



now also with
cylindrical shank



KUB Duon®

Twin cutter drill
with replaceable inserts

KUB Duon®



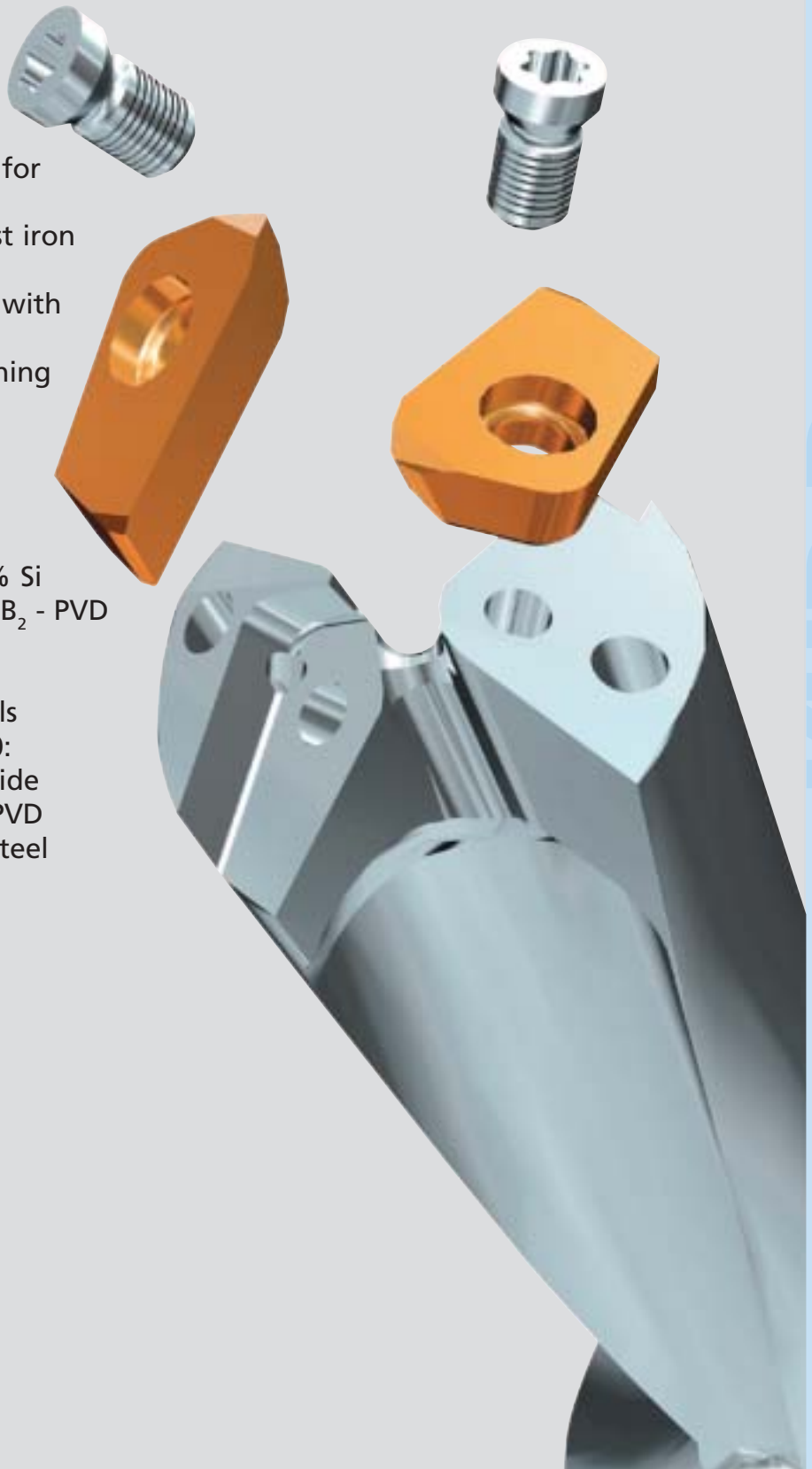
KUB Duon® Ø 17,3 – 36,2 mm

- **with ABS® connection**
- **with cylindrical shank (combination shank) to DIN 6535 E (similar to 1835 E) and 6595**
- **drilling depth up to 5 × D – R.H. cutting**

With this new drill design KOMET has transferred the principle of replaceable cutting heads to twin cutter tools.

- Twin cutting edges with high cutting speeds
- Drills with 2 replaceable screw-on cutter bodies; no regrinding necessary
- Face side, tangential mounting of inserts produces greater stability
- Precision ground inserts
- Drilling depth up to 5 × D
- Optimum internal coolant supply
- Diameter range 17.3 to 36.2 mm
- Torx Plus clamping system
- ABS connection
- With cylindrical shank (combination shank) to DIN 6535 E (similar to 1835 E) and 6595
- Intermediate hole sizes from other size inserts mounted in a standard body
- High level of productivity in the 5 × D range
- Bore can be carried out quickly and accurately; no pre-centering required

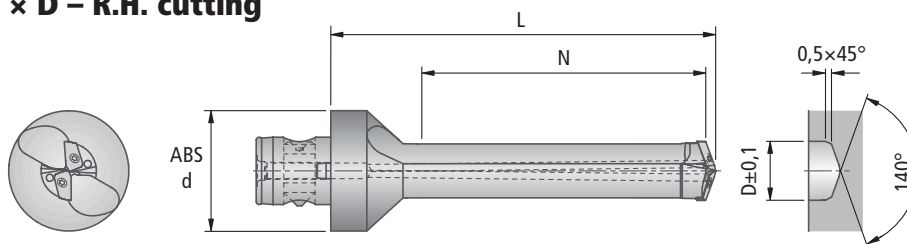
- Tried and tested BK84 cutting material
- BK2715 cutting material for maximum performance, mainly for machining cast iron
- BK8125 cutting material with increased toughness and edge stability, for machining all steel materials at low cutting speeds
- new BK7710 cutting material for controlled aluminium cutting (<10% Si content) with efficient TiB_2 - PVD coating
- new P40 cutting materials BK2740, BK8140, BK8440: an extremely tough carbide substrate with efficient PVD coating for demanding steel machining tasks



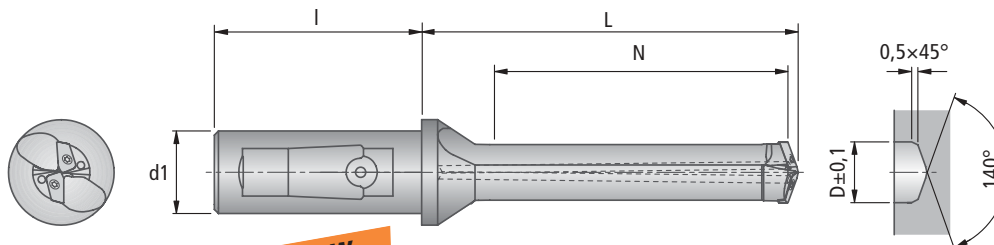
KUB Duon® Ø 17,3 – 20,7 mm

drilling depth up to 5 × D – R.H. cutting

ABS® connection



Cylindrical shank
(combination shank)
DIN 6535 HE
(similar to 1835 E)
and 6595



new

D	ABS					Cylindrical shank					Spares		
	ABS d	Order No.	N	L	kg approx.	Cylindrical shank d1xL	Order No.	N	L	kg approx.	Clamping screw Article	Screwdriver Article	Clamping torque Nm
17,3	50	U20 01750	90	125	0,6	25x56	U20 71750	90	114	0,34	N00 57660 S/M2,2x4,8-6IP	L05 00810 6IP	1,01
17,4													
17,5													
17,6													
17,7													
17,8	50	U20 01800	90	125	0,6	25x56	U20 71800	90	114	0,34	N00 57660 S/M2,2x4,8-6IP	L05 00810 6IP	1,01
17,9													
18,0													
18,1													
18,2	50	U20 01850	95	130	0,6	25x56	U20 71850	95	119	0,35	N00 57660 S/M2,2x4,8-6IP	L05 00810 6IP	1,01
18,3													
18,4													
18,5													
18,6													
18,7	50	U20 01900	95	130	0,6	25x56	U20 71900	95	119	0,35	N00 57660 S/M2,2x4,8-6IP	L05 00810 6IP	1,01
18,8													
18,9													
19,0													
19,1													
19,2	50	U20 01950	100	135	0,6	32x60	U20 81950	100	124	0,56	N00 57660 S/M2,2x4,8-6IP	L05 00810 6IP	1,01
19,3													
19,4													
19,5													
19,6													
19,7	50	U20 02000	100	135	0,6	32x60	U20 82000	100	124	0,56	N00 57660 S/M2,2x4,8-6IP	L05 00810 6IP	1,01
19,8													
19,9													
20,0													
20,1													
20,2	50	U20 02050	105	140	0,6	32x60	U20 82050	105	134	0,57	N00 57660 S/M2,2x4,8-6IP	L05 00810 6IP	1,01
20,3													
20,4													
20,5													
20,6													
20,7													

Important: See page 19 for application details and safety notes !

