

List HP343 - HY-PRO® CARB ALD: 3D

General Drilling Operations

Work Material		Aluminum Alloy		Cast Aluminum		Copper Alloy		Magnesium Alloy	
Drilling Speed		260 - 500 SFM		260- 650 SFM		130 - 330 SFM		200 - 330 SFM	
Drill Dia.		Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR
mm	Inch								
1	-	25,000	0.0008 - 0.0020	25,000	0.0008 - 0.0031	22,300	0.0003 - 0.0008	25,000	0.0008 - 0.0020
-	1/16	23,100	0.0012 - 0.0031	25,000	0.0012 - 0.0051	14,000	0.0004 - 0.0012	16,000	0.0012 - 0.0031
2	-	18,300	0.0016 - 0.0039	22,300	0.0016 - 0.0063	11,100	0.0006 - 0.0016	12,700	0.0016 - 0.0039
-	3/32	15,400	0.0020 - 0.0047	18,700	0.0020 - 0.0075	9,400	0.0008 - 0.0020	10,700	0.0020 - 0.0047
3	-	12,200	0.0024 - 0.0060	14,900	0.0024 - 0.0094	7,400	0.0009 - 0.0024	8,500	0.0024 - 0.0060
-	1/8	11,500	0.0024 - 0.0063	14,000	0.0024 - 0.0098	7,000	0.0012 - 0.0024	8,000	0.0024 - 0.0063
4	-	9,200	0.0031 - 0.0079	11,100	0.0031 - 0.0126	5,600	0.0013 - 0.0031	6,400	0.0031 - 0.0079
-	3/16	7,700	0.0039 - 0.0094	9,400	0.0039 - 0.0150	4,700	0.0016 - 0.0039	5,300	0.0039 - 0.0094
6	-	6,100	0.0047 - 0.0118	7,400	0.0047 - 0.0189	3,700	0.0019 - 0.0047	4,200	0.0047 - 0.0118
-	1/4	5,800	0.0051 - 0.0126	7,000	0.0051 - 0.0201	3,500	0.0020 - 0.0051	4,000	0.0051 - 0.0126
8	-	4,600	0.0063 - 0.0157	5,600	0.0063 - 0.0252	2,800	0.0025 - 0.0063	3,200	0.0063 - 0.0157
-	3/8	3,800	0.0075 - 0.0189	4,700	0.0075 - 0.0299	2,300	0.0031 - 0.0075	2,700	0.0075 - 0.0189
10	-	3,700	0.0079 - 0.0197	4,500	0.0079 - 0.0315	2,200	0.0031 - 0.0079	2,500	0.0079 - 0.0197
-	7/16	3,300	0.0087 - 0.0220	4,000	0.0087 - 0.0350	2,000	0.0035 - 0.0087	2,300	0.0087 - 0.0220
12	-	3,100	0.0094 - 0.0236	3,700	0.0094 - 0.0378	1,900	0.0038 - 0.0084	2,100	0.0094 - 0.0236
-	1/2	2,900	0.0098 - 0.0252	3,500	0.0098 - 0.0402	1,800	0.0039 - 0.0098	2,000	0.0098 - 0.0252

