2 Flute - Double Margin Carbide Drill

- 135° Point Geometry
- Coolant Holes
- Double Margin
- Varianta® Supral Coating
- Available: 12xD - 50xD

P M K S

Available Upon Request:
- Firm Hold Shank
- Additional PVD Coatings

Now Improved with EDGE CUT™ for Superior Cutter Performance

P1	Low-Carbon Steel - 1000 Series (>25 HRc)
P2	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)
P5	Ferritic, Martensitic & PH Stainless Steels - 400's, PH Types (≤35 HRc)
P6	Ferritic, Martensitic & PH Stainless Steels - 400's, PH Types (36-48 HRc)
M1	Austenitic Stainless Steel - Inox, 200 Series, 300 Series
M2	Austenitic Stainless Steel & Cast Stainless Steel - 310, 314, 316 (<25 HRc)
M3	Duplex Steel (Austenitic & Ferritic) - 323, 329, F55, 2205
K1	Gray Cast Iron
K2	Ductile Iron (<28 HRc)
K3	Ductile Iron (<38 HRc)
S1	Iron-Based, Heat-Resistant Alloys - Incoloy 800-802, A-286, N-155
S2	Nickel-Based, Cobalt-Based, Heat-Resistant Alloys - Haynes 188, Haynes 21, Hastelloy, Waspaloy, Inconel 625/718 (≤48hRc)
S4	Titanium Alloys - Commercially Pure, 6Al-AV, AStm 1/2/3, Ti-6Al-2SN-4Zr-2Mo (≤48 HRc)

IMPERIAL

	SFM (Vc) Surface Feet Per Minute					IPR = Inches Per Revolution				
	12xD	16xD	20xD	25xD	30xD	.118-.197Ø	.197-.315Ø	.315-.472Ø	.473-.630Ø	.473-.787Ø
P1	295.3	262.5	246.1	229.7	213.3	.003	.005	.007	.010	.012
P3	262.5	246.1	229.7	213.3	196.9	.003	.005	.007	.010	.012
M2	213.3	180.5	164.1	164.1	147.6	.003	.004	.005	.007	.009
K1	344.5	328.1	311.7	278.9	262.5	.007	.009	.013	.015	.018
S4	148.8	141.6	134.4	127.2	117.6	.005	.007	.011	.013	.016

	SFM (Vc) Surface Feet Per Minute		IPR = Inches Per Revolution					
	40xD	50xD	.118-.158Ø	.158-.197Ø	.197-.236Ø	.237-.276Ø	.276-.296Ø	.296-.315Ø
P1	246	246	.002	.003	.003	.004	.004	.005
P2	180.4	180.4	.002	.002	.003	.003	.004	.004
P3	180.4	180.4	.002	.002	.003	.003	.004	.004
P4	147.6	147.6	.001	.001	.002	.002	.003	.003
P5	114.8	114.8	.001	.001	.002	.002	.003	.003
P6	114.8	114.8	.001	.001	.002	.002	.003	.003
M1	114.8	114.8	.001	.001	.002	.002	.003	.003
M2	114.8	114.8	.001	.001	.002	.002	.003	.003
M3	98.4	98.4	.001	.001	.002	.002	.002	.003
K1	229.6	229.6	.003	.004	.005	.006	.007	.008
K2	180.4	180.4	.002	.002	.003	.003	.004	.004
K3	164	164	.001	.002	.002	.003	.003	.004
S1	114.8	114.8	.001	.001	.002	.002	.003	.003
S2	98.4	98.4	.001	.001	.002	.002	.002	.003
S4	114.8	114.8	.001	.001	.002	.002	.002	.003

METRIC

	Vc m/min (Cutting speed)					F[mm/u] Feed Per Revolution				
	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
P1	85	80	75	70	65	.100	.150	.200	.260	.330
P3	80	75	70	65	60	.100	.150	.200	.260	.330
M2	65	55	50	50	45	.080	.120	.150	.200	.250
K1	105	100	95	85	80	.200	.250	.350	.400	.460
S4	45	43	41	39	36	.130	.180	.280	.330	.410

	Vc m/min (Cutting speed)		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
P1	75	75	.048	.063	.078	.093	.103	.117
P2	55	55	.043	.058	.068	.083	.093	.103
P3	55	55	.043	.058	.068	.083	.093	.103
P4	45	45	.023	.033	.043	.053	.065	.071
P5	35	35	.023	.033	.043	.055	.063	.071
P6	35	35	.023	.033	.043	.055	.063	.071
M1	35	35	.023	.033	.043	.055	.063	.071
M2	35	35	.023	.033	.043	.055	.063	.071
M3	30	30	.020	.030	.040	.051	.060	.066
K1	70	70	.071	.098	.121	.15	.178	.198
K2	55	55	.040	.055	.065	.078	.090	.100
K3	50	50	.035	.050	.060	.075	.085	.095
S1	35	35	.023	.033	.043	.055	.063	.071
S2	30	30	.020	.030	.040	.051	.060	.066
S4	35	35	.021	.033	.042	.053	.062	.069