EP 0 547 049 and other patents (ABS®); patents applied for (KUB Duon®)

Inserts shown in bold print are kept in stock.
Intermediate dimensions can be supplied on request.

Supply includes:

KUB Duon® drill with clamping screws and screwdriver; insert not included (pack of 2 inserts).

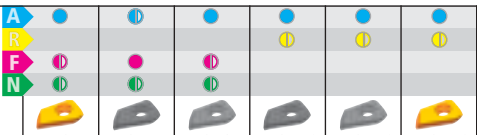

Order example: Insert:

for Ø18, coating BK84, Order No.: H60 18000.84

Areas of use:

(● = main use / ○ = suitable in some cases)

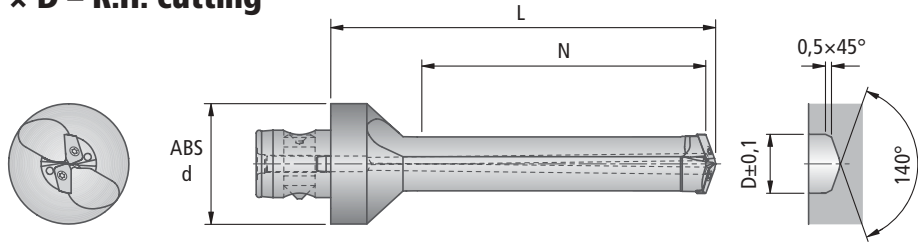
- high tensile strength steels, heat treated steels and tool steels
- stainless and acid resistant steels
- grey cast iron, SG cast iron
- cast aluminium alloys, brass and bronze which produce short chips

Basic recommendation										
Insert ISO-Code <small>enter carbide</small>	for workpiece material Order No.							Insert ISO-Code <small>enter carbide</small>	for workpiece material Order No.	
		BK84	BK2715	BK8125	BK2740	BK8140	BK8440			
XOHX 0802-17,3	H60 17300. ..							XOHX 0802-17,3-62	H62 17300. ..	
XOHX 0802-17,4	H60 17400. ..							XOHX 0802-17,4-62	H62 17400. ..	
XOHX 0802-17,5	H60 17500. ..	84	2715	8125	2740	8140	8440	XOHX 0802-17,5-62	H62 17500. ..	7710
XOHX 0802-17,6	H60 17600. ..							XOHX 0802-17,6-62	H62 17600. ..	
XOHX 0802-17,7	H60 17700. ..							XOHX 0802-17,7-62	H62 17700. ..	
XOHX 0802-17,8	H60 17800. ..							XOHX 0802-17,8-62	H62 17800. ..	
XOHX 0802-17,9	H60 17900. ..							XOHX 0802-17,9-62	H62 17900. ..	
XOHX 0802-18,0	H60 18000. ..	84	2715	8125	2740	8140	8440	XOHX 0802-18,0-62	H62 18000. ..	7710
XOHX 0802-18,1	H60 18100. ..							XOHX 0802-18,1-62	H62 18100. ..	
XOHX 0802-18,2	H60 18200. ..							XOHX 0802-18,2-62	H62 18200. ..	
XOHX 0802-18,3	H60 18300. ..							XOHX 0802-18,3-62	H62 18300. ..	
XOHX 0802-18,4	H60 18400. ..							XOHX 0802-18,4-62	H62 18400. ..	
XOHX 0802-18,5	H60 18500. ..	84	2715	8125	2740	8140	8440	XOHX 0802-18,5-62	H62 18500. ..	7710
XOHX 0802-18,6	H60 18600. ..							XOHX 0802-18,6-62	H62 18600. ..	
XOHX 0802-18,7	H60 18700. ..							XOHX 0802-18,7-62	H62 18700. ..	
XOHX 0802-18,8	H60 18800. ..							XOHX 0802-18,8-62	H62 18800. ..	
XOHX 0802-18,9	H60 18900. ..							XOHX 0802-18,9-62	H62 18900. ..	
XOHX 0802-19,0	H60 19000. ..	84	2715	8125	2740	8140	8440	XOHX 0802-19,0-62	H62 19000. ..	7710
XOHX 0802-19,1	H60 19100. ..							XOHX 0802-19,1-62	H62 19100. ..	
XOHX 0802-19,2	H60 19200. ..							XOHX 0802-19,2-62	H62 19200. ..	
XOHX 0802-19,3	H60 19300. ..							XOHX 0802-19,3-62	H62 19300. ..	
XOHX 0802-19,4	H60 19400. ..							XOHX 0802-19,4-62	H62 19400. ..	
XOHX 0802-19,5.....	H60 19500. ..	84	2715	8125	2740	8140	8440	XOHX 0802-19,5-62	H62 19500. ..	7710
XOHX 0802-19,6	H60 19600. ..							XOHX 0802-19,6-62	H62 19600. ..	
XOHX 0802-19,7	H60 19700. ..							XOHX 0802-19,7-62	H62 19700. ..	
XOHX 0802-19,8	H60 19800. ..							XOHX 0802-19,8-62	H62 19800. ..	
XOHX 0802-19,9	H60 19900. ..							XOHX 0802-19,9-62	H62 19900. ..	
XOHX 0802-20,0	H60 20000. ..	84	2715	8125	2740	8140	8440	XOHX 0802-20,0-62	H62 20000. ..	7710
XOHX 0802-20,1	H60 20100. ..							XOHX 0802-20,1-62	H62 20100. ..	
XOHX 0802-20,2	H60 20200. ..							XOHX 0802-20,2-62	H62 20200. ..	
XOHX 0802-20,3	H60 20300. ..							XOHX 0802-20,3-62	H62 20300. ..	
XOHX 0802-20,4	H60 20400. ..							XOHX 0802-20,4-62	H62 20400. ..	
XOHX 0802-20,5	H60 20500. ..	84	2715	8125	2740	8140	8440	XOHX 0802-20,5-62	H62 20500. ..	7710
XOHX 0802-20,6	H60 20600. ..							XOHX 0802-20,6-62	H62 20600. ..	
XOHX 0802-20,7	H60 20700. ..							XOHX 0802-20,7-62	H62 20700. ..	

