



Drilling - Metric

Date compiled

Mar. 29 2017

SPMX 050204								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev)			Speed Vc (m/min)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.04	0.06	0.05	250	350	300
	Low Alloy	200	0.06	0.12	0.01	150	220	180
	High Alloy	220	0.06	0.10	0.08	140	180	160
M	Austenitic	190	0.05	0.10	0.08	170	240	200
K	Grey Cast Iron	140	0.06	0.12	0.01	180	250	220

SPMX 060204								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev)			Speed Vc (m/min)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.04	0.06	0.05	250	350	300
	Low Alloy	200	0.08	0.14	0.10	150	220	180
	High Alloy	220	0.06	0.10	0.08	140	180	160
M	Austenitic	190	0.06	0.12	0.10	170	240	200
K	Grey Cast Iron	140	0.08	0.16	0.12	180	250	220

SPMX 07T308								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev)			Speed Vc (m/min)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.04	0.08	0.06	250	350	300
	Low Alloy	200	0.10	0.18	0.12	150	220	180
	High Alloy	220	0.08	0.12	0.10	140	180	160
M	Austenitic	190	0.08	0.15	0.12	170	240	200
K	Grey Cast Iron	140	0.12	0.20	0.15	180	250	220

SPMX 090408								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev)			Speed Vc (m/min)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.04	0.08	0.06	250	350	300
	Low Alloy	200	0.12	0.20	0.15	150	220	180
	High Alloy	220	0.08	0.14	0.10	140	180	160
M	Austenitic	190	0.09	0.16	0.12	170	240	200
K	Grey Cast Iron	140	0.15	0.25	0.20	180	250	220

SPMX 110408								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev)			Speed Vc (m/min)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.06	0.10	0.08	250	350	300
	Low Alloy	200	0.12	0.20	0.10	150	220	180
	High Alloy	220	0.08	0.14	0.12	140	180	160
M	Austenitic	190	0.10	0.17	0.15	170	240	200
K	Grey Cast Iron	140	0.16	0.28	0.20	180	250	220



SPMX 140508								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev)			Speed Vc (m/min)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.06	0.12	0.08	250	350	300
	Low Alloy	200	0.13	0.20	0.15	150	220	180
	High Alloy	220	0.08	0.14	0.10	140	180	160
M	Austenitic	190	0.11	0.18	0.15	170	240	200
K	Grey Cast Iron	140	0.18	0.30	0.24	180	250	220

WCMX 040208								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev)			Speed Vc (m/min)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.05	0.10	0.08	180	270	225
	Low Alloy	200	0.05	0.10	0.08	120	230	175
	High Alloy	220	0.07	0.10	0.09	70	170	120
M	Austenitic	190	0.05	0.10	0.08	170	230	200
K	Grey Cast Iron	140	0.10	0.11	0.11	150	230	190

WCMX 050308								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev)			Speed Vc (m/min)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.06	0.11	0.09	180	270	225
	Low Alloy	200	0.06	0.11	0.09	120	230	175
	High Alloy	220	0.09	0.11	0.10	70	170	120
M	Austenitic	190	0.06	0.11	0.09	170	230	200
K	Grey Cast Iron	140	0.13	0.12	0.13	150	230	190

WCMX 06T308								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev)			Speed Vc (m/min)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.06	0.12	0.07	180	270	230
	Low Alloy	200	0.06	0.12	0.06	120	230	180
	High Alloy	220	0.08	0.12	0.10	70	170	120
M	Austenitic	190	0.06	0.12	0.09	170	230	200
K	Grey Cast Iron	140	0.12	0.13	0.13	150	230	190

WCMX 080412								
Material			Cutting conditions					
Group	Sub Group	Hardness (HB)	Feed (mm/rev)			Speed Vc (m/min)		
			Min	Max	Recommend	Min	Max	Recommend
P	Non Alloy	120	0.06	0.16	0.11	180	270	225
	Low Alloy	200	0.06	0.16	0.11	120	230	175
	High Alloy	220	0.09	0.16	0.13	70	170	120
M	Austenitic	190	0.06	0.15	0.11	170	230	200
K	Grey Cast Iron	140	0.10	0.18	0.14	150	230	190