Drill Fix™ DFSP™ • Metric

Metric															
						Cutting Speed — vc Range — m/min			Recommended Feed Rate (fz) by Diameter						
Material Group		Condition	Pocket Seat	Geometry	Grade	min	Starting Value	max	Ø	SPGX05 DFTX2 14,00–18,00mm	SPGX06 DFT03 18,00–21,99mm	SPGX07 DFT05 22,00–25,99mm	SPGX09 DFT05 26,00–32,99mm	SPGX12 DFT06/..07 33,00–43,99mm	SPGX15 DFT07/..09 44,00–55,00mm
P	0	S	O	LP	KCU40	310	**325**	360	mm/r	0,06–0,10	0,06–0,11	0,08–0,14	0,12–0,21	0,14–0,26	0,16–0,26
			I	DS	KCU40										
		U	O	LP	KCU40	200	**215**	230	mm/r	0,05–0,07	0,06–0,08	0,07–0,10	0,07–0,12	0,09–0,15	0,11–0,21
			I	HP	KCU40										
		I	O	HP	KCU40	130	**135**	150	mm/r	0,05–0,07	0,06–0,08	0,07–0,10	0,07–0,12	0,09–0,15	0,11–0,21
			I	HP	KCU40										
	1	S	O	FP	KCPK10	310	**325**	360	mm/r	0,06–0,11	0,08–0,14	0,10–0,18	0,14–0,25	0,16–0,30	0,18–0,30
			I	HP	KC7140										
		U	O	FP	KCU25	200	**215**	230	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
		I	O	HP	KCU40	130	**135**	150	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	2	S	O	FP	KCPK10	310	**325**	360	mm/r	0,06–0,11	0,08–0,14	0,10–0,18	0,14–0,25	0,16–0,30	0,18–0,30
			I	HP	KC7140										
		U	O	FP	KCU25	200	**215**	230	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
		I	O	HP	KCU40	130	**135**	150	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	3	S	O	FP	KCPK10	260	**285**	320	mm/r	0,06–0,11	0,08–0,14	0,10–0,18	0,14–0,25	0,16–0,30	0,18–0,30
			I	HP	KC7140										
		U	O	HP	KCU25	180	**195**	220	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
		I	O	HP	KCU40	110	**120**	140	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	4	S	O	FP	KCPK10	220	**250**	300	mm/r	0,06–0,11	0,08–0,14	0,10–0,18	0,14–0,25	0,16–0,30	0,18–0,30
			I	HP	KC7140										
		U	O	HP	KCU25	150	**180**	220	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
		I	O	HP	KCU40	90	**110**	140	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	5	S	O	HP	KCU25	180	**200**	220	mm/r	0,06–0,11	0,08–0,14	0,10–0,18	0,14–0,25	0,16–0,30	0,18–0,30
			I	HP	KC7140										
		U	O	HP	KCU40	120	**135**	150	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
		I	O	HP	KC7140	70	**85**	100	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	6	S	O	HP	KCU25	180	**200**	220	mm/r	0,06–0,11	0,08–0,14	0,10–0,18	0,14–0,25	0,16–0,30	0,18–0,30
			I	HP	KC7140										
		U	O	HP	KCU40	120	**135**	150	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
		I	O	HP	KC7140	70	**85**	100	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13-0,25
			I	HP	KC7140										
M	1	S	O	LP	KCU40	150	**190**	230	mm/r	0,05–0,08	0,06–0,10	0,07–0,12	0,10–0,16	0,12–0,21	0,14–0,24
			I	DS	KCU40										
		U	O	LP	KCU40	100	**130**	160	mm/r	0,05–0,07	0,06–0,08	0,07–0,10	0,05–0,10	0,06–0,13	0,08–0,16
			I	DS	KCU40										
		I	O	MD	KC7140	60	**80**	100	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140										
	2	S	O	LP	KCU40	150	**180**	210	mm/r	0,05–0,08	0,06–0,10	0,07–0,12	0,10–0,16	0,12–0,21	0,14–0,24
			I	DS	KCU40										
		U	O	MD	KCU40	100	**130**	160	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,07–0,13	0,08–0,16	0,10–0,20
			I	MD	KC7140										
		I	O	MD	KC7140	60	**80**	100	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140										
	3	S	O	LP	KCU40	100	**130**	160	mm/r	0,05–0,07	0,06–0,08	0,07–0,10	0,05–0,10	0,06–0,13	0,08–0,16
			I	DS	KCU40										
		U	O	HP	KCU40	80	**110**	140	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,07–0,13	0,08–0,16	0,10–0,20
			I	HP	KC7140										
		I	O	MD	KC7140	50	**70**	90	mm/r	0,03–0,05	0,04–0,07	0,05–0,09	0,07–0,13	0,08–0,16	0,10–0,18
			I	MD	KC7140										

