

Speed & Feed Guide



Series 4005

PAC Drill | 2 FL | 5xD | Solid | Inch & Metric

Work Material	P						M				K				N			
	Carbon Steel		Alloy Steel		Tool Steel		300 & 400 SS		PH SS		Gray		Ductile		6061, 7075		> 10% Si	
SFM	220 - 350		210 - 315		205 - 295		130 - 200		120 - 190		235-390		170 - 300		300 - 460		330 - 385	
Drill Dia.	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR	RPM	IPR
	mm	inch																
1	23287	0.0008	21346	0.0008	20376	0.0008	15524	0.0006	14554	0.0006	26683	0.0008	22802	0.0008	33960	0.0014	32019	0.0014
	1/16	14669	0.0013	13446	0.0013	12835	0.0013	9779	0.0009	9168	0.0009	16808	0.0013	14363	0.0013	21392	0.0022	20170
2	11643	0.0016	10673	0.0016	10188	0.0016	7762	0.0012	7277	0.0012	13341	0.0016	11401	0.0016	16980	0.0028	16010	0.0028
	3/32	9779	0.0019	8964	0.0019	8557	0.0019	6519	0.0014	6112	0.0014	11205	0.0019	9575	0.0019	14261	0.0033	13446
3	7762	0.0024	7115	0.0024	6792	0.0024	5175	0.0018	4851	0.0018	8894	0.0024	7601	0.0024	11320	0.0041	10673	0.0041
	1/8	7334	0.0025	6723	0.0025	6418	0.0025	4890	0.0019	4584	0.0019	8404	0.0025	7182	0.0025	10696	0.0044	10085
4	5822	0.0031	5337	0.0031	5094	0.0031	3881	0.0024	3639	0.0024	6671	0.0031	5700	0.0031	8490	0.0055	8005	0.0055
	3/16	4890	0.0038	4482	0.0038	4278	0.0038	3260	0.0028	3056	0.0028	5603	0.0038	4788	0.0038	7131	0.0066	6723
6	3881	0.0047	3558	0.0047	3396	0.0047	2587	0.0035	2426	0.0035	4447	0.0047	3800	0.0047	5660	0.0083	5337	0.0083
	1/4	3667	0.0050	3362	0.0050	3209	0.0050	2445	0.0038	2292	0.0038	4202	0.0050	3591	0.0050	5348	0.0088	5042
8	2911	0.0063	2668	0.0063	2547	0.0063	1941	0.0047	1819	0.0047	3335	0.0063	2850	0.0063	4245	0.0110	4002	0.0110
	3/8	2445	0.0075	2241	0.0075	2139	0.0075	1630	0.0056	1528	0.0056	2801	0.0075	2394	0.0075	3565	0.0131	3362
10	2329	0.0079	2135	0.0079	2038	0.0079	1552	0.0059	1455	0.0059	2668	0.0079	2280	0.0079	3396	0.0138	3202	0.0138
	7/16	2096	0.0088	1921	0.0088	1834	0.0088	1397	0.0066	1310	0.0066	2401	0.0088	2052	0.0088	3056	0.0153	2881
12	1941	0.0094	1779	0.0094	1698	0.0094	1294	0.0071	1213	0.0071	2224	0.0094	1900	0.0094	2830	0.0165	2668	0.0165
	1/2	1834	0.0100	1681	0.0100	1604	0.0100	1222	0.0075	1146	0.0075	2101	0.0100	1795	0.0100	2674	0.0175	2521
14	1663	0.0110	1525	0.0110	1455	0.0110	1109	0.0083	1040	0.0083	1906	0.0110	1629	0.0110	2426	0.0193	2287	0.0193
	5/8	1467	0.0125	1345	0.0125	1284	0.0125	978	0.0094	917	0.0094	1681	0.0125	1436	0.0125	2139	0.0219	2017
18	1294	0.0142	1186	0.0142	1132	0.0142	862	0.0106	809	0.0106	1482	0.0142	1267	0.0142	1887	0.0248	1779	0.0248