



2 Flute - Single Margin Carbide Drill

- 135° Point Geometry
- Coolant Holes
- Double Margin
- 45° Protective Corner Chamfer
- Sistral Coating
- Available: 3xD - 30xD

Available Upon Request:

- Firm Hold Shank
- Additional PVD Coatings



S2

Nickel-Based, Cobalt-Based, Heat-Resistant Alloys - Haynes 188, Haynes 21, Hastelloy, Waspaloy, Inconel 625/718 ($\leq 48\text{HRC}$)

IMPERIAL

S2	SFM (Vc) Surface Feet Per Minute								IPR = Inches Per Revolution				
	3xD	5xD	8xD	12xD	16xD	20xD	25xD	30xD	.118-.197Ø	.197-.315Ø	.315-.472Ø	.4725-.630Ø	.630-.787Ø
	142	136	130	124	118	112	106	98	.002	.002	.003	.004	.005

METRIC

S2	Vc m/min (Cutting speed)								F[mm/u] Feed Per Revolution				
	3xD	5xD	8xD	12xD	16xD	20xD	25xD	30xD	3.00-4.99Ø	5.00-7.99Ø	8.00-11.99Ø	12.00-15.99Ø	16.00-20.00Ø
	43.3	41.5	39.6	37.8	36	34.1	32.3	29.9	.050	.050	.080	.100	.130