



## 2 Flute - Single Margin Carbide Drill

- 140° Point Geometry
- S-Point
- Coolant Holes
- Single Margin
- Sistral Coating
- Available: 3xD - 5xD

### Available Upon Request:

- Firm Hold Shank
- Additional PVD Coatings



|    |  |
|----|--|
| P1 | Low-Carbon Steel - 1000 Series (>25 HRc)         |
| P3 | Alloy Tool Steels - 1300, 2000, 3000 (≤35 HRc)   |
| P4 | Alloy Tool Steels - 1300, 2000, 3000 (36-48 HRc) |
| K1 | Gray Cast Iron                                   |
| H2 | Hardened Tool Steels (48-55 HRc)                 |
| H3 | Hardened Tool Steels (56-60 HRc)                 |
| H4 | Hardened Tool Steels (60-62 HRc)                 |
|    | Hardened Tool Steels (62-64 HRc)                 |

### IMPERIAL

SFM (Vc) Surface Feet Per Minute

IPR = Inches Per Revolution

|    | 3xD   | 5xD   | .118-.197Ø | .197-.315Ø | .315-.472Ø | .472-.630Ø | .630-.787Ø |
|----|-------|-------|------------|------------|------------|------------|------------|
| P1 | 278.9 | 262.5 | .007       | .009       | .011       | .013       | .015       |
| P3 | 229.7 | 213.3 | .005       | .008       | .010       | .012       | .014       |
| P4 | 147.6 | 131.2 | .005       | .008       | .010       | .012       | .014       |
| K1 | 262.5 | 246.1 | .007       | .009       | .013       | .015       | .018       |
| H2 | 91.9  | 75.5  | .003       | .004       | .004       | .005       | .006       |
| H3 | 52.5  | 36.1  | .003       | .004       | .004       | .005       | .006       |
| H4 | 45.9  | 29.5  | .003       | .004       | .004       | .005       | .006       |
|    | 32.8  | 23    | .003       | .004       | .004       | .005       | .006       |

### 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 | 85  | 80  | .180       | .240       | .300        | .350         | .40          |
| P3 | 70  | 65  | .150       | .210       | .270        | .320         | .370         |
| P4 | 45  | 40  | .150       | .210       | .270        | .320         | .370         |
| K1 | 80  | 75  | .200       | .250       | .350        | .40          | .460         |
| H2 | 28  | 23  | .080       | .090       | .110        | .130         | .150         |
| H3 | 16  | 11  | .080       | .090       | .110        | .130         | .150         |
| H4 | 14  | 9   | .080       | .090       | .110        | .130         | .150         |
|    | 10  | 7   | .080       | .090       | .110        | .130         | .150         |