

## List HP355 - HY-PRO® CARB ALD-HO: 5D, Coolant-Through

### General Drilling Operations

Work Material		Aluminum Alloy		Cast Aluminum		Copper Alloy		Magnesium Alloy	
Drilling Speed		260 - 650 SFM		400 - 820 SFM		130 - 400 SFM		200 - 425 SFM	
Drill Dia.		Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR
mm	Inch								
3	-	14,900	0.0024 - 0.0059	19,600	0.0024 - 0.0094	8,500	0.0009 - 0.0024	10,100	0.0024 - 0.0059
-	1/8	14,000	0.0024 - 0.0063	18,600	0.0024 - 0.0098	8,000	0.0012 - 0.0024	9,500	0.0024 - 0.0063
4	-	11,100	0.0031 - 0.0079	14,700	0.0031 - 0.0126	6,400	0.0013 - 0.0031	7,600	0.0031 - 0.0079
-	3/16	9,400	0.0039 - 0.0094	12,400	0.0039 - 0.0150	5,300	0.0016 - 0.0039	6,400	0.0039 - 0.0094
6	-	7,400	0.0047 - 0.0118	9,800	0.0047 - 0.0189	4,200	0.0019 - 0.0047	5,000	0.0047 - 0.0118
-	1/4	7,000	0.0051 - 0.0126	9,300	0.0051 - 0.0201	4,000	0.0020 - 0.0051	4,800	0.0051 - 0.0126
8	-	5,600	0.0063 - 0.0157	7,400	0.0063 - 0.0252	3,200	0.0025 - 0.0063	3,800	0.0063 - 0.0157
-	3/8	4,700	0.0075 - 0.0189	6,200	0.0075 - 0.0299	2,700	0.0031 - 0.0075	3,200	0.0075 - 0.0189
10	-	4,500	0.0079 - 0.0197	5,900	0.0079 - 0.0315	2,500	0.0031 - 0.0079	3,000	0.0079 - 0.0197
-	7/16	4,000	0.0087 - 0.0220	5,300	0.0087 - 0.0350	2,300	0.0035 - 0.0087	2,700	0.0087 - 0.0220
12	-	3,700	0.0094 - 0.0236	4,900	0.0094 - 0.0378	2,100	0.0038 - 0.0094	2,500	0.0094 - 0.0236
-	1/2	3,500	0.0098 - 0.0252	4,600	0.0098 - 0.0401	2,000	0.0039 - 0.0098	2,400	0.0098 - 0.0252

