



Twister® HP

Recommended Cutting Data 207CE - Inch


Workpiece Material Group	I S O	Tool Series	T Y P E	D E P T H	Speed - (SFM) Surface Feed Per minute	Drill Diameter			
						1/8	1/4	3/8	1/2
						Feed - (IPR) Inch per Rev			
Plastics	N	207CE		3	330	.002	.004	.005	.006
Kevlar/Graphite	N			3	420	.002	.004	.005	.006

Recommended Cutting Data 207CE - Metric


Workpiece Material Group	I S O	Tool Series	T Y P E	D E P T H	Speed Vc- (m/min) Meters Per minute	Drill Diameter			
						3.0	6.0	10.0	12.0
						Feed - (mm/rev) millimeters per Rev			
Plastics	N	207CE		3	100	.05	.10	.13	.15
Kevlar/Graphite	N			3	125	.05	.10	.13	.15

Twister® AL

Recommended Cutting Data 229 - Inch

Workpiece Material Group	I S O	T Y P E	D E P T H	vc - SFM	Drill Diameter				
					3/64	3/16	1/4	1/2	3/4
					f - IPR				
Non-Ferrous - Al < 14% Si	N		5	700	.003	.007	.012	.017	.024
Non-Ferrous - Al > 14% Si	N		5	500	.002	.003	.006	.009	.012
Non-Ferrous - Brass	N		5	400	.002	.003	.006	.009	.012
Non-Ferrous - Cu/Cu Alloys/Magnesium	N		5	300	.002	.003	.006	.009	.012

Recommended Cutting Data 229 - Metric

Workpiece Material Group	I S O	T Y P E	D E P T H	vc - m/min	Drill Diameter (mm)				
					1.5	3	6	12	20
					f - mm/Rev				
Non-Ferrous - Al < 14% Si	N		5	215	.080	.200	.310	.450	.610
Non-Ferrous - Al > 14% Si	N		5	155	.050	.080	.150	.250	.310
Non-Ferrous - Brass	N		5	120	.050	.080	.150	.250	.310
Non-Ferrous - Cu/Cu Alloys/Magnesium	N		5	90	.050	.080	.150	.250	.310

Technical data provided should be considered advisory only as variations may be necessary depending on the particular application.

For product information, call your local distributor.