

Kenna Universal™ Drills • B97_Series • Grade KC7315™ • Through Coolant • Drill Diameters 2–20mm (.0787–.7874")

Solid Carbide Drills

Material Group														
	Cutting Speed – vc				Metric									
	Range – m/min				Recommended Feed Rate (f) by Diameter									
	min	Starting Value	max		2,0	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0	
P	0	80	120	160	mm/r	0,04–0,10	0,06–0,12	0,07–0,14	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	70	100	140	mm/r	0,05–0,12	0,07–0,14	0,08–0,16	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	90	120	140	mm/r	0,05–0,12	0,07–0,14	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	60	80	100	mm/r	0,06–0,13	0,08–0,15	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	80	100	mm/r	0,06–0,13	0,07–0,15	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	mm/r	0,06–0,12	0,08–0,13	0,10–0,15	0,12–0,19	0,16–0,24	0,20–0,27	0,24–0,30	0,28–0,38	0,32–0,44
M	1	30	40	50	mm/r	0,03–0,06	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	0,03–0,07	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	0,03–0,06	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
K	1	80	120	170	mm/r	0,09–0,17	0,11–0,22	0,12–0,24	0,16–0,31	0,20–0,38	0,23–0,44	0,25–0,49	0,31–0,60	0,38–0,74
	2	80	110	140	mm/r	0,11–0,15	0,12–0,16	0,13–0,19	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	100	130	mm/r	0,07–0,15	0,08–0,17	0,09–0,19	0,12–0,25	0,14–0,30	0,17–0,35	0,19–0,40	0,24–0,48	0,30–0,60
N	1	90	230	315	mm/r	0,06–0,13	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	225	270	mm/r	0,06–0,12	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	270	mm/r	0,11–0,14	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	135	180	mm/r	0,06–0,12	0,08–0,16	0,01–0,20	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	10	25	30	mm/r	0,02–0,05	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	25	mm/r	0,02–0,03	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	10	25	30	mm/r	0,02–0,03	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	10	25	40	mm/r	0,02–0,03	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 (f) by Diameter									
	min	Starting Value	max		5/64 .078	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	260	390	520	IPR	.002-.004	.002-.005	.003-.005	.004-.007	.004-.009	.005-.010	.006-.012	.007-.014
1		230	330	460	IPR	.002-.005	.003-.006	.003-.006	.004-.009	.005-.010	.006-.012	.007-.014	.009-.017	.011-.022
2		300	390	460	IPR	.002-.005	.003-.006	.003-.006	.005-.009	.006-.010	.007-.012	.008-.014	.009-.017	.012-.021
3		200	260	330	IPR	.002-.005	.003-.006	.004-.007	.005-.009	.006-.011	.008-.013	.009-.015	.010-.019	.013-.023
4		160	260	330	IPR	.002-.005	.003-.006	.003-.007	.005-.009	.006-.011	.007-.013	.008-.015	.009-.019	.011-.023
5		160	200	260	IPR	.002-.005	.003-.005	.004-.006	.005-.008	.006-.009	.008-.011	.009-.012	.011-.015	.013-.017
M	1	100	130	160	IPR	.001-.002	.002-.003	.002-.004	.003-.004	.004-.005	.004-.006	.005-.006	.006-.007	.006-.008
	2	130	160	200	IPR	.001-.003	.002-.003	.002-.004	.003-.005	.004-.006	.004-.006	.005-.007	.006-.008	.006-.009
	3	100	130	160	IPR	.001-.002	.002-.003	.002-.004	.003-.004	.004-.005	.004-.006	.005-.006	.006-.007	.006-.008
K	1	260	390	560	IPR	.004-.007	.004-.009	.005-.009	.006-.012	.008-.015	.009-.017	.010-.019	.012-.024	.015-.029
	2	260	360	460	IPR	.004-.006	.005-.006	.005-.008	.006-.010	.008-.012	.009-.014	.010-.016	.012-.019	.015-.024
	3	260	330	430	IPR	.003-.006	.003-.007	.004-.008	.005-.010	.006-.012	.007-.014	.008-.016	.009-.019	.012-.024
N	1	300	750	1030	IPR	.002-.005	.003-.006	.004-.006	.005-.008	.006-.009	.008-.011	.009-.013	.011-.016	.013-.019
	2	300	740	890	IPR	.002-.005	.003-.006	.004-.008	.005-.009	.006-.011	.008-.013	.009-.014	.011-.017	.013-.021
	3	300	590	890	IPR	.004-.006	.005-.006	.005-.006	.006-.008	.006-.009	.008-.011	.009-.013	.011-.016	.013-.017
	4	300	440	590	IPR	.002-.005	.003-.006	.000-.008	.005-.009	.006-.011	.008-.013	.009-.014	.011-.016	.013-.019
S	1	30	80	100	IPR	.001-.002	.001-.002	.002-.003	.002-.004	.003-.005	.004-.005	.004-.006	.005-.006	.006-.007
	2	30	70	80	IPR	.001-.002	.001-.002	.001-.002	.002-.003	.003-.004	.003-.004	.004-.005	.004-.006	.004-.006
	3	30	80	100	IPR	.001-.001	.001-.002	.001-.002	.002-.003	.003-.004	.003-.004	.003-.004	.004-.005	.004-.006
	4	30	80	130	IPR	.001-.001	.001-.002	.001-.002	.002-.003	.003-.004	.003-.004	.004-.005	.004-.006	.004-.006