

Series M814 8xD

Series M814 8xD	Hardness	Vc (m/min)	DC • mm					
			1	2	3	4		
P CARBON STEELS 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 175 Bhn or ≤ 7 HRc	125 (100-150)	RPM	39746	19873	13249	9937	
			Fz	0.0229	0.0458	0.0686	0.0915	
			Feed (mm/min)	909	909	909	909	
	≤ 275 Bhn or ≤ 28 HRc	94 (76-113)	RPM	30052	15026	10017	7513	
			Fz	0.0216	0.0431	0.0647	0.0862	
			Feed (mm/min)	648	648	648	648	
H TOOL STEELS A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 475 Bhn or ≤ 50 HRc	46 (37-55)	RPM	14541	7271	4847	3635	
			Fz	0.0101	0.0203	0.0304	0.0405	
			Feed (mm/min)	147	147	147	147	
	K CAST IRONS Gray, Malleable, Ductile	≤ 220 Bhn or ≤ 19 HRc	110 (88-132)	RPM	34899	17449	11633	8725
				Fz	0.0318	0.0636	0.0954	0.1272
				Feed (mm/min)	1110	1110	1110	1110
M STAINLESS STEELS (FREE MACHINING) 303, 416, 420F, 430F, 440F		≤ 275 Bhn or ≤ 28 HRc	55 (44-66)	RPM	17449	8725	5816	4362
				Fz	0.0178	0.0355	0.0533	0.0710
				Feed (mm/min)	310	310	310	310
	≤ 325 Bhn or ≤ 35 HRc	38 (30-46)	RPM	12118	6059	4039	3029	
			Fz	0.0140	0.0281	0.0421	0.0562	
			Feed (mm/min)	170	170	170	170	
S SUPER ALLOYS (NICKEL, COBALT, IRON BASE) Inconel 601, 617, 625, Incoloy 800, Monel 400, Rene, Waspaloy	≤ 320 Bhn or ≤ 34 HRc	27 (22-33)	RPM	8725	4362	2908	2181	
			Fz	0.0096	0.0192	0.0288	0.0384	
			Feed (mm/min)	84	84	84	84	
	≤ 350 Bhn or ≤ 38 HRc	46 (37-55)	RPM	14541	7271	4847	3635	
			Fz	0.0093	0.0185	0.0278	0.0370	
			Feed (mm/min)	135	135	135	135	
N ALUMINUM ALLOYS 2017, 2024, 356, 6061, 7075	≤ 150 Bhn or ≤ 7 HRc	130 (104-155)	RPM	41200	20600	13733	10300	
			Fz	0.0395	0.0789	0.1184	0.1578	
			Feed (mm/min)	1626	1626	1626	1626	
	≤ 140 Bhn or ≤ 3 HRc	99 (79-119)	RPM	31506	15753	10502	7877	
			Fz	0.0407	0.0814	0.1221	0.1629	
			Feed (mm/min)	1283	1283	1283	1283	
COPPER ALLOYS Alum Bronze, C110, Muntz Brass	≤ 140 Bhn or ≤ 3 HRc	99 (79-119)	RPM	31506	15753	10502	7877	
			Fz	0.0407	0.0814	0.1221	0.1629	
			Feed (mm/min)	1283	1283	1283	1283	

- Note:**
- Bhn (Brinell) HRc (Rockwell C) HRb (Rockwell B)
 - rpm = (Vc x 1000) / (DC x 3.14)
 - mm/min = Fr x rpm (Fr x maximum available rpm when recommendation exceeds machine limit)
 - reduce speed and feed 30% when using uncoated drills
 - reduce speed and feed for materials harder than listed
 - refer to the KYOCERA SGS Tool Wizard® or sgsmicrotools.com for complete technical information

METRIC Series M814 15xD

Series M814 15xD	Hardness	Vc (m/min)	DC • mm					
			1	2	3	4		
P CARBON STEELS 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 175 Bhn or ≤ 7 HRc	125 (100-150)	RPM	39746	19873	13249	9937	
			Fz	0.0160	0.0320	0.0479	0.0639	
			Feed (mm/min)	635	635	635	635	
	≤ 275 Bhn or ≤ 28 HRc	94 (76-113)	RPM	30052	15026	10017	7513	
			Fz	0.0139	0.0279	0.0418	0.0558	
			Feed (mm/min)	419	419	419	419	
H TOOL STEELS A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 475 Bhn or ≤ 50 HRc	46 (37-55)	RPM	14541	7271	4847	3635	
			Fz	0.0070	0.0140	0.0210	0.0279	
			Feed (mm/min)	102	102	102	102	
	K CAST IRONS Gray, Malleable, Ductile	≤ 220 Bhn or ≤ 19 HRc	110 (68-132)	RPM	34899	17449	11633	8725
				Fz	0.0229	0.0459	0.0688	0.0917
				Feed (mm/min)	800	800	800	800
M STAINLESS STEELS (FREE MACHINING) 303, 416, 420F, 430F, 440F	≤ 275 Bhn or ≤ 28 HRc	55 (44-66)	RPM	17449	8725	5816	4362	
			Fz	0.0127	0.0253	0.0380	0.0507	
			Feed (mm/min)	221	221	221	221	
	STAINLESS STEELS (DIFFICULT) 304, 316, 321, 13-8 PH, 15-5PH, 17-4 PH, CUSTOM 450	≤ 325 Bhn or ≤ 35 HRc	38 (30-46)	RPM	12118	6059	4039	3029
				Fz	0.0094	0.0189	0.0283	0.0377
				Feed (mm/min)	114	114	114	114
S SUPER ALLOYS (NICKEL, COBALT, IRON BASE) Inconel 601, 617, 625, Incoloy 800, Monel 400, Rene, Waspaloy	≤ 320 Bhn or ≤ 34 HRc	27 (22-33)	RPM	8725	4362	2908	2181	
			Fz	0.0064	0.0128	0.0192	0.0256	
			Feed (mm/min)	56	56	56	56	
	TITANIUM ALLOYS Pure Titanium, Ti6Al4V, Ti6Al2Sn4Zr2Mo, Ti4Al4Mo2Sn0.5Si	≤ 350 Bhn or ≤ 38 HRc	46 (37-55)	RPM	14541	7271	4847	3635
				Fz	0.0077	0.0154	0.0231	0.0307
				Feed (mm/min)	112	112	112	112
N ALUMINUM ALLOYS 2017, 2024, 356, 6061, 7075	≤ 150 Bhn or ≤ 7 HRc	130 (104-155)	RPM	41200	20600	13733	10300	
			Fz	0.0287	0.0573	0.0860	0.1147	
			Feed (mm/min)	1181	1181	1181	1181	
	COPPER ALLOYS Alum Bronze, C110, Muntz Brass	≤ 140 Bhn or ≤ 3 HRc	99 (79-119)	RPM	31506	15753	10502	7877
				Fz	0.0286	0.0572	0.0859	0.1145
				Feed (mm/min)	902	902	902	902

Note:

- Bhn (Brinell) HRc (Rockwell C) HRb (Rockwell B)
- rpm = (Vc x 1000) / (DC x 3.14)
- mm/min = Fr x rpm (Fr x maximum available rpm when recommendation exceeds machine limit)
- reduce speed and feed 30% when using uncoated drills
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