

DRILL SPEED

This GUIDE is given as a reference only, as you will see various materials and thickness combinations will drill differently. For safety and accuracy, material should be secured before drilling.

If the material to be drilled is to be completely penetrated it is recommended to back the material with a wood surface and slow the feed rate as the drill breaks through.

It is very important to note that if drill chatter occurs while drilling, the drill speed is too high and must be reduced.

Example: four sheets of 1/4" stacked together may react differently from one piece of 1" thick material.

DRILL SPEEDS GUIDE

Diameter	Speed - RPM
1/16"	3000 - 4000
1/8"	1500 - 4000
3/16"	1200 - 3000
1/4"	1200 - 2000
5/16"	1200 - 2000
3/8"	1200 - 1500
7/16"	1000 - 1500
1/2"	800 - 1000
3/4"	500 - 800
1"	200 - 500

FEED RATE of .015" - .020"
Per Revolution

Abbeon.com

Abbeon Cal, Inc.

123 Gray Avenue, Santa Barbara, CA 93101

Phone: 800 / 922-0977 Fax: 805 / 966-7659

e-mail: abbeoncal@abbeon.com web: www.abbeon.com

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