

## Accupro Coolant Fed Carbide Drills

### **Speed and Feed Data - Applications in various materials**

<b>Material</b>	<b>SFM</b>	<b>Feed Rate (IPR)</b>					
		<b>1/8"</b>	<b>1/4"</b>	<b>3/8"</b>	<b>1/2"</b>	<b>5/8"</b>	<b>3/4"</b>
<i>Aluminum Alloys</i>	700-1000	0.0080	0.0125	0.0150	0.0190	0.0200	0.0220
<i>Brass &amp; Bronze</i>	300-600	0.0065	0.0100	0.0125	0.0150	0.0160	0.0180
<i>Low Carbon Steel RC-24 or less</i>	550	0.0065	0.0100	0.0125	0.0150	0.0160	0.0180
<i>Low Carbon Steel RC-24-32</i>	475	0.0065	0.0100	0.0125	0.0150	0.0160	0.0180
<i>Cast Iron</i>	525	0.0080	0.0125	0.0150	0.0190	0.0200	0.0220
<i>Steel RC-30-38</i>	225-275	0.0040	0.0060	0.0080	0.0100	0.0012	0.0014
<i>Steel RC-40-55</i>	110-180	0.0020	0.0030	0.0040	0.0045	0.0050	0.0055
<i>Copper</i>	400	0.0065	0.0100	0.0125	0.0150	0.0160	0.0180
<i>Tool Steel</i>	175-225	0.0030	0.0050	0.0065	0.0070	0.0080	0.0090
<i>Magnesium</i>	900	0.0065	0.0100	0.0125	0.0150	0.0160	0.0180
<i>Malleable Iron</i>	400	0.0065	0.0100	0.0125	0.0150	0.0160	0.0180
<i>Nickel Base Alloys</i>	50-80	0.0020	0.0030	0.0040	0.0050	0.0060	0.0070
<i>Stainless Steel - Soft</i>	180-195	0.0030	0.0050	0.0065	0.0070	0.0080	0.0090
<i>Stainless Steel - Hard</i>	130-150	0.0030	0.0050	0.0065	0.0070	0.0080	0.0090
<i>Titanium - Soft</i>	150	0.0020	0.0030	0.0040	0.0045	0.0050	0.0050
<i>Titanium - Hard</i>	125	0.0020	0.0030	0.0040	0.0045	0.0050	0.0050

*Note: All speed and feeds are suggested starting points. They may be increased or decreased depending on machine condition, hole depth, finish required, coolant pressure and flow rate, etc.*

*If drill depth exceeds 5 diameters, reduce speed and feed*