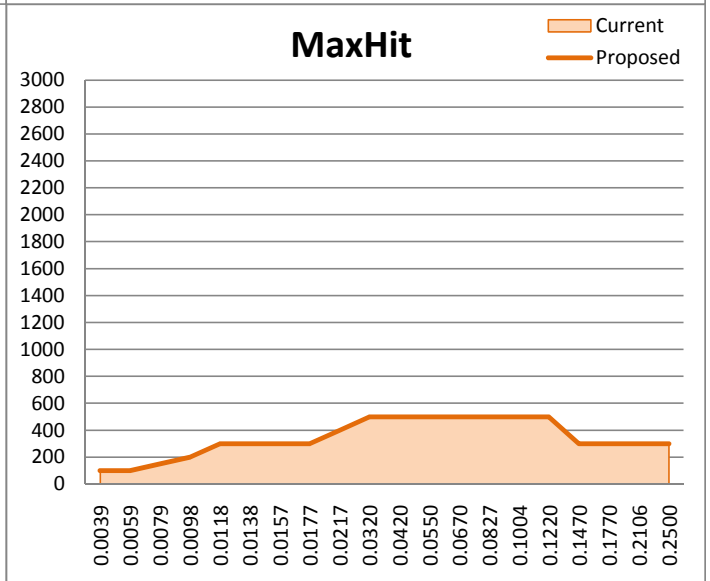
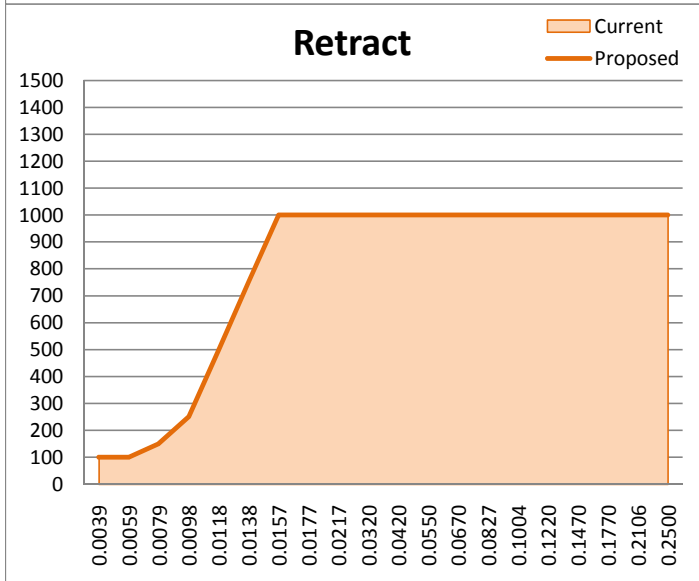
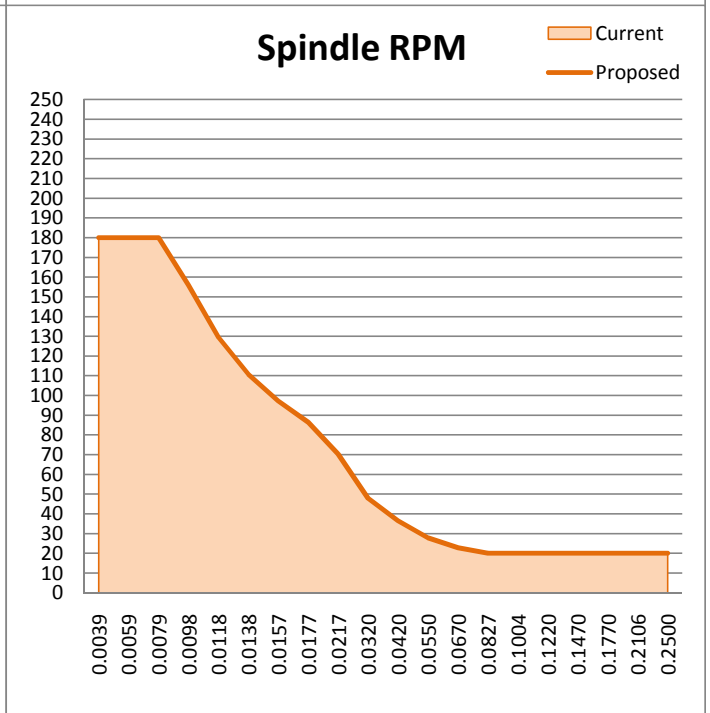
