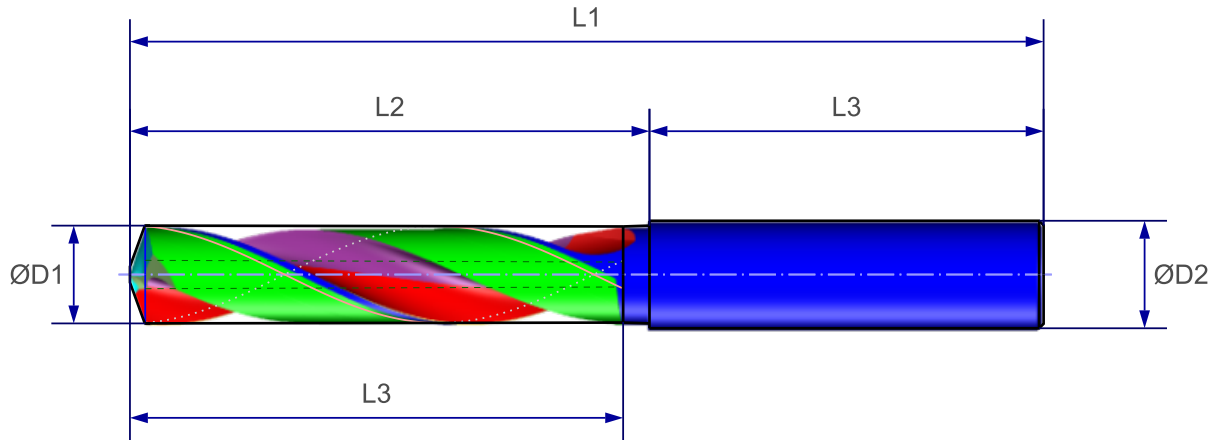
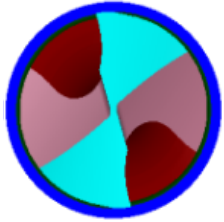
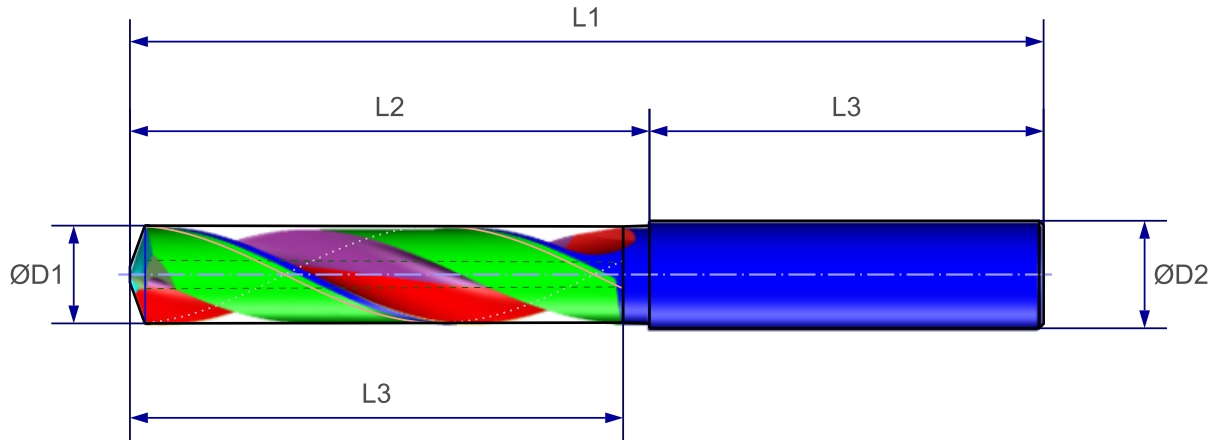
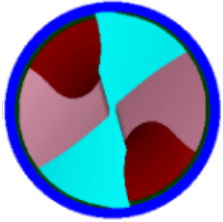


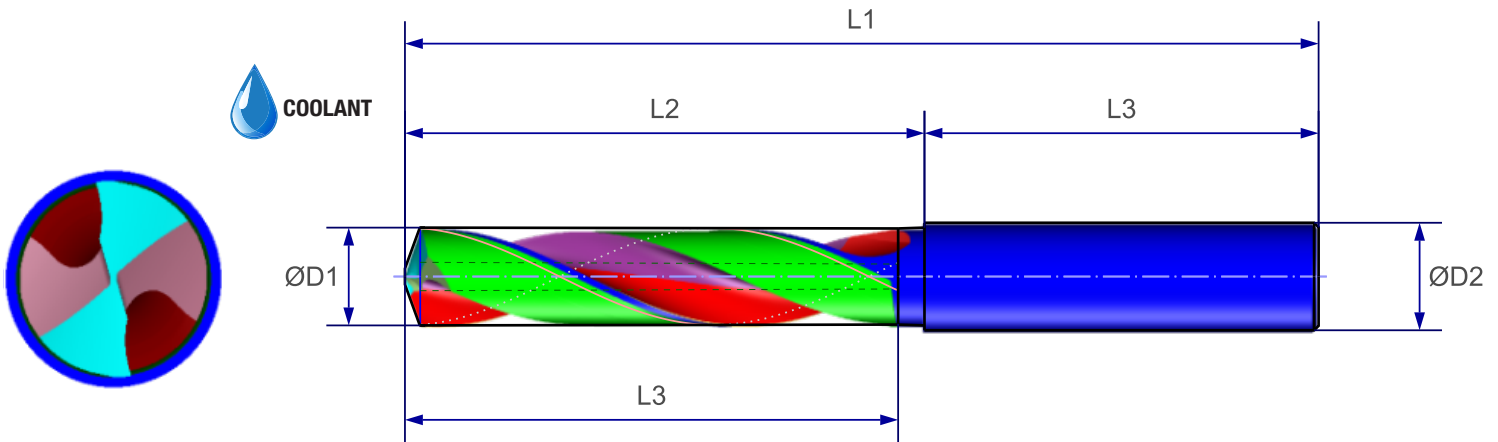
DESCRIPTION EXAMPLE... I=INCH, GP= General Pur- pose S=Solid 2=FLUTES 125=DIA, 3XD=FLUTE LENGTH	DRILL DIAM- ETER D1 inch m7	DRILLS FRACTION- AL & FOR THREADS	SHANK DI- AMETER D2 metric	OAL L1 inch	FLUTE LENGTH L2 inch	DRILLING DEPTH L3 inch	SHANK	
IGPS2-0892-3XD	0.089	4-40	6	2.441	0.787	0.653	1.417	
IGPS2-1096-3XD	0.110	6-32	6	2.441	0.787	0.623	1.417	
IGPS2-1250-3XD	.125	1/8	6	2.441	0.787	0.600	1.417	
IGPS2-1376-3XD	.138	8-32	6	2.441	0.787	0.581	1.417	
IGPS2-1406-3XD	.141	9/64	6	2.441	0.787	0.576	1.417	
IGPS2-1540-3XD	.154	10-24 UNC	6	2.598	0.945	0.714	1.417	
IGPS2-1562-3XD	.156	5/32	6	2.598	0.945	0.711	1.417	
IGPS2-1610-3XD	.161	10-32 UNF	6	2.598	0.945	0.704	1.417	
IGPS2-1690-3XD	.169	M5	6	2.598	0.945	0.692	1.417	
IGPS2-1719-3XD	.172	11/64	6	2.598	0.945	0.687	1.417	
IGPS2-1875-3XD	.188	3/16	6	2.598	1.102	0.821	1.417	



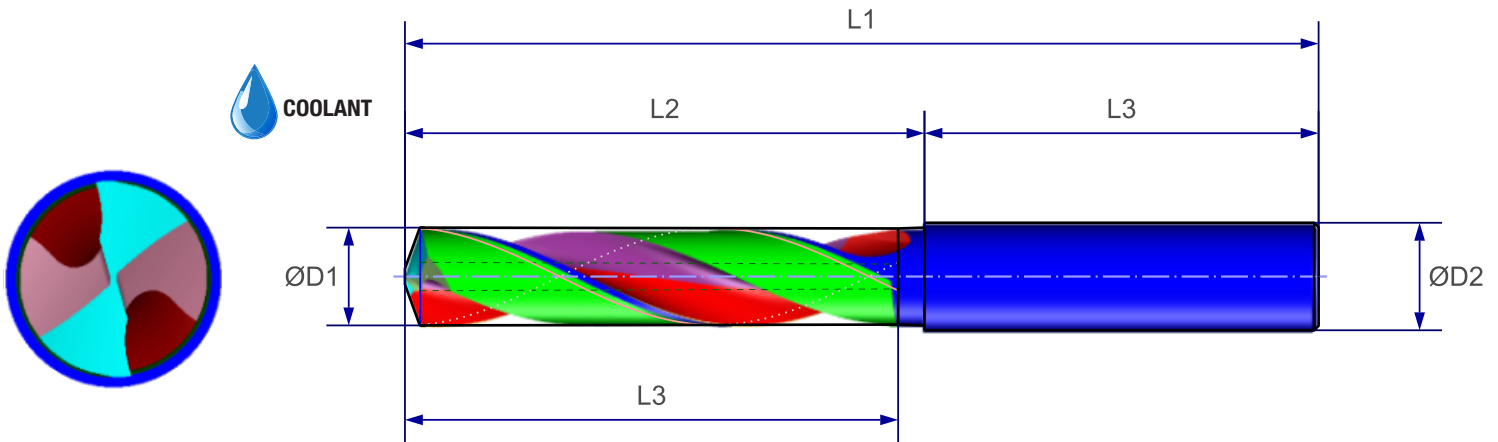
DESCRIPTION EXAMPLE... I=INCH, GP= General Pur- pose S=Solid 2=FLUTES 125=DIA, 3XD=FLUTE LENGTH	DRILL DIAM- ETER D1 inch m7	DRILLS FRACTION- AL & FOR THREADS	SHANK DI- AMETER D2 metric	OAL L1 inch	FLUTE LENGTH L2 inch	DRILLING DEPTH L3 inch	SHANK	
IGPS2-1890-3XD	.189	12-32 UNF	6	2.598	1.102	0.819	1.417	
IGPS2-2010-3XD	.201	M6	6	2.598	1.102	0.801	1.417	
IGPS2-2031-3XD	.203	13/64	6	2.598	1.102	0.797	1.417	
IGPS2-2045-3XD	.205	1/4-20	6	2.598	1.102	0.795	1.417	
IGPS2-2175-3XD	.218	1/4-28	6	2.598	1.102	0.776	1.417	
IGPS2-2188-3XD	.219	7/32	6	2.598	1.102	0.774	1.417	
IGPS2-2344-3XD	.234	15/64	6	2.598	1.102	0.750	1.417	
IGPS2-2500-3XD	.250	1/4	8	3.110	1.339	0.964	1.417	
IGPS2-2620-3XD	.262	5/16-18	8	3.110	1.339	0.946	1.417	
IGPS2-2746-3XD	.275	5/16-24	8	3.110	1.339	0.927	1.417	
IGPS2-2656-3XD	.266	17/64	8	3.110	1.339	0.941	1.417	



