



Speeds & Feeds

Product Table: Miniature High Performance Drills - Prehardened Steels

Characteristics: 3x-5x Length of Flute

Series: BVTxxx-C3, DHExxxx-C3, FKBxxxx-C3, GKTxxxx-C3

Product Notes:

Pecking cycles are recommended to avoid chip packing and breakage.

- For steels at 29-37 Rc, an initial peck should be 2-3x Diameter, and each subsequent peck should be 1-2x Diameter.
- For harder steels at 38-45 Rc, 1-2x Diameter is recommended for an initial peck, and each subsequent peck should be .5-1x Diameter.

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: 29-37 Rc (279-344 HBn)											
	SFM	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
CARBON STEELS Free-Machining/Low Carbon steels, 10xx - 1029 & all 10Lxx, 11xx - 1139 & all 11Lxx, 12xx - 1215 & all 12Lxx	240	.00063	.00130	.00197	.00260	.00328	.00391	.00525	.00785	.01050	.01575	.02100
1030 - 1095, 1140 - 1151, 13xx, 15xx, 2xx, 3xx, 4xx & 4Lxx, 5xx & 5Lxx, 50xxx & 50Lxxx, 51xxx & 51Lxxx, 52xxx & 52Lxxx, 6xxx, 8xxx, 9xxx	150	.00058	.00119	.00180	.00238	.00300	.00357	.00480	.00718	.00960	.01440	.01920
STAINLESS STEELS 203 EZ, 303 (all types), 416, 416Se, 416 Plus X, 420F, 420FSe, 430F, 430FSe, 440F, 440FSe	180	.00063	.00130	.00197	.00260	.00328	.00391	.00525	.00785	.01050	.01575	.02100
201, 202, 203, 205, 301, 302, 304, 304L, 308, 309, 310, 314, 316, 316L, 317, 321, 329, 330, 347, 348, 385, 403, 405, 409, 410, 413, 420, 429, 430, 434, 436, 442, 446, 501, 502	150	.00058	.00119	.00180	.00238	.00300	.00357	.00480	.00718	.00960	.01440	.01920
414, 431, 440A, 440B, 440C, 13-8, 15-5, 15-7, 17-4, 17-7	125	.00036	.00074	.00113	.00149	.00187	.00223	.00300	.00449	.00600	.00900	.01200
TOOL STEELS A, L, O, P, W series	125	.00058	.00119	.00180	.00238	.00300	.00357	.00480	.00718	.00960	.01440	.01920
D, H, M, T, S series	90	.00036	.00074	.00113	.00149	.00187	.00223	.00300	.00449	.00600	.00900	.01200
TITANIUM ALLOYS	100	.00036	.00074	.00113	.00149	.00187	.00223	.00300	.00449	.00600	.00900	.01200
HIGH TEMP ALLOYS Inconel, Hastelloy, Waspalloy, Monel, Nimonic, Haynes, Discaloy, Incoloy	70	.00036	.00074	.00113	.00149	.00187	.00223	.00300	.00449	.00600	.00900	.01200

MATERIAL	Hardness: 38-45 Rc (353-421 HBn)											
	SFM	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
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-	-	-	-	-	-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-	-	-	-	-	-
100	.00046	.00095	.00144	.00190	.00240	.00286	.00384	.00574	.00768	.01152	.01536	
90	.00029	.00060	.00090	.00119	.00150	.00179	.00240	.00359	.00480	.00720	.00960	
100	.00046	.00095	.00144	.00190	.00240	.00286	.00384	.00574	.00768	.01152	.01536	
75	.00029	.00060	.00090	.00119	.00150	.00179	.00240	.00359	.00480	.00720	.00960	
75	.00029	.00060	.00090	.00119	.00150	.00179	.00240	.00359	.00480	.00720	.00960	
50	.00029	.00060	.00090	.00119	.00150	.00179	.00240	.00359	.00480	.00720	.00960	