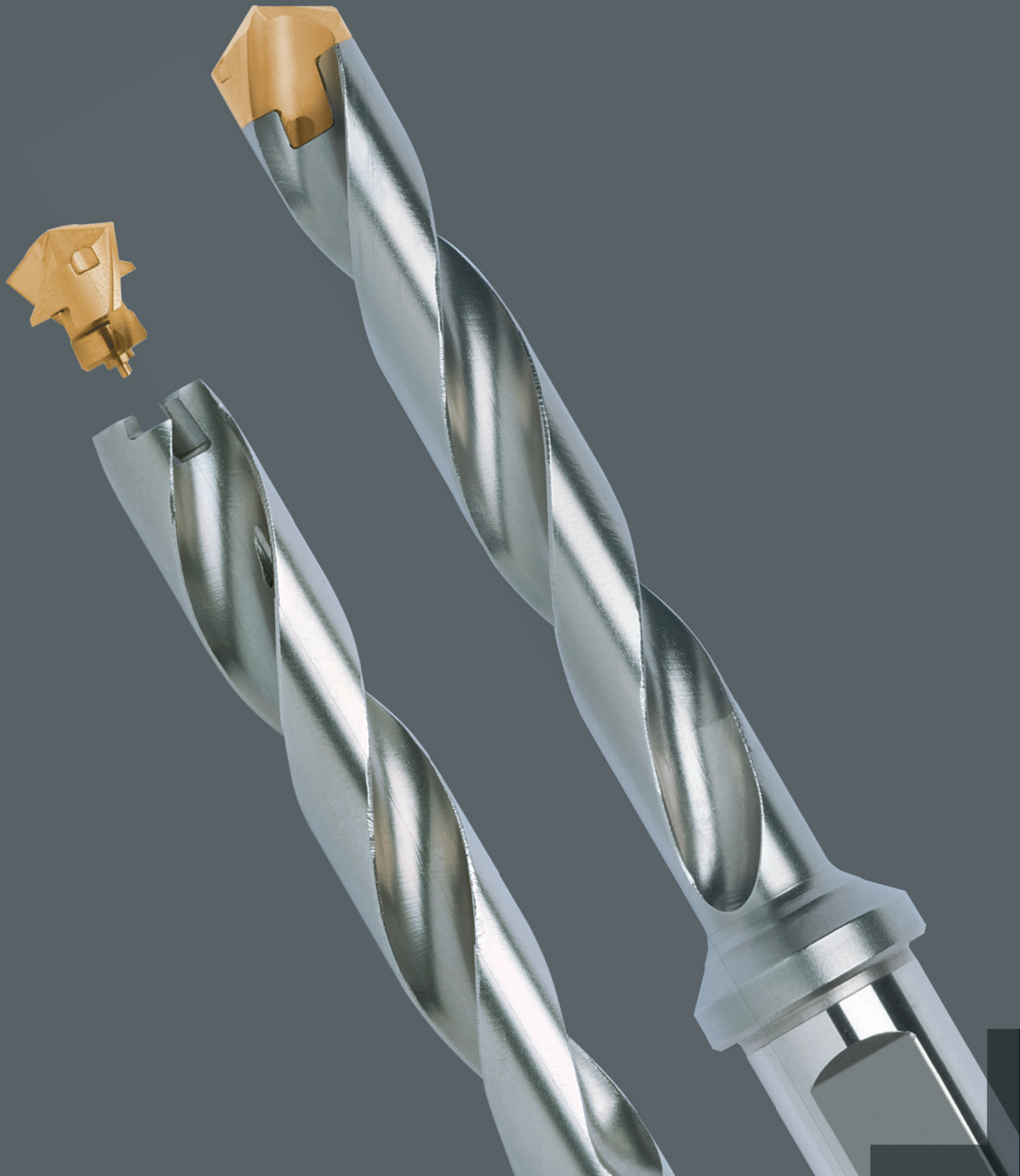


KOMET KUB K2™

Indexable heads for the smallest diameters



KOMET KUB K2™

Indexable heads for the smallest diameters

Applications:

- For diameter range 8 to 18.9 mm
- Suitable for use with steel, cast metal, aluminum and stainless materials
- Replaceable head system enables use with a wide variety of sections and coatings.