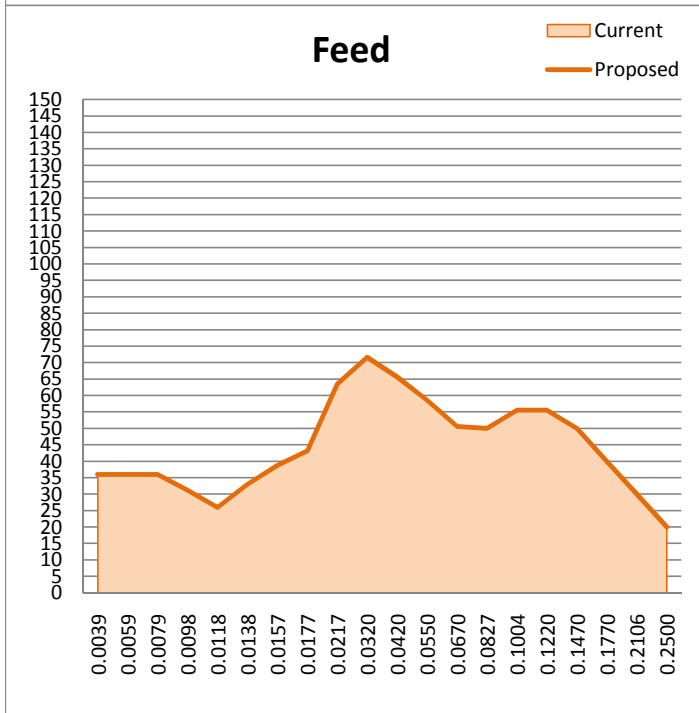
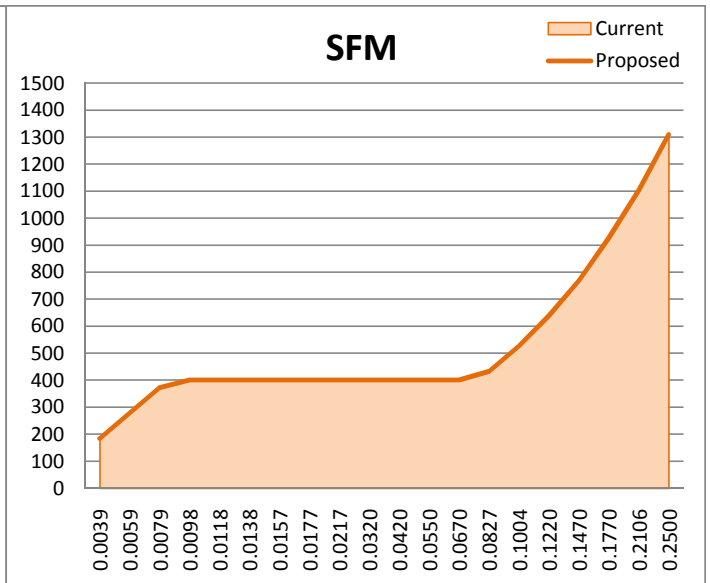
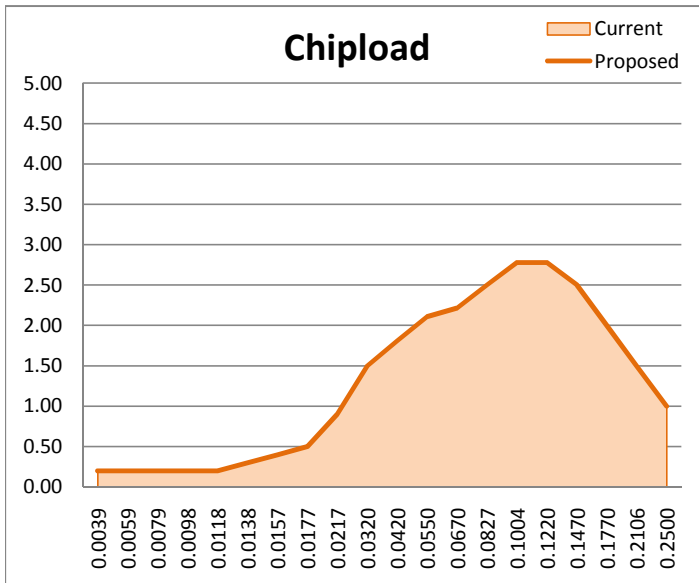




