

Twister® GP

204 / 206 Series Recommended Cutting Data - Inch 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 - SFM			Vc - SFM			
Steels	P	Low Carbon	150	180	210	200	230	260
		Medium Carbon	130	160	190	180	210	240
		Alloy Steels (≤ 35 HRC)	130	160	190	180	210	240
		Die / Tool Steels (≤ 45 HRC)	120	150	180	170	200	230
Stainless Steels	M	Free Machining		N/A		170	200	230
		Austenitic		N/A		140	170	200
Cast Irons	K	Gray		N/A		330	360	390
		Ductile & Malleable		N/A		200	230	260
Non-Ferrous	N	Aluminum - Wrought (≤ 10% Si)	400	450	500		N/A	
		Aluminum - Cast (> 10% Si)	300	350	400		N/A	
		Copper / Copper Alloys	200	250	300		N/A	
		Brass	400	450	500		N/A	
		Plastics	400	450	500		N/A	
		Kevlar / Graphite	350	400	450		N/A	

Drills - Technical Information
Series 204 / 206

Recommended Feeds By Material Group		Drill Diameter (inch)								
Workpiece Material Group	Material Type	1/32	1/16	1/8	1/4	3/8	1/2	5/8	3/4	
		Feed (in/rev)								
Steels	P	Low Carbon	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
		Medium Carbon	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
		Alloy Steels (≤ 35 HRC)	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
		Die / Tool Steels (≤ 45 HRC)	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
Stainless Steels	M	Free Machining	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
		Austenitic	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
Cast Irons	K	Gray	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
		Ductile & Malleable	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120
Non-Ferrous	N	Aluminum - Wrought (≤ 10% Si)	.0008	.0016	.0031	.0063	.0094	.0125	.0156	.0188
		Aluminum - Cast (> 10% Si)	.0008	.0016	.0031	.0063	.0094	.0125	.0156	.0188
		Copper / Copper Alloys	.0008	.0016	.0031	.0063	.0094	.0125	.0156	.0188
		Brass	.0008	.0016	.0031	.0063	.0094	.0125	.0156	.0188
		Plastics	.0009	.0019	.0038	.0075	.0113	.0150	.0188	.0225
		Kevlar / Graphite	.0005	.0010	.0020	.0040	.0060	.0080	.0100	.0120

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.