

# COOLANT THRU INDEXABLE DRILLS

## KOMET™ QUATRON INDEXABLE DRILLS

With Combination Straight Shank, Right Hand

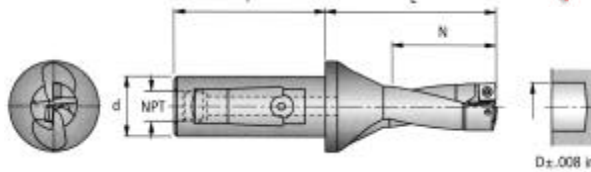
KOMET™

**FEATURES:**

- High stability and efficiency through the use and positioning of the square inserts.
- Better chip evacuation and reduced flute erosion through special tool body surface treatment.
- For difficult drilling conditions such as uneven casting surfaces, hardened steel surfaces and interrupted cut.
- Outstanding drilled hole quality with reduction in exit marks.
- Reduced tooling costs through four cutting edges with specially selected substrates and coatings.
- Inside and outside inserts same insert with the same coating is used, same insert screws.



**NEW ITEM!**



**Shank Dia: 0.750" & 1.250"**  
**Drill Dia: 0.562" to 1.750"**  
**Drill Depths: 2 X D**

Drill Dia D	Shank Dia d	Drill Depth 2 X D	Shank Length L	Flute Length N	Shoulder To Tip L	NPT	KOMET Reference	Part Number	Price Each
<b>0.562 - 0.687 Drill Diameter- 0.219 Insert I.C.</b>									
0.562	0.750	1.124	1.969	1.181	2.126	1/8	U11 21431	KQ0562-2D75-219	\$237.52
0.593	0.750	1.186	1.969	1.260	2.205	1/8	U11 21511	KQ0593-2D75-219	\$237.52
0.625	0.750	1.250	1.969	1.260	2.205	1/8	U11 21591	KQ0625-2D75-219	\$237.52
0.656	0.750	1.312	1.969	1.339	2.283	1/8	U11 21671	KQ0656-2D75-219	\$237.52
0.687	0.750	1.374	1.969	1.417	2.362	1/8	U11 21751	KQ0687-2D75-219	\$237.52
<b>0.703 - 0.843 Drill Diameter- 0.250 Insert I.C.</b>									
0.703	1.000	1.406	2.205	1.417	2.362	1/8	U11 31791	KQ0703-2D10-250	\$237.52
0.718	1.000	1.436	2.205	1.496	2.441	1/8	U11 31821	KQ0718-2D10-250	\$237.52
0.750	1.000	1.500	2.205	1.575	2.520	1/8	U11 31911	KQ0750-2D10-250	\$237.52
0.765	1.000	1.530	2.205	1.575	2.520	1/8	U11 31941	KQ0765-2D10-250	\$237.52
0.781	1.000	1.562	2.205	1.575	2.520	1/8	U11 31981	KQ0781-2D10-250	\$237.52
0.812	1.000	1.624	2.205	1.654	2.598	1/8	U11 32061	KQ0812-2D10-250	\$237.52
0.828	1.000	1.656	2.205	1.654	2.677	1/8	U11 32101	KQ0828-2D10-250	\$237.52
0.843	1.000	1.686	2.205	1.732	2.677	1/8	U11 32141	KQ0843-2D10-250	\$237.52
<b>0.875 - 1.062 Drill Diameter- 0.313 Insert I.C.</b>									
0.875	1.000	1.750	2.205	1.811	2.756	1/8	U11 32221	KQ0875-2D10-313	\$253.39
0.906	1.000	1.812	2.205	1.811	2.835	1/8	U11 32301	KQ0906-2D10-313	\$253.39
0.937	1.250	1.874	2.362	1.890	2.835	1/4	U11 42381	KQ0937-2D12-313	\$253.39
0.968	1.250	1.936	2.362	1.969	2.913	1/4	U11 42461	KQ0968-2D12-313	\$253.39
0.985	1.250	1.970	2.362	1.969	2.992	1/4	U11 42501	KQ0985-2D12-313	\$253.39
1.000	1.250	2.000	2.362	2.047	2.992	1/4	U11 42541	KQ1000-2D12-313	\$253.39
1.031	1.250	2.062	2.362	2.126	3.070	1/4	U11 42620	KQ1031-2D12-313	\$253.39
1.062	1.250	2.124	2.362	2.126	3.070	1/4	U11 42700	KQ1062-2D12-313	\$253.39
<b>1.109 - 1.281 Drill Diameter- 0.375 Insert I.C.</b>									
1.109	1.250	2.218	2.362	2.283	3.228	1/4	U11 42820	KQ1109-2D12-375	\$316.63
1.125	1.250	2.250	2.362	2.283	3.228	1/4	U11 42860	KQ1125-2D12-375	\$316.63
1.156	1.250	2.312	2.362	2.323	3.307	1/4	U11 42940	KQ1156-2D12-375	\$316.63
1.187	1.250	2.374	2.362	2.441	3.582	1/4	U11 43020	KQ1187-2D12-375	\$316.63
1.218	1.250	2.436	2.362	2.441	3.582	1/4	U11 43090	KQ1218-2D12-375	\$316.63
1.250	1.250	2.500	2.362	2.520	3.661	1/4	U11 43180	KQ1250-2D12-375	\$316.63
1.281	1.250	2.562	2.362	2.598	3.740	1/4	U11 43250	KQ1281-2D12-375	\$316.63
<b>1.312 - 1.750 Drill Diameter- 0.500 Insert I.C.</b>									
1.312	1.250	2.624	2.362	2.677	3.818	1/4	U11 43330	KQ1312-2D12-500	\$351.59
1.328	1.250	2.656	2.362	2.677	3.818	1/4	U11 43370	KQ1328-2D12-500	\$351.59
1.375	1.250	2.750	2.362	2.756	3.897	1/4	U11 43490	KQ1375-2D12-500	\$351.59
1.406	1.250	2.812	2.362	2.835	3.976	1/4	U11 43570	KQ1406-2D12-500	\$351.59
1.437	1.250	2.874	2.362	2.913	4.448	1/4	U11 43650	KQ1437-2D12-500	\$351.59
1.469	1.250	2.938	2.362	2.992	4.527	1/4	U11 43730	KQ1469-2D12-500	\$351.59
1.500	1.250	3.000	2.362	3.071	4.606	1/4	U11 43810	KQ1500-2D12-500	\$351.59
1.531	1.250	3.062	2.362	3.071	4.606	1/4	U11 43890	KQ1531-2D12-500	\$351.59
1.562	1.250	3.124	2.362	3.150	4.685	1/4	U11 43970	KQ1562-2D12-500	\$351.59
1.625	1.250	3.250	2.362	3.307	4.842	1/4	U11 44130	KQ1625-2D12-500	\$387.54
1.656	1.250	3.312	2.362	3.386	4.921	1/4	U11 44210	KQ1656-2D12-500	\$387.54
1.687	1.250	3.374	2.362	3.386	4.921	1/4	U11 44290	KQ1687-2D12-500	\$387.54
1.750	1.250	3.500	2.362	3.465	5.000	1/4	U11 44450	KQ1750-2D12-500	\$387.54

