

Technical Information

PREMIUM QUALITY AMERICAN-MADE CUTTING TOOLS



DRILLS - HIGH SPEED STEEL & M42 COBALT

ALTiN COATED INCREASE SFM BY 40%

SFM & CHIP LOAD

MATERIAL / TYPE	SFM			FEED in INCHES PER REVOLUTION (IPR) +/-25%									
	GENERAL PURPOSE	HSS HEAVY DUTY	COBALT	1/32"	3/32"	1/8"	5/32"	3/16"	1/4"	5/16"	3/8"	1/2"	9/16"
STEEL													
12L14, 12L15	115	115	115	.0008-.0009	.0026-.0033	.0040-.0053	.0046-.0060	.0051-.0067	.0059-.0078	.0075-.0098	.009-.0117	.0096-.0124	.0107-.0137
1005-1025, 1214, 1215, A36	98	98	98	0.0008	0.0026	0.004	0.0046	0.0051	0.0059	0.0075	0.009	0.0096	0.0107
1000'S, 1100'S	82	89	89	0.0007	.0020-.0022	.0029-.0033	.0033-.0038	.0037-.0043	.0043-.0050	.0054-.0063	.0065-.0075	.0070-.0081	.0080-.0091
4140, 4340, 52100, 8620, H11-H41, A2, D2, 01, P20, 420	30-66	33-79	33-79	.0006-.0007	.0015-.0020	.0021-.0029	.0024-.0033	.0027-.0037	.0031-.0043	.0039-.0054	.0047-.0065	.0051-.0070	.0059-.0080
STAINLESS STEEL													
200, 303, 416, 440	49	72	72	0.0007	0.0017	0.0024	0.0028	0.0031	0.0037	0.0045	0.0055	0.0059	0.0068
300 SERIES	26	36	36	0.0007	0.0022	0.0033	0.0038	0.0043	0.005	0.0063	0.0075	0.0081	0.0091
318-329, 400-446, DUPLEX	30	49	49	0.0006	0.0013	0.0017	0.002	0.0022	0.0025	0.0031	0.0039	0.0043	0.0049
CAST IRON													
GREY, G10, Gg40, J431C, A48 CLASS 20	79-98	92-115	92-115	.0006-.0008	.0013-.0026	.0021-.0040	.0024-.0046	.0027-.0051	.0031-.0059	.0039-.0075	.0047-.009	.0051-.0096	.0059-.0107
A220, A436, A439, A602, BLACK	66	72	72	0.0007	0.0017	0.0024	0.0028	0.0031	0.0037	0.0045	0.0055	0.0059	0.0068
BLACK Gts/Gtw, J434C	46	56	56	0.0007	0.0017	0.0024	0.0028	0.0031	0.0037	0.0045	0.0055	0.0059	0.0068
TITANIUM													
COMMERCIALLY PURE	75	92	92	0.0007	.0017-.0020	.0024-.0029	.0028-.0033	.0031-.0037	.0037-.0043	.0045-.0054	.0055-.0065	.0059-.0070	.0068-.0080
6Al4V, 6A14V-2SnMonel, Monel K	20-39	36-66	36-66	0.0006	.0011-.0015	.0015-.0021	.0016-.0024	.0018-.0027	.0021-.0031	.0026-.0039	.0031-.0047	.0035-.0051	.0041-.0059
NICKEL													
COMMERCIALLY PURE, 17644, 200, 5553	33	49	49	0.0007	0.0022	0.0033	0.0038	0.0043	0.005	0.0063	0.0075	0.0081	0.0091
Monel 400, Hastelloy C, Inconel 625, Waspalloy	20	23	23	0.0007	0.0017	0.0024	0.0028	0.0031	0.0037	0.0045	0.0055	0.0059	0.0068
Inconel 718, Nimonic 75-95, Rene 41, Inconel 825, A286	10	20	20	.0004-.0006	.0009-.0011	.0011-.0015	.0013-.0016	.0014-.0018	.0017-.0021	.0021-.0026	.0024-.0031	.0027-.0035	.0032-.0041
COPPER													
COMMERCIALLY PURE	108	125	125	.0007-.0008	.0022-.0026	.0033-.0040	.0038-.0046	.0043-.0051	.0050-.0059	.0063-.0075	.0075-.0090	.0081-.0096	.0091-.0107
BRASS, BRONZE 314-340, 350-370	115	131	131	.0007-.0008	.0020-.0030	.0029-.0047	.0033-.0053	.0037-.0059	.0043-.0068	.0054-.0087	.0065-.0104	.0070-.0110	.008-.0122
BRASS ALLOYED Cu+Al+Fe, LONG CHIPPING	89	89	89	0.0008	0.0026	0.004	0.0046	0.0051	0.0059	0.0075	0.009	0.0096	0.0107
High Strength Bronze	52	69	69	0.0007	.0020-.0022	.0029-.0033	.0033-.0038	.0037-.0043	.0043-.0050	.0054-.0063	.0065-.0075	.0070-.0081	.0080-.0091
ALUMINUM, MAGNESIUM													
Commercially Pure	108	108	108	0.0009	0.0033	0.0053	0.006	0.0067	0.0078	0.0098	0.0117	0.0124	0.0137
6061, T6	89-98	98	98	.0007-.0009	.0022-.0033	.0033-.0053	.0038-.0060	.0043-.0067	.0050-.0078	.0063-.0098	.0075-.0117	.0081-.0124	.0091-.0137
SYNTHETIC MATERIALS													
Thermoplastics	98	-	-	0.0009	0.0033	0.0053	0.006	0.0067	0.0078	0.0098	0.0117	0.0124	0.0137
Thermosetting Plastics	92	-	-	0.0008	0.0026	0.004	0.0046	0.0051	0.0059	0.0075	0.009	0.0096	0.0107
Reinforced Plastic Material	46	-	-	0.0007	0.002	0.0029	0.0033	0.0037	0.0043	0.0054	0.0065	0.007	0.008

TECHNICAL INFORMATION