

Carbide Solid Drill for Non-ferrous metals and Mild steel Machining

SSD-N

KORLOY
TECH-NEWS



- Stable drilling for high productivity
- Available for various workpieces such as mild steel and non-ferrous metals

Carbide Solid Drill for Non-ferrous metal and Mild steel Machining

SSD-N

The non-ferrous metals (aluminum and copper etc.) having lower melting point than other metals causes welding to easily occur in machining. That dulls the cutting edge of the tool and lowers the surface finish and chip evacuation and increases the cutting load which causes unexpected chipping and breakage of tools.

KORLOY launches a new drill for high performance in non-ferrous metals drilling.

The **SSD-N** with sharp cutting edge minimizes welding. In addition, the design for better chip control and X-shaped thinning increases machinability and chip evacuation drastically.

The SSD-N drill increases your productivity by stable machinability in machining of non-ferrous metals and mild steel etc.



Good surface finish

- Minimized welding in machining from the sharp cutting edge

Improved machinability

- Lower cutting load by applying the X-shaped thinning

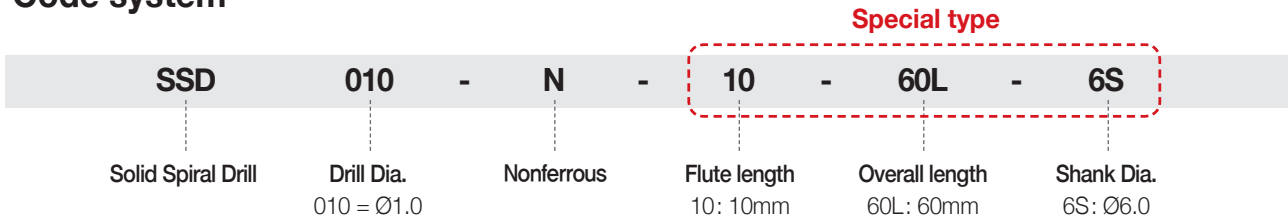
Better chip evacuation

- The design for reinforced chip control

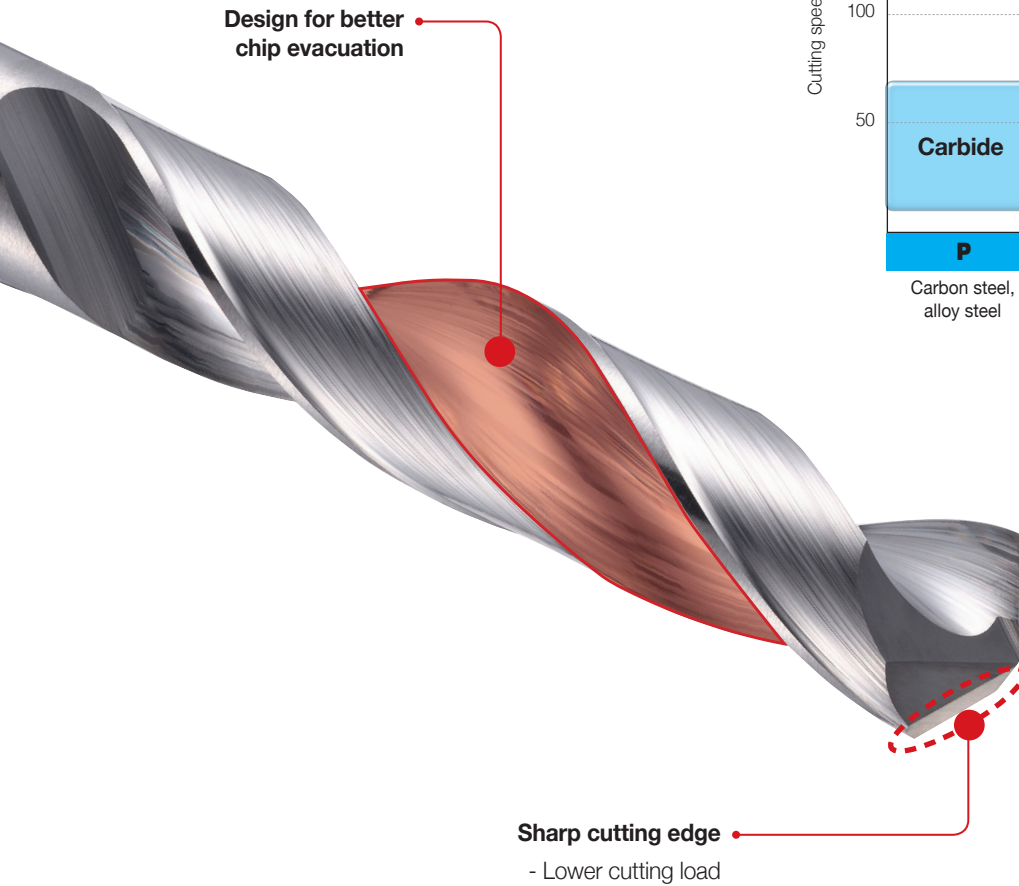
Various workpiece machining

- Non-ferrous metals and mild steel etc.

