

TX Drills • B/K411 Series • Grade KF1™ • 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	25,4
		<b>K</b>	1	115	60	140	mm/r	0,11 - 0,20	0,12 - 0,24	0,15 - 0,28	0,18 - 0,33	0,20 - 0,38	0,23 - 0,44	0,30 - 0,53
<b>N</b>	1	100	250	450	mm/r	0,16 - 0,25	0,19 - 0,29	0,23 - 0,35	0,27 - 0,42	0,31 - 0,50	0,36 - 0,57	0,44 - 0,69	0,52 - 0,82	0,62 - 0,96
<b>N</b>	2	200	100	300	mm/r	0,15 - 0,23	0,17 - 0,28	0,21 - 0,34	0,25 - 0,39	0,30 - 0,46	0,34 - 0,54	0,42 - 0,67	0,52 - 0,82	0,61 - 0,96
<b>N</b>	5	100	170	250	mm/r	0,16 - 0,28	0,15 - 0,32	0,19 - 0,36	0,23 - 0,40	0,25 - 0,44	0,28 - 0,48	0,32 - 0,56	0,35 - 0,63	0,42 - 0,72
<b>S</b>	4	20	40	50	mm/r	0,04 - 0,07	0,04 - 0,07	0,06 - 0,09	0,08 - 0,10	0,10 - 0,14	0,13 - 0,18	0,18 - 0,26	0,22 - 0,32	0,27 - 0,38
		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	1/1
		<b>K</b>	1	380	200	460	IPR	.004 - .008	.005 - .009	.006 - .011	.007 - .013	.008 - .015	.009 - .017	.012 - .021
<b>N</b>	1	330	820	1480	IPR	.006 - .010	.007 - .011	.009 - .014	.011 - .017	.012 - .020	.014 - .022	.017 - .027	.020 - .032	.024 - .038
<b>N</b>	2	660	330	980	IPR	.006 - .009	.007 - .011	.008 - .013	.010 - .015	.012 - .018	.013 - .021	.017 - .026	.020 - .032	.024 - .038
<b>N</b>	5	330	560	820	IPR	.006 - .011	.006 - .013	.007 - .014	.009 - .016	.010 - .017	.011 - .019	.013 - .022	.014 - .025	.017 - .028
<b>S</b>	4	70	130	160	IPR	.002 - .003	.002 - .003	.002 - .004	.003 - .004	.004 - .006	.005 - .007	.007 - .010	.009 - .013	.011 - .015

TX Drill Applications

The excellent stability of the TX drill enables it to be used for drilling through inclined planes, intersecting holes, and cored holes:

