



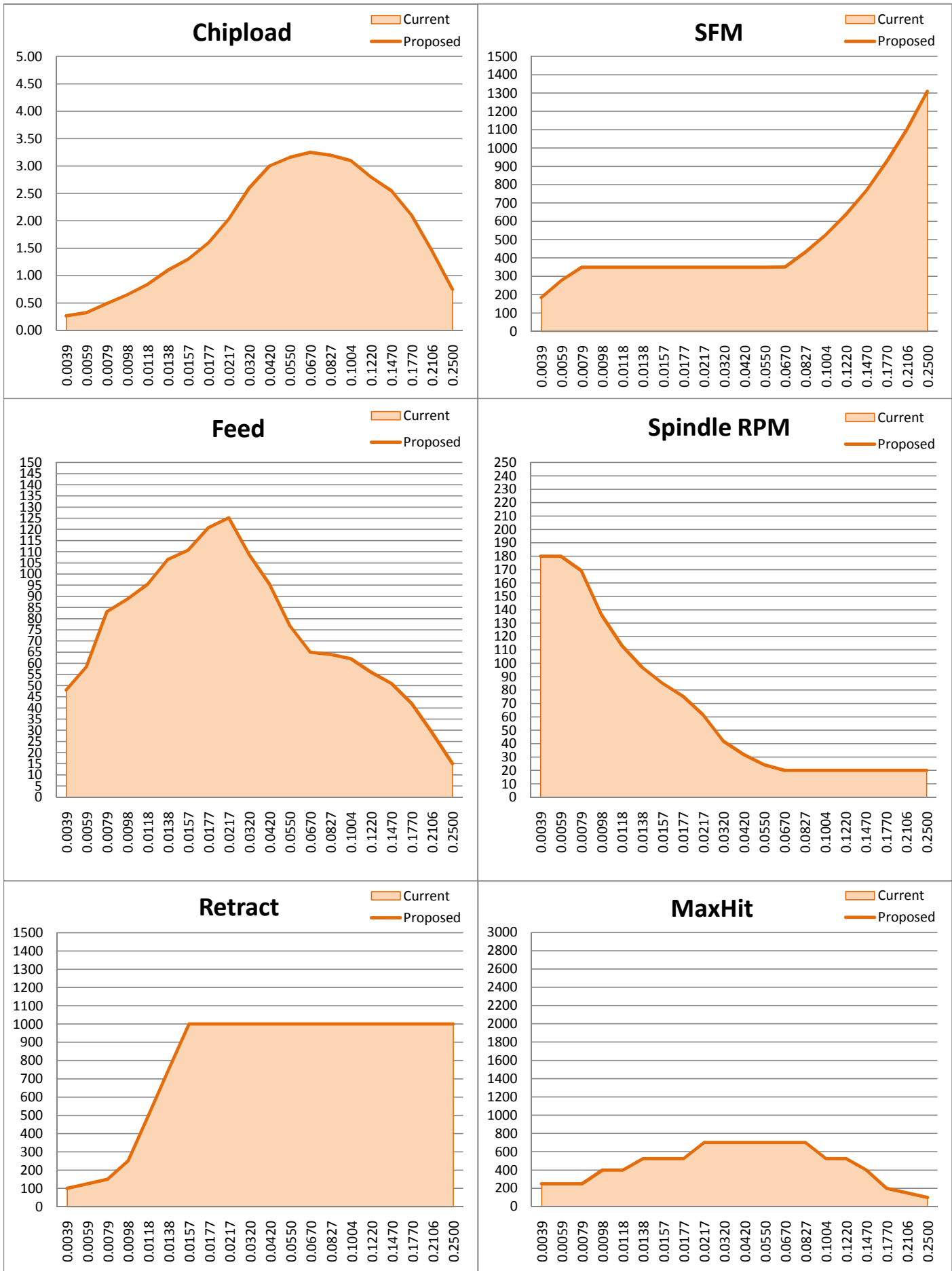
Application:	
Material Type:	Teflon
Drill Designs:	MDBT, UCMT/UCCP, WTCB

