

Cutting Condition Recommendations

Mtl. No.	V m/min	IFP-IQ
		Feed vs. Drill Diameter
		DC=33.0-40.0
		mm/rev
1	80-110-140	0.30-0.40-0.50
2	80-105-130	
3	80-100-120	
4	70-90-110	
5	50-70-90	
6	80-100-120	0.30-0.40-0.50
7	70-90-110	
8	50-70-90	
9	40-55-70	
10	50-70-90	0.25-0.30-0.35
11	40-60-80	
12	40-60-80	0.20-0.27-0.35
13		
14	30-50-70	0.20-0.27-0.35
31	30-45-60	0.16-0.20-0.25
32	20-35-50	
33		
34		
35		
36	20-35-50	0.18-0.22-0.27
37		

- Recommended cutting data