



# SPIDC

**SPEED**

**INDEXABLE**

**DRILL**

Importatore per l'Italia

**F.T.K.**  
**TOOLS**

  
**CE  
RA** **TIGER**  
TOOLING SYSTEM  
[WWW.KCERA.KR](http://WWW.KCERA.KR)

## SPIDC DRILL

- High efficient indexable drill
- Hardened alloy steel material
- Best design for chip evacuation
- Coolant hole
- Economical 4 corners (SP○○○)



## SPIDC DRILL HOLDER NAMING

# SPIDC 000-OD-S00-SP00

**SPEED  
INDEXABLE  
DRILL**

Ø Dia'

Aspect  
ratio  
(L/D)

Ø Shank Dia'

Insert spec

Ø12.5~60.0  
(10mm interval  
over Ø40 drill)

2 ~ 5D

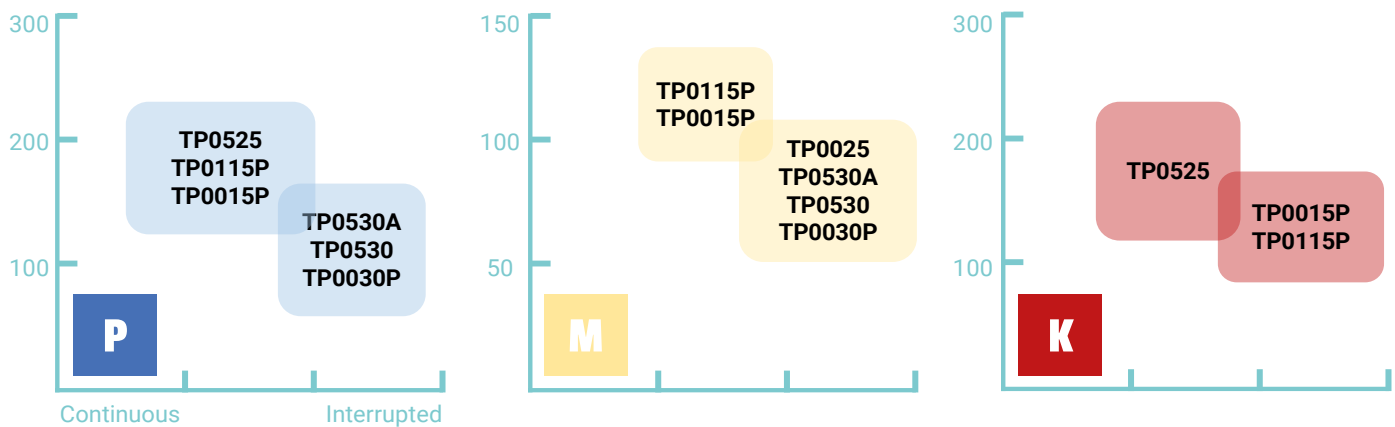
Ø20 / 25 /  
32 / 40

SPMG & SPGT  
05/ 06/ 07/  
09/ 11/ 14

## INSERT FEATURE & GRADE RANGE



- SPMG & SPGT(grinding type)
- Various grades



## INSERT GRADE FEATURE

Grade	ISO	Color	Feature
<b>TP0015P</b>	P25~P35 M10~M20 K25~K35 S05~S15	Copper	<ul style="list-style-type: none"> <li>• PVD Coated - TiAlSiN, Premium grade</li> <li>• As adapting micro grained substrate which has great impact resistance, Excellent in the universal machining of stainless steel</li> <li>• As adapting SALINA coating which has excellent resistance for thermal &amp; oxidation, it is recommended on high speed milling in mould</li> <li>• P(Steel) in and ext' insert / M(Stainless Steel) in and ext' insert / K(Cast iron) Int'</li> </ul>
<b>TP0115P</b>	P25~P35 M10~M20 K25~K35 S05~S15	Black	<ul style="list-style-type: none"> <li>• PVD Coated - AlTiN, Premium grade</li> <li>• As adapting micro grained substrate which has great impact resistance, Excellent in the universal machining of stainless steel</li> <li>• As adapting Balzers coating which has excellent adhesion, it is recommended on high speed milling in mould</li> <li>• P(Steel) in and ext' insert / M(Stainless Steel) in and ext' insert / K(Cast iron) Int'</li> </ul>
<b>TP0025</b>	M20~M30 S15~S25	Yellow	<ul style="list-style-type: none"> <li>• PVD Coated - TiN + TiAlN</li> <li>• Superior universal grade to cover all kinds of work piece like stainless steel and alloy steel, cast iron both continuous &amp; interrupted cutting condition</li> <li>• P(Steel) Int' / M(Stainless Steel) in and ext' insert</li> </ul>
<b>TP0525</b>	P15~P35 K15~K35	Black	<ul style="list-style-type: none"> <li>• PVD Coating- Advanced AlTiN</li> <li>• Optimization for grooving and drilling due to combining the substrate of superior wear resistance and toughness with the coating of excellent oxidation/chipping resistance</li> <li>• P(Steel) in and ext' insert / K(Cast iron) in and ext' insert</li> </ul>
<b>TP0530</b>	M15~M35	Black	<ul style="list-style-type: none"> <li>• PVD Coating - Advanced AlTiN (TP0530) / AlTiN+TiN (TP0530A)</li> <li>• Optimization for the interrupted grooving and drilling due to combining the substrate of superior wear resistance and toughness with the coating of excellent oxidation/chipping resistance</li> <li>• P(Steel) in and ext' insert / M(Stainless Steel) in and ext' insert</li> </ul>
<b>TP0530A</b>	P25~P35 S15~S25	Yellow	
<b>TP0030P</b>	P30~P40 M20~M30 S15~S25	Dark Cooper	<ul style="list-style-type: none"> <li>• PVD Coating- Advanced AlTiN</li> <li>• Optimization for the interrupted grooving and drilling due to combining the substrate of superior wear resistance and toughness with the coating of excellent oxidation/chipping resistance</li> <li>• P(Steel) in and ext' insert / M(Stainless Steel) in and ext' insert</li> </ul>

