

■ HP Drills • B28_HPS Series • Grade KN15™ • MQL and Through Coolant



Holemaking

Material Group		Cutting Speed – vc			Metric								
		Range – m/min			Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
N	1	120	230	450	mm/r	0,13–0,25	0,14–0,29	0,17–0,35	0,21–0,42	0,27–0,50	0,33–0,57	0,37–0,69	0,43–0,82
	2	120	220	350	mm/r	0,14–0,23	0,15–0,28	0,17–0,34	0,22–0,39	0,29–0,46	0,34–0,54	0,39–0,67	0,45–0,80
	3	100	180	400	mm/r	0,13–0,18	0,14–0,19	0,16–0,25	0,20–0,30	0,28–0,37	0,33–0,42	0,38–0,56	0,44–0,68
	4	100	130	300	mm/r	0,10–0,16	0,12–0,18	0,14–0,24	0,16–0,28	0,18–0,32	0,20–0,36	0,24–0,40	0,28–0,44
Material Group		Cutting Speed – vc			Inch								
		Range – SFM			Recommended Feed Rate (f) by Diameter								
		min	Starting Value	max		1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
N	1	390	750	1480	IPR	.005–.010	.006–.011	.007–.014	.008–.017	.011–.020	.013–.022	.015–.027	.017–.032
	2	390	720	1150	IPR	.006–.009	.006–.011	.007–.013	.009–.015	.011–.018	.013–.021	.015–.026	.018–.031
	3	330	590	1310	IPR	.005–.007	.006–.007	.006–.010	.008–.012	.011–.015	.013–.017	.015–.022	.017–.027
	4	330	430	980	IPR	.004–.006	.005–.007	.006–.009	.006–.011	.007–.013	.008–.014	.009–.016	.011–.017