

Length	Diameter	WROUGHT ALUMINUM ALLOYS <12% Si 1000-8000 SERIES		High Silicon Aluminum Alloys >12% 4000 Series & Castings		Copper & Copper Alloys <190 BHN		Nylon, Plastics, Phenolics, Rubbers, Resins, Toolboard	
		N1 SFM	N1 IPR	N2 SFM	N2 IPR	N3 SFM	N3 IPR	N4 SFM	N4 IPR
3xD	.0625-.125	680	0.0023	400	0.0020	190	0.0010	200	0.0012
	.125-.250	680	0.0068	400	0.0053	190	0.0013	200	0.0025
	.250-.375	680	0.0110	400	0.0085	200	0.0016	225	0.0045
	.375-.500	680	0.0013	400	0.0110	200	0.0019	225	0.0055
	.500-.625	680	0.0160	400	0.0140	200	0.0022	225	0.0070
	.625 & above	680	0.0170	400	0.0150	200	0.0025	225	0.0085
5xD	.0625-.125	680	0.0023	400	0.0020	190	0.0010	200	0.0012
	.125-.250	680	0.0068	400	0.0053	190	0.0013	200	0.0025
	.250-.375	680	0.0110	400	0.0085	200	0.0016	225	0.0045
	.375-.500	680	0.0013	400	0.0110	200	0.0019	225	0.0055
	.500-.625	680	0.0160	400	0.0140	200	0.0220	225	0.0070
	.625 & above	680	0.0170	400	0.0150	200	0.0025	225	0.0085

USING A PECK CYCLE HELPS CHIP EVACUATION, & COOL THE TOOL TIP WHILE DRILLING MATERIALS WHICH HAVE A POOR CHIP FORMATION

SLOW THE FEEDRATE TO 50% WHEN BREAKING THROUGH THE MATERIAL WILL HELP TOOL LIFE