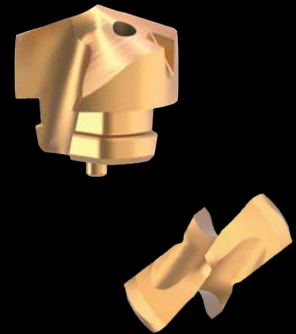


**FUTUR**  
**Carb**

1092 Chemin Ely  
Richmond, QC  
JOB 2H0  
819-826-1602

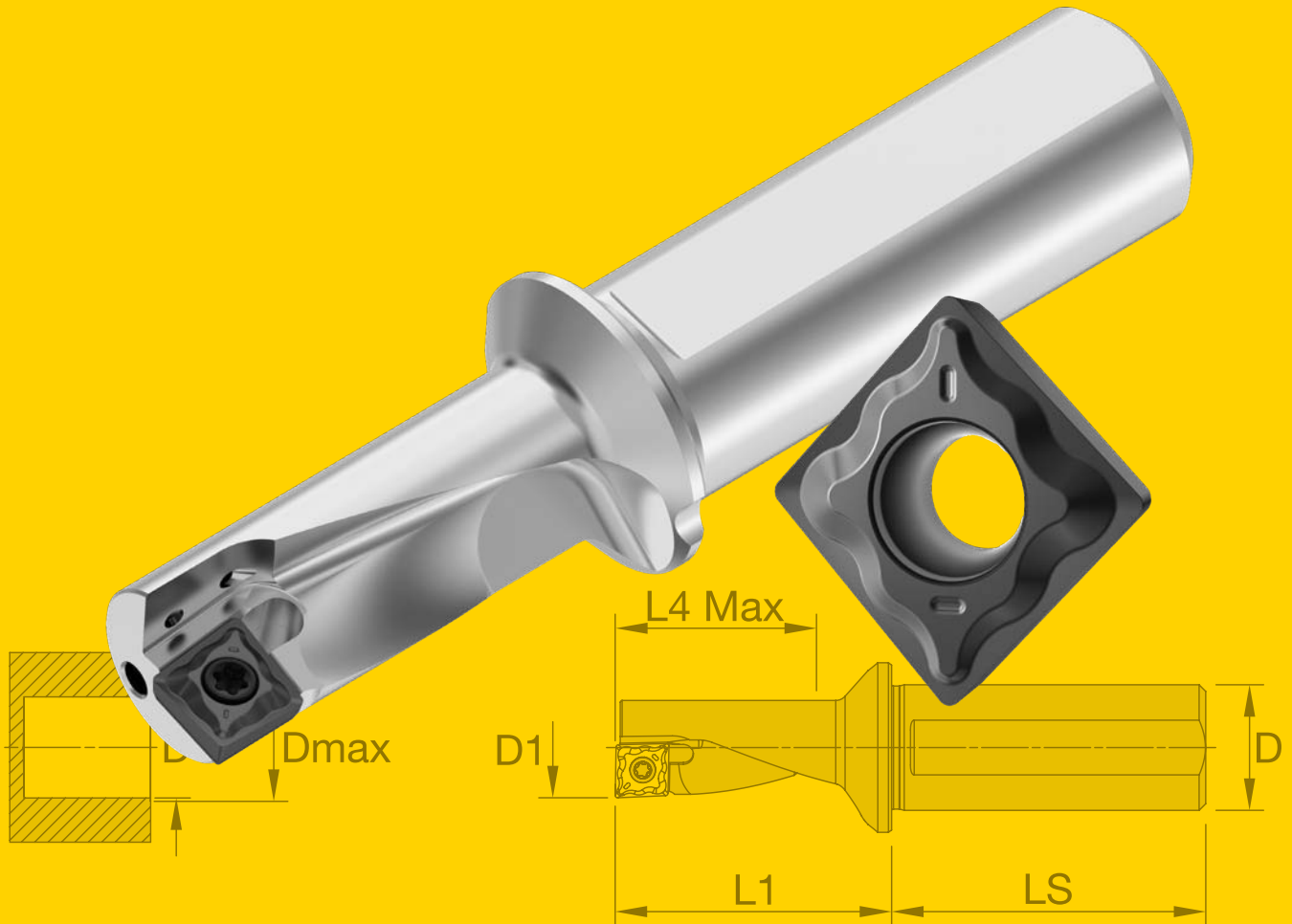


**SPRING 2026** inch  
**INNOVATIONS**

# Drill Fix MULTI™

## Cut Through Complexity

Experience new levels of productivity with Drill Fix MULTI. This innovative platform combines multiple operations like drilling, internal/external turning and facing into a single, high-performance tool, reducing setup time, minimizing tool changes and maximizing productivity. Whether it's for small to medium-sized components, this tooling system delivers consistent, high-quality results across several materials.



# Features & Benefits

- Reduces cycle time and the number of tool changes
- Can be used in small parts production with small lathes and Swiss-type machines
- For drilling, internal turning, external turning, facing and chamfering
- Insert grade KCU30 is the first choice generally and where drilling is the focus
- Insert grade KCPK25 is the first choice where turning is the focus, delivering higher productivity
- Ideal for general engineering and transportation industry machining
- 9 metric cutting diameters ranging from 8mm to 32mm

## Materials

**P** Steels      **M** Stainless Steels      **S** High-Temp Alloys

## Industries

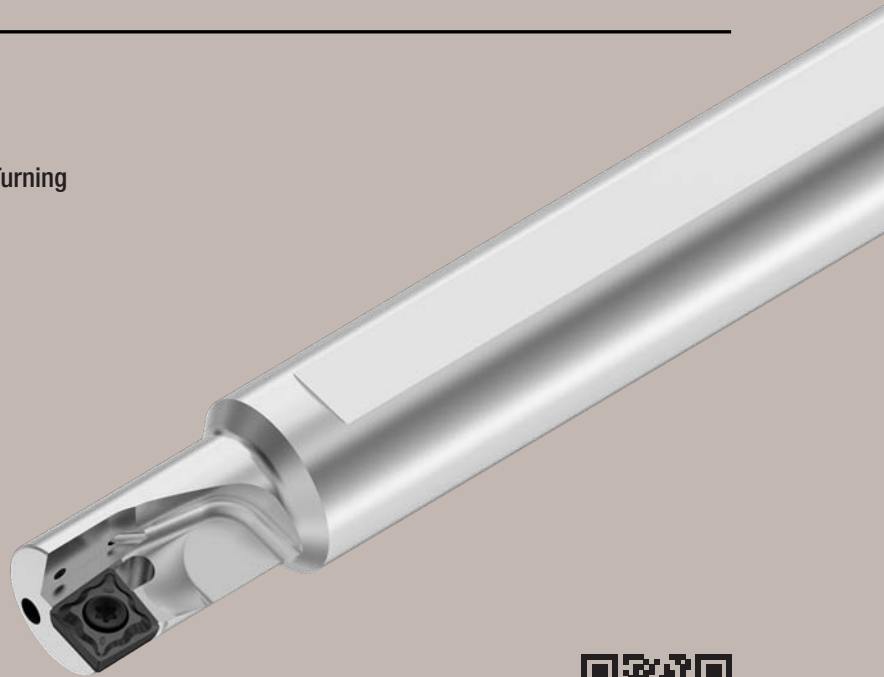
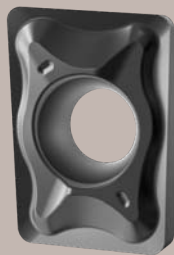
 General Engineering       Automotive       EV

 Oil & Gas       Wind & Solar       Aerospace

## Applications

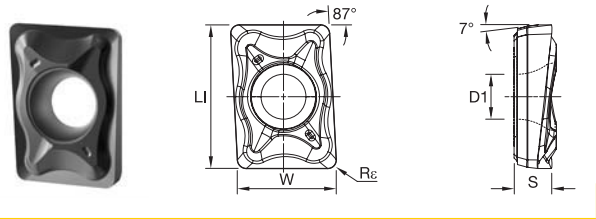
 Drilling       I.D. Turning       O.D. Turning

 Facing       Chamfering

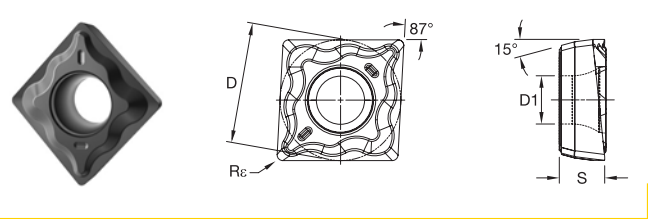


**EXPLORE**  
**Drill Fix MULTI**





Valid for smallest insert  
DFM04...R (RH only)



Valid for remaining larger sizes  
DFM(>04)...N (Neutral RH – LH)

HOLEMAKING

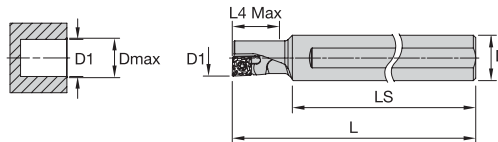
KCU30  
KCPK25

P	●	○
M	●	○
K	●	○
N	●	○
S	●	○
H	●	○

● Primary  
○ Secondary

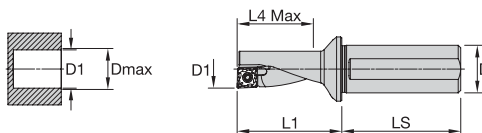
Drill Fix MULTI • Carbide Insert • MP Geometry

ISO Catalog Number	D		LI		W		D1		S		Re		KCU30	KCPK25
	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in		
DFM040104MPR	—	—	6.40	0.252	4.40	0.173	2.00	0.079	1.69	0.066	0.40	0.016	7381729	7381928
DFM050204MPN	5.65	0.222	—	—	—	—	2.00	0.079	1.98	0.078	0.40	0.016	7381730	7381929
DFM060204MPN	6.40	0.252	—	—	—	—	2.45	0.097	2.30	0.091	0.40	0.016	7381921	7381930
DFM070304MPN	7.50	0.295	—	—	—	—	2.80	0.110	3.10	0.122	0.40	0.016	7381922	7381941
DFM080304MPN	8.40	0.331	—	—	—	—	3.35	0.132	3.15	0.124	0.40	0.016	7381923	7381942
DFM09T304MPN	9.45	0.372	—	—	—	—	3.40	0.134	3.90	0.154	0.40	0.016	7381924	7381943
DFM10T308MPN	10.40	0.409	—	—	—	—	4.40	0.173	3.80	0.150	0.80	0.032	7381925	7381944
DFM130408MPN	13.35	0.526	—	—	—	—	5.30	0.209	4.70	0.185	0.80	0.032	7381926	7381945
DFM170508MPN	17.30	0.681	—	—	—	—	5.30	0.209	5.45	0.215	0.80	0.032	7381927	7381946



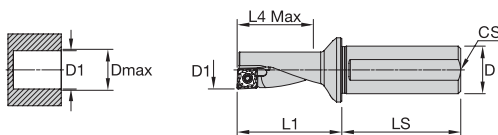
Drill Fix MULTI • Drill Body • 1.5 x D • Weldon Shank • Metric

Order Number	ISO Catalog Number	D1	D1 Max	L	L4 Max	LS	D	Insert
7387807	DFM08R150WB12M	7.85	8.30	80.00	12.00	62.10	12.00	DFM040104MPR
7387808	DFM10R150WB12M	9.85	10.50	90.00	15.00	71.70	12.00	DFM050204MPN
7387809	DFM12R150WB16M	12.50	11.85	100.00	18.00	75.90	16.00	DFM060204MPN
7387810	DFM14R150WB16M	13.80	14.50	110.00	21.00	85.50	16.00	DFM070304MPN
7387821	DFM16R150WB20M	15.80	16.50	125.00	24.00	96.50	20.00	DFM080304MPN
7387822	DFM18R150WB25M	17.80	18.50	135.00	27.00	103.20	25.00	DFM09T304MPN
7387824	DFM20R150WB25M	19.75	20.50	150.00	30.00	115.90	25.00	DFM10T308MPN
7387825	DFM25R150WB32M	24.75	25.80	180.00	37.50	136.40	32.00	DFM130408MPN
7387826	DFM32R150WB40M	31.75	33.00	200.00	48.00	143.20	40.00	DMF170508MPN



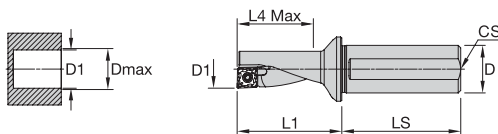
**Drill Fix MULTI • Drill Body • 2.25 x D • Weldon Shank • Metric**

Order Number	ISO Catalog Number	D1	D1 Max	L1	L	L4 Max	LS	D	Insert 1 Outside
7387827	DFM08R225WB10M	7.85	8.30	60.00	60.00	18.00	38.00	10.00	DFM040104MPR
7387828	DFM10R225WB12M	9.85	10.50	69.50	69.50	22.50	42.00	12.00	DFM050204MPN
7387829	DFM12R225WB16M	11.85	12.50	78.00	78.00	27.00	45.00	16.00	DFM060204MPN
7387830	DFM14R225WB16M	13.80	14.50	83.50	83.50	31.50	45.00	16.00	DFM070304MPN
7387831	DFM16R225WB20M	15.80	16.50	94.00	94.00	36.00	50.00	20.00	DFM080304MPN
7387832	DFM18R225WB25M	17.80	18.50	109.50	109.50	40.50	56.00	25.00	DFM09T304MPN
7387833	DFM20R225WB25M	19.75	20.50	111.00	111.00	45.00	56.00	25.00	DFM10T308MPN
7387834	DFM25R225WB32M	24.75	25.80	129.00	129.00	56.25	60.00	32.00	DFM130408MPN
7387835	DFM32R225WB40M	31.75	33.00	158.00	158.00	72.00	70.00	40.00	DMF170508MPN



