

MADE IN INDIA

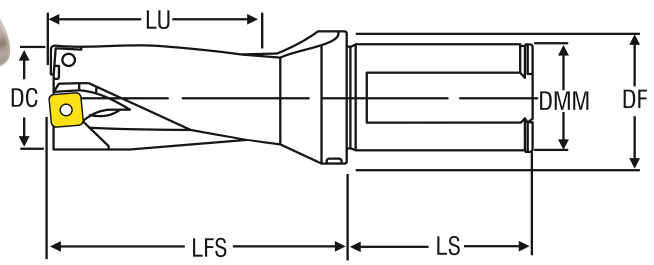


*Kerason*<sup>®</sup>



U-Drill



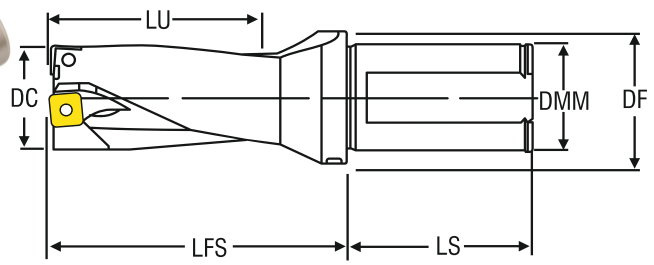


# INSERTED DRILL

## Drilling Depth - 2 x D.

- › Internal coolant.
- › Low cutting forces resulting in long tool life.
- › Diameter range of 12mm to 50mm in 2 x D, 3 x D, 4 x D, and 5 x D.
- › Highest feed rates and cutting speeds applicable due to highly stable tool body design.

DC (mm)	LU	Designation	Dimensions in mm				Spares		
			LFS	LS	DMM	DF	Insert	Screw	Key
12	24	KE852-12-24-20R7	46	50	20	25	SOMT040204-DP	M1.8X5	T-6
12.5	25	KE852-12.5-25-20R7	46	50	20	25			
13	26	KE852-13-26-20R7	46	50	20	25			
13.5	27	KE852-13.5-27-20R7	48	50	20	25			
14	28	KE852-14-28-25R7	51	55	25	32			
14.5	29	KE852-14.5-29-25R7	52	55	25	32			
15	30	KE852-15-30-25R7	52	55	25	32			
15.5	31	KE852-15.5-31-25R7	56	55	25	32			
16	32	KE852-16-32-25R7	56	55	25	32			
16.5	33	KE852-16.5-33-25R7	56	55	25	32			
17	34	KE852-17-34-25R7	58	55	25	32			
17.5	35	KE852-17.5-35-25R7	58	55	25	32			
18	36	KE852-18-36-25R7	59	55	25	32			
18.5	37	KE852-18.5-37-25R7	59	55	25	32			
19	38	KE852-19-38-25R7	60	55	25	32			
19.5	39	KE852-19.5-39-25R7	61	55	25	32			
20	40	KE852-20-40-25R7	62	55	25	32			
20.5	41	KE852-20.5-41-25R7	63	55	25	32			
21	42	KE852-21-42-25R7	64	55	25	32			
21.5	43	KE852-21.5-43-25R7	65	55	25	32			
22	44	KE852-22-44-25R7	66	55	25	38			
22.5	45	KE852-22.5-45-25R7	67	55	25	38			
23	46	KE852-23-46-25R7	68	55	25	38			
23.5	47	KE852-23.5-47-25R7	69	55	25	38			
24	48	KE852-24-48-25R7	70	55	25	38			
24.5	49	KE852-24.5-49-25R7	71	55	25	38			
25	50	KE852-25-50-32R7	72	60	32	40			
25.5	51	KE852-25.5-51-32R7	73	60	32	40			
26	52	KE852-26-52-32R7	74	60	32	42			
26.5	53	KE852-26.5-53-32R7	75	60	32	42			
27	54	KE852-27-54-32R7	76	60	32	42			
27.5	55	KE852-27.5-55-32R7	77	60	32	42			
28	56	KE852-28-56-32R7	78	60	32	44			
28.5	57	KE852-28.5-57-32R7	79	60	32	44			
29	58	KE852-29-58-32R7	80	60	32	44			
29.5	59	KE852-29.5-59-32R7	81	60	32	44			
30.5	61	KE852-30.5-61-32R7	83	60	32	44			
31	62	KE852-31-62-32R7	84	60	32	44			
31.5	63	KE852-31.5-63-32R7	85	60	32	44			
32	64	KE852-32-64-32R7	86	60	32	44			
32.5	65	KE852-32.5-65-32R7	87	60	32	44			
33	66	KE852-33-66-32R7	87	60	32	44			
33.5	67	KE852-33.5-67-32R7	88	60	32	44			
34	68	KE852-34-68-32R7	90	60	32	44			
34.5	69	KE852-34.5-69-32R7	91	60	32	44			
35	70	KE852-35-70-32R7	92	60	32	44			
35.5	71	KE852-35.5-71-32R7	92	60	32	44			
36	72	KE852-36-72-32R7	93	60	32	44			
37	74	KE852-37-74-32R7	95	60	32	44			
38	76	KE852-38-76-32R7	96	60	32	44			
39	78	KE852-39-78-40R7	99	70	40	50			
40	80	KE852-40-80-40R7	100	70	40	50			
41	82	KE852-41-82-40R7	103	70	40	50			
42	84	KE852-42-84-40R7	105	70	40	50			
43	86	KE852-43-86-40R7	107	70	40	50			
44	88	KE852-44-88-40R7	109	70	40	55			
45	90	KE852-45-90-40R7	111	70	40	55			
46	92	KE852-46-92-40R7	113	70	40	55			
47	94	KE852-47-94-40R7	115	70	40	55			
48	96	KE852-48-96-40R7	117	70	40	55			
49	98	KE852-49-98-40R7	119	70	40	59			
50	100	KE852-50-100-40R7	124	70	40	59			

