



# HAAS MODULAR DRILL HEADS

Feeds and Speeds

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Speed and Feed Chart - Inch											
Recommended Feed Rate per Revolution											
	Cutting Speed - SFM			Tool Diameter	.315	.394	.472	.551	.630	.787	1,000
	min	start	max								
<b>P1</b>	262	<b>410</b>	558	ipr	.004-.008	.005-.010	.006-.012	.007-.015	.007-.018	.010-.019	.012-.020
<b>P2</b>	345	<b>459</b>	591	ipr	.004-.011	.005-.014	.006-.015	.008-.018	.009-.018	.011-.020	.012-.020
<b>P3</b>	164	<b>246</b>	328	ipr	.004-.011	.005-.014	.006-.015	.008-.018	.009-.018	.011-.020	.012-.020
<b>P4</b>	164	<b>246</b>	328	ipr	.004-.011	.005-.014	.006-.015	.007-.018	.007-.018	.009-.019	.010-.020
<b>P5</b>	160	<b>210</b>	260	ipr	.004-.008	.004-.009	.004-.010	.006-.011	.006-.013	.007-.014	.009-.017
<b>P6</b>	160	<b>210</b>	260	ipr	.004-.008	.004-.009	.004-.010	.006-.011	.006-.013	.007-.014	.009-.017
<b>M1</b>	130	<b>260</b>	360	ipr	.002-.009	.003-.009	.004-.010	.004-.010	.004-.010	.005-.012	.006-.013
<b>M2</b>	110	<b>180</b>	250	ipr	.002-.009	.003-.009	.004-.010	.004-.010	.004-.010	.005-.012	.006-.013
<b>M3</b>	70	<b>110</b>	160	ipr	.002-.009	.003-.009	.004-.010	.004-.010	.004-.010	.005-.012	.006-.013
<b>K1</b>	197	<b>312</b>	558	ipr	.006-.011	.006-.013	.007-.014	.008-.017	.010-.019	.011-.020	.013-.022
<b>K2</b>	197	<b>246</b>	295	ipr	.006-.011	.006-.012	.007-.013	.008-.016	.010-.019	.011-.020	.013-.022
<b>K3</b>	131	<b>213</b>	295	ipr	.006-.012	.007-.013	.007-.014	.008-.016	.008-.017	.009-.019	.010-.020

NOTE: Through coolant recommended for greater than 3xD applications

<b>P</b>	Steel
<b>M</b>	Stainless Steel
<b>K</b>	Cast Iron
<b>N</b>	Non-Ferrous
<b>S</b>	High-Temp Alloys
<b>H</b>	Hardened Materials