



Speeds and Feeds for G3 **series Drills**. Solid carbide with 130 deg split point, TiAlCN coated.

Material	Hardness		Feed Per Rev.					
	Bhn	SFM	5/32"dia	1/4"	3/8"	1/2"	3/4"	1"
Aluminum 2011,2024,6061,7075	--	500	.0045	.0065	.0075	.0085	.01	.012
Free Machining 12L14, 1215,11L17	80-150	320	.004	.0055	.007	.008	.0095	.0011
Low Carbon Steel 1008, 1018, 1020	125-175	220	.0035	.0047	.0055	.0065	.0075	.009
Medium Carbon Steel 4140, 8620	200-280	170	.003	.0045	.0055	.0065	.0075	.009
Tool Steel, H.S.S A2,D2,M2,M42	300-400	110	.0025	.0035	.004	.0045	.0058	.007
Cast Iron	120-175	300	.0045	.0055	.007	.008	.0095	.011
Stainless Steel 300 Series	160-200	140	.003	.004	.0055	.0065	.0075	.009
Stainless Steel 400 Series	180-260	150	.003	.004	.0055	.0065	.0075	.009
Stainless Steel 15-5, 17-4	160-200	110	.003	.004	.0055	.0065	.0075	.009
Titanium 6AL-4V	320-280	50	.003	.0035	.005	.006	.007	.0075
Inconel 625, 718	280-320	50	.0028	.003	.0045	.005	.005	.006
Copper, Bronze	120-160	230	.004	.005	.006	.007	.009	.01
Brass (360 half hard)	--	500	.0045	.0065	.008	.0085	.01	.012

General pecking-- 1st peck after 2.0-1.5 X drill diameter, all other pecks 1X diameter.

Feed Per Rev. is based on standard cutting conditions

Feedrates can be increased up to 30% if cutting conditions are favorable.

6 guidelines for best cutting results

keep tip runout less than .001	Make sure drill is perpendicular	Follow Pecking Guide
workpiece rigidity is important	Use quality tool holder and collet	Provide high coolant flow

Note: Cutting speeds, feeds, and lubrication data are given as starting values only. Parameters should be varied to suite your particular conditions. MariTool is constantly improving products, tolerances, and reliability. As such, these speeds and feeds are subject to change without prior notice. Cutting tools may shatter and or produce dangerous fumes when being used. Appropriate protection is advised.

Rev A