Process Parameters:	
Cutting Speed (SFM)	350
Maximum Chipload (0.001"/Revolution)	3.25
Maximum Hit Count	700
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	0.27		100	250
2	0.0059	#97 - 0.15MM	0.33		125	250
3	0.0079	#92 - 0.20MM	0.49		150	250
4	0.0098	0.25MM	0.65		250	400
5	0.0118	0.30MM	0.84		500	400
6	0.0138	0.35MM	1.10		750	525
7	0.0157	0.40MM	1.30		1000	525
8	0.0177	0.45MM	1.60		1000	525
9	0.0217	0.55MM	2.03		1000	700
10	0.0320	#67	2.60		1000	700
11	0.0420	#58	3.00		1000	700
12	0.0550	#54	3.16		1000	700
13	0.0670	#51	3.25		1000	700
14	0.0827	2.10MM	3.20		1000	700
15	0.1004	2.55MM	3.10		1000	525
16	0.1220	3.10MM	2.80		1000	525
17	0.1470	#26	2.55		1000	400
18	0.1770	#16	2.10		1000	200
19	0.2106	5.35MM	1.45		1000	150
20	0.2500	1/4 - 6.35MM	0.75		1000	100

Teflon

MDBT, UCMT/UCCP, WTCB





Teflon MDBT, UCMT/UCCP, 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	48	180	100	250	-0.011	184	0.27
	0.0051	0.13MM	54	180	115	250	-0.011	240	0.30
	0.0059	#97 - 0.15MM	59	180	125	250	-0.011	278	0.33
	0.0063	#96	64	177	130	250	-0.011	292	0.36
	0.0067	#95	69	175	135	250	-0.012	307	0.39
	0.0071	#94	73	173	140	250	-0.012	321	0.43
	0.0075	#93	78	171	145	250	-0.012	336	0.46
UCMT / UCCP	0.0079	#92 - 0.20MM	83	169	150	250	-0.012	350	0.49
	0.0083	#91	85	161	171	300	-0.012	350	0.53
	0.0087	#90	86	154	192	325	-0.012	350	0.56
	0.0091	#89	87	147	213	350	-0.012	350	0.59
	0.0095	#88	88	141	234	400	-0.012	350	0.63
	0.0098	0.25MM	89	136	250	400	-0.012	350	0.65
	0.0100	#87	89	134	275	400	-0.012	350	0.67
	0.0105	#86	91	127	338	400	-0.012	350	0.72
	0.0110	#85	93	122	400	400	-0.013	350	0.77
	0.0115	#84	95	116	463	400	-0.013	350	0.81
	0.0118	0.30MM	95	113	500	400	-0.013	350	0.84
	0.0120	#83	97	111	525	425	-0.013	350	0.87
	0.0125	#82	100	107	588	450	-0.013	350	0.93
	0.0130	#81	103	103	650	475	-0.013	350	1.00
	0.0135	#80	105	99	713	525	-0.013	350	1.06
	0.0138	0.35MM	107	97	750	525	-0.013	350	1.10
	0.0145	#79	108	92	842	525	-0.013	350	1.17
	0.0156	1/64	111	86	987	525	-0.014	350	1.29
	0.0157	0.40MM	111	85	1000	525	-0.014	350	1.30
	0.0160	#78	112	84	1000	525	-0.014	350	1.35
	0.0177	0.45MM	121	76	1000	525	-0.014	350	1.60
	0.0180	#77	121	74	1000	550	-0.014	350	1.63
	0.0197	0.50MM	123	68	1000	625	-0.015	350	1.82
0.0200	#76	124	67	1000	650	-0.015	350	1.85	
MDBT	0.0210	#75	125	64	1000	675	-0.015	350	1.96
	0.0217	0.55MM	125	62	1000	700	-0.015	350	2.03
	0.0225	#74	123	59	1000	700	-0.015	350	2.08
	0.0236	0.60MM	121	57	1000	700	-0.016	350	2.14



