

## Drilling Feed & Speed Chart for

### GETEKÒ PCB Material

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**Recommended Tycom Drill Series: Series 100, 150, 450, 460, 475, 480**

(Note: Chart is based on 120K RPM Spindle Capability. Please use maximum spindle speed if listed RPM is unattainable)

| Size   | Diameter | Feed         | Speed   | Retract      | Z-Axis Offset | Max Hits | Chipload   | SFM |
|--------|----------|--------------|---------|--------------|---------------|----------|------------|-----|
|        | (inch)   | (Inches/min) | (k-rpm) | (inches/min) | (inches)      |          | (mils/rev) |     |
| 0.10mm | 0.0040   | 25           | 120     | 200          | -0.011        | 500      | 0.21       | 126 |
| 0.13mm | 0.0050   | 26           | 120     | 300          | -0.011        | 500      | 0.22       | 157 |
| 0.15mm | 0.0059   | 30           | 120     | 300          | -0.011        | 500      | 0.25       | 185 |
| #96    | 0.0063   | 34           | 120     | 400          | -0.011        | 500      | 0.28       | 198 |
| #95    | 0.0067   | 38           | 120     | 400          | -0.012        | 500      | 0.32       | 210 |
| #94    | 0.0071   | 42           | 120     | 500          | -0.012        | 500      | 0.35       | 223 |
| #93    | 0.0075   | 46           | 120     | 500          | -0.012        | 500      | 0.38       | 236 |
| #92    | 0.0079   | 50           | 120     | 500          | -0.012        | 500      | 0.42       | 248 |
| #91    | 0.0083   | 54           | 120     | 600          | -0.012        | 500      | 0.45       | 261 |
| #90    | 0.0087   | 58           | 120     | 600          | -0.012        | 500      | 0.48       | 273 |
| #89    | 0.0091   | 62           | 120     | 700          | -0.012        | 500      | 0.52       | 286 |
| #88    | 0.0095   | 66           | 120     | 700          | -0.012        | 500      | 0.55       | 298 |
| 0.25mm | 0.0098   | 68           | 120     | 800          | -0.012        | 500      | 0.57       | 308 |
| #87    | 0.0100   | 70           | 120     | 800          | -0.012        | 500      | 0.58       | 314 |
| #86    | 0.0105   | 74           | 120     | 800          | -0.012        | 500      | 0.62       | 330 |
| #85    | 0.0110   | 78           | 120     | 900          | -0.013        | 650      | 0.65       | 345 |
| #84    | 0.0115   | 82           | 120     | 900          | -0.013        | 650      | 0.68       | 361 |
| 0.30mm | 0.0118   | 84           | 120     | 1000         | -0.013        | 650      | 0.70       | 371 |
| #83    | 0.0120   | 86           | 120     | 1000         | -0.013        | 650      | 0.72       | 377 |
| #82    | 0.0125   | 90           | 120     | 1000         | -0.013        | 650      | 0.75       | 393 |
| #81    | 0.0130   | 94           | 120     | 1000         | -0.013        | 650      | 0.78       | 408 |
| #80    | 0.0135   | 96           | 117     | 1000         | -0.013        | 800      | 0.82       | 415 |
| 0.35mm | 0.0138   | 98           | 115     | 1000         | -0.013        | 800      | 0.85       | 415 |
| #79    | 0.0145   | 100          | 109     | 1000         | -0.013        | 800      | 0.92       | 415 |
| 1/64   | 0.0156   | 105          | 102     | 1000         | -0.014        | 800      | 1.03       | 415 |
| 0.40mm | 0.0158   | 106          | 100     | 1000         | -0.014        | 800      | 1.06       | 415 |
| #78    | 0.0160   | 108          | 99      | 1000         | -0.014        | 800      | 1.09       | 415 |
| 0.45mm | 0.0177   | 110          | 90      | 1000         | -0.014        | 800      | 1.22       | 415 |
| #77    | 0.0180   | 111          | 88      | 1000         | -0.014        | 800      | 1.26       | 415 |
| 0.50mm | 0.0197   | 115          | 81      | 1000         | -0.015        | 1000     | 1.42       | 415 |
| #76    | 0.0200   | 116          | 79      | 1000         | -0.015        | 1000     | 1.47       | 415 |