NOTE: Applying Drill Fix™ DFSP 5 x D requires high stability. It is highly recommended to be conservative in regard to speeds and feeds, and start with minimum values indicated.

Condition: S = Stable cutting conditions;
U = Unstable cutting conditions;
I = Interrupted cutting conditions

Pocket seat: I = Inboard insert;
O = Outboard insert

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Drill Fix™ DFSP™ • Metric

Metric																
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (fz) by Diameter							
						min	Starting Value	max	Ø	SPGX05 DFTX2 14,00–18,00mm	SPGX06 DFT03 18,00–21,99mm	SPGX07 DFT05 22,00–25,99mm	SPGX09 DFT05 26,00–32,99mm	SPGX12 DFT06/..07 33,00–43,99mm	SPGX15 DFT07/..09 44,00–55,00mm
K	1	S	O	FP	KCPK10	200	**240**	300	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KCU40										
		U	O	FP	KCU25	120	**155**	200	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KC7140										
		I	O	FP	KC7140	80	**100**	125	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	2	S	O	FP	KCPK10	180	**220**	260	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KCU40										
		U	O	HP	KCU25	110	**140**	170	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KC7140										
		I	O	HP	KC7140	80	**100**	120	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	3	S	O	HP	KCPK10	180	**220**	260	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KCU40										
		U	O	HP	KCU25	110	**140**	170	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KC7140										
		I	O	HP	KC7140	80	**100**	120	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
N	1	S	O	HP	KCPK10	350	**500**	650	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KMF										
		U	O	HP	KCU40	300	**400**	500	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KMF										
		I	O	HP	KCU40	200	**300**	400	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KMF										
	2	S	O	HP	KCPK10	300	**400**	500	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KMF										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KMF										
		I	O	HP	KCU40	175	**250**	325	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KMF										
	3	S	O	HP	KCPK10	300	**400**	500	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KMF										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KMF										
		I	O	HP	KCU40	150	**250**	350	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KMF										
	4	S	O	HP	KCU25	300	**400**	500	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KC7140										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KC7140										
		I	O	HP	KCU40	200	**300**	400	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	5	S	O	HP	KCU25	300	**400**	500	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KC7140										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KC7140										
		I	O	HP	KCU40	200	**300**	400	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KC7140										
	6	S	O	HP	KCU40	400	**450**	500	mm/r	0,07–0,12	0,10–0,16	0,12–0,20	0,16–0,28	0,18–0,32	0,20–0,34
			I	HP	KMF										
		U	O	HP	KCU40	250	**350**	450	mm/r	0,05–0,09	0,06–0,12	0,08–0,15	0,12–0,20	0,14–0,25	0,16–0,28
			I	HP	KMF										
		I	O	HP	KCU40	200	**300**	400	mm/r	0,04–0,06	0,05–0,08	0,06–0,10	0,09–0,15	0,11–0,18	0,13–0,25
			I	HP	KMF										

