

HIGH PERFORMANCE DRILLS

Premium Submicron Carbide :

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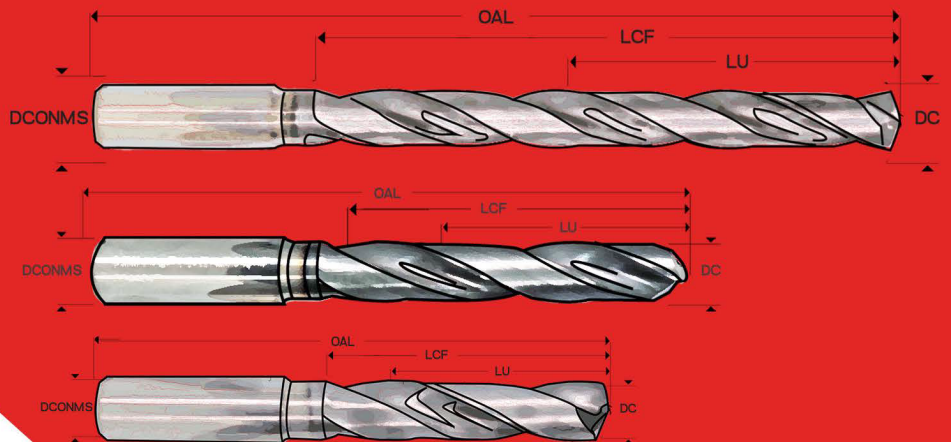
3xD Coolant

