FXC SERIES

PRECISION CUTTING TOOLS
Member IMC Group

		Wrought Aluminum Alloys <12% Si 1000- 8000 Series		High Silicon Aluminum Alloys >12% 4000 Series & Castings		Copper & Copper Alloys <190 BHN	
Length	**Diameter**	**N1 SFM**	**N1 IPR**	**N2 SFM**	**N2 IPR**	**N3 SFM**	**N3 IPR**
5xD	0.1250 - 0.2500	1100	0.0120	900	0.0110	300	0.0020
	0.2500 - 0.3750	1100	0.0140	900	0.0150	300	0.0040
	0.3750-0.4687	1100	0.0200	900	0.0190	300	0.0050
	0.4687 - above	1100	0.0250	900	0.0230	300	0.0060
8xD	0.1250 - 0.2500	1100	0.0120	900	0.0110	300	0.0020
	0.2500 - 0.3750	1100	0.0140	900	0.0150	300	0.0040
	0.3750-0.4687	1100	0.0200	900	0.0190	300	0.0050
	0.4687 - above	1100	0.0250	900	0.0230	300	0.0030
12xD	0.1250 - 0.2500	900	0.0120	750	0.0110	250	0.0020
	0.2500 - 0.3750	900	0.0140	750	0.0150	250	0.0040
	0.3750-0.4687	900	0.0200	750	0.0190	250	0.0050
	0.4687 - above	900	0.0250	750	0.0230	250	0.0060
16xD	0.1250 - 0.2500	900	0.0120	750	0.0110	250	0.0020
	0.2500 - 0.3750	900	0.0140	750	0.0150	250	0.0040
	0.3750-0.4687	900	0.0200	750	0.0190	250	0.0050
	0.4687 - above	900	0.0250	750	0.0230	250	0.0060

The FXC drill works great in thin wall applications and extrusions
Using a G73 peck cycle helps chip evacuation in deep hole drilling and materials which have a poor chip formation
16xD should utilize a pilot hole drill (PCX Series)
TIR SFM and tool alignment with materials are the most important factors in deep hole drilling
Use high pressure coolant when deep hole drilling
Use low pressure coolant when drilling the pilot pole
Slow the feed rate to 50% when breaking through the material