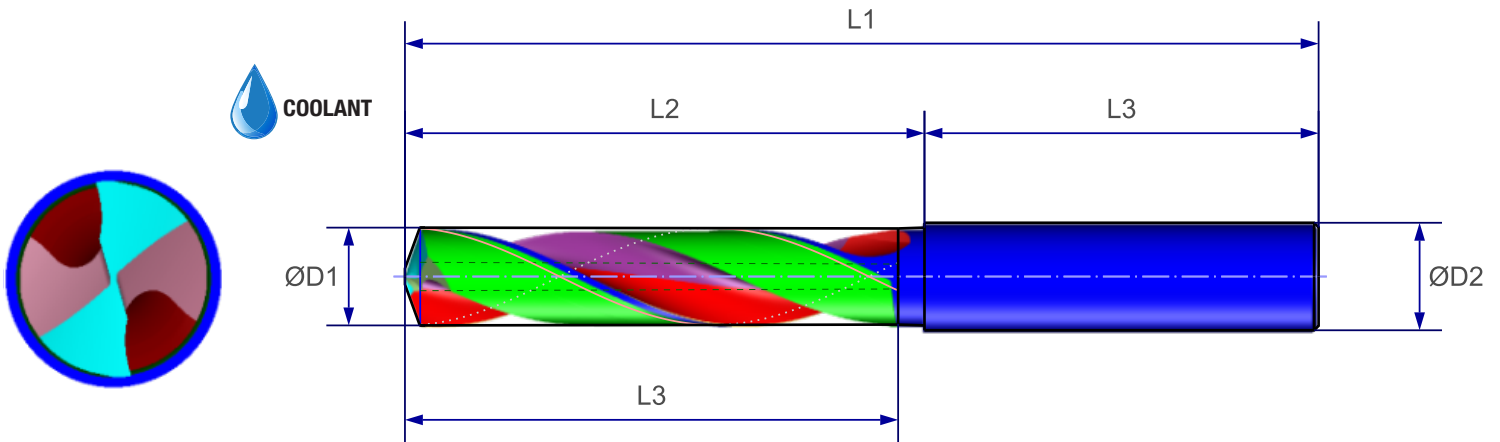
DESCRIPTION EXAMPLE... I=INCH, GP= General Pur- pose S=Solid 2=FLUTES 125=DIA, 3XD=FLUTE LENGTH	DRILL DIAM- ETER D1 inch m7	DRILLS FRACTION- AL & FOR THREADS	SHANK DI- AMETER D2 metric	OAL L1 inch	FLUTE LENGTH L2 inch	DRILLING DEPTH L3 inch	SHANK
IGPS2-2800-3XD	.280	MF8x1	8	3.110	1.614	1.194	1.417
IGPS2-2813-3XD	.281	9/32	8	3.110	1.614	1.192	1.417
IGPS2-2968-3XD	.297	19/64	8	3.110	1.614	1.169	1.417
IGPS2-3125-3XD	.313	5/16	8	3.110	1.614	1.145	1.417
IGPS2-3180-3XD	.318	3/8-16	10	3.504	1.850	1.373	1.575
IGPS2-3281-3XD	.328	21/64	10	3.504	1.850	1.358	1.575
IGPS2-3370-3XD	.337	3/8-24	10	3.504	1.850	1.345	1.575
IGPS2-3438-3XD	.344	11/32	10	3.504	1.850	1.334	1.575



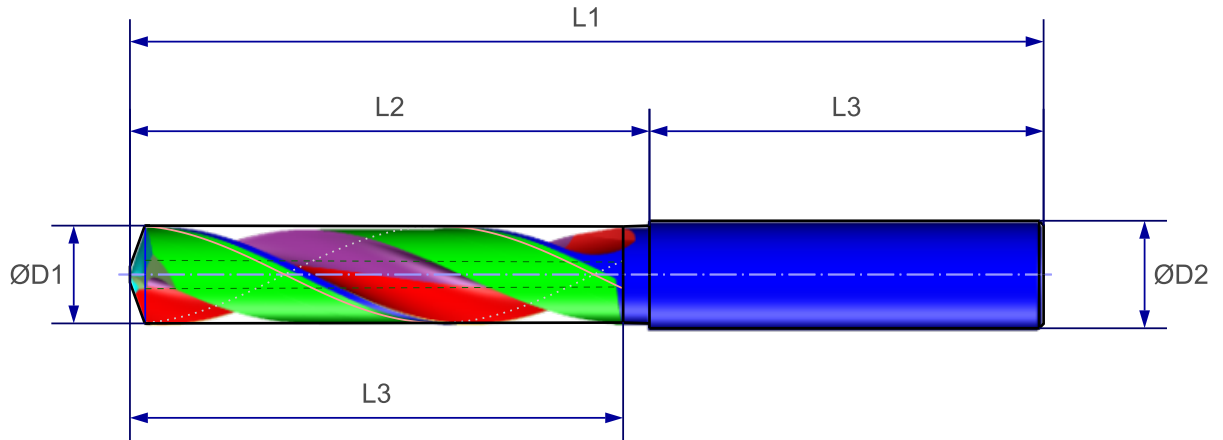
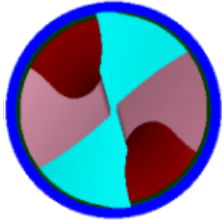
DESCRIPTION EXAMPLE... I=INCH, GP= General Purpose C=COOLANT 2=FLUTES 125=DIA, 3XD=FLUTE LENGTH	DRILL DIAM- ETER D1 inch m7	DRILLS FRACTION- AL & FOR THREADS	SHANK DI- AMETER D2 metric	OAL L1 inch	FLUTE LENGTH L2 inch	DRILLING DEPTH L3 inch	SHANK	
IGPC2- 1250-3XD	.125	1/8	6	2.441	0.787	0.600	1.417	
IGPC2- 1376-3XD	.138	8-32	6	2.441	0.787	0.581	1.417	
IGPC2- 1406-3XD	.141	9/64	6	2.441	0.787	0.576	1.417	
IGPC2- 1540-3XD	.154	10-24 UNC	6	2.598	0.945	0.714	1.417	
IGPC2- 1562-3XD	.156	5/32	6	2.598	0.945	0.711	1.417	
IGPC2- 1610-3XD	.161	10-32 UNF	6	2.598	0.945	0.704	1.417	
IGPC2- 1690-3XD	.169	M5	6	2.598	0.945	0.692	1.417	
IGPC2- 1719-3XD	.172	11/64	6	2.598	0.945	0.687	1.417	
IGPC2- 1875-3XD	.188	3/16	6	2.598	1.102	0.821	1.417	
IGPC2- 1890-3XD	.189	12-32 UNF	6	2.598	1.102	0.819	1.417	
IGPC2- 2010-3XD	.201	M6	6	2.598	1.102	0.801	1.417	



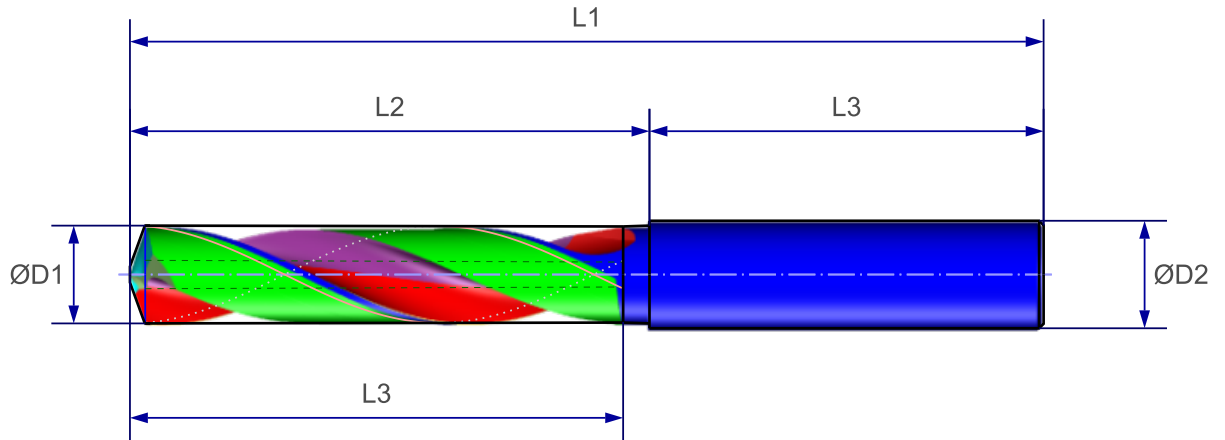
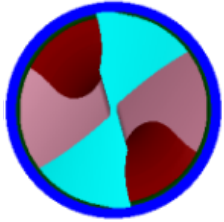
DESCRIPTION EXAMPLE... I=INCH, GP= General Purpose C=COOLANT 2=FLUTES 125=DIA, 3XD=FLUTE LENGTH	DRILL DIAM- ETER D1 inch m7	DRILLS FRACTION- AL & FOR THREADS	SHANK DI- AMETER D2 metric	OAL L1 inch	FLUTE LENGTH L2 inch	DRILLING DEPTH L3 inch	SHANK	
IGPC2-2031-3XD	.203	13/64	6	2.598	1.102	0.797	1.417	
IGPC2-2045-3XD	.205	1/4-20	6	2.598	1.102	0.795	1.417	
IGPC2-2175-3XD	.218	1/4-28	6	2.598	1.102	0.776	1.417	
IGPC2-2188-3XD	.219	7/32	6	2.598	1.102	0.774	1.417	
IGPC2-2344-3XD	.234	15/64	6	2.598	1.102	0.750	1.417	
IGPC2-2500-3XD	.250	1/4	8	3.110	1.339	0.964	1.417	
IGPC2-2620-3XD	.262	5/16-18	8	3.110	1.339	0.946	1.417	
IGPC2-2746-3XD	.275	5/16-24	8	3.110	1.339	0.927	1.417	
IGPC2-2656-3XD	.266	17/64	8	3.110	1.339	0.941	1.417	
IGPC2-2800-3XD	.280	MF8x1	8	3.110	1.614	1.194	1.417	
IGPC2-2813-3XD	.281	9/32	8	3.110	1.614	1.192	1.417	



