

■ HP Drills • B28\_HPS Series • Grade KN15™ • MQL and Through Coolant • Metric



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	
	N	1	120	230	450	mm/r	0,13–0,25	0,14–0,29	0,17–0,35	0,21–0,42	0,27–0,50	0,33–0,57	0,37–0,69
2		120	220	350	mm/r	0,14–0,23	0,15–0,28	0,17–0,34	0,22–0,39	0,29–0,46	0,34–0,54	0,39–0,67	0,45–0,80
3		100	180	400	mm/r	0,13–0,18	0,14–0,19	0,16–0,25	0,20–0,30	0,28–0,37	0,33–0,42	0,38–0,56	0,44–0,68
4		100	130	300	mm/r	0,10–0,16	0,12–0,18	0,14–0,24	0,16–0,28	0,18–0,32	0,20–0,36	0,24–0,40	0,28–0,44