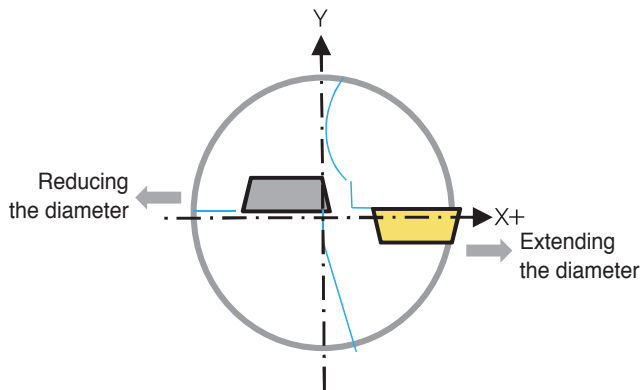


▶ Range of adjusting machining diameter in the lathe



- In machining in the lathe, the King Drill can extend and reduce the machining diameter with moving to the x axis. Please refer to the table showing the range of adjusting drilling diameter below.
- The more the drilling diameter is extended or reduced, the more the drill loses drilling balance. In this case, reduce the feed or cutting speed in machining.
- Reducing the machining diameter excessively could damage the holder.

Drill dia.	Range of adjusting drilling diameter(Ø)	Drill dia.	Range of adjusting drilling diameter(Ø)	Drill dia.	Range of adjusting drilling diameter(Ø)	Drill dia.	Range of adjusting drilling diameter(Ø)
12.0	11.7 ~12.4	24.5	23.9 ~25.1	37.0	36.3 ~37.7	49.5	48.7 ~50.2
12.5	12.2 ~12.9	25.0	24.4 ~25.6	37.5	36.8 ~38.2	50.0	49.2 ~50.7
13.0	12.7 ~13.4	25.5	24.9 ~26.1	38.0	37.3 ~38.7	50.5	49.7 ~51.2
13.5	13.2 ~13.9	26.0	25.4 ~26.6	38.5	37.8 ~39.2	51.0	50.2 ~51.7
14.0	13.6 ~14.5	26.5	25.9 ~27.1	39.0	38.3 ~39.7	51.5	50.7 ~52.2
14.5	14.1 ~15.0	27.0	26.4 ~27.6	39.5	38.8 ~40.2	52.0	51.2 ~52.7
15.0	14.6 ~15.5	27.5	26.9 ~28.1	40.0	39.3 ~40.7	52.5	51.7 ~53.2
15.5	15.1 ~16.0	27.8	27.4 ~28.6	40.5	39.8 ~41.2	53.0	52.2 ~53.7
16.0	15.6 ~16.5	28.5	27.9 ~29.1	41.0	40.3 ~41.7	53.5	52.7 ~54.2
16.5	16.0 ~17.0	29.0	28.4 ~29.6	41.5	40.8 ~42.2	54.0	53.2 ~54.7
17.0	16.5 ~17.5	29.5	28.9 ~30.1	42.0	41.3 ~42.7	54.5	53.7 ~55.2
17.5	17.0 ~18.0	30.0	29.3 ~30.7	42.5	41.8 ~43.2	55.0	54.2 ~55.7
18.0	17.5 ~18.5	30.5	29.8 ~31.2	43.0	42.2 ~43.7	55.5	54.7 ~56.2
18.5	18.0 ~19.0	31.0	30.3 ~31.7	43.5	42.7 ~44.2	56.0	55.2 ~56.7
19.0	18.5 ~19.5	31.5	30.8 ~32.2	44.0	43.2 ~44.7	56.5	55.7 ~57.2
19.5	19.0 ~20.0	32.0	31.3 ~32.7	44.5	43.7 ~45.2	57.0	56.2 ~57.7
20.0	19.4 ~20.6	32.5	31.8 ~33.2	45.0	44.2 ~45.7	57.5	56.7 ~58.2
20.5	19.9 ~21.1	33.0	32.3 ~33.7	45.5	44.7 ~46.2	58.0	57.2 ~58.7
21.0	20.4 ~21.6	33.5	32.8 ~34.2	46.0	45.2 ~46.7	58.5	57.7 ~59.2
21.5	20.9 ~22.1	34.0	33.3 ~34.7	46.5	45.7 ~47.2	59.0	58.2 ~59.7
22.0	21.4 ~22.6	34.5	33.8 ~35.2	47.0	46.2 ~47.7	59.5	58.7 ~60.2
22.5	21.9 ~23.1	35.0	34.3 ~35.7	47.5	46.7 ~48.2	60.0	59.2 ~60.7
23.0	22.4 ~23.6	35.5	34.8 ~36.2	48.0	47.2 ~48.7	60.5	59.7 ~61.2
23.5	22.9 ~24.1	36.0	35.3 ~36.7	48.5	47.7 ~49.2		
24.0	23.4 ~24.6	36.5	35.8 ~37.2	49.0	48.2 ~49.7		

▶ Insert and parts

Drill dia.	Peripheral insert	Central insert	Screw	Wrench	Torque(Nm)
Ø12.0~Ø13.5	SPMT040204-□□	XOMT040204-□□	FTNA0204	TW06P	0.4
Ø13.6~Ø16.0	SPMT050204-□□	XOMT050204-□□	FTNA0204	TW06P	0.4
Ø16.1~Ø19.5	SPMT060205-□□	XOMT060204-□□	FTKA02206S	TW07P	0.8
Ø19.6~Ø23.5	SPMT07T208-□□	XOMT07T205-□□	FTKA02565	TW07S	0.8
Ø23.6~Ø29.5	SPMT090308-□□	XOMT090305-□□	FTKA0307	TW09S	1.2
Ø29.6~Ø35.5	SPMT11T308-□□	XOMT11T306-□□	FTKA03508	TW15S	3
Ø35.6~Ø42.5	SPMT130410-□□	XOMT130406-□□	FTKA0410	TW15S	3
Ø42.6~Ø50.5	SPMT15M510-□□	XOMT15M508-□□	FTNC04511	TW20S	5
Ø50.6~Ø60.5	SPMT180510-□□	XOMT180508-□□	FTNA0511	TW20-100	5

- In clamping an insert, please clean the tip seat and apply CASMOLY1000 on the screw.
- Please make sure to use a Korloy-produced wrench and screw only.