

KMH Drill • B95_Series • Grade KCH15 • Through Coolant

Solid Carbide Drills

Material Group		Cutting Speed – vc			Metric									
		Range – m/min			Recommended Feed Rate per Rev									
		min	Starting Value	max	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0		
		mm/r												
P	4	50	70	100	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		
	5	50	60	80	0,08–0,14	0,10–0,16	0,12–0,20	0,16–0,24	0,20–0,28	0,24–0,32	0,28–0,40	0,32–0,48		
	6	40	50	70	0,05–0,08	0,06–0,10	0,08–0,14	0,10–0,18	0,13–0,22	0,14–0,24	0,18–0,32	0,23–0,41		
K	1	80	130	170	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		
	2	90	110	120	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		
	3	80	110	130	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	35	45	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		
	2	15	30	45	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		
	3	15	25	40	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		
	4	15	20	35	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			Inch									
		Range – SFM			Recommended Feed Rate per Rev									
		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												
P	4	160	230	330	.0024–.0059	.0031–.0067	.0047–.0091	.0055–.0110	.0067–.0130	.0075–.0150	.0091–.0185	.0114–.0232		
	5	160	200	260	.0031–.0055	.0039–.0079	.0047–.0079	.0063–.0094	.0079–.0110	.0094–.0126	.0110–.0157	.0126–.0189		
	6	130	160	230	.0020–.0031	.0024–.0039	.0031–.0055	.0039–.0071	.0051–.0087	.0055–.0094	.0071–.0126	.0091–.0161		
K	1	260	430	560	.0043–.0087	.0047–.0094	.0063–.0122	.0079–.0150	.0091–.0173	.0098–.0193	.0122–.0024	.0150–.0185		
	2	300	360	390	.0039–.0067	.0047–.0075	.0063–.0098	.0079–.0122	.0091–.0142	.0098–.0157	.0122–.0189	.0150–.0236		
	3	260	360	430	.0028–.0059	.0035–.0075	.0047–.0098	.0055–.0118	.0067–.0138	.0075–.0157	.0098–.0189	.0118–.0236		
H	1	70	110	150	.0012–.0024	.0016–.0031	.0024–.0039	.0031–.0047	.0035–.0051	.0039–.0055	.0047–.0063	.0055–.0071		
	2	50	100	150	.0008–.0016	.0012–.0024	.0020–.0031	.0028–.0039	.0031–.0043	.0035–.0047	.0039–.0055	.0043–.0063		
	3	50	80	130	.0008–.0016	.0008–.0020	.0016–.0028	.0024–.0035	.0028–.0039	.0031–.0043	.0035–.0051	.0039–.0059		
	4	50	70	110	.0008–.0016	.0012–.0024	.0020–.0031	.0028–.0039	.0031–.0043	.0035–.0047	.0039–.0055	.0043–.0063		