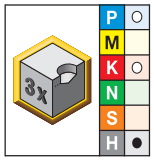
(B951A • ~3 x D — continued)



● first choice
○ alternate choice

short • KCH15	D1 diameter mm	in	fraction	L	L3	L4 max	L5	LS	D
B951A13000	13,000	.5118	–	107	60	43	2,6	45	14
B951A13500	13,500	.5315	–	107	60	43	2,7	45	14
B951A14000	14,000	.5512	–	107	60	43	2,8	45	14
B951A14500	14,500	.5709	–	115	65	45	2,9	48	16
B951A15500	15,500	.6102	–	115	65	45	3,1	48	16
B951A16000	16,000	.6299	–	133	83	63	3,2	48	16

Application Data

KMH Drill • B94_Series • Grade KCH10 • Flood Coolant

Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate per Rev		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	4	50	**70**	100	mm/r	0,06–0,15	0,08–0,17	0,12–0,23	0,14–0,28	0,17–0,33	0,19–0,38	0,23–0,47	0,29–0,59
P	5	40	**50**	70	mm/r	0,08–0,16	0,10–0,20	0,12–0,24	0,16–0,28	0,20–0,32	0,24–0,36	0,28–0,44	0,32–0,52
P	6	30	**40**	60	mm/r	0,05–0,07	0,06–0,10	0,08–0,14	0,10–0,18	0,12–0,22	0,14–0,24	0,18–0,32	0,23–0,41
K	1	80	**130**	150	mm/r	0,11–0,22	0,12–0,24	0,16–0,31	0,20–0,38	0,23–0,44	0,25–0,49	0,31–0,06	0,38–0,47
K	2	70	**110**	100	mm/r	0,10–0,17	0,12–0,19	0,16–0,25	0,20–0,31	0,23–0,36	0,25–0,40	0,31–0,48	0,38–0,60
K	3	80	**110**	120	mm/r	0,07–0,15	0,09–0,19	0,12–0,25	0,14–0,30	0,17–0,35	0,19–0,40	0,25–0,48	0,30–0,60
H	1	20	**30**	40	mm/r	0,03–0,06	0,04–0,08	0,06–0,10	0,08–0,12	0,09–0,13	0,10–0,14	0,12–0,16	0,14–0,18
H	2	15	**30**	40	mm/r	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16
H	3	15	**25**	35	mm/r	0,02–0,04	0,02–0,05	0,04–0,07	0,06–0,09	0,07–0,10	0,08–0,11	0,09–0,13	0,10–0,15
H	4	15	**20**	30	mm/r	0,02–0,04	0,03–0,06	0,05–0,08	0,07–0,10	0,08–0,11	0,09–0,12	0,10–0,14	0,11–0,16

Material Group		Cutting Speed — vc Range — SFM min	Starting Value	max	Inch Recommended Feed Rate per Rev		1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750
P	4	160	**230**	330	IPR	.0024-.0059	.0031-.0067	.0047-.0091	.0055-.0110	.0067-.0130	.0075-.0150	.0091-.0185	.0114-.0232
P	5	130	**160**	230	IPR	.0031–.0063	.0039–.0079	.0047–.0094	.0063–.0110	.0079–.0126	.0094–.0142	.0110–.0173	.0126–.0205
P	6	100	**130**	200	IPR	.0020-.0028	.0024-.0039	.0031-.0055	.0039-.0071	.0047-.0087	.0055-.0094	.0071-.0126	.0091-.0161
K	1	260	**430**	490	IPR	.0043-.0087	.0047-.0094	.0063-.0122	.0079-.0150	.0091-.0173	.0098-.0193	.0122-.0024	.0150-.0185
K	2	230	**360**	330	IPR	.0039–.0067	.0047–.0075	.0063–.0098	.0079–.0122	.0091–.0142	.0098–.0157	.0122–.0189	.0150–.0236
K	3	260	**360**	390	IPR	.0028-.0059	.0035-.0075	.0047-.0098	.0055-.0118	.0067-.0138	.0075-.0157	.0098-.0189	.0118-.0236
H	1	70	**100**	130	IPR	.0012-.0024	.0016-.0031	.0024-.0039	.0031-.0047	.0035-.0051	.0039-.0055	.0047-.0063	.0055-.0071
H	2	50	**100**	130	IPR	.0008–.0016	.0012–.0024	.0020–.0031	.0028–.0039	.0031–.0043	.0035–.0047	.0039–.0055	.0043–.0063
H	3	50	**80**	110	IPR	.0008-.0016	.0008-.0020	.0016-.0028	.0024-.0035	.0028-.0039	.0031-.0043	.0035-.0051	.0039-.0059
H	4	50	**70**	100	IPR	.0008–.0016	.0012–.0024	.0020–.0031	.0028–.0039	.0031–.0043	.0035–.0047	.0039–.0055	.0043–.0063