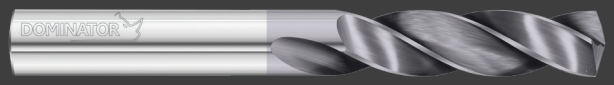
1505 NON-COOLANT DOMINATOR DRILL



FULLERTON

SPEEDS / FEEDS

Two 30° RH Spiral Flutes | 144° High Performance Point | Non-Coolant

		Imperial (in)						Metric (mm)					
		1/8	1/4	3/8	1/2	3/4	1	3	6	10	12	19	25
High Si Aluminum >10%	RPM	12,224	6,112	4,075	3,056	2,037	1,528	12,936	6,468	3,881	3,234	2,042	1,552
	IPM	49	43	37	31	29	24	1242	1087	931	776	724	621
	SFM	400	400	400	400	400	400	122	122	122	122	122	122
	IPR	.004	.007	.009	.010	.014	.016	0.10	0.17	0.24	0.24	0.35	0.40
Low Si Aluminum <10%	RPM	18,336	9,168	6,112	4,584	3,056	2,292	19,404	9,702	5,821	4,851	3,064	2,328
	IPM	73	64	55	46	43	37	1863	1630	1397	1164	1087	931
	SFM	600	600	600	600	600	600	183	183	183	183	183	183
	IPR	.004	.007	.009	.010	.014	.016	0.10	0.17	0.24	0.24	0.35	0.40
Brass & Copper	RPM	10,696	5,348	3,565	2,674	1,783	1,337	11,319	5,659	3,396	2,830	1,787	1,358
	IPM	43	32	29	27	21	19	1087	815	724	679	543	475
	SFM	350	350	350	350	350	350	107	107	107	107	107	107
	IPR	.004	.006	.008	.010	.012	.014	0.10	0.14	0.21	0.24	0.30	0.35
Graphite	RPM	15,280	7,640	5,093	3,820	2,547	1,910	16,170	8,085	4,851	4,042	2,553	1,940
	IPM	76	50	38	34	31	31	1940	1261	970	873	776	776
	SFM	500	500	500	500	500	500	152	152	152	152	152	152
	IPR	.005	.007	.008	.009	.012	.016	0.12	0.16	0.20	0.22	0.30	0.40
Cast Iron	RPM	10,696	5,348	3,565	2,674	1,783	1,337	11,319	5,659	3,396	2,830	1,787	1,358
	IPM	86	67	57	53	39	33	2173	1698	1449	1358	996	849
	SFM	350	350	350	350	350	350	107	107	107	107	107	107
	IPR	.008	.013	.016	.020	.022	.025	0.19	0.30	0.43	0.48	0.56	0.63
Hardened Steels >48RC	RPM	1,834	917	611	458	306	229	1,940	970	582	485	306	233
	IPM	4	3	2	2	2	1	93	70	62	58	39	29
	SFM	60	60	60	60	60	60	18	18	18	18	18	18
	IPR	.002	.003	.004	.005	.005	.005	0.05	0.07	0.11	0.12	0.13	0.13
Steels	RPM	3,667	1,834	1,222	917	611	458	3,881	1,940	1,164	970	613	466
	IPM	9	7	10	9	8	6	233	186	248	233	194	146
	SFM	120	120	120	120	120	120	37	37	37	37	37	37
	IPR	.003	.004	.008	.010	.013	.013	0.06	0.10	0.21	0.24	0.32	0.31
Stainless Steels	RPM	3,056	1,528	1,019	764	509	382	3,234	1,617	970	808	511	388
	IPM	8	5	5	5	4	3	194	136	129	126	103	78
	SFM	100	100	100	100	100	100	30	30	30	30	30	30
	IPR	.003	.004	.005	.007	.008	.008	0.06	0.08	0.13	0.16	0.20	0.20
Super Alloy (Nickel based Inconel)	RPM	1,834	917	611	458	306	229	1,940	970	582	485	306	233
	IPM	6	5	4	4	2	2	140	116	101	93	62	47
	SFM	60	60	60	60	60	60	18	18	18	18	18	18
	IPR	.003	.005	.007	.008	.008	.008	0.07	0.12	0.17	0.19	0.20	0.20
Titanium	RPM	3,056	1,528	1,019	764	509	382	3,234	1,617	970	808	511	388
	IPM	8	6	5	5	3	3	194	155	129	126	84	68
	SFM	100	100	100	100	100	100	30	30	30	30	30	30
	IPR	.003	.004	.005	.007	.007	.007	0.06	0.10	0.13	0.16	0.16	0.18

Composites are only recommended in unique situations. The parameters listed for tool series that are stocked uncoated are based on running an uncoated tool. If a coating is applied to the tools, the SFM can be increased by approximately 25%. All speed and feed recommendations should be considered only as a starting point. Start with conservative speeds and feeds while analyzing the rigidity of the process. Then cautiously progress incrementally to achieve optimum performance.