

Recommended Cutting Conditions : Holeshot Drill (DR)

Workpiece Material	Feed Rate (ipr)	Recommended Cutting Condition (Cutting Speed SFM)							Remarks
		Cermet	PVD Coated				MEGACOAT	Carbide	
		TN60	PR660	PR830	PR905	PR915	PR1230	KW10	
Low Carbon Steel	.0015-.0035	-	☆ 800~900	☆ 800~900	-	-	★ 800~900	-	Coolant
Carbon Steel	.005-.009	-	☆ 400~800	☆ 400~800	-	-	★ 400~800	-	
Alloy Steel	.004-.010	-	☆ 250~750	☆ 250~750	-	-	★ 250~750	-	
Tool Steel	.004-.010	-	☆ 250~750	☆ 250~750	-	-	★ 250~750	-	
Stainless Steel (Austenitic)	.0025-.006	-	☆ 200~600	☆ 200~600	-	-	★ 200~600	-	
Gray Cast Iron	.005-.011	-	-	-	★ 400~800	-	-	☆ 400~800	
Nodular Cast Iron (Ductile)	.004-.010	-	-	-	★ 300~500	-	-	☆ 300~500	
Non-ferrous Metal	.008-.010	☆ 1800~2000	-	-	-	-	-	★ 1800~2000	
Heat Resistant Alloy (Inconel 718)	.0010-.0015	-	-	☆ 75~150	-	☆ 100~150	★ 75~150	-	
Titanium Alloy	.0025-.0030	-	-	-	★ 100~210	★ 100~210	-	☆ 150~250	

★ : 1st Recommendation ☆ : 2nd Recommendation



Magic Drill DR

Drilling