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%

CARBON STEEL - Green 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**
CARBON ALLOY STEELS												
Free Cutting Mild Steel	<120	420M/mm^2	20-45	40-50	0.120	0.150	0.170	0.220	0.260	0.280	0.320	0.360
Low Carbon Steel	<200	758M/mm^2	18-40	30-40	0.085	0.110	0.120	0.160	0.200	0.200	0.240	0.280
Medium Carbon Steel	<250	861M/mm^2	14-25	25-35	0.062	0.080	0.095	0.120	0.150	0.150	0.160	0.210