



**METRIC**

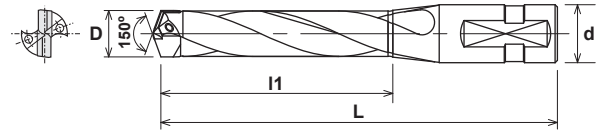
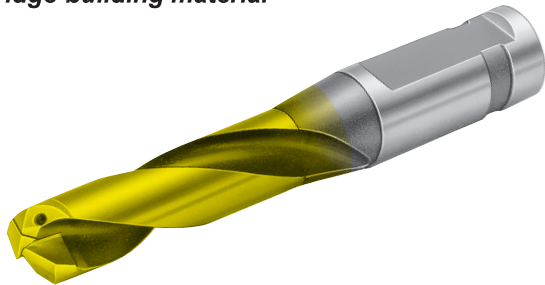
**S-Cut Drill**

**SCD-KMS Type**

- Enhanced chip evacuation with S-Cut point geometry provides longer and consistent tool life when drilling steel, cast iron or stainless steel.

- For bridge-building material

Diameter	Tolerance
over 18mm -up to 30mm	+0 / -0.021



**SCD-KMS-2D (2XD)**

CATALOG NUMBER	STK	DIMENSIONS			
		D	I1	L	d
SCD-2450-KMS-2D	•	24.5	75	160	32
SCD-2470-KMS-2D	•	24.7	75	160	32
SCD-2650-KMS-2D	•	26.5	81	168	32
SCD-2670-KMS-2D	•	26.7	81	168	32

**SCD-KMS (3XD)**

CATALOG NUMBER	STK	DIMENSIONS			
		D	I1	L	d
SCD-2450-KMS	•	24.5	100	185	32
SCD-2460-KMS	•	24.6	100	185	32
SCD-2470-KMS	•	24.7	100	185	32
SCD-2650-KMS	•	26.5	108	195	32
SCD-2670-KMS	•	26.7	108	195	32
SCD-2850-KMS	•	28.5	116	205	32
SCD-2870-KMS	•	28.7	116	205	32

**Recommended Cutting Data**

High Speed ~ Standard Speed ~ Low Speed

MATERIAL		TENSILE STRENGTH (N/mm <sup>2</sup> )	CUTTING CONDITION	
ROLLED STEEL	SS400	400 ~ 510	Vc (m/min)	80 ~ 70 ~ 60
	SM400	400 ~ 510	f (mm/rev)	0.20 ~ 0.30 ~ 0.40
	SM490	490 ~ 610	Vc (m/min)	75 ~ 65 ~ 55
	SM520	360	f (mm/rev)	0.20 ~ 0.25 ~ 0.35
	SM570	220		