



800-871-5022

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

### Suggested Drilling Feed Rates (inches per rev.)

MATERIAL	BRINELL HARDNESS	HOLE DIAMETER							
		1/16"	1/8	1/4	1/2	3/4	1	1 1/2	2
Aluminum	99-101	.001	.003	.007	.012	.016	.020	.025	.030
Aluminum Bronze	170-187	.001	.003	.004	.008	.010	.012	.015	.020
Bakelite	-	.002	.005	.006	.008	.010	.012	.015	.015
Brass	192-202	.001	.003	.004	.008	.012	.018	.020	.022
Bronze, Common	166-183	.001	.003	.004	.008	.012	.018	.020	.022
Bronze Phos.; 1/2 Hard	187-202	.001	.003	.004	.008	.010	.012	.015	.020
Bronze Phos.; Soft	149-163	.001	.003	.004	.008	.012	.018	.020	.022
Celluloid	-	.002	.004	.005	.006	.006	.008	.008	.010
Copper	80-85	.001	.003	.004	.008	.010	.012	.015	.020
Copper Mang.; 30% Mn	134	.001	.003	.005	.007	.009	.012	.014	.016
Duralumin	90-104	.001	.003	.005	.010	.015	.018	.020	.025
Iron, Cast; Med Soft	196	.001	.003	.005	.008	.010	.012	.014	.015
Iron, Cast; Hard	293-302	-	.001	.003	.005	.007	.009	.012	.012
Iron, Cast; Chilled	402	-	.001	.003	.005	.007	.009	.011	.011
Iron, Malleable	112-126	-	.002	.004	.007	.010	.012	.015	.018
Monel	149-170	-	.002	.003	.006	.008	.010	.012	.015
Nickel, Pure	187-202	-	.002	.003	.006	.008	.015	.018	.020
Nickel, Steel; 3 1/2%	196-241	-	.002	.003	.006	.008	.010	.012	.015
Rubber, Hard	-	.005	.010	.012	.015	.018	.020	.025	.030
Screw Stock, C.R.	170-196	.001	.003	.004	.007	.010	.012	.015	.018
Stl, Carbon	175-225	.001	.003	.004	.007	.010	.012	.015	.018
Stl, Drop Forged	170-196	.001	.002	.004	.007	.010	.012	.015	.018
Stl, Machinery	170-196	.001	.003	.005	.009	.012	.013	.018	.022
Stl, Magnet; Soft	241-302	-	.002	.003	.006	.008	.009	.010	.011
Stl, Magnet; Hard	321-512	-	.0005	.001	.002	.002	.003	.003	.004
Stl, Mang.; 7-13%	187-217	-	.0005	.001	.002	.002	.003	.003	.004
Stl, Mild; .20-.30C	170-202	.001	.003	.005	.010	.015	.018	.020	.025

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		1/16"	1/8	1/4	1/2	3/4	1	1 1/2	2
Stl, Molybdenum	196-235	-	.002	.004	.006	.010	.012	.015	.018
Stl, Spring	402	-	.002	.003	.005	.007	.009	.010	.010
Stl, Stainless	150-225	.001	.002	.004	.006	.008	.011	.013	.016
Stl, Stainless	460-520	-	.0005	.001	.002	.002	.003	.003	.004
Stl, .40-.50C	170-196	.001	.002	.004	.007	.010	.012	.015	.018
Stl, Struct; A-36	160	.001	.003	.005	.010	.015	.018	.020	.025
Stl, Tool; SAE, Forged	149	-	.002	.003	.006	.009	.011	.014	.016
Stl, Tool; SAE, Forged	402	-	.0005	.001	.002	.002	.003	.003	.004
Zinc, Alloy	112-126	.002	.003	.007	.012	.016	.018	.020	.025

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