| #75    | 0.0210   | 120          | 76      | 1000         | -0.015        | 1000     | 1.58       | 415 |
| 0.55mm | 0.0217   | 122          | 73      | 1000         | -0.015        | 1000     | 1.67       | 415 |
| #74    | 0.0225   | 124          | 70      | 1000         | -0.015        | 1000     | 1.77       | 415 |
| 0.60mm | 0.0236   | 126          | 67      | 1000         | -0.016        | 1000     | 1.88       | 415 |
| #73    | 0.0240   | 127          | 66      | 1000         | -0.016        | 1000     | 1.92       | 415 |

| Size   | Diameter | Feed         | Speed   | Retract      | Z-Axis Offset | Hits | Chipload   | SFM |
|--------|----------|--------------|---------|--------------|---------------|------|------------|-----|
|        | (inch)   | (Inches/min) | (k-rpm) | (inches/min) | (inches)      |      | (mils/rev) |     |
| #72    | 0.0250   | 128          | 63      | 1000         | -0.016        | 1000 | 2.03       | 415 |
| 0.65mm | 0.0256   | 128          | 62      | 1000         | -0.016        | 1000 | 2.06       | 415 |
| #71    | 0.0260   | 129          | 61      | 1000         | -0.016        | 1000 | 2.11       | 415 |
| 0.70mm | 0.0276   | 130          | 57      | 1000         | -0.016        | 1000 | 2.28       | 415 |
| #70    | 0.0280   | 130          | 57      | 1000         | -0.017        | 1000 | 2.28       | 415 |
| #69    | 0.0292   | 130          | 54      | 1000         | -0.017        | 1000 | 2.41       | 415 |
| 0.75mm | 0.0295   | 129          | 54      | 1000         | -0.017        | 1000 | 2.39       | 415 |
| #68    | 0.0310   | 128          | 51      | 1000         | -0.017        | 1000 | 2.51       | 415 |
| 1/32   | 0.0312   | 128          | 51      | 1000         | -0.017        | 1000 | 2.51       | 415 |
| 0.80mm | 0.0315   | 128          | 50      | 1000         | -0.017        | 1000 | 2.56       | 415 |
| #67    | 0.0320   | 127          | 50      | 1000         | -0.017        | 1000 | 2.54       | 415 |
| #66    | 0.0330   | 125          | 48      | 1000         | -0.018        | 1000 | 2.60       | 415 |
| 0.85mm | 0.0335   | 124          | 47      | 1000         | -0.018        | 1000 | 2.64       | 415 |
| #65    | 0.0350   | 122          | 45      | 1000         | -0.018        | 1000 | 2.71       | 415 |
| 0.90mm | 0.0354   | 122          | 45      | 1000         | -0.018        | 1000 | 2.71       | 415 |
| #64    | 0.0360   | 121          | 44      | 1000         | -0.018        | 1000 | 2.75       | 415 |
| #63    | 0.0370   | 120          | 43      | 1000         | -0.019        | 1000 | 2.79       | 415 |
| 0.95mm | 0.0374   | 120          | 42      | 1000         | -0.019        | 1000 | 2.86       | 415 |
| #62    | 0.0380   | 119          | 42      | 1000         | -0.019        | 1000 | 2.83       | 415 |
| #61    | 0.0390   | 118          | 41      | 1000         | -0.019        | 1000 | 2.88       | 415 |
| 1.00mm | 0.0394   | 118          | 40      | 1000         | -0.019        | 1000 | 2.95       | 415 |
| #60    | 0.0400   | 116          | 40      | 1000         | -0.019        | 1000 | 2.90       | 415 |
| #59    | 0.0410   | 115          | 39      | 1000         | -0.020        | 1000 | 2.95       | 415 |
| 1.05mm | 0.0413   | 114          | 38      | 1000         | -0.020        | 1000 | 3.00       | 415 |
| #58    | 0.0420   | 113          | 38      | 1000         | -0.020        | 1000 | 3.00       | 415 |
| #57    | 0.0430   | 111          | 37      | 1000         | -0.020        | 1000 | 3.00       | 415 |
| 1.10mm | 0.0433   | 111          | 37      | 1000         | -0.020        | 1000 | 3.00       | 415 |
| 1.15mm | 0.0453   | 108          | 35      | 1000         | -0.021        | 1000 | 3.00       | 415 |
| #56    | 0.0465   | 105          | 34      | 1000         | -0.021        | 1000 | 3.00       | 415 |
| 3/64   | 0.0469   | 102          | 34      | 1000         | -0.021        | 1000 | 3.00       | 415 |
