

RECOMMENDED CUTTING CONDITIONS

Tool	Work Material	Drill Diameter $\varnothing 3.0\text{--}\varnothing 6.0\text{ mm}$ $\varnothing .118\text{--}\varnothing .236\text{''}$		Drill Diameter $\varnothing 6.0\text{--}\varnothing 10.0\text{ mm}$ $\varnothing .240\text{--}\varnothing .394\text{''}$		Drill Diameter $\varnothing 10.0\text{--}\varnothing 16.0\text{ mm}$ $\varnothing .398\text{--}\varnothing .630\text{''}$	
		Cutting Speed (SFM)	Feed (IPR)	Cutting Speed (SFM)	Feed (IPR)	Cutting Speed (SFM)	Feed (IPR)
M A E	N Cast Aluminum Alloy	295 (130–460)	.006 (.002–.012)	330 (165–490)	.008 (.002–.012)	395 (195–560)	.010 (.004–.016)
	Die Cast Aluminum Alloy	330 (195–490)	.005 (.002–.010)	360 (230–525)	.006 (.002–.010)	425 (260–590)	.008 (.004–.012)
	K Gray Cast Iron	130 (65–195)	.006 (.004–.008)	195 (130–260)	.008 (.004–.012)	260 (195–330)	.012 (.008–.016)
	Ductile Cast Iron	100 (65–130)	.004 (.002–.006)	130 (65–195)	.005 (.002–.008)	195 (130–260)	.008 (.004–.012)
M A S	N Cast Aluminum Alloy	300 (195–490)	.006 (.002–.012)	390 (260–555)	.008 (.004–.012)	490 (330–655)	.010 (.004–.016)
	Die Cast Aluminum Alloy	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)