

Drill Fix MULTI • Face Turning • Drill Diameters 8.0 mm to 32 mm

Application Data • Metric

		Cutting Speed - Vc					Recommended Feed Rate by Diameter																			
Material Group		Range - m/min				Feed - fz mm/rev	Ø8mm		Ø10mm		Ø12mm		Ø14mm		Ø16mm		Ø18mm		Ø20mm		Ø25mm		Ø32mm			
		KCU30		KCPK25			DFM-040104MPR		DFM-050204MPN		DFM-060204MPN		DFM-070304MPN		DFM-080304MPN		DFM09T-304MPN		DFM10T-308MPN		DFM-130408MPN		DFM-170508MPN			
		Min	Max	Min	Max		Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
P	0	95	220	95	240	mm/r	0.03	0.09	0.03	0.12	0.03	0.14	0.03	0.16	0.03	0.18	0.03	0.20	0.03	0.22	0.04	0.24	0.04	0.27		
	1	95	220	95	240	mm/r	0.03	0.09	0.03	0.12	0.03	0.14	0.03	0.16	0.03	0.18	0.03	0.20	0.03	0.22	0.04	0.24	0.04	0.27		
	2	95	220	95	240	mm/r	0.03	0.09	0.03	0.12	0.03	0.14	0.03	0.16	0.03	0.18	0.03	0.20	0.03	0.22	0.04	0.24	0.04	0.27		
	3	80	210	80	230	mm/r	0.03	0.09	0.03	0.12	0.03	0.14	0.03	0.16	0.03	0.18	0.03	0.20	0.03	0.22	0.04	0.24	0.04	0.27		
	4	70	200	70	220	mm/r	0.03	0.09	0.03	0.12	0.03	0.14	0.03	0.16	0.03	0.18	0.03	0.20	0.03	0.22	0.04	0.24	0.04	0.27		
	5	60	190	60	210	mm/r	0.03	0.09	0.03	0.12	0.03	0.14	0.03	0.16	0.03	0.18	0.03	0.20	0.03	0.22	0.04	0.24	0.04	0.27		
M	6	60	190	60	210	mm/r	0.03	0.09	0.03	0.12	0.03	0.14	0.03	0.16	0.03	0.18	0.03	0.20	0.03	0.22	0.04	0.24	0.04	0.27		
	1	70	210	70	230	mm/r	0.03	0.07	0.03	0.10	0.03	0.12	0.03	0.13	0.03	0.14	0.03	0.16	0.03	0.18	0.04	0.20	0.04	0.22		
	2	65	205	65	225	mm/r	0.03	0.07	0.03	0.10	0.03	0.12	0.03	0.13	0.03	0.14	0.03	0.16	0.03	0.18	0.04	0.20	0.04	0.22		
S	3	55	190	55	210	mm/r	0.03	0.07	0.03	0.10	0.03	0.12	0.03	0.13	0.03	0.14	0.03	0.16	0.03	0.18	0.04	0.20	0.04	0.22		
	1	25	75	25	80	mm/r	0.03	0.06	0.03	0.08	0.03	0.10	0.03	0.11	0.03	0.12	0.03	0.14	0.03	0.15	0.04	0.17	0.04	0.19		
		A _p				mm	0.50-1.90		0.50-2.20		0.70-2.70		0.80-3.00		0.90-3.40		0.90-3.80		1.00-4.20		1.00-5.00		1.00-6.00			

For unstable and interrupted cuts, reduce maximum feed rate and starting feed rate (mean value between minimum and maximum) by 20%.

For unstable and interrupted cuts, start with minimum cutting speed.

