


Structural Steel GEN3SYS® XT Pro | Metric (mm)

ISO	Material	Speed (M/min) - Mist Coolant		Feed Rate (mm/rev) by Diameter												
		Hardness (BHN)	 AM420 Speed	12 series 12.00 - 12.99	13 series 13.00 - 13.99	14 series 14.00 - 14.99	15 series 15.00 - 15.99	16 series 16.00 - 16.99	17 series 17.00 - 17.99	18 series 18.00 - 19.99	20 series 20.00 - 21.99	22 series 22.00 - 23.99	24 series 24.00 - 25.99	26 series 26.00 - 28.99	29 series 29.00 - 31.99	32 series 32.00 - 35.00
P	Structural Steel	100 - 150	107	0.20	0.22	0.25	0.25	0.30	0.30	0.36	0.38	0.41	0.43	0.46	0.48	0.48
	A36, A285, A516, A572, etc.	150 - 250	91	0.18	0.20	0.23	0.23	0.25	0.25	0.30	0.36	0.38	0.41	0.43	0.46	0.46
		250 - 350	79	0.15	0.17	0.20	0.20	0.23	0.23	0.28	0.30	0.33	0.36	0.38	0.41	0.41

Speed and Feed Multiplier

	Depth of Cut	
	<= 1.5xD	> 1.5xD
Speed	See above chart	0.75
Feed	See above chart	0.90

NOTE: The speeds and feeds listed above are based on a rigid setup using air mist through tool coolant. Speed may be increased up to 50% if using high pressure flood or through coolant.

NOTE: If drilling dry without coolant, speed must be reduced significantly based on setup, drill depth, and material hardness. Up to 50% speed and feed reduction may be necessary in these types of applications. Contact the Application Engineering department for assistance.

NOTE: If drilling material thickness of 0.500" (12.7mm) or less, a minimum of 10% reduction in feed is required to minimize material deflection.