

Stack Drill • B551/B541 Series • Grade KN15™ • Dry



Holemaking

		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	16,0	20,0	
C	2	15	80	120	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
	3	10	10	15	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
	4	10	15	25	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
		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	5/8 .625	3/4 .750	
C	2	50	260	390	IPR	.001–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009
	3	30	30	50	IPR	.001–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009
	4	30	50	80	IPR	.001–.002	.001–.003	.001–.004	.002–.005	.002–.006	.002–.007	.002–.008	.003–.009