Benefits for you:

- **Easy replacement of the carbide drill heads**
even in the machine, with secure, user-friendly quick-change connector
- **Maximum performance and best possible feed**
with the latest coatings and high-end polished sections
- **Outstanding tension release properties**
with all materials, due to optimum surface quality of the cutting channels
- **Maximum performance and life of the main drill body**
due to a special surface treatment

KOMET KUB K2™ indexable head drill

With this new replaceable head system for the double-cutting KUB K2™, KOMET has introduced an ingenious system of replaceable drill heads.

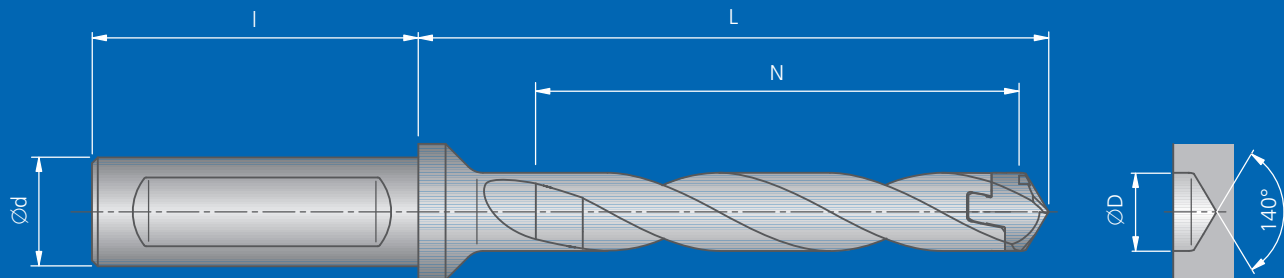
These now also make the most of the economic and flexibility advantages of replaceable cutting heads with small drilling diameters up to 8 mm.


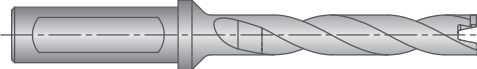
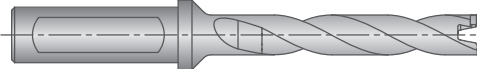
The double-cutting carbide drill heads have a patented self-fixing and self-centering attachment point making them very easy to change.

KOMET KUB K2™

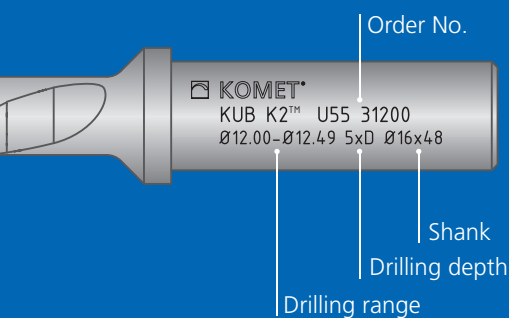
Ø 12.0 – 15.8 mm

Replaceable head drill (replaceable head/basic body) with cylindrical shank ISO 9677, R.H. cutting



Replaceable head					Basic body					Accessories	
ØD	Order No.		Coating	for workpiece material							Multi-key
				P	M	K	N	S	H		
8.0 ⋮ 12.0	Expanded version									Expanded version	L05 10020 size 2
12.3	H70 12000.01....	0.006	BK8425 BK2725								
12.4	H70 12300.01....	0.006									
12.5	H70 12400.01....	0.006									
12.8	H70 12500.01....	0.007	BK8425 BK2725								
13.0	H70 12800.01....	0.007									
13.5	H70 13000.01....	0.008	BK8425 BK2725								
13.8	H70 13500.01....	0.008									
14.0	H70 13800.01	0.008									
14.3	H70 14000.01	0.010	BK8425 BK2725								
14.4	H70 14300.01	0.010									
14.5	H70 14400.01	0.010									
14.8	H70 14500.01	0.010									
15.0	H70 14800.01	0.010	BK8425 BK2725								
15.5	H70 15000.01....	0.012									
15.8	H70 15500.01	0.012									
18.9	H70 15800.01	0.012									
⋮ 18.9	Expanded version										
											
