

HIGH SPEED DRILLS FOR METAL - COMPARISONS

COBALT FLUTE GROUND

- > Split point for quick start - no skidding on surfaces
- > Industrial quality & strength - higher operating speeds
- > Very long product life
- > Ability to withstand heat generation & perform for long periods without cooling
- > Ideal for most hardened metals stainless steel, titanium, bronze & cast iron.
- > Cut through weld seams
- > Less suitable for more general purpose applications.

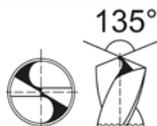
FLUTE GROUND

- > Split point for quick start and no skidding on surfaces
- > Industrial use - ideal for wide ranging, general use in relatively hard metals, plastics and wood.
- > Occasional use in stainless steel and other hard materials
- > Will wear more quickly in harder materials such as stainless steel

ROLL FORGED

- > Medium use and for general purpose applications on softer materials

HIGH SPEED DRILLS FOR METAL - DRILL POINTS



- > Drill harder steel alloys - self-centering
- > Flatter cutting face so engages quicker
- > Ideal for use in handheld power drills
- > Requires less operator force than 118° point drills



- > General purpose use - Not self-centering
- > More aggressive tip
- > For drilling softer materials like wood, aluminum and low to medium steel alloys
- > Will require centre punch for hard materials



SPEEDS GUIDE - METAL AND WOOD DRILLING

HIGH SPEED STEEL DRILLS FOR METAL - RPM

DIAMETER	STAINLESS STEEL	MILD STEEL	GREY CAST IRON	ALUMINIUM COPPER BRASS
1.0 mm	4456	7003	10504	12732
2.0 mm	2228	3501	5252	6366
3.0 mm	1485	2334	3501	4244
4.0 mm	1114	1751	2626	3183
5.0 mm	891	1401	2101	2546
6.0 mm	743	1167	1751	2122
7.0 mm	637	1000	1501	1819
8.0 mm	557	875	1313	1592
9.0 mm	495	778	1167	1415
10.0 mm	446	700	1050	1340
11.0 mm	405	637	955	1157
12.0 mm	371	584	875	1061
13.0 mm	343	539	808	979

AUGER WOOD DRILLS (HEX/S&S) - RPM

DIAMETER	SOFTWOOD	HARDWOOD
6-10 mm	2000	1500
11-15 mm	1500	1250
16-20 mm	1250	1000
21-25 mm	1000	750
26-32 mm	750	500

FLAT WOOD BITS - RPM

DIAMETER	COMPOSITES & SOFTWOOD
10-13 mm	2000
14-25 mm	1750
26-40 mm	1500



Drilling speeds listed are a guide only