Application:	
Material Type:	CIC
Drill Designs:	MDBT, WTCB

Process Parameters:	
Cutting Speed (SFM)	400
Maximum Chipload (0.001"/Revolution)	2.78
Maximum Hit Count	500
Maximum Spindle RPM	180
Minimum Spindle RPM	20
Z-Offset (1-Point Clearance + Additional Depth; 2-Diameter)	1
Additional Depth (inch)	0.010
Maximum Drill Depth (Inch)	0.040

	Diameter		Chipload	SFM	Retract	MaxHit
1	0.0039	0.10MM	0.20		100	100
2	0.0059	#97 - 0.15MM	0.20		100	100
3	0.0079	#92 - 0.20MM	0.20		150	150
4	0.0098	0.25MM	0.20		250	200
5	0.0118	0.30MM	0.20		500	300
6	0.0138	0.35MM	0.30		750	300
7	0.0157	0.40MM	0.40		1000	300
8	0.0177	0.45MM	0.50		1000	300
9	0.0217	0.55MM	0.90		1000	400
10	0.0320	#67	1.50		1000	500
11	0.0420	#58	1.81		1000	500
12	0.0550	#54	2.11		1000	500
13	0.0670	#51	2.22		1000	500
14	0.0827	2.10MM	2.50		1000	500
15	0.1004	2.55MM	2.78		1000	500
16	0.1220	3.10MM	2.78		1000	500
17	0.1470	#26	2.50		1000	300
18	0.1770	#16	2.00		1000	300
19	0.2106	5.35MM	1.50		1000	300
20	0.2500	1/4 - 6.35MM	1.00		1000	300





CIC MDBT, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
MDBT	0.0039	0.10MM	36	180	100	100	-0.011	184	0.20
	0.0051	0.13MM	36	180	100	100	-0.011	240	0.20
	0.0059	#97 - 0.15MM	36	180	100	100	-0.011	278	0.20
	0.0063	#96	36	180	110	125	-0.011	297	0.20
	0.0067	#95	36	180	120	125	-0.012	316	0.20
	0.0071	#94	36	180	130	150	-0.012	335	0.20
	0.0075	#93	36	180	140	150	-0.012	353	0.20
MDBT	0.0079	#92 - 0.20MM	36	180	150	150	-0.012	372	0.20
	0.0083	#91	35	174	171	175	-0.012	378	0.20
	0.0087	#90	34	169	192	175	-0.012	384	0.20
	0.0091	#89	33	164	213	200	-0.012	390	0.20
	0.0095	#88	32	159	234	200	-0.012	396	0.20
	0.0098	0.25MM	31	156	250	200	-0.012	400	0.20
	0.0100	#87	31	153	275	225	-0.012	400	0.20
	0.0105	#86	29	146	338	250	-0.012	400	0.20
	0.0110	#85	28	139	400	275	-0.013	400	0.20
	0.0115	#84	27	133	463	300	-0.013	400	0.20
	0.0118	0.30MM	26	129	500	300	-0.013	400	0.20
	0.0120	#83	27	127	525	300	-0.013	400	0.21
	0.0125	#82	29	122	588	300	-0.013	400	0.23
	0.0130	#81	30	118	650	300	-0.013	400	0.26
	0.0135	#80	32	113	713	300	-0.013	400	0.28
	0.0138	0.35MM	33	111	750	300	-0.013	400	0.30
	0.0145	#79	35	105	842	300	-0.013	400	0.33
	0.0156	1/64	38	98	987	300	-0.014	400	0.39
	0.0157	0.40MM	39	97	1000	300	-0.014	400	0.40
	0.0160	#78	39	95	1000	300	-0.014	400	0.41
	0.0177	0.45MM	43	86	1000	300	-0.014	400	0.50
	0.0180	#77	45	85	1000	325	-0.014	400	0.53
	0.0197	0.50MM	54	78	1000	350	-0.015	400	0.70
0.0200	#76	56	76	1000	375	-0.015	400	0.73	
MDBT	0.0210	#75	60	73	1000	400	-0.015	400	0.83
	0.0217	0.55MM	63	70	1000	400	-0.015	400	0.90
	0.0225	#74	64	68	1000	425	-0.015	400	0.95
	0.0236	0.60MM	65	65	1000	425	-0.016	400	1.01



