Application Data • PK(M) • WP40PD • Inch

Material Group		Cutting Speed — Vc Range — SFM min	Starting Value	max	Recommended Feed Rate (f) by Diameter: Tool Diameter (inch)	.630	.787	1.000	1.260	1.575
P	1	295	**410**	558	IPR	.007–.018	.010–.019	.010–.020	.011–.022	.011–.024
	2	344	**459**	590	IPR	.009–.018	.011–.020	.012–.020	.013–.022	.014–.024
	3	164	**246**	328	IPR	.009–.018	.011–.020	.012–.020	.013–.022	.014–.024
	4	164	**246**	328	IPR	.007–.018	.009–.019	.010–.020	.011–.022	.011–.023
	5	164	**213**	262	IPR	.006–.013	.007–.014	.009–.017	.009–.018	.010–.019
	6	164	**213**	262	IPR	.006–.013	.007–.014	.009–.017	.009–.018	.010–.019
M	1	131	**262**	361	IPR	.004–.010	.005–.012	.005–.013	.006–.014	.006–.015
	2	115	**180**	246	IPR	.004–.010	.005–.012	.005–.013	.006–.014	.006–.015
	3	66	**115**	164	IPR	.004–.010	.005–.012	.005–.013	.006–.014	.006–.015
K	1	197	**312**	558	IPR	.010–.019	.011–.020	.013–.022	.014–.024	.015–.026
	2	197	**246**	295	IPR	.010–.019	.011–.020	.013–.022	.014–.024	.015–.026
	3	131	**213**	295	IPR	.008–.017	.009–.019	.010–.020	.011–.022	.011–.023

NOTE: Through coolant recommended for greater than 3 x D applications.
Material group M is recommended for secondary applications.

Application Data • PK(M) • WP40PD • Metric

Material Group		Cutting Speed — Vc Range — m/min min	Starting Value	max	Recommended Feed Rate (f) by Diameter: Tool Diameter (mm)	16,0	20,0	25,0	32,0	40,0
P	1	90	**125**	170	mm/r	0,19–0,45	0,25–0,48	0,25–0,52	0,28–0,57	0,29–0,60
	2	105	**140**	180	mm/r	0,23–0,46	0,28–0,50	0,30–0,52	0,33–0,57	0,35–0,60
	3	50	**75**	100	mm/r	0,23–0,46	0,28–0,50	0,30–0,52	0,33–0,57	0,35–0,60
	4	50	**75**	100	mm/r	0,19–0,45	0,22–0,48	0,25–0,50	0,28–0,55	0,29–0,58
	5	50	**65**	80	mm/r	0,16–0,32	0,18–0,36	0,22–0,42	0,24–0,46	0,25–0,48
	6	50	**65**	80	mm/r	0,16–0,32	0,18–0,36	0,22–0,42	0,24–0,46	0,25–0,48
M	1	40	**80**	110	mm/r	0,11–0,26	0,13–0,28	0,13–0,32	0,14–0,35	0,15–0,37
	2	35	**55**	75	mm/r	0,11–0,26	0,13–0,28	0,13–0,32	0,14–0,35	0,15–0,37
	3	20	**35**	50	mm/r	0,11–0,26	0,13–0,28	0,13–0,32	0,14–0,35	0,15–0,37
K	1	60	**95**	170	mm/r	0,25–0,48	0,28–0,52	0,32–0,56	0,35–0,62	0,37–0,65
	2	60	**75**	90	mm/r	0,25–0,48	0,28–0,52	0,32–0,56	0,35–0,62	0,37–0,65
	3	40	**65**	90	mm/r	0,21–0,44	0,23–0,48	0,25–0,50	0,28–0,55	0,29–0,58

NOTE: Through coolant recommended for greater than 3 x D applications.
Material group M is recommended for secondary applications.

TDMX — TOP DRILL™ Modular X

Modular Drills • TOP DRILL Modular X

Application Data • FPE(M) • WP40PD • Inch

Material Group		Cutting Speed — Vc Range — SFM			Recommended Feed Rate (f) by Diameter					
		min	Starting Value	max	Tool Diameter (inch)	.630	.787	1.000	1.260	1.575
P	1	360	**460**	560	IPR	.007–.010	.007–.011	.009–.015	.010–.017	.013–.030
	2	330	**390**	460	IPR	.007–.010	.009–.011	.011–.015	.013–.017	.013–.030
	3	260	**330**	390	IPR	.006–.009	.007–.010	.009–.013	.010–.015	.013–.026
	4	230	**300**	360	IPR	.005–.009	.006–.010	.007–.013	.008–.015	.010–.026
M	1	130	**200**	260	IPR	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	2	110	**180**	230	IPR	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	3	70	**130**	200	IPR	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
K	1	300	**440**	570	IPR	.007–.010	.009–.011	.011–.015	.013–.017	.013–.030
	2	260	**390**	460	IPR	.007–.010	.009–.011	.011–.015	.013–.017	.013–.030
	3	230	**360**	410	IPR	.007–.010	.008–.011	.009–.015	.010–.017	.011–.022
S	1	70	**130**	200	IPR	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012
	3	50	**100**	150	IPR	.004–.007	.005–.008	.006–.010	.007–.011	.008–.012

NOTE: Through coolant recommended for greater than 3 x D applications.
Material group M is recommended for secondary applications.

Application Data • FPE(M) • WP40PD • Metric

Material Group		Cutting Speed — Vc Range — m/min			Recommended Feed Rate (f) by Diameter					
		min	Starting Value	max	Tool Diameter (mm)	16,0	20,0	25,0	32,0	40,0
P	1	110	**140**	170	mm/r	0,17–0,25	0,19–0,29	0,23–0,38	0,26–0,43	0,33–0,76
	2	100	**120**	140	mm/r	0,19–0,25	0,22–0,29	0,29–0,38	0,32–0,43	0,33–0,76
	3	80	**100**	120	mm/r	0,15–0,23	0,17–0,25	0,23–0,34	0,26–0,38	0,33–0,66
	4	70	**90**	110	mm/r	0,13–0,23	0,14–0,25	0,18–0,34	0,21–0,38	0,26–0,66
M	1	40	**60**	80	mm/r	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	2	35	**55**	70	mm/r	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	3	20	**40**	60	mm/r	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
K	1	90	**135**	175	mm/r	0,19–0,25	0,22–0,29	0,29–0,38	0,32–0,43	0,33–0,76
	2	80	**120**	140	mm/r	0,19–0,25	0,22–0,29	0,29–0,38	0,32–0,43	0,33–0,76
	3	70	**110**	125	mm/r	0,18–0,26	0,21–0,29	0,23–0,37	0,25–0,42	0,27–0,57
S	1	20	**40**	60	mm/r	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31
	3	15	**30**	45	mm/r	0,11–0,17	0,13–0,20	0,16–0,25	0,18–0,28	0,21–0,31

NOTE: Through coolant recommended for greater than 3 x D applications.
Material group M is recommended for secondary applications.