

Stack Drill • B556/B546 Series • Grade KN15™ • Through Coolant

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	
					mm/r								
N	1	120	230	450	mm/r	0,12-0,17	0,13-0,18	0,15-0,24	0,19-0,29	0,26-0,35	0,31-0,40	0,41-0,51	0,44-0,54
	2	120	220	350	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	0,44-0,54	0,48-0,58
	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	0,44-0,54	0,48-0,58
	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
C	2	15	120	150	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	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
	4	10	25	50	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

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	
					IPR								
N	1	390	750	1480	IPR	.005-.007	.005-.007	.006-.009	.007-.011	.010-.014	.012-.016	.016-.020	.017-.021
	2	390	720	1150	IPR	.005-.007	.006-.007	.006-.010	.008-.012	.011-.015	.013-.017	.017-.021	.019-.023
	3	330	590	1310	IPR	.005-.007	.006-.007	.006-.010	.008-.012	.011-.015	.013-.017	.017-.021	.019-.023
	4	330	430	980	IPR	.004-.006	.005-.007	.006-.009	.006-.011	.007-.013	.008-.014	.009-.016	.011-.017
C	2	50	390	490	IPR	.001-.002	.001-.003	.001-.004	.002-.005	.002-.006	.002-.007	.002-.008	.003-.009
	3	30	50	80	IPR	.001-.002	.001-.003	.001-.004	.002-.005	.002-.006	.002-.007	.002-.008	.003-.009
	4	30	80	160	IPR	.001-.002	.001-.003	.001-.004	.002-.005	.002-.006	.002-.007	.002-.008	.003-.009

Holemaking