

ADR-DLC/ADRL-DLC

Work Materials	Aluminum		Aluminum		Copper Alloys	
	Casting		6061, 7075			
Drill Diameter (mm)	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR
Ø0.10~0.29	3,200~7,700	0.0004~0.0016	31,800~22,000	0.0004~0.002	22,300~11,000	0.00008~0.0016
Ø0.30~0.49	7,400~9,700	0.0016~0.0032	21,200~19,500	0.002~0.004	10,600~9,700	0.0016~0.0032
Ø0.50~1.00	9,500~19,100	0.0032~0.005	19,100	0.004~0.006	9,500~6,400	0.0032~0.005

Drill Diameter	Pecking Distance
Ø0.10~Ø0.49	10% of drill diameter
Ø0.50~Ø1.00	20% of drill diameter

Remarks:

- Runout (with drill in spindle) should be less than 0.003mm (0.00012").
- If your machine cannot meet the recommended rotation speed, please use the higher speed and adjust the feed rate appropriately.
- For drills under Ø0.5mm (0.0197"), set machine/spindle at the most stable speed rather than following the recommended conditions shown in table.