



2 Flute - Four Margin Carbide Drill

- 130° Point Geometry
- Coolant Holes
- Four Margin
- ZircoPlus® Coating
- Available: 5xD - 16xD

Available Upon Request:

- Firm Hold Shank
- Additional PVD Coatings



K 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
N4	Metal Matrix Composite
N6	Carbon and Graphite Composite

IMPERIAL

IPR = Inches Per Revolution

	SFM (Vc) Surface Feet Per Minute	.118-.197Ø	.197-.315Ø	.315-.472Ø	.472-.630Ø	.473-.787Ø
K1	390	.006	.010	.011	.014	.018
N1	330-1480	.006	.008	.012	.014	.015
N2	330-980	.006	.008	.010	.012	.013
N3	330-980	.006	.008	.010	.012	.013
N4	330-980	.006	.008	.010	.012	.013
N6	330-820	.006	.006	.008	.010	.011

METRIC

F[mm/u] Feed Per Revolution

	Vc m/min (Cutting speed)	3.00-4.99Ø	5.00-7.99Ø	8.00-11.99Ø	12.00-15.99Ø	16.00-20.00Ø
K1	120	.140	.250	.280	.360	.450
N1	100-450	.160	.220	.270	.360	.440
N2	100-300	.150	.190	.250	.340	.420
N3	100-300	.150	.190	.250	.340	.420
N4	100-300	.150	.190	.250	.340	.420
N6	100-250	.160	.170	.230	.280	.350