

KORLOY *Strong*
PROMO 2020

KING DRILL

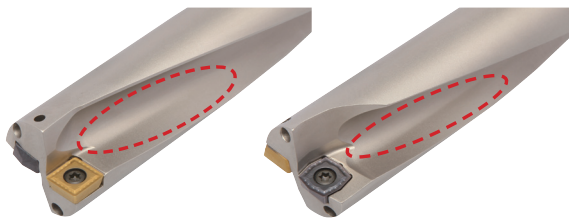
FREE DRILL BODY

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



● Features

- Optimized design of inserts for maximum drilling efficiency
- Excellent cutting performance and chip control due to the optimized geometry and chip breaker of both inserts, central & 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

- * (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

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 February ~ August 2020

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	