DXC

2 Flute - Double Margin Carbide Drill
HIGH-PERFORMANCE DRILLING

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

	Surface Feet Per Minute	IPR = Inches Per Revolution				
	12xD	.118-.194Ø	.197-.315Ø	.315-.472Ø	.472-.630Ø	.631-.787Ø
P1	295.3	0.003	0.005	0.007	0.01	0.012
P3	262.5	0.003	0.005	0.007	0.01	0.012
M2	213.3	0.003	0.004	0.005	0.007	0.009
K1	344.5	0.007	0.009	0.013	0.015	0.018
S4	148.8	0.005	0.007	0.011	0.013	0.016

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

	Vc m/min (Cutting speed)	F[mm/u] Feed Per Revolution				
	12xD	3.00-4.99Ø	5.00-7.99Ø	8.00-11.99Ø	12.00-15.99Ø	16.00-20.00Ø
P1	85	0.1	0.15	.02	0.26	0.33
P3	80	0.1	0.15	0.2	0.26	0.33
M2	65	0.08	0.12	.0.15	0.02	0.25
K1	105	0.2	0.25	0.35	0.04	0.46
S4	45	0.13	0.18	0.28	0.33	0.41