CIC MDBT, WTCB

Series	Diameter (in.)		Feed (IPM)	Speed (K-RPM)	Retract (IPM)	MaxHit	Z-offset (in.)	SFM	Chipload (0.001"/Rev.)
MDBT	0.0240	#73	66	64	1000	425	-0.016	400	1.03
	0.0250	#72	67	61	1000	450	-0.016	400	1.09
	0.0256	0.65MM	67	60	1000	450	-0.016	400	1.13
	0.0260	#71	68	59	1000	450	-0.016	400	1.15
	0.0276	0.70MM	69	55	1000	475	-0.016	400	1.24
	0.0280	#70	69	55	1000	475	-0.017	400	1.27
	0.0292	#69	70	52	1000	475	-0.017	400	1.34
	0.0295	0.75MM	70	52	1000	500	-0.017	400	1.35
	0.0310	#68	71	49	1000	500	-0.017	400	1.44
	0.0312	1/32	71	49	1000	500	-0.017	400	1.45
	0.0315	0.80MM	71	49	1000	500	-0.017	400	1.47
	0.0320	#67	72	48	1000	500	-0.017	400	1.50
	0.0330	#66	71	46	1000	500	-0.018	400	1.53
	0.0335	0.85MM	71	46	1000	500	-0.018	400	1.55
	0.0350	#65	69	44	1000	500	-0.018	400	1.59
	0.0354	0.90MM	69	43	1000	500	-0.018	400	1.60
	0.0360	#64	69	42	1000	500	-0.018	400	1.62
	0.0370	#63	68	41	1000	500	-0.019	400	1.65
	0.0374	0.95MM	68	41	1000	500	-0.019	400	1.67
	0.0380	#62	68	40	1000	500	-0.019	400	1.68
	0.0390	#61	67	39	1000	500	-0.019	400	1.71
	0.0394	1.00MM	67	39	1000	500	-0.019	400	1.73
	0.0400	#60	67	38	1000	500	-0.019	400	1.74
	0.0410	#59	66	37	1000	500	-0.020	400	1.78
	0.0413	1.05MM	66	37	1000	500	-0.020	400	1.78
	0.0420	#58	66	36	1000	500	-0.020	400	1.81
	0.0430	#57	65	36	1000	500	-0.020	400	1.83
	0.0433	1.10MM	65	35	1000	500	-0.020	400	1.84
	0.0441	1.12MM	64	35	1000	500	-0.020	400	1.85
	0.0453	1.15MM	63	34	1000	500	-0.021	400	1.88
	0.0465	#56	63	33	1000	500	-0.021	400	1.91
	0.0469	3/64	63	33	1000	500	-0.021	400	1.92
0.0472	1.20MM	62	32	1000	500	-0.021	400	1.93	
0.0492	1.25MM	61	31	1000	500	-0.021	400	1.97	
0.0512	1.30MM	60	30	1000	500	-0.022	400	2.02	