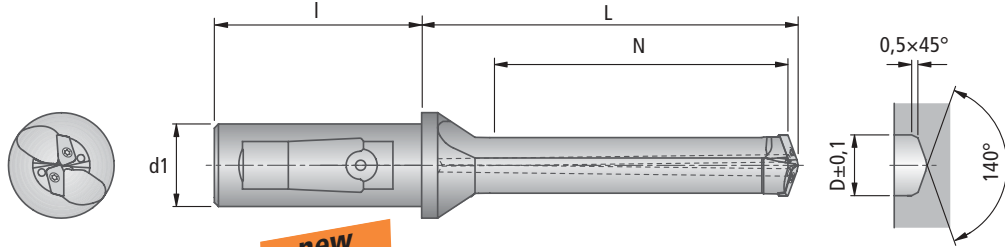
KUB Duon® Ø 20,8 – 24,2 mm

drilling depth up to 5 × D – R.H. cutting





ABS® connection



Cylindrical shank
(combination shank)
DIN 6535 HE
(similar to 1835 E)
and 6595



new

D	ABS					Cylindrical shank					Spares		
	ABS d	Order No.	N	L	 approx.	Cylindrical shank d1xL	Order No.	N	L	 approx.	 Clamping screw Order No. Article	 Screwdriver Order No. Article	Clamping torque Nm
20,8	50	U20 02100	105	140	0,6	32x60	U20 82100	105	134	0,58	N00 57630 S/M3x5,8-8IP	L05 00830 8IP	2,25
20,9													
21,0													
21,1													
21,2													
21,3	50	U20 02150	110	145	0,6	32x60	U20 82150	110	139	0,59	N00 57630 S/M3x5,8-8IP	L05 00830 8IP	2,25
21,4													
21,5													
21,6													
21,7	50	U20 02200	110	145	0,6	32x60	U20 82200	110	139	0,6	N00 57630 S/M3x5,8-8IP	L05 00830 8IP	2,25
21,8													
21,9													
22,0													
22,1													
22,2													
22,3	50	U20 02250	115	150	0,6	32x60	U20 82250	115	144	0,61	N00 57630 S/M3x5,8-8IP	L05 00830 8IP	2,25
22,4													
22,5													
22,6													
22,7													
22,8	50	U20 02300	115	150	0,6	32x60	U20 82300	115	144	0,62	N00 57630 S/M3x5,8-8IP	L05 00830 8IP	2,25
22,9													
23,0													
23,1													
23,2													
23,3	50	U20 02350	120	155	0,7	32x60	U20 82350	120	149	0,64	N00 57630 S/M3x5,8-8IP	L05 00830 8IP	2,25
23,4													
23,5													
23,6													
23,7													
23,8	50	U20 02400	120	155	0,7	32x60	U20 82400	120	149	0,65	N00 57630 S/M3x5,8-8IP	L05 00830 8IP	2,25
23,9													
24,0													
24,1													
24,2													

Important: See page 19 for application details and safety notes !

EP 0 547 049 and other patents (ABS®); patents applied for (KUB Duon®)

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Intermediate dimensions can be supplied on request.

Supply includes:

KUB Duon® drill with clamping screws and screwdriver; insert not included (pack of 2 inserts).








Order example: Insert:

for Ø21, coating BK84, Order No.: H60 21000.84

Areas of use:

(● = main use / ○ = suitable in some cases)

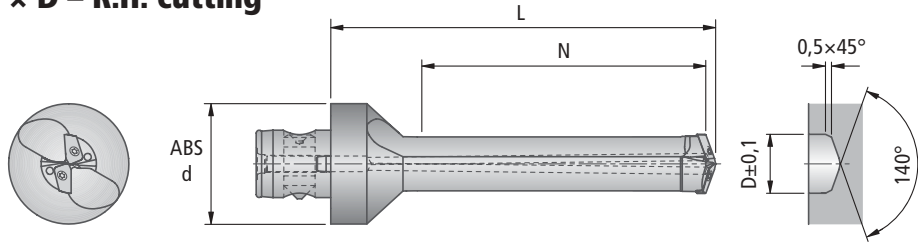
- high tensile strength steels, heat treated steels and tool steels
- stainless and acid resistant steels
- grey cast iron, SG cast iron
- cast aluminium alloys, brass and bronze which produce short chips

Basic recommendation															
Insert	for workpiece material	A R F N	●	○	●	○	●	○	●	○	Insert	for workpiece material	A R F N	●	○
enter carbide		     						enter carbide							
XOHX 1003-20,8	H60 20800. ..										XOHX 1003-20,8-62	H62 20800. ..			
XOHX 1003-20,9	H60 20900. ..										XOHX 1003-20,9-62	H62 20900. ..			
XOHX 1003-21,0	H60 21000. ..		●	○	○	○	○	○	○	○	XOHX 1003-21,0-62	H62 21000. ..		●	○
XOHX 1003-21,1	H60 21100. ..										XOHX 1003-21,1-62	H62 21100. ..			
XOHX 1003-21,2	H60 21200. ..										XOHX 1003-21,2-62	H62 21200. ..			
XOHX 1003-21,3	H60 21300. ..										XOHX 1003-21,3-62	H62 21300. ..			
XOHX 1003-21,4	H60 21400. ..										XOHX 1003-21,4-62	H62 21400. ..			
XOHX 1003-21,5	H60 21500. ..		●	○	○	○	○	○	○	○	XOHX 1003-21,5-62	H62 21500. ..		●	○
XOHX 1003-21,6	H60 21600. ..										XOHX 1003-21,6-62	H62 21600. ..			
XOHX 1003-21,7	H60 21700. ..										XOHX 1003-21,7-62	H62 21700. ..			
XOHX 1003-21,8	H60 21800. ..										XOHX 1003-21,8-62	H62 21800. ..			
XOHX 1003-21,9	H60 21900. ..										XOHX 1003-21,9-62	H62 21900. ..			
XOHX 1003-22,0	H60 22000. ..		●	○	○	○	○	○	○	○	XOHX 1003-22,0-62	H62 22000. ..		●	○
XOHX 1003-22,1	H60 22100. ..										XOHX 1003-22,1-62	H62 22100. ..			
XOHX 1003-22,2	H60 22200. ..										XOHX 1003-22,2-62	H62 22200. ..			
XOHX 1003-22,3	H60 22300. ..										XOHX 1003-22,3-62	H62 22300. ..			
XOHX 1003-22,4	H60 22400. ..										XOHX 1003-22,4-62	H62 22400. ..			
XOHX 1003-22,5	H60 22500. ..		●	○	○	○	○	○	○	○	XOHX 1003-22,5-62	H62 22500. ..		●	○
XOHX 1003-22,6	H60 22600. ..										XOHX 1003-22,6-62	H62 22600. ..			
XOHX 1003-22,7	H60 22700. ..										XOHX 1003-22,7-62	H62 22700. ..			
XOHX 1003-22,8	H60 22800. ..										XOHX 1003-22,8-62	H62 22800. ..			
XOHX 1003-22,9	H60 22900. ..										XOHX 1003-22,9-62	H62 22900. ..			
XOHX 1003-23,0	H60 23000. ..		●	○	○	○	○	○	○	○	XOHX 1003-23,0-62	H62 23000. ..		●	○
XOHX 1003-23,1	H60 23100. ..										XOHX 1003-23,1-62	H62 23100. ..			
XOHX 1003-23,2	H60 23200. ..										XOHX 1003-23,2-62	H62 23200. ..			
XOHX 1003-23,3	H60 23300. ..										XOHX 1003-23,3-62	H62 23300. ..			
XOHX 1003-23,4	H60 23400. ..										XOHX 1003-23,4-62	H62 23400. ..			
XOHX 1003-23,5	H60 23500. ..		●	○	○	○	○	○	○	○	XOHX 1003-23,5-62	H62 23500. ..		●	○
XOHX 1003-23,6	H60 23600. ..										XOHX 1003-23,6-62	H62 23600. ..			
XOHX 1003-23,7	H60 23700. ..										XOHX 1003-23,7-62	H62 23700. ..			
XOHX 1003-23,8	H60 23800. ..										XOHX 1003-23,8-62	H62 23800. ..			
XOHX 1003-23,9	H60 23900. ..										XOHX 1003-23,9-62	H62 23900. ..			
XOHX 1003-24,0	H60 24000. ..		●	○	○	○	○	○	○	○	XOHX 1003-24,0-62	H62 24000. ..		●	○
XOHX 1003-24,1	H60 24100. ..										XOHX 1003-24,1-62	H62 24100. ..			
XOHX 1003-24,2	H60 24200. ..										XOHX 1003-24,2-62	H6 24200. ..			