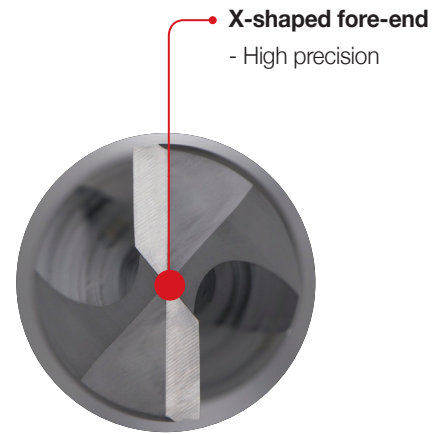
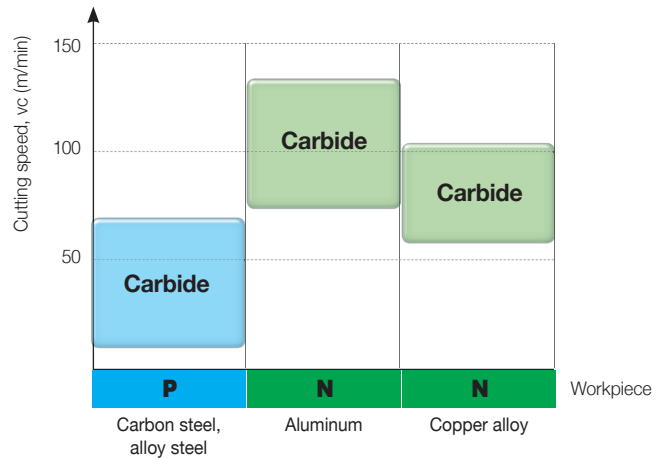
Code system



Features



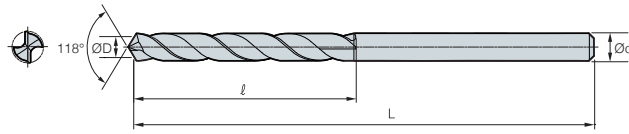
Application range



Recommended cutting conditions

Workpiece				Grade	Cutting speed vc (m/min)	Feed rate (mm/rev) per drill dia. (mm)			
ISO	Materials	Hardness (HB)	Ø2.5 - Ø4.0			Ø4.1 - Ø8.0	Ø8.1 - Ø12.0	Ø12.1 - Ø15.0	
P	Carbon steel	Low carbon steel	80 - 120	Carbide	35 (20 - 65)	0.02 - 0.06	0.04 - 0.08	0.06 - 0.12	0.10 - 0.16
N	Aluminum	Aluminum alloy	30 - 150		100 (94 - 120)	0.03 - 0.06	0.05 - 0.08	0.08 - 0.12	0.12 - 0.18
N	Copper alloy	Copper alloy	150 - 160		80 (65 - 95)	0.03 - 0.06	0.05 - 0.08	0.08 - 0.12	0.12 - 0.18

SSD - N

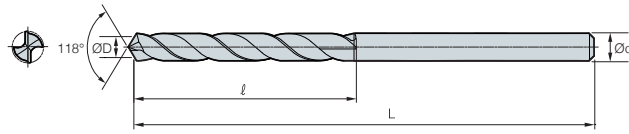


Coating	None
Tolerance (drill Dia.)	h8
Tolerance (shank Dia.)	h7
Point angle (θ°)	118°
Twist angle	30°
Thinning	X type
Coolant	External

(mm)