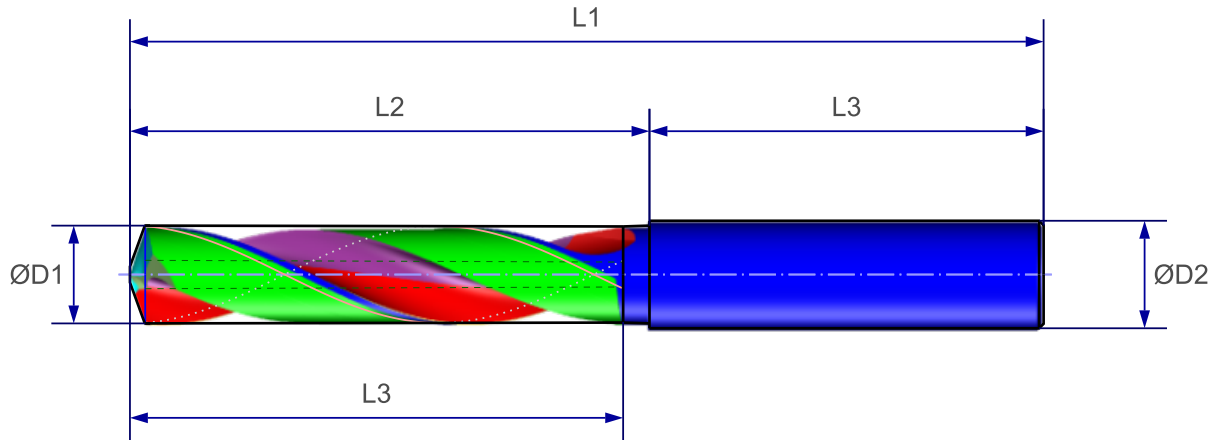
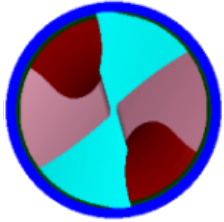
DESCRIPTION EXAMPLE... I=INCH, GP= General Purpose C=COOLANT 2=FLUTES 125=DIA, 3XD=FLUTE LENGTH	DRILL DIAM- ETER D1 inch m7	DRILLS FRACTION- AL & FOR THREADS	SHANK DI- AMETER D2 metric	OAL L1 inch	FLUTE LENGTH L2 inch	DRILLING DEPTH L3 inch	SHANK	
IGPC2- 2969-3XD	.297	19/64	8	3.110	1.614	1.169	1.417	
IGPC2- 3125-3XD	.313	5/16	8	3.110	1.614	1.145	1.417	
IGPC2- 3180-3XD	.318	3/8-16	10	3.504	1.850	1.373	1.575	



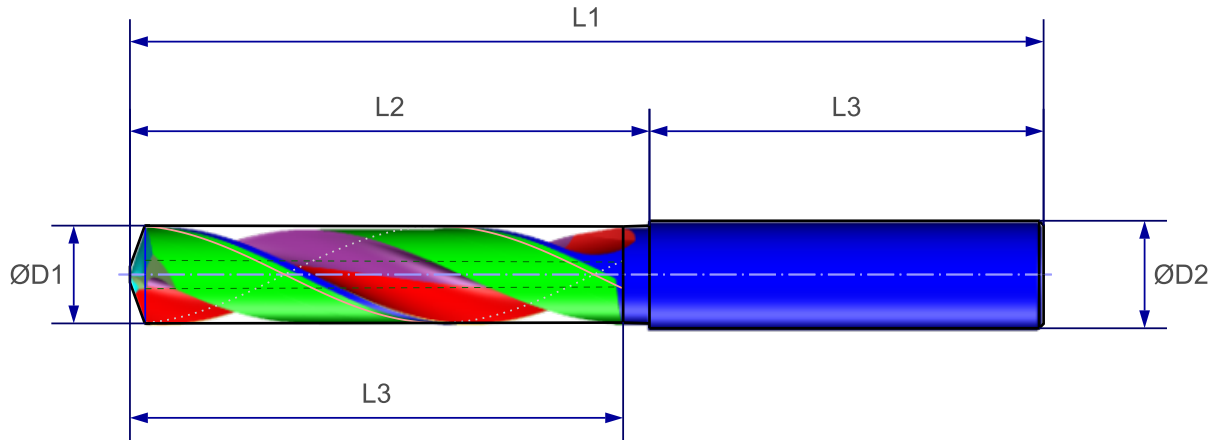
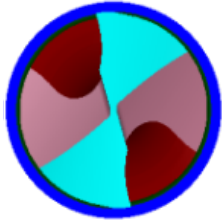
DESCRIPTION EXAMPLE... M=METRIC, GP= General Purpose, S=SOLID 2=FLUTES 3=Metric DIA, -3XD=FLUTE LENGTH	DRILL DIAMETER D1 mm m7	DRILLS FOR THREADS	SHANK DIAMETER D2	OAL L1 mm	FLUTE LENGTH L2 mm	DRILLING DEPTH L3 mm	SHANK
MGPS2-0255-3XD	2.55	M3	6	62	20	16	36
MGPS2-0300-3XD	3.00		6	62	20	15	36
MGPS2-0310-3XD	3.10		6	62	20	15	36
MGPS2-0320-3XD	3.20		6	62	20	15	36
MGPS2-0330-3XD	3.30		6	62	20	15	36
MGPS2-0337-3XD	3.37	M4	6	62	20	14	36
MGPS2-0340-3XD	3.40		6	62	20	14	36
MGPS2-0350-3XD	3.50		6	62	20	14	36
MGPS2-0360-3XD	3.60		6	62	20	14	36
MGPS2-0370-3XD	3.70		6	62	20	14	36



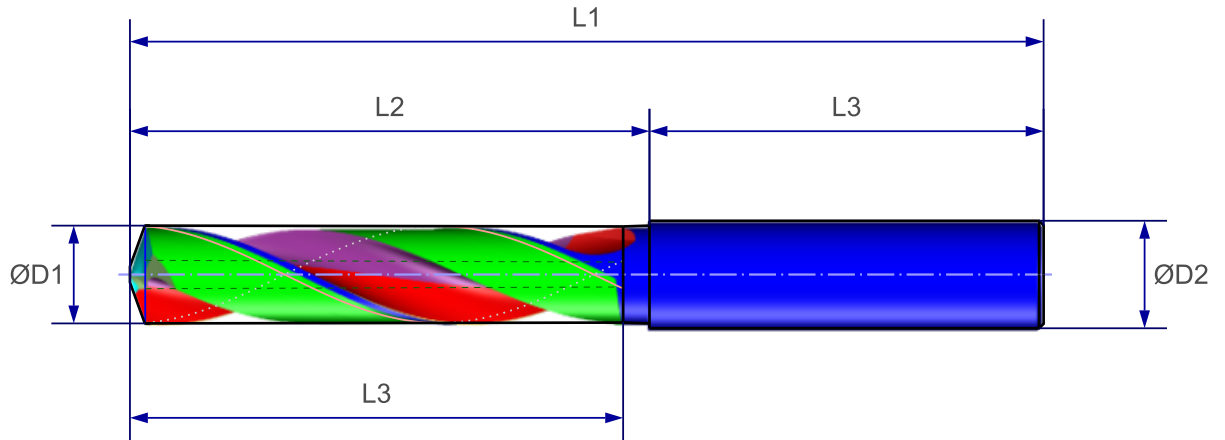
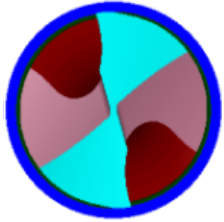
MGPS2-0380-3XD	3.80		6	66	24	18	36	
MGPS2-0390-3XD	3.90	10-24 UNC	6	66	24	18	36	
MGPS2-0400-3XD	4.00		6	66	24	18	36	
MGPS2-0410-3XD	4.10	10-32 UNF	6	66	24	17	36	
MGPS2-0420-3XD	4.20		6	66	24	17	36	
MGPS2-0430-3XD	4.30	MMC5	6	66	24	17	36	
MGPS2-0440-3XD	4.40		6	66	24	17	36	
MGPS2-0450-3XD	4.50		6	66	24	17	36	
MGPS2-0470-3XD	4.70		6	66	24	16	36	
MGPS2-0480-3XD	4.80	12-32 UNF	6	66	28	20	36	
MGPS2-0490-3XD	4.90		6	66	28	20	36	
MGPS2-0500-3XD	5.00		6	66	28	20	36	
MGPS2-0510-3XD	5.10	MMC6	6	66	28	20	36	
MGPS2-0520-3XD	5.20		6	66	28	20	36	
MGPS2-0530-3XD	5.30		6	66	28	20	36	



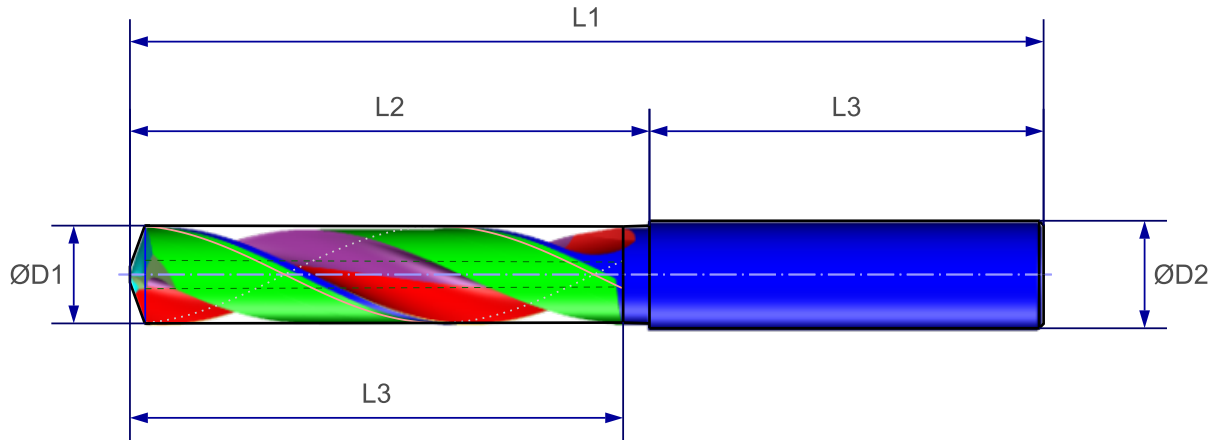
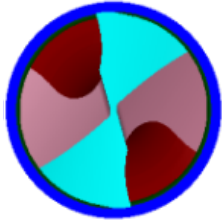
MGPS2-0540-3XD	5.40		6	66	28	19	36	
MGPS2-0550-3XD	5.50		6	66	28	19	36	
MGPS2-0560-3XD	5.60		6	66	28	19	36	
MGPS2-0570-3XD	5.70		6	66	28	19	36	
MGPS2-0580-3XD	5.80		6	66	28	19	36	
MGPS2-0590-3XD	5.90		6	66	28	19	36	
MGPS2-0600-3XD	6.00		8	79	34	25	36	
MGPS2-0610-3XD	6.10		8	79	34	24	36	
MGPS2-0620-3XD	6.20		8	79	34	24	36	
MGPS2-0630-3XD	6.30		8	79	34	24	36	
MGPS2-0640-3XD	6.40		8	79	34	24	36	
MGPS2-0650-3XD	6.50		8	79	34	24	36	
MGPS2-0660-3XD	6.60		8	79	34	24	36	
MGPS2-0670-3XD	6.70	5/18-18UNF	8	79	34	23	36	
MGPS2-0675-3XD	6.75		8	79	34	23	36	