Drill Fix MULTI • Int/Ext Turning • Drill Diameters 8.0 mm to 32 mm

Application Data • Metric

		Cutting Speed - Vc					Recommended Feed Rate by Diameter																	
Material Group	Range - m/min					Feed - fz mm/rev	Ø8mm		Ø10mm		Ø12mm		Ø14mm		Ø16mm		Ø18mm		Ø20mm		Ø25mm		Ø32mm	
	KCU30		KCPK25		DFM-040104MPR		DFM-050204MPN		DFM-060204MPN		DFM-070304MPN		DFM-080304MPN		DFM09T-304MPN		DFM10T-308MPN		DFM-130408MPN		DFM-170508MPN			
	Min	Max	Min	Max	Min		Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	
P	0	95	220	95	240	mm/r	0.03	0.13	0.03	0.15	0.03	0.16	0.03	0.18	0.03	0.2	0.03	0.22	0.03	0.24	0.04	0.26	0.04	0.3
	1	95	220	95	240	mm/r	0.03	0.13	0.03	0.15	0.03	0.16	0.03	0.18	0.03	0.2	0.03	0.22	0.03	0.24	0.04	0.26	0.04	0.3
	2	95	220	95	240	mm/r	0.03	0.13	0.03	0.15	0.03	0.16	0.03	0.18	0.03	0.2	0.03	0.22	0.03	0.24	0.04	0.26	0.04	0.3
	3	80	210	80	230	mm/r	0.03	0.13	0.03	0.15	0.03	0.16	0.03	0.18	0.03	0.2	0.03	0.22	0.03	0.24	0.04	0.26	0.04	0.3
	4	70	200	70	220	mm/r	0.03	0.13	0.03	0.15	0.03	0.16	0.03	0.18	0.03	0.2	0.03	0.22	0.03	0.24	0.04	0.26	0.04	0.3
	5	60	190	60	210	mm/r	0.03	0.13	0.03	0.15	0.03	0.16	0.03	0.18	0.03	0.2	0.03	0.22	0.03	0.24	0.04	0.26	0.04	0.3
M	6	60	190	60	210	mm/r	0.03	0.13	0.03	0.15	0.03	0.16	0.03	0.18	0.03	0.2	0.03	0.22	0.03	0.24	0.04	0.26	0.04	0.3
	1	70	210	70	230	mm/r	0.03	0.11	0.03	0.12	0.03	0.13	0.03	0.14	0.03	0.16	0.03	0.18	0.03	0.20	0.04	0.22	0.04	0.25
	2	65	205	65	225	mm/r	0.03	0.11	0.03	0.12	0.03	0.13	0.03	0.14	0.03	0.16	0.03	0.18	0.03	0.20	0.04	0.22	0.04	0.25
S	3	55	190	55	210	mm/r	0.03	0.11	0.03	0.12	0.03	0.13	0.03	0.14	0.03	0.16	0.03	0.18	0.03	0.20	0.04	0.22	0.04	0.25
	1	25	75	25	80	mm/r	0.03	0.09	0.03	0.1	0.03	0.11	0.03	0.12	0.03	0.14	0.03	0.15	0.03	0.17	0.04	0.19	0.04	0.21
		A _p				mm	0.50-2.70		0.50-3.20		0.70-3.70		0.80-4.00		0.90-4.20		0.90-4.70		1.00-5.30		1.00-6.50		1.00-7.00	

For unstable and interrupted cuts, reduce maximum feed rate and starting feed rate (mean value between minimum and maximum) by 20%.

For unstable and interrupted cuts, start with minimum cutting speed.

Drill Fix MULTI • Holemaking • Drill Diameters 8.0 mm to 32 mm

Application Data • Metric

		Cutting Speed - Vc					Recommended Feed Rate by Diameter																			
Material Group		Range - m/min				Feed - fz mm/rev	Ø8mm		Ø10mm		Ø12mm		Ø14mm		Ø16mm		Ø18mm		Ø20mm		Ø25mm		Ø32mm			
		KCU30		KCPK25			DFM-040104MPR		DFM-050204MPN		DFM-060204MPN		DFM-070304MPN		DFM-080304MPN		DFM09T-304MPN		DFM10T-308MPN		DFM-130408MPN		DFM-170508MPN			
		Min	Max	Min	Max		Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
P	0	95	220	95	240	mm/r	0.03	0.06	0.03	0.06	0.03	0.07	0.03	0.08	0.03	0.08	0.03	0.09	0.03	0.10	0.04	0.12	0.04	0.15		
	1	95	220	95	240	mm/r	0.03	0.06	0.03	0.06	0.03	0.07	0.03	0.08	0.03	0.08	0.03	0.09	0.03	0.10	0.04	0.12	0.04	0.15		
	2	95	220	95	240	mm/r	0.03	0.06	0.03	0.06	0.03	0.07	0.03	0.08	0.03	0.08	0.03	0.09	0.03	0.10	0.04	0.12	0.04	0.15		
	3	80	210	80	230	mm/r	0.03	0.06	0.03	0.06	0.03	0.07	0.03	0.08	0.03	0.08	0.03	0.09	0.03	0.10	0.04	0.12	0.04	0.15		
	4	70	200	70	220	mm/r	0.03	0.06	0.03	0.06	0.03	0.07	0.03	0.08	0.03	0.08	0.03	0.09	0.03	0.10	0.04	0.12	0.04	0.15		
	5	60	190	60	210	mm/r	0.03	0.06	0.03	0.06	0.03	0.07	0.03	0.08	0.03	0.08	0.03	0.09	0.03	0.10	0.04	0.12	0.04	0.15		
M	6	60	190	60	210	mm/r	0.03	0.06	0.03	0.06	0.03	0.07	0.03	0.08	0.03	0.08	0.03	0.09	0.03	0.10	0.04	0.12	0.04	0.15		
	1	70	210	70	230	mm/r	0.03	0.06	0.03	0.06	0.03	0.07	0.03	0.08	0.03	0.08	0.03	0.09	0.03	0.10	0.04	0.12	0.04	0.15		
	2	65	205	65	225	mm/r	0.03	0.06	0.03	0.06	0.03	0.07	0.03	0.08	0.03	0.08	0.03	0.09	0.03	0.10	0.04	0.12	0.04	0.15		
S	3	55	190	55	210	mm/r	0.03	0.06	0.03	0.06	0.03	0.07	0.03	0.08	0.03	0.08	0.03	0.09	0.03	0.10	0.04	0.12	0.04	0.15		
	1	25	75	25	80	mm/r	0.03	0.06	0.03	0.06	0.03	0.07	0.03	0.08	0.03	0.08	0.03	0.09	0.03	0.10	0.04	0.12	0.04	0.15		

