

Twister® GP

224 / 226 Series Recommended Cutting Data - Metric 5xD & 3xD, Solid Drilling

Recommended Speeds By Material Group		Uncoated			ALtima® Coated			
Workpiece Material Group	Material Type	3-5xD Solid			3-5xD Solid			
		Low	Mid	High	Low	Mid	High	
		Vc - M/Min			Vc - M/Min			
Steels	P	Low Carbon	45	55	65	60	70	80
		Medium Carbon	40	50	60	55	65	75
		Alloy Steels (≤ 35 HRC)	40	50	60	55	65	75
		Die / Tool Steels (≤ 45 HRC)	35	45	55	50	60	70
Stainless Steels	M	Free Machining		N/A		50	60	70
		Austenitic		N/A		45	50	60
Cast Irons	K	Gray		N/A		100	110	120
		Ductile & Malleable		N/A		60	70	80
Non-Ferrous	N	Aluminum - Wrought (≤ 10% Si)	120	135	150		N/A	
		Aluminum - Cast (> 10% Si)	90	105	120		N/A	
		Copper / Copper Alloys	60	75	90		N/A	
		Brass	120	135	150		N/A	
		Plastics	120	135	150		N/A	
		Kevlar / Graphite	105	120	135		N/A	

Recommended Feeds By Material Group		Drill Diameter (mm)								
Workpiece Material Group	Material Type	1	1.5	3	6	10	12	16	20	
		Feed (mm/rev)								
Steels	P	Low Carbon	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
		Medium Carbon	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
		Alloy Steels (≤ 35 HRC)	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
		Die / Tool Steels (≤ 45 HRC)	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
Stainless Steels	M	Free Machining	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
		Austenitic	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
Cast Irons	K	Gray	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
		Ductile & Malleable	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320
Non-Ferrous	N	Aluminum - Wrought (≤ 10% Si)	0.025	0.038	0.075	0.150	0.250	0.300	0.400	0.500
		Aluminum - Cast (> 10% Si)	0.025	0.038	0.075	0.150	0.250	0.300	0.400	0.500
		Copper / Copper Alloys	0.025	0.038	0.075	0.150	0.250	0.300	0.400	0.500
		Brass	0.025	0.038	0.075	0.150	0.250	0.300	0.400	0.500
		Plastics	0.030	0.045	0.090	0.180	0.300	0.360	0.480	0.600
		Kevlar / Graphite	0.016	0.024	0.048	0.096	0.160	0.192	0.256	0.320

Note: .5 to 1xD pecking may be required in difficult-to-machine/long chipping materials, or when exceeding 3xD hole depths.

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