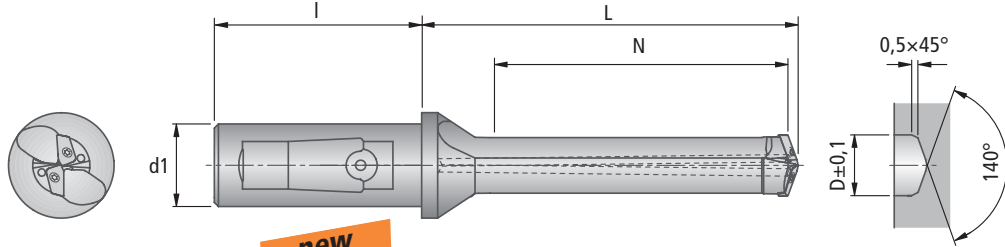
KUB Duon® Ø 24,3 – 27,7 mm

drilling depth up to 5 × D – R.H. cutting

ABS® connection



Cylindrical shank
(combination shank)
DIN 6535 HE
(similar to 1835 E)
and 6595



new

D	ABS					Cylindrical shank					Spares		
	ABS d	Order No.	N	L	approx.	Cylindrical shank d1xL	Order No.	N	L	approx.	Clamping screw Order No. Article	Screwdriver Order No. Article	Clamping torque Nm
24,3	50	U20 02450	125	160	0,7	32x60	U20 82450	125	154	0,67	N00 57630 S/M3x5,8-8IP	L05 00830 8IP	2,25
24,4													
24,5													
24,6													
24,7													
24,8	50	U20 02500	125	160	0,7	32x60	U20 82500	125	154	0,68	N00 57640 S/M3,5x6,9-10IP	L05 00850 10IP	3,00
24,9													
25,0													
25,1													
25,2	50	U20 02550	130	165	0,7	32x60	U20 82550	130	159	0,69	N00 57640 S/M3,5x6,9-10IP	L05 00850 10IP	3,00
25,3													
25,4													
25,5													
25,6													
25,7													
25,8	50	U20 02600	130	165	0,7	32x60	U20 82600	130	159	0,71	N00 57640 S/M3,5x6,9-10IP	L05 00850 10IP	3,00
25,9													
26,0													
26,1													
26,2	50	U20 02650	135	170	0,7	32x60	U20 82650	135	164	0,73	N00 57640 S/M3,5x6,9-10IP	L05 00850 10IP	3,00
26,3													
26,4													
26,5													
26,6													
26,7	50	U20 02700	135	170	0,7	32x60	U20 82700	135	164	0,74	N00 57640 S/M3,5x6,9-10IP	L05 00850 10IP	3,00
26,8													
26,9													
27,0													
27,1													
27,2	50	U20 02750	140	175	0,8	40x68	U20 92750	140	169	1,11	N00 57640 S/M3,5x6,9-10IP	L05 00850 10IP	3,00
27,3													
27,4													
27,5													
27,6													
27,7													

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Supply includes:

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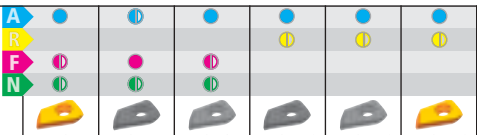
Order example: Insert:

for Ø24.5, coating BK84, Order No.: H60 24500.84

Areas of use:

(● = main use / ○ = suitable in some cases)

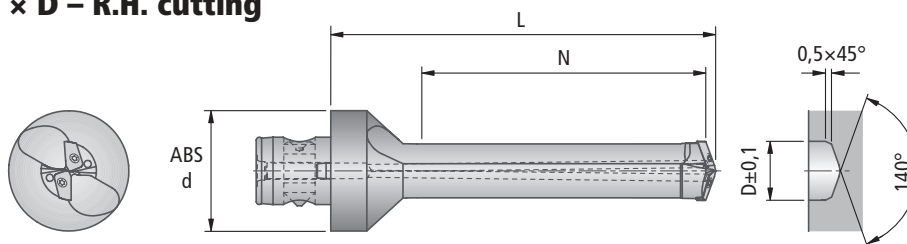
- high tensile strength steels, heat treated steels and tool steels
- stainless and acid resistant steels
- grey cast iron, SG cast iron
- cast aluminium alloys, brass and bronze which produce short chips

Basic recommendation										
Insert ISO-Code enter carbide	for workpiece material Order No.							Insert ISO-Code enter carbide	for workpiece material Order No.	
		BK84	BK2715	BK8125	BK2740	BK8140	BK8440			BK7710
XOHX 1003-24,3	H60 24300. ..	84	2715	8125	2740	8140	8440	XOHX 1003-24,3-62	H62 24300. ..	7710
XOHX 1003-24,4	H60 24400. ..							XOHX 1003-24,4-62	H62 24400. ..	
XOHX 1003-24,5	H60 24500. ..							XOHX 1003-24,5-62	H62 24500. ..	
XOHX 1003-24,6	H60 24600. ..							XOHX 1003-24,6-62	H62 24600. ..	
XOHX 1003-24,7	H60 24700. ..							XOHX 1003-24,7-62	H62 24700. ..	
XOHX 12T3-24,8	H60 24800. ..	84	2715	8125	2740	8140	8440	XOHX 12T3-24,8-62	H62 24800. ..	7710
XOHX 12T3-24,9	H60 24900. ..							XOHX 12T3-24,9-62	H62 24900. ..	
XOHX 12T3-25,0	H60 25000. ..							XOHX 12T3-25,0-62	H62 25000. ..	
XOHX 12T3-25,1	H60 25100. ..							XOHX 12T3-25,1-62	H62 25100. ..	
XOHX 12T3-25,2	H60 25200. ..							XOHX 12T3-25,2-62	H62 25200. ..	
XOHX 12T3-25,3	H60 25300. ..	84	2715	8125	2740	8140	8440	XOHX 12T3-25,3-62	H62 25300. ..	7710
XOHX 12T3-25,4	H60 25400. ..							XOHX 12T3-25,4-62	H62 25400. ..	
XOHX 12T3-25,5	H60 25500. ..							XOHX 12T3-25,5-62	H62 25500. ..	
XOHX 12T3-25,6	H60 25600. ..							XOHX 12T3-25,6-62	H62 25600. ..	
XOHX 12T3-25,7	H60 25700. ..							XOHX 12T3-25,7-62	H62 25700. ..	
XOHX 12T3-25,8	H60 25800. ..	84	2715	8125	2740	8140	8440	XOHX 12T3-25,8-62	H62 25800. ..	7710
XOHX 12T3-25,9	H60 25900. ..							XOHX 12T3-25,9-62	H62 25900. ..	
XOHX 12T3-26,0	H60 26000. ..							XOHX 12T3-26,0-62	H62 26000. ..	
XOHX 12T3-26,1	H60 26100. ..							XOHX 12T3-26,1-62	H62 26100. ..	
XOHX 12T3-26,2	H60 26200. ..							XOHX 12T3-26,2-62	H62 26200. ..	
XOHX 12T3-26,3	H60 26300. ..	84	2715	8125	2740	8140	8440	XOHX 12T3-26,3-62	H62 26300. ..	7710
XOHX 12T3-26,4	H60 26400. ..							XOHX 12T3-26,4-62	H62 26400. ..	
XOHX 12T3-26,5	H60 26500. ..							XOHX 12T3-26,5-62	H62 26500. ..	
XOHX 12T3-26,6	H60 26600. ..							XOHX 12T3-26,6-62	H62 26600. ..	
XOHX 12T3-26,7	H60 26700. ..							XOHX 12T3-26,7-62	H62 26700. ..	
XOHX 12T3-26,8	H60 26800. ..	84	2715	8125	2740	8140	8440	XOHX 12T3-26,8-62	H62 26800. ..	7710
XOHX 12T3-26,9	H60 26900. ..							XOHX 12T3-26,9-62	H62 26900. ..	
XOHX 12T3-27,0	H60 27000. ..							XOHX 12T3-27,0-62	H62 27000. ..	
XOHX 12T3-27,1	H60 27100. ..							XOHX 12T3-27,1-62	H62 27100. ..	
XOHX 12T3-27,2	H60 27200. ..							XOHX 12T3-27,2-62	H62 27200. ..	
XOHX 12T3-27,3	H60 27300. ..	84	2715	8125	2740	8140	8440	XOHX 12T3-27,3-62	H62 27300. ..	7710
XOHX 12T3-27,4	H60 27400. ..							XOHX 12T3-27,4-62	H62 27400. ..	
XOHX 12T3-27,5	H60 27500. ..							XOHX 12T3-27,5-62	H62 27500. ..	
XOHX 12T3-27,6	H60 27600. ..							XOHX 12T3-27,6-62	H62 27600. ..	
XOHX 12T3-27,7	H60 27700. ..							XOHX 12T3-27,7-62	H62 27700. ..	

