

Series 300, 400, 402

2 FL | Spot Drill | Spade Drill | Combination Drill

Material		Hardness	SFM	(IPR) Cutting Tool Diameter						
				1/32	1/16	1/8	1/4	3/8	1/2	
P	Steel	Free Machining & Low Carbon: 10XX, 11XX, 12XX, A36	≤ 28 Rc	175	0.0005	0.0010	0.0015	0.0030	0.0040	0.0050
	Steel	Medium/High Carbon Steels, Alloy Steels: 13XX, 41XX, 43XX, 86XX	28-38 Rc	165						
	Die Steels	A2, H13, L6, P20, S7	28-44 Rc	150						
M	Stainless Steels	Easy to Machine, 430F, 301, 303, 410, 416 Annealed, 420F, 430, 430F	≤ 28 Rc	125						
	Stainless Steels	Moderately Difficult to Machine, Nitronic 50, 301, 303, 304, 304L, 316, 316L, 321, 347	≤ 28 Rc	60						
S	Super Alloys	High Temp, Nimonics, Inconel, Monel, Hastelloy	≤ 42 Rc	40						
	Super Alloys	Titanium: Ti 3Al-2.5V, Ti 6Al-4V Ti 10V-2Fe-3Al	≤ 42 Rc	80						
H	Hardened Steels	-	35-45 Rc	50						
K	Cast Iron	Gray: SAE J431, ASTM A48	160-200 HB	275						
	Cast Iron	Ductile & Malleable, ASTM A536, ASTM 897, ASTM A47, ASTM A220	200-250 HB	175						