

RECOMMENDED CUTTING CONDITIONS

Work Material		X			
		CFRP			
Drill Dia. DC (mm)	Drill Dia. DC (inch)	Cutting speed (m/min)	Revolution (min ⁻¹)	Feed (Min.—Max.) (mm/rev)	Feed rate (mm/min)
4.76	.1875	100	6700	0.08 (0.05—0.12)	540
6.38	.251	100	5000	0.1 (0.05—0.12)	500
7.96	.3125	100	4000	0.1 (0.05—0.12)	400
9.55	.375	100	3400	0.1 (0.05—0.12)	340
11.14	.4375	100	2900	0.1 (0.05—0.12)	290