



DEEPTRIO^{DTA}™ 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									
	7	Low Alloy Steels		.002-.004	.002-.004	.003-.006				
	8									
	9									
	10	Alloy Steels		262-394	.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	Malleable Cast Iron								
20										
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	Non-Metallic								
	29									
	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	Alloy Steels		.001-.004	.001-.005	.002-.006
	10					
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	Copper Alloy				
	26					
	27					
	28	Non-Metallic				
	29					
30						
S	31	High Temp Alloy, Inconel 718, etc.	66-164	.001-.002	.001-.003	.002-.003
	32					
	33					
	34					
	35					
	36	Titanium Alloy, Ti-Al-4V, etc.	98-197	.001-.004	.001-.005	.001-.005
37						
H	38	Hardened Steel >40HRC	131-328	.001-.003	.001-.003	.001-.003
	39					
	40	Chilled Cast Iron				
	41	Cast Iron-Hardened				