| 1.20mm | 0.0472   | 102          | 34      | 1000         | -0.021        | 1000 | 3.00       | 415 |
| 1.25mm | 0.0492   | 96           | 32      | 1000         | -0.021        | 800  | 3.00       | 415 |
| 1.30mm | 0.0512   | 93           | 31      | 1000         | -0.022        | 800  | 3.00       | 415 |
| #55    | 0.0520   | 90           | 30      | 1000         | -0.022        | 800  | 3.00       | 415 |
| 1.35mm | 0.0531   | 90           | 30      | 1000         | -0.022        | 800  | 3.00       | 415 |
| #54    | 0.0550   | 87           | 29      | 1000         | -0.023        | 800  | 3.00       | 415 |
| 1.40mm | 0.0551   | 87           | 29      | 1000         | -0.023        | 800  | 3.00       | 415 |
| 1.45mm | 0.0571   | 84           | 28      | 1000         | -0.023        | 800  | 3.00       | 415 |
| 1.50mm | 0.0591   | 81           | 27      | 1000         | -0.024        | 800  | 3.00       | 415 |
| #53    | 0.0595   | 81           | 27      | 1000         | -0.024        | 800  | 3.00       | 415 |
| 1.55mm | 0.0610   | 78           | 26      | 1000         | -0.024        | 800  | 3.00       | 415 |
| 1/16   | 0.0625   | 75           | 25      | 1000         | -0.025        | 800  | 3.00       | 415 |
| 1.60mm | 0.0630   | 75           | 25      | 1000         | -0.025        | 800  | 3.00       | 415 |
| #52    | 0.0635   | 75           | 25      | 1000         | -0.025        | 800  | 3.00       | 415 |
| 1.65mm | 0.0650   | 72           | 24      | 1000         | -0.025        | 800  | 3.00       | 415 |
| 1.70mm | 0.0669   | 72           | 24      | 1000         | -0.026        | 800  | 3.00       | 415 |
| #51    | 0.0670   | 72           | 24      | 1000         | -0.026        | 800  | 3.00       | 415 |
| 1.75mm | 0.0689   | 69           | 23      | 1000         | -0.026        | 800  | 3.00       | 415 |
|        |          |              |         |              |               |      |            |     |

| Size   | Diameter | Feed         | Speed   | Retract      | Z-Axis Offset | Hits | Chipload   | SFM |
|--------|----------|--------------|---------|--------------|---------------|------|------------|-----|
|        | (inch)   | (Inches/min) | (k-rpm) | (inches/min) | (inches)      |      | (mils/rev) |     |
| #50    | 0.0700   | 69           | 23      | 1000         | -0.026        | 800  | 3.00       | 415 |
| 1.80mm | 0.0709   | 66           | 22      | 1000         | -0.027        | 650  | 3.00       | 415 |
| 1.85mm | 0.0728   | 66           | 22      | 1000         | -0.027        | 650  | 3.00       | 415 |
| #49    | 0.0730   | 66           | 22      | 1000         | -0.027        | 650  | 3.00       | 415 |
| 1.90mm | 0.0748   | 63           | 21      | 1000         | -0.027        | 650  | 3.00       | 415 |
| #48    | 0.0760   | 63           | 21      | 1000         | -0.028        | 650  | 3.00       | 415 |
| 1.95mm | 0.0768   | 63           | 21      | 1000         | -0.028        | 650  | 3.00       | 415 |
| 5/64   | 0.0781   | 60           | 20      | 1000         | -0.028        | 650  | 3.00       | 415 |
| #47    | 0.0785   | 60           | 20      | 1000         | -0.028        | 650  | 3.00       | 415 |
| 2.00mm | 0.0787   | 60           | 20      | 1000         | -0.028        | 650  | 3.00       | 415 |
| 2.05mm | 0.0807   | 60           | 20      | 1000         | -0.029        | 650  | 3.00       | 422 |
| #46    | 0.0810   | 60           | 20      | 1000         | -0.029        | 650  | 3.00       | 424 |
| #45    | 0.0820   | 60           | 20      | 1000         | -0.029        | 650  | 3.00       | 429 |
| 2.10mm | 0.0827   | 60           | 20      | 1000         | -0.029        | 650  | 3.00       | 433 |
| 2.15mm | 0.0846   | 60           | 20      | 1000         | -0.030        | 650  | 3.00       | 443 |
| #44    | 0.0860   | 60           | 20      | 1000         | -0.030        | 650  | 3.00       | 450 |
| 2.20mm | 0.0866   | 60           | 20      | 1000         | -0.030        | 650  | 3.00       | 453 |
