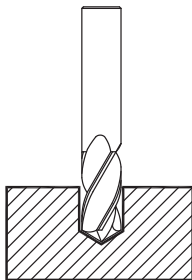
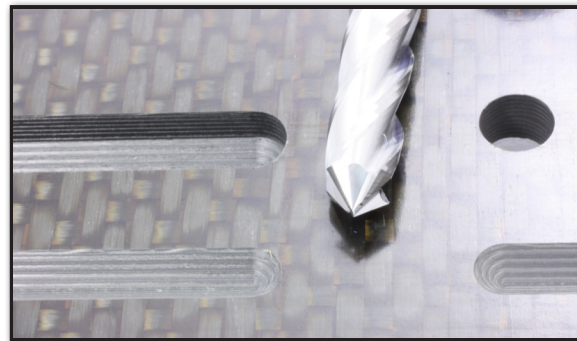


Speeds and Feeds for Drill Mills

Fractional

* Solids *

Type	Rc Hardness	SFM (Vc)	CHIPLOAD PER FLUTE (Fz)			
		152M, 152MA 154M, 154MA	1/8" - 1/4"	1/4" - 3/8"	3/8" - 1/2"	1/2" - 3/4"
STAINLESS STEELS						
13/8, 15/5, 17-4, pH Types	< 35	125 - 175	.0003" - .0008"	.0005" - .0010"	.0008" - .0020"	.0010" - .0030"
400 Series	< 35	125 - 175	.0003" - .0008"	.0005" - .0010"	.0008" - .0020"	.0010" - .0030"
HIGH STRENGTH TOOL STEELS						
4140, 4340, 6150, 5210, A2, D2, P20, H11, H13, S2, O1	< 30	125 - 200	.0003" - .0008"	.0005" - .0010"	.0008" - .0020"	.0010" - .0030"
	30 - 38	90 - 125	.0002" - .0004"	.0003" - .0005"	.0005" - .0015"	.0010" - .0020"
MEDIUM ALLOY TOOL STEELS						
200, 250, 300	< 35	150 - 225	.0005" - .0010"	.0007" - .0015"	.0010" - .0025"	.0015" - .0040"
CARBON STEELS						
A36, 1000's, 1100's, 1300's	< 35	150 - 250	.0005" - .0010"	.0007" - .0015"	.0010" - .0025"	.0015" - .0040"
CAST MATERIAL						
Steel		150 - 250	.0007" - .0015"	.0010" - .0020"	.0015" - .0030"	.0020" - .0040"
Aluminum		200 - 350	.0007" - .0015"	.0010" - .0020"	.0015" - .0030"	.0020" - .0040"
ALUMINUM						
Aircraft Grade (6061, 7075)		250 - 400	.0007" - .0015"	.0010" - .0020"	.0015" - .0030"	.0020" - .0040"
MAGNESIUM						
		250 - 400	.0007" - .0015"	.0010" - .0020"	.0015" - .0030"	.0020" - .0040"
COPPER						
Copper Alloys		250 - 350	.0005" - .0010"	.0007" - .0015"	.0010" - .0025"	.0015" - .0035"
BRASS, BRONZE						
Brass, Aluminum/Bronze, Low Silicon Bronze		250 - 350	.0005" - .0010"	.0007" - .0015"	.0010" - .0025"	.0015" - .0035"
COMPOSITE MATERIAL						
Glass Epoxy, Fiberglass, Plastics		250 - 450	.0007" - .0015"	.0010" - .0020"	.0015" - .0030"	.0020" - .0040"
Graphite, G10, Carbon Fiber		300 - 500	.0007" - .0015"	.0010" - .0020"	.0015" - .0030"	.0020" - .0040"



Slotting

DRILL MILL USES:

Solids - primarily for use in composites and plastics.

NOTE - ABOVE ARE STARTING PARAMETERS ONLY. HIGHER RESULTS MAY BE ACHIEVED WITH OPTIMUM CONDITIONS.