## INSERT LINE-UP

Designation	TP0015P	TP0115P	TP0025	TP0525	TP0530	TP0530A	TP0030P
SPMG050204-TT			●	●		●	
SPMG060204-TT			●	●		●	
SPMG07T308-TT			●	●		●	
SPMG090408-TT			●	●		●	
SPMG110408-TT			●	●		●	
SPMG140512-TT			●	●		●	
SPGT050204-TT1	●	●					●
SPGT060204-TT1	●	●					●
SPGT07T308-TT1	●	●					●
SPGT090408-TT1	●	●					●
SPGT110408-TT1	●	●					●
SPGT140512-TT1	●	●					●

● : Stock

## CHIP BREAKER LINE-UP



TT1

Best design for chip evacuation in stainless steel cut

Optimized chip breaker for mild steel and stainless steel



TT

Optimized chip breaker for multi purposed drill cut

## INT' & EXT' GRADE COMBINATION

ISO	Internal grade	External grade
<b>P</b>	<b>WE RECOMMEND</b> TP0015P TP0115P	TP0015P TP0115P
	TP0025	TP0525
	<b>WE RECOMMEND</b> TP0525	
	TP0530	
<b>M</b>	TP0015P TP0115P	TP0015P TP0115P
	TP0025	TP0025
	<b>WE RECOMMEND</b> TP0530 TP0530A	TP0530 TP0530A
	<b>WE RECOMMEND</b> TP0030P	TP0030P
<b>K</b>	TP0015P	TP0525
	TP0115P	
	<b>WE RECOMMEND</b> TP0525	

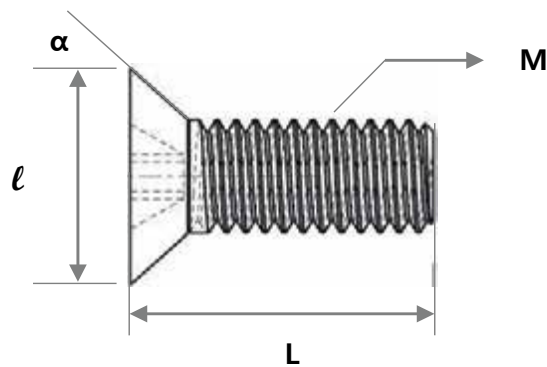
## RECOMMENDED CUTTING CONDITION

ISO	Material	Dia. (mm)	Ø12~16		Ø17~23		Ø24~29		Ø30~42		Ø43~60	
			Vc (m/min)	fn (mm/rev)	Vc (m/min)	fn (mm/rev)	Vc (m/min)	fn (mm/rev)	Vc (m/min)	fn (mm/rev)	Vc (m/min)	fn (mm/rev)
<b>P</b>	Carbon Steel	<b>Condition</b>	80~220	0.04~0.10	80~220	0.05~0.13	80~220	0.05~0.15	80~220	0.05~0.20	80~220	0.05~0.20
	Alloy Steel		80~220	0.04~0.10	80~220	0.05~0.13	80~220	0.05~0.15	80~220	0.05~0.20	80~220	0.05~0.20
	Free Harden Steel		80~180	0.04~0.08	80~180	0.04~0.10	80~180	0.05~0.12	80~180	0.05~0.15	80~180	0.05~0.15
<b>M</b>	Stainless Steel		80~160	0.04~0.08	80~160	0.04~0.08	80~160	0.04~0.10	80~160	0.04~0.10	80~160	0.04~0.10
	HRSA		80~130	0.04~0.06	80~130	0.04~0.06	80~130	0.04~0.08	80~130	0.04~0.08	80~130	0.04~0.08
<b>K</b>	FC / GC		100~250	0.04~0.12	100~250	0.05~0.14	100~250	0.05~0.18	100~250	0.05~0.22	100~250	0.05~0.25
	FCD / GCD		100~200	0.04~0.10	100~200	0.05~0.12	100~200	0.05~0.16	100~200	0.05~0.18	100~200	0.05~0.20

## HOLE TOLERANCE AFTER DRILLING

Aspect ratio (L/D)	Tolerance (mm)		Total tolerance (mm)
	min	max	
<b>2D</b>	-0.1	+0.2	0.3
<b>3D</b>	-0.1	+0.3	0.4
<b>4D</b>	-0.1	+0.4	0.5
<b>5D</b>	-0.1	+0.4	0.5

## INSERT CLAMPING SCREW

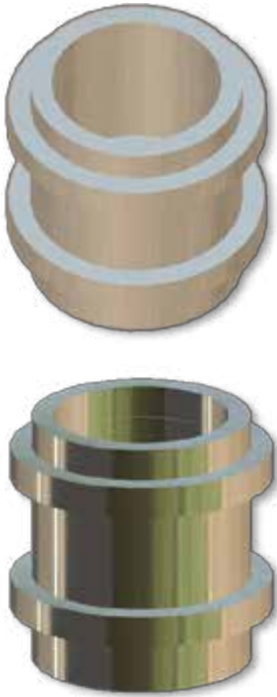


Insert	Tap (M)	Length (l)	Length (L)	Taper angle (α)	Wrench
SPMG050204	M2.2	2.7	5	60	T6
SPMG060204	M2.2	3	6	60	T7
SPMG07T308	M2.5	3.6	8	60	T8
SPMG090408	M3.5	5.2	10	48	T15
SPMG110408	M4	5.7	10	60	T15
SPMG140512	M5	6.8	12	60	T20

