

HP Drills • B221_HP, B222_HP Series • Grade KCPK15™ • Flood Coolant for Drill Diameters 3–20mm

Solid Carbide Drills

		Cutting Speed – vc			Metric								
		Range – m/min			Recommended Feed Rate (f) by Diameter								
Material Group	min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0	
P	1	70	110	150	mm/r	0,08 - 0,16	0,07 - 0,17	0,08 - 0,24	0,08 - 0,29	0,09 - 0,35	0,12 - 0,42	0,25 - 0,55	0,33 - 0,67
	2	90	120	160	mm/r	0,08 - 0,15	0,07 - 0,14	0,12 - 0,23	0,14 - 0,29	0,16 - 0,28	0,19 - 0,40	0,25 - 0,50	0,33 - 0,60
	3	60	90	120	mm/r	0,09 - 0,16	0,09 - 0,17	0,15 - 0,27	0,18 - 0,33	0,20 - 0,35	0,25 - 0,44	0,33 - 0,55	0,37 - 0,67
	4	50	80	120	mm/r	0,08 - 0,16	0,08 - 0,17	0,13 - 0,27	0,16 - 0,33	0,17 - 0,33	0,21 - 0,44	0,26 - 0,54	0,32 - 0,62
	6	50	80	120	mm/r	0,06 - 0,11	0,07 - 0,13	0,09 - 0,17	0,13 - 0,24	0,15 - 0,24	0,18 - 0,30	0,23 - 0,40	0,28 - 0,49
	K	1	70	100	120	mm/r	0,11 - 0,21	0,09 - 0,18	0,14 - 0,28	0,16 - 0,37	0,20 - 0,40	0,22 - 0,45	0,28 - 0,58
2		70	120	120	mm/r	0,11 - 0,19	0,09 - 0,16	0,14 - 0,23	0,16 - 0,32	0,19 - 0,32	0,22 - 0,37	0,28 - 0,47	0,36 - 0,60
3		50	90	130	mm/r	0,08 - 0,17	0,07 - 0,14	0,12 - 0,25	0,13 - 0,27	0,16 - 0,29	0,18 - 0,39	0,25 - 0,48	0,29 - 0,58
		Cutting Speed – vc			Inch								
		Range – SFM			Recommended Feed Rate (f) by Diameter								
Material Group	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	
P	1	230	360	490	IPR	.003 - .006	.003 - .007	.003 - .009	.003 - .011	.004 - .014	.005 - .017	.010 - .022	.013 - .026
	2	300	390	520	IPR	.003 - .006	.003 - .006	.005 - .009	.006 - .011	.006 - .011	.007 - .016	.010 - .020	.013 - .024
	3	200	300	390	IPR	.004 - .006	.004 - .007	.006 - .011	.007 - .013	.008 - .014	.010 - .017	.013 - .022	.015 - .026
	4	160	260	390	IPR	.003 - .006	.003 - .007	.005 - .011	.006 - .013	.007 - .013	.008 - .017	.010 - .021	.013 - .024
	6	160	260	390	IPR	.002 - .004	.003 - .005	.004 - .007	.005 - .009	.006 - .009	.007 - .012	.009 - .016	.011 - .019
	K	1	230	330	390	IPR	.004 - .008	.004 - .007	.006 - .011	.006 - .015	.008 - .016	.009 - .018	.011 - .023
2		230	390	390	IPR	.004 - .007	.004 - .006	.006 - .009	.006 - .013	.007 - .013	.009 - .015	.011 - .019	.014 - .024
3		160	300	430	IPR	.003 - .007	.003 - .006	.005 - .010	.005 - .011	.006 - .011	.007 - .015	.010 - .019	.011 - .023

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