



## List 5630 - EXOPRO® Mega Muscle®: 10D

### General Drilling Operations

Work Material		Carbon Steels, Mild Steels 1010, 1050, 12L14		Alloy Steels 4140, 4130		Cast Iron		Ductile Cast Iron		Cast Aluminum	
Drilling Speed		260-395 SFM		200-295 SFM		260-395 SFM		195-330 SFM		260-660 SFM	
Drill Dia.		Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR
mm	Inch										
5	-	6,350	0.007 - 0.009	5,750	0.007 - 0.009	6,350	0.007 - 0.011	5,100	0.007 - 0.009	8,900	0.008 - 0.016
6	-	5,300	0.008 - 0.011	4,800	0.008 - 0.011	5,300	0.008 - 0.014	4,200	0.008 - 0.011	7,400	0.009 - 0.019
-	1/4	5,000	0.009 - 0.012	4,550	0.009 - 0.012	5,000	0.009 - 0.016	4,000	0.007 - 0.012	7,000	0.010 - 0.020
8	-	4,000	0.011 - 0.015	3,600	0.011 - 0.015	4,000	0.011 - 0.018	3,200	0.009 - 0.015	5,600	0.013 - 0.025
-	3/8	3,300	0.012 - 0.017	3,050	0.012 - 0.017	3,300	0.012 - 0.020	2,700	0.012 - 0.017	4,700	0.015 - 0.030
10	-	3,200	0.013 - 0.019	2,900	0.013 - 0.019	3,200	0.013 - 0.023	2,500	0.012 - 0.019	4,500	0.016 - 0.031
-	7/16	2,900	0.014 - 0.021	2,600	0.014 - 0.021	2,900	0.014 - 0.025	2,300	0.013 - 0.021	4,000	0.017 - 0.035
12	-	2,700	0.016 - 0.023	2,400	0.016 - 0.023	2,700	0.016 - 0.028	2,100	0.014 - 0.023	3,700	0.019 - 0.038
-	1/2	2,500	0.016 - 0.024	2,250	0.016 - 0.024	2,500	0.016 - 0.028	2,000	0.015 - 0.024	3,500	0.020 - 0.040
14	-	2,300	0.017 - 0.026	2,050	0.017 - 0.026	2,300	0.017 - 0.029	1,800	0.017 - 0.026	3,200	0.022 - 0.044
-	5/8	2,000	0.018 - 0.029	1,800	0.018 - 0.029	2,000	0.018 - 0.030	1,600	0.019 - 0.029	2,800	0.025 - 0.050

### General Drilling Operations

Work Material		Special Alloy Steels, Hardened Steels			
Hardness		26-30 HRC		30-34 HRC	
Drilling Speed		195-295 SFM		160-230 SFM	
Drill Dia.		Speed RPM	Feed IPR	Speed RPM	Feed IPR
mm	Inch				
5	-	4,750	0.006 - 0.007	3,750	0.005 - 0.007
6	-	4,000	0.007 - 0.010	3,200	0.007 - 0.010
-	1/4	3,700	0.007 - 0.010	3,000	0.007 - 0.010
8	-	3,000	0.009 - 0.014	2,400	0.009 - 0.014
-	3/8	2,500	0.011 - 0.017	2,000	0.011 - 0.017
10	-	2,400	0.012 - 0.018	1,900	0.012 - 0.018
-	7/16	2,100	0.013 - 0.020	1,700	0.013 - 0.020
12	-	2,000	0.014 - 0.022	1,600	0.014 - 0.022
-	1/2	1,900	0.015 - 0.022	1,500	0.015 - 0.022
14	-	1,700	0.017 - 0.023	1,350	0.017 - 0.023
-	5/8	1,500	0.019 - 0.024	1,200	0.018 - 0.023

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