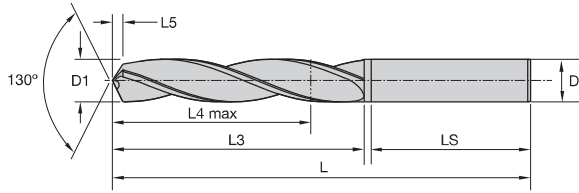
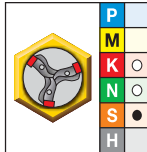




Solid Carbide Drills



■ K125 • ~5 x D



- first choice
- alternate choice

K715	D1 diameter				L	L3	L4 max	L5	LS	D
	in	mm	fraction	wire size						
K125A02500	.2500	6,350	1/4	E	3.74	1.69	1.37	.067	1.95	.2500
K125A02813	.2813	7,144	9/32	—	4.33	1.97	1.59	.076	2.26	.3125
K125A02950	.2950	7,493	—	M	4.33	1.97	1.59	.079	2.26	.3125
K125A03125	.3125	7,938	5/16	—	4.33	1.97	1.59	.084	2.26	.3125
K125A03438	.3437	8,731	11/32	—	4.92	2.36	1.92	.092	2.46	.3750
K125A03750	.3750	9,525	3/8	—	4.92	2.36	1.92	.101	2.46	.3750
K125A04063	.4063	10,319	13/32	—	5.24	2.60	2.09	.109	2.54	.4375
K125A04219	.4219	10,716	27/64	—	5.24	2.60	2.09	.113	2.54	.4375
K125A04375	.4375	11,112	7/16	—	5.24	2.60	2.09	.117	2.54	.4375
K125A04844	.4844	12,303	31/64	—	5.63	2.76	2.19	.130	2.78	.5000
K125A05000	.5000	12,700	1/2	—	5.63	2.76	2.19	.134	2.78	.5000
K125A05625	.5625	14,288	9/16	—	6.10	2.99	2.36	.151	3.01	.5625
K125A06250	.6250	15,875	5/8	—	6.73	3.23	2.54	.168	3.41	.6250

Tolerance • Metric			Tolerance • Inch		
nominal size range	D1 tolerance m7	D tolerance h6	nominal size range	D1 tolerance m7	D tolerance h6
>3-6	0,004/0,016	0,000/-0,008	>.1181-.2362	.0002/.0006	.0000/- .0003
>6-10	0,006/0,021	0,000/-0,009	>.2362-.3937	.0002/.0008	.0000/- .0004
>10-18	0,007/0,025	0,000/-0,011	>.3937-.7087	.0003/.0010	.0000/- .0004
>18-25,4	0,008/0,029	0,000/-0,013	>.7087-1.0000	.0003/.0011	.0000/- .0005

■ TF Drills • B/K125 Series • Grade K715™ • Through Coolant for Drill Diameters 3–20mm

Material Group	Cutting Speed – vc Range – m/min		Metric Recommended Feed Rate (f) by Diameter									
	min	Starting Value	max	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0	
	S 4	80	70	90	mm/r	—	—	0,03 - 0,08	0,03 - 0,08	0,03 - 0,08	0,08 - 0,15	0,08 - 0,15
Material Group	Cutting Speed – vc Range – SFM		Inch Recommended Feed Rate (f) by Diameter									
	min	Starting Value	max	1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4	
	S 4	260	230	300	IPR	—	—	.001 - .003	.001 - .003	.001 - .003	.003 - .006	.003 - .006