










INCH

INCH CARBIDE CENTER DRILLS

Material	Property	Vc : SFM Uncoated	Vc : SFM AlTiN	Feed : (ipt)				
				Ø < 0.0787"	Ø < 0.1181"	Ø < 0.2362"	Ø < 0.3937"	Ø < 0.6299"
	<70 ksi	230 ~ 260	260 ~ 295	0.0039	0.0047	0.0087	0.0130	0.0177
	<115 ksi	195 ~ 245	230 ~ 295	0.0039	0.0047	0.0087	0.0130	0.0177
	<145 ksi	165 ~ 195	195 ~ 230	0.0028	0.0031	0.0059	0.0091	0.0122
	<190 ksi	80 ~ 130	100 ~ 165	0.0024	0.0028	0.0051	0.0079	0.0106
	-	65 ~ 100	100 ~ 130	0.0024	0.0031	0.0059	0.0079	0.0118
	-	65 ~ 80	100 ~ 130	0.0197	0.0276	0.0051	0.0071	0.0106
	<130 ksi	65 ~ 100	100 ~ 130	0.0024	0.0031	0.0059	0.0079	0.0118
	>130 ksi							
	<8HRC	165 ~ 195	195 ~ 230	0.0039	0.0047	0.0087	0.0130	0.0177
	>8HRC	115 ~ 165	130 ~ 195	0.0031	0.0039	0.0067	0.0118	0.0157
	Silicon <10%	330 ~ 490	330 ~ 495	0.0047	0.0059	0.0079	0.0098	0.0157
	Silicon >10%	230 ~ 295	230 ~ 295	0.0047	0.0059	0.0079	0.0098	0.0157
	-	230 ~ 295	230 ~ 295	0.0047	0.0059	0.0079	0.0098	0.0157
	-	490 ~ 655	490 ~ 655	0.0051	0.0059	0.0098	0.0157	0.0197

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