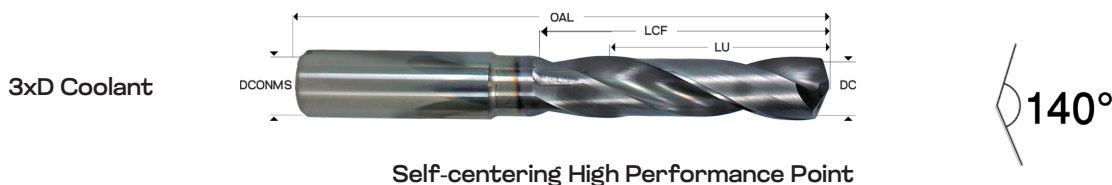
3xD Non-Coolant

5xD Coolant

8xD Coolant

Self-centering High Performance Point

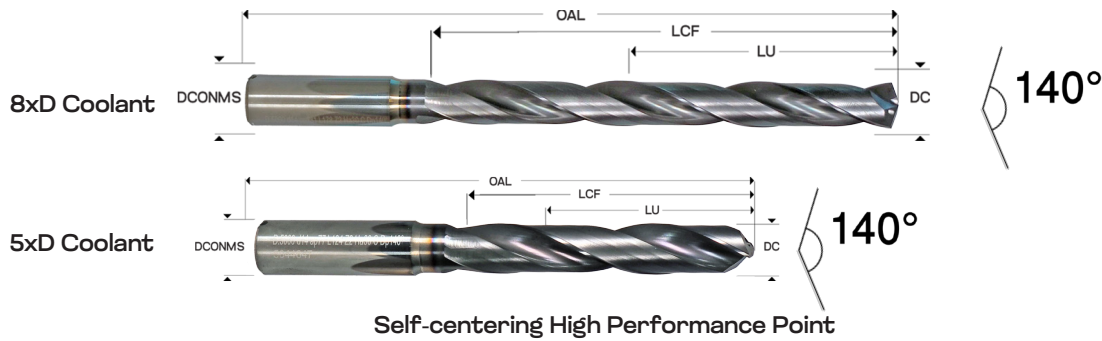




3xD Coolant										3xD non-coolant						
DC		DCONMS		LU	LCF	OAL	Part Number	Price	DCONMS	LCF	OAL	Part Number	Price			
Fraction	mm	Decimal	mm	mm	mm	mm			Fraction	mm	Fraction	mm	mm			
	3.000	0.1181	6	16	20	62	MT029547465	26.66	3.000		16	46	MU110115804	26.82		
	3.100	0.1220	6	15	20	62	MT029547466	25.11	3.100		18	49	MU110115805	27.03		
1/8	3.175	0.1250	6	15	20	62	MT029547468	25.11	1/8	3.175	45/64	-	1-59/64	-	MU110115806	27.03
	3.200	0.1260	6	15	20	62	MT029547471	25.11	3.200		18	49	MU110115807	27.03		
	3.300	0.1299	6	15	20	62	MT029547473	25.11	3.300		18	49	MU110115808	27.03		
	3.400	0.1339	6	15	20	62	MT029547477	25.11	3.400		20	52	MU110115809	28.24		
	3.500	0.1378	6	15	20	62	MT029547478	25.11	3.500		20	52	MU110115810	28.24		
9/64	3.571	0.1406	-	-	-	-	-	-	9/64	3.571	25/32	-	2-3/64	-	MU110115811	30.02
	3.600	0.1417	6	15	20	62	MT029547480	25.11	3.600		20	52	MU110115812	30.02		
	3.700	0.1457	6	14	20	62	MT029547481	25.11	3.700		20	52	MU110115813	30.02		
25	3.797	0.1495	6	18	24	66	MT029547482	25.11	-	-	-	-	-	-	-	-
	3.800	0.1496	-	-	-	-	-	-	3.800		22	55	MU110115814	31.37		
	3.900	0.1535	6	18	24	66	MT029547484	25.11	3.900		22	55	MU110115815	31.37		
5/31	3.970	0.1563	6	18	24	66	MT029547486	25.11	5/32	3.970	7/8	-	2-3/16	-	MU110115816	31.37
	4.000	0.1575	6	18	24	66	MT029547487	25.11	4.000		22	55	MU110115817	31.37		
	4.100	0.1614	6	18	24	66	MT029547488	25.11	4.100		22	55	MU110115818	32.48		
	4.200	0.1654	6	18	24	66	MT029547489	25.11	4.200		22	55	MU110115819	32.48		
	4.300	0.1693	6	18	24	66	MT029547491	25.11	4.300		24	58	MU110115820	34.01		
11/64	4.370	0.1719	-	-	-	-	-	-	11/64	4.370	15/16	-	2-9/32	-	MU110115821	34.01
	4.400	0.1732	6	17	24	66	MT029547494	25.11	4.400		24	58	MU110115822	34.01		
	4.500	0.1772	6	17	24	66	MT029547495	25.11	4.500		24	58	MU110115823	34.01		
	4.600	0.1811	6	17	24	66	MT029547497	25.11	4.600		24	58	MU110115824	34.01		
	4.650	0.1831	6	17	24	66	MT029547498	25.11	-	-	-	-	-	-	-	-
13	4.700	0.1850	6	17	24	66	MT029547453	25.11	4.700		24	58	MU110115825	35.61		
