



Product Table: Miniature High Performance Drills - Hardened Steels
Characteristics: 12x Length of Flute
Series: EFGxxx-C6

Product Notes:

- Pecking cycles are recommended to avoid chip packing and breakage.
- For ferrous materials at 38-45 Rc, 1-2x Diameter is recommended for an initial peck, and each subsequent peck should be .5-1x Diameter.
- For harder steels at > 45 Rc, .5-1x Diameter peck depth 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.

Material	Hardness	SFM	Chip Load (IPR - Inches per Revolution) By Drill Diameter								
			.015	.031	.047	.062	.078	.093	.125	.187	.250
Hardened Steels	38-45 Rc	150	.00019	.00039	.00059	.00077	.00097	.00116	.00156	.00233	.00312
	45-55 Rc	90	.00014	.00029	.00044	.00058	.00073	.00087	.00117	.00175	.00234
	56-68 Rc	40	.00009	.00019	.00029	.00039	.00049	.00058	.00078	.00117	.00156