

List 1800 - V-Select

General Drilling Operations

Work Material	Low Carbon Steels 1010, 1018		Carbon Steels		Alloy Steels 4140, 4340		Tool Steels D2, H13		Stainless Steel 15-5PH, 17-4PH		Cast Iron		Cast Aluminum	
Drilling Speed	72-132 SFM		52-99 SFM		40-82 SFM		26-52 SFM		45 - 75 SFM		72-131 SFM		164-328 SFM	
Drill Dia. mm	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR
2	4,950	0.002-0.004	3,660	0.002-0.004	2,960	0.002-0.004	1,900	0.002-0.004	2,910	0.002-0.004	4,920	0.003-0.004	12,000	0.005-0.007
3	3,300	0.004-0.005	2,800	0.004-0.005	2,400	0.004-0.005	1,320	0.004-0.005	1,940	0.004-0.005	3,850	0.004-0.006	10,000	0.008-0.011
4	2,470	0.004-0.006	2,100	0.004-0.006	1,800	0.004-0.006	950	0.004-0.006	1,460	0.004-0.006	2,900	0.005-0.007	7,500	0.009-0.015
5	1,980	0.005-0.007	1,600	0.005-0.007	1,400	0.005-0.007	750	0.005-0.007	1,160	0.005-0.007	2,260	0.006-0.009	6,300	0.011-0.016
6	1,650	0.005-0.007	1,320	0.005-0.007	1,180	0.005-0.007	630	0.005-0.007	970	0.005-0.007	1,900	0.007-0.010	5,000	0.013-0.019
8	1,240	0.006-0.009	1,000	0.006-0.009	900	0.006-0.009	480	0.006-0.009	730	0.006-0.009	1,400	0.008-0.012	4,000	0.015-0.021
10	990	0.008-0.011	800	0.008-0.011	710	0.008-0.011	380	0.008-0.011	580	0.008-0.011	1,120	0.010-0.014	3,150	0.018-0.025
12	820	0.009-0.013	670	0.009-0.013	600	0.009-0.013	320	0.009-0.013	490	0.009-0.013	950	0.012-0.017	2,650	0.021-0.030
13	760	0.010-0.014	620	0.010-0.014	550	0.010-0.014	300	0.010-0.014	450	0.010-0.014	880	0.012-0.017	2,450	0.022-0.031

ABOUT OSG

DRILLING

THREADING

MILLING

HOLDERS

INDEX

