



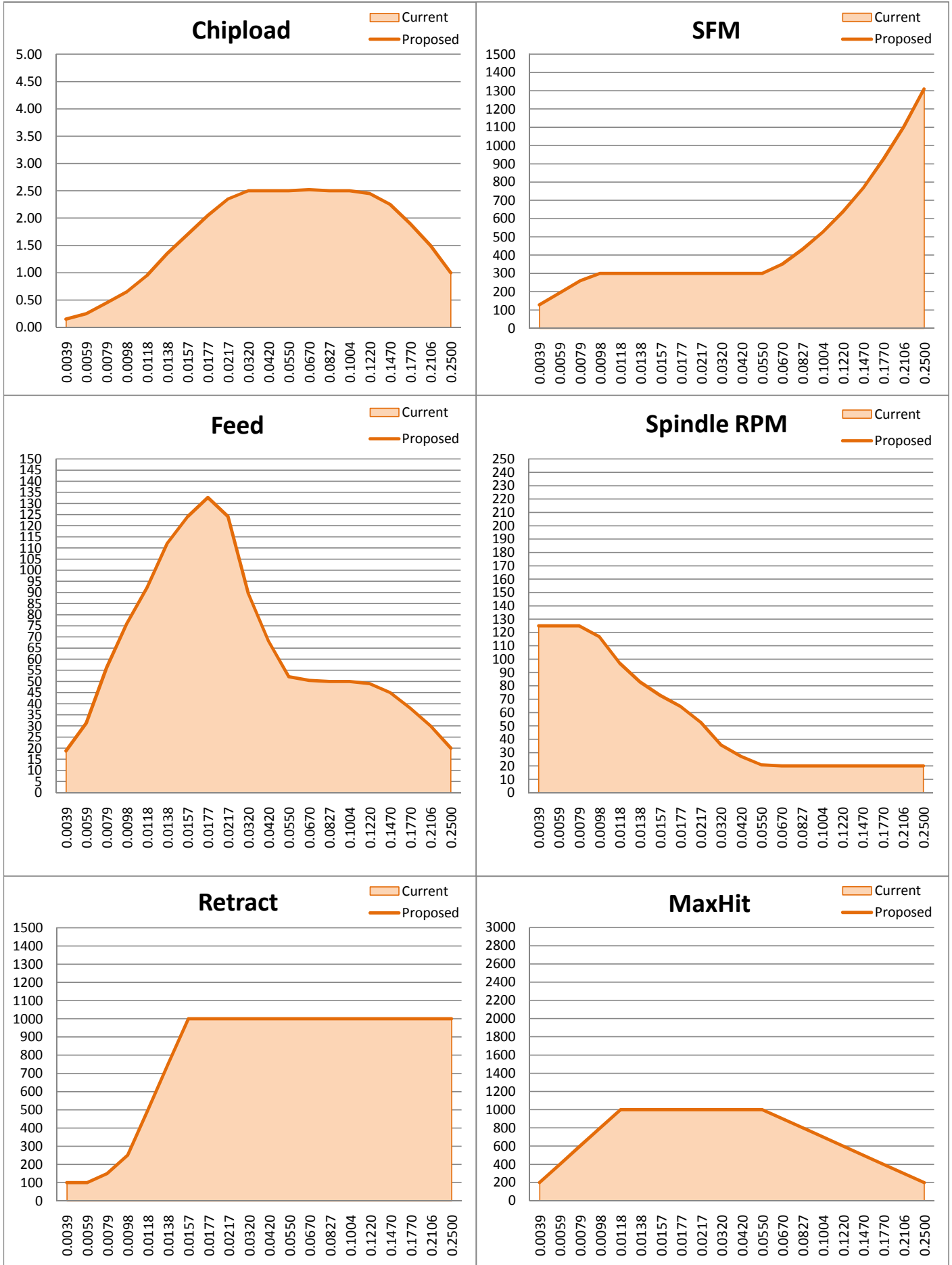
Application:	
Material Type:	Flex
Drill Designs:	MDBT, WTCB