## PERFORMANCE TEST #1

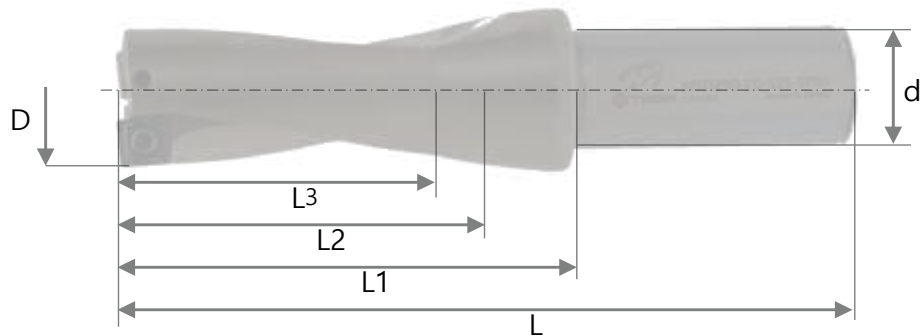
	Work piece	Part	BUSH			
		Material	SCM415H			
		Work	DRILL			
Cutting Condition	L/D & Holder	Vc	Fn	Ap	Coolant	
		(m/min)	(mm/rev)	(mm)		
	3D / 27mm	125	0.12		WET	
Result	SPMG090408-DG TT9030			80 PCS		
	SPGT090408-TT1 TP0115P			95 PCS		

## PERFORMANCE TEST #2

	Work piece	Part	MACHINERY PART			
		Material	SUS316			
		Work	DRILL			
Cutting Condition	L/D & Holder	Vc	Fn	Ap	Coolant	
		(m/min)	(mm/rev)	(mm)		
	3D / 25.5mm	85	0.13	59	Y	
Result	ZCMT080304 PR1225			35 PCS		
	SPMG07T308 -TT1 TP0530A			48 PCS		



## 2D DRILL HOLDER



Designation	CP CODE	D	L	L1	L2	L3	d	INSERT	Clamping screw	Wrench
SPIDC125-2D-S20-SP05	03080001	12.5	105	55	30	25	20	SPMG/SPGT 050204	M2.2X5	T6
SPIDC130-2D-S20-SP05	03080004	13	106	56	31	26				
SPIDC135-2D-S20-SP05	03080007	13.5	107	57	32	27				
SPIDC140-2D-S25-SP05	03080010	14	114	58	33	28				
SPIDC145-2D-S25-SP05	03080013	14.5	115	59	34	29				
SPIDC150-2D-S25-SP05	03080016	15	116	60	35	30				
SPIDC155-2D-S25-SP05	03080019	15.5	117	61	36	31				
SPIDC160-2D-S25-SP06	03080022	16	118	62	37	32				
SPIDC165-2D-S25-SP06	03080025	16.5	119	63	38	33				
SPIDC170-2D-S25-SP06	03080028	17	120	64	39	34				
SPIDC175-2D-S25-SP06	03080031	17.5	121	65	40	35				
SPIDC180-2D-S25-SP06	03080034	18	122	66	41	36				
SPIDC185-2D-S25-SP06	03080037	18.5	123	67	42	37	25	SPMG/SPGT 060204	M2.2X6	T7
SPIDC190-2D-S25-SP06	03080040	19	124	68	43	38				
SPIDC195-2D-S25-SP06	03080043	19.5	125	69	44	39				
SPIDC200-2D-S25-SP06	03080046	20	126	70	45	40				
SPIDC205-2D-S25-SP06	03080049	20.5	127	71	46	41				
SPIDC210-2D-S25-SP06	03080052	21	133	77	47	42				
SPIDC215-2D-S25-SP06	03080055	21.5	134	78	48	43				
SPIDC220-2D-S25-SP07	03080058	22	135	79	49	44				
SPIDC225-2D-S25-SP07	03080061	22.5	136	80	50	45				
SPIDC230-2D-S25-SP07	03080064	23	137	81	51	46				
SPIDC235-2D-S25-SP07	03080067	23.5	138	82	52	47				
SPIDC240-2D-S25-SP07	03080070	24	139	83	53	48				
SPIDC245-2D-S25-SP07	03080073	24.5	140	84	54	49				
SPIDC250-2D-S25-SP07	03080076	25	141	85	55	50				
SPIDC255-2D-S32-SP07	03080079	25.5	146	86	56	51				
SPIDC260-2D-S32-SP07	03080082	26	147	87	57	52				
SPIDC265-2D-S32-SP07	03080085	26.5	147.5	88	58	53				
SPIDC270-2D-S32-SP07	03080088	27	149	89	59	54				
SPIDC275-2D-S32-SP07	03080091	27.5	150	90	60	55				
SPIDC280-2D-S32-SP09	03080094	28	151	91	61	56				
SPIDC285-2D-S32-SP09	03080097	28.5	152	92	62	57				
SPIDC290-2D-S32-SP09	03080100	29	153	93	63	58				
SPIDC295-2D-S32-SP09	03080103	29.5	154	94	64	59				
SPIDC300-2D-S32-SP09	03080106	30	155	95	65	60				
SPIDC295-2D-S32-SP09	03080103	29.5	154	94	64	59	32	SPMG/SPGT 090408	M3.5X10	T15
SPIDC290-2D-S32-SP09	03080097	28.5	152	92	62	57				