CIC MDBT, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
MDBT	0.0520	#55	60	29	1000	500	-0.022	400	2.04
	0.0531	1.35MM	59	29	1000	500	-0.022	400	2.06
	0.0550	#54	59	28	1000	500	-0.023	400	2.11
	0.0551	1.40MM	58	28	1000	500	-0.023	400	2.11
	0.0571	1.45MM	57	27	1000	500	-0.023	400	2.13
	0.0591	1.50MM	55	26	1000	500	-0.024	400	2.14
	0.0595	#53	55	26	1000	500	-0.024	400	2.15
	0.0610	1.55MM	54	25	1000	500	-0.024	400	2.16
	0.0625	1/16	53	24	1000	500	-0.025	400	2.18
	0.0630	1.60MM	53	24	1000	500	-0.025	400	2.18
	0.0635	#52	53	24	1000	500	-0.025	400	2.19
	0.0650	1.65MM	52	24	1000	500	-0.025	400	2.20
	0.0669	1.70MM	51	23	1000	500	-0.026	400	2.22
	0.0670	#51	51	23	1000	500	-0.026	400	2.22
	0.0689	1.75MM	50	22	1000	500	-0.026	404	2.25
	0.0700	#50	50	22	1000	500	-0.026	406	2.27
	0.0709	1.80MM	50	22	1000	500	-0.027	408	2.29
	0.0728	1.85MM	50	22	1000	500	-0.027	412	2.32
	0.0730	#49	50	22	1000	500	-0.027	413	2.33
	0.0748	1.90MM	50	21	1000	500	-0.027	416	2.36
	0.0760	#48	50	21	1000	500	-0.028	419	2.38
	0.0768	1.95MM	50	21	1000	500	-0.028	421	2.39
	0.0781	5/64	50	21	1000	500	-0.028	423	2.42
	0.0785	#47	50	21	1000	500	-0.028	424	2.42
	0.0787	2.00MM	50	21	1000	500	-0.028	425	2.43
	0.0807	2.05MM	50	20	1000	500	-0.029	429	2.46
	0.0810	#46	50	20	1000	500	-0.029	429	2.47
	0.0820	#45	50	20	1000	500	-0.029	432	2.49
	0.0827	2.10MM	50	20	1000	500	-0.029	433	2.50
	0.0846	2.15MM	51	20	1000	500	-0.030	443	2.53
	0.0860	#44	51	20	1000	500	-0.030	450	2.55
	0.0866	2.20MM	51	20	1000	500	-0.030	453	2.56
	0.0886	2.25MM	52	20	1000	500	-0.031	464	2.59
0.0890	#43	52	20	1000	500	-0.031	466	2.60	
0.0906	2.30MM	52	20	1000	500	-0.031	474	2.62	



CIC MDBT, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
MDBT	0.0925	2.35MM	53	20	1000	500	-0.032	484	2.65
	0.0935	#42	53	20	1000	500	-0.032	490	2.67
	0.0938	3/32	53	20	1000	500	-0.032	491	2.67
	0.0945	2.40MM	54	20	1000	500	-0.032	495	2.69
	0.0960	#41	54	20	1000	500	-0.032	503	2.71
	0.0965	2.45MM	54	20	1000	500	-0.032	505	2.72
	0.0980	#40	55	20	1000	500	-0.033	513	2.74
	0.0984	2.50MM	55	20	1000	500	-0.033	515	2.75
	0.0995	#39	55	20	1000	500	-0.033	521	2.76
	0.1004	2.55MM	56	20	1000	500	-0.033	526	2.78
	0.1015	#38	56	20	1000	500	-0.034	531	2.78
	0.1024	2.60MM	56	20	1000	500	-0.034	536	2.78
	0.1040	#37	56	20	1000	500	-0.034	545	2.78
	0.1043	2.65MM	56	20	1000	500	-0.034	546	2.78
	0.1063	2.70MM	56	20	1000	500	-0.035	557	2.78
	0.1065	#36	56	20	1000	500	-0.035	558	2.78
	0.1083	2.75MM	56	20	1000	500	-0.035	567	2.78
	0.1094	7/64	56	20	1000	500	-0.036	573	2.78
	0.1100	#35	56	20	1000	500	-0.036	576	2.78
	0.1102	2.80MM	56	20	1000	500	-0.036	577	2.78
	0.1110	#34	56	20	1000	500	-0.036	581	2.78
	0.1122	2.85MM	56	20	1000	500	-0.036	587	2.78
	0.1130	#33	56	20	1000	500	-0.036	592	2.78
	0.1142	2.90MM	56	20	1000	500	-0.037	598	2.78
	0.1160	#32	56	20	1000	500	-0.037	607	2.78
	0.1161	2.95MM	56	20	1000	500	-0.037	608	2.78
	0.1181	3.00MM	56	20	1000	500	-0.038	618	2.78
	0.1200	#31	56	20	1000	500	-0.038	628	2.78
0.1201	3.05MM	56	20	1000	500	-0.038	629	2.78	
0.1220	3.10MM	56	20	1000	500	-0.038	639	2.78	
0.1240	3.15MM	55	20	1000	500	-0.039	649	2.76	
0.1250	1/8	55	20	1000	500	-0.039	654	2.74	
WTCB	0.1260	3.20MM	55	20	1000	475	-0.018	660	2.73
	0.1280	3.25MM	54	20	1000	475	-0.018	670	2.71
	0.1285	#30	54	20	1000	450	-0.018	673	2.71