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(See Following Page For Inserts)

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## INDEXABLE DRILL INSERTS For KOMET™ Quatron Drills



# KOMET™

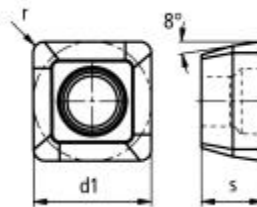
### GRADES:

**Grade BK84** - Coated C5 Inserts for Drilling Steels, Cast Steels and 400 Series Stainless

**Grade 7930** - TiAlN coated carbide on p40 base with extremely high wear resistance. med to high cutting speed for rough and finish and with interrupt cut. For non-alloy steel, cast steel, die steel rust-proof and stainless steel

### CHIPBREAKERS:

**Chipbreaker 01** - For good chip control  
**Chipbreaker 13** - For Chip Control



### Grade BK84 - Coated C5, Chipbreaker 01

ISO Code	Drill Dia	IC	T	R	KOMET Ref. Number	Part Number	Price Each	Screws \$2.08 each	Wrench \$6.00 each
SOEX050204-01	0.562-0.687	0.219	0.094	0.016	W83 13000.01	KOM-219-BK84-01	\$7.88	KOM-N0056041	KOM-6IP
SOEX060306-01	0.703-0.843	0.250	0.125	0.024	W83 18000.09	KOM-250-BK84-01	\$7.88	KOM-N0057553	TX-208
SOEX07T308-01	0.875-1.062	0.313	0.141	0.031	W83 23000.01	KOM-313-BK84-01	\$8.24	KOM-N0057571	KOM-8IP
SOEX090408-01	1.109-1.281	0.375	0.172	0.031	W83 32000.15	KOM-375-BK84-01	\$9.49	KOM-N0057261	TX-215
SOEX120508-01	1.312-1.750	0.500	0.203	0.031	W83 44000.18	KOM-500-BK84-01	\$10.06	KOM-N0057301	KOM-20IP

