

Drilling

Diameter *
 SFPM *
RPM = 919
Revolutions per minute

IPM
 Drill Area
Drilling MRR 11.96

Drill Diameter
 IPR
 SFPM
 "Kc" of Material *
 Machine Efficiency *
Drill Horse Power 8.29

Drill Diameter
 IPR
 "Kc" of Material
Pounds Of Thrust

Number of Edges *
 IPR *
 RPM
IPM = 9.744
Inches per minute

Drill Diameter
Drill Area 1.227

HP
 RPM
Torque 47.35
in Foot / Pounds

Feed per Tooth
 1/2 Point Angle *
 Sin of angle
Normal Chip Thickness 0.0033

Steels

Mat.	"Kc"	"Mc"	"P"	"key"
1	196,000	0.21	0.33	1010
2	218,000	0.22	0.38	1018
3	218,000	0.25	0.5	1045
4	247,000	0.24	0.78	4340
5	276,000	0.24	0.93	P2-P20
6	290,000	0.24	0.97	A2-D2
7	421,000	0.22	1	harder

Stainless Steels

8	254,000	0.22	0.44	304
9	276,000	0.2	0.47	316
10	297,000	0.2	0.54	310
11	312,000	0.2	0.82	17-4ph

Cast Iron

12	167,000	0.22	0.33	med
13	178,000	0.25	0.5	mal
14	196,000	0.28	0.65	ductile
15	213,000	0.3	0.83	white

Aluminum & Non Ferrous

16	101,000	0.25	0.25	<16%
17	101,000	0.27	0.33	>16%

Nickel Alloys

20	377,000	0.24	1	625-Monel
21	479,000	0.24	1.12	718

Titanium

22	210,000	0.23	0.65	6al4v
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