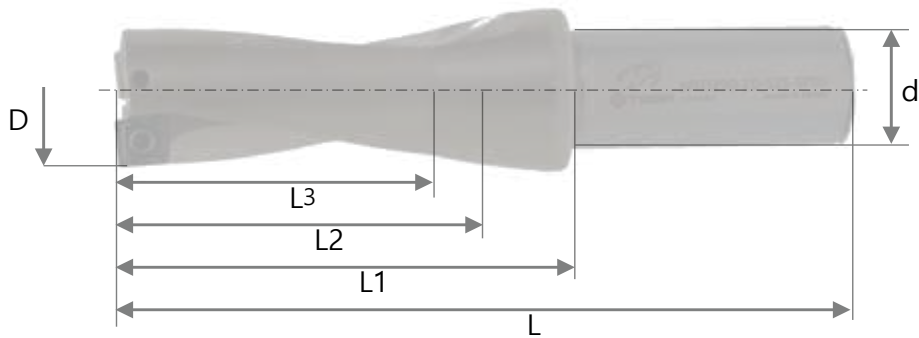


## 2D DRILL HOLDER



Designation	CP CODE	D	L	L1	L2	L3	d	INSERT	Clamping screw	Wrench
SPIDC305-2D-S32-SP09	03080109	30.5	156	96	66	61	32	SPMG/SPGT 090408	M3.5X10	T15
SPIDC310-2D-S32-SP09	03080112	31	157	97	67	62				
SPIDC315-2D-S32-SP09	03080115	31.5	158	98	68	63				
SPIDC320-2D-S32-SP09	03080118	32	159	99	69	64				
SPIDC325-2D-S32-SP09	03080121	32.5	160	100	70	65				
SPIDC330-2D-S32-SP09	03080124	33	161	101	71	66				
SPIDC335-2D-S32-SP09	03080127	33.5	162	102	72	67				
SPIDC340-2D-S32-SP11	03080130	34	163	103	73	68				
SPIDC345-2D-S32-SP11	03080133	34.5	157	97	90	69				
SPIDC350-2D-S32-SP11	03080136	35	165	105	75	70				
SPIDC355-2D-S32-SP11	03080139	35.5	159	99	92	71				
SPIDC360-2D-S32-SP11	03080142	36	167	107	77	72				
SPIDC365-2D-S32-SP11	03080145	36.5	161	101	94	73				
SPIDC370-2D-S32-SP11	03080148	37	169	109	79	74				
SPIDC375-2D-S32-SP11	03080151	37.5	162	102	96	75				
SPIDC380-2D-S32-SP11	03080154	38	171	111	81	76				
SPIDC385-2D-S32-SP11	03080157	38.5	164	104	90	77				
SPIDC390-2D-S32-SP11	03080160	39	173	113	83	78				
SPIDC395-2D-S32-SP11	03080163	39.5	166	106	100	79				
SPIDC400-2D-S32-SP11	03080166	40	175	115	85	80				
SPIDC410-2D-S32-SP11	03080169	41	177	117	87	82				
SPIDC420-2D-S40-SP14	03080172	42	189	119	89	84	40	SPMG/SPGT 140512	M5X12	T20
SPIDC430-2D-S40-SP14	03080175	43	196	126	91	86				
SPIDC440-2D-S40-SP14	03080178	44	198	128	93	88				
SPIDC450-2D-S40-SP14	03080181	45	200	130	95	90				
SPIDC460-2D-S40-SP14	03080184	46	202	132	97	92				
SPIDC470-2D-S40-SP14	03080187	47	204	134	99	94				
SPIDC480-2D-S40-SP14	03080190	48	206	136	101	96				
SPIDC490-2D-S40-SP14	03080193	49	208	138	103	98				
SPIDC500-2D-S40-SP14	03080196	50	210	140	105	100				
SPIDC510-2D-S40-SP07	03080438	51	202	132	125	102				
SPIDC520-2D-S40-SP07	03080439	52	204	134	127	104				
SPIDC530-2D-S40-SP07	03080440	53	206	136	129	106				
SPIDC540-2D-S40-SP07	03080441	54	208	138	131	108				
SPIDC550-2D-S40-SP09	03080442	55	210	140	133	110				
SPIDC560-2D-S40-SP09	03080443	56	212	142	135	112				
SPIDC570-2D-S40-SP09	03080444	57	214	144	137	114				
SPIDC580-2D-S40-SP09	03080445	58	216	146	139	116				
SPIDC590-2D-S40-SP09	03080446	59	218	148	141	118				
SPIDC600-2D-S40-SP09	03080447	60	220	150	143	120				
								SPMG/SPGT 07T308	M2.5X8	T8
								SPMG/SPGT 090408	M3.5X10	T15

