



### Solid Carbide AlTiN Coated CNC 118° Point Center Drill, High Performance 60° Countersink

Material	Surface Feet Per Minute (SFM)	Chip Load Per Tooth				
		5/64" (2mm)	1/8" (3mm)	1/4" (6mm)	3/8" (10mm)	5/8" (16mm)
Steel: < 81 HRB (B)	400 - 600	0.0047"	0.0055"	0.0079"	0.0138"	0.0217"
Steel: < 24 Rc (C)	300 - 470	0.0047"	0.0055"	0.0079"	0.0138"	0.0217"
Steel: 24 - 32 Rc	200 - 350	0.0035"	0.0039"	0.0055"	0.0087"	0.0094"
Steel: 32 - 41 Rc	150 - 220	0.0035"	0.0039"	0.0055"	0.0087"	0.0094"
Stainless Steel/Titanium	90 - 130	0.0035"	0.0039"	0.0055"	0.0087"	0.0094"
Inconel/Nimonic/Waspaloy	80 - 110	0.0031"	0.0028"	0.0047"	0.0067"	0.0094"
Thermoplastics	1,500 - 2,050	0.0079"	0.0087"	0.0193"	0.0354"	0.0374"

Tool Reference #'s
51670
51672

#### Simple Machining Calculations:

To find **RPM**: (SFM x 3.82) / diameter of tool

To find **SFM**: 0.262 x diameter of tool x RPM

To find **Feed Rate IPM**: RPM x # of flutes x chip load

To find **Chip Load**: Feed Rate IPM / (RPM x # of Flutes)

**Depth of Cut:** 1 x D Use recommended chip load

2 x D Reduce chip load by 25%

3 x D Reduce chip load by 50%

**Disclaimer:** These values are based on test results. Your results may vary. It is important to understand that these values are only recommendations.