

DIAbide

Cutting Data: Turning and Drilling

Turning Data

Unfilled Plastics

Application	Cutting Speed Vc	Feed Rate per Rev, f
Rough	2000 - 3000	0.010 - 0.020
Finish	—	—

Graphite/Carbon

Application	Cutting Speed Vc	Feed Rate per Rev, f
Rough	—	—
Finish	3000 - 4000	0.003 - 0.010

Green-Ceramic/Carbide

Application	Cutting Speed Vc	Feed Rate per Rev, f
Rough	100 - 500	0.002 - 0.010
Finish	100 - 500	0.002 - 0.010

Reinforced Plastics

Application	Cutting Speed Vc	Feed Rate per Rev, f
Rough	500 - 1000	0.008 - 0.020
Finish	—	—

Composite Material

Application	Cutting Speed Vc	Feed Rate per Rev, f
Rough	—	—
Finish	1000 - 1500	0.003 - 0.010

Drilling Data

Drill Diameter	Graphite Hard Carbon	Green Ceramic, Green Carbide, Powder Filled Plastics	Unfilled Plastics	Glass Fiber Reinforced Plastics
	Cutting Speed, Vc	Cutting Speed, Vc	Cutting Speed, Vc	Cutting Speed, Vc
	500 - 2500	200 - 1000	200 - 700	200 - 500
	Feed Rate per Rev, f	Feed Rate per Rev, f	Feed Rate per Rev, f	Feed Rate per Rev, f
1/32 - 1/16	0.00025 - 0.001	0.0002 - 0.00075	0.00025 - 0.001	0.00025 - 0.001
1/16 - 1/8	0.0005 - 0.002	0.0005 - 0.002	0.0005 - 0.002	0.0005 - 0.002
1/8 - 3/16	0.001 - 0.004	0.001 - 0.003	0.001 - 0.004	0.001 - 0.004
3/16 - 1/4	0.002 - 0.005	0.002 - 0.004	0.002 - 0.005	0.002 - 0.005
1/4 - 5/16	0.002 - 0.006	0.002 - 0.005	0.002 - 0.006	0.002 - 0.006
5/16 - 3/8	0.002 - 0.008	0.002 - 0.006	0.002 - 0.008	0.002 - 0.008
3/8 - 1/2	0.002 - 0.010	0.002 - 0.008	0.002 - 0.010	0.002 - 0.010