
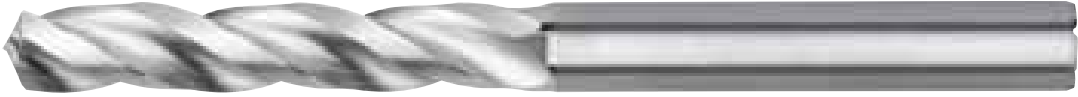


■ TF Drills • B125 Series • Grade K715™ • Through Coolant for Drill Diameters 3–20mm

Material Group													
		Cutting Speed – vc			Metric								
		Range – m/min			Recommended Feed Rate (f) by Diameter								
	min	Starting Value	max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0	
S	4	80	70	90	mm/r	—	—	0,03 - 0,08	0,03 - 0,08	0,03 - 0,08	0,08 - 0,15	0,08 - 0,15	—