

MATERIAL	SFM	Hardness: ≤ 28 Rc (≤ 271 HBn)												
		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	0.375	0.500	0.625	0.750
<b>ALUMINUM ALLOYS</b>														
Casting (2xx, 5xx, 7xx, 8xx)	450	.00059	.00123	.00186	.00246	.00309	.00368	.00495	.00741	.00990	.01485	.01980	.02475	.02970
Wrought (1xxx, 2xxx, 3xxx, 5xxx, 6xxx, 7xxx, 8xxx)	600													
Casting - 3%-5% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	450	.00053	.00110	.00168	.00221	.00278	.00331	.00446	.00666	.00891	.01337	.01782	.02228	.02673
Casting - 5%-8% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	420													
Casting - 8%-12% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	390													
Casting - 12%-16% Si (3xx, A3xx, C3xx, 4xx, A4xx, B4xx)	350													
Wrought - 5%-8% Si (4xxx)	600													
Wrought - 8%-12% Si (4xxx)	480													
<b>MAGNESIUM ALLOYS</b>	900	.00059	.00123	.00186	.00246	.00309	.00368	.00495	.00741	.00990	.01485	.01980	.02475	.02970
<b>ZINC ALLOYS</b>	480													
<b>COPPER ALLOYS</b>														
High Coppers - 90%+ (C1xxxx)	170	.00048	.00098	.00149	.00196	.00247	.00295	.00396	.00592	.00792	.01188	.01584	.01980	.02376
Brass (Copper Zinc alloys, C2xxxx, C3xxxx, C4xxxx, C6400-C69800)	375													
Phosphor Bronzes (Copper Tin alloys, C5xxxx)	170													
Aluminum Bronzes (Copper Aluminum alloys, C60600-C64200)	375													
Silicon Bronzes (Copper Silicon alloys, C64700-C66100)	375													
Copper Nickels, Nickel Silvers (Copper Nickel alloys, C7xxxx)	170													
Cast Copper Alloys (C83300-C86200, C86400-C87900, C92200-C95800, C97300-C97800, C99400-C99700)	400													
<b>PLASTICS</b>														
Unfilled Plastics	500	.00059	.00123	.00186	.00246	.00309	.00368	.00495	.00741	.00990	.01485	.01980	.02475	.02970
Reinforced Plastics	350	.00048	.00098	.00149	.00247	.00295	.00396	.00592	.00792	.01188	.01584	.01980	.02376	.03168



Speeds & Feeds

**Product Table:** Miniature High Performance Drills - Aluminum Alloys  
**Characteristics:** 8x-10x Length of Flute  
**Series:** CBGxxxx-C8, ERYxxxx-C8, HYXxxxx-C8

Product Notes:

Pecking cycles are recommended to avoid chip packing and breakage. For Non-Ferrous materials, the initial peck depth should be 3-5x Diameter with each subsequent peck at 2-3x Diameter.

For hole depths 12x Diameter or greater, a pilot hole of up to 1.5x Diameter is recommended.

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.