

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 |