



## REFERENCE

### Technical Information for Standard Carbide Drills

#### Recommended Cutting Conditions – Solid Carbide – 118° Point

Diameter	NON-ALLOY STEELS		ALLOY STEELS		SOFT GRAY CAST IRON		HARD GRAY CAST IRON	
	RPM	Inch/Rev.	RPM	Inch/Rev.	RPM	Inch/Rev.	RPM	Inch/Rev.
3/64	23,000	0.0012	17,200	0.0012	32,000	0.0016	23,000	0.0016
5/64	11,500	0.0016	8,600	0.0016	16,000	0.0020	11,500	0.0020
1/8	7,800	0.0020	5,750	0.0020	10,500	0.0024	7,600	0.0024
5/32	5,800	0.0024	4,300	0.0024	7,800	0.0028	5,700	0.0028
13/64	4,700	0.0028	3,450	0.0028	6,200	0.0031	4,550	0.0031
15/64	3,900	0.0031	2,850	0.0031	5,200	0.0035	3,800	0.0035
9/32	3,350	0.0035	2,450	0.0035	4,500	0.0039	3,250	0.0039
5/16	2,900	0.0039	2,150	0.0039	3,900	0.0047	2,850	0.0047
23/64	2,600	0.0043	1,900	0.0043	3,450	0.0055	2,550	0.0055
25/64	2,350	0.0047	1,700	0.0047	3,100	0.0063	2,300	0.0063
7/16	2,150	0.0051	1,500	0.0051	2,850	0.0071	2,100	0.0071
15/32	1,950	0.0055	1,450	0.0055	2,600	0.0079	1,900	0.0079
33/64	1,800	0.0063	1,350	0.0063	2,400	0.0079	1,750	0.0079

Diameter	STAINLESS STEELS		Al-Si ALLOY Si<10%		Al-Si ALLOY Si>10%		Ti, Ni ALLOY STEELS	
	RPM	Inch/Rev.	RPM	Inch/Rev.	RPM	Inch/Rev.	RPM	Inch/Rev.
3/64	12,000	0.0016	54,000	0.0020	42,000	0.0020	11,800	0.0008
5/64	6,000	0.0012	27,000	0.0024	21,000	0.0024	5,900	0.0012
1/8	4,000	0.0016	18,000	0.0028	14,000	0.0028	3,900	0.0016
5/32	3,000	0.0020	13,000	0.0031	10,500	0.0031	2,950	0.0020
13/64	2,400	0.0024	10,500	0.0035	8,500	0.0035	2,350	0.0024
15/64	2,000	0.0028	8,800	0.0043	7,100	0.0043	1,950	0.0028
9/32	1,700	0.0031	7,600	0.0051	6,100	0.0051	1,700	0.0031
5/16	1,500	0.0035	6,600	0.0059	5,350	0.0059	1,450	0.0035
23/64	1,350	0.0039	5,900	0.0067	4,750	0.0067	1,300	0.0039
25/64	1,200	0.0043	5,300	0.0075	4,250	0.0075	1,200	0.0043
7/16	1,100	0.0047	4,850	0.0083	3,900	0.0083	1,050	0.0047
15/32	1,000	0.0051	4,450	0.0091	3,550	0.0091	980	0.0051
33/64	950	0.0051	4,100	0.0098	3,300	0.0098	905	0.0051

Carbon Steel HB225	Alloy Steel HB225-325	Cast Iron	Aluminum	Stainless Steel	Titanium	Mild Steel
●	●	○	○	○	○	●

● Excellent ○ Good