### Grade 7930 - TIALN COATED, Chipbreaker 01

ISO Code	Drill Dia	IC	T	R	KOMET Ref. Number	Part Number	Price Each	Screws \$2.08 each	Wrench \$6.00 each
SOEX050204-01	0.562-0.687	0.219	0.094	0.016	W83 13000.01	KOM-219-7930-01	\$7.88	KOM-N0056041	KOM-6IP
SOEX060306-01	0.703-0.843	0.250	0.125	0.024	W83 18000.09	KOM-250-7930-01	\$7.88	KOM-N0057553	TX-208
SOEX07T308-01	0.875-1.062	0.313	0.141	0.031	W83 23000.01	KOM-313-7930-01	\$8.24	KOM-N0057571	KOM-8IP
SOEX090408-01	1.109-1.281	0.375	0.172	0.031	W83 32000.15	KOM-375-7930-01	\$9.49	KOM-N0057261	TX-215
SOEX120508-01	1.312-1.750	0.500	0.203	0.031	W83 44000.18	KOM-500-7930-01	\$10.06	KOM-N0057301	KOM-20IP

### Grade BK84 - Coated C5, Chipbreaker 13

ISO Code	Drill Dia	IC	T	R	KOMET Ref. Number	Part Number	Price Each
SOEX050204-13	0.562-0.687	0.219	0.094	0.016	W83 13000.02	KOM-219-BK84-13	\$7.88
SOEX060306-13	0.703-0.843	0.250	0.125	0.024	W83 18000.10	KOM-250-BK84-13	\$7.88
SOEX07T308-13	0.875-1.062	0.313	0.141	0.031	W83 23000.02	KOM-313-BK84-13	\$8.24
SOEX090408-13	1.109-1.281	0.375	0.172	0.031	W83 32000.17	KOM-375-BK84-13	\$9.49
SOEX120508-13	1.312-1.750	0.500	0.203	0.031	W83 44000.19	KOM-500-BK84-13	\$10.06

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## SPEEDS & FEEDS

# KOMET™

Material Group	Tensile strength (lbf/in <sup>2</sup> )	Hardness HB	Material	Material Example AISI / SAE	Cutting speed V f/ft/min	2 x D Maximum feedrate f, in/rev							
						Ø .562 - Ø .624	Ø .625 - Ø .686	Ø .687 - Ø .843	Ø .844 - Ø 1.062	Ø 1.109 - Ø 1.281	Ø 1.312 - Ø 1.750	Ø 1.781 - Ø 2.000	Ø 2.062 - Ø 2.500
1	<72500	-	Unalloyed steel	A570.611A57.81	980	0.004	0.005	0.005	0.006	0.006	0.006	0.006	0.006
2	72500-130000	-	Low alloy steel	5120 1055 5115	820	0.005	0.006	0.006	0.008	0.008	0.010	0.008	0.008
2.1	<72500	-	Lead alloy	12L13	980	0.006	0.006	0.007	0.010	0.010	0.012	0.010	0.010
3	>130000	-	High alloy steel heat resistant structural, heat treated, nitride steels	4140 1064	660	0.006	0.006	0.007	0.008	0.008	0.01	0.008	0.008
4	>13000	-	Tool steel	H13 H21	590	0.004	0.005	0.006	0.007	0.007	0.008	0.007	0.007
4.1	-	-	HSS		260	0.003	0.004	0.005	0.006	-	-	0.006	-
5	-	250	Special alloy: Inconel, Hastelloy, Nimonic, etc.	Inconel® 718 Nimonic® 80A	110	0.002	0.003	0.004	0.005	0.005	0.005	0.005	0.005
5.1	5800	-	Titanium, Titanium alloy	AMS R54520	260	0.002	0.003	0.004	0.005	0.005	0.005	0.005	0.005
6	<87000	-	Stainless steel: austenitic 300 series	3041 316	590	0.003	0.004	0.005	0.006	0.006	0.006	0.006	0.006
6.1	<130000	-	Stainless steel	630	520	0.003	0.003	0.005	0.006	0.006	0.008	0.006	0.006
7	>130000	-	Stainless steel: martensitic/ferritic 400 series	420 403	520	0.002	0.003	0.004	0.005	0.005	0.006	0.005	0.005
8	-	180	Grey cast iron	No 35b No 50 b	660	0.006	0.006	0.01	0.012	0.012	0.012	0.012	0.012

If you do not see your material listed, please call for our complete speed & feed chart

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