

**DEEPTRIOMC™ & DEEPTRIOCD™****OPERATING PARAMETERS -
DT* CHIP BREAKER-SMALL DIA.**

*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)
				.313-.393" (7.94-9.99mm)
P	1	Low Carbon Steels (C <0.3)	197-328	.002-.006
	2			
	3			
	4	Carbon Steels (C>0.3)		.002-.003
	5			
	6	Low Alloy Steels		.002-.003
	7			
	8			
	9	Alloy Steels		.002-.006
	10			
	11			
M	12	Stainless Steels (Ferritic)	197-328	.002-.003
	13	Stainless Steels (Martensitic)		
	14	Stainless Steels (Austenitic)	197-262	
K	15	Grey Cast Iron	197-328	.002-.008
	16			
	17	Nodular Cast Iron		
	18			
	19	Malleable Cast Iron		
20				
N*	21	Aluminum Alloy Forging	197-328	.002-.007
	22			
	23			
	24	Aluminum Alloy Casting		
	25			
	26	Copper Alloy		
	27			
	28			
	29	Non-Metallic		
30				
S	31	High Temp Alloy, Inconel 718, etc.	66-164	.002-.002
	32			
	33			
	34			
	35			
	36	Titanium Alloy, Ti-Al-4V, etc.	98-197	.002-.004
	37			
H	38	Hardened Steel >40HRC	66-164	.002-.002
	39			
	40	Chilled Cast Iron		
	41	Cast Iron-Hardened		



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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)				
				.394-.465" (10-11.8 mm)	.466-.551" (11.81-13.99 mm)	.552-.709" (14-18 mm)	.710-1.260" (18.01-32 mm)	1.261-1.575" (32.01-40 mm)
P	1	Low Carbon Steels (C <0.3)	262-459	.002-.003	.002-.004	.002-.005	.003-.006	.004-.010
	2							
	3							
	4	Carbon Steels (C>0.3)		.002-.006	.002-.006	.003-.007	.003-.008	.004-.012
	5							
	6							
	7	Low Alloy Steels		.002-.003	.002-.004	.002-.005	.003-.006	.004-.010
	8							
	9							
	10	Alloy Steels	262-394	.002-.006	.002-.006	.003-.007	.003-.008	.004-.012
	11							
M	12	Stainless Steels (Ferritic)	197-328	.002-.003	.002-.004	.002-.004	.002-.005	.004-.006
	13	Stainless Steels (Martensitic)						
	14	Stainless Steels (Austenitic)						
K	15	Grey Cast Iron	262-459	.002-.008	.002-.010	.002-.010	.002-.010	.002-.012
	16							
	17	Nodular Cast Iron						
	18							
	19	Malleable Cast Iron						
20								
N*	21	Aluminum Alloy Forging	328-656	.002-.007	.002-.008	.003-.009	.003-.009	.004-.012
	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-.003	.002-.003	.002-.004	.002-.005
	32							
	33							
	34							
	35							
	36	Titanium Alloy, Ti-Al-4V, etc.	98-197	.002-.004	.002-.005	.002-.005	.003-.006	.004-.007
	37							
H	38	Hardened Steel >40HRC	164-328	.002-.003	.002-.003	.002-.003	.002-.004	.002-.005
	39							
	40	Chilled Cast Iron						
	41	Cast Iron-Hardened						



DEEPTRIO^{MC}™ & DEEPTRIO^{GD}™

**OPERATING PARAMETERS -
ML CHIP BREAKER**

ISO	Material	Condition	Speed (SFM)	Feed (inch/rev) Drill Diameter (inch)				
				.394-.465" (10-11.8 mm)	.466-.551" (11.81-13.99 mm)	.552-.709" (14-18 mm)	.710-1.260" (18.01-32 mm)	1.261-1.575" (32.01-40 mm)
P	1	Low Carbon Steels (C <0.3)	164-328	NA	NA	.001-.004	.001-.004	.001-.004
	2							
	3							
	4	Carbon Steels (C>0.3)		NA	NA	.001-.004	.001-.005	.001-.005
	5							
	6							
	7	Low Alloy Steels		NA	NA	.001-.005	.003-.004	.001-.004
	8							
	9							
	10	Alloy Steels		NA	NA	.001-.004	.001-.005	.001-.005
11								
M	12	Stainless Steels (Ferritic)	164-328	NA	NA	.001-.002	.001-.002	.001-.004
	13	Stainless Steels (Martensitic)						
	14	Stainless Steels (Austenitic)						
K	15	Grey Cast Iron	164-328	NA	NA	.001-.006	.002-.005	.001-.006
	16							
	17	Nodular Cast Iron						
	18							
	19	Malleable Cast Iron						
20								
N	21	Aluminum Alloy Forging	262-525	NA	NA	.001-.006	.001-.006	.001-.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	NA	NA	.001-.002	.001-.003	.001-.003
	32							
	33							
	34							
	35							
	36	Titanium Alloy, Ti-Al-4V, etc.	98-197	NA	NA	.001-.004	.001-.005	.001-.004
	37							
H	38	Hardened Steel >40HRC	131-328	NA	NA	.001-.003	.001-.003	.001-.004
	39							
	40	Chilled Cast Iron						
	41	Cast Iron-Hardened						