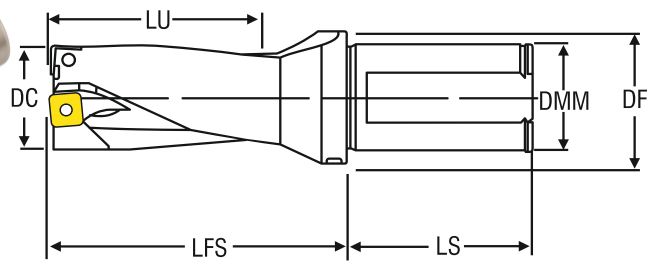


# INSERTED DRILL

## Drilling Depth - 3 x D.

- › Internal coolant.
- › Low cutting forces resulting in long tool life.
- › Diameter range of 12mm to 50mm in 2 x D, 3 x D, 4 x D, and 5 x D.
- › Highest feed rates and cutting speeds applicable due to highly stable tool body design.

DC (mm)	LU	Designation	Dimensions in mm				Spares		
			LFS	LS	DMM	DF	Insert	Screw	Key
12	36	KE853-12-36-20R7	57	50	20	25	SOMT040204-DP	M1.8X5	T-6
12.5	38	KE853-12.5-38-20R7	58	50	20	25			
13	39	KE853-13-39-20R7	60	50	20	25			
13.5	41	KE853-13.5-41-20R7	61	50	20	25			
14	42	KE853-14-42-25R7	65	55	25	32			
14.5	44	KE853-14.5-44-25R7	66	55	25	32			
15	45	KE853-15-45-25R7	66	55	25	32			
15.5	47	KE853-15.5-47-25R7	66	55	25	32			
16	48	KE853-16-48-25R7	72	55	25	32			
16.5	50	KE853-16.5-50-25R7	72	55	25	32			
17	51	KE853-17-51-25R7	75	55	25	32			
17.5	53	KE853-17.5-53-25R7	75	55	25	32			
18	54	KE853-18-54-25R7	78	55	25	32			
18.5	56	KE853-18.5-56-25R7	78	55	25	32			
19	57	KE853-19-57-25R7	79	55	25	32			
19.5	59	KE853-19.5-59-25R7	80	55	25	32			
20	60	E853-20-60-25R7	82	55	25	32			
20.5	62	KE853-20.5-62-25R7	84	55	25	32			
21	63	KE853-21-63-25R7	84	55	25	32			
21.5	65	KE853-21.5-65-25R7	86	55	25	32			
22	66	KE853-22-66-25R7	88	55	25	38			
22.5	68	KE853-22.5-68-25R7	89	55	25	38			
23	69	KE853-23-69-25R7	91	55	25	38			
23.5	71	KE853-23.5-71-25R7	92	55	25	38			
24	72	KE853-24-72-25R7	94	55	25	38			
24.5	74	KE853-24.5-74-25R7	95	55	25	38			
25	75	KE853-25-75-32R7	96	60	32	40			
25.5	77	KE853-25.5-77-32R7	98	60	32	40			
26	78	KE853-26-78-32R7	98	60	32	42			
26.5	80	KE853-26.5-80-32R7	100	60	32	42			
27	81	KE853-27-81-32R7	102	60	32	42			