**Drill Fix MULTI • Drill Body • 2.25 x D • Weldon Shank • Swiss Machines • Metric**

Order Number	ISO Catalog Number	D1	D1 Max	L1	L	L4 Max	LS	D	CS	Insert 1 Outside
7387846	DFM08R225WB22M	7.85	8.30	85.00	85.00	18.00	60.00	22.00	G 1/8	DFM040104MPR
7387847	DFM10R225WB22M	9.85	10.50	90.00	90.00	22.50	60.00	22.00	G 1/8	DFM050204MPN
7387848	DFM12R225WB22M	11.85	12.50	95.00	95.00	27.00	60.00	22.00	G 1/8	DFM060204MPN
7387849	DFM14R225WB22M	13.80	14.50	98.50	98.50	31.50	60.00	22.00	G 1/8	DFM070304MPN
7387850	DFM16R225WB22M	15.80	16.50	104.00	104.00	36.00	60.00	22.00	G 1/8	DFM080304MPN
7387851	DFM18R225WB22M	17.80	18.50	114.00	114.00	40.50	60.00	22.00	G 1/8	DFM09T304MPN
7387852	DFM20R225WB22M	19.75	20.50	115.00	115.00	45.00	60.00	22.00	G 1/8	DFM10T308MPN



**Drill Fix MULTI • Drill Body • 2.25 x D • Weldon Shank • Inch**

Order Number	ISO Catalog Number	D1	D1 Max	L1	L	L4 Max	LS	D	CS	Insert 1 Outside
7387836	DFM0315R225WB050	0.315	0.327	2.485	2.485	0.709	1.615	0.500	G 1/16	DFM040104MPR
7387837	DFM0394R225WB050	0.388	0.413	2.700	2.700	0.886	1.615	0.500	G 1/16	DFM050204MPN
7387838	DFM0472R225WB063	0.492	0.467	2.993	2.993	1.063	1.693	0.625	G 1/8	DFM060204MPN
7387839	DFM0551R225WB063	0.543	0.571	3.213	3.213	1.240	1.693	0.625	G 1/8	DFM070304MPN
7387840	DFM0630R225WB075	0.650	0.622	3.700	3.700	1.417	1.970	0.750	G 1/8	DFM080304MPN
7387841	DFM0709R225WB100	0.728	0.701	4.315	4.315	1.595	2.205	1.000	G 1/8	DFM09T304MPN
7387842	DFM0787R225WB100	0.807	0.778	4.375	4.375	1.772	2.205	1.000	G 1/8	DFM10T308MPN
7387843	DFM0984R225WB125	1.016	0.974	5.000	5.000	2.215	2.285	1.250	G 1/8	DFM130408MPN
7387844	DFM1260R225WB150	1.250	1.299	6.196	6.196	2.835	2.736	1.500	G 1/8	DMF170508MPN

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

### Application Data • Metric

Material Group	Cutting Speed - Vc					Feed - fz mm/rev	Recommended Feed Rate by Diameter																	
	Range - m/min						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	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 <sub>p</sub>						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

Material Group	Cutting Speed - Vc					Feed - fz mm/rev	Recommended Feed Rate by Diameter																	
	Range - m/min						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	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 <sub>p</sub>						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.

HOLEMAKING

## Drill Fix MULTI • Holmaking • Drill Diameters 8.0 mm to 32 mm Application Data • Metric

Material Group	Cutting Speed - Vc					Feed - fz mm/rev	Recommended Feed Rate by Diameter																	
	Range - m/min				mm/r		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

Material Group	Cutting Speed - Vc					Feed - fz in/rev	Recommended Feed Rate (mm) by Diameter																	
	Range - SFM				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
<b>A<sub>p</sub></b>						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

Material Group	Cutting Speed - Vc					Feed - fz in/rev	Recommended Feed Rate (mm) by Diameter																	
	Range - SFM				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	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
	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
S	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
<b>A<sub>p</sub></b>						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

Material Group	Cutting Speed - Vc					Feed - fz in/rev	Recommended Feed Rate (mm) by Diameter																	
	Range - SFM				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	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
	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
S	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

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.

HOLEMAKING

# Drill Fix MULTI

LET'S TAKE YOUR MANUFACTURING  
TO THE NEXT LEVEL

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