

RECOMMENDED CUTTING CONDITIONS

Work Material		S			
		Heat Resistant Alloy Inconel718 etc.		Titanium Alloy Ti-6Al-4V etc.	
Drill Dia. DC (mm)	L/D	Revolution (min ⁻¹)	Feed (Min.—Max.) (mm/rev)	Revolution (min ⁻¹)	Feed (Min.—Max.) (mm/rev)
3	≤ 3	1000	0.06 (0.04—0.10)	4200	0.08 (0.06—0.12)
4	≤ 3	790	0.06 (0.04—0.10)	3100	0.10 (0.08—0.16)
5	≤ 3	760	0.08 (0.06—0.12)	2500	0.12 (0.08—0.20)
6	≤ 3	790	0.10 (0.08—0.15)	2100	0.14 (0.10—0.20)
8	≤ 3	590	0.10 (0.08—0.15)	1600	0.18 (0.15—0.25)
10	≤ 3	570	0.10 (0.08—0.15)	1300	0.22 (0.18—0.28)
12	≤ 3	530	0.12 (0.08—0.15)	1100	0.24 (0.20—0.30)

Note 1) High pressure through spindle coolant is recommended for stable drilling.

Note 2) Emulsion type water-soluble coolant is recommended.

Note 3) When using non water-soluble coolant reduce the cutting speed by 10-20%.

Note 4) When drilling using an external coolant system, peck / step feed drilling is recommended at every DC x 0.5 to promote the breaking of chips.

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DRILLING