

Recommended Cutting Data 204 / 206 - Inch

Recommended Speeds By Material Group		Vc - SFM						
Material Group	Material Type	Uncoated			ALtima® Coated			
		3-5xD Solid			3-5xD Solid			
		Low	Mid	High	Low	Mid	High	
Steels	P	Low Carbon	150	- 180	- 210	200	- 230	- 260
		Medium Carbon	130	- 160	- 190	180	- 210	- 240
		Alloy Steels (≤ 35 HRC)	130	- 160	- 190	180	- 210	- 240
		Die / Tool Steels (≤ 45 HRC)	120	- 150	- 180	170	- 200	- 230
Stainless Steels	M	Free Machining	-	N/A	-	170	- 200	- 230
		Austenitic	-	N/A	-	140	- 170	- 200
Cast Irons	K	Gray	-	N/A	-	330	- 360	- 390
		Ductile & Malleable	-	N/A	-	200	- 230	- 260
Non-Ferrous	N	Aluminum - Wrought (≤ 10% Si)	400	- 450	- 500	-	N/A	-
		Aluminum - Cast (> 10% Si)	300	- 350	- 400	-	N/A	-
		Copper / Copper Alloys	200	- 250	- 300	-	N/A	-
		Brass	400	- 450	- 500	-	N/A	-
		Plastics	400	- 450	- 500	-	N/A	-
		Kevlar / Graphite	350	- 400	- 450	-	N/A	-

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.

Recommended Cutting Data 204 / 206 - Inch, Continued

Recommended Feeds By Material Group		Drill Diameter (inch)								
Material Group	Material Type	1/32	1/16	1/8	1/4	3/8	1/2	5/8	3/4	
		Feed (in/rev)								
Steels	P	Low Carbon	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
		Medium Carbon	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
		Alloy Steels (≤ 35 HRC)	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
		Die / Tool Steels (≤ 45 HRC)	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
Stainless Steels	M	Free Machining	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
		Austenitic	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
Cast Irons	K	Gray	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
		Ductile & Malleable	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
Non-Ferrous	N	Aluminum - Wrought (≤ 10% Si)	.0008	.0016	.0031	.0063	.0094	.0125	.0156	.0188
		Aluminum - Cast (> 10% Si)	.0008	.0016	.0031	.0063	.0094	.0125	.0156	.0188
		Copper / Copper Alloys	.0008	.0016	.0031	.0063	.0094	.0125	.0156	.0188
		Brass	.0008	.0016	.0031	.0063	.0094	.0125	.0156	.0188
		Plastics	.0009	.0019	.0038	.0075	.0113	.0150	.0188	.0225
		Kevlar / Graphite	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120

.5 to 1xD pecking may be required in difficult-to-machine / long chipping materials, or when exceeding 3xD hole depths.