy	130~400	PC5300	133 (66~199)	0.0039~0.0079	0.0047~0.0087	0.0051~0.0098
		Ti-heat resisting alloy	130~400	PC5300	133 (66~199)	0.0039~0.0079	0.0047~0.0087	0.0051~0.0098
		High-hardened steel	Over 400	PC5300	116 (66~166)	0.0039~0.0079	0.0047~0.0087	0.0051~0.0098

- In case of 8D, reduce the cutting conditions to 40~50% or machine the beginning of hole first.(1.5D)
- In case of interrupted machining, reduce the feed to 30~50% machining around the interrupted part

Application Range