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Drill Fix™ DFSP™ • Metric

Metric															
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — m/min			Recommended Feed Rate (fz) by Diameter						
						min	Starting Value	max	Ø	SPGX05 DFTX2 14,00–18,00mm	SPGX06 DFT03 18,00–21,99mm	SPGX07 DFT05 22,00–25,99mm	SPGX09 DFT05 26,00–32,99mm	SPGX12 DFT06/..07 33,00–43,99mm	SPGX15 DFT07/..09 44,00–55,00mm
S	1	S	O	HP	KCU40	60	**70**	75	mm/r	0,03–0,06	0,04–0,08	0,05–0,10	0,08–0,12	0,10–0,15	0,12–0,18
			I	MD	KC7140										
		U	O	HP	KCU40	40	**50**	60	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140										
		I	O	HP	KCU40	25	**30**	40	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140										
	2	S	O	HP	KCU40	50	**60**	70	mm/r	0,03–0,06	0,04–0,08	0,05–0,10	0,08–0,12	0,10–0,15	0,12–0,18
			I	MD	KC7140										
		U	O	HP	KCU40	30	**40**	50	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140										
		I	O	HP	KCU40	25	**30**	40	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140										
	3	S	O	LP	KCU40	70	**80**	90	mm/r	0,03–0,06	0,04–0,08	0,05–0,10	0,08–0,12	0,10–0,15	0,12–0,18
			I	DS	KC7140										
		U	O	LP	KCU40	50	**60**	70	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	DS	KC7140										
		I	O	HP	KCU40	30	**40**	50	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140										
	4	S	O	LP	KCU40	70	**80**	90	mm/r	0,03–0,06	0,04–0,08	0,05–0,10	0,08–0,12	0,10–0,15	0,12–0,18
			I	DS	KC7140										
		U	O	LP	KCU40	50	**60**	70	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	DS	KC7140										
		I	O	HP	KCU40	30	**40**	50	mm/r	0,02–0,03	0,02–0,04	0,03–0,05	0,04–0,06	0,05–0,08	0,06–0,10
			I	MD	KC7140										

