Kenna Universal™ Drills • B966, B967 Series • Grade KC7315™ • Flood Coolant • Drill Diameters 3–20mm (.1181–.7874")

Material Group		Cutting Speed — vc Range — m/min min	Starting Value	max	Metric Recommended Feed Rate (f) by Diameter		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
P	0	70	90	115	mm/r		0,05–0,11	0,08–0,14	0,09–0,19	0,11–0,22	0,13–0,26	0,15–0,30	0,19–0,36	0,24–0,46
	1	60	70	100	mm/r		0,06–0,13	0,09–0,16	0,11–0,22	0,13–0,26	0,15–0,31	0,18–0,35	0,22–0,42	0,28–0,54
	2	80	90	100	mm/r		0,06–0,13	0,08–0,16	0,12–0,22	0,14–0,26	0,17–0,31	0,20–0,35	0,24–0,42	0,31–0,53
	3	50	70	90	mm/r		0,07–0,15	0,09–0,17	0,13–0,23	0,15–0,28	0,19–0,33	0,22–0,38	0,26–0,47	0,34–0,59
	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
	5	40	50	70	mm/r		0,06–0,12	0,08–0,14	0,10–0,18	0,12–0,22	0,16–0,26	0,18–0,28	0,22–0,36	0,26–0,42
	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
M	1	30	40	50	mm/r		0,04–0,07	0,05–0,09	0,08–0,11	0,09–0,12	0,10–0,14	0,12–0,16	0,14–0,18	0,16–0,20
	2	40	50	60	mm/r		0,04–0,08	0,06–0,10	0,08–0,12	0,09–0,14	0,10–0,16	0,12–0,18	0,14–0,20	0,16–0,22
	3	30	40	50	mm/r		0,04–0,07	0,06–0,09	0,08–0,11	0,09–0,12	0,10–0,14	0,12–0,16	0,14–0,18	0,16–0,20
K	1	80	130	170	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
	2	90	110	120	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
	3	80	110	130	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
N	1	90	230	270	mm/r		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
	2	90	220	270	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
	3	90	180	225	mm/r		0,12–0,14	0,13–0,16	0,14–0,20	0,16–0,24	0,20–0,28	0,24–0,32	0,28–0,40	0,32–0,44
	4	90	130	270	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	0,28–0,40	0,32–0,48
S	1	20	25	30	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
	2	10	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
	3	20	25	40	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
	4	20	25	50	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 (fz) by Diameter		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	0	230	300	380	IPR		.002–.004	.003–.005	.004–.007	.004–.009	.005–.010	.006–.012	.007–.014	.009–.018
	1	200	230	330	IPR		.002–.005	.004–.006	.004–.009	.005–.010	.006–.012	.007–.014	.009–.017	.011–.021
	2	260	300	330	IPR		.002–.005	.003–.006	.005–.009	.006–.010	.007–.012	.008–.014	.009–.017	.012–.021
	3	160	230	300	IPR		.003–.006	.004–.007	.005–.009	.006–.011	.008–.013	.009–.015	.010–.019	.013–.023
	4	160	230	330	IPR		.002–.006	.003–.007	.005–.009	.006–.011	.007–.013	.008–.015	.009–.019	.011–.023
	5	130	160	230	IPR		.002–.005	.003–.006	.004–.007	.005–.009	.006–.010	.007–.011	.009–.014	.010–.017
	6	100	130	200	IPR		.002–.003	.002–.004	.003–.006	.004–.007	.005–.009	.006–.009	.007–.013	.009–.016
M	1	100	130	160	IPR		.002–.003	.002–.004	.003–.004	.004–.005	.004–.006	.005–.006	.006–.007	.006–.008
	2	130	160	200	IPR		.002–.003	.002–.004	.003–.005	.004–.006	.004–.006	.005–.007	.006–.008	.006–.009
	3	100	130	160	IPR		.002–.003	.002–.004	.003–.004	.004–.005	.004–.006	.005–.006	.006–.007	.006–.008
K	1	260	430	560	IPR		.004–.009	.005–.009	.006–.012	.008–.015	.009–.017	.010–.019	.012–.002	.015–.019
	2	300	360	390	IPR		.004–.007	.005–.008	.006–.010	.008–.012	.009–.014	.010–.016	.012–.019	.015–.024
	3	260	360	430	IPR		.003–.006	.004–.008	.005–.010	.006–.012	.007–.014	.008–.016	.010–.019	.012–.024
N	1	300	750	890	IPR		.003–.006	.004–.006	.005–.008	.006–.009	.008–.011	.009–.013	.011–.016	.013–.019
	2	300	720	890	IPR		.003–.006	.004–.008	.005–.009	.006–.011	.008–.013	.009–.014	.011–.017	.013–.021
	3	300	590	740	IPR		.005–.006	.005–.006	.006–.008	.006–.009	.008–.011	.009–.013	.011–.016	.013–.017
	4	300	430	890	IPR		.003–.006	.004–.008	.005–.009	.006–.011	.008–.013	.009–.014	.011–.016	.013–.019
S	1	70	80	100	IPR		.001–.002	.002–.003	.002–.004	.003–.005	.004–.005	.004–.006	.005–.006	.006–.007
	2	30	70	100	IPR		.001–.002	.001–.002	.002–.003	.003–.004	.003–.004	.004–.005	.004–.006	.004–.006
	3	70	80	130	IPR		.001–.002	.001–.002	.002–.003	.002–.004	.003–.004	.003–.004	.004–.005	.004–.006
	4	70	80	160	IPR		.001–.002	.001–.002	.002–.003	.003–.004	.003–.004	.004–.005	.004–.006	.004–.006