3/16	4.760	0.1875	6	21	28	66	MT029547499	25.11	3/16	4.760	3/16	-	2-7/16	-	MU110115826	35.61
12	4.800	0.1890	6	21	28	66	MT029547451	25.11	4.800		26	62	MU110115827	35.61		
	4.900	0.1929	6	21	28	66	MT029547502	25.11	4.900		26	58	MU110115828	35.61		
	5.000	0.1969	6	20	28	66	MT029547505	27.11	5.000		26	58	MU110115829	35.61		
	5.100	0.2008	6	20	28	66	MT029547506	27.11	5.100		26	58	MU110115830	35.61		
13/64	5.160	0.2031	-	-	-	-	-	-	13/64	5.160	13/64	-	2-7/16	-	MU110115831	42.74
	5.200	0.2047	6	20	28	66	MT029547509	27.11	5.200		26	58	MU110115832	42.74		
	5.300	0.2087	6	20	28	66	MT029547511	27.11	5.300		26	58	MU110115833	42.74		
	5.400	0.2126	6	20	28	66	MT029547512	27.11	5.400		28	66	MU110115834	42.74		
	5.500	0.2165	6	20	28	66	MT029547513	27.11	5.500		28	66	MU110115835	42.74		
7/32	5.560	0.2188	6	20	28	66	MT029547515	27.11	7/32	5.560	1-1/8	-	2-5/8	-	MU110115836	44.71
	5.600	0.2205	6	20	28	66	MT029547516	27.11	5.600		28	66	MU110115837	44.71		
	5.700	0.2244	6	19	28	66	MT029547517	27.11	5.700		28	66	MU110115838	44.71		
	5.800	0.2283	6	19	28	66	MT029547518	27.11	5.800		28	66	MU110115839	44.71		
	5.900	0.2323	6	19	28	66	MT029547519	27.11	5.900		28	66	MU110115840	44.71		
15/64	5.950	0.2344	-	-	-	-	-	-	15/64	5.950	1-1/8	-	2-5/8	-	MU110115841	44.71
	6.000	0.2362	6	19	28	66	MT029547521	27.11	6.000		28	66	MU110115842	44.71		
	6.100	0.2402	8	25	34	79	MT029547522	33.72	6.100		31	70	MU110115843	53.39		
	6.200	0.2441	8	25	34	79	MT029547523	33.72	6.200		31	70	MU110115844	53.39		
	6.300	0.2480	8	25	34	79	MT029547526	33.72	6.300		31	70	MU110115845	53.39		
1/4-E	6.350	0.2500	8	24	34	79	MT029547527	33.72	1/4	6.350	1-5/8	-	3-3/16	-	MU110115846	53.39
	6.400	0.2520	8	24	34	79	MT029547530	33.72	6.400		31	70	MU110115847	53.39		
	6.500	0.2559	8	24	34	79	MT029547532	33.72	6.500		31	70	MU110115848	59.09		
	6.600	0.2598	8	24	34	79	MT029547534	33.72	6.600		31	70	MU110115849	67.52		
	6.700	0.2638	8	24	34	79	MT029547535	33.72	6.700		31	70	MU110115850	67.52		
17/64	6.750	0.2656	-	-	-	-	-	-	17/64	6.750	1-11/16	-	3-17/64	-	MU110115851	68.78
	6.800	0.2677	8	24	34	79	MT029547537	33.72	6.800		34	74	MU110115852	67.78		
	6.900	0.2717	8	31	41	79	MT029547540	33.72	6.900		34	74	MU110115853	67.78		

