

M:ATR: X

5566 Series - MATRX PD-1 Drills

5566 Series PD-1 Drill's three-flute design allows for ultimate material removal rates and burr teeth provide a clean shearing of fibers.

Flute Diameter	Carbon, Carbon Graphite, Unfilled Plastics		Composites		Fiber Reinforced Plastics		Green Ceramics, Green Carbide	
	Speed SFM	Feed IPR	Speed SFM	Feed IPR	Speed SFM	Feed IPR	Speed SFM	Feed IPR
1/8"	500-2400	.0015-.004	300-1400	.0008-.002	500-1600	.0008-.002	300-1200	.0008-.0025
3/16"	800-2400	.0025-.004	400-1400	.001-.0025	800-1600	.001-.0025	300-1200	.0015-.003
1/4"	800-2400	.003-.005	400-1400	.0015-.003	800-1600	.0015-.003	300-1200	.0025-.004
5/16"	800-2400	.004-.0055	400-1400	.003-.005	800-1600	.003-.005	300-1200	.003-.005
3/8"	800-2400	.0050-.008	400-1400	.004-.0065	800-1600	.004-.0065	300-1200	.005-.007
1/2"	800-2400	.006-.009	400-1400	.006-.009	800-1600	.0065-.012	300-1200	.0065-.008

The parameters listed for tool series that are stocked uncoated are based on running an uncoated tool.

If a coating is applied to the tools, the SFM can be increased by approximately 25%.

All speed and feed recommendations should be considered only as a starting point. Start with conservative speeds and feeds while analyzing the rigidity of the process. Then cautiously progress incrementally to achieve optimum performance.

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