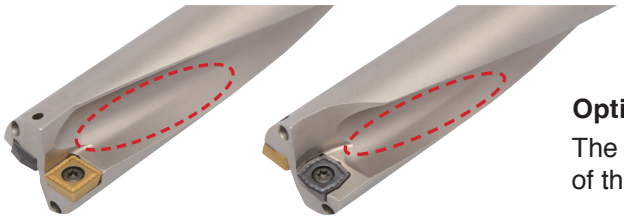
KORLOY *Strong*
PROMO 2021.B

KING DRILL
FREE DRILL BODY

- With Purchase of 40 Inserts up to 1.00 Inch
- With Purchase of 60 Inserts up to 2.00 Inch

* (End-user) Drop-shipment only
* Limited to US or Korea stock drills and inserts
* Limited to 6 free drill bodies
* 5D over 1" drills require 80 inserts

- Optimized design of inserts for maximum drilling efficiency
- Excellent cutting performance and chip control due to the optimized geometry and chip breaker of both inserts, central & peripheral
- Different inserts, optimized for the central and peripheral insert locations in order to maximize cutting tool life



Optimized flute system - 2 coolant holes applied

The optimized shape of the flute increases the rigidity of the drill body and improves chip evacuation

High Speed and High Efficiency Indexable Drill

- **Excellent Chip Control** - Highly effective chipbreaker design for hole making applications. Excellent chip control and surface finish due to optimized insert geometries
- **Stable Tool Life** - Optimized balance between cutting edges and grades improves stability of tool life

KORLOY AMERICA

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Promotion Validity :
From July 1st ~ December 31st

Optimized Insert Design for Maximum Drilling Efficiency

KING DRILL

- High performance and improved chip evacuation

Recommended Cutting Condition

Workpiece				Insert			vc (sfm)	Depth of cut = 2D, 3D, 4D Fn (ipr) depending on drill Dia. (inch)				
ISO		Workpiece	Hardness (HB)	Chip breaker	Grade			Ø0.47~Ø0.63	Ø0.64~Ø0.91	Ø0.92~Ø1.14	Ø1.15~Ø1.65	Ø1.66~Ø2.36
					Central	Peripheral						
P	Carbon steel	Low carbon steel	80~180	LD	PC5335	PC5335	394 (197~558)	0.0016~0.0031	0.0016~0.0031	0.0016~0.0031	0.0016~0.0031	0.0016~0.0031
				PD/RD	PC5300	PC3500	492 (394~591)					
						NC5330	591 (459~722)					
		High carbon steel	180~280	PD	PC5300	PC3500	394 (295~492)	0.0016~0.0039	0.0016~0.0047	0.002~0.0063	0.0024~0.0063	0.0024~0.0071
						NC5330	492 (361~623)	0.0016~0.0024	0.0016~0.0028	0.0016~0.0031	0.0016~0.0031	0.0016~0.0031
	Alloy steel	Low alloy steel	140~260	LD	PC5335	PC5335	394 (197~525)	0.0024~0.0039	0.0024~0.0039	0.0024~0.0047	0.0024~0.0055	0.0024~0.0055
				PD	PC5300	PC3500	492 (394~558)	0.0024~0.0047	0.0024~0.0047	0.0024~0.0055	0.0024~0.0063	0.0024~0.0063
						NC5330	591 (459~689)	0.0024~0.0031	0.0024~0.0031	0.0024~0.0039	0.0024~0.0047	0.0024~0.0047
		Hardened low alloy steel	200~400	PD	PC5300	PC5300	328 (164~492)	0.0016~0.0039	0.0024~0.0039	0.0024~0.0047	0.0024~0.0055	0.0024~0.0055
		High alloy steel	260~320	PD	PC5300	PC3500	328 (164~525)	0.002~0.0043	0.002~0.0043	0.002~0.0051	0.002~0.0059	0.002~0.0059
		Hardened high alloy steel	300~450	PD	PC5300	PC5300	230 (98~394)	0.0016~0.0031	0.0024~0.0031	0.0024~0.0039	0.0024~0.0047	0.0024~0.0047
M	Stainless steel	Stainless steel	135-275	LD	PD5335	PC5335	394 (262~459)	0.0016~0.0028	0.0016~0.0028	0.0016~0.0028	0.0016~0.0031	0.0016~0.0031
				PD	PC5300	PC5300	427 (328~525)	0.0016~0.0028	0.0016~0.0028	0.0016~0.0028	0.0016~0.0031	0.0016~0.0031
K	Cast iron	Gray cast iron	150~230	PD	PC5300	PC6510	623 (492~820)	0.0016~0.0047	0.002~0.0055	0.0024~0.0071	0.0039~0.0087	0.0039~0.0102
		Ductile cast iron	150~230	PD	PC5300	PC6510	427 (328~525)	0.0016~0.0028	0.0016~0.0031	0.0016~0.0039	0.002~0.0047	0.002~0.0047
S	Heat resisting alloy	Ni-heat resisting alloy	130~400	PD	PC5300	PC5300	164 (98~328)	0.0016~0.0039	0.0016~0.0039	0.0016~0.0039	0.0016~0.0039	0.0016~0.0039
		Ti-heat resisting alloy	130~400	LD	PC5335	PC5335	197 (131~262)	0.0016~0.0031	0.0016~0.0039	0.0024~0.0047	0.0024~0.0055	0.0024~0.0063
				PD	PC5300	PC5300	197 (131~262)	0.0016~0.0031	0.0016~0.0039	0.0024~0.0047	0.0024~0.0055	0.0024~0.0063
		High hardened steel	over 400	PD	PC5300	PC5300	131 (66~262)	0.0016~0.002	0.0016~0.0024	0.0016~0.0031	0.0016~0.0031	0.0016~0.0031
N	Aluminium	Aluminium	30~150	ND	H01	H01	984 (820~1312)	0.0020~0.0055	0.0024~0.0063	0.0039~0.0087	0.0063~0.0039	0.0047~0.0098
		Alloyed copper	150-160	ND	H01	H01	820 (656~984)	0.0020~0.0055	0.0024~0.0063	0.0039~0.0087	0.0063~0.0039	0.0047~0.0098

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

Insert Shape

Chip breaker	PD		LD		ND		RD
Insert	Peripheral insert	Central insert	Peripheral insert	Central insert	Peripheral insert	Central insert	Central insert
Shape