

■ Stack Drill • B551/B541 Series • Grade KN15™ • Dry



Holemaking



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	
	C	2	15	80	120	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21
	3	10	10	15	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23
	4	10	15	25	mm/r	0,01–0,05	0,02–0,07	0,03–0,10	0,04–0,12	0,05–0,15	0,05–0,18	0,06–0,21	0,07–0,23