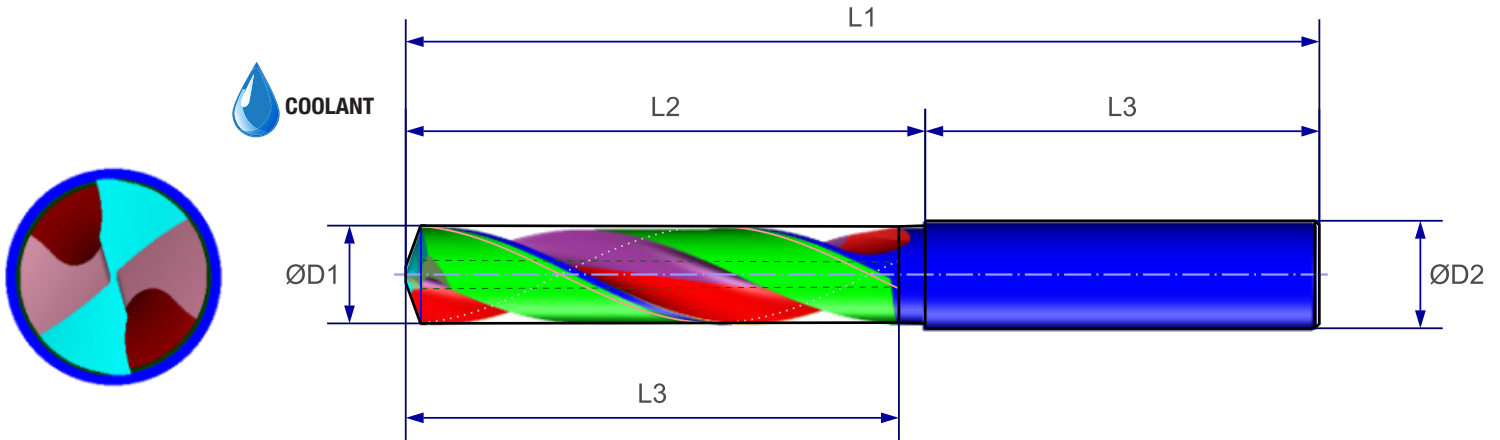
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MGPS2-0690-3XD	6.90		8	79	34	23	36	
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MGPS2-0710-3XD	7.10	MMCF8x1	8	79	41	30	36	
MGPS2-0720-3XD	7.20		8	79	41	30	36	
MGPS2-0730-3XD	7.30		8	79	41	30	36	
MGPS2-0740-3XD	7.40		8	79	41	29	36	
MGPS2-0750-3XD	7.50		8	79	41	29	36	
MGPS2-0760-3XD	7.60		8	79	41	29	36	
MGPS2-0770-3XD	7.70		8	79	41	29	36	
MGPS2-0780-3XD	7.80		8	79	41	29	36	
MGPS2-0790-3XD	7.90		8	79	41	29	36	
MGPS2-0800-3XD	8.00		10	89	47	35	40	
MGPS2-0810-3XD	8.10		10	89	47	34	40	
MGPS2-0820-3XD	8.20		10	89	47	34	40	



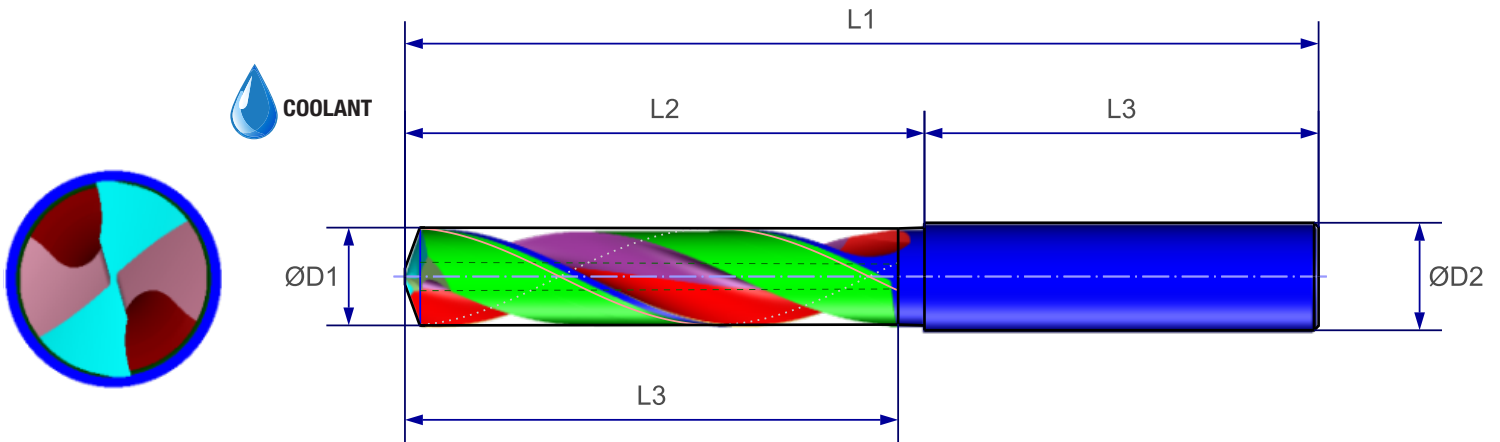
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MGPS2-0840-3XD	8.40		10	89	47	34	40	
MGPS2-0850-3XD	8.50		10	89	47	34	40	
MGPS2-0860-3XD	8.60	M10 X 1.5	10	89	47	34	40	
MGPS2-0870-3XD	8.70		10	89	47	33	40	
MGPS2-0880-3XD	8.80		10	89	47	33	40	
MGPS2-0890-3XD	8.90		10	89	47	33	40	
MGPS2-0900-3XD	9.00		10	89	47	33	40	
MGPS2-0910-3XD	9.10		10	89	47	33	40	
MGPS2-0920-3XD	9.20		10	89	47	33	40	
MGPS2-0930-3XD	9.30		10	89	47	33	40	
MGPS2-0940-3XD	9.40		10	89	47	32	40	
MGPS2-0950-3XD	9.50		10	89	47	32	40	
MGPS2-0960-3XD	9.60		10	89	47	32	40	
MGPS2-0970-3XD	9.70		10	89	47	32	40	



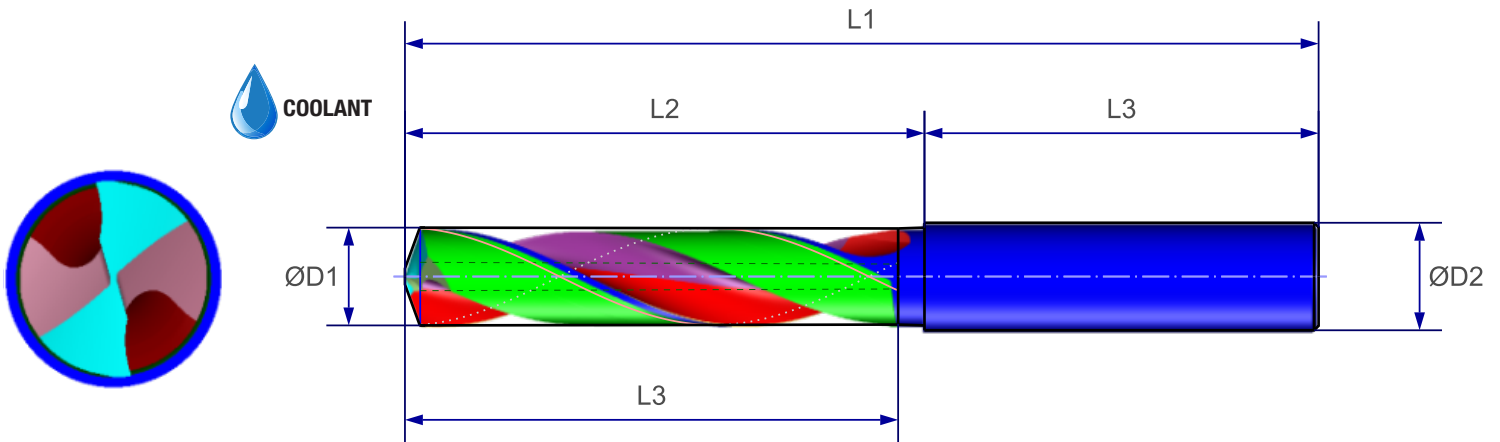
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MGPS2-0990-3XD	9.90		10	89	47	32	40	
MGPS2-1000-3XD	10.00	7/16-20 UNF	12	102	55	40	45	
MGPS2-1010-3XD	10.10		12	102	55	39	45	
MGPS2-1020-3XD	10.20		12	102	55	39	45	
MGPS2-1030-3XD	10.30		12	102	55	39	45	
MGPS2-1040-3XD	10.40	M12 X 1.75	12	102	55	39	45	
MGPS2-1050-3XD	10.50		12	102	55	39	45	
MGPS2-1060-3XD	10.60		12	102	55	39	45	
MGPS2-1070-3XD	10.70		12	102	55	38	45	
MGPS2-1080-3XD	10.80		12	102	55	38	45	
MGPS2-1085-3XD	10.85	M12 X 1.25	12	102	55	38	45	
MGPS2-1090-3XD	10.90		12	102	55	38	45	
MGPS2-1100-3XD	11.00		12	102	55	38	45	
MGPS2-1110-3XD	11.10		12	102	55	38	45	