| 2.25mm | 0.0886   | 60           | 20      | 1000         | -0.031        | 650  | 3.00       | 464 |
| #43    | 0.0890   | 60           | 20      | 1000         | -0.031        | 650  | 3.00       | 466 |
| 2.30mm | 0.0906   | 60           | 20      | 1000         | -0.031        | 500  | 3.00       | 474 |
| 2.35mm | 0.0925   | 60           | 20      | 1000         | -0.032        | 500  | 3.00       | 484 |
| #42    | 0.0935   | 60           | 20      | 1000         | -0.032        | 500  | 3.00       | 489 |
| 3/32   | 0.0938   | 60           | 20      | 1000         | -0.032        | 500  | 3.00       | 491 |
| 2.40mm | 0.0945   | 60           | 20      | 1000         | -0.032        | 500  | 3.00       | 495 |
| #41    | 0.0960   | 60           | 20      | 1000         | -0.032        | 500  | 3.00       | 502 |
| 2.45mm | 0.0965   | 60           | 20      | 1000         | -0.033        | 500  | 3.00       | 505 |
| #40    | 0.0980   | 60           | 20      | 1000         | -0.033        | 500  | 3.00       | 513 |
| 2.50mm | 0.0984   | 60           | 20      | 1000         | -0.033        | 500  | 3.00       | 515 |
| #39    | 0.0995   | 60           | 20      | 1000         | -0.033        | 500  | 3.00       | 521 |
| 2.55mm | 0.1004   | 60           | 20      | 1000         | -0.033        | 500  | 3.00       | 525 |
| #38    | 0.1015   | 60           | 20      | 1000         | -0.034        | 500  | 3.00       | 531 |
| 2.60mm | 0.1024   | 60           | 20      | 1000         | -0.034        | 500  | 3.00       | 536 |
| #37    | 0.1040   | 60           | 20      | 1000         | -0.034        | 500  | 3.00       | 544 |
| 2.65mm | 0.1043   | 60           | 20      | 1000         | -0.034        | 500  | 3.00       | 546 |
| 2.70mm | 0.1063   | 60           | 20      | 1000         | -0.035        | 500  | 3.00       | 556 |
| #36    | 0.1065   | 60           | 20      | 1000         | -0.035        | 500  | 3.00       | 557 |
| 2.75mm | 0.1083   | 60           | 20      | 1000         | -0.035        | 500  | 3.00       | 567 |
| 7/64   | 0.1094   | 60           | 20      | 1000         | -0.036        | 500  | 3.00       | 573 |
| #35    | 0.1100   | 60           | 20      | 1000         | -0.036        | 500  | 3.00       | 576 |
| 2.80mm | 0.1102   | 60           | 20      | 1000         | -0.036        | 500  | 3.00       | 577 |
| #34    | 0.1110   | 60           | 20      | 1000         | -0.036        | 500  | 3.00       | 581 |
| 2.85mm | 0.1122   | 60           | 20      | 1000         | -0.036        | 500  | 3.00       | 587 |
| #33    | 0.1130   | 60           | 20      | 1000         | -0.036        | 500  | 3.00       | 591 |
| 2.90mm | 0.1142   | 60           | 20      | 1000         | -0.037        | 500  | 3.00       | 598 |
| #32    | 0.1160   | 60           | 20      | 1000         | -0.037        | 500  | 3.00       | 607 |
| 2.95mm | 0.1161   | 60           | 20      | 1000         | -0.037        | 500  | 3.00       | 608 |
| 3.00mm | 0.1181   | 60           | 20      | 1000         | -0.038        | 500  | 3.00       | 618 |
| #31    | 0.1200   | 60           | 20      | 1000         | -0.038        | 500  | 3.00       | 628 |
|        |          |              |         |              |               |      |            |     |

| Size   | Diameter | Feed         | Speed   | Retract      | Z-Axis Offset | Hits | Chipload   | SFM |
|--------|----------|--------------|---------|--------------|---------------|------|------------|-----|
|        | (inch)   | (Inches/min) | (k-rpm) | (inches/min) | (inches)      |      | (mils/rev) |     |
| 3.05mm | 0.1201   | 60           | 20      | 1000         | -0.038        | 500  | 3.00       | 629 |
| 3.10mm | 0.1220   | 60           | 20      | 1000         | -0.038        | 500  | 3.00       | 638 |
| 3.15mm | 0.1240   | 60           | 20      | 1000         | -0.039        | 500  | 3.00       | 649 |