3xD		5xD		7xD							
Order No.		dxl		L		N					

Supply includes: Please order replaceable head, basic body and multi-key separately



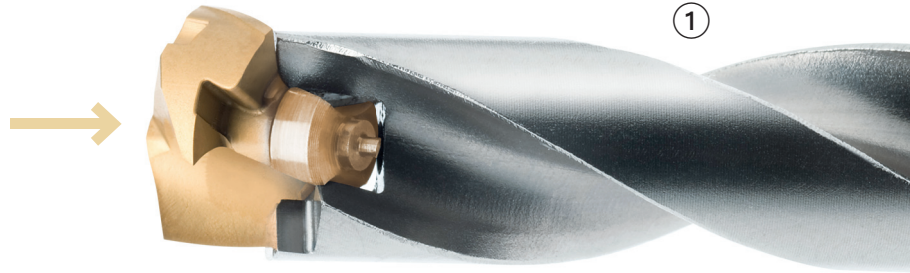
Patented design (KUB K2™)

KOMET KUB K2™

Fitting the indexable head



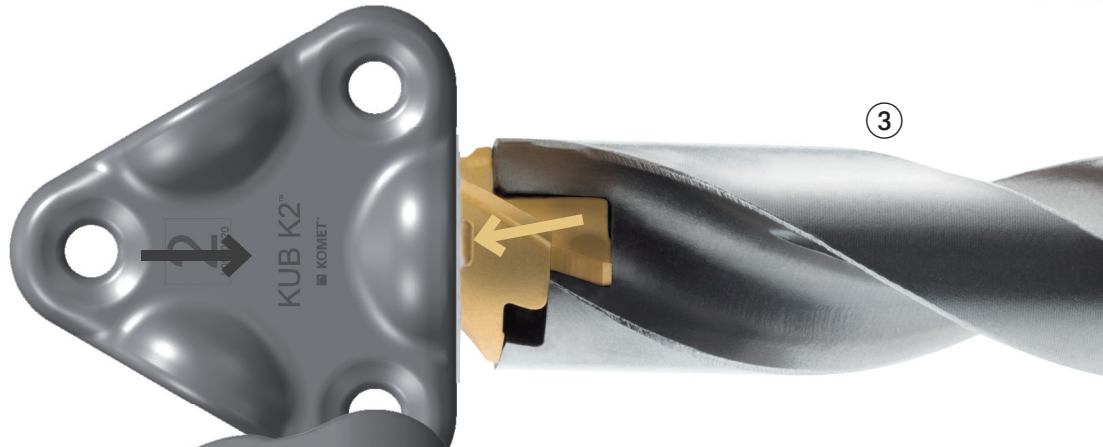
- ① Insert and remove the replaceable head at the attachment point.



- ② Turn the replaceable head manually until it slots into the attachment point.



- ③ Fit the multi-key over the assembly notch. Turn the replaceable head. In this position, the required torque is increased, as the replaceable head is screwed in position.



- ④ Turn the replaceable head until it stops.



- ⑤ Fully fitted replaceable head.



The multi-key is also used to remove the replaceable head. In order to ensure a secure fit, the main body should be fixed in place when screwing the head in or out.