# 3D DRILL HOLDER



Designation	CP CODE	D	L	L1	L2	L3	d	INSERT	Clamping screw	Wrench
SPIDC125-3D-S20-SP05	03080002	12.5	117.5	67.5	42.5	37.5	20	SPMG/SPGT 050204	M2.2X5	T6
SPIDC130-3D-S20-SP05	03080005	13	119	69	44	39				
SPIDC135-3D-S20-SP05	03080008	13.5	120.6	70.5	45.5	40.5				
SPIDC140-3D-S25-SP05	03080011	14	128	72	47	42				
SPIDC145-3D-S25-SP05	03080014	14.5	129.5	73.5	48.5	43.5				
SPIDC150-3D-S25-SP05	03080017	15	131	75	50	45				
SPIDC155-3D-S25-SP05	03080020	15.5	132.5	76.5	51.5	46.5				
SPIDC160-3D-S25-SP06	03080023	16	134	78	53	48				
SPIDC165-3D-S25-SP06	03080026	16.5	135.5	79.5	54.5	49.5				
SPIDC170-3D-S25-SP06	03080029	17	137	81	56	51				
SPIDC175-3D-S25-SP06	03080032	17.5	138.5	82.5	57.5	52.5	25	SPMG/SPGT 060204	M2.2X6	T7
SPIDC180-3D-S25-SP06	03080035	18	140	84	59	54				
SPIDC185-3D-S25-SP06	03080038	18.5	141.5	85.5	60.5	55.5				
SPIDC190-3D-S25-SP06	03080041	19	143	87	62	57				
SPIDC195-3D-S25-SP06	03080044	19.5	144.5	88.5	63.5	58.5				
SPIDC200-3D-S25-SP06	03080047	20	146	90	65	60				
SPIDC205-3D-S25-SP06	03080050	20.5	147.5	91.5	66.5	61.5				
SPIDC210-3D-S25-SP06	03080053	21	154	98	68	63				
SPIDC215-3D-S25-SP06	03080056	21.5	155.5	99.5	69.5	64.5				
SPIDC220-3D-S25-SP07	03080059	22	157	101	71	66				
SPIDC225-3D-S25-SP07	03080062	22.5	158.5	102.5	72.5	67.5				
SPIDC230-3D-S25-SP07	03080065	23	160	104	74	69				
SPIDC235-3D-S25-SP07	03080068	23.5	161.5	105.5	75.5	70.5				
SPIDC240-3D-S25-SP07	03080071	24	163	107	77	72				
SPIDC245-3D-S25-SP07	03080074	24.5	164.5	108.5	78.5	73.5				
SPIDC250-3D-S25-SP07	03080077	25	166	110	80	75				
SPIDC255-3D-S32-SP07	03080080	25.5	171.5	111.5	81.5	76.5				
SPIDC260-3D-S32-SP07	03080083	26	173	113	83	78				
SPIDC265-3D-S32-SP07	03080086	26.5	174	114.5	84.5	79.5				
SPIDC270-3D-S32-SP07	03080089	27	176	116	86	81	SPMG/SPGT 090408	M3.5X10	T15	
SPIDC275-3D-S32-SP07	03080092	27.5	177.5	117.5	87.5	82.5				
SPIDC280-3D-S32-SP09	03080095	28	179	119	89	84				
SPIDC285-3D-S32-SP09	03080098	28.5	180.5	120.5	90.5	85.5				
SPIDC290-3D-S32-SP09	03080101	29	182	122	92	87				
SPIDC295-3D-S32-SP09	03080104	29.5	183.5	123.5	93.5	88.5				
SPIDC300-3D-S32-SP09	03080107	30	185	125	95	90				

# 3D DRILL HOLDER



Designation	CP CODE	D	L	L1	L2	L3	d	INSERT	Clamping screw	Wrench
SPIDC305-3D-S32-SP09	03080110	30.5	186.5	126.5	96.5	91.5	32	SPMG/SPGT 090408	M3.5X10	T15
SPIDC310-3D-S32-SP09	03080113	31	188	128	98	93				
SPIDC315-3D-S32-SP09	03080116	31.5	189.5	129.5	99.5	94.5				
SPIDC320-3D-S32-SP09	03080119	32	191	131	101	96				
SPIDC325-3D-S32-SP09	03080122	32.5	192.5	132.5	102.5	97.5				
SPIDC330-3D-S32-SP09	03080125	33	194	134	104	99				
SPIDC335-3D-S32-SP09	03080128	33.5	195.5	135.5	105.5	100.5				
SPIDC340-3D-S32-SP11	03080131	34	197	137	107	102				
SPIDC345-3D-S32-SP11	03080134	34.5	191.5	131.5	124.5	103.5				
SPIDC350-3D-S32-SP11	03080137	35	200	140	110	105				
SPIDC355-3D-S32-SP11	03080140	35.5	194.5	134.5	127.5	106.5				
SPIDC360-3D-S32-SP11	03080143	36	203	143	113	108				
SPIDC365-3D-S32-SP11	03080146	36.5	197.5	137.5	130.5	109.5				
SPIDC370-3D-S32-SP11	03080149	37	206	146	116	111				
SPIDC375-3D-S32-SP11	03080152	37.5	199.5	139.5	132.5	112.5				
SPIDC380-3D-S32-SP11	03080155	38	209	149	119	114				
SPIDC385-3D-S32-SP11	03080158	38.5	202.5	142.5	135.5	115.5				
SPIDC390-3D-S32-SP11	03080161	39	212	152	122	117				
SPIDC395-3D-S32-SP11	03080164	39.5	205.5	145.5	138.5	118.5				
SPIDC400-3D-S32-SP11	03080167	40	215	155	125	120				
SPIDC410-3D-S32-SP11	03080170	41	218	158	128	123				
SPIDC420-3D-S40-SP14	03080173	42	231	161	131	126	40	SPMG/SPGT 140512	M5X12	T20
SPIDC430-3D-S40-SP14	03080176	43	239	169	134	129				
SPIDC440-3D-S40-SP14	03080179	44	242	172	137	132				
SPIDC450-3D-S40-SP14	03080182	45	245	175	140	135				
SPIDC460-3D-S40-SP14	03080185	46	248	178	143	138				
SPIDC470-3D-S40-SP14	03080188	47	251	181	146	141				
SPIDC480-3D-S40-SP14	03080191	48	254	184	149	144				
SPIDC490-3D-S40-SP14	03080194	49	257	187	152	147				
SPIDC500-3D-S40-SP14	03080197	50	260	190	155	150				
SPIDC510-3D-S40-SP07	03080428	51	253	183	176	153				
SPIDC520-3D-S40-SP07	03080429	52	256	186	179	156				
SPIDC530-3D-S40-SP07	03080430	53	259	189	182	159				
SPIDC540-3D-S40-SP07	03080431	54	262	192	185	162				
SPIDC550-3D-S40-SP09	03080432	55	265	195	188	165				
SPIDC560-3D-S40-SP09	03080433	56	268	198	191	168				
SPIDC570-3D-S40-SP09	03080434	57	271	201	194	171				
SPIDC580-3D-S40-SP09	03080435	58	274	204	197	174				
SPIDC590-3D-S40-SP09	03080436	59	277	207	200	177				
SPIDC600-3D-S40-SP09	03080437	60	280	210	203	180				
								SPMG/SPGT 07T308	M2.5X8	T8
								SPMG/SPGT 090408	M3.5X10	T15

