



Drilling - Inch

Date compiled

Mar. 29 2017

SPMX 050204								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.002	0.002	0.002	640	896	768
	Low Alloy	200	0.002	0.005	0.000	384	563	461
	High Alloy	220	0.002	0.004	0.003	358	461	410
M	Austenitic	190	0.002	0.004	0.003	435	614	512
K	Grey Cast Iron	140	0.002	0.005	0.000	461	640	563

SPMX 060204								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.002	0.002	0.002	640	896	768
	Low Alloy	200	0.003	0.005	0.004	384	563	461
	High Alloy	220	0.002	0.004	0.003	358	461	410
M	Austenitic	190	0.002	0.005	0.004	435	614	512
K	Grey Cast Iron	140	0.003	0.006	0.005	461	640	563

SPMX 07T308								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.002	0.003	0.002	640	896	768
	Low Alloy	200	0.004	0.007	0.005	384	563	461
	High Alloy	220	0.003	0.005	0.004	358	461	410
M	Austenitic	190	0.003	0.006	0.005	435	614	512
K	Grey Cast Iron	140	0.005	0.008	0.006	461	640	563

SPMX 090408								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.002	0.003	0.002	640	896	768
	Low Alloy	200	0.005	0.008	0.006	384	563	461
	High Alloy	220	0.003	0.005	0.004	358	461	410
M	Austenitic	190	0.004	0.006	0.005	435	614	512
K	Grey Cast Iron	140	0.006	0.010	0.008	461	640	563

SPMX 110408								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.002	0.004	0.003	640	896	768
	Low Alloy	200	0.005	0.008	0.004	384	563	461
	High Alloy	220	0.003	0.005	0.005	358	461	410
M	Austenitic	190	0.004	0.007	0.006	435	614	512
K	Grey Cast Iron	140	0.006	0.011	0.008	461	640	563



SPMX 140508								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.002	0.005	0.003	640	896	768
	Low Alloy	200	0.005	0.008	0.006	384	563	461
	High Alloy	220	0.003	0.005	0.004	358	461	410
M	Austenitic	190	0.004	0.007	0.006	435	614	512
K	Grey Cast Iron	140	0.007	0.012	0.009	461	640	563

WCMX 040208								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.002	0.004	0.003	590	885	740
	Low Alloy	200	0.002	0.004	0.003	395	755	575
	High Alloy	220	0.003	0.004	0.003	230	560	395
M	Austenitic	190	0.002	0.004	0.003	560	755	655
K	Grey Cast Iron	140	0.004	0.004	0.004	490	755	625

WCMX 050308								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.002	0.004	0.003	590	885	740
	Low Alloy	200	0.002	0.004	0.003	395	755	575
	High Alloy	220	0.004	0.004	0.004	230	560	395
M	Austenitic	190	0.002	0.004	0.003	560	755	655
K	Grey Cast Iron	140	0.005	0.005	0.005	490	755	625

WCMX 06T308								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.002	0.005	0.003	590	885	755
	Low Alloy	200	0.002	0.005	0.002	395	755	590
	High Alloy	220	0.003	0.005	0.004	230	560	395
M	Austenitic	190	0.002	0.005	0.004	560	755	655
K	Grey Cast Iron	140	0.005	0.005	0.005	490	755	625

WCMX 080412								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (Inch/rev)			Speed Vc (SFM)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.002	0.006	0.004	590	885	740
	Low Alloy	200	0.002	0.006	0.004	395	755	575
	High Alloy	220	0.004	0.006	0.005	230	560	395
M	Austenitic	190	0.002	0.006	0.004	560	755	655
K	Grey Cast Iron	140	0.004	0.007	0.006	490	755	625