KOMET KUB K2™

Guideline values for solid drilling

Material group						KUB K2™ 5xD											
						Cutting speed v _c (m/min)						Feed f (mm/U)					
Material						Ø8–11.9			Ø12–14.9			Ø16–18.9					
Example material code/DIN						min	opt.	max	min	opt.	max	min	opt.	max			
P	1.0	≤ 500		non-alloy steels	St37-2/1.0037 9SMn28/1.0715 St44-2/1.0044	90	110	130					0.15	0.20	0.25	Expanded version	
	2.0	500-900		non-alloy / low alloy steels	St52-2 / 1.0050 C55 / 1.0525 16MnCr5 / 1.7131	80	100	120					0.15	0.20	0.25		
	2.1	< 500		lead alloys	9SMnPb28 / 1.0718	80	100	120					0.20	0.25	0.30		
	3.0	> 900		non alloy / low alloy steels: heat resostant structural, heat treated, nitride and tools steels	42CrMo4 / 1.7225 CK60 / 1.1221	70	90	110					0.20	0.25	0.30		
	4.0	> 900		high alloy steels	X6CrMo4 / 1.2341 X165CrMoV12/1.2601	50	70	90					0.15	0.20	0.25		
M	6.0	≤ 600		stainless steels	X2CrNi189 / 1.4306 X5CrNiMo1810/1.4401				50	70	90		0.15	0.20	0.25		
	6.1	< 900		stainless steels	X8CrNb17/1.4511 X10CrNiMoTi1810/1.4571				40	60	80		0.18	0.20	0.22		
	7.0	> 900		stainless / fireproof steels	X10CrAl7 / 1.4713 X8CrS-38-18/1.4862				30	50	70		0.16	0.18	0.20		
K	8.0		180	gray cast iron	GG-25/0.6025 GG-35/0.6035	70	90	110					0.20	0.30	0.40		
	8.1		250	alloy gray cast iron	GG-NiCr202 / 0.6660	60	80	100					0.20	0.30	0.40		
	9.0	≤ 600	130	spheroidal graphite cast iron, ferritic	GGG-40 / 0.7040	60	80	100					0.25	0.35	0.45		
	9.1		230	spheroidal graphite cast iron, ferritic/perlitic	GGG-50 / 0.7050 GGG-55 / 0.7055 GTW-55 / 0.8055	50	70	90					0.25	0.35	0.45		
	10.0	> 600	250	spheroidal graphite cast iron, perlitic malleable iron	GGG-60 / 0.7060 GTS-65 / 0.8165	50	70	90					0.25	0.35	0.45		
	10.1		200	alloyed spheroidal graphite cast iron	GGG-NiCr20-2 /0.7661	30	50	70					0.20	0.25	0.35		
	10.2		300	vermicular cast iron	GGV Ti < 0,2 GGV Ti > 0,2	40	60	80					0.25	0.35	0.45		

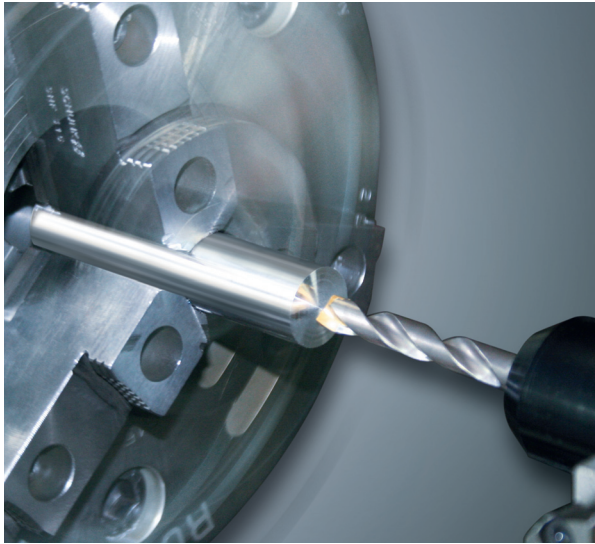
Note: The application details shown depend on the environmental and application conditions (e.g. machine, ambient temperature, use of lubricant/coolant and the machining result required). These are subject to correct operating conditions, correct application and compliance with the spindle speed limits given for the tools.

KOMET KUB K2™

Application examples



Stationary application in a cyclically-controlled lathe



Material: 42CrMo4
 $v_c = 90 \text{ m/min}$; $f = 0.22 \text{ mm/rev}$




Rotating application in a machining center




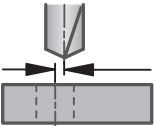
Material: 1.4571, V4A
 $v_c = 70 \text{ m/min}$; $f = 0.2 \text{ mm/rev}$

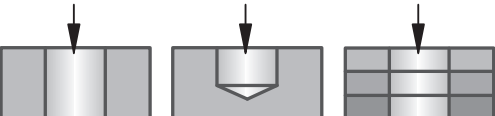


Recommendations

1.  **Coolant**
 - internal coolant supply min. 5 bar

2.  **Rotating application**
 - max. concentricity in rotating application 0.05 mm

3.  **Stationary application**
 - max. offset in stationary application 0.025 mm

4.  **For through holes, blind holes and stack plate drilling**

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