Teflon MDBT, UCMT/UCCP, WTCB

Series	Diameter (in.)		Feed (IPM)	Speed (K-RPM)	Retract (IPM)	MaxHit	Z-offset (in.)	SFM	Chipload (0.001"/Rev.)
MDBT	0.0240	#73	120	56	1000	700	-0.016	350	2.16
	0.0250	#72	118	53	1000	700	-0.016	350	2.21
	0.0256	0.65MM	117	52	1000	700	-0.016	350	2.25
	0.0260	#71	117	51	1000	700	-0.016	350	2.27
	0.0276	0.70MM	114	48	1000	700	-0.016	350	2.36
	0.0280	#70	114	48	1000	700	-0.017	350	2.38
	0.0292	#69	112	46	1000	700	-0.017	350	2.45
	0.0295	0.75MM	112	45	1000	700	-0.017	350	2.46
	0.0310	#68	110	43	1000	700	-0.017	350	2.54
	0.0312	1/32	110	43	1000	700	-0.017	350	2.56
	0.0315	0.80MM	109	42	1000	700	-0.017	350	2.57
	0.0320	#67	109	42	1000	700	-0.017	350	2.60
	0.0330	#66	107	41	1000	700	-0.018	350	2.64
	0.0335	0.85MM	106	40	1000	700	-0.018	350	2.66
	0.0350	#65	104	38	1000	700	-0.018	350	2.72
	0.0354	0.90MM	103	38	1000	700	-0.018	350	2.74
	0.0360	#64	102	37	1000	700	-0.018	350	2.76
	0.0370	#63	101	36	1000	700	-0.019	350	2.80
	0.0374	0.95MM	101	36	1000	700	-0.019	350	2.82
	0.0380	#62	100	35	1000	700	-0.019	350	2.84
	0.0390	#61	99	34	1000	700	-0.019	350	2.88
	0.0394	1.00MM	98	34	1000	700	-0.019	350	2.90
	0.0400	#60	98	33	1000	700	-0.019	350	2.92
	0.0410	#59	97	33	1000	700	-0.020	350	2.96
	0.0413	1.05MM	96	32	1000	700	-0.020	350	2.97
	0.0420	#58	95	32	1000	700	-0.020	350	3.00
	0.0430	#57	94	31	1000	700	-0.020	350	3.01
	0.0433	1.10MM	93	31	1000	700	-0.020	350	3.02
	0.0441	1.12MM	92	30	1000	700	-0.020	350	3.03
	0.0453	1.15MM	90	30	1000	700	-0.021	350	3.04
	0.0465	#56	88	29	1000	700	-0.021	350	3.06
	0.0469	3/64	87	29	1000	700	-0.021	350	3.06
0.0472	1.20MM	87	28	1000	700	-0.021	350	3.06	
0.0492	1.25MM	84	27	1000	700	-0.021	350	3.09	
0.0512	1.30MM	81	26	1000	700	-0.022	350	3.11	