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Drill Fix™ DFSP™ • Inch

Inch																
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM min	Starting Value	max	Recommended Feed Rate (fz) by Diameter Ø	SPGX05 DFTX2 .551–.708"	SPGX06 DFT03 .709–.865"	SPGX07 DFT05 .866–1.023"	SPGX09 DFT05 1.024–1.299"	SPGX12 DFT06/..07 1.300–1.732"	SPGX15 DFT07/..09 1.733–2.165"
P	0	S	O	LP	KCU40	1017	**1066**	1181	SFM	0.0024–0.0039	0.0024–0.0043	0.0031–0.0055	0.0047–0.0083	0.0055–0.0102	0.0063–0.0102
			I	DS	KCU40										
		U	O	LP	KCU40	656	**705**	754	SFM	0.0020–0.00284	0.0024–0.0031	0.0028–0.0039	0.0028–0.0047	0.0035–0.0059	0.0043–0.0081
			I	HP	KCU40										
		I	O	HP	KCU40	426	**443**	492	SFM	0.0020–0.00284	0.0024–0.0031	0.0028–0.0039	0.0028–0.0047	0.0035–0.0059	0.0043–0.0081
			I	HP	KCU40										
	1	S	O	FP	KCPK10	1017	**1066**	1181	SFM	0.0024–0.0043	0.0031–0.0055	0.0039–0.0071	0.0055–0.0098	0.0063–0.0118	0.0071–0.0118
			I	HP	KC7140										
		U	O	FP	KCU25	656	**705**	754	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
		I	O	HP	KCU40	426	**443**	492	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	2	S	O	FP	KCPK10	1017	**1066**	1181	SFM	0.0024–0.0043	0.0031–0.0055	0.0039–0.0071	0.0055–0.0098	0.0063–0.0118	0.0071–0.0118
			I	HP	KC7140										
		U	O	FP	KCU25	656	**705**	754	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
		I	O	HP	KCU40	426	**443**	492	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	3	S	O	FP	KCPK10	853	**935**	1050	SFM	0.0024–0.0043	0.0031–0.0055	0.0039–0.0071	0.0055–0.0098	0.0063–0.0118	0.0071–0.0118
			I	HP	KC7140										
		U	O	HP	KCU25	590	**640**	722	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
		I	O	HP	KCU40	361	**394**	459	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	4	S	O	FP	KCPK10	722	**820**	984	SFM	0.0024–0.0043	0.0031–0.0055	0.0039–0.0071	0.0055–0.0098	0.0063–0.0118	0.0071–0.0118
			I	HP	KC7140										
		U	O	HP	KCU25	492	**590**	722	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
		I	O	HP	KCU40	295	**361**	459	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	5	S	O	HP	KCU25	590	**656**	722	SFM	0.0024–0.0043	0.0031–0.0055	0.0039–0.0071	0.0055–0.0098	0.0063–0.0118	0.0071–0.0118
			I	HP	KC7140										
		U	O	HP	KCU40	394	**443**	492	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
		I	O	HP	KC7140	230	**279**	328	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	6	S	O	HP	KCU25	590	**656**	722	SFM	0.0024–0.0043	0.0031–0.0055	0.0039–0.0071	0.0055–0.0098	0.0063–0.0118	0.0071–0.0118
			I	HP	KC7140										
		U	O	HP	KCU40	394	**443**	492	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
		I	O	HP	KC7140	230	**279**	328	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
M	1	S	O	LP	KCU40	492	**623**	754	SFM	0.0020–0.0031	0.0024–0.0039	0.0028–0.0047	0.0039–0.0063	0.0047–0.0083	0.0055–0.0094
			I	DS	KCU40										
		U	O	LP	KCU40	328	**426**	525	SFM	0.0020–0.0028	0.0024–0.0031	0.0028–0.0039	0.0020–0.0039	0.0024–0.0051	0.0031–0.0063
			I	DS	KCU40										
		I	O	MD	KC7140	197	**262**	328	SFM	0.0012–0.0020	0.0016–0.0028	0.0020–0.0035	0.0028–0.0051	0.0031–0.0063	0.0039–0.0071
			I	MD	KC7140										
	2	S	O	LP	KCU40	492	**590**	689	SFM	0.0020–0.0031	0.0024–0.0039	0.0028–0.0047	0.0039–0.0063	0.0047–0.0083	0.0055–0.0094
			I	DS	KCU40										
		U	O	MD	KCU40	328	**426**	525	SFM	0.0012–0.0020	0.0016–0.0028	0.0020–0.0035	0.0028–0.0051	0.0031–0.0063	0.0039–0.0079
			I	MD	KC7140										
		I	O	MD	KC7140	197	**262**	328	SFM	0.0012–0.0020	0.0016–0.0028	0.0020–0.0035	0.0028–0.0051	0.0031–0.0063	0.0039–0.0071
			I	MD	KC7140										
	3	S	O	LP	KCU40	328	**426**	525	SFM	0.0020–0.0028	0.0024–0.0031	0.0028–0.0039	0.0020–0.0039	0.0024–0.0051	0.0031–0.0063
			I	DS	KCU40										
		U	O	HP	KCU40	262	**361**	459	SFM	0.0012–0.0020	0.0016–0.0028	0.0020–0.0035	0.0028–0.0051	0.0031–0.0063	0.0039–0.0079
			I	HP	KC7140										
		I	O	MD	KC7140	164	**230**	295	SFM	0.0012–0.0020	0.0016–0.0028	0.0020–0.0035	0.0028–0.0051	0.0031–0.0063	0.0039–0.0071
			I	MD	KC7140										

