













# INCH

## INCH CARBIDE DRILLS

Material	Property	Vc : SFM Uncoated	Vc : SFM AlTiN	Feed : (ipt)				
				Ø0.0787"	Ø0.1575"	Ø0.3150"	Ø0.4724"	Ø0.6299"
	<70 ksi	330	330	0.00157	0.00236	0.00472	0.00669	0.00906
	<115 ksi	330	330	0.00157	0.00236	0.00472	0.00669	0.00906
	<145 ksi	260	260	0.00118	0.00157	0.00315	0.00512	0.00630
	<190 ksi	130	195	0.00079	0.00157	0.00276	0.00433	0.00630
	55HRC	20 ~ 35	25 ~ 40	0.00079	0.00118	0.00236	0.00276	0.00315
	68HRC	20 ~ 35	25 ~ 40	0.00079	0.00118	0.00236	0.00276	0.00315
	Ferritic	230	260	0.00118	0.00157	0.00315	0.00512	0.00630
	Martensitic	165	195	0.00118	0.00157	0.00315	0.00512	0.00630
	Austenitic	150	130	0.00118	0.00157	0.00315	0.00512	0.00630
	-	115	165	0.00079	0.00157	0.00276	0.00433	0.00630
	-	80	130	0.00079	0.00118	0.00236	0.00276	0.00315
	<130 ksi	115	165	0.00118	0.00157	0.00315	0.00512	0.00630
	>130 ksi	80	130	0.00157	0.00236	0.00472	0.00669	0.00906
	<8HRC	230	260	0.00236	0.00354	0.00787	0.00984	0.01378
	>8HRC	195	165	0.00197	0.00315	0.00472	0.00945	0.01102
	Silicon <10%	490	490	0.00197	0.00315	0.00472	0.00945	0.01102
	Silicon >10%	260	260	0.00197	0.00315	0.00472	0.00945	0.01102
	-	330	330	0.00236	0.00354	0.00787	0.00984	0.01378
	thermoplastic	330	330 ~ 655	0.00079	0.00157	0.00276	0.00433	0.00630
	thermoset	330	330 ~ 655	0.00079	0.00157	0.00276	0.00433	0.00630
	-	330	330 ~ 490	0.00079	0.00157	0.00276	0.00433	0.00630

DRILLS

END MILLS

ROUTERS

THREAD MILLS & TAPS

ENGRAVERS

BORING BARS

REAMERS

SAWS

TECHNICAL

INDEX