Process Parameters:	
Cutting Speed (SFM)	300
Maximum Chipload (0.001"/Revolution)	2.52
Maximum Hit Count	1000
Maximum Spindle RPM	125
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	0.15		100	200
2	0.0059	#97 - 0.15MM	0.25		100	400
3	0.0079	#92 - 0.20MM	0.45		150	600
4	0.0098	0.25MM	0.65		250	800
5	0.0118	0.30MM	0.95		500	1000
6	0.0138	0.35MM	1.35		750	1000
7	0.0157	0.40MM	1.70		1000	1000
8	0.0177	0.45MM	2.05		1000	1000
9	0.0217	0.55MM	2.35		1000	1000
10	0.0320	#67	2.50		1000	1000
11	0.0420	#58	2.50		1000	1000
12	0.0550	#54	2.50		1000	1000
13	0.0670	#51	2.52		1000	900
14	0.0827	2.10MM	2.50		1000	800
15	0.1004	2.55MM	2.50		1000	700
16	0.1220	3.10MM	2.45		1000	600
17	0.1470	#26	2.25		1000	500
18	0.1770	#16	1.90		1000	400
19	0.2106	5.35MM	1.50		1000	300
20	0.2500	1/4 - 6.35MM	1.00		1000	200

Flex

MDBT, WTCB





Flex 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	19	125	100	200	-0.011	128	0.15
	0.0051	0.13MM	26	125	100	325	-0.011	167	0.21
	0.0059	#97 - 0.15MM	31	125	100	400	-0.011	193	0.25
	0.0063	#96	36	125	110	450	-0.011	206	0.29
	0.0067	#95	41	125	120	500	-0.012	219	0.33
	0.0071	#94	46	125	130	525	-0.012	232	0.37
	0.0075	#93	51	125	140	575	-0.012	245	0.41
MDBT	0.0079	#92 - 0.20MM	56	125	150	600	-0.012	259	0.45
	0.0083	#91	61	123	171	650	-0.012	267	0.49
	0.0087	#90	65	121	192	700	-0.012	276	0.53
	0.0091	#89	69	120	213	750	-0.012	285	0.58
	0.0095	#88	73	118	234	775	-0.012	293	0.62
	0.0098	0.25MM	76	117	250	800	-0.012	300	0.65
	0.0100	#87	78	115	275	825	-0.012	300	0.68
	0.0105	#86	82	109	338	875	-0.012	300	0.76
	0.0110	#85	86	104	400	925	-0.013	300	0.83
	0.0115	#84	90	100	463	975	-0.013	300	0.91
	0.0118	0.30MM	92	97	500	1000	-0.013	300	0.95
	0.0120	#83	95	95	525	1000	-0.013	300	0.99
	0.0125	#82	100	92	588	1000	-0.013	300	1.09
	0.0130	#81	105	88	650	1000	-0.013	300	1.19
	0.0135	#80	109	85	713	1000	-0.013	300	1.29
	0.0138	0.35MM	112	83	750	1000	-0.013	300	1.35
	0.0145	#79	117	79	842	1000	-0.013	300	1.48
	0.0156	1/64	124	73	987	1000	-0.014	300	1.68
	0.0157	0.40MM	124	73	1000	1000	-0.014	300	1.70
	0.0160	#78	126	72	1000	1000	-0.014	300	1.75
	0.0177	0.45MM	133	65	1000	1000	-0.014	300	2.05
	0.0180	#77	132	64	1000	1000	-0.014	300	2.07
	0.0197	0.50MM	128	58	1000	1000	-0.015	300	2.20
0.0200	#76	127	57	1000	1000	-0.015	300	2.22	
MDBT	0.0210	#75	125	55	1000	1000	-0.015	300	2.30
	0.0217	0.55MM	124	53	1000	1000	-0.015	300	2.35
	0.0225	#74	120	51	1000	1000	-0.015	300	2.36
	0.0236	0.60MM	115	49	1000	1000	-0.016	300	2.38



