

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							
85-800	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: $RPM = (3.82 \times SFM) / \text{tool dia.}$
 $\text{Feedrate (IPM)} = RPM \times IPR$

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