



# Recommended Speeds and Feeds

## T-A® Thin Wall (TW) Super Cobalt Drill Insert *(for material up to 6mm thick)*

Material	Material Hardness (BHN)	Speed (M/min) Mist Coolant TiAlN	FEED (mm/rev)			
			14mm – 16mm	18mm – 24mm	25mm – 35mm	36mm – 47mm
HSS Super Cobalt	100 - 150	34	0.25	0.30	0.38	0.45
	150 – 250	31	0.23	0.28	0.35	0.40
	250 – 350	28	0.20	0.25	0.28	0.38

• 0.95 multiplier for feed rate on Long Length Holder

## T-A® 150° Structural Steel (SS) Super Cobalt Drill Insert *(for material above 6mm thick)*

Material	Material Hardness (BHN)	Speed (M/min) Mist Coolant TiAlN	FEED (mm/rev)			
			14mm – 16mm	18mm – 24mm	25mm – 35mm	36mm – 47mm
HSS Super Cobalt	100 – 150	34	0.25	0.30	0.38	0.45
	150 – 250	31	0.23	0.28	0.35	0.40
	250 – 350	28	0.20	0.25	0.28	0.38

• 0.95 multiplier for feed rate on Long Length Holder

## GEN2 T-A™ HSS Super Cobalt Drill Insert *(for material above 6mm thick)*

Material	Material Hardness (BHN)	Speed (M/min) Mist Coolant AM200®	FEED (mm/rev)			
			14mm – 16mm	18mm – 24mm	25mm – 35mm	36mm – 47mm
HSS Super Cobalt	100 – 150	40	0.25	0.30	0.38	0.45
	150 – 250	35	0.23	0.28	0.35	0.40
	250 – 350	30	0.20	0.25	0.28	0.38

• 0.95 multiplier for feed rate on Long Length Holder

## GEN2 T-A™ Carbide Drill Insert

Material	Material Hardness (BHN)	Speed (M/min) Mist Coolant AM200®	FEED (mm/rev)			
			14mm – 16mm	18mm – 24mm	25mm – 35mm	36mm – 47mm
K35 Carbide	100-150	75	0.25	0.30	0.38	0.45
	150-250	61	0.23	0.28	0.35	0.40
	250-350	57	0.20	0.25	0.28	0.38

• 0.95 multiplier for feed rate on Long Length Holder



## Carbide Drill Insert

Material	Material Hardness (BHN)	Speed (M/min) Mist Coolant AM200®	FEED (mm/rev)												
			12	13	14	15	16	17	18	20	22	24	26	29	
K35 Carbide	100 – 150	75	0.28	0.28	0.30	0.30	0.30	0.30	0.30	0.36	0.36	0.36	0.36	0.45	0.45
	150 – 250	61	0.24	0.24	0.27	0.27	0.27	0.28	0.28	0.33	0.33	0.33	0.33	0.42	0.42
	250 - 350	57	0.20	0.20	0.24	0.24	0.24	0.24	0.28	0.30	0.30	0.30	0.30	0.33	0.33

• 0.80 multiplier for feed rate on 7 x Diameter holder

**IMPORTANT NOTE:** - The speeds and feeds listed above are considered a general guideline for all applications. In the case of extreme ductile steels a further reduction in speed of 20% should be applied, in these instances GEN3SYS is the preferred option with its advanced geometry though rigidity must be excellent. Factory technical assistance is also available for your specific applications through our Application Engineering Team

mm/min = (RPM) • (mm/rev)

M/min = RPM • 0.003 • Dia

RPM = M/min • (318.47/Dia)