DEEP TRIO BTA™ DRILL HEAD OPERATING PARAMETERS

ISO	Material	Condition	ML Chip Breaker		
			Speed (SFM)	Feed (in/rev) .551 - .708	Feed (in/rev) .709 - 1.260
P	1, 2	Low carbon steels (C <0.3)	164 - 328	.001 - .004	.001 - .004
	3, 4, 5	Carbon steels (C>0.3)	164 - 328	.001 - .004	.001 - .005
	6, 10	Low alloy steels	164 - 328	.001 - .004	.001 - .004
	7, 8, 9, 11	Alloy steels	164 - 328	.001 - .004	.001 - .005
M	12, 13	Stainless steels (Matensitic and ferritic)	164 - 328	.001 - .002	.001 - .002
	14	Stainless steels (Austenitic)			
		Stainless steels (Precipitation hardening)			
K	15, 16, 19, 20	Ductile cast iron	164 - 328	.001 - .006	.001 - .007
	17, 18	Gray cast iron			
N	21, 22, 23, 24	Aluminum Alloy	262 - 525	.001 - .006	.001 - .006
S	31, 32, 33, 34, 35	High Temp Alloy, Inconel 718, etc.	66 - 164	.001 - .002	.001 - .003
	36, 37	Titanium Alloy, Ti-Al-4V etc...	98 - 197	.001 - .004	.001 - .005
H	38, 39, 40, 41	Hardened steel >40HRC	131 - 328	.001 - .003	.001 - .004

ISO	Material	Condition	DT Chip Breaker				
			Speed (SFM) .472 - .551	Speed (SFM) .551 - .700"	Feed (in/rev) .472 - .551	Feed (in/rev) .551 - .708	Feed (in/rev) .709 - 1.260
P	1, 2	Low carbon steels (C <0.3)	262 - 459	262 - 394	.002 - .004	.003 - .004	.003 - .004
	3, 4, 5	Carbon steels (C>0.3)	262 - 459	262 - 394	.002 - .006	.003 - .006	.003 - .008
	6, 10	Low alloy steels	262 - 459	262 - 394	.002 - .004	.003 - .004	.003 - .004
	7, 8, 9, 11	Alloy steels	262 - 459	262 - 394	.002 - .006	.003 - .006	.003 - .008
M	12, 13	Stainless steels (Matensitic and ferritic)	197 - 328	197 - 328	.002 - .004	.003 - .004	.003 - .004
	14	Stainless steels (Austenitic)					
		Stainless steels (Precipitation hardening)					
K	15, 16, 19, 20	Ductile cast iron	262 - 459	197 - 459	.002 - .010	.003 - .010	.003 - .012
	17, 18	Gray cast iron					
N	21, 22, 23, 24	Aluminum Alloy	328 - 656	328 - 656	.002 - .008	.003 - .008	.003 - .008
S	31, 32, 33, 34, 35	High Temp Alloy, Inconel 718, etc.	66 - 164	66 - 164	.002 - .003	.002 - .003	.002 - .004
	36, 37	Titanium Alloy, Ti-Al-4V etc...	98 - 197	98 - 197	.002 - .005	.003 - .005	.003 - .006
H	38, 39, 40, 41	Hardened steel >40HRC	164 - 328	131 - 328	.002 - .003	.002 - .003	.002 - .004