RECOMMENDED CUTTING CONDITIONS

Tool		Work Material	Drill Diameter ø3.0—ø6.0 mm ø.118″—ø.236″		Drill Diameter ø6.0—ø10.0 mm ø.240″—ø.394″		Drill Diameter ø10.0—ø16.0 mm ø.398″—ø.630″	
			Cutting Speed (SFM)	Feed (IPR)	Cutting Speed (SFM)	Feed (IPR)	Cutting Speed (SFM)	Feed (IPR)
MAE	N	Cast Aluminum Alloy	295 (130—460)	.006 (.002—.012)	330 (165—490)	.008 (.002—.012)	395 (195—560)	.010 (.004—.016)
		Die Cast Aluminum Alloy	330 (195—490)	.005 (.002—.010)	360 (230—525)	.006 (.002—.010)	425 (260—590)	.008 (.004—.012)
	K	Gray Cast Iron	130 (65—195)	.006 (.004—.008)	195 (130—260)	.008 (.004—.012)	260 (195—330)	.012 (.008—.016)
		Ductile Cast Iron	100 (65—130)	.004 (.002—.006)	130 (65—195)	.005 (.002—.008)	195 (130—260)	.008 (.004—.012)
MAS	N	Cast Aluminum Alloy	300 (195—490)	.006 (.002—.012)	390 (260—555)	.008 (.004—.012)	490 (330—655)	.010 (.004—.016)
		Die Cast Aluminum Alloy	390 (260—555)	.005 (.002—.010)	490 (330—590)	.006 (.002—.010)	525 (390—655)	.008 (.004—.012)
	K	Gray Cast Iron	195 (130—260)	.006 (.004—.008)	260 (195—360)	.008 (.004—.012)	330 (230—425)	.012 (.008—.016)
		Ductile Cast Iron	145 (100—195)	.004 (.002—.006)	195 (130—260)	.005 (.002—.008)	260 (195—330)	.008 (.004—.012)

HOLE AND DRILL DIAMETERS FOR THREAD

Thread Size	Thread Tapping			Roll Thread Tapping		
	Super Burnish Drill Diameter (**DC**mm)	Hole Diameter Tolerance (ømm)		Super Burnish Drill Diameter (**DC**mm)	Hole Diameter Tolerance (ømm)	
		Max.	Min.		Max.	Min.
M4x0.7	**3.3**	3.242	3.422	**3.65**	3.65	3.70
M5x0.8	**4.2**	4.134	4.334	**4.60**	4.59	4.66
M6x1.0	**5.0**	4.917	5.153	**5.50**	5.48	5.57
M8x1.25	**6.8**	6.647	6.912	**7.35**	7.34	7.41
M10x1.5	**8.5**	8.376	8.676	**9.21**	9.18	9.28
M12x1.75	**10.3**	10.106	10.441	**11.08**	11.05	11.15
M14x2	**12.0**	11.835	12.210	**12.96**	12.92	13.04
M16x2	**14.0**	13.835	14.210	**14.96**	14.92	15.04