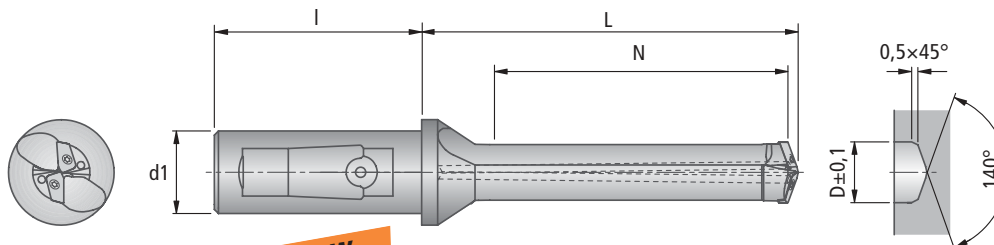
KUB Duon® Ø 27,8 – 31,2 mm

drilling depth up to 5 × D – R.H. cutting





ABS® connection



Cylindrical shank
(combination shank)
DIN 6535 HE
(similar to 1835 E)
and 6595



new

D	ABS					Cylindrical shank					Spares		
	ABS d	Order No.	N	L	 approx.	Cylindrical shank d1xL	Order No.	N	L	 approx.	 Clamping screw Order No. Article	 Screwdriver Order No. Article	Clamping torque Nm
27,8	50	U20 02800	140	175	0,8	40x68	U20 92800	140	169	1,12	N00 57640 S/M3,5x6,9-10IP	L05 00850 10IP	3,00
27,9													
28,0													
28,1													
28,2													
28,3	50	U20 02850	145	180	0,8	40x68	U20 92850	145	174	1,14	N00 57640 S/M3,5x6,9-10IP	L05 00850 10IP	3,00
28,4													
28,5													
28,6													
28,7													
28,8	50	U20 02900	145	180	0,8	40x68	U20 92900	145	174	1,16	N00 57640 S/M3,5x6,9-10IP	L05 00850 10IP	3,00
28,9													
29,0													
29,1													
29,2													
29,3	50	U20 02950	150	190	0,9	40x68	U20 92950	150	179	1,18	N00 57640 S/M3,5x6,9-10IP	L05 00850 10IP	3,00
29,4													
29,5													
29,6													
29,7													
29,8	50	U20 03000	150	190	0,9	40x68	U20 93000	150	179	1,20	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
29,9													
30,0													
30,1													
30,2													
30,3	50	U20 03050	155	195	0,9	40x68	U20 93050	155	184	1,22	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
30,4													
30,5													
30,6													
30,7													
30,8	50	U20 03100	155	195	0,9	40x68	U20 93100	155	184	1,24	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
30,9													
31,0													
31,1													
31,2													

Important: See page 19 for application details and safety notes !

EP 0 547 049 and other patents (ABS®); patents applied for (KUB Duon®)

Inserts shown in bold print are kept in stock.
Intermediate dimensions can be supplied on request.

Supply includes:

KUB Duon® drill with clamping screws and screwdriver; insert not included (pack of 2 inserts).

Order example: Insert:

for Ø28, coating BK84, Order No.: H60 28000.84

Areas of use:

(● = main use / ○ = suitable in some cases)

- high tensile strength steels, heat treated steels and tool steels
- stainless and acid resistant steels
- grey cast iron, SG cast iron
- cast aluminium alloys, brass and bronze which produce short chips

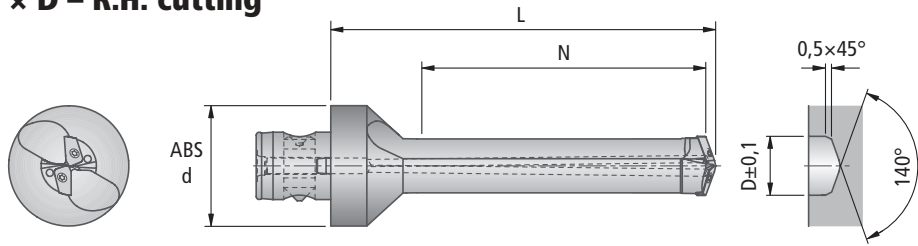
Basic recommendation										
Insert ISO-Code enter carbide	for workpiece material Order No.							Insert ISO-Code enter carbide	for workpiece material Order No.	
		BK84	BK2715	BK8125	BK2740	BK8140	BK8440			
XOHX 12T3-27,8	H60 27800. ..							XOHX 12T3-27,8-62	H62 27800. ..	
XOHX 12T3-27,9	H60 27900. ..							XOHX 12T3-27,9-62	H62 27900. ..	
XOHX 12T3-28,0	H60 28000. ..	84	2715	8125	2740	8140	8440	XOHX 12T3-28,0-62	H62 28000. ..	7710
XOHX 12T3-28,1	H60 28100. ..							XOHX 12T3-28,1-62	H62 28100. ..	
XOHX 12T3-28,2	H60 28200. ..							XOHX 12T3-28,2-62	H62 28200. ..	
XOHX 12T3-28,3	H60 28300. ..							XOHX 12T3-28,3-62	H62 28300. ..	
XOHX 12T3-28,4	H60 28400. ..							XOHX 12T3-28,4-62	H62 28400. ..	
XOHX 12T3-28,5	H60 28500. ..	84	2715	8125	2740	8140	8440	XOHX 12T3-28,5-62	H62 28500. ..	7710
XOHX 12T3-28,6	H60 28600. ..							XOHX 12T3-28,6-62	H62 28600. ..	
XOHX 12T3-28,7	H60 28700. ..							XOHX 12T3-28,7-62	H62 28700. ..	
XOHX 12T3-28,8	H60 28800. ..							XOHX 12T3-28,8-62	H62 28800. ..	
XOHX 12T3-28,9	H60 28900. ..							XOHX 12T3-28,9-62	H62 28900. ..	
XOHX 12T3-29,0	H60 29000. ..	84	2715	8125	2740	8140	8440	XOHX 12T3-29,0-62	H62 29000. ..	7710
XOHX 12T3-29,1	H60 29100. ..							XOHX 12T3-29,1-62	H62 29100. ..	
XOHX 12T3-29,2	H60 29200. ..							XOHX 12T3-29,2-62	H62 29200. ..	
XOHX 12T3-29,3	H60 29300. ..							XOHX 12T3-29,3-62	H62 29300. ..	
XOHX 12T3-29,4	H60 29400. ..							XOHX 12T3-29,4-62	H62 29400. ..	
XOHX 12T3-29,5	H60 29500. ..	84	2715	8125	2740	8140	8440	XOHX 12T3-29,5-62	H62 29500. ..	7710
XOHX 12T3-29,6	H60 29600. ..							XOHX 12T3-29,6-62	H62 29600. ..	
XOHX 12T3-29,7	H60 29700. ..							XOHX 12T3-29,7-62	H62 29700. ..	
XOHX 1504-29,8	H60 29800. ..							XOHX 1504-29,8-62	H62 29800. ..	
XOHX 1504-29,9	H60 29900. ..							XOHX 1504-29,9-62	H62 29900. ..	
XOHX 1504-30,0	H60 30000. ..	84	2715	8125	2740	8140	8440	XOHX 1504-30,0-62	H62 30000. ..	7710
XOHX 1504-30,1	H60 30100. ..							XOHX 1504-30,1-62	H62 30100. ..	
XOHX 1504-30,2	H60 30200. ..							XOHX 1504-30,2-62	H62 30200. ..	
XOHX 1504-30,3	H60 30300. ..							XOHX 1504-30,3-62	H62 30300. ..	
XOHX 1504-30,4	H60 30400. ..							XOHX 1504-30,4-62	H62 30400. ..	
XOHX 1504-30,5	H60 30500. ..	84	2715	8125	2740	8140	8440	XOHX 1504-30,5-62	H62 30500. ..	7710
XOHX 1504-30,6	H60 30600. ..							XOHX 1504-30,6-62	H62 30600. ..	
XOHX 1504-30,7	H60 30700. ..							XOHX 1504-30,7-62	H62 30700. ..	
XOHX 1504-30,8	H60 30800. ..							XOHX 1504-30,8-62	H62 30800. ..	
XOHX 1504-30,9	H60 30900. ..							XOHX 1504-30,9-62	H62 30900. ..	
XOHX 1504-31,0	H60 31000. ..	84	2715	8125	2740	8140	8440	XOHX 1504-31,0-62	H62 31000. ..	7710
XOHX 1504-31,1	H60 31100. ..							XOHX 1504-31,1-62	H62 31100. ..	
XOHX 1504-31,2	H60 31200. ..							XOHX 1504-31,2-62	H62 31200. ..	

