

## ASWR/ASWD

Work Materials	Aluminum Alloys		Resin	
	6061, 7075			
Drill Diameter (mm)	Speed RPM	Feed IPR	Speed RPM	Feed IPR
Ø0.10~0.29	20,000	0.00004~0.00012	17,000	0.00004~0.00012
Ø0.30~0.45	20,000	0.0002~0.0008	17,000	0.0002~0.0008
Ø0.50~0.75	17,000	0.0004~0.0012	14,500	0.0004~0.0012
Ø0.80~0.95	15,000	0.0008~0.0016	12,800	0.0008~0.0016
Ø1.00~1.40	12,000	0.0012~0.002	10,000	0.0012~0.002
Ø1.50~1.90	9,000	0.0012~0.002	7,700	0.0012~0.002
Ø2.00~2.90	6,500	0.0012~0.002	5,500	0.0012~0.002
Ø3.00	4,200	0.0012~0.002	3,500	0.002

Drill Diameter	Pecking Distance
Ø0.10~Ø0.49	10% of drill diameter
Ø0.50~Ø1.00	20% of drill diameter
Above Ø1.00	*25-50% of drill diameter

\*Start at 25% and increase if needed, to 50%

### Remarks:

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