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%

CAST IRON - White

Tool Material			**TAPPING**	**DRILLING**								
MACHINED MATERIALS	**HARDNESS MATERIALS**	**HARDNESS MATERIALS**	**Cutting Speed Metres/min**	**Cutting Speed Metres/min**	**Feed Rate for Diameters 3mm**	**5mm**	**6mm**	**8mm**	**10mm**	**12mm**	**16mm**	**20mm**
CAST IRONS												
Plain Grey Irons	<150	541M/mm^2	16-30	35-45	0.120	0.150	0.170	0.220	0.260	0.280	0.320	0.360
Plain 'SG' Iron	<250	861M/mm^2	12-20	23-35	0.062	0.080	0.095	0.120	0.140	0.150	0.160	0.210
Alloy 'SG' Iron Nickel Hard	>250	861M/mm^2	07-14	15-28	0.062	0.080	0.095	0.120	0.140	0.150	0.160	0.210