For unstable and interrupted cuts, reduce maximum feed rate and starting feed rate (mean value between minimum and maximum) by 20%.

For unstable and interrupted cuts, start with minimum cutting speed.

Drill Fix MULTI • Face Turning • Drill Diameters .315" to 1.26"

Application Data • Inch

		Cutting Speed - Vc					Recommended Feed Rate (mm) by Diameter																			
Material Group		Range - SFM				Feed - fz in/rev	0.315 in		0.394 in		0.472 in		0.551 in		0.630 in		0.709 in		0.787 in		0.984 in		1.260 in			
		KCU30		KCPK25			DFM-040104MPR		DFM-050204MPN		DFM-060204MPN		DFM-070304MPN		DFM-080304MPN		DFM09T-304MPN		DFM10T-308MPN		DFM-130408MPN		DFM-170508MPN			
		Min	Max	Min	Max		Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
P	0	310	720	310	785	in/rev	0.001	0.004	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.002	0.009	0.002	0.011		
	1	310	720	310	785	in/rev	0.001	0.004	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.002	0.009	0.002	0.011		
	2	310	720	310	785	in/rev	0.001	0.004	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.002	0.009	0.002	0.011		
	3	260	685	260	750	in/rev	0.001	0.004	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.002	0.009	0.002	0.011		
	4	225	655	225	720	in/rev	0.001	0.004	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.002	0.009	0.002	0.011		
	5	195	620	195	685	in/rev	0.001	0.004	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.002	0.009	0.002	0.011		
M	6	195	620	195	685	in/rev	0.001	0.004	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.002	0.009	0.002	0.011		
	1	225	685	225	750	in/rev	0.001	0.003	0.001	0.004	0.001	0.005	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.002	0.008	0.002	0.009		
	2	210	670	210	735	in/rev	0.001	0.003	0.001	0.004	0.001	0.005	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.002	0.008	0.002	0.009		
S	3	180	620	180	685	in/rev	0.001	0.003	0.001	0.004	0.001	0.005	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.002	0.008	0.002	0.009		
	1	80	245	80	260	in/rev	0.001	0.002	0.001	0.003	0.001	0.004	0.001	0.004	0.001	0.005	0.001	0.006	0.001	0.006	0.002	0.007	0.002	0.007		
A _p						in	0.020 - 0.075		0.020 - 0.087		0.028 - 0.106		0.031 - 0.118		0.035 - 0.134		0.035 - 0.150		0.039 - 0.165		0.039 - 0.197		0.039 - 0.236			

For unstable and interrupted cuts, reduce maximum feed rate and starting feed rate (mean value between minimum and maximum) by 20%.
For unstable and interrupted cuts, start with minimum cutting speed.

Drill Fix MULTI • Int/Ext Turning • Drill Diameters .315" to 1.26"