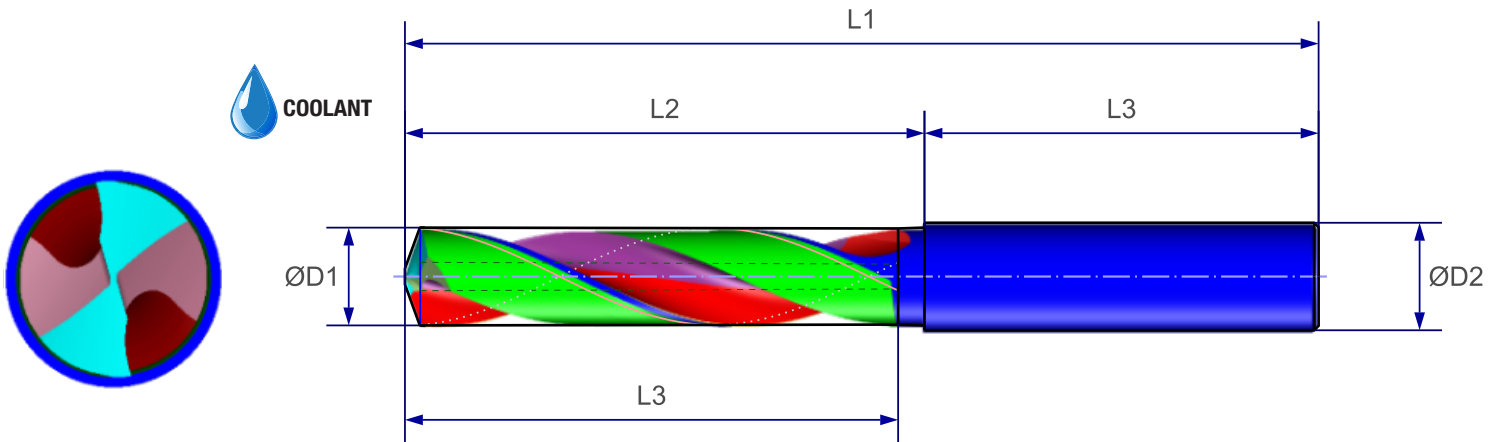
DESCRIPTION EXAMPLE... M=METRIC, GP= Gen- eral Purpose, C=COOLANT 2=FLUTES 3=Metric DIA, -3XD=FLUTE LENGTH	DRILL DIAM- ETER D1 mm m7	DRILLS FOR THREADS	SHANK DIAMETER D2	OAL L1 mm	FLUTE LENGTH L2 mm	DRILLING DEPTH L3 mm	SHANK	
MGPC2-0300-3XD	3.00		6	62	20	15	36	
MGPC2-0310-3XD	3.10		6	62	20	15	36	
MGPC2-0320-3XD	3.20		6	62	20	15	36	
MGPC2-0330-3XD	3.30		6	62	20	15	36	
MGPC2-0337-3XD	3.37	M4	6	62	20	14	36	
MGPC2-0340-3XD	3.40		6	62	20	14	36	
MGPC2-0350-3XD	3.50		6	62	20	14	36	
MGPC2-0360-3XD	3.60		6	62	20	14	36	
MGPC2-0370-3XD	3.70		6	62	20	14	36	
MGPC2-0380-3XD	3.80		6	66	24	18	36	



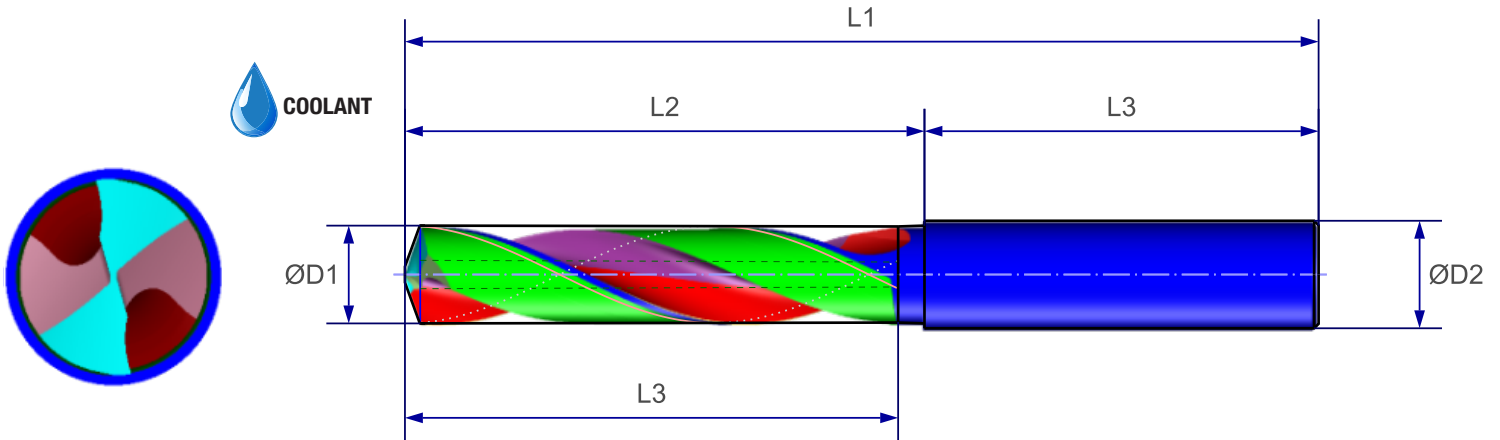
MGPC2-0390-3XD	3.90	10-24 UNC	6	66	24	18	36	
MGPC2-0400-3XD	4.00		6	66	24	18	36	
MGPC2-0410-3XD	4.10	10-32 UNF	6	66	24	17	36	
MGPC2-0420-3XD	4.20		6	66	24	17	36	
MGPC2-0430-3XD	4.30	MMC5	6	66	24	17	36	
MGPC2-0440-3XD	4.40		6	66	24	17	36	
MGPC2-0450-3XD	4.50		6	66	24	17	36	
MGPC2-0470-3XD	4.70		6	66	24	16	36	
MGPC2-0480-3XD	4.80	12-32 UNF	6	66	28	20	36	
MGPC2-0490-3XD	4.90		6	66	28	20	36	
MGPC2-0500-3XD	5.00		6	66	28	20	36	
MGPC2-0510-3XD	5.10	MMC6	6	66	28	20	36	
MGPC2-0520-3XD	5.20		6	66	28	20	36	
MGPC2-0530-3XD	5.30		6	66	28	20	36	
MGPC2-0540-3XD	5.40		6	66	28	19	36	



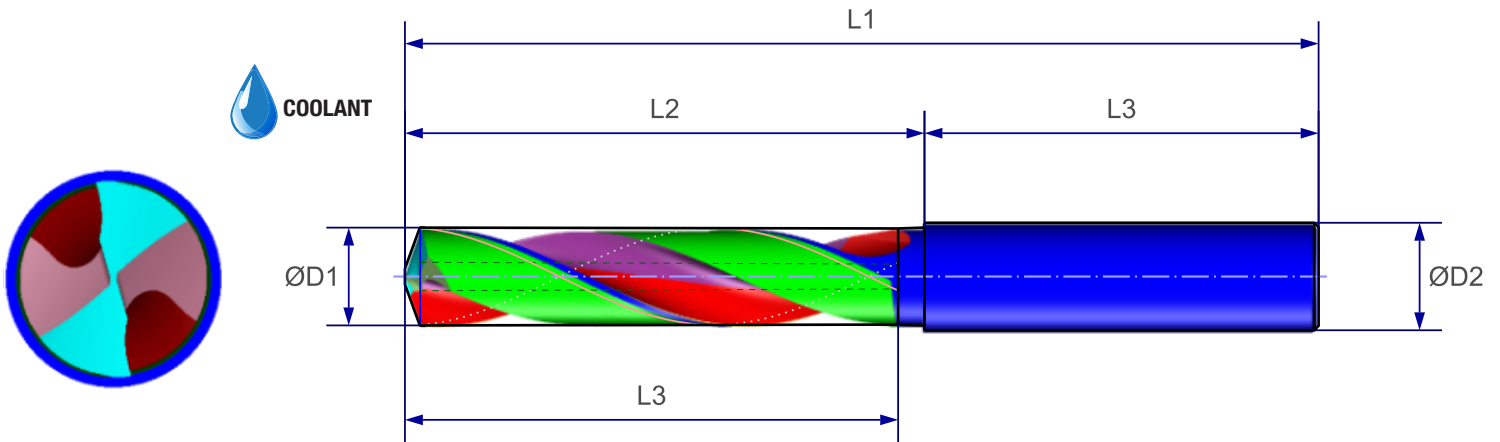
MGPC2-0550-3XD	5.50		6	66	28	19	36	
MGPC2-0560-3XD	5.60		6	66	28	19	36	
MGPC2-0570-3XD	5.70		6	66	28	19	36	
MGPC2-0580-3XD	5.80		6	66	28	19	36	
MGPC2-0590-3XD	5.90		6	66	28	19	36	
MGPC2-0600-3XD	6.00		8	79	34	25	36	
MGPC2-0610-3XD	6.10		8	79	34	24	36	
MGPC2-0620-3XD	6.20		8	79	34	24	36	
MGPC2-0630-3XD	6.30		8	79	34	24	36	
MGPC2-0640-3XD	6.40		8	79	34	24	36	
MGPC2-0650-3XD	6.50		8	79	34	24	36	
MGPC2-0660-3XD	6.60		8	79	34	24	36	
MGPC2-0670-3XD	6.70	5/18-18UNF	8	79	34	23	36	
MGPC2-0675-3XD	6.75		8	79	34	23	36	
MGPC2-0680-3XD	6.80		8	79	34	23	36	



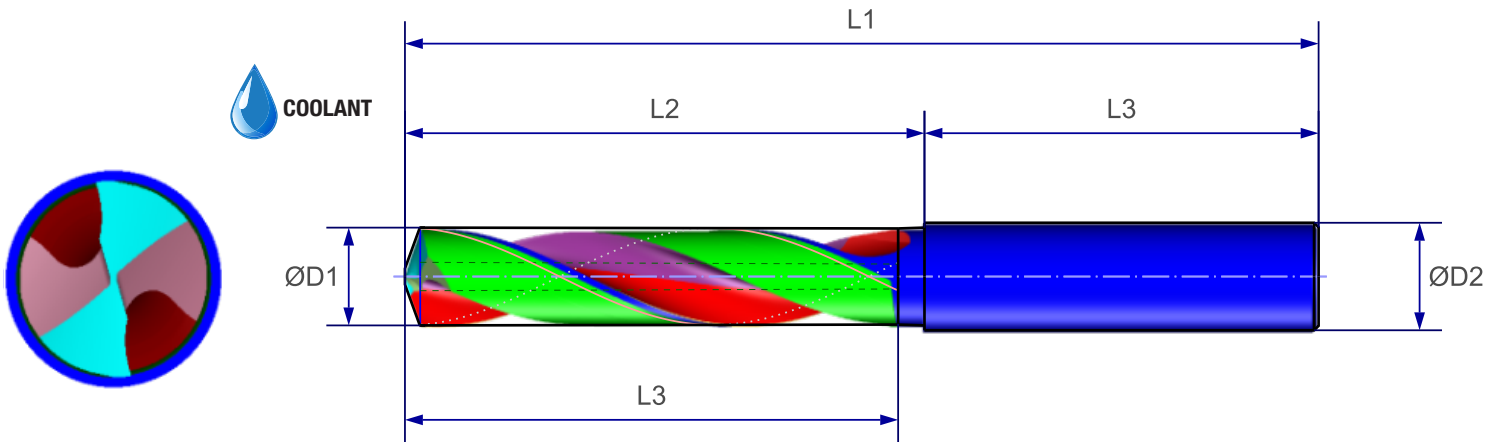
MGPC2-0690-3XD	6.90		8	79	34	23	36	
MGPC2-0700-3XD	7.00		8	79	34	23	36	
MGPC2-0710-3XD	7.10	MMCF8x1	8	79	41	30	36	
MGPC2-0720-3XD	7.20		8	79	41	30	36	
MGPC2-0730-3XD	7.30		8	79	41	30	36	
MGPC2-0740-3XD	7.40		8	79	41	29	36	
MGPC2-0750-3XD	7.50		8	79	41	29	36	
MGPC2-0760-3XD	7.60		8	79	41	29	36	
MGPC2-0770-3XD	7.70		8	79	41	29	36	
MGPC2-0780-3XD	7.80		8	79	41	29	36	
MGPC2-0790-3XD	7.90		8	79	41	29	36	
MGPC2-0800-3XD	8.00		10	89	47	35	40	
MGPC2-0810-3XD	8.10		10	89	47	34	40	
MGPC2-0820-3XD	8.20		10	89	47	34	40	
MGPC2-0830-3XD	8.30		10	89	47	34	40	



