High Performance Carbide Drills for Aluminum Speed and Feed Recommendations

List No. 5604 Non-Coolant-Through Drills

Material	Drilling Depth	Surface Speed (SFM)	Feed in Inches Per Revolution by Drill Diameter (IPR)					
			Inch Sizes					
			< .1181	.1181 - .1969	.1970 - .3150	.3151 - .4724	.4725 - .6299	.6300 - .7874
			Metric Sizes					
			< 3.0	≥ 3.0 ≤ 5.0	> 5.0 ≤ 8.0	> 8.0 ≤ 12.0	> 12.0 ≤ 16.0	> 16.0 ≤ 20.0
Wrought Aluminum Alloys	3xD	1070	200-250 SFM 1.5mm at .005 IPR 2.0mm at .007 IPR 2.5mm at .009 IPR	.012	.015	.019	.023	.025
	5xD	1005						
Low Silicon Aluminum Alloys < 12%	3xD	1070	390-500 SFM 1.5mm at .002 IPR 2.0mm at .003 IPR 2.5mm at .004 IPR	.013	.017	.022	.025	.027
	5xD	1005						
High Silicon Aluminum Alloys > 12%	3xD	1040	390-500 SFM 1.5mm at .002 IPR 2.0mm at .003 IPR 2.5mm at .004 IPR	.011	.015	.019	.023	.025
	5xD	975						
Copper & Copper Alloys	3xD	510	Not Recommended	.009	.011	.015	.015	.021
	5xD	445						

Speeds and Feeds are suggested starting points and may be increased or decreased depending on actual material and machining conditions.

NOTE: Information in this chart is for reference only. We will not be held liable for any consequential damages or economic loss due to the use of information contained within this chart.