

Machining Conditions for DR-CA Large Diameter DR-TWIST Drills

Material	Vc (SFM)	Feed (IPR)		
		2.24-2.63 dia.	2.75-2.87 dia.	2.91-3.13 dia.
Low Carbon Steel (<0.3% C)	590-820	.003-.005	.003-.005	.004-.006
Carbon Steel (>0.3% C)	525-720	.005-.007	.005-.007	.006-.008
Low Alloy Steel (<HB300)	490-720	.004-.007	.004-.007	.005-.008
High Alloy Steel (>HB300)	425-590	.004-.006	.004-.006	.005-.007
Stainless Steel	560-785	.003-.006	.003-.006	.004-.007
Cast Iron	590-820	.006-.009	.006-.009	.007-.010
Ductile Cast Iron	425-655	.004-.008	.004-.008	.005-.009
Aluminum	1080-1245	.006-.010	.006-.010	.007-.011
Ti Alloy (Ti 6Al)	100-195	.005-.006	.008-.006	.006-.007