Application Data • Inch

		Cutting Speed - Vc					Recommended Feed Rate (mm) by Diameter																	
Material Group		Range - SFM				Feed - fz in/rev	0.315 in		0.394 in		0.472 in		0.551 in		0.630 in		0.709 in		0.787 in		0.984 in		1.260 in	
		KCU30		KCPK25			DFM-040104MPR		DFM-050204MPN		DFM-060204MPN		DFM-070304MPN		DFM-080304MPN		DFM09T-304MPN		DFM10T-308MPN		DFM-130408MPN		DFM-170508MPN	
		Min	Max	Min	Max		Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
P	0	310	720	310	785	in/rev	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.001	0.009	0.002	0.010	0.002	0.012
	1	310	720	310	785	in/rev	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.001	0.009	0.002	0.010	0.002	0.012
	2	310	720	310	785	in/rev	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.001	0.009	0.002	0.010	0.002	0.012
	3	260	685	260	750	in/rev	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.001	0.009	0.002	0.010	0.002	0.012
	4	225	655	225	720	in/rev	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.001	0.009	0.002	0.010	0.002	0.012
	5	195	620	195	685	in/rev	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.001	0.009	0.002	0.010	0.002	0.012
M	6	195	620	195	685	in/rev	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.001	0.009	0.001	0.009	0.002	0.010	0.002	0.012
	1	225	685	225	750	in/rev	0.001	0.004	0.001	0.005	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.002	0.009	0.002	0.010
	2	210	670	210	735	in/rev	0.001	0.004	0.001	0.005	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.002	0.009	0.002	0.010
S	3	180	620	180	685	in/rev	0.001	0.004	0.001	0.005	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.001	0.008	0.002	0.009	0.002	0.010
	1	80	245	80	260	in/rev	0.001	0.004	0.001	0.004	0.001	0.004	0.001	0.005	0.001	0.006	0.001	0.006	0.001	0.007	0.002	0.007	0.002	0.008
A _p						in	0.020 - 0.106		0.020 - 0.126		0.028 - 0.146		0.031 - 0.157		0.035 - 0.165		0.035 - 0.185		0.039 - 0.209		0.039 - 0.256		0.039 - 0.276	

For unstable and interrupted cuts, reduce maximum feed rate and starting feed rate (mean value between minimum and maximum) by 20%.
For unstable and interrupted cuts, start with minimum cutting speed.

Drill Fix MULTI • Holemaking • Drill Diameters .315" to 1.26"

Application Data • Inch

		Cutting Speed - Vc					Recommended Feed Rate (mm) by Diameter																			
Material Group		Range - SFM				Feed - fz in/rev	0.315 in		0.394 in		0.472 in		0.551 in		0.630 in		0.709 in		0.787 in		0.984 in		1.260 in			
		KCU30		KCPK25			DFM-040104MPR		DFM-050204MPN		DFM-060204MPN		DFM-070304MPN		DFM-080304MPN		DFM09T-304MPN		DFM10T-308MPN		DFM-130408MPN		DFM-170508MPN			
		Min	Max	Min	Max		Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max		
P	0	310	720	310	785	in/rev	0.001	0.002	0.001	0.002	0.001	0.003	0.001	0.003	0.001	0.003	0.001	0.004	0.001	0.004	0.002	0.005	0.002	0.006		
	1	310	720	310	785	in/rev	0.001	0.002	0.001	0.002	0.001	0.003	0.001	0.003	0.001	0.003	0.001	0.004	0.001	0.004	0.002	0.005	0.002	0.006		
	2	310	720	310	785	in/rev	0.001	0.002	0.001	0.002	0.001	0.003	0.001	0.003	0.001	0.003	0.001	0.004	0.001	0.004	0.002	0.005	0.002	0.006		
	3	260	685	260	750	in/rev	0.001	0.002	0.001	0.002	0.001	0.003	0.001	0.003	0.001	0.003	0.001	0.004	0.001	0.004	0.002	0.005	0.002	0.006		
	4	225	655	225	720	in/rev	0.001	0.002	0.001	0.002	0.001	0.003	0.001	0.003	0.001	0.003	0.001	0.004	0.001	0.004	0.002	0.005	0.002	0.006		
	5	195	620	195	685	in/rev	0.001	0.002	0.001	0.002	0.001	0.003	0.001	0.003	0.001	0.003	0.001	0.004	0.001	0.004	0.002	0.005	0.002	0.006		
M	6	195	620	195	685	in/rev	0.001	0.002	0.001	0.002	0.001	0.003	0.001	0.003	0.001	0.003	0.001	0.004	0.001	0.004	0.002	0.005	0.002	0.006		
	1	225	685	225	750	in/rev	0.001	0.002	0.001	0.002	0.001	0.003	0.001	0.003	0.001	0.003	0.001	0.004	0.001	0.004	0.002	0.005	0.002	0.006		
	2	210	670	210	735	in/rev	0.001	0.002	0.001	0.002	0.001	0.003	0.001	0.003	0.001	0.003	0.001	0.004	0.001	0.004	0.002	0.005	0.002	0.006		
S	3	180	620	180	685	in/rev	0.001	0.002	0.001	0.002	0.001	0.003	0.001	0.003	0.001	0.003	0.001	0.004	0.001	0.004	0.002	0.005	0.002	0.006		
	1	80	245	80	260	in/rev	0.001	0.002	0.001	0.002	0.001	0.003	0.001	0.003	0.001	0.003	0.001	0.004	0.001	0.004	0.002	0.005	0.002	0.006		