CIC MDBT, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
WTCB	0.1299	3.30MM	54	20	1000	450	-0.019	680	2.69
	0.1319	3.35MM	53	20	1000	425	-0.019	691	2.67
	0.1339	3.40MM	53	20	1000	425	-0.019	701	2.65
	0.1358	3.45MM	52	20	1000	400	-0.019	711	2.62
	0.1360	#29	52	20	1000	400	-0.019	712	2.62
	0.1378	3.50MM	52	20	1000	375	-0.019	722	2.60
	0.1398	3.55MM	52	20	1000	375	-0.019	732	2.58
	0.1405	#28	51	20	1000	375	-0.019	736	2.57
	0.1406	9/64	51	20	1000	375	-0.019	736	2.57
	0.1417	3.60MM	51	20	1000	350	-0.019	742	2.56
	0.1437	3.65MM	51	20	1000	350	-0.019	752	2.54
	0.1440	#27	51	20	1000	325	-0.019	754	2.53
	0.1457	3.70MM	50	20	1000	325	-0.020	763	2.51
	0.1470	#26	50	20	1000	300	-0.020	770	2.50
	0.1476	3.75MM	50	20	1000	300	-0.020	773	2.49
	0.1495	#25	49	20	1000	300	-0.020	783	2.46
	0.1496	3.80MM	49	20	1000	300	-0.020	783	2.46
	0.1516	3.85MM	48	20	1000	300	-0.020	794	2.42
	0.1520	#24	48	20	1000	300	-0.020	796	2.42
	0.1535	3.90MM	48	20	1000	300	-0.020	804	2.39
	0.1540	#23	48	20	1000	300	-0.020	806	2.38
	0.1555	3.95MM	47	20	1000	300	-0.020	814	2.36
	0.1562	5/32	47	20	1000	300	-0.020	818	2.35
	0.1570	#22	47	20	1000	300	-0.020	822	2.33
	0.1575	4.00MM	47	20	1000	300	-0.020	825	2.33
	0.1590	#21	46	20	1000	300	-0.020	833	2.30
	0.1594	4.05MM	46	20	1000	300	-0.020	835	2.29
	0.1610	#20	45	20	1000	300	-0.021	843	2.27
	0.1614	4.10MM	45	20	1000	300	-0.021	845	2.26
	0.1634	4.15MM	45	20	1000	300	-0.021	856	2.23
	0.1654	4.20MM	44	20	1000	300	-0.021	866	2.19
	0.1660	#19	44	20	1000	300	-0.021	869	2.18
	0.1673	4.25MM	43	20	1000	300	-0.021	876	2.16
0.1693	4.30MM	43	20	1000	300	-0.021	886	2.13	
0.1695	#18	43	20	1000	300	-0.021	887	2.13	



