



Product Table: Miniature High Performance Drills - Prehardened Steels
Characteristics: 3x-5x Length of Flute
Series: BVTxxx-C3, DHExxx-C3

Product Notes:

- Pecking cycles are recommended to avoid chip packing and breakage.
- For steels at 29-37 Rc, an initial peck should be 2-3x Diameter, and each subsequent peck should be 1-2x Diameter.
 - For harder steels at 38-45 Rc, 1-2x Diameter is recommended for an initial peck, and each subsequent peck should be .5-1x Diameter.

General Notes:

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions.

If you require additional information, Harvey Tool has a team of technical experts available to assist you through even the most challenging applications. Please contact us at **800-645-5609** or **Harveytech@harveyperformance.com**.

WARNING: Cutting tools may shatter under improper use. Government regulations require use of safety glasses and other appropriate safety equipment in the vicinity of use.

MATERIAL	Hardness: 29-37 Rc (279-344 HBn)									
	SFM	Chip Load (IPR - Inches Per Revolution) By Drill Diameter								
		0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250
CARBON STEELS Free-Machining/Low Carbon steels, 10xx 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	240	.00063	.00130	.00197	.00260	.00328	.00391	.00525	.00785	.01050
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xxx, 3xxx, 4xxx & 4xLxx, 5xxx & 5xLxx, 50xxx & 50Lxx, 51xxx & 51Lxx, 52xxx & 52Lxx, 6xxx, 8xxx, 9xxx	150	.00058	.00119	.00180	.00238	.00300	.00357	.00480	.00718	.00960
STAINLESS STEELS 203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	180	.00063	.00130	.00197	.00260	.00328	.00391	.00525	.00785	.01050
201, 202, 203, 205, 301, 302, 304, 304L, 308, 309, 310, 314, 316, 316L, 317, 321, 329, 330, 347, 348, 385, 403, 405, 409, 410, 413, 420, 429, 430, 434, 436, 442, 446, 501, 502	150	.00058	.00119	.00180	.00238	.00300	.00357	.00480	.00718	.00960
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	125	.00036	.00074	.00113	.00149	.00187	.00223	.00300	.00449	.00600
TOOL STEELS A, L, O, P, W series	125	.00058	.00119	.00180	.00238	.00300	.00357	.00480	.00718	.00960
D, H, M, T, S series	90	.00036	.00074	.00113	.00149	.00187	.00223	.00300	.00449	.00600
TITANIUM ALLOYS	100	.00036	.00074	.00113	.00149	.00187	.00223	.00300	.00449	.00600
HIGH TEMP ALLOYS Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discolloy, Incoloy	70	.00036	.00074	.00113	.00149	.00187	.00223	.00300	.00449	.00600

MATERIAL	Hardness: 38-45 Rc (353-421 HBn)									
	SFM	Chip Load (IPR - Inches Per Revolution) By Drill Diameter								
		0.015	0.031	0.047	0.062	0.078	0.093	0.125	0.187	0.250
-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-
100	.00046	.00095	.00144	.00190	.00240	.00286	.00384	.00574	.00768	
90	.00029	.00060	.00090	.00119	.00150	.00179	.00240	.00359	.00480	
100	.00046	.00095	.00144	.00190	.00240	.00286	.00384	.00574	.00768	
75	.00029	.00060	.00090	.00119	.00150	.00179	.00240	.00359	.00480	
75	.00029	.00060	.00090	.00119	.00150	.00179	.00240	.00359	.00480	
50	.00029	.00060	.00090	.00119	.00150	.00179	.00240	.00359	.00480	