



**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					
	4	Carbon Steels (C >0.3)		.002-.003		
	5					
	6	Low Alloy Steels		.002-.003		
	7					
	8					
	9					
	10					
	M	11		Alloy Steels	.002-.006	
			.002-.003			
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		Titanium Alloy, Ti-Al-4V, etc.	98-197	.002-.004	
	36					
	37					
H	38	Hardened Steel >40HRC	66-164	.002-.002		
	39					
	40	Chilled Cast Iron				
	41	Cast Iron-Hardened				



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**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								
	4	Carbon Steels (C >0.3)		.002-.006	.002-.006	.003-.007	.003-.008	.004-.012	
	5								
	6	Low Alloy Steels		.002-.003	.002-.004	.002-.005	.003-.006	.004-.010	
	7								
	8								
	9								
	10	Alloy Steels		.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.
	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							
	4	Carbon Steels (C >0.3)		NA	NA	.001-.004	.001-.005	.001-.005
	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 (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							
	24	Aluminum Alloy Casting						
	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							
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						