DEEPTRIOMC & DEEPTRIOGD 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	Carbon Steels (C>0.3)		
	4			
	5			.002–.003
	6	Low Alloy Steels		
	7			
	8			
	9			
	10	Alloy Steels		.002–.006
	11			.002–.003
M	12	Stainless Steels (Ferritic)	197–328	.002–.003
	13	Stainless Steels (Matensitic)		
	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	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–.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		

DEEPTRIOMC & DEEPTRIOGD 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)				
				.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	Carbon Steels (C>0.3)		.002–.006	.002–.006	.003–.007	.003–.008	.004–.012
	4							
	5							
	6	Low Alloy Steels		.002–.003	.002–.004	.002–.005	.003–.006	.004–.010
	7							
	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 (Matensitic)						
	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							
	29	Non-Metallic						
	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						

DEEPTRIOMC & DEEPTRIOGD 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	Carbon Steels (C>0.3)		NA	NA	.001-.004	.001-.005	.001-.005
	4							
	5							
	6	Low Alloy Steels		NA	NA	.001-.005	.003-.004	.001-.004
	7							
	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 (Matensitic)						
	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							
	29	Non-Metallic						
	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						