27.5	83	KE853-27.5-83-32R7	104	60	32	42			
28	84	KE853-28-84-32R7	105	60	32	44			
28.5	86	KE853-28.5-86-32R7	107	60	32	44			
29	87	KE853-29-87-32R7	108	60	32	44			
29.5	89	KE853-29.5-89-32R7	110	60	32	44			
30	90	KE853-30-90-32R7	111	60	32	44			
30.5	92	KE853-30.5-92-32R7	113	60	32	44			
31	93	KE853-31-93-32R7	114	60	32	44			
31.5	95	KE853-31.5-95-32R7	116	60	32	44			
32	96	KE853-32-96-32R7	117	60	32	44			
32.5	97	KE853-32.5-97-32R7	119	60	32	44			
33	99	KE853-33-99-32R7	120	60	32	44			
33.5	100	KE853-33.5-100-32R7	121	60	32	44			
34	102	KE853-34-102-32R7	124	60	32	44			
34.5	103	KE853-34.5-103-32R7	126	60	32	44			
35	105	KE853-35-105-32R7	127	60	32	44			
35.5	106	KE853-35.5-106-32R7	128	60	32	44			
36	108	KE853-36-108-32R7	129	60	32	44			
37	111	KE853-37-111-32R7	131	60	32	44			
38	114	KE853-38-114-32R7	134	60	32	44			
39	117	KE853-39-117-40R7	138	70	40	50			
40	120	KE853-40-120-40R7	140	70	40	50			
41	123	KE853-41-123-40R7	140	70	40	50			
42	126	KE853-42-126-40R7	147	70	40	50			
43	129	KE853-43-129-40R7	150	70	40	50			
44	132	KE853-44-132-40R7	153	70	40	55			
45	135	KE853-45-135-40R7	156	70	40	55			
46	138	KE853-46-135-40R7	159	70	40	55			
47	141	KE853-47-135-40R7	162	70	40	55			
48	144	KE853-48-135-40R7	165	70	40	55			
49	147	KE853-49-135-40R7	168	70	40	59			
50	150	KE853-50-135-40R7	169	70	40	59			

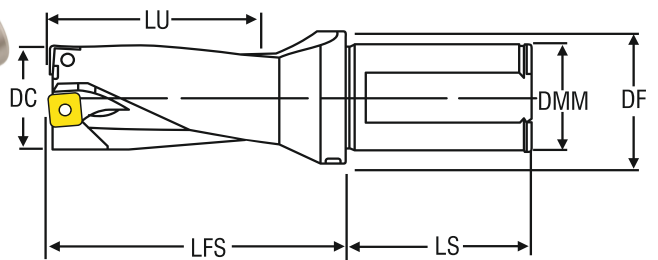


# INSERTED DRILL

## Drilling Depth - 4 x D.

- › Internal coolant.
- › Low cutting forces resulting in long tool life.
- › Diameter range of 12mm to 50mm in 2 x D, 3 x D, 4 x D, and 5 x D.
- › Highest feed rates and cutting speeds applicable due to highly stable tool body design.

