

High Performance Carbide Drills for Aluminum

Speed and Feed Recommendations

List No. 5605 Coolant-Through Drills

Material	Drilling Depth	Surface Speed (SFM)	Feed in Inches Per Revolution by Drill Diameter (IPR)				
			Inch Sizes				
			.1181 - .1969	.1970 - .3150	.3151 - .4724	.4725 - .6299	.6300 - .7874
			Metric Sizes				
			≥ 3.0 ≤ 5.0	> 5.0 ≤ 8.0	> 8.0 ≤ 12.0	> 12.0 ≤ 16.0	> 16.0 ≤ 20.0
Wrought Aluminum Alloys	3xD	1115	.012	.015	.019	.023	.025
	5xD	1180					
	12xD	820					
Low Silicon Aluminum Alloys < 12%	3xD	1115	.013	.017	.022	.025	.027
	5xD	1180					
	12xD	820					
High Silicon Aluminum Alloys > 12%	3xD	1065	.011	.015	.019	.023	.025
	5xD	1145					
	12xD	800					
Copper & Copper Alloys	3xD	515	.009	.011	.015	.015	.021
	5xD	525					
	12xD	390					

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.