5566 POLYDRILL

FULLERTON

SPEEDS / FEEDS

5566 Series PolyDrill's three-flute design allows for ultimate material removal rates and burr teeth provide a clean shearing of fibers.

FLUTE DIAMETER	CARBON, CARBON GRAPHITE, UNFILLED PLASTICS				COMPOSITES				FIBER REINFORCED PLASTICS				GREEN CERAMICS, GREEN CARBIDE			
	Speed (SFM)		Feed (IPR)		Speed (SFM)		Feed (IPR)		Speed (SFM)		Feed (IPR)		Speed (SFM)		Feed (IPR)	
1/8"	500	2400	0.0015	0.004	400	1400	0.0008	0.002	500	1600	0.0008	0.002	300	1200	0.0008	0.0025
3/16"	800	2400	0.0025	0.004	400	1400	0.001	0.0025	800	1600	0.001	0.0025	300	1200	0.0015	0.003
1/4"	800	2400	0.003	0.005	400	1400	0.0015	0.003	800	1600	0.0015	0.003	300	1200	0.0025	0.004
5/16"	800	2400	0.004	0.0055	400	1400	0.003	0.005	800	1600	0.003	0.005	300	1200	0.003	0.005
3/8"	800	2400	0.005	0.008	400	1400	0.004	0.0065	800	1600	0.004	0.0065	300	1200	0.005	0.007
1/2"	800	2400	0.006	0.009	400	1400	0.006	0.009	800	1600	0.0065	0.012	300	1200	0.0065	0.008

FLUTE DIAMETER	CARBON, CARBON GRAPHITE, UNFILLED PLASTICS				COMPOSITES				FIBER REINFORCED PLASTICS				GREEN CERAMICS, GREEN CARBIDE			
	Speed (SMM)		Feed (MMPR)		Speed (SMM)		Feed (MMPR)		Speed (SMM)		Feed (MMPR)		Speed (SMM)		Feed (MMPR)	
3.00	152	732	0.038	0.102	122	427	0.020	0.051	152	732	0.038	0.102	152	732	0.038	0.102
5.00	244	732	0.064	0.102	122	427	0.025	0.064	244	732	0.064	0.102	244	732	0.064	0.102
6.00	244	732	0.076	0.127	122	427	0.038	0.076	244	732	0.076	0.127	244	732	0.076	0.127
8.00	244	732	0.102	0.140	122	427	0.076	0.127	244	732	0.102	0.140	244	732	0.102	0.140
10.00	244	732	0.127	0.203	122	427	0.102	0.165	244	732	0.127	0.203	244	732	0.127	0.203
12.00	244	732	0.152	0.229	122	427	0.152	0.229	244	732	0.152	0.229	244	732	0.152	0.229

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.