



**Product Table:** High Performance Drills - Aluminum & Aluminum Alloys

**Characteristics:** 3x & 5x LOF

**Product Notes:**

Pecking cycles are recommended to avoid chip packing and tool breakage.

- For Non-Ferrous materials, the initial peck should be 3-5x Diameter with each subsequent peck at 2-3x Diameter.

With correct geometry, Drills under 5x LOF should not need a peck cycle.

Material Guide		SFM	Chip Load (IPR) by Drill Diameter											
			1/16	5/64	3/32	1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4
Wrought Aluminum Alloy	2014, 5062, 6061, 7050, 7075, 7475	350-1500	.003-.004	.003-.004	.004-.005	.005-.006	.005-.007	.006-.008	.008-.010	.009-.012	.010-.013	.011-.015	.014-.018	.016-.020
Cast Aluminum Alloy	319.0, 328.0, 355.0, 360.0, 380.0, 383.0, 390.0, 520.0, 535.0	300-875	.002-.003	.002-.003	.003-.004	.004-.005	.004-.006	.005-.007	.006-.008	.007-.010	.008-.011	.009-.013	.011-.015	.013-.017
Copper Alloy	Cu-ETP, CuBe2, CuZn30, CuZn36Pb3, CuZn10, CuSn5	300-520	.002-.003	.002-.003	.003-.004	.004-.005	.004-.006	.005-.007	.006-.008	.007-.010	.008-.011	.009-.013	.011-.015	.013-.017

**General Notes:**

All posted speed and feed parameters are suggested starting values that may be increased given optimal setup conditions.

If you require additional information, Valor Holemaking has a team of technical experts available to assist you through even the most challenging applications. Please contact us at **866-840-1505** or **Valortech@harveyperformance.com**.

WARNING: Cutting tools may shatter under improper use. Government regulations require use of safety glasses and other appropriate safety equipment in the vicinity of use.