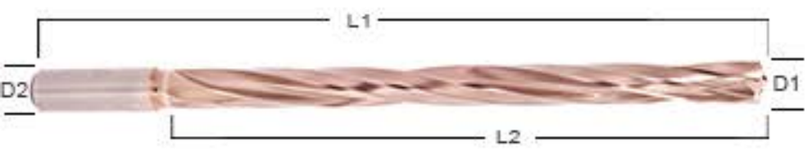

2 Flute - Triple Margin Carbide Drill

- 135° Point Geometry
- Coolant Holes
- Triple Margin
- ZircoPlus® Coating
- Available: 3xD - 50xD

Available Upon Request:
- Firm Hold Shank
- Avaliable with Exxtral Carbon

Now Improved with EDGE CUT™ for Superior Cutter Performance

N

N1	Wrought Aluminum Alloys
N2	Low-Silicon Aluminum Alloys Si <12.2% - 6061, 7075
N3	High-Silicon Aluminum Alloys Si >12.2% - 6061, 7075
N5	Copper & Copper Alloys

IMPERIAL

	SFM (Vc)					IPR = Inches Per Revolution				
	3xD	5xD	8xD	12xD	16xD	.118-.197Ø	.197-.315Ø	.315-.472Ø	.472-.630Ø	.473-.787Ø
N1	1115	1181	1050	820	525	.012	.015	.019	.023	.025
N2	1115	1181	1050	820	525	.013	.017	.022	.025	.027
N3	1066	1148	1018	804	459	.011	.015	.019	.023	.025
N5	518	525	443	394	295	.009	.011	.015	.015	.021

	SFM (Vc)			IPR = Inches Per Revolution				
	20xD	25xD	30xD	.118-.197Ø	.197-.315Ø	.315-.472Ø	.472-.630Ø	.473-.787Ø
N1	492	426	397	.008	.010	.014	.016	.018
N2	492	426	397	.010	.012	.015	.018	.020
N3	426	393	377	.008	.010	.014	.016	.018
N5	262	246	213	.008	.010	.014	.016	.018

	SFM (Vc)		IPR = Inches Per Revolution					
	40xD	50xD	.118-.158Ø	.158-.197Ø	.197-.236Ø	.236-.276Ø	.276-.296Ø	.296-.315Ø
N1	361	361	.007	.008	.008	.009	.010	.012
N2	361	361	.007	.008	.008	.009	.010	.012
N3	344	344	.006	.006	.007	.008	.009	.010
N5	180	180	.007	.007	.008	.010	.011	.013

METRIC

	Vc m/min(Vc)					F[mm/u] Feed Per Revolution				
	3xD	5xD	8xD	12xD	16xD	3.00-4.99Ø	5.00-7.99Ø	8.00-11.99Ø	12.00-15.99Ø	16.00-20.00Ø
N1	340	360	320	250	160	.300	.400	.500	.600	.650
N2	340	360	320	250	160	.350	.450	.550	.650	.700
N3	325	350	310	245	140	.300	.400	.500	.600	.650
N5	158	160	135	120	90	.230	.300	.380	.450	.520

	Vc m/min(Vc)			F[mm/u] Feed Per Revolution				
	20xD	25xD	30xD	3.00-4.99Ø	5.00-7.99Ø	8.00-11.99Ø	12.00-15.99Ø	16.00-20.00Ø
N1	150	130	120	.200	.250	.350	.400	.460
N2	150	130	120	.250	.300	.380	.450	.520
N3	130	120	115	.200	.250	.350	.400	.460
N5	80	75	65	0.200	.250	.350	.400	.460

	Vc m/min(Vc)		F[mm/u] Feed Per Revolution					
	40xD	50xD	3.00-3.99Ø	4.00-4.99Ø	5.00-5.99Ø	6.00-6.99Ø	7.00-7.49Ø	7.50-8.00Ø
N1	110	110	.190	.200	.210	.240	.260	.300
N2	110	110	.190	.200	.210	.240	.260	.300
N3	105	105	.150	.160	.180	.200	.220	.250
N5	55	55	.180	.190	.200	.250	.270	.330