Flex 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	114	48	1000	1000	-0.016	300	2.38
	0.0250	#72	110	46	1000	1000	-0.016	300	2.40
	0.0256	0.65MM	108	45	1000	1000	-0.016	300	2.41
	0.0260	#71	106	44	1000	1000	-0.016	300	2.41
	0.0276	0.70MM	101	42	1000	1000	-0.016	300	2.44
	0.0280	#70	100	41	1000	1000	-0.017	300	2.44
	0.0292	#69	97	39	1000	1000	-0.017	300	2.46
	0.0295	0.75MM	96	39	1000	1000	-0.017	300	2.46
	0.0310	#68	92	37	1000	1000	-0.017	300	2.49
	0.0312	1/32	91	37	1000	1000	-0.017	300	2.49
	0.0315	0.80MM	91	36	1000	1000	-0.017	300	2.49
	0.0320	#67	90	36	1000	1000	-0.017	300	2.50
	0.0330	#66	87	35	1000	1000	-0.018	300	2.50
	0.0335	0.85MM	86	34	1000	1000	-0.018	300	2.50
	0.0350	#65	82	33	1000	1000	-0.018	300	2.50
	0.0354	0.90MM	81	32	1000	1000	-0.018	300	2.50
	0.0360	#64	80	32	1000	1000	-0.018	300	2.50
	0.0370	#63	77	31	1000	1000	-0.019	300	2.50
	0.0374	0.95MM	77	31	1000	1000	-0.019	300	2.50
	0.0380	#62	75	30	1000	1000	-0.019	300	2.50
	0.0390	#61	73	29	1000	1000	-0.019	300	2.50
	0.0394	1.00MM	73	29	1000	1000	-0.019	300	2.50
	0.0400	#60	72	29	1000	1000	-0.019	300	2.50
	0.0410	#59	70	28	1000	1000	-0.020	300	2.50
	0.0413	1.05MM	69	28	1000	1000	-0.020	300	2.50
	0.0420	#58	68	27	1000	1000	-0.020	300	2.50
	0.0430	#57	67	27	1000	1000	-0.020	300	2.50
	0.0433	1.10MM	66	26	1000	1000	-0.020	300	2.50
	0.0441	1.12MM	65	26	1000	1000	-0.020	300	2.50
	0.0453	1.15MM	63	25	1000	1000	-0.021	300	2.50
	0.0465	#56	62	25	1000	1000	-0.021	300	2.50
	0.0469	3/64	61	24	1000	1000	-0.021	300	2.50
0.0472	1.20MM	61	24	1000	1000	-0.021	300	2.50	
0.0492	1.25MM	58	23	1000	1000	-0.021	300	2.50	
0.0512	1.30MM	56	22	1000	1000	-0.022	300	2.50	



