







INCH

INCH CARBIDE COOLANT MICRO DRILLS

Material	Property	Vc : SFM Uncoated	Vc : SFM AlTiN	Feed : (ipt)				
				Ø < 0.0394"	Ø < 0.0591"	Ø < 0.0787"	Ø < 0.0984"	Ø < 0.1181"
	<70 ksi	65 ~ 165	80 ~ 260	0.0008 ~ 0.0016	0.0008 ~ 0.0016	0.0012 ~ 0.0024	0.0016 ~ 0.0031	0.0016 ~ 0.0031
	<115 ksi							
	<145 ksi	50 ~ 115	80 ~ 260	0.0008 ~ 0.0016	0.0008 ~ 0.0016	0.0012 ~ 0.0024	0.0016 ~ 0.0031	0.0016 ~ 0.0031
	<190 ksi	35 ~ 80	65 ~ 150	0.0008 ~ 0.0016	0.0008 ~ 0.0016	0.0012 ~ 0.0020	0.0016 ~ 0.0024	0.0016 ~ 0.0024
	-	50 ~ 130	50 ~ 115	0.0004 ~ 0.0008	0.0004 ~ 0.0008	0.0008 ~ 0.0016	0.0012 ~ 0.0024	0.0012 ~ 0.0024
		35 ~ 80						
	<130 ksi	15 ~ 35	50 ~ 115	0.0004 ~ 0.0008	0.0004 ~ 0.0008	0.0008 ~ 0.0016	0.0012 ~ 0.0024	0.0012 ~ 0.0024
	>130 ksi							
	<8HRC	80 ~ 215	100 ~ 295	0.0008 ~ 0.0039	0.0008 ~ 0.0039	0.0012 ~ 0.0024	0.0016 ~ 0.0035	0.0016 ~ 0.0035
	>8HRC	80 ~ 195	80 ~ 260	0.0039 ~ 0.0059	0.0039 ~ 0.0059	0.0059 ~ 0.0098	0.0079 ~ 0.0118	0.0079 ~ 0.0118
Aluminum	165 ~ 490							
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	Silicon <12%	150 ~ 360	165 ~ 655	0.0012 ~ 0.0024	0.0012 ~ 0.0024	0.0016 ~ 0.0028	0.0028 ~ 0.0047	0.0028 ~ 0.0047
	Silicon >12%	150 ~ 360	165 ~ 655	0.0008 ~ 0.0024	0.0008 ~ 0.0024	0.0012 ~ 0.0028	0.0016 ~ 0.0039	0.0016 ~ 0.0039

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