| 1/8    | 0.1250   | 60           | 20      | 1000         | -0.039        | 500  | 3.00       | 654 |
| 3.20mm | 0.1260   | 50           | 20      | 1000         | -0.018        | 400  | 2.50       | 659 |
| 3.25mm | 0.1280   | 50           | 20      | 1000         | -0.018        | 400  | 2.50       | 670 |
| #30    | 0.1285   | 50           | 20      | 1000         | -0.019        | 400  | 2.50       | 672 |
| 3.30mm | 0.1299   | 50           | 20      | 1000         | -0.019        | 400  | 2.50       | 680 |
| 3.35mm | 0.1319   | 50           | 20      | 1000         | -0.019        | 400  | 2.50       | 690 |
| 3.40mm | 0.1339   | 50           | 20      | 1000         | -0.019        | 400  | 2.50       | 701 |
| 3.45mm | 0.1358   | 50           | 20      | 1000         | -0.019        | 400  | 2.50       | 711 |
| #29    | 0.1360   | 50           | 20      | 1000         | -0.019        | 400  | 2.50       | 712 |
| 3.50mm | 0.1378   | 50           | 20      | 1000         | -0.019        | 400  | 2.50       | 721 |
| 3.55mm | 0.1398   | 50           | 20      | 1000         | -0.019        | 400  | 2.50       | 732 |
| #28    | 0.1405   | 50           | 20      | 1000         | -0.019        | 400  | 2.50       | 735 |
| 9/64   | 0.1406   | 50           | 20      | 1000         | -0.019        | 400  | 2.50       | 736 |
| 3.60mm | 0.1417   | 50           | 20      | 1000         | -0.019        | 400  | 2.50       | 742 |
| 3.65mm | 0.1437   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 752 |
| #27    | 0.1440   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 754 |
| 3.70mm | 0.1457   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 762 |
| #26    | 0.1470   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 769 |
| 3.75mm | 0.1476   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 772 |
| #25    | 0.1495   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 782 |
| 3.80mm | 0.1496   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 783 |
| 3.85mm | 0.1516   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 793 |
| #24    | 0.1520   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 795 |
| 3.90mm | 0.1535   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 803 |
| #23    | 0.1540   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 806 |
| 3.95   | 0.1555   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 814 |
| 5/32   | 0.1562   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 817 |
| #22    | 0.1570   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 822 |
| 4.00mm | 0.1575   | 50           | 20      | 1000         | -0.020        | 400  | 2.50       | 824 |
| #21    | 0.1590   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 832 |
| 4.05mm | 0.1594   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 834 |
| #20    | 0.1610   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 843 |
| 4.10mm | 0.1614   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 845 |
| 4.15mm | 0.1634   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 855 |
| 4.20mm | 0.1654   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 866 |
| #19    | 0.1660   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 869 |
| 4.25mm | 0.1673   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 876 |
| 4.30mm | 0.1693   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 886 |
| #18    | 0.1695   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 887 |
| 4.35mm | 0.1713   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 896 |
| 11/64  | 0.1719   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 900 |
| #17    | 0.1730   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 905 |
| 4.40mm | 0.1732   | 40           | 20      | 1000         | -0.021        | 250  | 2.00       | 906 |
| 4.45mm | 0.1752   | 40           | 20      | 1000         | -0.022        | 250  | 2.00       | 917 |
| #16    | 0.1770   | 40           | 20      | 1000         | -0.022        | 250  | 2.00       | 926 |