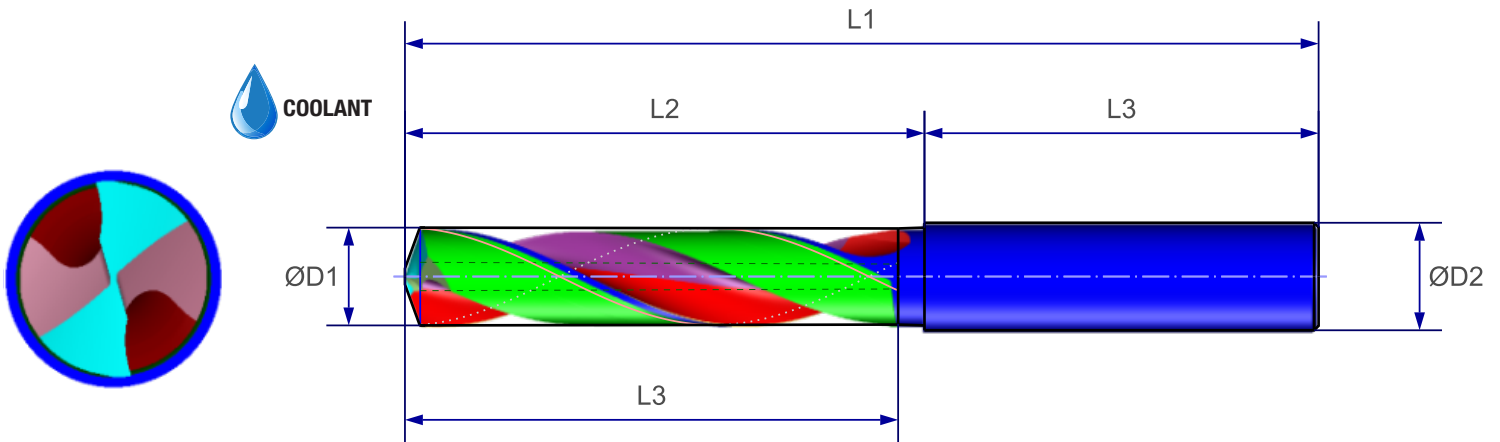
MGPC2-0840-3XD	8.40		10	89	47	34	40	
MGPC2-0850-3XD	8.50		10	89	47	34	40	
MGPC2-0860-3XD	8.60	M10 X 1.5	10	89	47	34	40	
MGPC2-0870-3XD	8.70		10	89	47	33	40	
MGPC2-0880-3XD	8.80		10	89	47	33	40	
MGPC2-0890-3XD	8.90		10	89	47	33	40	
MGPC2-0900-3XD	9.00		10	89	47	33	40	
MGPC2-0910-3XD	9.10		10	89	47	33	40	
MGPC2-0920-3XD	9.20		10	89	47	33	40	
MGPC2-0930-3XD	9.30		10	89	47	33	40	
MGPC2-0940-3XD	9.40		10	89	47	32	40	
MGPC2-0950-3XD	9.50		10	89	47	32	40	
MGPC2-0960-3XD	9.60		10	89	47	32	40	
MGPC2-0970-3XD	9.70		10	89	47	32	40	
MGPC2-0980-3XD	9.80		10	89	47	32	40	



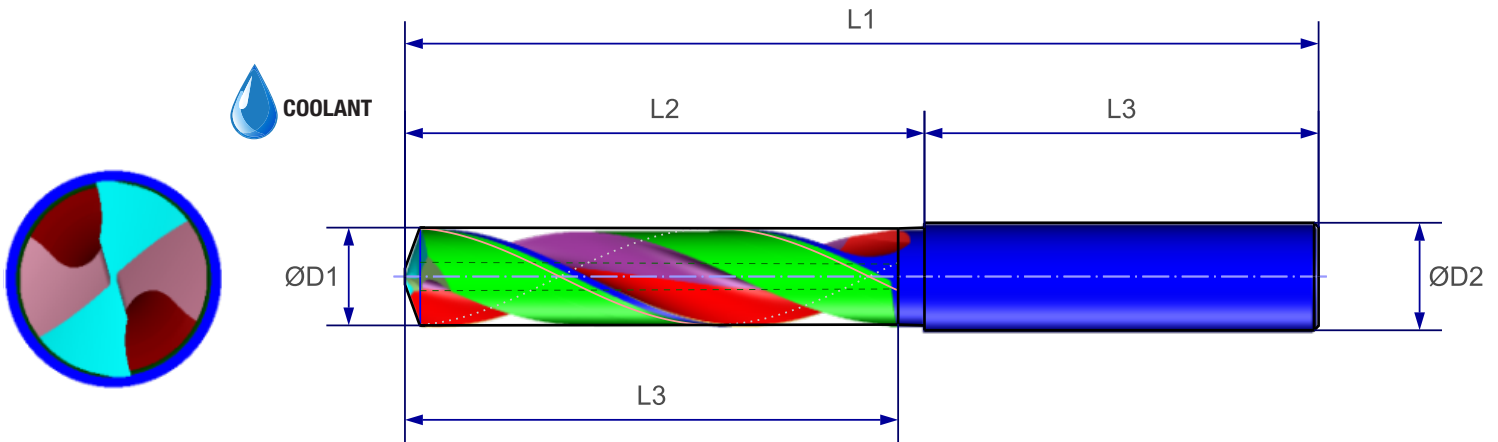
MGPC2-0990-3XD	9.90		10	89	47	32	40	
MGPC2-1000-3XD	10.00	7/16-20 UNF	12	102	55	40	45	
MGPC2-1010-3XD	10.10		12	102	55	39	45	
MGPC2-1020-3XD	10.20		12	102	55	39	45	
MGPC2-1030-3XD	10.30		12	102	55	39	45	
MGPC2-1040-3XD	10.40	M12 X 1.75	12	102	55	39	45	
MGPC2-1050-3XD	10.50		12	102	55	39	45	
MGPC2-1060-3XD	10.60		12	102	55	39	45	
MGPC2-1070-3XD	10.70		12	102	55	38	45	
MGPC2-1080-3XD	10.80		12	102	55	38	45	
MGPC2-1085-3XD	10.85	M12 X 1.25	12	102	55	38	45	
MGPC2-1090-3XD	10.90		12	102	55	38	45	
MGPC2-1100-3XD	11.00		12	102	55	38	45	
MGPC2-1110-3XD	11.10		12	102	55	38	45	



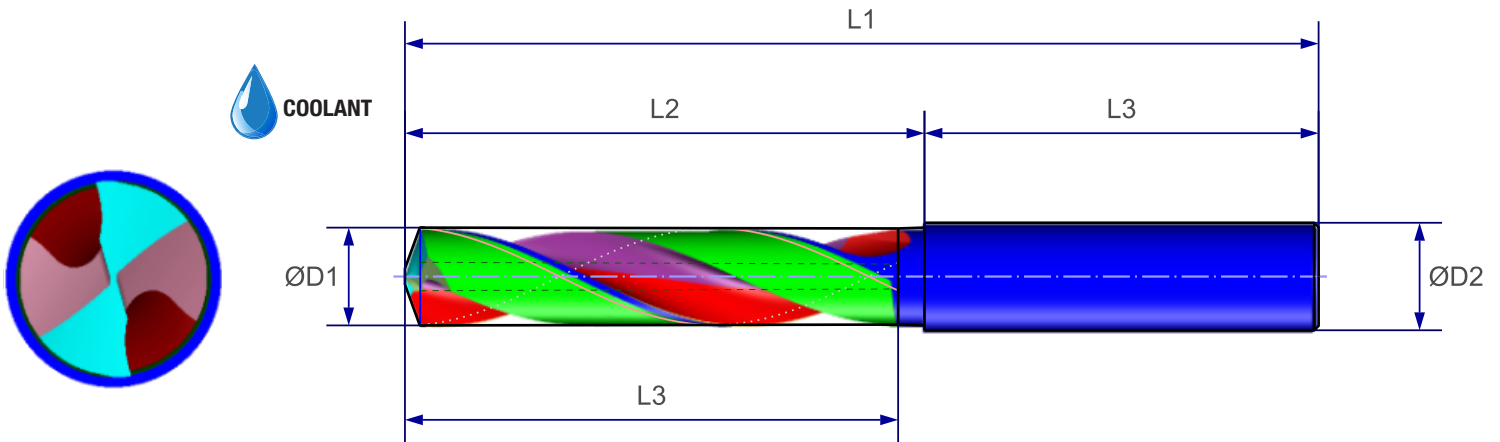
DESCRIPTION EXAMPLE... I=INCH GP= General Pur- pose C=Cool- ant 2=FLUTES 125=DIA, 5XD=Flute Length	DRILL DIAME- TER D1 inch m7	DRILLS FRACTION- AL & FOR THREADS	SHANK DI- AMETER D2 metric	OAL L1 inch	FLUTE LENGTH L2 inch	DRILLING DEPTH L3 inch	SHANK
IGPC2-1250-5XD	.125	1/8	6	2.598	1.102	0.915	1.417
IGPC2-1406-5XD	.141	9/64	6	2.598	1.102	0.891	1.417
IGPC2-1540-5XD	.154	10-24 UNC	6	2.913	1.417	1.186	1.417
IGPC2-1562-5XD	.156	5/32	6	2.913	1.417	1.183	1.417
IGPC2-1610-5XD	.161	10-32 UNF	6	2.913	1.417	1.176	1.417
IGPC2-1690-5XD	.169	M5	6	2.913	1.417	1.164	1.417
IGPC2-1719-5XD	.172	11/64	6	2.913	1.417	1.159	1.417
IGPC2-1875-5XD	.188	3/16	6	3.228	1.732	1.451	1.417
IGPC2-1890-5XD	.189	12-32 UNF	6	3.228	1.732	1.449	1.417
IGPC2-2010-5XD	.201	M6	6	3.228	1.732	1.431	1.417