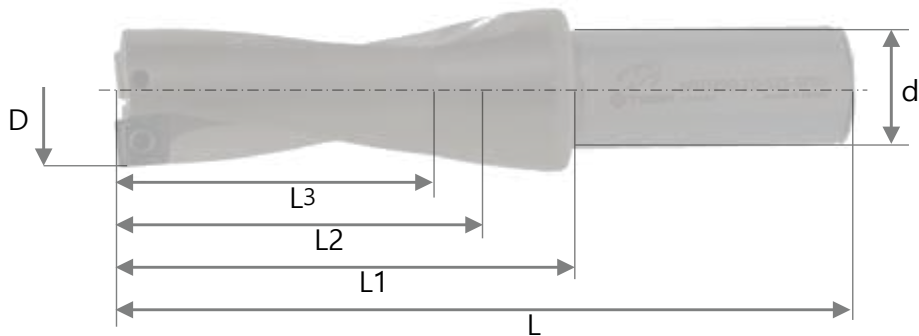


# 4D DRILL HOLDER



Designation	CP CODE	D	L	L1	L2	L3	d	INSERT	Clamping screw	Wrench
SPIDC305-4D-S32-SP09	03080111	30.5	217	157	127	122	32	SPMG/SPGT 090408	M3.5X10	T15
SPIDC310-4D-S32-SP09	03080114	31	219	159	129	124				
SPIDC315-4D-S32-SP09	03080117	31.5	221	161	131	126				
SPIDC320-4D-S32-SP09	03080120	32	223	163	133	128				
SPIDC325-4D-S32-SP09	03080123	32.5	225	165	135	130				
SPIDC330-4D-S32-SP09	03080126	33	227	167	137	132				
SPIDC335-4D-S32-SP09	03080129	33.5	229	169	139	134				
SPIDC340-4D-S32-SP11	03080132	34	231	171	141	136				
SPIDC345-4D-S32-SP11	03080135	34.5	226	166	159	138				
SPIDC350-4D-S32-SP11	03080138	35	235	175	145	140				
SPIDC355-4D-S32-SP11	03080141	35.5	230	170	163	142				
SPIDC360-4D-S32-SP11	03080144	36	239	179	149	144				
SPIDC365-4D-S32-SP11	03080147	36.5	234	174	167	146				
SPIDC370-4D-S32-SP11	03080150	37	243	183	153	148				
SPIDC375-4D-S32-SP11	03080153	37.5	237	177	170	150				
SPIDC380-4D-S32-SP11	03080156	38	247	187	157	152				
SPIDC385-4D-S32-SP11	03080159	38.5	241	181	174	154				
SPIDC390-4D-S32-SP11	03080162	39	251	191	161	156				
SPIDC395-4D-S32-SP11	03080165	39.5	245	185	178	158				
SPIDC400-4D-S32-SP11	03080168	40	255	195	165	160				
SPIDC410-4D-S32-SP11	03080171	41	259	199	169	164				
SPIDC420-4D-S40-SP14	03080174	42	273	203	173	168	40	SPMG/SPGT 140512	M5X12	T20
SPIDC430-4D-S40-SP14	03080177	43	282	212	177	172				
SPIDC440-4D-S40-SP14	03080180	44	286	216	181	176				
SPIDC450-4D-S40-SP14	03080183	45	290	220	185	180				
SPIDC460-4D-S40-SP14	03080186	46	294	224	189	184				
SPIDC470-4D-S40-SP14	03080189	47	298	228	193	188				
SPIDC480-4D-S40-SP14	03080192	48	302	232	197	192				
SPIDC490-4D-S40-SP14	03080195	49	306	236	201	196				
SPIDC500-4D-S40-SP14	03080198	50	310	240	205	200				
SPIDC510-4D-S40-SP07	03080418	51	304	234	227	204				
SPIDC520-4D-S40-SP07	03080419	52	308	238	231	208				
SPIDC530-4D-S40-SP07	03080420	53	312	242	235	212				
SPIDC540-4D-S40-SP07	03080421	54	316	246	239	216				
SPIDC550-4D-S40-SP09	03080422	55	320	250	243	220				
SPIDC560-4D-S40-SP09	03080423	56	324	254	247	224				
SPIDC570-4D-S40-SP09	03080424	57	328	258	251	228				
SPIDC580-4D-S40-SP09	03080425	58	332	262	255	232				
SPIDC590-4D-S40-SP09	03080426	59	336	266	259	236				
SPIDC600-4D-S40-SP09	03080427	60	340	270	263	240				
								SPMG/SPGT 07T308	M2.5X8	T8
								SPMG/SPGT 090408	M3.5X10	T15