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3xD Coolant										3xD non-coolant						
DC		DCONMS		LU	LCF	OAL	Part Number	Price	DCONMS		LCF	OAL	Part Number	Price		
Fraction	mm	Decimal	mm	mm	mm	mm			Fraction	mm	Fraction	mm	Fraction	mm		
	7.000	0.2756	8	31	41	79	MT029547541	38.72	7.000	34		74	MU110115854	67.25		
	7.100	0.2795	8	30	41	79	MT029547543	38.72	7.100	34		74	MU110115855	77.53		
9/32	7.140	0.2813	8	30	41	79	MT029547544	38.72	9/32"	1-3/4	-	3-7/16	-	MU110115856	81.92	
	7.200	0.2835	8	30	41	79	MT029547545	38.72	7.200	34		74	MU110115857	77.53		
	7.300	0.2874	8	30	41	79	MT029547546	38.72	7.300	34		74	MU110115858	77.53		
	7.400	0.2913	8	30	41	79	MT029547547	38.72	7.400	34		74	MU110115859	77.53		
	7.500	0.2953	8	30	41	79	MT029547549	38.72	7.500	34		74	MU110115860	77.23		
19/64	7.540	0.2969	-	-	-	-	-	-	19/64	7.540	1-7/8	-	3-9/16	-	MU110115861	86.01
	7.600	0.2992	-	-	-	-	-	-		7.600	37		79	MU110115862	85.07	
	7.700	0.3031	8	29	41	79	MT029547553	38.72	7.700	37		79	MU110115863	85.07		
	7.800	0.3071	8	29	41	79	MT029547555	38.72	7.800	37		79	MU110115864	85.07		
	7.900	0.3110	8	29	41	79	MT029547556	38.72	7.900	37		79	MU110115865	85.07		
5/16	7.940	0.3125	8	29	41	79	MT029547557	38.72	5/16"	1-7/8	-	3-9/16	-	MU110115866	87.42	
	8.000	0.3150	8	29	41	79	MT029547558	38.72	8.000	37		79	MU110115867	85.07		
	8.100	0.3189	10	35	47	89	MT029547560	47.50	8.100	37		79	MU110115868	100.27		
	8.200	0.3228	10	35	47	89	MT029547561	47.50	8.200	37		79	MU110115869	100.27		
	8.300	0.3268	10	35	47	89	MT029547563	47.50	8.300	37		79	MU110115870	100.27		
21/64	8.330	0.3281	-	-	-	-	-	-	21/64	8.330	2-1/16	-	3-3/4	-	MU110115871	104.43
	8.400	0.3307	10	34	47	89	MT029547565	47.50	8.400	37		79	MU110115872	100.27		
	8.500	0.3346	10	34	47	89	MT029547566	47.50	8.500	37		79	MU110115873	100.27		
	8.600	0.3386	10	34	47	89	MT029547568	47.50	8.600	40		84	MU110115874	108.54		
	8.700	0.3425	10	34	47	89	MT029547570	47.50	8.700	40		84	MU110115875	108.54		
11/32	8.730	0.3438	10	34	47	89	MT029547571	49.58	11/32	8.730	2-3/16	-	3-7/8	-	MU110115876	108.54
	8.800	0.3465	10	34	47	89	MT029547572	47.50	8.800	40		84	MU110115877	108.54		
	8.900	0.3504	-	-	-	-	-	-	8.900	40		84	MU110115878	108.54		
	9.000	0.3543	10	34	47	89	MT029547573	47.50	9.000	40		84	MU110115879	108.54		
	9.100	0.3583	-	-	-	-	-	-	9.100	40		84	MU110115880	116.76		
13/64	9.130	0.3594	-	-	-	-	-	-	23/64	9.130	2-9/32	-	4	-	MU110115881	116.76
