Twister® GP

Recommended Cutting Data 224 / 226 - Metric

Recommended Speeds By Material Group			Vc - M/Min										
Material Group		Material Type	Uncoated						ALtima® Coated				
			3-5xD Solid						3-5xD Solid				
			Low	-	Mid	-	High		Low	-	Mid	-	High
Steels	P	Low Carbon	45	-	**55**	-	65		60	-	**70**	-	80
		Medium Carbon	40	-	**50**	-	60		55	-	**65**	-	75
		Alloy Steels (≤ 35 HRC)	40	-	**50**	-	60		55	-	**65**	-	75
		Die / Tool Steels (≤ 45 HRC)	35	-	**45**	-	55		50	-	**60**	-	70
Stainless Steels	M	Free Machining		-	**N/A**	-			50	-	**60**	-	70
		Austenitic		-	**N/A**	-			45	-	**50**	-	60
Cast Irons	K	Gray		-	**N/A**	-			100	-	**110**	-	120
		Ductile & Malleable		-	**N/A**	-			60	-	**70**	-	80
Non-Ferrous	N	Aluminum - Wrought (≤ 10% Si)	120	-	**135**	-	150			-	**N/A**	-	
		Aluminum - Cast (> 10% Si)	90	-	**105**	-	120			-	**N/A**	-	
		Copper / Copper Alloys	60	-	**75**	-	90			-	**N/A**	-	
		Brass	120	-	**135**	-	150			-	**N/A**	-	
		Plastics	120	-	**135**	-	150			-	**N/A**	-	
		Kevlar / Graphite	105	-	**120**	-	135			-	**N/A**	-	

Recommended Cutting Data 224 / 226 - Metric, Continued

Recommended Feeds By Material Group			Drill Diameter (mm)							
Material Group		Material Type	1	1.5	3	6	10	12	16	20
			Feed (mm/rev)							
Steels	P	Low Carbon	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
		Medium Carbon	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
		Alloy Steels (≤ 35 HRC)	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
		Die / Tool Steels (≤ 45 HRC)	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
Stainless Steels	M	Free Machining	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
		Austenitic	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
Cast Irons	K	Gray	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
		Ductile & Malleable	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
Non-Ferrous	N	Aluminum - Wrought (≤ 10% Si)	0.025	0.038	0.075	0.150	0.250	0.300	0.400	0.500
		Aluminum - Cast (> 10% Si)	0.025	0.038	0.075	0.150	0.250	0.300	0.400	0.500
		Copper / Copper Alloys	0.025	0.038	0.075	0.150	0.250	0.300	0.400	0.500
		Brass	0.025	0.038	0.075	0.150	0.250	0.300	0.400	0.500
		Plastics	0.030	0.045	0.090	0.180	0.300	0.360	0.480	0.600
		Kevlar / Graphite	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320

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