# 5D DRILL HOLDER



Designation	CP CODE	D	L	L1	L2	L3	d	INSERT	Clamping screw	Wrench
SPIDC125-5D-S20-SP05	03080448	12.5	142.5	92.5	67.5	62.5	20	SPMG/SPGT 050204	M2.2X5	T6
SPIDC130-5D-S20-SP05	03080449	13.0	145	95	70	65				
SPIDC135-5D-S20-SP05	03080450	13.5	147.6	97.5	72.5	67.5				
SPIDC140-5D-S25-SP05	03080451	14.0	156	100	75	70				
SPIDC145-5D-S25-SP05	03080452	14.5	158.5	102.5	77.5	72.5				
SPIDC150-5D-S25-SP05	03080453	15.0	161	105	80	75				
SPIDC155-5D-S25-SP05	03080454	15.5	163.5	107.5	82.5	77.5				
SPIDC160-5D-S25-SP06	03080455	16.0	166	110	85	80				
SPIDC165-5D-S25-SP06	03080456	16.5	168.5	112.5	87.5	82.5				
SPIDC170-5D-S25-SP06	03080457	17.0	171	115	90	85				
SPIDC175-5D-S25-SP06	03080458	17.5	173.5	117.5	92.5	87.5				
SPIDC180-5D-S25-SP06	03080459	18.0	176	120	95	90	25	SPMG/SPGT 060204	M2.2X6	T7
SPIDC185-5D-S25-SP06	03080460	18.5	178.5	122.5	97.5	92.5				
SPIDC190-5D-S25-SP06	03080461	19.0	181	125	100	95				
SPIDC195-5D-S25-SP06	03080462	19.5	183.5	127.5	102.5	97.5				
SPIDC200-5D-S25-SP06	03080463	20.0	186	130	105	100				
SPIDC205-5D-S25-SP06	03080464	20.5	188.5	132.5	107.5	102.5				
SPIDC210-5D-S25-SP06	03080465	21.0	196	140	110	105				
SPIDC215-5D-S25-SP06	03080466	21.5	198.5	142.5	112.5	107.5				
SPIDC220-5D-S25-SP07	03080467	22.0	201	145	115	110				
SPIDC225-5D-S25-SP07	03080468	22.5	203.5	147.5	117.5	112.5				
SPIDC230-5D-S25-SP07	03080469	23.0	206	150	120	115				
SPIDC235-5D-S25-SP07	03080470	23.5	208.5	152.5	122.5	117.5	32	SPMG/SPGT 07T308	M2.5X8	T8
SPIDC240-5D-S25-SP07	03080471	24.0	211	155	125	120				
SPIDC245-5D-S25-SP07	03080472	24.5	213.5	157.5	127.5	122.5				
SPIDC250-5D-S25-SP07	03080473	25.0	216	160	130	125				
SPIDC255-5D-S32-SP07	03080474	25.5	222.5	162.5	132.5	127.5				
SPIDC260-5D-S32-SP07	03080475	26.0	225	165	135	130				
SPIDC265-5D-S32-SP07	03080476	26.5	227	167.5	137.5	132.5				
SPIDC270-5D-S32-SP07	03080477	27.0	230	170	140	135				
SPIDC275-5D-S32-SP07	03080478	27.5	232.5	172.5	142.5	137.5				
SPIDC280-5D-S32-SP09	03080479	28.0	235	175	145	140				
SPIDC285-5D-S32-SP09	03080480	28.5	237.5	177.5	147.5	142.5				
SPIDC290-5D-S32-SP09	03080481	29.0	240	180	150	145	SPMG/SPGT 090408	M3.5X10	T15	
SPIDC295-5D-S32-SP09	03080482	29.5	242.5	182.5	152.5	147.5				
SPIDC300-5D-S32-SP09	03080483	30.0	245	185	155	150				










# 5D DRILL HOLDER



Designation	CP CODE	D	L	L1	L2	L3	d	INSERT	Clamping screw	Wrench
SPIDC305-5D-S32-SP09	03080484	30.5	247.5	187.5	157.5	152.5	32	SPMG/SPGT 090408	M3.5X10	T15
SPIDC310-5D-S32-SP09	03080485	31.0	250	190	160	155				
SPIDC315-5D-S32-SP09	03080486	31.5	252.5	192.5	162.5	157.5				
SPIDC320-5D-S32-SP09	03080487	32.0	255	195	165	160				
SPIDC325-5D-S32-SP09	03080488	32.5	257.5	197.5	167.5	162.5				
SPIDC330-5D-S32-SP09	03080489	33.0	260	200	170	165				
SPIDC335-5D-S32-SP09	03080490	33.5	262.5	202.5	172.5	167.5				
SPIDC340-5D-S32-SP11	03080491	34.0	265	205	175	170				
SPIDC345-5D-S32-SP11	03080492	34.5	267.5	207.5	177.5	172.5				
SPIDC350-5D-S32-SP11	03080493	35.0	270	210	180	175				
SPIDC355-5D-S32-SP11	03080494	35.5	272.5	212.5	182.5	177.5				
SPIDC360-5D-S32-SP11	03080495	36.0	275	215	185	180				
SPIDC365-5D-S32-SP11	03080496	36.5	277.5	217.5	187.5	182.5				
SPIDC370-5D-S32-SP11	03080497	37.0	280	220	190	185				
SPIDC375-5D-S32-SP11	03080498	37.5	282.5	222.5	192.5	187.5				
SPIDC380-5D-S32-SP11	03080499	38.0	285	225	195	190				
SPIDC385-5D-S32-SP11	03080500	38.5	287.5	227.5	197.5	192.5				
SPIDC390-5D-S32-SP11	03080501	39.0	290	230	200	195				
SPIDC395-5D-S32-SP11	03080502	39.5	292.5	232.5	202.5	197.5				
SPIDC400-5D-S32-SP11	03080503	40.0	295	235	205	200				
SPIDC410-5D-S32-SP11	03080504	41.0	300	240	210	205				
SPIDC420-5D-S40-SP14	03080505	42.0	315	245	215	210	40	SPMG/SPGT 140512	M5X12	T20
SPIDC430-5D-S40-SP14	03080506	43.0	325	255	220	215				
SPIDC440-5D-S40-SP14	03080507	44.0	330	260	225	220				
SPIDC450-5D-S40-SP14	03080508	45.0	335	265	230	225				
SPIDC460-5D-S40-SP14	03080509	46.0	340	270	235	230				
SPIDC470-5D-S40-SP14	03080510	47.0	345	275	240	235				
SPIDC480-5D-S40-SP14	03080511	48.0	350	280	245	240				
SPIDC490-5D-S40-SP14	03080512	49.0	355	285	250	245				
SPIDC500-5D-S40-SP14	03080513	50.0	360	290	255	250				
SPIDC510-5D-S40-SP07	03080514	51.0	355	285	278	255				
SPIDC520-5D-S40-SP07	03080515	52.0	360	290	283	260				
SPIDC530-5D-S40-SP07	03080516	53.0	365	295	288	265				
SPIDC540-5D-S40-SP07	03080517	54.0	370	300	293	270				
SPIDC550-5D-S40-SP09	03080518	55.0	375	305	298	275				
SPIDC560-5D-S40-SP09	03080519	56.0	380	310	303	280				
SPIDC570-5D-S40-SP09	03080520	57.0	385	315	308	285				
SPIDC580-5D-S40-SP09	03080521	58.0	390	320	313	290				
SPIDC590-5D-S40-SP09	03080522	59.0	395	325	318	295				
SPIDC600-5D-S40-SP09	03080523	60.0	400	330	323	300				
									SPMG/SPGT 07T308	
								SPMG/SPGT 090408	M3.5X10	T15



