

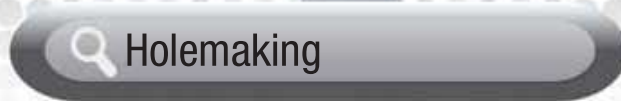
■ SPF Drills • B/K531, B/K532 Series • Grade KDF400™ • Dry Applications for Drill Diameters 3–12mm



		Cutting Speed – vc			Metric						
		Range – m/min			Recommended Feed Rate (f) by Diameter						
Material Group		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0
N 6	6	90	120	150	mm/r	0,03 - 0,20	0,03 - 0,20	0,03 - 0,20	0,03 - 0,20	0,03 - 0,20	0,03 - 0,20
		Cutting Speed – vc			Inch						
		Range – SFM			Recommended Feed Rate (f) by Diameter						
Material Group		min	Starting Value	max		1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500
N 6	6	300	390	490	IPR	.001 - .008	.001 - .008	.001 - .008	.001 - .008	.001 - .008	.001 - .008

Solid Carbide Drills

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