|        |          |              |         |              |               |      |            |     |

| Size   | Diameter | Feed         | Speed   | Retract      | Z-Axis Offset | Hits | Chipload   | SFM  |
|--------|----------|--------------|---------|--------------|---------------|------|------------|------|
|        | (inch)   | (Inches/min) | (k-rpm) | (inches/min) | (inches)      |      | (mils/rev) |      |
| 4.50mm | 0.1772   | 40           | 20      | 1000         | -0.022        | 250  | 2.00       | 927  |
| 4.55mm | 0.1792   | 40           | 20      | 1000         | -0.022        | 250  | 2.00       | 938  |
| #15    | 0.1800   | 40           | 20      | 1000         | -0.022        | 250  | 2.00       | 942  |
| 4.60mm | 0.1811   | 40           | 20      | 1000         | -0.022        | 250  | 2.00       | 948  |
| #14    | 0.1820   | 40           | 20      | 1000         | -0.022        | 250  | 2.00       | 952  |
| 4.65mm | 0.1831   | 40           | 20      | 1000         | -0.022        | 250  | 2.00       | 958  |
| #13    | 0.1850   | 40           | 20      | 1000         | -0.022        | 250  | 2.00       | 968  |
| 4.70mm | 0.1850   | 40           | 20      | 1000         | -0.022        | 250  | 2.00       | 968  |
| 4.75mm | 0.1870   | 40           | 20      | 1000         | -0.022        | 250  | 2.00       | 979  |
| 3/16   | 0.1875   | 40           | 20      | 1000         | -0.022        | 250  | 2.00       | 981  |
| 4.80mm | 0.1890   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 989  |
| #12    | 0.1890   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 989  |
| 4.85mm | 0.1909   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 999  |
| #11    | 0.1910   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 1000 |
| 4.90mm | 0.1929   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 1010 |
| #10    | 0.1935   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 1013 |
| 4.95mm | 0.1949   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 1020 |
| #9     | 0.1960   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 1026 |
| 5.00mm | 0.1968   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 1030 |
| 5.05mm | 0.1988   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 1040 |
| #8     | 0.1990   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 1041 |
| 5.10mm | 0.2008   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 1051 |
| #7     | 0.2010   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 1052 |
| 5.15mm | 0.2028   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 1061 |
| 13/64  | 0.2031   | 30           | 20      | 1000         | -0.023        | 200  | 1.50       | 1063 |
| #6     | 0.2040   | 30           | 20      | 1000         | -0.024        | 200  | 1.50       | 1068 |
| 5.20mm | 0.2047   | 30           | 20      | 1000         | -0.024        | 200  | 1.50       | 1071 |
| #5     | 0.2055   | 30           | 20      | 1000         | -0.024        | 200  | 1.50       | 1075 |
| 5.25mm | 0.2067   | 30           | 20      | 1000         | -0.024        | 200  | 1.50       | 1082 |
| 5.30mm | 0.2087   | 30           | 20      | 1000         | -0.024        | 200  | 1.50       | 1092 |
| #4     | 0.2090   | 30           | 20      | 1000         | -0.024        | 200  | 1.50       | 1094 |
| 5.35mm | 0.2106   | 30           | 20      | 1000         | -0.024        | 200  | 1.50       | 1102 |
| 5.40mm | 0.2126   | 30           | 20      | 1000         | -0.024        | 200  | 1.50       | 1113 |
| #3     | 0.2130   | 30           | 20      | 1000         | -0.024        | 200  | 1.50       | 1115 |
| 5.45mm | 0.2146   | 30           | 20      | 1000         | -0.024        | 200  | 1.50       | 1123 |
| 5.50mm | 0.2165   | 30           | 20      | 1000         | -0.024        | 200  | 1.50       | 1133 |
| 5.55mm | 0.2185   | 30           | 20      | 1000         | -0.024        | 200  | 1.50       | 1143 |