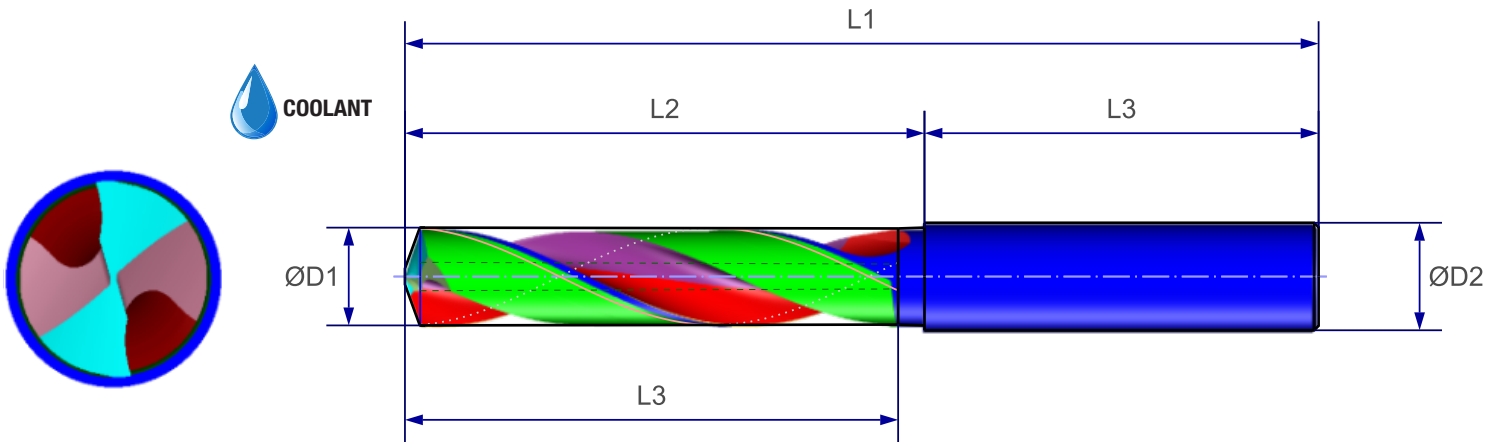
IGPC2-2031-5XD	.203	13/64	6	3.228	1.732	1.427	1.417
IGPC2-2188-5XD	.219	7/32	6	3.228	1.732	1.404	1.417
IGPC2-2344-5XD	.234	15/64	6	3.228	1.732	1.380	1.417
IGPC2-2500-5XD	.250	1/4	8	3.583	2.087	1.712	1.417
IGPC2-2620-5XD	.262	5/18-18UNF	8	3.583	2.087	1.694	1.417
IGPC2-2656-5XD	.266	17/64	8	3.583	2.087	1.689	1.417
IGPC2-2800-5XD	.280	MF8x1	8	3.583	2.087	1.667	1.417
IGPC2-2813-5XD	.281	9/32	8	3.583	2.087	1.665	1.417
IGPC2-2968-5XD	.297	19/64	8	3.583	2.087	1.642	1.417
IGPC2-3125-5XD	.313	5/16	8	3.583	2.087	1.618	1.417
IGPC2-3281-5XD	.328	21/64	10	4.055	2.402	1.910	1.575
IGPC2-3438-5XD	.344	11/32	10	4.055	2.402	1.886	1.575



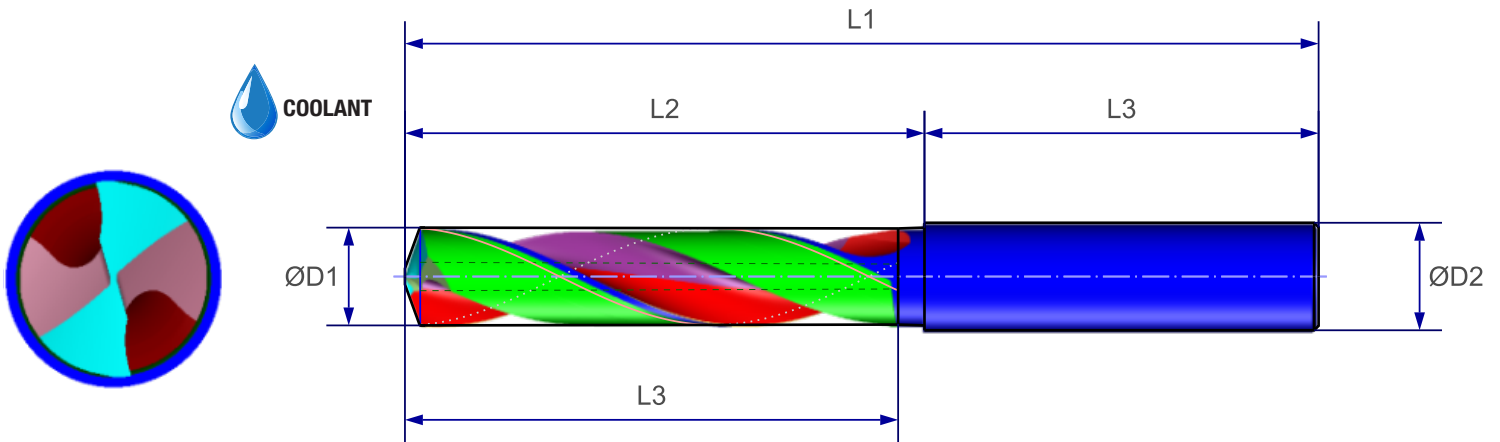
DESCRIPTION EXAMPLE... M=METRIC, GP= General Purpose, C=COOLANT 2=FLUTES 3=Metric DIA, -5XD=FLUTE LENGTH	DRILL DIAME- TER D1 mm m7	DRILLS FOR THREADS	SHANK DIAMETER D2	OAL L1 mm	FLUTE LENGTH L2 mm	DRILLING DEPTH L3 mm	SHANK	
MGPC2-0300-5XD	3.00		6	66	28	23	36	
MGPC2-0310-5XD	3.10		6	66	28	23	36	
MGPC2-0320-5XD	3.20		6	66	28	23	36	
MGPC2-0330-5XD	3.30		6	66	28	23	36	
MGPC2-0340-5XD	3.40	M4	6	66	28	22	36	
MGPC2-0350-5XD	3.50		6	66	28	22	36	
MGPC2-0360-5XD	3.60		6	66	28	22	36	
MGPC2-0370-5XD	3.70		6	66	28	22	36	
MGPC2-0380-5XD	3.80		6	74	36	30	36	
MGPC2-0390-5XD	3.90	10-24 UNC	6	74	36	30	36	



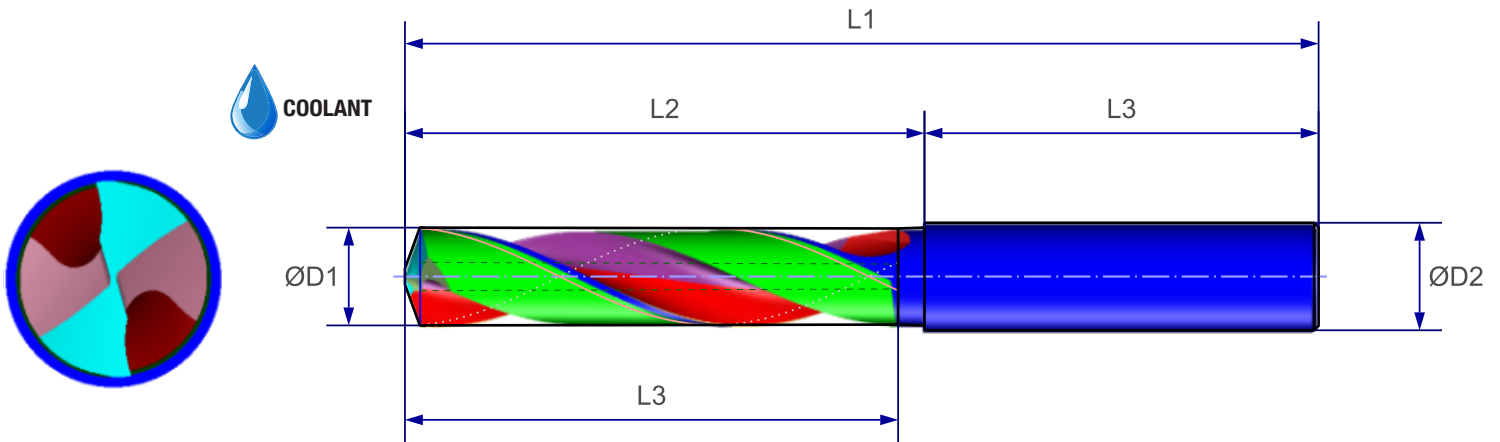
MGPC2-0400-5XD	4.00		6	74	36	30	36	
MGPC2-0410-5XD	4.10	10-32 UNC	6	74	36	29	36	
MGPC2-0420-5XD	4.20		6	74	36	29	36	
MGPC2-0430-5XD	4.30	M5	6	74	36	29	36	
MGPC2-0440-5XD	4.40		6	74	36	29	36	
MGPC2-0450-5XD	4.50		6	74	36	29	36	
MGPC2-0470-5XD	4.70		6	74	36	28	36	
MGPC2-0480-5XD	4.80	12-32 UNC	6	82	44	36	36	
MGPC2-0490-5XD	4.90		6	82	44	36	36	
MGPC2-0500-5XD	5.00		6	82	44	36	36	
MGPC2-0510-5XD	5.10	M6	6	82	44	36	36	
MGPC2-0520-5XD	5.20		6	82	44	36	36	
MGPC2-0530-5XD	5.30	1/4-20 UNC	6	82	44	36	36	
MGPC2-0540-5XD	5.40		6	82	44	35	36	
MGPC2-0550-5XD	5.50		6	82	44	35	36	



