Machining Recommendations for FINEBEAM Drills

ISO	Material		Condition	Tensile Strength [N/mm²]	Material Group No.(1)	Hardness (HB)	Chipbreaker	Cutting speed V_c (m/min)	Feed : f (mm/rev) Drill dia. (mm) 25.00 - 43.00	Feed : f (mm/rev) Drill dia. (mm) 43.01 - 89.00
P	Non-alloy steel and cast steel, free cutting steel	< 0.25 %C	Annealed	420	1	125	HF	70-130	0.11-0.41	0.14-0.45
							G	70-130	0.10-0.30	0.12-0.35
		≥0.25% C	Annealed	650	2	190	HF	70-130	0.11-0.41	0.14-0.45
							G	70-130	0.10-0.30	0.12-0.35
		< 0.55% C	Quenched and tempered	850	3	250	HF	70-130	0.11-0.41	0.14-0.45
							G	70-130	0.10-0.30	0.12-0.35
		≥0.55% C	Annealed	750	4	220	HF	70-130	0.11-0.41	0.14-0.45
							G	70-130	0.10-0.30	0.12-0.35
			Quenched and tempered	1000	5	300	HF	70-130	0.11-0.41	0.14-0.45
							G	70-130	0.10-0.30	0.12-0.35
	Low alloy and cast steel (less than 5% of alloying elements)		Annealed	600	6	200	HF	70-120	0.11-0.41	0.20-0.45
							G	70-120	0.10-0.30	0.12-0.35
			Quenched and tempered	930	7	275	HF	55-110	0.11-0.41	0.20-0.45
							G	60-120	0.10-0.30	0.12-0.35
				1000	8	300	HF	55-110	0.11-0.41	0.20-0.45
							G	60-120	0.10-0.30	0.12-0.35
				1200	9	350	HF	55-110	0.11-0.41	0.20-0.45
							G	60-120	0.10-0.30	0.12-0.35
	High alloyed steel, cast steel and tool steel		Annealed	680	10	200	HF	55-110	0.11-0.38	0.20-0.40
							G	70-130	0.10-0.30	0.12-0.35
			Quenched and tempered	1100	11	325	HF	55-110	0.11-0.38	0.20-0.40
							G	70-130	0.10-0.30	0.12-0.35
	Stainless steel and cast steel		Ferritic/martensitic	680	12	200	HF	40-110	0.11-0.41	0.20-0.45
							G	70-130	0.10-0.30	0.12-0.35
			Martensitic	820	13	240	HF	40-110	0.11-0.41	0.20-0.45
							G	70-130	0.10-0.30	0.12-0.35
M	Stainless steel and cast steel		Austenitic, duplex	600	14	180	HF	40-110	0.11-0.41	0.20-0.45
							G	70-130	0.10-0.30	0.12-0.35
K	Grey cast iron (GG)		Ferritic/pearlitic		15	180	HF	50-110	0.11-0.38	0.24-0.41
							G	50-110	0.10-0.25	0.12-0.35
			Pearlitic/martensitic		16	260	HF	50-110	0.11-0.38	0.24-0.41
							G	50-110	0.10-0.25	0.12-0.35
	Nodular cast iron (GGG)		Ferritic		17	160	HF	50-110	0.11-0.38	0.24-0.41
							G	50-110	0.10-0.25	0.12-0.35
			Pearlitic		18	250	HF	50-110	0.11-0.38	0.24-0.41
							G	50-110	0.10-0.25	0.12-0.35
	Malleable cast iron		Ferritic		19	130	HF	50-110	0.11-0.38	0.24-0.41
							G	50-110	0.10-0.25	0.12-0.35
			Pearlitic		20	230	HF	50-110	0.11-0.38	0.24-0.41
							G	50-110	0.10-0.25	0.12-0.35
N	Aluminum-wrought alloys		Not hardenable		21	60	HF	65-150	0.09-0.33	0.24-0.35
							G	65-130	0.10-0.25	0.12-0.35
			Hardenable		22	100	HF	65-150	0.09-0.33	0.24-0.35
							G	65-130	0.08-0.23	0.12-0.27
	Aluminum-cast alloys	≤ 12% Si	Not hardenable		23	75	HF	65-150	0.09-0.33	0.24-0.35
							G	65-130	0.08-0.23	0.12-0.27
			Hardenable		24	90	HF	65-150	0.09-0.33	0.24-0.35
							G	65-130	0.08-0.23	0.12-0.27
		>12% Si	High temperature		25	130	HF	65-150	0.09-0.33	0.24-0.35
							G	65-130	0.08-0.23	0.12-0.27
	Copper alloys	>1% Pb	Free cutting		26	110	HF	65-150	0.09-0.33	0.24-0.35
							G	65-130	0.08-0.23	0.12-0.27
			Brass		27	90	HF	65-150	0.09-0.33	0.24-0.35
							G	65-130	0.08-0.23	0.12-0.27
			Electrolitic copper		28	100	HF	65-150	0.09-0.33	0.24-0.35
							G	65-130	0.08-0.23	0.12-0.27
S	High temp. alloys	Fe based	Annealed		31	200	HF	20-55	0.09-0.30	0.20-0.33
							G	20-50	0.08-0.23	0.12-0.27
			Hardened		32	280	HF	20-55	0.09-0.30	0.20-0.33
							G	20-50	0.08-0.23	0.12-0.27
		Ni / Co based	Annealed		33	250	HF	20-55	0.09-0.30	0.20-0.33
							G	20-50	0.08-0.23	0.12-0.27
			Hardened		34	350	HF	20-55	0.09-0.30	0.20-0.33
							G	20-50	0.08-0.23	0.12-0.27
			Cast		35	320	HF	20-55	0.09-0.30	0.20-0.33
							G	20-50	0.08-0.23	0.12-0.27
	Titanium alloys		Pure	400	36		HF	30-60	0.09-0.30	0.20-0.33
							G	30-60	0.08-0.23	0.12-0.27
			Alpha+beta alloys hardened	1050	37		HF	30-60	0.09-0.30	0.20-0.33
							G	30-60	0.08-0.23	0.12-0.27
H	Hardened steel	≥ 40HRC	Hardened		38		HF	30-60	0.09-0.30	0.20-0.33
							G	30-60	0.08-0.23	0.12-0.27

(1) Based on ISO 513 and VDI 3323 standards