| 7/32   | 0.2188   | 30           | 20      | 1000         | -0.024        | 200  | 1.50       | 1145 |
| 5.60mm | 0.2205   | 30           | 20      | 1000         | -0.025        | 200  | 1.50       | 1154 |
| #2     | 0.2210   | 30           | 20      | 1000         | -0.025        | 200  | 1.50       | 1157 |
| 5.65mm | 0.2224   | 30           | 20      | 1000         | -0.025        | 150  | 1.50       | 1164 |
| 5.70mm | 0.2244   | 30           | 20      | 1000         | -0.025        | 150  | 1.50       | 1174 |
| 5.75mm | 0.2264   | 30           | 20      | 1000         | -0.025        | 150  | 1.50       | 1185 |
| #1     | 0.2280   | 30           | 20      | 1000         | -0.025        | 150  | 1.50       | 1193 |
| 5.80mm | 0.2283   | 30           | 20      | 1000         | -0.025        | 150  | 1.50       | 1195 |
| 5.85mm | 0.2302   | 30           | 20      | 1000         | -0.025        | 150  | 1.50       | 1205 |
| 5.90mm | 0.2323   | 30           | 20      | 1000         | -0.025        | 150  | 1.50       | 1216 |
| A      | 0.2340   | 30           | 20      | 1000         | -0.025        | 150  | 1.50       | 1225 |
|        |          |              |         |              |               |      |            |      |

| Size   | Diameter | Feed         | Speed   | Retract      | Z-Axis Offset | Hits | Chipload   | SFM  |
|--------|----------|--------------|---------|--------------|---------------|------|------------|------|
|        | (inch)   | (Inches/min) | (k-rpm) | (inches/min) | (inches)      |      | (mils/rev) |      |
| 5.95mm | 0.2343   | 30           | 20      | 1000         | -0.026        | 150  | 1.50       | 1226 |
| 15/64  | 0.2344   | 30           | 20      | 1000         | -0.026        | 150  | 1.50       | 1227 |
| 6.00mm | 0.2362   | 30           | 20      | 1000         | -0.026        | 150  | 1.50       | 1236 |
| B      | 0.2380   | 30           | 20      | 1000         | -0.026        | 150  | 1.50       | 1246 |
| 6.05mm | 0.2382   | 30           | 20      | 1000         | -0.026        | 150  | 1.50       | 1247 |
| 6.10mm | 0.2402   | 30           | 20      | 1000         | -0.026        | 150  | 1.50       | 1257 |
| C      | 0.2420   | 30           | 20      | 1000         | -0.026        | 150  | 1.50       | 1266 |
| 6.15mm | 0.2421   | 30           | 20      | 1000         | -0.026        | 150  | 1.50       | 1267 |
| 6.20mm | 0.2441   | 30           | 20      | 1000         | -0.026        | 150  | 1.50       | 1277 |
| D      | 0.2460   | 30           | 20      | 1000         | -0.026        | 150  | 1.50       | 1287 |
| 6.25mm | 0.2461   | 30           | 20      | 1000         | -0.026        | 150  | 1.50       | 1288 |
| 6.30mm | 0.2480   | 30           | 20      | 1000         | -0.026        | 150  | 1.50       | 1298 |
| 6.35mm | 0.2500   | 30           | 20      | 1000         | -0.027        | 150  | 1.50       | 1308 |
| 6.40mm | 0.2520   | 30           | 20      | 1000         | -0.027        | 150  | 1.50       | 1319 |
| 6.50mm | 0.2559   | 30           | 20      | 1000         | -0.027        | 150  | 1.50       | 1339 |
| F      | 0.2570   | 30           | 20      | 1000         | -0.027        | 150  | 1.50       | 1345 |
| 6.60mm | 0.2598   | 30           | 20      | 1000         | -0.027        | 150  | 1.50       | 1360 |
|        |          |              |         |              |               |      |            |      |

In some cases, there may be an opportunity to increase the chipload based on the application's robustness. Variables such as machine technology and condition, stack support materials, and Tycom design selection may allow the increased throughput with higher chiploads. Multiply the recommended chipload by 1.15 to reach the higher chipload.

If the application is not as robust due to heavy glass, high copper content, tight annular ring requirements, or similar, multiply the recommended chipload by 0.85.

