

# GENERAL MACHINING GUIDE

Drilling based on Jobber drill lengths  
For deep hole drilling reduce speeds by

3 x Drill Diameter	10%
4 x Drill Diameter	20%
5 x Drill Diameter	30%
More than 6 x Drill Diameter	40%

## STAINLESS STEEL - Blue Band

Tool Material			TAPPING	DRILLING									
MACHINED MATERIALS	HARDNESS MATERIALS	HARDNESS MATERIALS	Cutting Speed	Cutting Speed	Feed Rate for Diameters								
			Metres/min	Metres/min	3mm	5mm	6mm	8mm	10mm	12mm	16mm	20mm	
<b>STAINLESS STEEL</b>													
Free Cutting	<250	861M/mm <sup>2</sup>	12-20	12-22	0.085	0.110	0.120	0.160	0.190	0.200	0.240	0.280	
Austenitic	<250	861M/mm <sup>2</sup>	08-16	10-15	0.085	0.110	0.120	0.160	0.190	0.200	0.240	0.280	
"Martensitic, Ferritic"	>300	971M/mm <sup>2</sup>	07-10	12-18	0.062	0.080	0.095	0.120	0.140	0.150	0.160	0.210	
<b>TITANIUM</b>													
"Pure Titanium, unalloyed"	<200	758M/mm <sup>2</sup>	10-16	20-32	0.062	0.080	0.095	0.120	0.140	0.150	0.160	0.210	
Titanium Alloys	>300	971M/mm <sup>2</sup>	05-10	06-12	0.062	0.080	0.095	0.120	0.140	0.150	0.160	0.210	
<b>NICKEL</b>													
"Pure Nickel, Unalloyed"	<300	971M/mm <sup>2</sup>	09-15	10-15	0.085	0.110	0.120	0.160	0.190	0.200	0.240	0.280	