DC (mm)	LU	Designation	Dimensions in mm				Spares		
			LFS	LS	DMM	DF	Insert	Screw	Key
12	48	KE854-12-48-20R7	69	50	20	25	SOMT040204-DP	M1.8X5	T-6
12.5	50	KE854-12.5-50-20R7	71	50	20	25			
13	52	KE854-13-52-20R7	73	50	20	25			
13.5	54	KE854-13.5-54-20R7	75	50	20	25			
14	56	KE854-14-56-25R7	79	55	25	32			
14.5	58	KE854-14.5-58-25R7	81	55	25	32			
15	60	KE854-15-60-25R7	81	55	25	32			
15.5	62	KE854-15.5-62-25R7	86	55	25	32			
16	64	KE854-16-64-25R7	87	55	25	32			
16.5	66	KE854-16.5-66-25R7	88	55	25	32			
17	68	KE854-17-68-25R7	92	55	25	32			
17.5	70	KE854-17.5-70-25R7	93	55	25	32			
18	72	KE854-18-72-25R7	95	55	25	32			
18.5	74	KE854-18.5-74-25R7	96	55	25	32			
19	76	KE854-19-76-25R7	98	55	25	32			
19.5	78	KE854-19.5-78-25R7	100	55	25	32			
20	80	KE854-20-80-25R7	102	55	25	32			
20.5	82	KE854-20.5-82-25R7	104	55	25	32			
21	84	KE854-21-84-25R7	105	55	25	32			
21.5	86	KE854-21.5-86-25R7	108	55	25	32			
22	88	KE854-22-88-25R7	110	55	25	38			
22.5	90	KE854-22.5-90-25R7	112	55	25	38			
23	92	KE854-23-92-25R7	114	55	25	38			
23.5	94	KE854-23.5-94-25R7	116	55	25	38			
24	96	KE854-24-96-25R7	118	55	25	38			
24.5	98	KE854-24.5-98-25R7	120	55	25	38			
25	100	KE854-25-100-32R7	121	60	32	40			
25.5	102	KE854-25.5-102-32R7	123	60	32	40			
26	104	KE854-26-104-32R7	125	60	32	42			
26.5	106	KE854-26.5-106-32R7	127	60	32	42			
27	108	KE854-27-108-32R7	129	60	32	42			
27.5	110	KE854-27.5-110-32R7	131	60	32	42			
28	112	KE854-28-112-32R7	133	60	32	44			
28.5	114	KE854-28.5-114-32R7	135	60	32	44			
29	116	KE854-29-116-32R7	137	60	32	44			
29.5	118	KE854-29.5-118-32R7	139	60	32	44			
30	120	KE854-30-120-32R7	141	60	32	44			
30.5	122	KE854-30.5-122-32R7	143	60	32	44			
31	124	KE854-31-124-32R7	145	60	32	44			
31.5	126	KE854-31.5-126-32R7	147	60	32	44			
32	128	KE854-32-128-32R7	149	60	32	44			
32.5	130	KE854-32.5-130-32R7	151	60	32	44			
33	132	KE854-33-132-32R7	153	60	32	44			
33.5	134	KE854-33.5-134-32R7	154	60	32	44			
34	136	KE854-34-136-32R7	158	60	32	44			
34.5	138	KE854-34.5-138-32R7	159	60	32	44			
35	140	KE854-35-140-32R7	161	60	32	44			
35.5	142	KE854-35.5-142-32R7	163	60	32	44			
36	144	KE854-36-144-32R7	165	60	32	44			
37	148	KE854-37-148-32R7	169	60	32	44			
38	152	KE854-38-152-32R7	172	60	32	44			
39	156	KE854-39-156-40R7	177	70	40	50			
40	160	KE854-40-160-40R7	179	70	40	50			
41	164	KE854-41-164-40R7	185	70	40	50			
42	168	KE854-42-168-40R7	189	70	40	50			
43	172	KE854-43-172-40R7	193	70	40	50			
44	176	KE854-44-176-40R7	197	70	40	55			
45	180	KE854-45-180-40R7	201	70	40	55			
46	184	KE854-46-184-40R7	205	70	40	55			
47	188	KE854-47-188-40R7	209	70	40	55			
48	192	KE854-48-192-40R7	213	70	40	55			
49	196	KE854-49-196-40R7	217	70	40	59			
50	200	KE854-50-200-40R7	221	70	40	59			



# INSERTED DRILL

## Drilling Depth - 5 x D.

- › Internal coolant.
- › Low cutting forces resulting in long tool life.
- › Diameter range of 12mm to 50mm in 2 x D, 3 x D, 4 x D, and 5 x D.
- › Highest feed rates and cutting speeds applicable due to highly stable tool body design.

