# List 7532 - EXOPRO® AERO-H
# List 5732 - EXOCARB® AERO-H

| Work Material | Carbon & Glass Fiber Reinforced Plastics | | CFRP + Aluminum Stack | | CFRP + Titanium Stack | | CFRP + CRES Stack | |
|---|---|---|---|---|---|---|---|---|
| Cutting Speed | 165 - 260 SFM | | 200-400 SFM | | 40-60 SFM | | 30-50 SFM | |
| Drill Dia. (in) | Speed RPM | Feed IPR | Speed RPM | Feed IPR | Speed RPM | Feed IPR | Speed RPM | Feed IPR |
| #40 | 8,000 | 0.0008 - 0.0020 | 11,700 | 0.0010 - 0.0030 | 1,900 | 0.0002 - 0.0007 | 1,550 | 0.0002 - 0.0007 |
| #30 | 6,100 | 0.0008 - 0.0030 | 8,900 | 0.0030 - 0.0040 | 1,500 | 0.0004 - 0.0009 | 1,150 | 0.0004 - 0.0009 |
| #20 | 4,900 | 0.0012 - 0.0030 | 7,100 | 0.0040 - 0.0050 | 1,225 | 0.0006 - 0.0011 | 950 | 0.0006 - 0.0011 |
| #11 | 4,100 | 0.0012 - 0.0030 | 6,000 | 0.0040 - 0.0050 | 1,000 | 0.0007 - 0.0012 | 800 | 0.0007 - 0.0012 |
| #2 | 3,550 | 0.0014 - 0.0040 | 5,200 | 0.0050 - 0.0060 | 875 | 0.0009 - 0.0014 | 675 | 0.0009 - 0.0014 |
| 1/4 | 3,100 | 0.0016 - 0.0040 | 4,500 | 0.0060 - 0.0070 | 750 | 0.0010 - 0.0015 | 600 | 0.0010 - 0.0015 |
| 5/16 | 3,170 | 0.0016 - 0.0040 | 3,600 | 0.0070 - 0.0080 | 625 | 0.0013 - 0.0018 | 475 | 0.0013 - 0.0018 |
| 3/8 | 2,100 | 0.0020 - 0.0040 | 3,000 | 0.0090 - 0.0100 | 500 | 0.0016 - 0.0021 | 400 | 0.0016 - 0.0021 |
| 7/16 | 1,790 | 0.0020 - 0.0040 | 2,600 | 0.0100 - 0.0110 | 425 | 0.0019 - 0.0024 | 350 | 0.0019 - 0.0024 |
| 1/2 | 1,570 | 0.0020 - 0.0040 | 2,300 | 0.0120 - 0.0130 | 375 | 0.0023 - 0.0028 | 275 | 0.0023 - 0.0028 |

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.