



**Speeds & Feeds**

**Product Table:** Miniature High Performance Drills - Hardened Steels

**Characteristics:** 3x-5x Length of Flute

**Series:** BGNxxxx-C6, CSGxxxx-C6, FDWxxxx-C6, GBSxxxx-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](mailto: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	.375
Hardened Steels	38-45 Rc	150	.00029	.00060	.00090	.00119	.00150	.00179	.00240	.00359	.00480	.00720
	45-55 Rc	90	.00022	.00045	.00068	.00089	.00112	.00134	.00180	.00269	.00360	.00540
	56-68 Rc	40	.00014	.00030	.00045	.00060	.00075	.00089	.00120	.00180	.00240	.00360