Recommended Cutting Data

- Feeds and Speed for starting point only. It is recommended to use these values as a starting point until optimal results are obtained.

YTDI Indexable Drills, Metric

Material Group / Condition	Drill Dia.	8~16mm		16~25mm		25~32mm		32~40mm		40~50mm	
		Speed (m/min)	Feed (mm/rev)	Speed (m/min)	Feed (mm/rev)	Speed (m/min)	Feed (mm/rev)	Speed (m/min)	Feed (mm/rev)	Speed (m/min)	Feed (mm/rev)
Grey cast iron	(FC)	50~70	0.20~0.30	50~70	0.25~0.45	50~80	0.35~0.55	60~90	0.34~0.58	80~100	0.38~0.60
Nodular cast iron	(FCD)	40~65	0.15~0.25	40~65	0.22~0.45	45~75	0.32~0.52	50~80	0.35~0.62	70~100	0.38~0.60
Carbon steel	(S45C)	55~70	0.15~0.30	55~70	0.16~0.40	60~85	0.20~0.40	70~90	0.22~0.48	75~95	0.25~0.54
Alloy steel	(SCM440)	50~75	0.15~0.30	50~75	0.15~0.40	55~80	0.18~0.40	60~90	0.25~0.47	65~95	0.27~0.52
Hardened steel	(SKD11)	40~50	0.10~0.20	40~50	0.12~0.28	40~50	0.16~0.35	40~60	0.20~0.38	40~60	0.22~0.42
Stainless steel	(SUS)	30~40	0.10~0.20	35~50	0.10~0.22	35~50	0.15~0.28	40~55	0.18~0.30	40~55	0.22~0.32
Aluminum 130HB	(AL)	80~100	0.20~0.30	80~100	0.25~0.40	90~110	0.30~0.45	90~110	0.30~0.45	90~120	0.30~0.50

- The data is recommended for 3xDia. and should be silghtly reduced for 5xD & 7xD drills.

YTDI Indexable Drills, Inches

Material Group / Condition	Drill Dia.	.3150~.6299		.6299~.9843		.9843~1.2598		1.2598~1.5748		1.5748~1.9685	
		Speed (SFM)	Feed (IPR)	Speed (SFM)	Feed (IPR)	Speed (SFM)	Feed (IPR)	Speed (SFM)	Feed (IPR)	Speed (SFM)	Feed (IPR)
Grey cast iron	(FC)	160~230	0.008~0.012	160~230	0.010~0.018	160~260	0.014~0.022	200~300	0.013~0.023	260~330	0.015~0.024
Nodular cast iron	(FCD)	130~210	0.006~0.010	130~210	0.009~0.018	150~240	0.013~0.021	160~260	0.014~0.025	230~330	0.015~0.024
Carbon steel	(S45C)	180~230	0.006~0.012	180~230	0.006~0.016	200~280	0.008~0.016	230~300	0.009~0.019	240~310	0.010~0.021
Alloy steel	(SCM440)	160~240	0.006~0.012	160~240	0.006~0.016	180~260	0.007~0.016	200~300	0.010~0.009	210~310	0.011~0.021
Hardened steel	(SKD11)	130~160	0.004~0.008	130~160	0.005~0.011	130~160	0.006~0.014	130~200	0.008~0.015	130~200	0.009~0.017
Stainless steel	(SUS)	100~130	0.004~0.008	110~160	0.004~0.009	110~160	0.006~0.011	130~160	0.007~0.012	130~180	0.009~0.013
Aluminum 130HB	(AL)	260~330	0.008~0.01	260~330	0.010~0.016	300~360	0.012~0.018	300~360	0.012~0.018	300~390	0.012~0.020

YTD Carbide Brazed Tipped Drills, Metric

Material Group / Condition	Drill Dia.	13.5~15.0mm		~20.0mm		~41.5mm	
		Speed (m/min)	Feed (mm/rev)	Speed (m/min)	Feed (mm/rev)	Speed (m/min)	Feed (mm/rev)
Grey cast iron	(FC)	50~80	0.20~0.35	50~80	0.20~0.40	50~80	0.25~0.50
Nodular cast iron	(FCD)	50~70	0.20~0.35	50~70	0.20~0.40	50~70	0.25~0.50
Carbon steel	(S45C)	40~65	0.15~0.30	40~65	0.20~0.40	40~65	0.20~0.45
Alloy steel	(SCM440)	40~60	0.10~0.25	40~60	0.15~0.35	40~60	0.20~0.40
Hardened steel	(SKD11)	30~40	0.10~0.25	30~40	0.15~0.30	30~40	0.20~0.35
Stainless steel	(SUS)	30~40	0.10~0.20	30~40	0.15~0.25	30~40	0.20~0.30

YSD, YSDF, YSDP, YCD Solid Carbide Drills

Material Group / Drill Dia.	3~5mm		5~8mm		8~10mm		10~12mm		12~14mm		14~20mm	
	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed	Speed	Feed
Grey cast iron (FC)	80~85	0.1~0.25	80~90	0.2~0.3	85~95	0.2~0.35	90~95	0.2~0.4	90~100	0.2~0.4	95~100	0.2~0.5
Nodular cast iron (FCD)	80~85	0.1~0.25	80~85	0.2~0.3	80~85	0.2~0.35	80~90	0.2~0.4	80~90	0.2~0.4	80~90	0.2~0.5
Carbon steel (S45C)	60~65	0.1~0.2	65~70	0.15~0.25	70~75	0.15~0.25	70~80	0.2~0.3	70~80	0.25~0.3	75~80	0.3~0.4
Alloy steel (SCM440)	50~55	0.1~0.25	55~60	0.15~0.25	60~65	0.15~0.3	60~70	0.2~0.35	65~70	0.25~0.35	65~70	0.3~0.45
Hardened steel (SKD11)	25~30	0.06~0.12	25~30	0.1~0.15	30~35	0.1~0.2	30~35	0.1~0.25	30~35	0.1~0.25	30~35	0.1~0.25
Stainless steel (SUS)	20~25	0.05~0.1	20~25	0.1~0.15	25~30	0.1~0.2	25~30	0.1~0.25	25~30	0.1~0.25	25~30	0.1~0.25

