

Solid Carbide Square Drills

Material	Cutting Speed SFM (m/min)	Feed Rate inch/rev (mm/rev)				
		0.12-0.24in (3-6mm)	0.24-0.36in (6-9mm)	0.36-0.48in (9-12mm)	0.48-0.63in (12-16mm)	0.63-1.00in (16-25mm)
Aluminium die cast alloy	200 - 330					
zinc die cast alloy	(60 - 100)	0.001/0.004	0.0015/0.006	0.002/0.008	0.002/0.012	0.008/0.016
Aluminium alloy (castings)	130 - 200 (40 - 60)	(0.03/0.10)	(0.04/0.15)	(0.05/0.20)	(0.06/0.30)	(0.20/0.40)
Cast iron (soft)	100 - 200 (30 - 60)	0.001/0.003 (0.03/0.08)	0.0015/0.005 (0.04/0.12)	0.002/0.008 (0.05/0.20)	0.002/0.012 (0.06/0.30)	0.008/0.016 (0.20/0.40)
Cast iron (hard)	50 - 130 (15 - 40)	0.008/0.002 (0.02/0.05)	0.001/0.003 (0.03/0.08)	0.0016/0.005 (0.04/0.12)	0.002/0.006 (0.05/0.15)	0.008/0.012 (0.20/0.30)

Solid Carbide Coolant Feed Square Drills

Material	Cutting Speed SFM (m/min)	Feed Rate inch/rev (mm/rev)				
		0.12-0.24in (3-6mm)	0.24-0.36in (6-9mm)	0.36-0.48in (9-12mm)	0.48-0.63in (12-16mm)	0.63-1.00in (16-25mm)
Aluminium die cast alloy	330 - 700					
zinc die cast alloy	(100 - 210)	0.004/0.006	0.006/0.010	0.010/0.012	0.012/0.016	0.016/0.020
Aluminium alloy (castings)	260 - 650 (80 - 200)	(0.10/0.18)	(0.18/0.25)	(0.25/0.30)	(0.30/0.40)	(0.40/0.50)
Cast iron (soft)	230 - 400 (70 - 120)	0.004/0.006 (0.10/0.15)	0.006/0.008 (0.15/0.20)	0.008/0.010 (0.20/0.25)	0.010/0.014 (0.25/0.35)	0.014/0.016 (0.35/0.40)
Cast iron (hard)	230 - 400 (70 - 120)	0.003/0.005 (0.08/0.12)	0.005/0.007 (0.12/0.18)	0.007/0.009 (0.18/0.22)	0.009/0.012 (0.22/0.30)	0.012/0.014 (0.30/0.35)

Cutting fluid: Water soluble / lightduty oil.

Pressure: 20 Bar (290 P.S.I.) minimum

Flow rate: 4.5 litres / minutes minimum

Concentration: Normally 3% - 4% but may vary depending on the cutting fluid.
(We suggest that you follow the recommendation of the manufacturer of the cutting fluid.)