Teflon MDBT, UCMT/UCCP, WTCB

Series	Diameter (in.)		Feed (IPM)	Speed (K-RPM)	Retract (IPM)	MaxHit	Z-offset (in.)	SFM	Chipload (0.001"/Rev.)
MDBT	0.0520	#55	80	26	1000	700	-0.022	350	3.12
	0.0531	1.35MM	79	25	1000	700	-0.022	350	3.14
	0.0550	#54	77	24	1000	700	-0.023	350	3.16
	0.0551	1.40MM	77	24	1000	700	-0.023	350	3.16
	0.0571	1.45MM	74	23	1000	700	-0.023	350	3.18
	0.0591	1.50MM	72	23	1000	700	-0.024	350	3.19
	0.0595	#53	72	22	1000	700	-0.024	350	3.19
	0.0610	1.55MM	70	22	1000	700	-0.024	350	3.21
	0.0625	1/16	69	21	1000	700	-0.025	351	3.22
	0.0630	1.60MM	68	21	1000	700	-0.025	351	3.22
	0.0635	#52	68	21	1000	700	-0.025	351	3.22
	0.0650	1.65MM	67	21	1000	700	-0.025	351	3.24
	0.0669	1.70MM	65	20	1000	700	-0.026	351	3.25
	0.0670	#51	65	20	1000	700	-0.026	351	3.25
	0.0689	1.75MM	65	20	1000	700	-0.026	361	3.24
	0.0700	#50	65	20	1000	700	-0.026	367	3.24
	0.0709	1.80MM	65	20	1000	700	-0.027	371	3.24
	0.0728	1.85MM	65	20	1000	700	-0.027	381	3.23
	0.0730	#49	65	20	1000	700	-0.027	382	3.23
	0.0748	1.90MM	65	20	1000	700	-0.027	392	3.23
	0.0760	#48	64	20	1000	700	-0.028	398	3.22
	0.0768	1.95MM	64	20	1000	700	-0.028	402	3.22
	0.0781	5/64	64	20	1000	700	-0.028	409	3.21
	0.0785	#47	64	20	1000	700	-0.028	411	3.21
	0.0787	2.00MM	64	20	1000	700	-0.028	412	3.21
	0.0807	2.05MM	64	20	1000	700	-0.029	423	3.21
	0.0810	#46	64	20	1000	700	-0.029	424	3.21
	0.0820	#45	64	20	1000	700	-0.029	429	3.20
	0.0827	2.10MM	64	20	1000	700	-0.029	433	3.20
	0.0846	2.15MM	64	20	1000	700	-0.030	443	3.19
	0.0860	#44	64	20	1000	675	-0.030	450	3.18
	0.0866	2.20MM	64	20	1000	675	-0.030	453	3.18
	0.0886	2.25MM	63	20	1000	650	-0.031	464	3.17
0.0890	#43	63	20	1000	650	-0.031	466	3.16	
0.0906	2.30MM	63	20	1000	625	-0.031	474	3.16	



Teflon MDBT, UCMT/UCCP, 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	63	20	1000	625	-0.032	484	3.14
	0.0935	#42	63	20	1000	600	-0.032	490	3.14
	0.0938	3/32	63	20	1000	600	-0.032	491	3.14
	0.0945	2.40MM	63	20	1000	600	-0.032	495	3.13
	0.0960	#41	62	20	1000	575	-0.032	503	3.12
	0.0965	2.45MM	62	20	1000	575	-0.032	505	3.12
	0.0980	#40	62	20	1000	550	-0.033	513	3.11
	0.0984	2.50MM	62	20	1000	550	-0.033	515	3.11
	0.0995	#39	62	20	1000	550	-0.033	521	3.11
	0.1004	2.55MM	62	20	1000	525	-0.033	526	3.10
	0.1015	#38	62	20	1000	525	-0.034	531	3.08
	0.1024	2.60MM	61	20	1000	525	-0.034	536	3.07
	0.1040	#37	61	20	1000	525	-0.034	545	3.05
	0.1043	2.65MM	61	20	1000	525	-0.034	546	3.05
	0.1063	2.70MM	60	20	1000	525	-0.035	557	3.02
	0.1065	#36	60	20	1000	525	-0.035	558	3.02
	0.1083	2.75MM	60	20	1000	525	-0.035	567	2.99
	0.1094	7/64	60	20	1000	525	-0.036	573	2.98
	0.1100	#35	59	20	1000	525	-0.036	576	2.97
	0.1102	2.80MM	59	20	1000	525	-0.036	577	2.96
	0.1110	#34	59	20	1000	525	-0.036	581	2.95
	0.1122	2.85MM	59	20	1000	525	-0.036	587	2.94
	0.1130	#33	59	20	1000	525	-0.036	592	2.93
	0.1142	2.90MM	58	20	1000	525	-0.037	598	2.91
	0.1160	#32	58	20	1000	525	-0.037	607	2.88
	0.1161	2.95MM	58	20	1000	525	-0.037	608	2.88
	0.1181	3.00MM	57	20	1000	525	-0.038	618	2.85
	0.1200	#31	57	20	1000	525	-0.038	628	2.83
0.1201	3.05MM	57	20	1000	525	-0.038	629	2.83	
0.1220	3.10MM	56	20	1000	525	-0.038	639	2.80	
0.1240	3.15MM	56	20	1000	525	-0.039	649	2.78	
0.1250	1/8	55	20	1000	525	-0.039	654	2.77	
WTCB	0.1260	3.20MM	55	20	1000	525	-0.018	660	2.76
	0.1280	3.25MM	55	20	1000	500	-0.018	670	2.74
	0.1285	#30	55	20	1000	500	-0.018	673	2.74



