

2 Flute Drills

Series 101 Fractional	Hardness	Vc (sfm)	DC • in								
			1/64	1/32	1/16	1/8	1/4	3/8	1/2		
CARBON STEELS 1018, 1040, 1080, 1090, 10L50, 1140, 1212, 12L15, 1525, 1536	≤ 175 Bhn or ≤ 7 HRc	265 (212-318)	RPM	64787	32394	16197	8098	4049	2699	2025	
			Fr	0.00021	0.0004	0.0008	0.0017	0.0033	0.0050	0.0067	
			Feed (ipm)	13.5	13.5	13.5	13.5	13.5	13.5	13.5	
	≤ 300 Bhn or ≤ 32 HRc	125 (100-150)	RPM	30560	15280	7640	3820	1910	1273	955	
			Fr	0.00020	0.0004	0.0008	0.0016	0.0031	0.0047	0.0063	
			Feed (ipm)	6.0	6.0	6.0	6.0	6.0	6.0	6.0	
	≤ 425 Bhn or ≤ 45 HRc	85 (68-102)	RPM	20781	10390	5195	2598	1299	866	649	
			Fr	0.00011	0.0002	0.0004	0.0008	0.0017	0.0025	0.0034	
			Feed (ipm)	2.2	2.2	2.2	2.2	2.2	2.2	2.2	
	ALLOY STEELS 4140, 4150, 4320, 5120, 5150, 8630, 86L20, 50100	≤ 275 Bhn or ≤ 28 HRc	230 (184-276)	RPM	56230	28115	14058	7029	3514	2343	1757
				Fr	0.00019	0.0004	0.0007	0.0015	0.0030	0.0045	0.0060
				Feed (ipm)	10.5	10.5	10.5	10.5	10.5	10.5	10.5
≤ 375 Bhn or ≤ 40 HRc		145 (116-174)	RPM	35450	17725	8862	4431	2216	1477	1108	
			Fr	0.00019	0.0004	0.0007	0.0015	0.0030	0.0045	0.0060	
			Feed (ipm)	6.6	6.6	6.6	6.6	6.6	6.6	6.6	
≤ 425 Bhn or ≤ 45 HRc		60 (48-72)	RPM	14669	7334	3667	1834	917	611	458	
			Fr	0.00008	0.0002	0.0003	0.0007	0.0013	0.0020	0.0026	
			Feed (ipm)	1.2	1.2	1.2	1.2	1.2	1.2	1.2	
TOOL STEELS A2, D2, H13, L2, M2, P20, S7, T15, W2		≤ 250 Bhn or ≤ 24 HRc	85 (68-102)	RPM	20781	10390	5195	2598	1299	866	649
				Fr	0.00011	0.0002	0.0004	0.0009	0.0018	0.0027	0.0035
				Feed (ipm)	2.3	2.3	2.3	2.3	2.3	2.3	2.3
	≤ 375 Bhn or ≤ 40 HRc	55 (44-66)	RPM	13446	6723	3362	1681	840	560	420	
			Fr	0.00005	0.0001	0.0002	0.0004	0.0008	0.0012	0.0017	
			Feed (ipm)	0.7	0.7	0.7	0.7	0.7	0.7	0.7	
STAINLESS STEELS (FREE MACHINING) 303, 416, 420F, 430F 440F	≤ 250 Bhn or ≤ 24 HRc	210 (168-252)	RPM	51341	25670	12835	6418	3209	2139	1604	
			Fr	0.00015	0.0003	0.0006	0.0012	0.0024	0.0036	0.0048	
			Feed (ipm)	7.7	7.7	7.7	7.7	7.7	7.7	7.7	
	≤ 330 Bhn or ≤ 36 HRc	110 (88-132)	RPM	26893	13446	6723	3362	1681	1121	840	
			Fr	0.00009	0.0002	0.0004	0.0007	0.0015	0.0022	0.0030	
			Feed (ipm)	2.5	2.5	2.5	2.5	2.5	2.5	2.5	
	STAINLESS STEELS (DIFFICULT) 304, 316, 321, 13-8 PH, 15-5PH, 17-4 PH, Custom 450	≤ 275 Bhn or ≤ 28 HRc	65 (52-78)	RPM	15891	7946	3973	1986	993	662	497
				Fr	0.00010	0.0002	0.0005	0.0009	0.0018	0.0025	0.0035
				Feed (ipm)	1.7	1.7	1.7	1.7	1.7	1.7	1.7
		≤ 375 Bhn or ≤ 40 HRc	55 (44-66)	RPM	13446	6723	3362	1681	840	560	420
				Fr	0.00010	0.0002	0.0004	0.0008	0.0015	0.0023	0.0031
				Feed (ipm)	1.3	1.3	1.3	1.3	1.3	1.3	1.3
CAST IRONS Gray, Malleable, Ductile	≤ 220 Bhn or ≤ 19 HRc	280 (224-336)	RPM	68454	34227	17114	8557	4278	2852	2139	
			Fr	0.00026	0.0005	0.0010	0.0020	0.0041	0.0061	0.0082	
			Feed (ipm)	17.5	17.5	17.5	17.5	17.5	17.5	17.5	
	≤ 330 Bhn or ≤ 36 HRc	250 (200-300)	RPM	61120	30560	15280	7640	3820	2547	1910	
			Fr	0.00025	0.0005	0.0010	0.0020	0.0041	0.0061	0.0081	
			Feed (ipm)	15.5	15.5	15.5	15.5	15.5	15.5	15.5	

