



2 Flute - Triple Margin Carbide Drill

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

Available Upon Request:

- Firm Hold Shank
- Available with Exxtral Carbon



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 |