KUB DUON

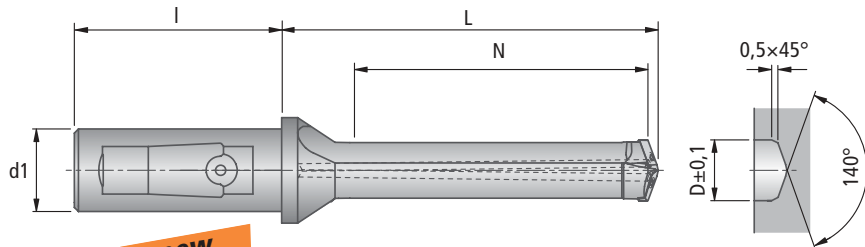
KUB Duon® Ø 31,3 – 34,7 mm

drilling depth up to 5 × D – R.H. cutting





ABS® connection



Cylindrical shank
(combination shank)
DIN 6535 HE
(similar to 1835 E)
and 6595



new

D	ABS					Cylindrical shank					Spares		
	ABS d	Order No.	N	L	 approx.	Cylindrical shank d1xL	Order No.	N	L	 approx.	 Order No. Article	 Order No. Article	Clamping torque Nm
31,3	50	U20 03150	160	200	0,9	40x68	U20 93150	160	189	1,27	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
31,4													
31,5													
31,6													
31,7													
31,8	50	U20 03200	160	200	0,9	40x68	U20 93200	160	189	1,28	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
31,9													
32,0													
32,1													
32,2													
32,3	50	U20 03250	165	205	0,9	40x68	U20 93250	165	194	1,32	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
32,4													
32,5													
32,6													
32,7													
32,8	50	U20 03300	165	205	0,9	40x68	U20 93300	165	194	1,33	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
32,9													
33,0													
33,1													
33,2													
33,3	50	U20 03350	170	210	0,9	40x68	U20 93350	170	199	1,36	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
33,4													
33,5													
33,6													
33,7													
33,8	50	U20 03400	170	210	1,0	40x68	U20 93400	170	199	1,37	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
33,9													
34,0													
34,1													
34,2													
34,3	50	U20 03450	175	215	1,0	40x68	U20 93450	175	204	1,41	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
34,4													
34,5													
34,6													
34,7													

Important: See page 19 for application details and safety notes !

EP 0 547 049 and other patents (ABS®); patents applied for (KUB Duon®)

Inserts shown in bold print are kept in stock.
Intermediate dimensions can be supplied on request.

Supply includes:

KUB Duon® drill with clamping screws and screwdriver; insert not included (pack of 2 inserts).

Order example: Insert:

for Ø32, coating BK84, Order No.: H60 32000.84

Areas of use:

(● = main use / ○ = suitable in some cases)

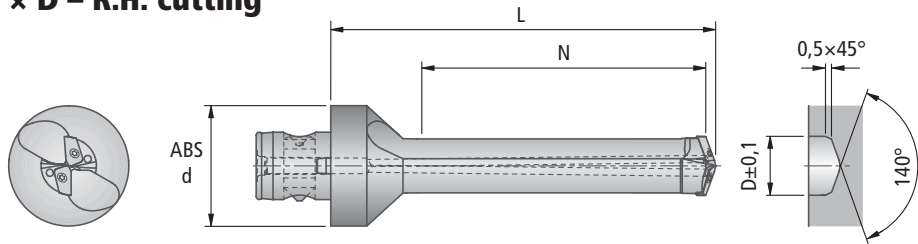
- high tensile strength steels, heat treated steels and tool steels
- stainless and acid resistant steels
- grey cast iron, SG cast iron
- cast aluminium alloys, brass and bronze which produce short chips

Basic recommendation										
Insert	for workpiece material						Insert	for workpiece material		
	ISO-Code	Order No.								ISO-Code
enter carbide							enter carbide			
XOHX1504-31,3	H60 31300. ..						XOHX1504-31,3-62	H62 31300. ..		
XOHX1504-31,4	H60 31400. ..						XOHX1504-31,4-62	H62 31400. ..		
XOHX 1504-31,5	H60 31500. ..	84	2715	8125	2740	8140	XOHX 1504-31,5-62	H62 31500. ..	7710	
XOHX1504-31,6	H60 31600. ..						XOHX1504-31,6-62	H62 31600. ..		
XOHX1504-31,7	H60 31700. ..						XOHX1504-31,7-62	H62 31700. ..		
XOHX1504-31,8	H60 31800. ..						XOHX1504-31,8-62	H62 31800. ..		
XOHX1504-31,9	H60 31900. ..						XOHX1504-31,9-62	H62 31900. ..		
XOHX 1504-32,0	H60 32000. ..	84	2715	8125	2740	8140	XOHX 1504-32,0-62	H62 32000. ..	7710	
XOHX1504-32,1	H60 32100. ..						XOHX1504-32,1-62	H62 32100. ..		
XOHX1504-32,2	H60 32200. ..						XOHX1504-32,2-62	H62 32200. ..		
XOHX1504-32,3	H60 32300. ..						XOHX1504-32,3-62	H62 32300. ..		
XOHX1504-32,4	H60 32400. ..						XOHX1504-32,4-62	H62 32400. ..		
XOHX 1504-32,5	H60 32500. ..	84	2715	8125	2740	8140	XOHX 1504-32,5-62	H62 32500. ..	7710	
XOHX1504-32,6	H60 32600. ..						XOHX1504-32,6-62	H62 32600. ..		
XOHX1504-32,7	H60 32700. ..						XOHX1504-32,7-62	H62 32700. ..		
XOHX1504-32,8	H60 32800. ..						XOHX1504-32,8-62	H62 32800. ..		
XOHX1504-32,9	H60 32900. ..						XOHX1504-32,9-62	H62 32900. ..		
XOHX 1504-33,0	H60 33000. ..	84	2715	8125	2740	8140	XOHX 1504-33,0-62	H62 33000. ..	7710	
XOHX1504-33,1	H60 33100. ..						XOHX1504-33,1-62	H62 33100. ..		
XOHX1504-33,2	H60 33200. ..						XOHX1504-33,2-62	H62 33200. ..		
XOHX1504-33,3	H60 33300. ..						XOHX1504-33,3-62	H62 33300. ..		
XOHX1504-33,4	H60 33400. ..						XOHX1504-33,4-62	H62 33400. ..		
XOHX 1504-33,5	H60 33500. ..	84	2715	8125	2740	8140	XOHX 1504-33,5-62	H62 33500. ..	7710	
XOHX1504-33,6	H60 33600. ..						XOHX1504-33,6-62	H62 33600. ..		
XOHX1504-33,7	H60 33700. ..						XOHX1504-33,7-62	H62 33700. ..		
XOHX1504-33,8	H60 33800. ..						XOHX1504-33,8-62	H62 33800. ..		
XOHX1504-33,9	H60 33900. ..						XOHX1504-33,9-62	H62 33900. ..		
XOHX 1504-34,0	H60 34000. ..	84	2715	8125	2740	8140	XOHX 1504-34,0-62	H62 34000. ..	7710	
XOHX1504-34,1	H60 34100. ..						XOHX1504-34,1-62	H62 34100. ..		
XOHX1504-34,2	H60 34200. ..						XOHX1504-34,2-62	H62 34200. ..		
XOHX1504-34,3	H60 34300. ..						XOHX1504-34,3-62	H62 34300. ..		
XOHX1504-34,4	H60 34400. ..						XOHX1504-34,4-62	H62 34400. ..		
XOHX 1504-34,5	H60 34500. ..	84	2715	8125	2740	8140	XOHX 1504-34,5-62	H62 34500. ..	7710	
XOHX1504-34,6	H60 34600. ..						XOHX1504-34,6-62	H62 34600. ..		
XOHX1504-34,7	H60 34700. ..						XOHX1504-34,7-62	H62 34700. ..		

