



2 Flute - Double Margin Carbide Drill

Available Upon Request:
 • Firm Hold Shank
 • Additional PVD Coatings



- 140° Point Geometry
- Coolant Holes
- Double Margin
- Varianta® Supral Coating
- Available: 3xD - 8xD

P M K S

P1	Low-Carbon Steel - 1000 Series (>25 HRc)
P3	Alloy Tool Steels - 1300, 2000, 3000 (≤35 HRc)
M2	Austenitic Stainless Steel & Cast Stainless Steel - 310, 314, 316 (<25 HRc)
K1	Gray Cast Iron
S4	Titanium Alloys - Commercially Pure, 6Al-AV, AStm 1/2/3, Ti-6Al-2Sn-4Zr-2Mo (≤48 HRc)

IMPERIAL

	SFM (Vc) Surface Feet Per Minute		IPR = Inches Per Revolution				
	3xD	5xD	.118-.197Ø	.197-.315Ø	.315-.472Ø	.472-.630Ø	.631-.787Ø
P1	328.1	328.1	.006	.008	.011	.013	.015
P3	246.1	246.1	.003	.004	.005	.008	.009
M2	229.7	229.7	.003	.004	.005	.008	.009
K1	262.5	262.5	.004	.006	.008	.011	.014
S4	98.4	98.4	.001	.003	.004	.006	.007

	SFM (Vc) Surface Feet Per Minute		IPR = Inches Per Revolution				
	8xD	.118-.194Ø	.197-.315Ø	.315-.472Ø	.472-.630Ø	.631-.787Ø	
P1	311.7	.003	.005	.007	.010	.012	
P3	295.3	.003	.005	.007	.010	.012	
M2	213.3	.003	.004	.005	.007	.009	
K1	82	.001	.003	.004	.006	.007	
S4	229.7	.007	.009	.013	.015	.018	

METRIC

	Vc m/min (Cutting speed)		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
P1	100	100	.160	.220	.280	.340	.380
P3	75	75	.080	.120	.150	.210	.250
M2	70	70	.080	.120	.150	.220	.250
K1	80	80	.130	.180	.230	.300	.380
S4	30	30	.040	.080	.120	.160	.200

	Vc m/min (Cutting speed)		F[mm/u] Feed Per Revolution				
	8xD	3.00-4.99Ø	5.00-7.99Ø	8.00-11.99Ø	12.00-15.99Ø	16.00-20.00Ø	
P1	95	.100	.150	.20	.260	.330	
P3	90	.100	.150	.20	.260	.330	
M2	65	.080	.120	.150	.20	.250	
K1	25	.040	.080	.120	.160	.20	
S4	70	.20	.250	.350	.400	.460	