

### 103

Material	speed in sfm	feed per revolution (in / rev)				
		$\phi$ 1/8	$\phi$ >1/8-1/4	$\phi$ >1/4-3/8	$\phi$ >3/8-1/2	$\phi$ >1/2-3/4
<b>Heat Treatable Steel / Aceros de temple / Acier trempé</b>						
< 200 Bhn	300	.0033 - .0039	.0039 - .0059	.0059 - .0079	.0079 - .0098	.0098 - .0120
< 240 Bhn	260	.0033 - .0039	.0039 - .0059	.0059 - .0079	.0079 - .0098	.0098 - .0120
< 40 Rc	215	.0008 - .0024	.0024 - .0035	.0033 - .0051	.0039 - .0059	.0049 - .0060
< 45 Rc	165	.0008 - .0024	.0024 - .0035	.0033 - .0051	.0039 - .0059	.0049 - .0060
<b>Tool Steel / Aceros de herramientas / Acier à outils</b>						
< 235 Bhn	165	.0008 - .0024	.0020 - .0031	.0030 - .0039	.0031 - .0047	.0047 - .0058
< 300 Bhn	130	.0008 - .0024	.0020 - .0031	.0030 - .0039	.0031 - .0047	.0047 - .0058
< 40 Rc	115	.0006 - .0016	.0014 - .0022	.0018 - .0031	.0030 - .0039	.0039 - .0050
< 45 Rc	100	.0006 - .0016	.0014 - .0022	.0018 - .0031	.0030 - .0039	.0039 - .0050
> 45 Rc	80	.0006 - .0016	.0014 - .0022	.0018 - .0031	.0030 - .0039	.0039 - .0050
<b>Titanium Alloys / Aleaciones de titanio / Alliage de titane</b>						
< 160 Bhn	130	.0008 - .0020	.0016 - .0022	.0020 - .0030	.0024 - .0039	.0040 - .0062
< 280 Bhn	100	.0006 - .0016	.0014 - .0018	.0016 - .0024	.0020 - .0031	.0030 - .0045
> 40 Rc	65	.0006 - .0016	.0014 - .0018	.0016 - .0024	.0020 - .0031	.0030 - .0045
<b>Malleable Cast Iron / Fundición maleable / Fonte acierée malléable</b>						
< 200 Bhn	260	.0016 - .0039	.0031 - .0059	.0035 - .0067	.0047 - .0091	.0090 - .0110
> 200 Bhn	200	.0016 - .0039	.0031 - .0059	.0035 - .0067	.0047 - .0091	.0090 - .0110
<b>Gray Cast Iron / Fundición Gris / Fonte acierée grise</b>						
< 200 Bhn	330	.0016 - .0039	.0031 - .0059	.0035 - .0067	.0047 - .0091	.0090 - .0120
> 200 Bhn	260	.0016 - .0039	.0031 - .0059	.0035 - .0067	.0047 - .0091	.0090 - .0120
<b>Copper Alloys – Brittle / Aleación de cobre fragil / Alliage de cuivre - mou</b>						
	360	.0010 - .0022	.0020 - .0032	.0030 - .0035	.0032 - .0047	.0045 - .0060
<b>Aluminum – High Silicon / Aluminio – alto contenido de silicio / Aluminium à forte teneur de silice</b>						
	360	.0020 - .0049	.0039 - .0071	.0059 - .0079	.0067 - .0118	.0110 - .0130
<b>Magnesium Alloys / Aleaciones de magnesio / Alliage de magnésium</b>						
	525	.0016 - .0039	.0031 - .0059	.0035 - .0067	.0047 - .0091	.0090 - .0120

### 106

Material	speed in sfm	feed per revolution (in / rev)				
		$\phi$ $\leq$ 1/16	$\phi$ >1/16-1/8	$\phi$ >1/8-1/4	$\phi$ >1/4-3/8	$\phi$ >3/8-1/2
<b>Tool Steel / Aceros de herramientas / Acier à outils</b>						
> 45 Rc	80	.0002 - .0004	.0004 - .0008	.0006 - .0016	.0014 - .0022	.0018 - .0031
<b>Malleable Cast Iron / Fundición maleable / Fonte acierée malléable</b>						
< 200 Bhn	260	.0006 - .0012	.0012 - .0024	.0016 - .0039	.0031 - .0059	.0035 - .0067
> 200 Bhn	200	.0006 - .0012	.0012 - .0024	.0016 - .0039	.0031 - .0059	.0035 - .0067
<b>Gray Cast Iron / Fundición Gris / Fonte acierée grise</b>						
< 200 Bhn	330	.0006 - .0012	.0012 - .0024	.0016 - .0039	.0031 - .0059	.0035 - .0067
> 200 Bhn	260	.0006 - .0012	.0012 - .0024	.0016 - .0039	.0031 - .0059	.0035 - .0067

**E**

All recommendations should be considered a starting point, with possible variations to achieve optimum results. Increase the speed 20% when using coated drills.

**FR**

Les informations techniques mentionnées sont des valeurs moyennes données à titre indicatif et sont modifiables pour optimiser les résultats. Augmenter la vitesse de 20 % lorsque vous utilisez des forets monobloc revêtues.

**ES**

Todas la recomendaciones deberían ser consideradas como punto de partida, con posibles variaciones para conseguir óptimos resultados. Incrementar la velocidad un 20% al utilizar brocas recubiertas.