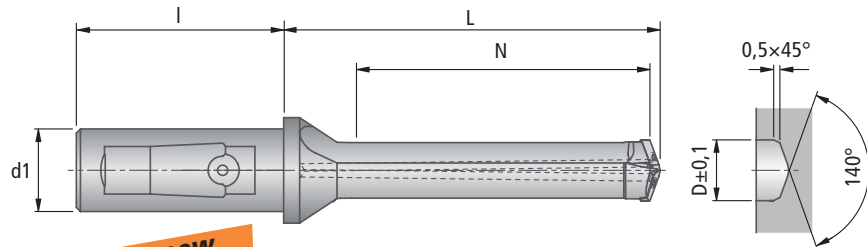
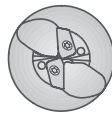
KUB Duon® Ø 34,8 – 36,2 mm

drilling depth up to 5 × D – R.H. cutting





ABS® connection



Cylindrical shank
(combination shank)
DIN 6535 HE
(similar to 1835 E)
and 6595



new

D	ABS					Cylindrical shank					Spares		
	ABS d	Order No.	N	L	 approx.	Cylindrical shank d1×l	Order No.	N	L	 approx.	 Order No. Article	 Order No. Article	Clamping torque Nm
34,8	50	U20 03500	175	215	1,0	40×68	U20 93500	175	204	1,43	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
34,9													
35,0													
35,1													
35,2	50	U20 03550	180	220	1,0	40×68	U20 93550	180	209	1,47	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
35,3													
35,4													
35,5													
35,6	50	U20 03600	180	220	1,0	40×68	U20 93600	180	209	1,49	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
35,7													
35,8													
35,9													
36,0	50	U20 03600	180	220	1,0	40×68	U20 93600	180	209	1,49	N00 57650 S/M4x8,7-15IP	L05 00860 15IP	4,40
36,1													
36,2													

Important: See page 19 for application details and safety notes !

Inserts shown in bold print are kept in stock.
Intermediate dimensions can be supplied on request.

Supply includes:

KUB Duon® drill with clamping screws and screwdriver; insert not included (pack of 2 inserts).

Order example: Insert:

for Ø35, coating BK84, Order No.: H60 35000.84

Areas of use:

(● = main use / ○ = suitable in some cases)

- high tensile strength steels, heat treated steels and tool steels
- stainless and acid resistant steels
- grey cast iron, SG cast iron
- cast aluminium alloys, brass and bronze which produce short chips

Basic recommendation										
Insert ISO-Code enter carbide	for workpiece material Order No.	for workpiece material						Insert ISO-Code enter carbide	for workpiece material Order No.	
		●	○	●	○	○	○			
		BK84	BK2715	BK8125	BK2740	BK8140	BK8440		BK7710	
XOHX1504-34,8	H60 34800. ..							XOHX1504-34,8-62	H62 34800. ..	
XOHX1504-34,9	H60 34900. ..							XOHX1504-34,9-62	H62 34900. ..	
XOHX 1504-35,0	H60 35000. ..	84	2715	8125	2740	8140	8440	XOHX 1504-35,0-62	H62 35000. ..	7710
XOHX1504-35,1	H60 35100. ..							XOHX1504-35,1-62	H62 35100. ..	
XOHX1504-35,2	H60 35200. ..							XOHX1504-35,2-62	H62 35200. ..	
XOHX1504-35,3	H60 35300. ..							XOHX1504-35,3-62	H62 35300. ..	
XOHX1504-35,4	H60 35400. ..							XOHX1504-35,4-62	H62 35400. ..	
XOHX 1504-35,5	H60 35500. ..	84	2715	8125	2740	8140	8440	XOHX 1504-35,5-62	H62 35500. ..	7710
XOHX1504-35,6	H60 35600. ..							XOHX1504-35,6-62	H62 35600. ..	
XOHX1504-35,7	H60 35700. ..							XOHX1504-35,7-62	H62 35700. ..	
XOHX1504-35,8	H60 35800. ..							XOHX1504-35,8-62	H62 35800. ..	
XOHX1504-35,9	H60 35900. ..							XOHX1504-35,9-62	H62 35900. ..	
XOHX 1504-36,0	H60 36000. ..	84	2715	8125	2740	8140	8440	XOHX 1504-36,0-62	H62 36000. ..	7710
XOHX1504-36,1	H60 36100. ..							XOHX1504-36,1-62	H62 36100. ..	
XOHX1504-36,2	H60 36200. ..							XOHX1504-36,2-62	H62 36200. ..	

KUB DUON

KUB Duon® Ø 17,3 – 36,2 mm

Applications

1

Workpiece: Cast frame
 Material: GGG50
 Machine: Machining centre
 Tool: U20 02500; Ø 25 mm
 Insert: H60 25000.2715

Cutting data:
 $v_c = 100$ m/min
 $f = 0,4$ mm
 Tool life 53 m



✓ Abrasive material

2

Workpiece: Gear rack
 Material: C45
 Machine: Boring machine with
 ABS spindle flange
 Tool: U20 02200; Ø 22 mm
 Insert: H60 22000.84

Cutting data:
 $v_c = 137$ m/min
 $f = 0,14$ mm
 Tool life 20 m

- ✓ Stable machine
- ✓ Coolant supplied via coolant ring
- ✓ Interrupted cut



3

Workpiece: Chain link connection
 Material: 35Mn5Cr (1200-1400 N/m²)
 Machine: Machining centre ISO50
 Tool: U20 02100; Ø 21 mm rotating
 Insert: H60 21000.84

**Performance comparison,
 KUB Duon / Competitor:**

$v_c = 70$ m/min + 75%

$v_c = 108$ m/min

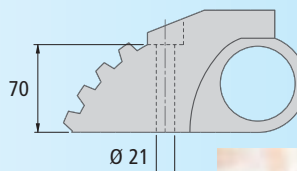
$f = 0,1$ mm + 60%

$f = 0,16$ mm

Tool life 1,6 m

Tool life 9,9 m + 600%

- ✓ Heat treated steel with high tensile strength



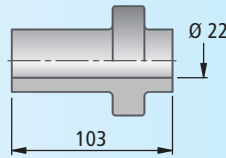
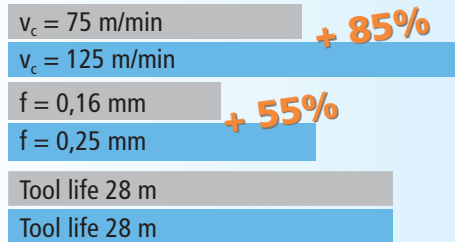
4

Workpiece: Bolt

Material: 35MnVS5
 Machine: Lathe (stationary)
 Tool: U20 02200; Ø 22 mm
 Insert: H60 22000.2715

✓ **User friendly - inserts can be changed from the front**

Performance comparison, KUB Duon / Competitor:



