

Twister® GP

300 Series Recommended Cutting Data - Inch

Workpiece Material Group	I S O	Hardness	T Y P E	vc - SFM	Drill Diameter (Inch)					
					1/64	1/32	1/16	1/8	3/16	1/4
					f - IPR					
Free Machining & Low Carbon Steels 1006, 1008, 1015, 1018, 1020, 1022, 1025, 1117, 1140, 1141, 11L08, 11L14, 1213, 12L13, 12L14, 1215, 1330	P	up to 28 Rc		175	.0007	.0010	.0020	.0030	.0040	.0060
Medium Carbon & High Carbon Steels, Alloy Steels & Easy to Machine Tool Steels 1030, 1035, 1040, 1045, 1050, 1052, 1055, 1060, 1085, 1095, 1541, 1551, 9255, 2515, 3135, 3415, 4130, 4137, 4140, 4150, 4320, 4340, 4520, 5015, 5115, 5120, 5132, 5140, 5155, 6150, 8620, 9262, 9840, 52100, O1, O2, O6, S2, W1 to W310	P	28 to 38 Rc	●	150	.0007	.0010	.0020	.0030	.0040	.0060
Aluminum (<10% Si) 6061-T6 / 7075-T6	N			400	.0007	.0010	.0020	.0030	.0040	.0060
Aluminum (>10% Si) Copper / Brass	N		●	250	.0007	.0010	.0020	.0030	.0040	.0060
Plastics	N			300	.0007	.0010	.0020	.0030	.0040	.0060
Cast Iron - Gray CG, ASTM A48, CLASS 20, 25, 30, 35, SAE J431C, GRADES G1800, G3000, G3500, GG 10, 15, 20, 25, 30, 35, 40	K	up to 240 HB		275	.0007	.0010	.0020	.0030	.0040	.0060
Cast Iron - Ductile & Malleable CGI 60-40-18, 65-45-12, D4018, D4512, D5506, 32510, 35108, M3210, M4504, M5503, 250, 300, 350, 400, 450	K	over 240 HB	●	175	.0007	.0010	.0020	.0030	.0040	.0060

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

Twister® GP

300 Series Recommended Cutting Data - Metric

Workpiece Material Group	ISO	Hardness	TYPE	vc - m/min	Drill Diameter (mm)			
					0.5	1	2	3
					f - mm/Rev			
Free Machining & Low Carbon Steels 1006, 1008, 1015, 1018, 1020, 1022, 1025, 1117, 1140, 1141, 11L08, 11L14, 1213, 12L13, 12L14, 1215, 1330	P	up to 28 Rc		55	.017	.025	.050	.076
Medium Carbon & High Carbon Steels, Alloy Steels & Easy to Machine Tool Steels 1030, 1035, 1040, 1045, 1050, 1052, 1055, 1060, 1085, 1095, 1541, 1551, 9255, 2515, 3135, 3415, 4130, 4137, 4140, 4150, 4320, 4340, 4520, 5015, 5115, 5120, 5132, 5140, 5155, 6150, 8620, 9262, 9840, 52100, O1, O2, O6, S2, W1 to W310	P	28 to 38 Rc	●	45	.017	.025	.050	.076
Aluminum (<10% Si) 6061-T6 / 7075-T6	N			120	.017	.025	.050	.076
Aluminum (>10% Si) Copper / Brass	N		●	75	.017	.025	.050	.076
Plastics	N			90	.017	.025	.050	.076
Cast Iron - Gray CG, ASTM A48, CLASS 20, 25, 30, 35, SAE J431C, GRADES G1800, G3000, G3500, GG 10, 15, 20, 25, 30, 35, 40	K	up to 240 HB		85	.017	.025	.050	.076
Cast Iron - Ductile & Malleable CGI 60-40-18, 65-45-12, D4018, 4512, D5506, 32510, 35108, M3210, M4504, M5503, 250, 300, 350, 400, 450	K	over 240 HB	●	55	.017	.025	.050	.076



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