












# INCH

(Specials)

## INCH CARBIDE CHAMFERING DRILLS

Material	Property	Vc : SFM Uncoated	Vc : SFM AlTiN	Feed : (ipt)							
				Ø0.0787"	Ø0.1575"	Ø0.2362"	Ø0.3150"	Ø0.3937"	Ø0.4724"	Ø0.6299"	Ø0.7874"
	<70 ksi	230	245	0.00098	0.00197	0.00315	0.00551	0.00551	0.00748	0.00945	0.01102
	<115 ksi	130	195	0.00098	0.00197	0.00315	0.00551	0.00551	0.00748	0.00945	0.01102
	<145 ksi	115	130	0.00091	0.00177	0.00276	0.00472	0.00472	0.00709	0.00866	0.01102
	<190 ksi	100	115	0.00091	0.00177	0.00276	0.00472	0.00669	0.00669	0.00866	0.01024
	55HRC	80	100	0.00079	0.00157	0.00236	0.00433	0.00433	0.00630	0.00866	0.00984
	68HRC	80	100	0.00079	0.00157	0.00236	0.00433	0.00433	0.00630	0.00866	0.00984
	Ferritic	80	100	0.00091	0.00177	0.00276	0.00472	0.00669	0.00669	0.00866	0.01024
	Austenitic	80	100	0.00079	0.00157	0.00236	0.00433	0.00433	0.00630	0.00866	0.00984
	-	65	80	0.00079	0.00157	0.00236	0.00433	0.00433	0.00630	0.00866	0.00984
	<130 ksi	80	100	0.00079	0.00157	0.00236	0.00433	0.00433	0.00630	0.00866	0.00984
	>130 ksi										
	<8HRC	115	130	0.00091	0.00177	0.00276	0.00472	0.00472	0.00709	0.00866	0.01102
	>8HRC	100	115								
	-	490	655	0.00098	0.00197	0.00354	0.00591	0.00787	0.00787	0.01063	0.01378
	-	260	395	0.00197	0.00394	0.00591	0.00984	0.01181	0.01181	0.01378	0.01772
	-	490	-	0.00098	0.00197	0.00354	0.00591	0.00787	0.00787	0.01063	0.01378

DRILLS

END MILLS

ROUTERS

THREAD MILLS & TAPS

ENGRAVERS

BORING BARS

REAMERS

SAWS

TECHNICAL

INDEX