



Material Classification	Hardness		Speed		Drill Diameter			
	Bhn	Rc	sfm	m / min	3 – 5 mm	>5 – 8 mm	>8 – 12 mm	12 – 16 mm
					(.118 – .197 in.)	(.203 – .316 in.)	(.328 – .500 in.)	(.512 – .640 in.)
					Feed / Revolution			
Low Carbon Steel 1018	≤ 170	≤ 5	450	135	.10 – .15 (.004 – .006)	.15 – .25 (.006 – .010)	.25 – .40 (.010 – .016)	.40 – .50 (.016 – .020)
Alloyed Steel 4140	≤ 270	≤ 28	300	90	.075 – .12 (.003 – .005)	.12 – .20 (.005 – .008)	.20 – .30 (.008 – .012)	.30 – .40 (.012 – .016)
High-Strength Steel 4340, 300M	≤ 400	≤ 43	190	60	.05 – .10 (.002 – .004)	.10 – .15 (.004 – .006)	.15 – .23 (.006 – .009)	.23 – .30 (.009 – .012)
Tool Steel H-13	≤ 170	≤ 5	230	70	.05 – .10 (.002 – .004)	.10 – .18 (.004 – .007)	.18 – .25 (.007 – .010)	.25 – .33 (.010 – .013)
Cast Iron	150 – 200	1 – 15	400	120	.12 – .20 (.005 – .008)	.20 – .33 (.008 – .013)	.33 – .50 (.013 – .020)	.50 – .65 (.020 – .026)
	200 – 300	15 – 30	245	75	.10 – .18 (.004 – .007)	.18 – .28 (.007 – .011)	.28 – .43 (.011 – .017)	.43 – .55 (.017 – .022)
	300 – 400	30 – 45	190	60	.075 – .15 (.003 – .006)	.15 – .25 (.006 – .010)	.25 – .38 (.010 – .015)	.38 – .50 (.015 – .020)
Stainless Steel 316, 17-4PH, 15-5PH	≤ 225	≤ 20	140	45	.050 – .075 (.002 – .003)	.075 – .12 (.003 – .005)	.12 – .20 (.005 – .008)	.20 – .25 (.008 – .010)
Stainless Steel 304, 410, 420	≤ 170	≤ 5	180	55	.075 – .10 (.003 – .004)	.10 – .15 (.004 – .006)	.15 – .25 (.006 – .010)	.25 – .33 (.010 – .013)
Titanium 6Al4V	≤ 380	≤ 40	100	30	.050 – .075 (.002 – .003)	.075 – .10 (.003 – .004)	.10 – .15 (.004 – .006)	.15 – .20 (.006 – .008)
High-Temperature Alloys Inconel 718	≤ 400	≤ 43	50	15	.025 – .050 (.001 – .002)	.050 – .075 (.002 – .003)	.075 – .10 (.003 – .004)	.10 – .12 (.004 – .005)



Resharpener service available upon request.



Servicio de reafilado disponible por pedido.



Service de réaffutage disponible sur demande.