

Recommended Cutting Conditions

(inch)

Workpiece Material			Heat Resistant Alloys Inconel718 etc.		Titanium Alloys Ti-6Al-4V etc.	
DC		L/D	Cutting Speed vc (SFM)	Feed fr (Min.—Max.) (IPR)	Cutting Speed vc (SFM)	Feed fr (Min.—Max.) (IPR)
inch	mm					
.1181	3.000	≤ 5	30	.002 (.002—.004)	130	.003 (.002—.005)
.1575	4.000	≤ 5	30	.002 (.002—.004)	130	.004 (.003—.006)
.1969	5.000	≤ 5	40	.003 (.002—.005)	130	.005 (.003—.008)
.2362	6.000	≤ 5	50	.004 (.003—.006)	130	.006 (.004—.008)
.3150	8.000	≤ 5	50	.004 (.003—.006)	130	.007 (.006—.010)
.3937	10.000	≤ 5	60	.004 (.003—.006)	130	.009 (.007—.011)
.4724	12.000	≤ 5	65	.005 (.003—.006)	130	.009 (.008—.012)
.5512	14.000	≤ 5	65	.005 (.003—.006)	130	.009 (.008—.012)

Note 1) Spindle through & high pressure coolant system is recommended to make stable holes.

Note 2) Emulsion type of water-soluble coolant is recommended.

Note 3) In non water-insoluble coolant, reduce the cutting speed by 10%-20%.

Note 4) When drilling length of DCx1 or more with the use of external coolant system, step drilling is recommended in every DCx0.5 to encourage chips to break.