Flex 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	55	22	1000	1000	-0.022	300	2.50
	0.0531	1.35MM	54	22	1000	1000	-0.022	300	2.50
	0.0550	#54	52	21	1000	1000	-0.023	300	2.50
	0.0551	1.40MM	52	21	1000	1000	-0.023	300	2.50
	0.0571	1.45MM	52	21	1000	1000	-0.023	309	2.50
	0.0591	1.50MM	51	21	1000	975	-0.024	317	2.51
	0.0595	#53	51	20	1000	975	-0.024	319	2.51
	0.0610	1.55MM	51	20	1000	950	-0.024	325	2.51
	0.0625	1/16	51	20	1000	950	-0.025	332	2.51
	0.0630	1.60MM	51	20	1000	950	-0.025	334	2.51
	0.0635	#52	51	20	1000	950	-0.025	336	2.52
	0.0650	1.65MM	51	20	1000	925	-0.025	342	2.52
	0.0669	1.70MM	50	20	1000	925	-0.026	350	2.52
	0.0670	#51	50	20	1000	900	-0.026	351	2.52
	0.0689	1.75MM	50	20	1000	900	-0.026	361	2.52
	0.0700	#50	50	20	1000	900	-0.026	367	2.52
	0.0709	1.80MM	50	20	1000	900	-0.027	371	2.52
	0.0728	1.85MM	50	20	1000	875	-0.027	381	2.51
	0.0730	#49	50	20	1000	875	-0.027	382	2.51
	0.0748	1.90MM	50	20	1000	875	-0.027	392	2.51
	0.0760	#48	50	20	1000	850	-0.028	398	2.51
	0.0768	1.95MM	50	20	1000	850	-0.028	402	2.51
	0.0781	5/64	50	20	1000	850	-0.028	409	2.51
	0.0785	#47	50	20	1000	850	-0.028	411	2.51
	0.0787	2.00MM	50	20	1000	850	-0.028	412	2.51
	0.0807	2.05MM	50	20	1000	825	-0.029	423	2.50
	0.0810	#46	50	20	1000	825	-0.029	424	2.50
	0.0820	#45	50	20	1000	825	-0.029	429	2.50
	0.0827	2.10MM	50	20	1000	800	-0.029	433	2.50
	0.0846	2.15MM	50	20	1000	800	-0.030	443	2.50
	0.0860	#44	50	20	1000	800	-0.030	450	2.50
	0.0866	2.20MM	50	20	1000	800	-0.030	453	2.50
	0.0886	2.25MM	50	20	1000	775	-0.031	464	2.50
0.0890	#43	50	20	1000	775	-0.031	466	2.50	
0.0906	2.30MM	50	20	1000	775	-0.031	474	2.50	



Flex 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	50	20	1000	750	-0.032	484	2.50
	0.0935	#42	50	20	1000	750	-0.032	490	2.50
	0.0938	3/32	50	20	1000	750	-0.032	491	2.50
	0.0945	2.40MM	50	20	1000	750	-0.032	495	2.50
	0.0960	#41	50	20	1000	725	-0.032	503	2.50
	0.0965	2.45MM	50	20	1000	725	-0.032	505	2.50
	0.0980	#40	50	20	1000	725	-0.033	513	2.50
	0.0984	2.50MM	50	20	1000	725	-0.033	515	2.50
	0.0995	#39	50	20	1000	725	-0.033	521	2.50
	0.1004	2.55MM	50	20	1000	700	-0.033	526	2.50
	0.1015	#38	50	20	1000	700	-0.034	531	2.50
	0.1024	2.60MM	50	20	1000	700	-0.034	536	2.50
	0.1040	#37	50	20	1000	700	-0.034	545	2.49
	0.1043	2.65MM	50	20	1000	700	-0.034	546	2.49
	0.1063	2.70MM	50	20	1000	675	-0.035	557	2.49
	0.1065	#36	50	20	1000	675	-0.035	558	2.49
	0.1083	2.75MM	50	20	1000	675	-0.035	567	2.48
	0.1094	7/64	50	20	1000	675	-0.036	573	2.48
	0.1100	#35	50	20	1000	675	-0.036	576	2.48
	0.1102	2.80MM	50	20	1000	675	-0.036	577	2.48
	0.1110	#34	50	20	1000	675	-0.036	581	2.48
	0.1122	2.85MM	49	20	1000	650	-0.036	587	2.47
	0.1130	#33	49	20	1000	650	-0.036	592	2.47
	0.1142	2.90MM	49	20	1000	650	-0.037	598	2.47
	0.1160	#32	49	20	1000	650	-0.037	607	2.46
	0.1161	2.95MM	49	20	1000	650	-0.037	608	2.46
	0.1181	3.00MM	49	20	1000	625	-0.038	618	2.46
	0.1200	#31	49	20	1000	625	-0.038	628	2.45
0.1201	3.05MM	49	20	1000	625	-0.038	629	2.45	
0.1220	3.10MM	49	20	1000	600	-0.038	639	2.45	
0.1240	3.15MM	49	20	1000	600	-0.039	649	2.43	
0.1250	1/8	49	20	1000	600	-0.039	654	2.43	
WTCB	0.1260	3.20MM	48	20	1000	600	-0.018	660	2.42
	0.1280	3.25MM	48	20	1000	600	-0.018	670	2.40
	0.1285	#30	48	20	1000	575	-0.018	673	2.40