continued on next page

FRACTIONAL 2 Flute Drills

Series 101 Fractional	Hardness	Vc (sfm)	DC • in								
			1/64	1/32	1/16	1/8	1/4	3/8	1/2		
N ALUMINUM ALLOYS 2017, 2024, 356, 6061, 7075	≤ 80 Bhn or ≤ 47 HRb	540	RPM	132019	66010	33005	16502	8251	5501	4126	
		(432-648)	Fr	0.00030	0.0006	0.0012	0.0024	0.0048	0.0073	0.0097	
			Feed (ipm)	40.0	40.0	40.0	40.0	40.0	40.0	40.0	
	≤ 150 Bhn or ≤ 88 HRb	455	RPM	111238	55619	27810	13905	6952	4635	3476	
		(364-546)	Fr	0.00031	0.0006	0.0013	0.0025	0.0050	0.0076	0.0101	
			Feed (ipm)	35.0	35.0	35.0	35.0	35.0	35.0	35.0	
	COPPER ALLOYS Alum Bronze, C110, Muntz Brass	≤ 140 Bhn or ≤ 3 HRc	190	RPM	46451	23226	11613	5806	2903	1935	1452
			(152-228)	Fr	0.00015	0.0003	0.0006	0.0012	0.0024	0.0036	0.0048
				Feed (ipm)	7.0	7.0	7.0	7.0	7.0	7.0	7.0
		≤ 200 Bhn or ≤ 23 HRc	175	RPM	42784	21392	10696	5348	2674	1783	1337
			(140-210)	Fr	0.00015	0.0003	0.0006	0.0012	0.0024	0.0036	0.0048
				Feed (ipm)	6.4	6.4	6.4	6.4	6.4	6.4	6.4
PLASTICS Polycarbonate, PVC	500 (400-600)	RPM	122240	61120	30560	15280	7640	5093	3820		
		Fr	0.00031	0.0006	0.0012	0.0025	0.0050	0.0075	0.0099		
		Feed (ipm)	38.0	38.0	38.0	38.0	38.0	38.0	38.0		
S HIGH TEMP ALLOYS (NICKEL, COBALT, IRON BASE) Inconel 601, 617, 625, Incoloy 800, Monel 400, Rene, Waspaloy	≤ 220 Bhn or ≤ 19 HRc	40	RPM	9779	4890	2445	1222	611	407	306	
		(32-48)	Fr	0.00010	0.0002	0.0004	0.0008	0.0016	0.0025	0.0033	
			Feed (ipm)	1.0	1.0	1.0	1.0	1.0	1.0	1.0	
	≤ 320 Bhn or ≤ 34 HRc	25	RPM	6112	3056	1528	764	382	255	191	
		(20-30)	Fr	0.00010	0.0002	0.0004	0.0008	0.0016	0.0024	0.0031	
			Feed (ipm)	0.6	0.6	0.6	0.6	0.6	0.6	0.6	
	≤ 425 Bhn or ≤ 45 HRc	20	RPM	4890	2445	1222	611	306	204	153	
		(16-24)	Fr	0.00004	0.0001	0.0002	0.0003	0.0007	0.0010	0.0013	
			Feed (ipm)	0.2	0.2	0.2	0.2	0.2	0.2	0.2	
	TITANIUM ALLOYS (DIFFICULT) Pure Titanium, Ti6Al4V, Ti6Al2Sn4Zr2Mo, Ti4Al4Mo2Sn0.5Si, Ti-6Al4V	≤ 275 Bhn or ≤ 28 HRc	85	RPM	20781	10390	5195	2598	1299	866	649
			(68-102)	Fr	0.00020	0.0004	0.0008	0.0016	0.0032	0.0049	0.0065
				Feed (ipm)	4.2	4.2	4.2	4.2	4.2	4.2	4.2
≤ 350 Bhn or ≤ 38 HRc		65	RPM	15891	7946	3973	1986	993	662	497	
		(52-78)	Fr	0.00011	0.0002	0.0004	0.0009	0.0017	0.0026	0.0034	
			Feed (ipm)	1.7	1.7	1.7	1.7	1.7	1.7	1.7	
≤ 440 Bhn or ≤ 47 HRc	55	RPM	13446	6723	3362	1681	840	560	420		
	(44-66)	Fr	0.00010	0.0002	0.0004	0.0008	0.0015	0.0023	0.0031		
		Feed (ipm)	1.3	1.3	1.3	1.3	1.3	1.3	1.3		
H TOOL STEELS A2, D2, H13, L2, M2, P20, S7, T15, W2	≤ 475 Bhn or ≤ 50 HRc	40	RPM	9779	4890	2445	1222	611	407	306	
		(32-48)	Fr	0.00005	0.0001	0.0002	0.0004	0.0008	0.0012	0.0016	
			Feed (ipm)	0.5	0.5	0.5	0.5	0.5	0.5	0.5	

Bhn (Brinell) HRc (Rockwell C) HRb (Rockwell B)

$rpm = Vc \times 3.82 / DC$

$ipm = Fr \times rpm$

reduce speed and feed 30 percent when using uncoated drills

reduce speed and feed for materials harder than listed

refer to the SGS Tool Wizard® for complete technical information (www.kyocera-sgstool.com)