Teflon MDBT, UCMT/UCCP, 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	500	-0.019	680	2.72
	0.1319	3.35MM	54	20	1000	500	-0.019	691	2.70
	0.1339	3.40MM	54	20	1000	475	-0.019	701	2.68
	0.1358	3.45MM	53	20	1000	475	-0.019	711	2.66
	0.1360	#29	53	20	1000	475	-0.019	712	2.66
	0.1378	3.50MM	53	20	1000	450	-0.019	722	2.64
	0.1398	3.55MM	52	20	1000	450	-0.019	732	2.62
	0.1405	#28	52	20	1000	450	-0.019	736	2.62
	0.1406	9/64	52	20	1000	450	-0.019	736	2.61
	0.1417	3.60MM	52	20	1000	450	-0.019	742	2.60
	0.1437	3.65MM	52	20	1000	425	-0.019	752	2.58
	0.1440	#27	52	20	1000	425	-0.019	754	2.58
	0.1457	3.70MM	51	20	1000	425	-0.020	763	2.56
	0.1470	#26	51	20	1000	400	-0.020	770	2.55
	0.1476	3.75MM	51	20	1000	400	-0.020	773	2.54
	0.1495	#25	50	20	1000	400	-0.020	783	2.51
	0.1496	3.80MM	50	20	1000	400	-0.020	783	2.51
	0.1516	3.85MM	50	20	1000	375	-0.020	794	2.48
	0.1520	#24	50	20	1000	375	-0.020	796	2.48
	0.1535	3.90MM	49	20	1000	375	-0.020	804	2.45
	0.1540	#23	49	20	1000	375	-0.020	806	2.45
	0.1555	3.95MM	48	20	1000	350	-0.020	814	2.42
	0.1562	5/32	48	20	1000	350	-0.020	818	2.41
	0.1570	#22	48	20	1000	350	-0.020	822	2.40
	0.1575	4.00MM	48	20	1000	350	-0.020	825	2.39
	0.1590	#21	47	20	1000	325	-0.020	833	2.37
	0.1594	4.05MM	47	20	1000	325	-0.020	835	2.36
	0.1610	#20	47	20	1000	325	-0.021	843	2.34
	0.1614	4.10MM	47	20	1000	325	-0.021	845	2.33
	0.1634	4.15MM	46	20	1000	300	-0.021	856	2.30
	0.1654	4.20MM	45	20	1000	300	-0.021	866	2.27
	0.1660	#19	45	20	1000	275	-0.021	869	2.27
0.1673	4.25MM	45	20	1000	275	-0.021	876	2.25	
0.1693	4.30MM	44	20	1000	275	-0.021	886	2.22	
0.1695	#18	44	20	1000	250	-0.021	887	2.21	



