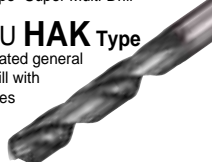
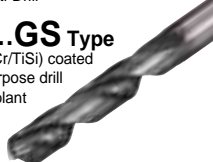
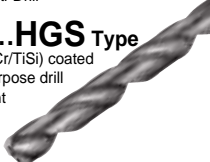


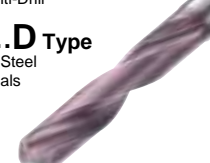




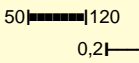
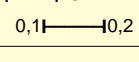
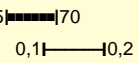
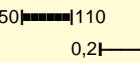
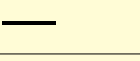
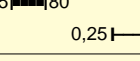
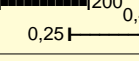
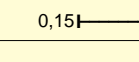
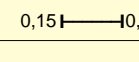
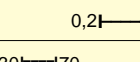
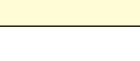
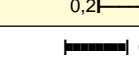
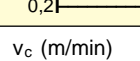




Multi-Drill Series Selection Guide

● According to Drill Types / Applications

Application		General ↔ Special		
Solid Type	"Super Multi-Drill" MDS/MDW Type	<div>m7 DIN Type "Super Multi-Drill"</div> <div>SDP...U HAK Type</div> <div>AlCrTiN coated general purpose drill with coolant holes</div> <div></div> <div>øD : 3,0 ~ 16mm L/D : 3, 5, 7 ⇒ K6 ~ 11</div>	<div>"Super Multi-Drill"</div> <div>MDW...GS Type</div> <div>DEX (TiAlCr/TiSi) coated general purpose drill without coolant holes</div> <div></div> <div>øD : 2,0 ~ 16mm L/D : ~ 2, ~ 4 ⇒ K14 ~ 15</div>	<div>"Super Multi-Drill"</div> <div>MDW...HGS Type</div> <div>DEX (TiAlCr/TiSi) coated general purpose drill with coolant holes</div> <div></div> <div>øD : 4,0 ~ 16mm L/D : ~ 3, ~ 5 ⇒ K16 ~ 17</div>
		<div>m7 DIN Type "Super Multi-Drill"</div> <div>MDS...K-HAK Type</div> <div>TiAlN coated general purpose drill with coolant holes</div> <div></div> <div>øD : 2,0 ~ 12mm L/D : ~ 2, ~ 4 ⇒ K18 ~ 19</div>	<div>"Super Multi-Drill"</div> <div>MDS...G Type</div> <div>For Cast Iron & Aluminum</div> <div></div> <div>øD : 2,8 ~ 20mm L/D : ~ 3 ⇒ K20 ~ 23</div>	<div>"Super Multi-Drill"</div> <div>MDS...D Type</div> <div>Hardened Steel Exotic Metals</div> <div></div> <div>øD : 1,0 ~ 16,1mm L/D : ~ 3 (Stock in Japan)</div>
Brazed Type	"Super Multi-Drill" KDS Type	<div>"Super Multi-Drill"</div> <div>KDS... MAK Type</div> <div>General Purpose Drill</div> <div></div> <div>øD : 12 ~ 26mm L/D : ~ 3 ⇒ K36 ~ 37</div>	<div>Long Type "Super Multi-Drill"</div> <div>KDS... LAK Type</div> <div>Deep Hole Drilling</div> <div></div> <div>øD : 12 ~ 26mm L/D : ~ 5 ⇒ K38 ~ 39</div>	—
		<div>—</div>	<div>Long Type "Super Multi-Drill"</div> <div>KDS... DAK Type</div> <div>Good Chip Removal</div> <div></div> <div>øD : 9 ~ 22mm L/D : ~ 7 ⇒ K40 ~ 41</div>	<div>Extra Long Typ "Super Multi-Drill"</div> <div>KDS... FA Type</div> <div>For Cast Irons and Aluminium Alloys</div> <div></div> <div>øD : 9 ~ 22mm L/D : ~ 7 ⇒ K42</div> <div>Delivery on request</div>

■ Recommended Cutting Conditions by Work Materials

Work		Steel	Stainless Steel	Cast Iron	Non-ferrous Metals
Drill	Solid Type	SDP...U HAK  MDW...GS/HGS 			—
	Brazed Type	MDS...G 	—		
Drill	Brazed Type	KDS...AK (MAK/LAK/DAK) 			—
	Brazed Type	KDS...FA 	—		

 Cutting speed v_c (m/min)
 Feed f (mm/rev)