



800-871-5022

More information can be found at www.HQ-Drill.com.

Machinability of Metals	
(Based on 100% machinability for AISI 1212 steel)	
Carbon Steels:	Percentage
1015	72%
1018	78%
1020	72%
1022	78%
1030	70%
1040	64%
1042	64%
1050	54%
1095	42%
1117	91%
1137	72%
1141	70%
1141 annealed	81%
1144	76%
1144 annealed	85%
1144 stressproof	83%
1212	100%
1213	136%
12L14	170%
1215	136%
Alloy Steels:	Percentage
2355 annealed	70%
4130 annealed	72%
4140 annealed	66%
4142 annealed	66%
41L42	77%
4150 annealed	60%
4340 annealed	57%
4620	66%
4820 annealed	49%
52100 annealed	40%
6150 annealed	60%
8620	66%
86L20	77%
9310 annealed	51%
Stainless Steels and Super Alloys:	Percentage
302 annealed	45%
303 annealed	78%
304 annealed	45%



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Stainless Steels and Super Alloys:	Percentage
316 annealed	45%
321 annealed	36%
347 annealed	36%
410 annealed	54%
416 annealed	110%
420 annealed	45%
430 annealed	54%
431 annealed	45%
440A	45%
15-5PH condition A	48%
17-4PH condition A	48%
A286 aged	33%
Hastelloy X	19%
Tool Steels:	Percentage
A-2	42%
A-6	33%
D-2	27%
D-3	27%
M-2	39%
O-1	42%
O-2	42%
Gray Caast Iron:	Percentage
ASTM class 20 annealed	73%
ASTM class 25	55%
ASTM class 30	48%
ASTM class 35	48%
ASTM class 40	48%
ASTM class 45	36%
ASTM class 50	36%
Nodular Iron:	Percentage
60-40- 18 annealed	61%
65-45- 12 annealed	61%
80-55-06	39%
Aluminum and Magnesium Alloys:	Percentage
aluminum, cold drawn	360%
aluminum, cast	450%
aluminum, die cast	76%
magnesium, cold drawn	480%
magnesium, cast	480%