



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