

RECOMMENDED CUTTING CONDITIONS

Work Material	Drill Dia. ϕ .1250" – ϕ .2344"		Drill Dia. ϕ .2500" – ϕ .3906"		Drill Dia. ϕ .4062" – ϕ .7812"	
	Cutting Speed (SFM)	Feed (IPR)	Cutting Speed (SFM)	Feed (IPR)	Cutting Speed (SFM)	Feed (IPR)
N Aluminum Alloy Casting	330 (195–490)	.006 (.002–.012)	390 (260–555)	.008 (.004–.012)	490 (330–655)	.010 (.004–.016)
Aluminum Alloy Die Casting	390 (260–555)	.005 (.002–.010)	490 (330–590)	.006 (.002–.010)	525 (390–655)	.008 (.004–.012)
K Gray Cast Iron	195 (130–260)	.006 (.004–.008)	260 (195–360)	.008 (.004–.012)	330 (230–425)	.012 (.008–.016)
Ductile Cast Iron	145 (100–195)	.004 (.002–.006)	195 (130–260)	.005 (.002–.008)	260 (195–330)	.008 (.004–.012)