CIC MDBT, WTCB

Series	Diameter		Feed	Speed	Retract	MaxHit	Z-offset	SFM	Chipload
	(in.)		(IPM)	(K-RPM)	(IPM)		(in.)		(0.001"/Rev.)
WTCB	0.1713	4.35MM	42	20	1000	300	-0.021	897	2.10
	0.1719	11/64	42	20	1000	300	-0.021	900	2.09
	0.1730	#17	41	20	1000	300	-0.021	906	2.07
	0.1732	4.40MM	41	20	1000	300	-0.021	907	2.06
	0.1752	4.45MM	41	20	1000	300	-0.022	917	2.03
	0.1770	#16	40	20	1000	300	-0.022	927	2.00
	0.1772	4.50MM	40	20	1000	300	-0.022	928	2.00
	0.1791	4.55MM	39	20	1000	300	-0.022	938	1.97
	0.1800	#15	39	20	1000	300	-0.022	942	1.96
	0.1811	4.60MM	39	20	1000	300	-0.022	948	1.94
	0.1820	#14	39	20	1000	300	-0.022	953	1.93
	0.1831	4.65MM	38	20	1000	300	-0.022	959	1.91
	0.1850	4.70MM	38	20	1000	300	-0.022	969	1.88
	0.1870	4.75MM	37	20	1000	300	-0.022	979	1.85
	0.1875	3/16	37	20	1000	300	-0.022	982	1.84
	0.1890	#12 - 4.80MM	36	20	1000	300	-0.022	990	1.82
	0.1909	4.85MM	36	20	1000	300	-0.023	1000	1.79
	0.1910	#11	36	20	1000	300	-0.023	1000	1.79
	0.1929	4.90MM	35	20	1000	300	-0.023	1010	1.76
	0.1935	#10	35	20	1000	300	-0.023	1013	1.75
	0.1949	4.95MM	35	20	1000	300	-0.023	1020	1.73
	0.1960	#9	34	20	1000	300	-0.023	1026	1.72
	0.1969	5.00MM	34	20	1000	300	-0.023	1031	1.70
	0.1988	5.05MM	34	20	1000	300	-0.023	1041	1.68
	0.1990	#8	33	20	1000	300	-0.023	1042	1.67
	0.2008	5.10MM	33	20	1000	300	-0.023	1051	1.65
	0.2010	#7	33	20	1000	300	-0.023	1052	1.64
	0.2028	5.15MM	32	20	1000	300	-0.023	1062	1.62
	0.2031	13/64	32	20	1000	300	-0.023	1063	1.61
	0.2040	#6	32	20	1000	300	-0.023	1068	1.60
	0.2047	5.20MM	32	20	1000	300	-0.023	1072	1.59
	0.2055	#5	32	20	1000	300	-0.024	1076	1.58
0.2067	5.25MM	31	20	1000	300	-0.024	1082	1.56	
0.2087	5.30MM	31	20	1000	300	-0.024	1093	1.53	
0.2090	#4	30	20	1000	300	-0.024	1094	1.52	



CIC MDBT, WTCB

Series	Diameter (in.)		Feed (IPM)	Speed (K-RPM)	Retract (IPM)	MaxHit	Z-offset (in.)	SFM	Chipload (0.001"/Rev.)
WTCB	0.2106	5.35MM	30	20	1000	300	-0.024	1103	1.50
	0.2126	5.40MM	29	20	1000	300	-0.024	1113	1.47
	0.2130	#3	29	20	1000	300	-0.024	1115	1.47
	0.2146	5.45MM	29	20	1000	300	-0.024	1124	1.45
	0.2165	5.50MM	29	20	1000	300	-0.024	1134	1.43
	0.2185	5.55MM	28	20	1000	300	-0.024	1144	1.40
	0.2188	7/32	28	20	1000	300	-0.024	1146	1.40
	0.2205	5.60MM	27	20	1000	300	-0.025	1155	1.37
	0.2210	#2	27	20	1000	300	-0.025	1157	1.37
	0.2224	5.65MM	27	20	1000	300	-0.025	1164	1.35
	0.2244	5.70MM	26	20	1000	300	-0.025	1175	1.32
	0.2264	5.75MM	26	20	1000	300	-0.025	1185	1.30
	0.2280	#1	26	20	1000	300	-0.025	1194	1.28
	0.2283	5.80MM	26	20	1000	300	-0.025	1195	1.28
	0.2303	5.85MM	25	20	1000	300	-0.025	1206	1.25
	0.2323	5.90MM	24	20	1000	300	-0.025	1216	1.22
	0.2340	#A	24	20	1000	300	-0.025	1225	1.20
	0.2343	5.95MM	24	20	1000	300	-0.025	1227	1.20
	0.2344	15/64	24	20	1000	300	-0.025	1227	1.20
	0.2362	6.00MM	24	20	1000	300	-0.026	1237	1.18
	0.2380	#B	23	20	1000	300	-0.026	1246	1.15
	0.2382	6.05MM	23	20	1000	300	-0.026	1247	1.15
	0.2402	6.10MM	22	20	1000	300	-0.026	1258	1.12
	0.2420	#C	22	20	1000	300	-0.026	1267	1.10
	0.2421	6.15MM	22	20	1000	300	-0.026	1268	1.10
	0.2441	6.20MM	21	20	1000	300	-0.026	1278	1.07
	0.2460	#D	21	20	1000	300	-0.026	1288	1.05
	0.2461	6.25MM	21	20	1000	300	-0.026	1289	1.05
	0.2480	6.30MM	21	20	1000	300	-0.026	1299	1.03
	0.2500	1/4 - 6.35MM	20	20	1000	300	-0.026	1309	1.00