

SE Drills • B256 Series • Grade KC7315™ • Through 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	120	145	175	mm/r	0,08 - 0,11	0,09 - 0,15	0,11 - 0,15	0,13 - 0,19	0,13 - 0,22	0,15 - 0,27	0,18 - 0,33
2		80	100	120	mm/r	0,08 - 0,11	0,08 - 0,13	0,09 - 0,17	0,15 - 0,21	0,16 - 0,25	0,18 - 0,33	0,22 - 0,42	0,26 - 0,50
3		80	90	120	mm/r	0,08 - 0,11	0,09 - 0,15	0,11 - 0,15	0,13 - 0,19	0,13 - 0,22	0,15 - 0,27	0,18 - 0,33	0,22 - 0,37
4		60	70	80	mm/r	0,06 - 0,09	0,07 - 0,13	0,09 - 0,13	0,11 - 0,15	0,11 - 0,17	0,13 - 0,22	0,15 - 0,27	0,17 - 0,30
		Cutting Speed – vc			Inch								
		Range – SFM			Recommended Feed Rate (f) by Diameter								
Material Group		min	Starting Value	max		1/8	3/16	1/4	5/16	3/8	1/2	5/8	3/4
						.125	.188	.250	.313	.375	.500	.625	.750
P	1	390	480	570	IPR	.003 - .004	.004 - .006	.004 - .006	.005 - .007	.005 - .009	.006 - .011	.007 - .013	.009 - .015
	2	260	330	390	IPR	.003 - .004	.003 - .005	.004 - .007	.006 - .008	.006 - .010	.007 - .013	.009 - .017	.010 - .020
	3	260	300	390	IPR	.003 - .004	.004 - .006	.004 - .006	.005 - .007	.005 - .009	.006 - .011	.007 - .013	.009 - .015
	4	200	230	260	IPR	.002 - .004	.003 - .005	.004 - .005	.004 - .006	.004 - .007	.005 - .009	.006 - .011	.007 - .012

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