Modular Drill • KSEM PLUS™ • Inch • A1 and B1 Style

Inch											
Material Group		Condition	Cutting Speed — vc Range — SFM			Recommended Feed Rate (fz) by Diameter					
			min	Starting Value	max	Ø	KSEM 14....17 DFR/DFC04... 1.102–1.249	KSEM 15....18 DFT/DFC05... 1.250–1.416	KSEM 13....22 DFT/DFC06... 1.417–1.771	KSEM 18....28 DFT/DFC07... 1.772–2.204	KSEM 20....34 DFT/DFC09... 2.205–4.0295
P	1	S	370	**775**	944	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	290	**532**	698	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	205	**327**	451	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
	2	S	295	**623**	755	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		U	233	**427**	558	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		I	164	**262**	361	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
	3	S	295	**591**	755	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		U	230	**394**	558	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		I	164	**230**	361	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
	4	S	295	**459**	722	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		U	230	**361**	525	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		I	264	**262**	361	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
	5	S	295	**427**	689	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		U	230	**328**	689	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		I	164	**230**	492	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
	6	S	230	**295**	591	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		U	164	**246**	394	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
		I	131	**197**	328	IPR	0.006–0.011	0.006–0.011	0.008–0.014	0.008–0.016	0.008–0.018
M	1	S	197	**361**	443	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	131	**230**	295	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	98	**164**	213	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
	2	S	197	**328**	443	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	131	**197**	295	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	98	**164**	213	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
	3	S	164	**295**	443	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	131	**197**	295	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	82	**131**	213	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
K	1	S	295	**558**	755	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
		U	197	**394**	525	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
		I	131	**230**	295	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
	2	S	295	**525**	722	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
		U	197	**361**	525	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
		I	131	**230**	328	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
	3	S	295	**492**	689	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
		U	197	**328**	492	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
		I	115	**197**	295	IPR	0.007–0.012	0.007–0.012	0.009–0.014	0.009–0.017	0.012–0.019
N	1	S	492	**787**	1181	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	328	**525**	787	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	197	**328**	525	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
	2	S	492	**722**	1181	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	328	**492**	787	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	197	**328**	525	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
	3	S	492	**722**	1181	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	328	**492**	787	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	197	**328**	525	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
	4	S	492	**722**	1181	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	328	**492**	787	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	197	**328**	525	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
	5	S	492	**722**	1181	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	328	**492**	787	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	197	**328**	525	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
	6	S	492	**656**	1181	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	328	**459**	787	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	197	**295**	525	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
	7	S	361	**722**	853	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		U	230	**459**	558	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
		I	148	**295**	361	IPR	0.005–0.008	0.005–0.008	0.006–0.011	0.006–0.013	0.008–0.016
S	1	S	82	**164**	246	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	66	**131**	197	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	49	**98**	164	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
	2	S	66	**131**	197	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	49	**98**	148	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	39	**82**	115	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
	3	S	66	**131**	197	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	49	**98**	148	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	39	**82**	131	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
	4	S	66	**131**	197	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		U	49	**98**	148	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014
		I	39	**82**	131	IPR	0.005–0.010	0.005–0.010	0.006–0.011	0.006–0.013	0.008–0.014