DC (mm)	LU	Designation	Dimensions in mm				Spares		
			LFS	LS	DMM	DF	Insert	Screw	Key
12	60	KE855-12-60-20R7	81	50	20	25	SOMT040204-DP	M1.8X5	T-6
12.5	62.5	KE855-12.5-62.5-20R7	83	50	20	25			
13	65	KE855-13-65-20R7	86	50	20	25			
13.5	67.5	KE855-13.5-67.5-20R7	88	50	20	25			
14	70	KE855-14-70-25R7	94	55	25	32			
14.5	72.5	KE855-14.5-72.5-25R7	96	55	25	32			
15	75	KE855-15-75-25R7	97	55	25	32			
15.5	77.5	KE855-15.5-77.5-25R7	103	55	25	32			
16	80	KE855-16-48-25R7	105	55	25	32			
16.5	82.5	KE855-16.5-82.5-25R7	105	55	25	32			
17	85	KE855-17-85-25R7	110	55	25	32			
17.5	87.5	KE855-17.5-87.5-25R7	112	55	25	32			
18	90	KE855-18-90-25R7	114	55	25	32			
18.5	92.5	KE855-18.5-92.5-25R7	116	55	25	32			
19	95	KE855-19-95-25R7	118	55	25	32			
19.5	97.5	KE855-19.5-97.5-25R7	120	55	25	32			
20	100	KE855-20-100-25R7	123	55	25	32			
20.5	102.5	KE855-20.5-102.5-25R7	125	55	25	32			
21	105	KE855-21-105-25R7	127	55	25	32			
21.5	107.5	KE855-21.5-107.5-25R7	129	55	25	32			
22	110	KE855-22-110-25R7	133	55	25	38			
22.5	112.5	KE855-22.5-112.5-25R7	135	55	25	38			
23	115	KE855-23-115-25R7	138	55	25	38			
23.5	117.5	KE855-23.5-117.5-25R7	140	55	25	38			
24	120	KE855-24-120-25R7	143	55	25	38			
24.5	122.5	KE855-24.5-122.5-25R7	145	55	25	38			
25	125	KE855-25-125-32R7	147	60	32	40			
25.5	127.5	KE855-25.5-127.5-32R7	150	60	32	40			
26	130	KE855-26-130-32R7	152	60	32	42			
26.5	132.5	KE855-26.5-80-32R7	155	60	32	42			
27	135	KE855-27-135-32R7	157	60	32	42			
27.5	137.5	KE855-27.5-137.5-32R7	160	60	32	42			
28	140	KE855-28-140-32R7	162	60	32	44			
28.5	142.5	KE855-28.5-142.5-32R7	164	60	32	44			
29	145	KE855-29-145-32R7	167	60	32	44			
29.5	147.5	KE855-29.5-147.5-32R7	170	60	32	44			
30	150	KE855-30-150-32R7	172	60	32	44			
30.5	152.5	KE855-30.5-152.5-32R7	175	60	32	44			
31	155	KE855-31-155-32R7	177	60	32	44			
31.5	157.5	KE855-31.5-157.5-32R7	178	60	32	44			
32	160	KE855-32-160-32R7	180	60	32	44			
32.5	162.5	KE855-32.5-162.5-32R7	184	60	32	44			
33	165	KE855-33-165-32R7	187	60	32	44			
33.5	167.5	KE855-33.5-167.5-32R7	189	60	32	44			
34	170	KE855-34-170-32R7	192	60	32	44			
34.5	172.5	KE855-34.5-172.5-32R7	194	60	32	44			
35	175	KE855-35-175-32R7	196	60	32	44			
35.5	177.5	KE855-35.5-177.5-32R7	198	60	32	44			
36	180	KE855-36-180-32R7	201	60	32	44			
37	185	KE855-37-185-32R7	206	60	32	44			
38	190	KE855-38-190-32R7	210	60	32	44			
39	195	KE855-39-195-40R7	216	70	40	50			
40	200	KE855-40-200-40R7	220	70	40	50			
41	205	KE855-41-205-40R7	226	70	40	50			
42	210	KE855-42-210-40R7	231	70	40	50			
43	215	KE855-43-215-40R7	236	70	40	50			
44	220	KE855-44-220-40R7	241	70	40	55			
45	225	KE855-45-225-40R7	246	70	40	55			
46	230	KE855-46-230-40R7	251	70	40	55			
47	235	KE855-47-235-40R7	256	70	40	55			
48	240	KE855-48-240-40R7	261	70	40	55			
49	245	KE855-49-245-40R7	266	70	40	59			
50	250	KE855-50-250-40R7	271	70	40	59			