	9.200	0.3622	10	33	47	89	MT029547576	51.80	9.200	40		84	MU110115882	116.76		
	9.300	0.3661	10	33	47	89	MT029547577	51.80	9.300	40		84	MU110115883	116.76		
	9.400	0.3701	-	-	-	-	-	-	9.400	40		84	MU110115884	116.76		
	9.500	0.3740	10	33	47	89	MT029547579	57.30	9.500	40		84	MU110115885	116.76		
3/8	9.525	0.3750	10	33	47	89	MT029547580	57.30	3/8	9.525	2-3/8	-	4-1/8	-	MU110115886	120.24
	9.600	0.3780	10	33	47	89	MT029547583	57.30	9.600	43		89	MU110115887	120.24		
	9.700	0.3819	-	-	-	-	-	-	9.700	43		89	MU110115888	120.24		
	9.800	0.3858	10	32	47	89	MT029547584	57.30	9.800	43		89	MU110115889	120.24		
	9.900	0.3898	10	32	47	89	MT029547586	57.30	9.900	43		89	MU110115890	120.24		
25/64"	9.920	0.3906	-	-	-	-	-	-	25/64	9.920	2-3/8	-	4-1/8	-	MU110115891	124.76
	10.000	0.3937	10	32	47	89	MT029547588	57.30	10.000	43		89	MU110115892	120.24		
	10.100	0.3976	12	40	55	102	MT029547590	68.33	-	-		-	-	-	-	
	10.200	0.4016	12	40	55	102	MT029547591	68.33	10.200	43		89	MU110115893	133.91		
	10.300	0.4055	12	40	55	102	MT029547593	68.33	-	-		-	-	-	-	
13/32	10.320	0.4063	12	40	55	102	MT029547595	68.33	13/32	10.320	2-5/8	-	4-13/32	-	MU110115894	152.91
	10.400	0.4094	12	39	55	102	MT029547596	68.33	-	-		-	-	-	-	
	10.500	0.4134	12	39	55	102	MT029547597	75.73	10.500	43		89	MU110115895	135.83		
27/64	10.716	0.4219	-	-	-	-	-	-	27/64	10.716	2-11/16	-	4-1/2	-	MU110115896	155.01
	10.800	0.4252	12	39	55	102	MT029547599	75.73	-	-		-	-	-	-	
	11.000	0.4331	12	38	55	102	MT029547600	75.73	11.000	47		95	MU110115897	148.21		
	11.100	0.4370	12	38	55	102	MT029547601	75.73	-	-		-	-	-	-	
7/16	11.113	0.4375	12	38	55	102	MT029547602	75.73	7/16	11.113	2-13/16	-	4-5/8	-	MU110115898	170.11
	11.200	0.4409	12	38	55	102	MT029547603	75.73	-	-		-	-	-	-	
	11.500	0.4528	12	38	55	102	MT029547605	75.73	11.500	47		95	MU110115899	169.80		
29/64	11.510	0.4531	-	-	-	-	-	-	29/64	11.510	2-7/8	-	4-3/4	-	MU110115900	193.16
	11.700	0.4606	12	37	55	102	MT029547607	75.73	-	-		-	-	-	-	
	11.800	0.4646	12	37	55	102	MT029547608	75.73	-	-		-	-	-	-	
15/32	11.910	0.4688	12	37	55	102	MT029547609	75.73	15/32	11.910	2-7/8	-	4-3/4	-	MU110115901	189.22
	12.000	0.4724	12	37	55	102	MT029547610	75.73	12.000	51		102	MU110115902	170.00		
31/64	12.303	0.4844	-	-	-	-	-	-	31/64	12.303	3	-	5-5/16	-	MU110115903	202.04
1/2	12.700	0.5000	14	41	60	107	MT029547617	87.57	1/2	12.700	3-1/16	-	5-3/8	-	MU110115904	224.77



