







INCH

INCH CARBIDE HIGH PERFORMANCE COOLANT MICRO DRILLS

Material	Property	Vc : SFM AITiN	Feed : (ipt)				
			Ø0.1575"	Ø0.03150"	Ø0.4724"	Ø0.6299"	Ø0.7874"
	<70 ksi	360	0.0047	0.0059	0.0110	0.0134	0.0161
	<115 ksi	330	0.0071	0.0098	0.0138	0.0150	0.0161
	<145 ksi	260	0.0063	0.0087	0.0122	0.0134	0.0146
	<190 ksi	215	0.0063	0.0087	0.0122	0.0134	0.0146
	-	200	0.0039	0.0051	0.0075	0.0087	0.0098
	-	80	0.0039	0.0051	0.0075	0.0087	0.0098
	<130 ksi	100	0.0031	0.0043	0.0063	0.0071	0.0079
	>130 ksi						
	<8HRC	295	0.0071	0.0087	0.0138	0.0150	0.0161
	>8HRC	260	0.0063	0.0098	0.0122	0.0134	0.0146

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