



3 Flute - Single Margin Carbide Drill

- 130° Point Geometry
- Coolant Holes
- Single Margin
- ZircoPlus® Coating
- Available: 3xD - 5xD

Available Upon Request:

- Firm Hold Shank
- Available with Exxtral Carbon



N

K1	Gray Cast Iron
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	.118-.197Ø	.197-.315Ø	.315-.472Ø	.472-.630Ø	.472-.787Ø
K1	262.5	229.7	.005	.007	.010	.013	.017
N1	623.4	590.6	.005	.007	.010	.013	.017
N2	492.2	459.3	.005	.007	.010	.013	.017
N3	393.7	360.9	.005	.007	.010	.013	.017
N5	492.2	459.3	.003	.005	.007	.010	.012

METRIC

	SFM (Vc)		F[mm/u] Feed Per Revolution				
	3xD	5xD	3.00-4.99Ø	5.00-7.99Ø	8.00-11.99Ø	12.00-15.99Ø	16.00-20.00Ø
K1	80	70	.140	.200	.280	.350	.450
N1	190	180	.140	.200	.280	.350	.450
N2	150	140	.140	.200	.280	.350	.450
N3	120	110	.140	.200	.280	.350	.450
N5	150	140	.100	.150	.200	.260	.330