

Help table for tool selection

Ø mm	L / D	Machining										
		solid drilling	blind hole	forge/ casting skin, interface	angled start and drilling out, interrupted cut	convex	cross bore	centering bore, seam	chamber	stack plate drilling	rough boring	adjustable
14,0 - 65,0 ±0,2	2 × D	●	●	●	●	●	●	●	●	●	●	●
14,0 - 65,0 ±0,2	3 × D	●	●	●	◐	●	●	●	●	●	●	●
14,0 - 44,0 ±0,2	4 × D	●	●	○	○	◐	◐	◐		●	◐	◐
12,0 - 44,0 ±0,1	2 × D	●	●	●	●	●	◐	◐	●		◐	●
12,0 - 54,0 ±0,1	3 × D	●	●	●	●	◐	◐	◐	◐		○	●
14,0 - 44,0 ±0,1	4 × D	●	●	◐	○	○	○	○	○			◐
38,5 - 82,0 ^{+1,0} _{-0,5}	3 × D	●	●	○	○	○	○	○	○		○	◐
45,0 - 82,0 ±0,2	2 × D	●	●	●	●	●	◐	◐	●		◐	◐
45,0 - 82,0 ±0,2	3 × D	●	●	●	◐	◐	◐	◐	◐			◐
17,3 - 44,2 ±0,1	5 × D	●	●	◐	○	◐	◐	○	◐	●	○	
20,0 - 64,0 ±0,1	9 × D	●	●	◐	○	○	○	○	○			
65,0 - 155,0	up to 9 × D	●	●	◐	○	○	○	○	○			●
80,0 - 155,0	6 × D	●	●	◐	○	○	○	○	○			●
83,0 - 128,0 ±0,4	4 × D	●	●	◐	○	○	○	○	○			
83,0 - 198,0 ±0,5	3 × D	●		◐	◐	◐	◐	●	●			
37,0 - 70,0 ±0,5	3 × D		◐								●	●
14,0 - 82,0	2 × D	◐	◐	◐	○	◐	◐	◐	◐	●	○	○
14,0 - 82,0	3 × D	◐	◐	◐	○	◐	◐	◐	◐	●	○	○
14,0 - 44,0	1,5-4 × D	●	●	●	◐	◐	◐	◐	◐			●

Coolant				Tool	Material						Connection							
Emulsion		MQL			P	M	K	N	S	H	right			left				
internal	external	internal	external								ABS	Cylindrical shank	VDI compatible	ABS	VDI compatible			
●	◐	●	◐	 KUB Quatron®	●	●	●	●	●	○	1.10	1.14						
●	◐	●	◐		●	●	●	●	●	○								
●	◐	●	◐		●	●	●	●	●	○								
●	◐	●	◐	 KUB Trigon®	●	●	●	●	●	○	1.22	1.28	1.36	1.46	1.50			
●	◐	●	○		●	●	●	●	○									
●	○	●	○		●	●	●	○										
●	○	◐	○	 KUB® V82 / V83 / V84	●	●	●	●			1.58							
●	◐	◐	◐	 KUB® V13 / V14	●	●	●	●	●	○	1.62		1.66					
●	○	◐	○		●	●	●	●	●									
●	○	●	○	 KUB Duon®	●	●	●	●			1.70	1.70						
●		○		 KUB Centron®	●	●	●	●			1.90							
●		○		 KUB® V46 / V47	●	●	●	●			1.98							
●		○		 KUB® Drill head V464	●		●	●			1.104							
●	○	◐	○	 KUB® Drill head	●	●	●	●			1.108							
●	○	◐	○	 Trepanning tool	●	●	●	●			1.112							
●	◐	◐	○	 KUB® Flat-bottoming tool	●	●	●	●			1.110							
●	◐	◐	○	 Packet drill	●	◐	●	◐			1.113							
●	○	◐	○		●	◐	●	◐										
●	◐	◐	○	 Easy Special™	●	●	●	●	●		Chapter 4							