

■ TOP DRILL S • TDS212 • WK15PD™ • Flood Coolant • Metric

Material Group													
		Cutting Speed — vc Range — m/min			Recommended Feed Rate (f) by Diameter								
		min	—	max	Tool Diameter (mm)	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
K	15, 16	70	—	170	mm/r	0,16–0,31	0,20–0,38	0,23–0,44	0,25–0,49	0,31–0,60	0,38–0,74	0,31–0,60	0,38–0,74
	17, 18, 19	80	—	140	mm/r	0,16–0,25	0,20–0,31	0,23–0,36	0,25–0,40	0,31–0,48	0,38–0,60	0,31–0,48	0,38–0,60
	20	70	—	130	mm/r	0,12–0,25	0,14–0,30	0,17–0,35	0,19–0,40	0,24–0,48	0,30–0,60	0,24–0,48	0,30–0,60

■ TOP DRILL S • TDS411/TDS412/TDS413 • WK15PD • Through Coolant • Metric

Material Group													
		Cutting Speed — vc Range — m/min			Recommended Feed Rate (f) by Diameter								
		min	—	max	Tool Diameter (mm)	3,0	4,0	6,0	8,0	10,0	12,0	16,0	20,0
K	15, 16	80	—	190	mm/r	0,11–0,22	0,12–0,24	0,16–0,31	0,20–0,38	0,23–0,44	0,25–0,49	0,31–0,60	0,38–0,74
	17, 18, 19	90	—	170	mm/r	0,12–0,16	0,13–0,19	0,16–0,25	0,20–0,31	0,23–0,36	0,25–0,40	0,31–0,48	0,38–0,60
	20	80	—	150	mm/r	0,08–0,17	0,09–0,19	0,12–0,25	0,14–0,30	0,17–0,35	0,19–0,40	0,24–0,48	0,30–0,60

Metric
tolerance

nominal size range	D1 tolerance m7	D tolerance h6
>3–6	0,004/0,016	0,000/-0,008
>6–10	0,006/0,021	0,000/-0,009
>10–18	0,007/0,025	0,000/-0,011
>18–25,4	0,008/0,029	0,000/-0,013