

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

| Material                                 | Vc<br>(m/min) | Feed (mm/rev) |            |            |
|--|---------------|---------------|------------|------------|
|  |               | 57-66 dia.    | 67-73 dia. | 74-80 dia. |
| <b>Low Carbon Steel<br/>(&lt;0.3% C)</b> | 180-250       | 0.08-0.12     | 0.08-0.12  | 0.09-0.14  |
| <b>Carbon Steel<br/>(&gt;0.3% C)</b>     | 160-220       | 0.12-0.18     | 0.12-0.18  | 0.14-0.21  |
| <b>Low Alloy Steel<br/>(&lt;HB300)</b>   | 150-220       | 0.10-0.18     | 0.10-0.18  | 0.12-0.21  |
| <b>High Alloy Steel<br/>(&gt;HB300)</b>  | 130-180       | 0.10-0.15     | 0.10-0.15  | 0.12-0.17  |
| <b>Stainless Steel</b>                   | 170-240       | 0.08-0.15     | 0.08-0.15  | 0.09-0.17  |
| <b>Cast Iron</b>                         | 180-250       | 0.15-0.22     | 0.15-0.22  | 0.17-0.25  |
| <b>Ductile<br/>Cast Iron</b>             | 130-200       | 0.10-0.20     | 0.10-0.20  | 0.12-0.23  |
| <b>Aluminum</b>                          | 330-380       | 0.15-0.25     | 0.15-0.25  | 0.17-0.29  |
| <b>Ti Alloy<br/>(Ti 6Al)</b>             | 30-60         | 0.12-0.16     | 0.12-0.16  | 0.14-0.18  |