

SPADE DRILLS - CARBIDE

Technical Information

General Purpose Carbide Spade Drills									
Material Guide		Machinability	Rc	SFM	Feed Per Tooth				
					1/32"- 1/16"	1/16"-1/8"	1/8"-1/4"	1/4"-3/8"	3/8"-1/2"
NICKEL BASE ALLOYS	Inconel - 625/718, Waspalloy, Rene, Hastelloy	Difficult	≤ 42 Rc	40	.0005-.0010	.0010-.0015	.0015-.0030	.0030-.0040	.0040-.0050
IRON BASE ALLOYS	"Incoloy 800-802, Multimet N-155, Timken 16-25-6, Carpenter 22-b3"	Difficult	≤ 42 Rc	40	.0005-.0011	.0010-.0016	.0015-.0031	.0030-.0041	.0040-.0051
MONEL	Monel - 65% Nickel	Difficult	≤ 42 Rc	40	.0005-.0012	.0010-.0017	.0015-.0032	.0030-.0042	.0040-.0052
TITANIUM ALLOYS	"Commercially Pure, 6AL-4V, STM 1/2/3, 6AL-25N-4Zr-2Mo-Si"	Difficult	≤ 42 Rc	80	.0005-.0013	.0010-.0018	.0015-.0033	.0030-.0043	.0040-.0053
STAINLESS STEEL (PH)	13/8, 15/5, 17-4	Difficult	"≤ 28 Rc > 28 Rc"	"125 60"	.0005-.0014	.0010-.0019	.0015-.0034	.0030-.0044	.0040-.0054
STAINLESS STEEL (AUSTENITIC)	303, 303Se	Free-Machining	≤ 28 Rc	125	.0005-.0014	.0010-.0019	.0015-.0034	.0030-.0044	.0040-.0054
	304, 304L, 316, 316L, 200 Series	Difficult	"≤ 28 Rc > 28 Rc"	"125 60"	.0005-.0015	.0010-.0020	.0015-.0035	.0030-.0045	.0040-.0055
STAINLESS STEEL (MARTENSITIC)	416	Free-Machining	≤ 28 Rc	125	.0005-.0014	.0010-.0019	.0015-.0034	.0030-.0044	.0040-.0054
	403, 410, 440	Difficult	"≤ 28 Rc > 28 Rc"	"125 60"	.0005-.0016	.0010-.0021	.0015-.0036	.0030-.0046	.0040-.0056
HIGH STRENGTH TOOL STEELS	4340, 6150, 5210, A2, D2, P20, H11, H13, S2, O1	Difficult	28-44 Rc	150	.0005-.0017	.0010-.0022	.0015-.0037	.0030-.0047	.0040-.0057
MEDIUM ALLOY STEELS	4140, 8620, 52100	Moderate	28-38 Rc	165	.0005-.0018	.0010-.0023	.0015-.0038	.0030-.0048	.0040-.0058
CARBON STEELS	1018, 1045, 1117, 1215, 1300 Series	Free-Machining	≤ 28 Rc	175	.0005-.0019	.0010-.0024	.0015-.0039	.0030-.0049	.0040-.0059
DUCTILE	Ductile Cast Irons	Moderate	> 240 HB	175	.0005-.0020	.0010-.0025	.0015-.0040	.0030-.0050	.0040-.0060
CAST IRONS	Gray Cast Irons	Moderate	≤ 240 HB	275	.0005-.0021	.0010-.0026	.0015-.0041	.0030-.0051	.0040-.0061