# INSERTED DRILL

## Recommended Cutting Data

Workpiece		VC Cutting Speed	Feed (aspect ratio=3D) (m/rev) depending on drill Dia.				
		(m/min)	12-16mm	17-23mm	24-29mm	30-42mm	43-50mm
P Steel	Carbon Steel	60-150-180	0.04~0.08	0.04~0.08	0.04~0.08	0.04~0.08	0.04~0.08
		130-190-250					
	Alloy Steel	80-140-250	0.04~0.10	0.04~0.12	0.05~0.16	0.08~0.18	0.10~0.22
		60-150-180					
		90-150-200	0.06~0.12	0.06~0.14	0.06~0.14	0.06~0.16	0.06~0.16
		50-100-150					
		50-100-160	0.04~0.18	0.06~0.12	0.08~0.18	0.08~0.18	0.08~0.22
		30-70-120					
M Stainless Steel	40-90-150	0.04~0.10	0.04~0.12	0.04~0.12	0.04~0.12	0.04~0.12	
				0.06~0.16	0.06~0.14	0.06~0.20	
	60-100-10	0.04~0.10	0.04~0.12	0.04~0.12	0.04~0.12	0.04~0.12	
				0.06~0.14	0.06~0.14	0.06~0.14	
K Cast	150-190-250	0.04~0.10	0.04~0.12	0.10~0.22	0.06~0.18	0.10~0.26	
	100-150-200						0.04~0.14

●(V=m/min) (Min.—Optimum—Max.) ●(N)=[1000 × (V)] ÷ [3.14 × (D)] ●(F)=[(ft) × (Z) × (N)]

**Note :**



### VISION (CORE VALUE) :

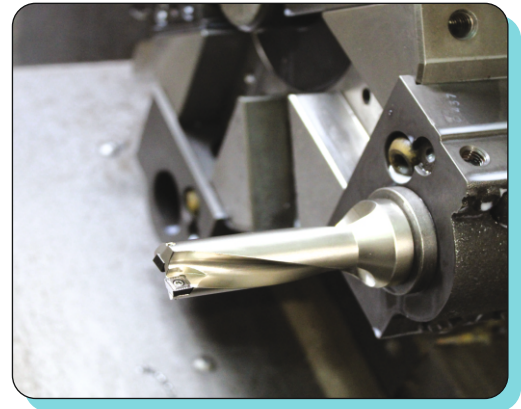
Delivering Quality in Time.  
In any case helping customers at Best.  
Creating happiness among ourselves.  
Encouraging individual ability.

### MISSION :

To build best tools and solutions by investing in most advanced technology which will give highest level of customer satisfaction and enable to excel there business.

### CORE PURPOSE :

To help improve the metal cutting process around the world.



### Features & Applications :

#### › **Balanced Design**

Cutting force during drilling is balanced between central insert and peripheral insert. The relative position of each insert is optimised to provide stable drilling.

#### › **Excellent Chip Control**

The chip evacuation direction can be controlled with the chip control groove at the centre of the breaker, enabling good chip evacuation.

#### › **Versatile Tool for a Variety of Machining Applications**

Select among four types of chipbreakers for different applications, allowing optimal drilling for a variety of work materials and conditions. Suitable for a applications for drilling with thru coolant machine.

#### › **Economical Four-Cornered Insert**

This product has an extremely economical design where a single insert type can be used for the central insert or peripheral insert, with two corners for each position - a total of four corners.

### Productivity and Profitability :

› Achieve highest feed rates with rectangular-shaped inserts that offer a soft starting cut and highest stability.

› Use X-offset on turning machines to adjust the drill diameter, eliminating the need for specials in many applications and on machining centers, to reach tolerance optimization.

› Same insert size is used in each pocket, reducing inventory costs.





Kerason®



Symbol  
of  
Excellence



Kerason®



## KERASON ENGINEERING COMPANY

**Manufacturer of Indexable U-drill**

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Make In India



एक कदम स्वच्छता की ओर