Teflon MDBT, UCMT/UCCP, 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	44	20	1000	250	-0.021	897	2.19
	0.1719	11/64	44	20	1000	250	-0.021	900	2.18
	0.1730	#17	43	20	1000	250	-0.021	906	2.16
	0.1732	4.40MM	43	20	1000	250	-0.021	907	2.16
	0.1752	4.45MM	43	20	1000	225	-0.022	917	2.13
	0.1770	#16	42	20	1000	200	-0.022	927	2.10
	0.1772	4.50MM	42	20	1000	200	-0.022	928	2.10
	0.1791	4.55MM	41	20	1000	200	-0.022	938	2.06
	0.1800	#15	41	20	1000	200	-0.022	942	2.04
	0.1811	4.60MM	40	20	1000	200	-0.022	948	2.02
	0.1820	#14	40	20	1000	200	-0.022	953	2.00
	0.1831	4.65MM	40	20	1000	200	-0.022	959	1.98
	0.1850	4.70MM	39	20	1000	200	-0.022	969	1.95
	0.1870	4.75MM	38	20	1000	200	-0.022	979	1.91
	0.1875	3/16	38	20	1000	200	-0.022	982	1.90
	0.1890	#12 - 4.80MM	37	20	1000	200	-0.022	990	1.87
	0.1909	4.85MM	37	20	1000	200	-0.023	1000	1.83
	0.1910	#11	37	20	1000	200	-0.023	1000	1.83
	0.1929	4.90MM	36	20	1000	200	-0.023	1010	1.79
	0.1935	#10	36	20	1000	200	-0.023	1013	1.78
	0.1949	4.95MM	35	20	1000	175	-0.023	1020	1.75
	0.1960	#9	35	20	1000	175	-0.023	1026	1.73
	0.1969	5.00MM	34	20	1000	175	-0.023	1031	1.72
	0.1988	5.05MM	34	20	1000	175	-0.023	1041	1.68
	0.1990	#8	33	20	1000	175	-0.023	1042	1.67
	0.2008	5.10MM	33	20	1000	175	-0.023	1051	1.64
	0.2010	#7	33	20	1000	175	-0.023	1052	1.64
	0.2028	5.15MM	32	20	1000	175	-0.023	1062	1.60
	0.2031	13/64	32	20	1000	175	-0.023	1063	1.60
	0.2040	#6	32	20	1000	175	-0.023	1068	1.58
	0.2047	5.20MM	31	20	1000	175	-0.023	1072	1.56
	0.2055	#5	31	20	1000	175	-0.024	1076	1.55
0.2067	5.25MM	31	20	1000	175	-0.024	1082	1.53	
0.2087	5.30MM	30	20	1000	175	-0.024	1093	1.49	
0.2090	#4	30	20	1000	175	-0.024	1094	1.48	



Teflon MDBT, UCMT/UCCP, 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	29	20	1000	150	-0.024	1103	1.45
	0.2126	5.40MM	28	20	1000	150	-0.024	1113	1.41
	0.2130	#3	28	20	1000	150	-0.024	1115	1.41
	0.2146	5.45MM	28	20	1000	150	-0.024	1124	1.38
	0.2165	5.50MM	27	20	1000	150	-0.024	1134	1.35
	0.2185	5.55MM	26	20	1000	150	-0.024	1144	1.31
	0.2188	7/32	26	20	1000	150	-0.024	1146	1.30
	0.2205	5.60MM	25	20	1000	150	-0.025	1155	1.27
	0.2210	#2	25	20	1000	150	-0.025	1157	1.27
	0.2224	5.65MM	25	20	1000	150	-0.025	1164	1.24
	0.2244	5.70MM	24	20	1000	150	-0.025	1175	1.20
	0.2264	5.75MM	23	20	1000	150	-0.025	1185	1.17
	0.2280	#1	23	20	1000	150	-0.025	1194	1.14
	0.2283	5.80MM	23	20	1000	150	-0.025	1195	1.14
	0.2303	5.85MM	22	20	1000	125	-0.025	1206	1.10
	0.2323	5.90MM	21	20	1000	125	-0.025	1216	1.06
	0.2340	#A	21	20	1000	125	-0.025	1225	1.03
	0.2343	5.95MM	21	20	1000	125	-0.025	1227	1.03
	0.2344	15/64	21	20	1000	125	-0.025	1227	1.03
	0.2362	6.00MM	20	20	1000	125	-0.026	1237	1.00
	0.2380	#B	19	20	1000	125	-0.026	1246	0.96
	0.2382	6.05MM	19	20	1000	125	-0.026	1247	0.96
	0.2402	6.10MM	18	20	1000	125	-0.026	1258	0.92
	0.2420	#C	18	20	1000	125	-0.026	1267	0.89
	0.2421	6.15MM	18	20	1000	125	-0.026	1268	0.89
	0.2441	6.20MM	17	20	1000	125	-0.026	1278	0.85
	0.2460	#D	16	20	1000	125	-0.026	1288	0.82
	0.2461	6.25MM	16	20	1000	125	-0.026	1289	0.82
0.2480	6.30MM	16	20	1000	125	-0.026	1299	0.79	
0.2500	1/4 - 6.35MM	15	20	1000	100	-0.026	1309	0.75	