5xD Coolant							8xD Coolant						
DC		DCONMS	LU	LCF	OAL	Part Number	Price	LU	LCF	OAL	Part Number	Price	
Fraction	mm	Decimal	mm	mm	mm			mm	mm	mm			
	3.000	0.1181	6	24	28	66	MT029547697	30.63	30	34	72	MT029547926	60.58
	3.100	0.1220	6	23	28	66	MT029547698	30.63	29	34	72	MT029547928	60.58
1/8	3.175	0.1250	6	23	28	66	MT029547700	30.63	29	34	72	MT029547929	60.58
	3.200	0.1260	6	23	28	66	MT029547701	30.63	29	34	72	MT029547930	60.38
	3.300	0.1299	6	23	28	66	MT029547702	30.63	29	34	72	MT029547931	60.38
	3.400	0.1339	6	23	28	66	MT029547705	30.63	29	34	72	MT029547932	60.38
	3.500	0.1378	6	23	28	66	MT029547706	30.63	29	34	72	MT029547934	60.38
	3.600	0.1417	6	23	28	66	MT029547708	30.63	29	34	72	MT029547936	61.58
	3.700	0.1457	6	22	28	66	MT029547709	30.63	28	34	72	MT029547937	61.58
#25	3.797	0.1495	6	30	36	74	MT029547711	30.63	37	43	81	MT029547939	61.58
	3.900	0.1535	6	30	36	74	MT029547713	30.63	37	43	81	MT029547940	61.58
	5/32"	0.1563	6	30	36	74	MT029547714	30.63	37	43	81	MT029547941	54.41
	4.000	0.1575	6	30	36	74	MT029547715	30.63	37	43	81	MT029547942	61.58
	4.100	0.1614	6	30	36	74	MT029547717	30.63	37	43	81	MT029547944	62.58
	4.200	0.1654	6	30	36	74	MT029547719	30.63	37	43	81	MT029547945	53.72
	4.300	0.1693	6	30	36	74	MT029547720	30.63	37	43	81	MT029547946	62.58
	4.400	0.1732	6	29	36	74	MT029547724	30.63	36	43	81	MT029547949	62.58
	4.500	0.1772	6	29	36	74	MT029547725	30.63	36	43	81	MT029547953	53.02
	4.600	0.1811	6	29	36	74	MT029547726	32.13	36	43	81	MT029547954	62.58
	4.650	0.1831	6	29	36	74	MT029547727	32.13	36	43	81	MT029547955	62.58
#13	4.700	0.1850	6	29	36	74	MT029547681	32.13	57	43	81	MT029547917	62.58
3/16	4.760	0.1875	6	29	44	82	MT029547728	32.13	50	57	95	MT029547956	62.58
#12	4.800	0.1890	6	37	44	82	MT029547680	32.13	50	57	95	MT029547916	62.58
	4.900	0.1929	6	37	44	82	MT029547730	32.13	50	57	95	MT029547958	62.58
	5.000	0.1969	6	36	44	82	MT029547733	32.13	49	57	95	MT029547959	62.58
	5.100	0.2008	6	36	44	82	MT029547734	34.63	49	57	95	MT029547960	62.58
	5.200	0.2047	6	36	44	82	MT029547736	34.63	49	57	95	MT029547962	53.02
	5.300	0.2087	6	36	44	82	MT029547737	34.63	49	57	95	MT029547963	62.58
	5.400	0.2126	6	36	44	82	MT029547738	34.63	49	57	95	MT029547964	62.58
	5.500	0.2165	6	36	44	82	MT029547739	34.63	49	57	95	MT029547965	62.58
7/32	5.560	0.2188	6	36	44	82	MT029547741	35.63	49	57	95	MT029547967	51.63
	5.600	0.2205	6	36	44	82	MT029547743	35.63	49	57	95	MT029547968	62.58
	5.700	0.2244	6	35	44	82	MT029547744	35.63	48	57	95	MT029547969	62.58
	5.800	0.2283	6	35	44	82	MT029547746	35.63	48	57	95	MT029547970	62.58
	5.900	0.2323	6	35	44	82	MT029547748	35.63	48	57	95	MT029547971	62.58
	6.000	0.2362	6	35	44	82	MT029547750	35.63	48	57	95	MT029547973	62.58
	6.100	0.2402	8	44	53	91	MT029547751	38.93	67	76	114	MT029547976	68.10
	6.200	0.2441	8	44	53	91	MT029547752	38.93	67	76	114	MT029547979	62.34
	6.300	0.2480	8	44	53	91	MT029547757	38.93	67	76	114	MT029547981	68.10
1/4-E	6.350	0.2500	8	43	53	91	MT029547758	38.93	66	76	114	MT029547982	68.10