5

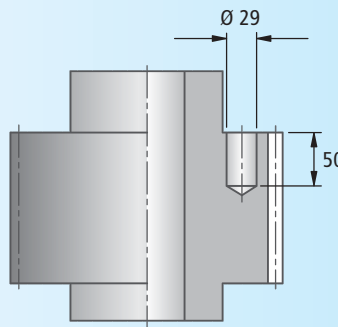
Workpiece: Gearwheel

Material: 42CrMoV4
 Machine: Machining centre with universal angled head
 Tool: U20 02900; Ø 29 mm
 Insert: H60 29000.84

✓ **Tool restriction easily bridged**

Cutting data:

$v_c = 140$ m/min
 $f_c = 0,25$ mm
 Tool life: no wear visible after 9.6 m



6

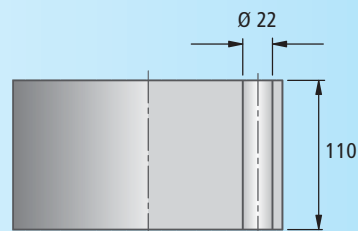
Workpiece: Extruder housing

Material: 34CrNiMo6
 Machine: Vertical CNC boring machine
 Tool: U20 02200; Ø 22 mm
 Insert: H60 22000.2715

✓ **Coolant supply via cooling ring adaptor**
 ✓ **Coolant pressure only 5 bar**

Cutting data:

$v_c = 120$ m/min
 $f_c = 0,25$ mm
 Tool life 22 m

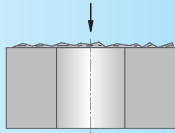


Technical Notes for KUB Duon®

up to **5 × D**

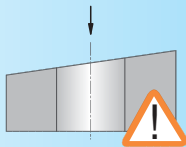
1 Starting on uneven surfaces (cast surfaces)

- Possible in principle
- Reduce feed rate when starting bore



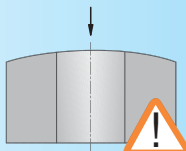
2 Starting on angled surfaces

- Spot face surface before starting bore
- Avoid chips jams



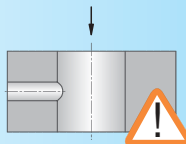
2.1 Starting on cambered surfaces

- Centered boring can be started with reduced feed rate
- Spot facing is required if the point for starting the bore is outside the radius centre



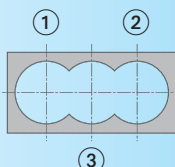
3 Drilling through a cross bore

- Halve feed rate at interruption
- Cross bore max. 1/3 of bore diameter
- Off-centre cross bore **not possible**



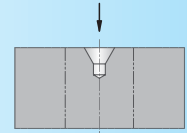
4 Drilling a chamber

- First bore Nos. ① + ②, then bore No. ③
- Ensure division is symmetrical
- Avoid chips jams
- Offset max. $0.8 \times D$



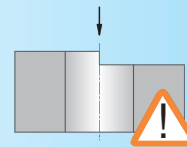
5 Starting on a groove or large centering bore

- Possible under certain conditions
- Reduce feed rate if necessary
- Face beforehand where centre is particularly large



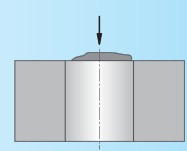
6 Starting on an edge

- Start point must be flat



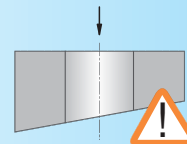
7 Starting on a welded seam

- Reduce feed rate when starting bore
- Face beforehand if necessary



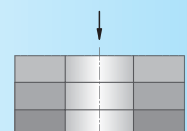
8 Angled bore exit

- Possible under certain conditions
- Reduce feed rate if necessary



9 Drilling through stacked plates

- Possible in principle
- Avoid large spaces between elements



KUB Duon® Ø 17,3 – 36,2 mm

Technical Notes



Guideline values for solid drilling with KUB Duon®

Material group	Strength Rm N/mm²	Hardness HB	Material	Material example material code/DIN	Cutting speed v _c m/min	Max. feed f (mm/rev)		
						Ø 17,3 - 20,7	Ø 20,8 - 29,7	Ø 29,8 - 36,2
1.0	≤500		non-alloy steels	S37-2 / 1.0037, 95Mn28 / 1.0715, St44-2 / 1.0044				
2.0	500-900		non-alloy / low alloy steels	S52-2 / 1.0050, C55 / 1.0525, 16MnCr5 / 1.7131	140	0,30	0,40	0,45
2.1	<500		lead alloys	95MnPb28 / 1.0718	160	0,30	0,40	0,50
3.0	>900		non alloy / low alloy steels: heat resostant structural, heat treated, nitride and tools steels	42CrMo4 / 1.7225, CK60 / 1.1221	120	0,20	0,25	0,30
4.0	>900		high alloy steels	X6CrMo4 / 1.2341, X165CrMoV12/1.2601	100	0,15	0,20	0,25
4.1			high alloy steels					
5.0		250	special alloys: Inconel, Hastelloy, Nimonic, etc.	Inconel 718/2.4668, Nimonic 80A/2.4631				
5.1	400		titanium, titanium alloys	TiAl5Sn2 / 3.7114				
6.0	≤600		stainless steels	X2CrNi189 / 1.4306, X5CrNiMo1810/ 1.4401	90	0,13	0,15	0,17
6.1	<900		stainless steels	X8CrNb17/1.4511, X10CrNiMoTi1810/ 1.4571				
7.0	>900		stainless / fireproof steels	X20Cr13 / 1.4021, X40Cr13 / 1.4034				
8.0		180	gray cast iron	GG-25/0.6025, GG-35/0.6035	140	0,30	0,40	0,50
8.1		250	alloy gray cast iron	GG-NiCr202 / 0.6660	100	0,20	0,30	0,40
9.0	≤600	130	spheroidal, graphite cast iron, ferritic	GGG-40 / 0.7040	120	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	100	0,20	0,30	0,40
10.0	>600	250	spheroidal graph. cast iron, perlitic, malleable iron	GGG-60 / 0.7060 GTS-65 / 0.8165	120	0,20	0,30	0,40
10.1		200	alloyed spheroidal graphite cast iron	GGG-NiCr20-2 / 0.7661	100	0,25	0,35	0,45
10.2		300	vermicular cast iron	GGV Ti < 0,2 GGV Ti > 0,2	80	0,20	0,30	0,40
12.0		90	copper alloy, brass, lead-alloy bronze, lead bronze: good cut	CuZn36Pb3 / 2.1182, G-CuPb15Sn / 2.1182	180	0,30	0,40	0,50
12.1		100	copper alloy, brass, bronze: average cut	CuZn40Al1 / 2.0550, E-Cu57 / 2.0060				
13.0		60	wrought aluminium alloys	AlMg1 / 3.3315, AlMnCu / 3.0517	400	0,20	0,20	0,20
13.1		75	cast alum. alloy: Si-content <10% magnesium alloy	G-AlMg5 / 3.3561, G-AlSi9Mg / 3.2373	350	0,20	0,20	0,20
14.0		100	cast alum.alloy: Si-content >10%	G-AlSi10Mg / 3.2381				
15.0	1400		hardened steels < 45 HRC					
16.0	1800		hardened steels > 45 HRC					

✓ Flexibility is the trump card



◀ Design to customer requirement e.g. with integral steps or chamfering insert

Suitable for retro-fitting a chamfering cartridge ▶



Safety notes

- Important note: On exit of the drill a disc as shown is ejected. With rotating components this can cause accidents. Please arrange suitable guarding.
- The technical notes provided in the application details depend on the environmental and application conditions (such as machine, environmental temperature, lubrication/coolant used and desired machining results): these are based on proper application conditions, use and compliance with the spindle speed limits given for the tools.
- To prevent damage to machine and tool, we recommend that the drive power be calculated in advance. The drive power which is actually available will be found in the machine manufacturer's spindle speed/performance diagram.
- Safety equipment should be provided to protect personnel from flying chips.
- To ensure the best possible tool life, the insert should be changed promptly.

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