## CAUTION

Kinds of drill	Case	Description
	Drilling On Irregular Surface	<ul style="list-style-type: none"> <li>• Concentration of cutting resistance enables chipping and breakage of the insert.</li> <li>• The feed should be changed to 25% of the normal feed when drill is closed to material.</li> </ul>
	Drilling On Protruded Surface	<ul style="list-style-type: none"> <li>• Machining is possible when the inner insert first contacts the workpiece during machining</li> <li>• The feed should be changed to 50% of the normal feed when drill is closed to material and processed</li> </ul>
	Drilling On Concaved Surface	<ul style="list-style-type: none"> <li>• Reduced to 50% of recommended cutting condition when drill is closed to material</li> </ul>
	Drilling On Sloped Surface	<ul style="list-style-type: none"> <li>• The recommended cutting condition should be reduced to 50%</li> </ul>
	Drilling On Crossed Hole	<ul style="list-style-type: none"> <li>• The recommended cutting condition should be reduced to 50% at the intersection</li> </ul>
	Drilling On Overlapped Materials	<ul style="list-style-type: none"> <li>• Possible chipping and breakage of insert</li> <li>• The feed should be changed to 25% of the normal feed when drill is closed to material.</li> </ul>
	Overlapped Drilling	<ul style="list-style-type: none"> <li>• The recommended cutting condition should be reduced to 50%</li> </ul>

# TROUNLR SHOOTING

Trouble	Problem	Check list & solution
Chattering	Chattering While cutting	<ul style="list-style-type: none"> <li>● Check clamping condition of work piece and drill.</li> <li>● Change cutting speed and feed low.</li> <li>● Change overhang(L/D) shortly.</li> <li>● Check the torque of machine.</li> </ul>
Bad chip evacuation	Long chip	<ul style="list-style-type: none"> <li>● Mind steel &amp; stainless steel : increase the cutting speed and decrease feed.</li> <li>● Alloy steel and carbon steel : increase the cutting speed and feed.</li> </ul>
	Short chip	<ul style="list-style-type: none"> <li>● Decrease the cutting speed and feed.</li> </ul>
Low insert tool life	Wear or Chipping	<ul style="list-style-type: none"> <li>● Check the cutting condition again.</li> <li>● Change the grade.</li> <li>● Change overhang(L/D) shortly.</li> <li>● Improve clamping condition of work piece or holder</li> </ul>
Bad surface roughness	Scratch on the face.	<ul style="list-style-type: none"> <li>● Decrease feed or increase cutting speed.</li> <li>● Change overhang(L/D) shortly.</li> <li>● Improve clamping condition of work piece or holer</li> </ul>
Hole size error After cut	Hole size gap compared to drill dia'	<ul style="list-style-type: none"> <li>● Milling : if the size is over, Increase the lubricant oil discharge pressure</li> </ul>
		<ul style="list-style-type: none"> <li>● Turning : if the size is insufficient, Check the centering condition of drill.</li> </ul>
Holes size error on In and out hole	Different size of hole input and output	<ul style="list-style-type: none"> <li>● Change overhang(L/D) shortly.</li> <li>● Change cutting condition for better chip control.</li> <li>● Increase the lubricant oil discharge pressure.</li> </ul>



# MEMO

A large rectangular area with a light blue grid pattern, intended for writing a memo. The grid consists of small, evenly spaced squares. The area is framed by a thin, rounded border in a slightly darker shade of blue.

# KCERA INC.

K-CERA Inc. exports to more than 10 countries worldwide through the Global Outsourcing system creating new products with high quality and reasonable price competitiveness by combining and combining excellent resources for cutting tool sectors around the world. Won the 1million dollar tower in 2018

Our cutting tool brand, CERA TIGER, has already been proven in reasonable prices and excellent performance in overseas markets, especially in the European market. Thanks to the enthusiastic support of the overseas market, we have successfully launched CERA TIGER products in the domestic market since the second half of 2017, and are striving to reach our customers through various marketing strategies such as participating in the 2019 INTERMOLD 2019 exhibition and launching global catalogs.

Under the spirit of "the best cutting tool solution and aggressive market pioneer spirit"

K-CERA Inc. promises to develop the market and strive for endless development in the field of ultra-precision tools with top priority on customer needs first under the mission / vision / goal of "20 billion won in 2024" for the customer's satisfaction.

We look forward to your continued interest and support.





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***F.T.K. Tools S.r.L***

*Sede Legale:*

Piazza della Repubblica, 2  
20124 Milano - Italy

*Ufficio commerciale:*

Corso Galileo Ferraris 51/R  
10034 Chivasso (To) - Italy  
[info@ftktools.com](mailto:info@ftktools.com)