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5xD Coolant										8xD Coolant				
DC			DCONMS	LU	LCF	OAL	Part Number	Price	LU	LCF	OAL	Part Number	Price	
Fraction	mm	Decimal	mm	mm	mm	mm		mm	mm	mm				
	6.400	0.2520	8	43	53	91	MT029547760	38.93	66	76	114	MT029547983	68.10	
	6.500	0.2559	8	43	53	91	MT029547763	38.93	66	76	114	MT029547984	68.10	
	6.600	0.2598	8	43	53	91	MT029547766	41.33	66	76	114	MT029547985	68.10	
	6.700	0.2638	8	43	53	91	MT029547767	41.33	66	76	114	MT029547986	68.10	
	6.800	0.2677	8	43	53	91	MT029547769	41.33	66	76	114	MT029547988	68.10	
	6.900	0.2717	8	43	53	91	MT029547772	41.33	66	76	114	MT029547990	68.10	
	7.000	0.2756	8	42	53	91	MT029547773	43.25	65	76	114	MT029547991	68.10	
	7.100	0.2795	8	42	53	91	MT029547774	45.13	65	76	114	MT029547993	68.10	
9/32	7.140	0.2813	8	42	53	91	MT029547775	45.13	65	76	114	MT029547994	60.43	
	7.200	0.2835	8	42	53	91	MT029547776	45.13	65	76	114	MT029547996	68.10	
	7.300	0.2874	8	42	53	91	MT029547778	45.13	65	76	114	MT029547997	68.10	
	7.400	0.2913	8	42	53	91	MT029547779	45.13	65	76	114	MT029547998	68.10	
	7.500	0.2953	8	42	53	91	MT029547782	45.13	65	76	114	MT029547999	68.10	
	7.700	0.3031	8	41	53	91	MT029547786	48.13	64	76	114	MT029548002	68.10	
	7.800	0.3071	8	41	53	91	MT029547787	48.13	64	76	114	MT029548003	68.10	
	7.900	0.3110	8	41	53	91	MT029547789	48.13	64	76	114	MT029548005	68.10	
5/16	7.940	0.3125	8	41	53	91	MT029547790	48.13	64	76	114	MT029548006	68.10	
	8.000	0.3150	8	41	53	91	MT029547791	48.13	64	76	114	MT029548008	68.10	
	8.100	0.3189	10	49	61	103	MT029547792	53.64	83	95	142	MT029548011	93.27	
	8.200	0.3228	10	49	61	103	MT029547793	53.64	83	95	142	MT029548013	93.27	
	8.300	0.3268	10	49	61	103	MT029547797	53.64	83	95	142	MT029548014	93.27	
	8.400	0.3307	10	48	61	103	MT029547799	55.34	82	95	142	MT029548016	93.27	
	8.500	0.3346	10	48	61	103	MT029547800	55.34	82	95	142	MT029548018	93.27	
	8.600	0.3386	10	48	61	103	MT029547801	57.94	82	95	142	MT029548021	93.27	
	8.700	0.3425	10	48	61	103	MT029547803	57.94	82	95	142	MT029548022	93.27	
11/32	8.730	0.3438	10	48	61	103	MT029547804	57.94	82	95	142	MT029548023	93.27	
	8.800	0.3465	10	48	61	103	MT029547805	57.94	82	95	142	MT029548025	93.27	
	9.000	0.3543	10	48	61	103	MT029547807	57.94	82	95	142	MT029548026	93.27	
	9.200	0.3622	10	47	61	103	MT029547810	60.64	81	95	142	MT029548030	93.27	
	9.300	0.3661	10	47	61	103	MT029547811	60.64	81	95	142	MT029548031	93.27	
	9.500	0.3740	10	47	61	103	MT029547813	64.64	81	95	142	MT029548032	93.27	
3/8	9.525	0.3750	10	47	61	103	MT029547814	64.64	81	95	142	MT029548033	93.27	
	9.600	0.3780	10	47	61	103	MT029547817	64.64	81	95	142	MT029548034	93.27	
	9.800	0.3858	10	46	61	103	MT029547818	64.64	80	95	142	MT029548037	93.27	
	9.900	0.3898	10	46	61	103	MT029547819	64.64	80	95	142	MT029548039	93.27	
	10.000	0.3937	10	46	61	103	MT029547821	64.64	80	95	142	MT029548042	93.27	
	10.100	0.3976	12	56	71	118	MT029547822	80.11	99	114	162	MT029548043	123.79	
	10.200	0.4016	12	56	71	118	MT029547823	80.11	99	114	162	MT029548044	123.79	
	10.300	0.4055	12	56	71	118	MT029547824	80.11	99	114	162	MT029548045	123.79	
13/32	10.320	0.4063	12	56	71	118	MT029547825	80.11	98	114	162	MT029548046	123.79	
	10.400	0.4094	12	55	71	118	MT029547826	80.11	98	114	162	MT029548048	123.79	
	10.500	0.4134	12	55	71	118	MT029547827	84.11	98	114	162	MT029548049	123.79	
	10.800	0.4252	12	55	71	118	MT029547831	84.11	98	114	162	MT029548053	123.79	
	11.000	0.4331	12	55	71	118	MT029547832	86.19	98	114	162	MT029548054	123.79	
	11.100	0.4370	12	54	71	118	MT029547835	84.11	97	114	162	MT029548055	123.79	
7/16	11.113	0.4375	12	54	71	118	MT029547836	84.11	97	114	162	MT029548056	123.79	
	11.200	0.4409	12	54	71	118	MT029547837	84.11	97	114	162	MT029548057	123.79	
	11.500	0.4528	12	54	71	118	MT029547838	84.11	97	114	162	MT029548058	123.79	
	11.700	0.4606	12	53	71	118	MT029547841	84.11	96	114	162	MT029548060	123.79	
	11.800	0.4646	12	53	71	118	MT029547842	84.11	96	114	162	MT029548061	123.79	
15/32	11.910	0.4688	12	53	71	118	MT029547843	84.11	96	114	162	MT029548062	123.79	
	12.000	0.4724	12	53	71	118	MT029547844	84.11	96	114	162	MT029548063	123.79	
1/2	12.700	0.5000	14	58	77	124	MT029547852	103.02	112	114	162	MT029548071	144.96	