Flex 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	48	20	1000	575	-0.019	680	2.39
	0.1319	3.35MM	47	20	1000	575	-0.019	691	2.37
	0.1339	3.40MM	47	20	1000	575	-0.019	701	2.35
	0.1358	3.45MM	47	20	1000	550	-0.019	711	2.34
	0.1360	#29	47	20	1000	550	-0.019	712	2.34
	0.1378	3.50MM	46	20	1000	550	-0.019	722	2.32
	0.1398	3.55MM	46	20	1000	550	-0.019	732	2.31
	0.1405	#28	46	20	1000	550	-0.019	736	2.30
	0.1406	9/64	46	20	1000	550	-0.019	736	2.30
	0.1417	3.60MM	46	20	1000	525	-0.019	742	2.29
	0.1437	3.65MM	46	20	1000	525	-0.019	752	2.28
	0.1440	#27	45	20	1000	525	-0.019	754	2.27
	0.1457	3.70MM	45	20	1000	525	-0.020	763	2.26
	0.1470	#26	45	20	1000	500	-0.020	770	2.25
	0.1476	3.75MM	45	20	1000	500	-0.020	773	2.24
	0.1495	#25	44	20	1000	500	-0.020	783	2.22
	0.1496	3.80MM	44	20	1000	500	-0.020	783	2.22
	0.1516	3.85MM	44	20	1000	500	-0.020	794	2.20
	0.1520	#24	44	20	1000	500	-0.020	796	2.19
	0.1535	3.90MM	43	20	1000	500	-0.020	804	2.17
	0.1540	#23	43	20	1000	500	-0.020	806	2.17
	0.1555	3.95MM	43	20	1000	475	-0.020	814	2.15
	0.1562	5/32	43	20	1000	475	-0.020	818	2.14
	0.1570	#22	43	20	1000	475	-0.020	822	2.13
	0.1575	4.00MM	43	20	1000	475	-0.020	825	2.13
	0.1590	#21	42	20	1000	475	-0.020	833	2.11
	0.1594	4.05MM	42	20	1000	475	-0.020	835	2.11
	0.1610	#20	42	20	1000	475	-0.021	843	2.09
	0.1614	4.10MM	42	20	1000	475	-0.021	845	2.08
	0.1634	4.15MM	41	20	1000	450	-0.021	856	2.06
	0.1654	4.20MM	41	20	1000	450	-0.021	866	2.04
	0.1660	#19	41	20	1000	450	-0.021	869	2.03
0.1673	4.25MM	40	20	1000	450	-0.021	876	2.01	
0.1693	4.30MM	40	20	1000	450	-0.021	886	1.99	
0.1695	#18	40	20	1000	425	-0.021	887	1.99	



