

Table with columns: Material group, Hardness (HRC, BHN), SFM, and Feed Rate - IPR (1/16 in, 1/8 in, 1/4 in, 3/8 in, 1/2 in, 5/8 in, 3/4 in, 1 in, 1 1/4 in, 1 1/2 in).

Table with columns: Material group, Hardness (HRC, BHN), SFM, and Feed Rate - IPR (1/16 in, 1/8 in, 1/4 in, 3/8 in, 1/2 in, 5/8 in, 3/4 in, 1 in, 1 1/4 in, 1 1/2 in).

Note: Pilot holes (depth >1xD) are recommended when drilling depths greater than 7xD. The pilot hole can be produced with a short, rigid drill. The diameter should be 0,01 - 0,02 mm larger than the diameter of the finish drill. Ratio drills can produce their own pilot hole by reducing speed and feed rates by 30-40%.