

(B224/B225\_HP • ~3 x D/-5 x D continued)

Solid Carbide Drills

short • KCPK15	long • KCPK15	D1 diameter				L5	LS	D
		mm	in	fraction	wire size			
B224A17000HP	B225A17000HP	17,000	.6693	—	—	3,2	48	18
B224A17463HP	B225A17463HP	17,463	.6875	11/16	—	3,2	48	18
B224A17500HP	B225A17500HP	17,500	.6890	—	—	3,3	48	18
—	B225A17700HP	17,700	.6969	—	—	3,3	48	18
B224A18000HP	B225A18000HP	18,000	.7087	—	—	3,3	48	18
—	B225A18500HP	18,500	.7283	—	—	3,4	50	20
B224A19000HP	B225A19000HP	19,000	.7480	—	—	3,5	50	20
B224A19050HP	B225A19050HP	19,050	.7500	3/4	—	3,5	50	20
—	B225A19200HP	19,200	.7559	—	—	3,6	50	20
—	B225A19250HP	19,250	.7579	—	—	3,6	50	20
—	B225A19300HP	19,300	.7598	—	—	3,6	50	20
—	B225A19500HP	19,500	.7677	—	—	3,6	50	20
B224A20000HP	B225A20000HP	20,000	.7874	—	—	3,7	50	20
—	B225A20500HP	20,500	.8071	—	—	3,8	50	20
—	B225A21000HP	21,000	.8268	—	—	3,9	50	20

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

■ HP Drills • B224HP, B225HP Series • Grade KCPK15™ • Through Coolant or MQL (Minimum Quantity Lubricant) for Drill Diameters 3–20mm

Material Group	Cutting Speed — vc			Metric									
	Range — m/min			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	
P	1	130	240	290	mm/r	0,09 - 0,18	0,11 - 0,21	0,14 - 0,25	0,16 - 0,34	0,18 - 0,39	0,20 - 0,43	0,22 - 0,51	0,26 - 0,58
	2	190	230	270	mm/r	0,09 - 0,18	0,11 - 0,21	0,14 - 0,25	0,16 - 0,34	0,18 - 0,39	0,20 - 0,43	0,22 - 0,51	0,26 - 0,58
	3	130	160	190	mm/r	0,01 - 0,11	0,12 - 0,21	0,14 - 0,24	0,16 - 0,34	0,18 - 0,39	0,20 - 0,43	0,22 - 0,51	0,26 - 0,58
	4	110	150	170	mm/r	0,07 - 0,15	0,09 - 0,18	0,12 - 0,20	0,15 - 0,28	0,17 - 0,33	0,19 - 0,37	0,22 - 0,43	0,25 - 0,48
	5	110	150	190	mm/r	0,07 - 0,13	0,11 - 0,11	0,12 - 0,20	0,15 - 0,28	0,17 - 0,33	0,19 - 0,37	0,22 - 0,43	0,25 - 0,48
	P	Cutting Speed — vc			Inch								
Range — SFM			Recommended Feed Rate (f) by Diameter										
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	
1		430	790	950	IPR	.004 - .007	.004 - .008	.006 - .010	.006 - .013	.007 - .015	.008 - .017	.009 - .020	.010 - .023
2		620	750	890	IPR	.004 - .007	.004 - .008	.006 - .010	.006 - .013	.007 - .015	.008 - .017	.009 - .020	.010 - .023
3		430	520	620	IPR	.000 - .004	.005 - .008	.006 - .009	.006 - .013	.007 - .015	.008 - .017	.009 - .020	.010 - .023
4	360	490	560	IPR	.003 - .006	.004 - .007	.005 - .008	.006 - .011	.007 - .013	.007 - .015	.009 - .017	.010 - .019	
5	360	490	620	IPR	.003 - .005	.004 - .004	.005 - .008	.006 - .011	.007 - .013	.007 - .015	.009 - .017	.010 - .019	