



MULTI-1 DRILLS

RECOMMENDED CUTTING CONDITIONS

PREMIUM HSS-PM MULTI-1 DRILLS

CDRA05, CDRA06, CDRA07 SERIES

WORK MATERIAL	STRUCTURAL STEEL CARBON STEEL			ALLOY STEEL			MOLD STEEL STAINLESS STEEL			
	DIAMETER	RPM	FEED		RPM	FEED		RPM	FEED	
			(IPR)	(inch/min)		(IPR)	(inch/min)		(IPR)	(inch/min)
3/32	5000	.0030	15.00	4000	.0030	12.00	1800	.0030	5.40	
1/8	3800	.0050	19.00	3000	.0040	12.00	1400	.0040	5.60	
5/32	3000	.0060	18.00	2400	.0050	12.00	1100	.0040	4.40	
3/16	2500	.0070	17.50	2000	.0050	10.00	900	.0040	3.60	
1/4	1900	.0080	15.20	1500	.0070	10.50	700	.0050	3.50	
5/16	1500	.0090	13.50	1200	.0080	9.60	550	.0070	3.85	
3/8	1250	.0100	12.50	1000	.0090	9.00	450	.0080	3.60	
1/2	950	.0110	10.45	750	.0100	7.50	350	.0090	3.15	

WORK MATERIAL	NICKEL ALLOY TITANIUM ALLOY			CAST IRON			ALUMINIUM ALLOY COPPER ALLOY NONFERROUS ALLOY			
	DIAMETER	RPM	FEED		RPM	FEED		RPM	FEED	
			(IPR)	(inch/min)		(IPR)	(inch/min)		(IPR)	(inch/min)
3/32	800	.0010	0.80	5700	.0040	22.80	8700	.0040	34.80	
1/8	600	.0020	1.20	4250	.0060	25.50	6500	.0060	39.00	
5/32	500	.0020	1.00	3400	.0070	23.80	5200	.0070	36.40	
3/16	400	.0020	0.80	2850	.0080	22.80	4300	.0080	34.40	
1/4	300	.0030	0.90	2100	.0100	21.00	3200	.0090	28.80	
5/16	250	.0030	0.75	1750	.0120	21.00	2600	.0110	28.60	
3/8	200	.0040	0.80	1450	.0120	17.40	2200	.0130	28.60	
1/2	150	.0050	0.75	1100	.0150	16.50	1650	.0150	24.75	

N = R.P.M

S = Inch per Revolution(inch/rev.)