Flex 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	39	20	1000	425	-0.021	897	1.97
	0.1719	11/64	39	20	1000	425	-0.021	900	1.96
	0.1730	#17	39	20	1000	425	-0.021	906	1.95
	0.1732	4.40MM	39	20	1000	425	-0.021	907	1.94
	0.1752	4.45MM	38	20	1000	425	-0.022	917	1.92
	0.1770	#16	38	20	1000	400	-0.022	927	1.90
	0.1772	4.50MM	38	20	1000	400	-0.022	928	1.90
	0.1791	4.55MM	38	20	1000	400	-0.022	938	1.88
	0.1800	#15	37	20	1000	400	-0.022	942	1.86
	0.1811	4.60MM	37	20	1000	400	-0.022	948	1.85
	0.1820	#14	37	20	1000	400	-0.022	953	1.84
	0.1831	4.65MM	37	20	1000	400	-0.022	959	1.83
	0.1850	4.70MM	36	20	1000	400	-0.022	969	1.80
	0.1870	4.75MM	36	20	1000	375	-0.022	979	1.78
	0.1875	3/16	36	20	1000	375	-0.022	982	1.78
	0.1890	#12 - 4.80MM	35	20	1000	375	-0.022	990	1.76
	0.1909	4.85MM	35	20	1000	375	-0.023	1000	1.73
	0.1910	#11	35	20	1000	375	-0.023	1000	1.73
	0.1929	4.90MM	34	20	1000	375	-0.023	1010	1.71
	0.1935	#10	34	20	1000	375	-0.023	1013	1.70
	0.1949	4.95MM	34	20	1000	350	-0.023	1020	1.69
	0.1960	#9	33	20	1000	350	-0.023	1026	1.67
	0.1969	5.00MM	33	20	1000	350	-0.023	1031	1.66
	0.1988	5.05MM	33	20	1000	350	-0.023	1041	1.64
	0.1990	#8	33	20	1000	350	-0.023	1042	1.64
	0.2008	5.10MM	32	20	1000	350	-0.023	1051	1.62
	0.2010	#7	32	20	1000	350	-0.023	1052	1.61
	0.2028	5.15MM	32	20	1000	325	-0.023	1062	1.59
	0.2031	13/64	32	20	1000	325	-0.023	1063	1.59
	0.2040	#6	32	20	1000	325	-0.023	1068	1.58
	0.2047	5.20MM	31	20	1000	325	-0.023	1072	1.57
	0.2055	#5	31	20	1000	325	-0.024	1076	1.56
0.2067	5.25MM	31	20	1000	325	-0.024	1082	1.55	
0.2087	5.30MM	30	20	1000	325	-0.024	1093	1.52	
0.2090	#4	30	20	1000	325	-0.024	1094	1.52	



Flex 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	275	-0.025	1155	1.37
	0.2210	#2	27	20	1000	275	-0.025	1157	1.37
	0.2224	5.65MM	27	20	1000	275	-0.025	1164	1.35
	0.2244	5.70MM	26	20	1000	275	-0.025	1175	1.32
	0.2264	5.75MM	26	20	1000	275	-0.025	1185	1.30
	0.2280	#1	26	20	1000	275	-0.025	1194	1.28
	0.2283	5.80MM	26	20	1000	275	-0.025	1195	1.28
	0.2303	5.85MM	25	20	1000	250	-0.025	1206	1.25
	0.2323	5.90MM	24	20	1000	250	-0.025	1216	1.22
	0.2340	#A	24	20	1000	250	-0.025	1225	1.20
	0.2343	5.95MM	24	20	1000	250	-0.025	1227	1.20
	0.2344	15/64	24	20	1000	250	-0.025	1227	1.20
	0.2362	6.00MM	24	20	1000	250	-0.026	1237	1.18
	0.2380	#B	23	20	1000	250	-0.026	1246	1.15
	0.2382	6.05MM	23	20	1000	250	-0.026	1247	1.15
	0.2402	6.10MM	22	20	1000	225	-0.026	1258	1.12
	0.2420	#C	22	20	1000	225	-0.026	1267	1.10
	0.2421	6.15MM	22	20	1000	225	-0.026	1268	1.10
	0.2441	6.20MM	21	20	1000	225	-0.026	1278	1.07
	0.2460	#D	21	20	1000	225	-0.026	1288	1.05
	0.2461	6.25MM	21	20	1000	225	-0.026	1289	1.05
0.2480	6.30MM	21	20	1000	225	-0.026	1299	1.03	
0.2500	1/4 - 6.35MM	20	20	1000	200	-0.026	1309	1.00	