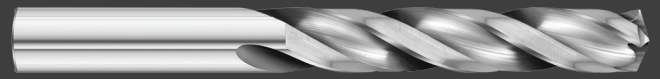


# 1540 DRILL



## **FULLERTON** S P E E D S / F E E D S

### Three 30° RH Spiral Flutes | 150° Thinned Point

		Imperial (in)						Metric (mm)					
		1/8	1/4	3/8	1/2	3/4	1	3	6	10	12	19	25
Cast Iron	RPM	9,168	4,584	3,056	2,292	1,528	1,146	9,702	4,851	2,911	2,425	1,532	1,164
	IPM	37	28	24	23	18	16	931	699	621	582	466	407
	SFM	300	300	300	300	300	300	91	91	91	91	91	91
	IPR	.004	.006	.008	.010	.012	.014	0.10	0.14	0.21	0.24	0.30	0.35
Steels	RPM	4,890	2,445	1,630	1,222	815	611	5,174	2,587	1,552	1,294	817	621
	IPM	15	12	10	10	8	7	373	310	248	248	207	186
	SFM	160	160	160	160	160	160	49	49	49	49	49	49
	IPR	.003	.005	.006	.008	.010	.012	0.07	0.12	0.16	0.19	0.25	0.30

Not Recommended for High Si Aluminum >10%, Low Si Aluminum <10%, Composites, Plastics, Brass & Copper, Graphite, Hardened Steels >48 RC, Stainless Steels, Super Alloy (Nickel based, Inconel), or Titanium.  
 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.