DEEP TRIO 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	Carbon Steels (C>0.3)		.002–.006	.002–.008	.002–.008
	4					
	5					
	6	Low Alloy Steels		.002–.004	.002–.004	.003–.006
	7					
	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 (Matensitic)				
	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					
	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				

DEEP TRIO BTA™ OPERATING PARAMETERS - ML CHIP BREAKER

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	Carbon Steels (C>0.3)		.001–.004	.001–.005	.002–.006
	4					
	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 (Matensitic)				
	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	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				