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Drill Fix™ DFSP™ • Inch

Inch																
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (fz) by Diameter							
						min	Starting Value	max	Ø	SPGX05 DFTX2 .551–.708"	SPGX06 DFT03 .709–.865"	SPGX07 DFT05 .866–1.023"	SPGX09 DFT05 1.024–1.299"	SPGX12 DFT06/..07 1.300–1.732"	SPGX15 DFT07/..09 1.733–2.165"
K	1	S	O	FP	KCPK10	656	**787**	984	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KCU40										
		U	O	FP	KCU25	394	**508**	656	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KC7140										
		I	O	FP	KC7140	262	**328**	410	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	2	S	O	FP	KCPK10	590	**722**	853	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KCU40										
		U	O	HP	KCU25	361	**459**	558	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KC7140										
		I	O	HP	KC7140	262	**328**	394	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	3	S	O	HP	KCPK10	590	**722**	853	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KCU40										
		U	O	HP	KCU25	361	**459**	558	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KC7140										
		I	O	HP	KC7140	262	**328**	394	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
N	1	S	O	HP	KCPK10	1148	**1640**	2132	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KMF										
		U	O	HP	KCU40	984	**1312**	1640	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KMF										
		I	O	HP	KCU40	656	**984**	1312	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KMF										
	2	S	O	HP	KCPK10	984	**1312**	1640	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KMF										
		U	O	HP	KCU40	820	**1148**	1476	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KMF										
		I	O	HP	KCU40	574	**820**	1066	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KMF										
	3	S	O	HP	KCPK10	984	**1312**	1640	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KMF										
		U	O	HP	KCU40	820	**1148**	1476	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KMF										
		I	O	HP	KCU40	492	**820**	1148	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KMF										
	4	S	O	HP	KCU25	984	**1312**	1640	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KC7140										
		U	O	HP	KCU40	820	**1148**	1476	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KC7140										
		I	O	HP	KCU40	656	**984**	1312	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KC7140										
	5	S	O	HP	KCU40	1312	**1476**	1640	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KMF										
		U	O	HP	KCU40	820	**1148**	1476	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KMF										
		I	O	HP	KCU40	656	**984**	1312	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KMF										
	6	S	O	HP	KCU40	1312	**1476**	1640	SFM	0.0028–0.0047	0.0039–0.0063	0.0047–0.0079	0.0063–0.0110	0.0071–0.0126	0.0079–0.0134
			I	HP	KMF										
		U	O	HP	KCU40	820	**1148**	1476	SFM	0.0020–0.0035	0.0024–0.0047	0.0031–0.0059	0.0047–0.0079	0.0055–0.0098	0.0063–0.0110
			I	HP	KMF										
		I	O	HP	KCU40	656	**984**	1312	SFM	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039	0.0035–0.0059	0.0043–0.0071	0.0051–0.0098
			I	HP	KMF										

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Drill Fix™ DFSP™ • Inch

Inch																
Material Group		Condition	Pocket Seat	Geometry	Grade	Cutting Speed — vc Range — SFM			Recommended Feed Rate (fz) by Diameter							
						min	Starting Value	max	Ø	SPGX05 DFTX2 .551–.708"	SPGX06 DFT03 .709–.865"	SPGX07 DFT05 .866–1.023"	SPGX09 DFT05 1.024–1.299"	SPGX12 DFT06/..07 1.300–1.732"	SPGX15 DFT07/..09 1.733–2.165"
S	1	S	O	HP	KCU40	197	**230**	246	SFM	0.0012–0.0024	0.0016–0.0031	0.0020–0.0039	0.0031–0.0047	0.0039–0.0059	0.0047–0.0071
			I	MD	KC7140										
		U	O	HP	KCU40	131	**164**	197	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
		I	O	HP	KCU40	82	**98**	131	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
	2	S	O	HP	KCU40	164	**197**	230	SFM	0.0012–0.0024	0.0016–0.0031	0.0020–0.0039	0.0031–0.0047	0.0039–0.0059	0.0047–0.0071
			I	MD	KC7140										
		U	O	HP	KCU40	98	**131**	164	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
		I	O	HP	KCU40	82	**98**	131	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
	3	S	O	HP	KCU40	230	**262**	295	SFM	0.0012–0.0024	0.0016–0.0031	0.0020–0.0039	0.0031–0.0047	0.0039–0.0059	0.0047–0.0071
			I	MD	KC7140										
		U	O	HP	KCU40	164	**197**	230	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
		I	O	HP	KCU40	98	**131**	164	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
	4	S	O	HP	KCU40	230	**262**	295	SFM	0.0012–0.0024	0.0016–0.0031	0.0020–0.0039	0.0031–0.0047	0.0039–0.0059	0.0047–0.0071
			I	MD	KC7140										
		U	O	HP	KCU40	164	**197**	230	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										
		I	O	HP	KCU40	98	**131**	164	SFM	0.0008–0.0012	0.0008–0.0016	0.0012–0.0020	0.0016–0.0024	0.0020–0.0031	0.0024–0.0039
			I	MD	KC7140										

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