



**Product Table:** Miniature Drills

| Material              | SFM | IPR by Drill Diameter |        |        |        |        |        |        |
|-----------------------|-----|-----------------------|--------|--------|--------|--------|--------|--------|
|                       |     | .015                  | .031   | .047   | .063   | .078   | .093   | .125   |
| Composite - Laminates | 350 | .00048                | .00099 | .00150 | .00250 | .00298 | .00400 | .00598 |
| Unfilled Plastics     | 500 | .00060                | .00124 | .00188 | .00248 | .00312 | .00372 | .00500 |
| Reinforced Plastics   | 350 | .00048                | .00099 | .00150 | .00250 | .00298 | .00400 | .00598 |

**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.

**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