

## RECOMMENDED CUTTING CONDITIONS

Workpiece Material		CFRP				Titanium Alloys Ti-6Al-4V				
Drill Dia. DC (mm)	Drill Dia. DC (inch)	Cutting Speed (m/min)	Revolution (min <sup>-1</sup> )	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)	Cutting Speed (m/min)	Revolution (min <sup>-1</sup> )	Feed rate (Min.—Max.) (mm/rev)	Table Feed (mm/min)	Peck machining (mm)
<b>6.38</b>	<b>.251</b>	100	5000	0.15 (0.10—0.20)	750	15	750	0.02 (0.01—0.03)	15	1
<b>9.55</b>	<b>.375</b>	100	3400	0.15 (0.10—0.20)	680	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) It is recommended to divide cutting conditions per each workpiece material.