



Product Table: Helical Step Drills

Material	Type	SFM	IPR by Drill Diameter																			
			.0980	.1250	.1285	.1406	.1563	.1590	.1610	.1719	.1875	.1910	.1935	.1990	.2010	.2031	.2188	.2280	.2340	.2380	.2500	
Carbon and Aramid Fiber	Solid Laminate	320	0.0004	0.0005	0.0005	0.0005	0.0005	0.0005	0.0007	0.0008	0.0008	0.0008	0.0008	0.0008	0.0008	0.0008	0.0009	0.0010	0.0010	0.0010	0.0010	0.0012
Fiberglass	Solid Laminate	275	0.0004	0.0005	0.0005	0.0005	0.0005	0.0005	0.0007	0.0008	0.0008	0.0008	0.0008	0.0008	0.0008	0.0008	0.0009	0.0010	0.0010	0.0010	0.0010	0.0012
Carbon Graphite	Solid Laminate	450	0.0004	0.0005	0.0005	0.0005	0.0005	0.0005	0.0007	0.0008	0.0008	0.0008	0.0008	0.0008	0.0008	0.0008	0.0009	0.0010	0.0010	0.0010	0.0010	0.0012

Product Notes:

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, Corehog has a team of technical experts available to assist you through even the most challenging applications. Please contact us at **833-584-3448** or **corehogtech@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.