

List 7530 - EXOPRO® AERO-S

Work Material	Carbon & Glass Fiber Reinforced Plastics		CFRP + Aluminum Stack	
Cutting Speed	165 - 260 SFM		200-400 SFM	
Drill Diameter (in)	Speed RPM	Feed IPR	Speed RPM	Feed IPR
#40	8,000	0.0008 - 0.0020	11,700	0.0010 - 0.0030
#30	6,100	0.0008 - 0.0030	8,900	0.0030 - 0.0040
#20	4,900	0.0012 - 0.0030	7,100	0.0040 - 0.0050
#11	4,100	0.0012 - 0.0030	6,000	0.0040 - 0.0050
#2	3,550	0.0014 - 0.0040	5,200	0.0050 - 0.0060
1/4	3,100	0.0016 - 0.0040	4,500	0.0060 - 0.0070
5/16	3,170	0.0016 - 0.0040	3,600	0.0070 - 0.0080
3/8	2,100	0.0020 - 0.0040	3,000	0.0090 - 0.0100
7/16	1,790	0.0020 - 0.0040	2,600	0.0100 - 0.0110
1/2	1,570	0.0020 - 0.0040	2,300	0.0120 - 0.0130

1. Feed rates can and should be adjusted depending on stack makeup, with higher feed rates in the composite portion and lower feeds in the metal portion.
2. Peck drilling may be necessary for enhanced quality and proper chip evacuation.
3. There are many factors that can effect successful stack drilling; please contact OSG about your specific application for best recommendation.