Operating Guidelines • Series LPC Tips (Self-Centering) NEW

ISO	Material		Condition	Tensile Strength RM (N/mm^2)	Hardness HB	Matl. Group No.	Cutting Speed Vc (SFM)	Feed vs. Drill Diameter – IPR (inches/rev)	
								Ø20–29.9 mm (.7874–1.1772")	Ø30–34.9 mm (1.1811–1.3740")
P	Non-alloy steel and cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	260–460	.010–.018	.012–.020
		≥0.25%C	Annealed	650	190	2	260–430		
		<0.55%C	Quenched and tempered	850	250	3	260–400		
		≥0.55%C	Annealed	750	220	4	230–360		
			Quenched and tempered	1000	300	5	165–300		
	Low alloy steel and cast steel (less than 5% alloying elements)		Annealed	600	200	6	230–400	.008–.016	.010–.018
			Quenched and tempered	930	275	7	230–360		
				1000	300	8	165–300		
				1200	350	9	130–230		
	High alloy steel, cast steel, and tool steel		Annealed	680	200	10	165–300	.008–.012	.010–.014
			Quenched and tempered	1100	325	11	130–260		
K	Grey cast iron (GG)		Ferritic	-	160	15	300–530	.012–.020	.014–.022
			Pearlitic	-	250	16	260–460		
	Cast iron nodular (GGG)		Ferritic	-	180	17	300–595		
			Pearlitic	-	260	18	260–460		
	Malleable cast iron		Ferritic	-	130	19	300–530		
			Pearlitic	-	230	20	260–460		

NOTE: For deep hole drilling (+8xD), reduce the cutting parameters by 30%