



DEEPTRIO^{BTA}™ OPERATING PARAMETERS - DT* CHIP BREAKER

*NOTE: DT-P inserts available ONLY for N (non-ferrous) ISO category; DT inserts available for all categories noted below.

ISO	Material	Condition	Speed (SFM)	Feed (inch/rev) Drill Diameter (inch)							
				.551-.708" (14-18 mm)	.709-1.102" (18.01-28 mm)	1.103-1.575" (28.01-40 mm)					
P	1	Low Carbon Steels (C <0.3)	262-459	.002-.004	.002-.004	.003-.006					
	2										
	3										
	4	Carbon Steels (C>0.3)		.002-.006	.002-.008	.002-.008					
	5										
	6	Low Alloy Steels		.002-.004	.002-.004	.003-.006					
	7										
	8										
	9										
	10	Alloy Steels		.002-.006	.003-.008	.002-.008					
	11										
M	12	Stainless Steels (Ferritic)	197-328	.002-.004	.002-.004	.002-.004					
	13	Stainless Steels (Martensitic)									
	14	Stainless Steels (Austenitic)									
K	15	Grey Cast Iron	262-459	.002-.010	.003-.012	.003-.012					
	16										
	17	Nodular Cast Iron									
	18										
	19										
20	Malleable Cast Iron										
N*	21	Aluminum Alloy Forging	328-656	.002-.008	.002-.008	.002-.008					
	22										
	23	Aluminum Alloy Casting									
	24										
	25										
	26	Copper Alloy									
	27										
	28										
	29	Non-Metallic									
	30										
S	31	High Temp Alloy, Inconel 718, etc.	66-164	.002-.003	.002-.004	.002-.005					
	32										
	33										
	34										
	35										
	36						Titanium Alloy, Ti-Al-4V, etc.	98-197	.002-.005	.002-.006	.002-.006
	37										
H	38	Hardened Steel >40HRC	164-328	.002-.003	.002-.004	.002-.004					
	39										
	40						Chilled Cast Iron				
	41						Cast Iron-Hardened				



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ISO	Material	Condition	Speed (SFM)	Feed (inch/rev) Drill Diameter (inch)		
				.551-.708" (14-18 mm)	.709-1.102" (18.01-28 mm)	1.103-1.575" (28.01-40 mm)
P	1	Low Carbon Steels (C <0.3)	164-328	.001-.004	.001-.004	.002-.003
	2					
	3					
	4	Carbon Steels (C>0.3)		.001-.004	.001-.005	.002-.006
	5					
	6	Low Alloy Steels		.001-.004	.001-.004	.002-.003
	7					
	8					
	9					
	10	Alloy Steels		.001-.004	.001-.005	.002-.006
	11					
M	12	Stainless Steels (Ferritic)	164-328	.001-.004	.001-.004	.001-.004
	13	Stainless Steels (Martensitic)				
	14	Stainless Steels (Austenitic)				
K	15	Grey Cast Iron	164-328	.001-.010	.002-.007	.002-.007
	16					
	17	Nodular Cast Iron				
	18					
	19	Malleable Cast Iron				
20						
N	21	Aluminum Alloy Forging	262-525	.001-.006	.001-.006	.001-.006
	22					
	23	Aluminum Alloy Casting				
	24					
	25					
	26	Copper Alloy				
	27					
	28					
	29	Non-Metallic				
	30					
S	31	High Temp Alloy, Inconel 718, etc.	66-164	.001-.002	.001-.003	.002-.003
	32					
	33					
	34					
	35					
	36					
37						
H	38	Hardened Steel >40HRC	131-328	.001-.003	.001-.003	.001-.003
	39					
	40	Chilled Cast Iron				
	41	Cast Iron-Hardened				