Twister® AL

229 Series Recommended Cutting Data - **Inch** 5xD, Solid Drilling

Workpiece Material Group	ISO	TYPE	DEPTH	vc - SFM	Drill Diameter (Inch)				
					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

229 Series Recommended Cutting Data - **Metric** 5xD, Solid Drilling

Workpiece Material Group	ISO	TYPE	DEPTH	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.