COOLANT-THRU

3xD & 5xD Speeds & Feeds (Inches)

IPR = Inches Per Revolution

Material	SFM (Vc) Surface Feet Per Minute	D1mm	>3.00 ≤ 5.00	>5.00 ≤ 8.00	>8.00 ≥ 12.00	>12.00 ≤ 16.00	>16.00 ≤ 20.00
		Dec. Inch	.1181 - .1969	.1970 - .3150	.3151 - .4724	.4725 - .6299	.6300 - .7874
P1 Low-Carbon Steel - 1000 Series (<25 HRc)	328.1		.006	.008	.011	.013	.015
P3 Alloy Tool Steels - 1300,2000,3000 (<35 HRc)	246.1		.003	.004	.005	.008	.009
K1 Gray Cast Iron	262.5		.004	.006	.008	.011	.014

Note: These are only recommended starting figures that depend on conditions such as machine rigidity, type of coating (if any), ect. **Testing Recommended**

8xD Speeds & Feeds (Inches)

IPR = Inches Per Revolution

Material	SFM (Vc) Surface Feet Per Minute	D1mm	>3.00 ≤ 5.00	>5.00 ≤ 8.00	>8.00 ≥ 12.00	>12.00 ≤ 16.00	>16.00 ≤ 20.00
		Dec. Inch	.1181 - .1969	.1970 - .3150	.3151 - .4724	.4725 - .6299	.6300 - .7874
P1 Low-Carbon Steel - 1000 Series (<25 HRc)	311.7		.003	.005	.007	.010	.012
P3 Alloy Tool Steels - 1300, 2000, 3000 (<35 HRc)	295.3		.003	.005	.007	.010	.012
K1 Gray Cast Iron	229.7		.007	.009	.013	.015	.018

Note: These are only recommended starting figures that depend on conditions such as machine rigidity, type of coating (if any), ect. **Testing Recommended**

NON-COOLANT-THRU

3xD Speeds & Feeds (Inches)

IPR = Inches Per Revolution

Material	SFM (Vc) Surface Feet Per Minute	D1mm	>3.00 ≤ 5.00	>5.00 ≤ 8.00	>8.00 ≥ 12.00	>12.00 ≤ 16.00	>16.00 ≤ 20.00
		Dec. Inch	.1181 - .1969	.1970 - .3150	.3151 - .4724	.4725 - .6299	.6300 - .7874
P1 Low-Carbon Steel - 1000 Series (<25 HRc)	275		.003	.005	.01	.013	.016
P3 Alloy Tool Steels - 1300, 2000, 3000 (<35 HRc)	200		.0023	.0047	.0094	.0126	.014
K1 Gray Cast Iron	200		.0023	.0047	.0094	.0126	.014

Note: These are only recommended starting figures that depend on conditions such as machine rigidity, type of coating (if any), ect. **Testing Recommended**