Designation	ØD	Ød	ℓ	L
SSD 010-N	1.0	1.0	10	38
011-N	1.1	1.1	10	38
012-N	1.2	1.2	10	38
013-N	1.3	1.3	13	38
014-N	1.4	1.4	13	38
015-N	1.5	1.5	13	38
016-N	1.6	1.6	13	38
017-N	1.7	1.7	13	38
018-N	1.8	1.8	13	38
019-N	1.9	1.9	13	38
020-N	2.0	2.0	16	45
021-N	2.1	2.1	16	45
022-N	2.2	2.2	16	45
023-N	2.3	2.3	16	45
024-N	2.4	2.4	18	50
025-N	2.5	2.5	20	50
026-N	2.6	2.6	20	50
027-N	2.7	2.7	22	50
028-N	2.8	2.8	22	50
029-N	2.9	2.9	22	50
030-N	3.0	3.0	22	50
031-N	3.1	3.1	25	50
032-N	3.2	3.2	25	50
033-N	3.3	3.3	25	50
034-N	3.4	3.4	25	50
035-N	3.5	3.5	25	50
036-N	3.6	3.6	28	55
037-N	3.7	3.7	28	55
038-N	3.8	3.8	28	55
039-N	3.9	3.9	28	55
040-N	4.0	4.0	28	55
041-N	4.1	4.1	30	60
042-N	4.2	4.2	30	60
043-N	4.3	4.3	30	60
044-N	4.4	4.4	30	60
045-N	4.5	4.5	30	60
046-N	4.6	4.6	33	65
047-N	4.7	4.7	33	65
048-N	4.8	4.8	35	65
049-N	4.9	4.9	35	65
050-N	5.0	5.0	35	65
051-N	5.1	5.1	35	65
052-N	5.2	5.2	35	65
053-N	5.3	5.3	35	65
054-N	5.4	5.4	35	65
055-N	5.5	5.5	35	65
056-N	5.6	5.6	38	75
057-N	5.7	5.7	38	75
058-N	5.8	5.8	38	75
059-N	5.9	5.9	38	75
060-N	6.0	6.0	38	75

SSD - N

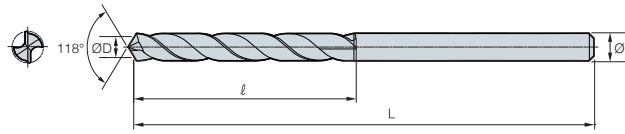


Coating	None
Tolerance (drill Dia.)	h8
Tolerance (shank Dia.)	h7
Point angle (θ°)	118°
Twist angle	30°
Thinning	X type
Coolant	External

(mm)

Designation	ØD	Ød	ℓ	L	
SSD	061-N	6.1	6.1	38	75
	062-N	6.2	6.2	38	75
	063-N	6.3	6.3	38	75
	064-N	6.4	6.4	38	75
	065-N	6.5	6.5	38	75
	066-N	6.6	6.6	45	80
	067-N	6.7	6.7	45	80
	068-N	6.8	6.8	45	80
	069-N	6.9	6.9	45	80
	070-N	7.0	7.0	45	80
	071-N	7.1	7.1	45	80
	072-N	7.2	7.2	45	80
	073-N	7.3	7.3	45	80
	074-N	7.4	7.4	45	80
	075-N	7.5	7.5	45	80
	076-N	7.6	7.6	50	85
	077-N	7.7	7.7	50	85
	078-N	7.8	7.8	50	85
	079-N	7.9	7.9	50	85
	080-N	8.0	8.0	50	85
	081-N	8.1	8.1	50	85
	082-N	8.2	8.2	50	85
	083-N	8.3	8.3	50	85
	084-N	8.4	8.4	50	85
	085-N	8.5	8.5	50	85
	086-N	8.6	8.6	50	95
	087-N	8.7	8.7	50	95
	088-N	8.8	8.8	50	95
	089-N	8.9	8.9	50	95
	090-N	9.0	9.0	50	95
091-N	9.1	9.1	50	95	
092-N	9.2	9.2	50	95	
093-N	9.3	9.3	50	95	
094-N	9.4	9.4	50	95	
095-N	9.5	9.5	50	95	
096-N	9.6	9.6	50	95	
097-N	9.7	9.7	50	95	
098-N	9.8	9.8	50	95	
099-N	9.9	9.9	55	100	
100-N	10.0	10.0	55	100	
101-N	10.1	10.1	55	115	
102-N	10.2	10.2	55	115	
103-N	10.3	10.3	55	115	
104-N	10.4	10.4	55	115	
105-N	10.5	10.5	55	115	
106-N	10.6	10.6	60	115	
107-N	10.7	10.7	60	115	
108-N	10.8	10.8	60	115	
109-N	10.9	10.9	60	115	
110-N	11.0	11.0	60	115	

SSD - N



Coating	None
Tolerance (drill Dia.)	h8
Tolerance (shank Dia.)	h7
Point angle (θ°)	118°
Twist angle	30°
Thinning	X type
Coolant	External

(mm)

Designation	ØD	Ød	l	L	
SSD	111-N	11.1	11.1	65	120
	112-N	11.2	11.2	65	120
	113-N	11.3	11.3	65	120
	115-N	11.5	11.5	65	120
	118-N	11.8	11.8	65	120
	119-N	11.9	11.9	65	120
	120-N	12.0	12.0	65	120
	124-N	12.4	12.4	70	125
	125-N	12.5	12.5	70	125
	130-N	13.0	13.0	75	130



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