YSDC(D5), YSDCF(D5), YSDCP(D5) Solid Coolant Hole Drills

Materials		speed (V) (m/min)	Feed rate in dia.			
			3~8mm	8~12mm	12~16mm	16~20mm
Unalloyed steel	Carbon < 0.25%	80~100	0.1~0.2	0.15~0.25	0.2~0.4	0.25~0.5
	Carbon : 0.25~0.55%	80~100	0.1~0.2	0.15~0.25	0.2~0.4	0.25~0.5
	High Carbon & Carbon tool steel	80~100	0.1~0.2	0.15~0.25	0.2~0.4	0.25~0.5
Low alloyed steel	Non hardened HB 150~260	70~100	0.1~0.2	0.2~0.3	0.2~0.35	0.25~0.4
High alloyed steel	Annealed HSS HB 150~270	40~70	0.08~0.15	0.12~0.22	0.2~0.4	0.25~0.4
Stainless steel	Austenitic Ni>8%, C=18~25%	35~50	0.08~0.15	0.12~0.25	0.15~0.3	0.2~0.35
Malleable cast iron	Ferritic	80~100	0.15~0.3	0.25~0.35	0.3~0.4	0.3~0.45
	Pearlitic	70~90	0.1~0.25	0.2~0.4	0.25~0.4	0.25~0.5
Grey cast iron	Low tensile strength	80~100	0.1~0.25	0.25~0.35	0.3~0.45	0.35~0.55
	High tensile strength	70~90	0.1~0.22	0.2~0.33	0.3~0.4	0.35~0.5

Note

1. YES Carbide drill is not recommended to operate in low powered equipment.
2. Check spindle, machine and fixture rigidity before operation.
3. Make sure that coincide drill point with the center of material when lathe operation.
4. Feed enough cutting fluids.

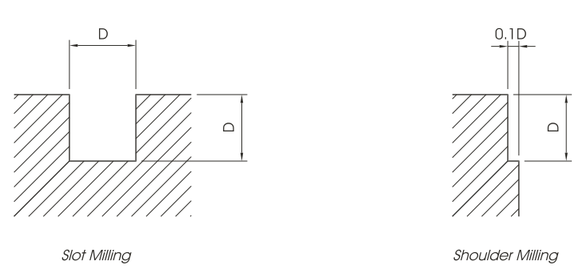
Recommended Cutting Data

YSET Carbide End Mills

Diameter / Material Condition		Carbon steel (S50C) (Speed = 40m/min)			Alloy steel (SCM, SKD, SUS) (Speed = 30m/min)		
		rpm	Feed(mm/min)		rpm	Feed(mm/min)	
(mm)	Flutes		Slot	Shoulder		Slot	Shoulder
2.0	2	5,600	80	200	4,800	60	150
2.5	2	4,500	80	200	3,800	60	150
3.0	2	3,700	80	200	3,200	60	150
4.0	2	2,800	80	200	2,400	60	150
5.0	2	2,200	80	200	1,900	60	150
	4		-	300		-	230
6.0	2	1,900	80	200	1,600	60	150
	4		-	300		-	230
7.0	2	1,600	80	200	1,400	60	150
8.0	2	1,400	80	200	1,200	60	150
	4		-	300		-	230
9.0	2	1,200	80	200	1,100	60	150
10.0	2	1,100	80	200	950	60	150
	4		-	300		-	230
11.0	2	1,000	80	200	870	60	150
12.0	2	930	80	200	800	60	150
	4		-	300		-	230
14.0	2	800	80	200	680	60	150
	4		-	300		-	230
15.0	2	750	80	200	640	60	150
	4		-	300		-	230
16.0	2	700	80	200	600	60	150
	4		-	300		-	230
18.0	2	620	80	200	530	60	150
	4		-	300		-	230
20.0	2	560	80	200	480	60	150
	4		-	300		-	230

YSET Carbide Roughing End Mills

Diameter / Material Condition	Carbon steel (S50C) (Speed = 40m/min)			Alloy steel (SCM, SKD, SUS) (Speed = 30m/min)		
	rpm	Feed(mm/min)		rpm	Feed(mm/min)	
		Slot	Shoulder		Slot	Shoulder
6	2100	120	300	1600	100	250
8	1600	120	300	1200	100	250
10	1300	120	300	950	100	250
12	1100	120	300	800	100	250
14	900	120	300	680	100	250
16	800	120	300	600	100	250
20	640	100	250	480	80	200
25	510	100	250	380	80	200



Slot Milling *Shoulder Milling*

YSET/HH Carbide High Helix End Mills

Diameter / Material Condition	HRC 55 v=25m/min		HRC 60 v=20m/min		HRC 65 v=15m/min		HRC 70 v=12m/min	
	rpm	Feed	rpm	Feed	rpm	Feed	rpm	Feed
6	1300	200	1100	160	800	120	640	100
8	1000	200	800	160	600	120	480	100
10	800	200	640	160	480	120	380	100
12	600	200	530	160	400	120	320	100
16	500	200	400	160	300	120	240	100
20	400	200	320	160	240	120	200	100
25	320	200	250	160	190	120	150	100
32	270	200	210	160	160	120	130	100