

HPR DRILLS APPLICATION DATA **METRIC**



Material Group	Cutting Speed — Vc		Metric									
	Range — m/min		Recommended Feed Rate per Rev									
	Min	Max		3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0	
P	P0	140	290	mm/r	0.13 - 0.24	0.14 - 0.26	0.15 - 0.30	0.17 - 0.34	0.19 - 0.38	0.21 - 0.42	0.24 - 0.50	0.28 - 0.58
	P1	130	290	mm/r	0.15 - 0.30	0.16 - 0.33	0.18 - 0.39	0.20 - 0.45	0.22 - 0.51	0.24 - 0.57	0.28 - 0.69	0.32 - 0.81
	P2	190	270	mm/r	0.14 - 0.29	0.15 - 0.32	0.18 - 0.38	0.21 - 0.43	0.24 - 0.49	0.27 - 0.55	0.33 - 0.66	0.39 - 0.77
	P3	130	190	mm/r	0.15 - 0.30	0.17 - 0.33	0.20 - 0.38	0.23 - 0.44	0.26 - 0.50	0.29 - 0.56	0.36 - 0.67	0.42 - 0.79
	P4	110	170	mm/r	0.13 - 0.25	0.15 - 0.27	0.19 - 0.33	0.22 - 0.38	0.26 - 0.43	0.30 - 0.48	0.37 - 0.59	0.44 - 0.69
	P5	70	110	mm/r	0.11 - 0.21	0.13 - 0.24	0.15 - 0.28	0.18 - 0.33	0.21 - 0.38	0.24 - 0.42	0.29 - 0.51	0.35 - 0.61
P6	60	100	mm/r	0.11 - 0.21	0.13 - 0.24	0.15 - 0.28	0.18 - 0.33	0.21 - 0.38	0.24 - 0.42	0.29 - 0.51	0.35 - 0.61	
K	K1	130	210	mm/r	0.12 - 0.27	0.15 - 0.33	0.21 - 0.43	0.26 - 0.51	0.30 - 0.59	0.34 - 0.65	0.41 - 0.77	0.47 - 0.87
	K2	90	180	mm/r	0.12 - 0.27	0.15 - 0.33	0.21 - 0.43	0.26 - 0.51	0.30 - 0.59	0.34 - 0.65	0.41 - 0.77	0.47 - 0.87
	K3	70	130	mm/r	0.10 - 0.22	0.13 - 0.27	0.18 - 0.36	0.23 - 0.43	0.27 - 0.49	0.31 - 0.55	0.37 - 0.65	0.43 - 0.74

Looking for speeds and feeds? Visit kennametalnovo.com to get cutting data specific to your application!



HPR DRILLS APPLICATION DATA **INCH**



Material Group	Cutting Speed — Vc		Inch									
	Range — SFM		Recommended Feed Rate per Rev									
	Min	Max		1/8 .125	3/16 .188	1/4 .250	5/16 .313	3/8 .375	1/2 .500	5/8 .625	3/4 .750	
	P	P0	460	950	ipr	.005 - .009	.005 - .010	.006 - .012	.007 - .013	.008 - .015	.008 - .017	.010 - .020
P1		430	950	ipr	.006 - .012	.006 - .013	.007 - .015	.008 - .018	.009 - .020	.009 - .022	.011 - .027	.013 - .032
P2		620	890	ipr	.005 - .012	.006 - .013	.007 - .015	.008 - .017	.009 - .019	.011 - .022	.013 - .026	.015 - .030
P3		430	620	ipr	.006 - .012	.007 - .013	.008 - .015	.009 - .017	.010 - .020	.012 - .022	.014 - .027	.017 - .031
P4		360	560	ipr	.005 - .010	.006 - .011	.007 - .013	.009 - .015	.010 - .017	.012 - .019	.015 - .023	.017 - .027
P6		200	330	ipr	.004 - .008	.005 - .009	.006 - .011	.007 - .013	.008 - .015	.009 - .017	.012 - .020	.014 - .024
K	K1	430	690	ipr	.005 - .011	.006 - .013	.008 - .017	.010 - .020	.012 - .023	.013 - .026	.016 - .030	.019 - .034
	K2	300	590	ipr	.005 - .011	.006 - .013	.008 - .017	.010 - .020	.012 - .023	.013 - .026	.016 - .030	.019 - .034
	K3	230	430	ipr	.004 - .009	.005 - .011	.007 - .014	.009 - .017	.011 - .019	.012 - .022	.015 - .026	.017 - .029

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