

(K254/K255/K256\_YPC • ~3 x D/-5 x D/-8 x D continued)

Solid Carbide Drills

	short • KCK10 P M K N S H	regular • KCK10 P M K N S H	long • KCK10 P M K N S H	D1 diameter			L5	LS	D	
				in	mm	fraction				wire size
—	—	K255A07656YPC	—	.7656	19,446	49/64	—	.189	1.99	.8125
K254A08125YPC	—	K255A08125YPC	—	.8125	20,638	13/16	—	.200	1.99	.8125
K254A08750YPC	—	K255A08750YPC	—	.8750	22,225	7/8	—	.215	2.07	.8750

nominal size range	Tolerance • Metric		nominal size range	Tolerance • Inch	
	D1 tolerance m7	D tolerance h6		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

■ YPC Drills • B/K25\_YPC Series • Grade KCK10™ • Through Coolant 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		
K	1	130	160	210	mm/r	0,08 - 0,12	0,15 - 0,21	0,21 - 0,29	0,26 - 0,37	0,30 - 0,42	0,34 - 0,45	0,38 - 0,53	0,42 - 0,58
	2	90	130	180	mm/r	0,08 - 0,12	0,14 - 0,18	0,20 - 0,27	0,24 - 0,32	0,26 - 0,38	0,32 - 0,42	0,36 - 0,48	0,39 - 0,53
	3	70	90	130	mm/r	0,07 - 0,11	0,11 - 0,15	0,16 - 0,22	0,20 - 0,27	0,23 - 0,32	0,25 - 0,35	0,29 - 0,40	0,32 - 0,43
Material Group	Cutting Speed — vc			Inch									
	Range — SFM			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		
K	1	430	520	690	IPR	.003 - .005	.006 - .008	.008 - .011	.010 - .015	.012 - .017	.013 - .018	.015 - .021	.017 - .023
	2	300	430	590	IPR	.003 - .005	.006 - .007	.008 - .011	.009 - .013	.010 - .015	.013 - .017	.014 - .019	.015 - .021
	3	230	300	430	IPR	.003 - .004	.004 - .006	.006 - .009	.008 - .011	.009 - .013	.010 - .014	.011 - .016	.013 - .017