

RECOMMENDED CUTTING CONDITIONS

Work Material		X			
Work Material		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)
6.38	.251	100	5000	0.15 (0.10—0.20)	750
9.55	.375	100	3400	0.15 (0.10—0.20)	680

Work Material		N					S				
Work Material		Aluminium Alloy (Si<5%) A6061, A7075 etc.					Titanium Alloy Ti-6Al-4V etc.				
Drill Dia. DC (mm)	Drill Dia. DC (inch)	Cutting speed (m/min)	Revolution (min ⁻¹)	Feed (Min.—Max.) (mm/rev)	Feed rate (mm/min)	Peck machining (mm)	Cutting speed (m/min)	Revolution (min ⁻¹)	Feed (Min.—Max.) (mm/rev)	Feed rate (mm/min)	Peck machining (mm)
6.38	.251	100	5000	0.15 (0.10—0.20)	750	3	15	750	0.02 (0.01—0.03)	15	1
9.55	.375	100	3400	0.15 (0.10—0.20)	500	3	15	500	0.02 (0.01—0.03)	10	1

Note 1) This condition is for when internal air or mist is used.

Note 2) We recommend to divide cutting conditions in each work material.