

D Drill Cutting Data Recommendations

Recommended Chip Load per Tooth by Cutting Diameter (in)																	
Series		SFM	3	1/8	3/16	5	6	1/4	5/16	8	3/8	7/16	1/2	5/8	3/4	7/8	1
67-800	Composites	230		.001-.003	.001-.003			.002-.004	.002-.004		.003-.005	.003-.005	.003-.005				
68-900	Composites	230		.001				.0015			.0015		.0015				
70-500	Plastic	200		.019-.021				.021-.023			.023-.025		.025-.027				
72-000*	Wood		.009-.011			.011-.013	.013-.015			.015-.017							
85-900	Composites	230		.0005	.0005			.001	.001		.0015		.001				
86-150	Composites	150-250		.001	.001			.0015			.0015		.0015				

* Gang drills run at 4,500 RPM and 150 IPM

FORMULAS: RPM = (3.82 x SFM) / tool dia.
 Feedrate (IPM) = RPM x IPR

DEFINITIONS:
 IPM = Inches Per Minute
 IPR = Inches Per Revolution

F Foam Cutting Data Recommendations

DEPTH OF CUT: 1 x D Use recommended chip load
 2 x D Reduce chip load by 25%
 3 x D Reduce chip load by 50%

Recommended Chip Load per Tooth by Cutting Diameter (in)																							
Series	Cut	1/16	3/32	1/8	5/32	3/16	7/32	1/4	5/16	3/8	7/16	1/2	9/16	5/8	3/4	7/8	1	1 1/8	1 1/4	1 1/2	1 3/4	2	
40-550	1 x D											.004-.006											
48-000	1 x D			.002-.004		.002-.004		.003-.005	.003-.005	.004-.006		.005-.007		.006-.008	.007-.009		.010						
52-550	1 x D			.002-.004		.002-.004		.004-.006	.004-.006	.004-.006													
52-700	1 x D			.002-.004		.002-.004		.004-.006	.004-.006	.004-.006		.005-.007		.006-.008	.007-.009		.010						
56-000P	1 x D			.002-.004		.002-.004		.004-.006		.004-.006		.005-.007											
77-100	1 x D			.002-.004				.004-.006															