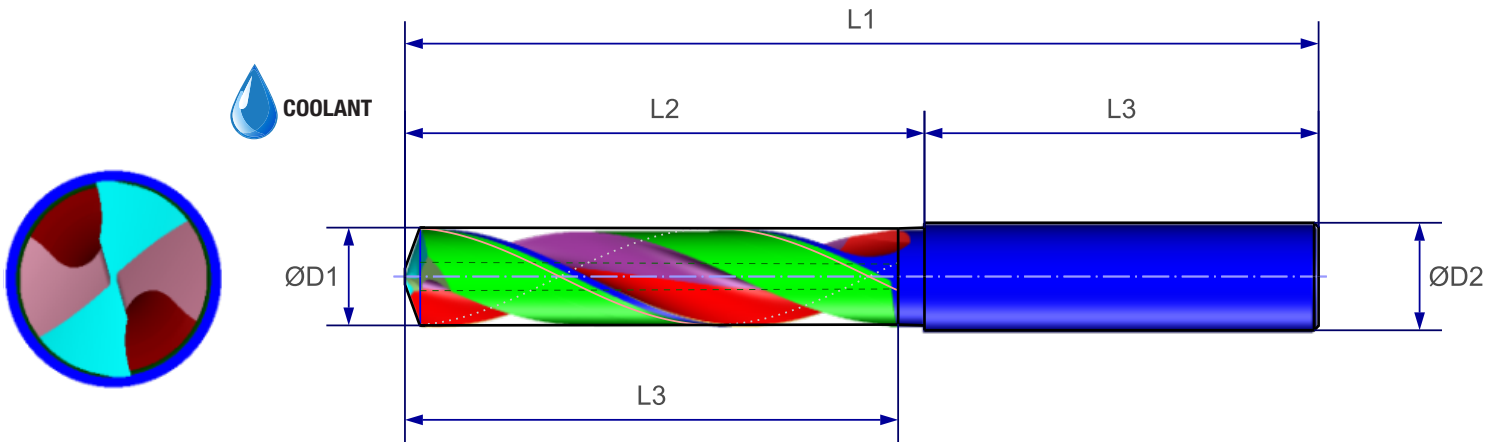
MGPC2-0560-5XD	5.60		6	82	44	35	36	
MGPC2-0570-5XD	5.70		6	82	44	35	36	
MGPC2-0580-5XD	5.80		6	82	44	35	36	
MGPC2-0590-5XD	5.90		6	82	44	35	36	
MGPC2-0600-5XD	6.00		8	91	53	44	36	
MGPC2-0610-5XD	6.10		8	91	53	43	36	
MGPC2-0620-5XD	6.20		8	91	53	43	36	
MGPC2-0630-5XD	6.30		8	91	53	43	36	
MGPC2-0640-5XD	6.40		8	91	53	43	36	
MGPC2-0650-5XD	6.50		8	91	53	43	36	
MGPC2-0660-5XD	6.60		8	91	53	43	36	
MGPC2-0670-5XD	6.70	5/18-18UNF	8	91	53	42	36	
MGPC2-0675-5XD	6.75		8	91	53	42	36	
MGPC2-0680-5XD	6.80		8	91	53	42	36	
MGPC2-0690-5XD	6.90	M8	8	91	53	42	36	



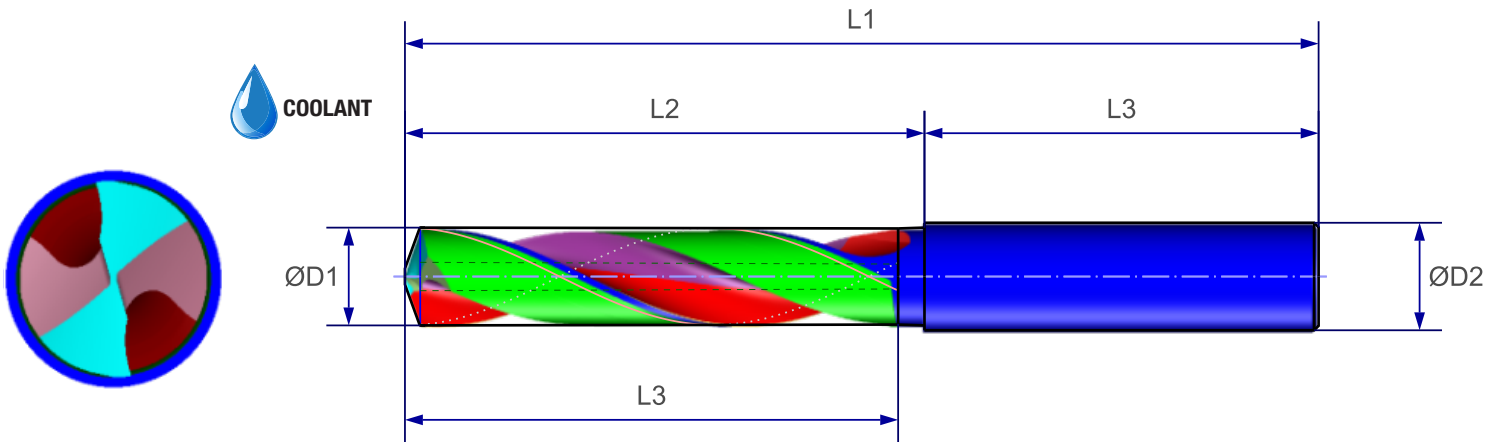
MGPC2-0700-5XD	7.00		8	91	53	42	36	
MGPC2-0710-5XD	7.10	MF8x1	8	91	53	42	36	
MGPC2-0720-5XD	7.20		8	91	53	42	36	
MGPC2-0730-5XD	7.30		8	91	53	42	36	
MGPC2-0740-5XD	7.40		8	91	53	41	36	
MGPC2-0750-5XD	7.50		8	91	53	41	36	
MGPC2-0760-5XD	7.60		8	91	53	41	36	
MGPC2-0770-5XD	7.70		8	91	53	41	36	
MGPC2-0780-5XD	7.80		8	91	53	41	36	
MGPC2-0790-5XD	7.90		8	91	53	41	36	
MGPC2-0800-5XD	8.00		10	103	61	49	40	
MGPC2-0810-5XD	8.10		10	103	61	48	40	
MGPC2-0820-5XD	8.20	3/8-16 UNC	10	103	61	48	40	
MGPC2-0830-5XD	8.30		10	103	61	48	40	
MGPC2-0840-5XD	8.40		10	103	61	48	40	



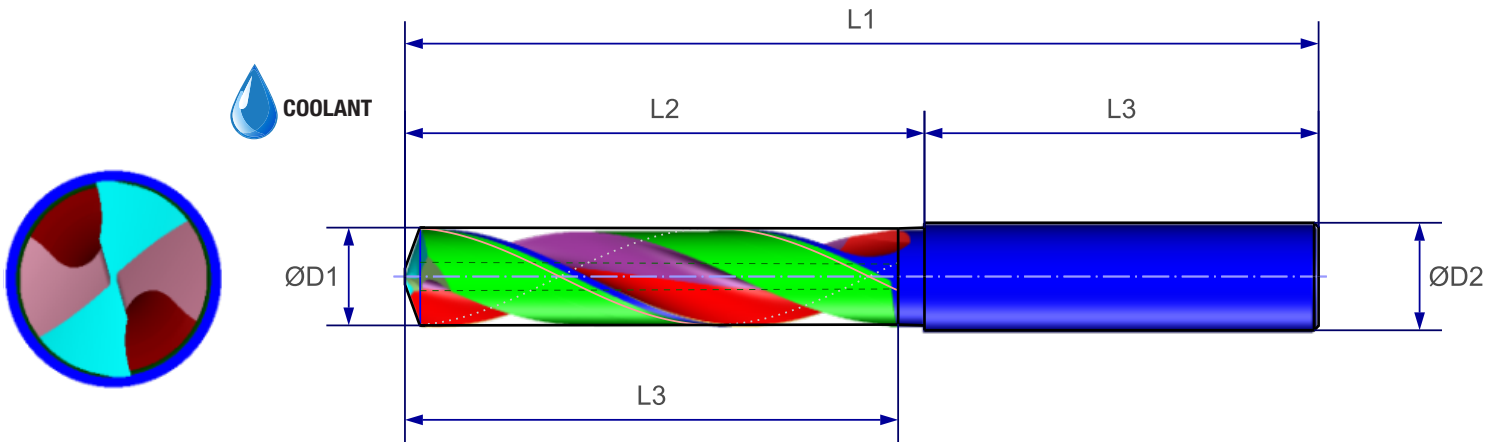
MGPC2-0850-5XD	8.50		10	103	61	48	40	
MGPC2-0860-5XD	8.60	3/8-24 UNF	10	103	61	48	40	
MGPC2-0870-5XD	8.70	M10	10	103	61	47	40	
MGPC2-0880-5XD	8.80		10	103	61	47	40	
MGPC2-0890-5XD	8.90	MF10x1.25	10	103	61	47	40	
MGPC2-0900-5XD	9.00		10	103	61	47	40	
MGPC2-0910-5XD	9.10		10	103	61	47	40	
MGPC2-0920-5XD	9.20		10	103	61	47	40	
MGPC2-0930-5XD	9.30		10	103	61	47	40	
MGPC2-0940-5XD	9.40		10	103	61	46	40	
MGPC2-0950-5XD	9.50		10	103	61	46	40	
MGPC2-0960-5XD	9.60		10	103	61	46	40	
MGPC2-0970-5XD	9.70		10	103	61	46	40	
MGPC2-0980-5XD	9.70		10	103	61	46	40	
MGPC2-0990-5XD	9.90		10	103	61	46	40	



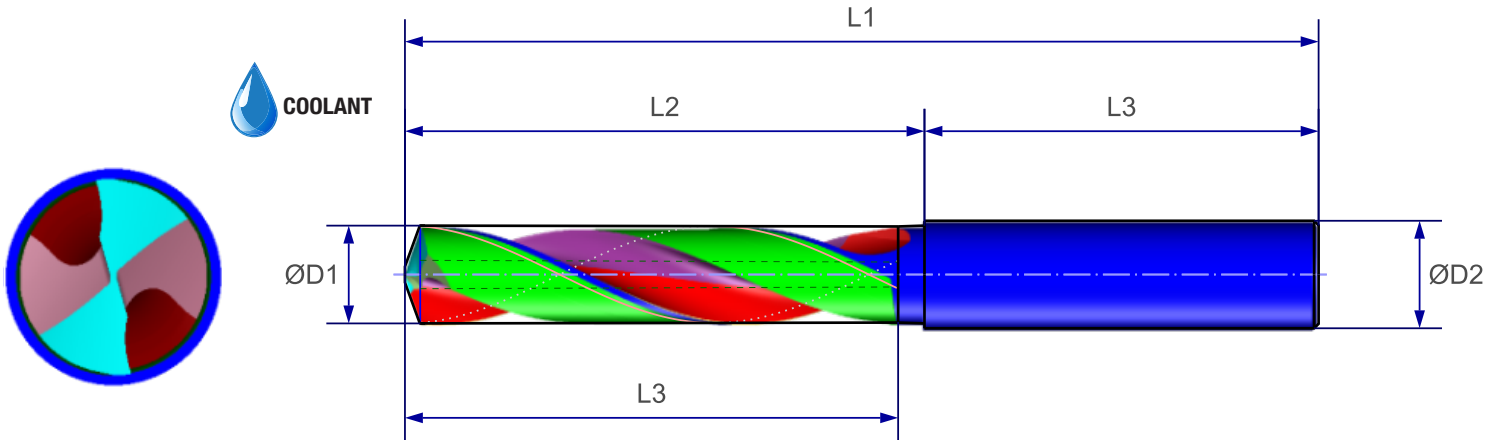
MGPC2-1000-5XD	10.00	7/16-20 UNF	12	118	71	56	45	
MGPC2-1010-5XD	10.10		12	118	71	55	45	
MGPC2-1020-5XD	10.20		12	118	71	55	45	
MGPC2-1030-5XD	10.30		12	118	71	55	45	
MGPC2-1040-5XD	10.40	M12	12	118	71	55	45	
MGPC2-1050-5XD	10.50		12	118	71	55	45	
MGPC2-1060-5XD	10.60		12	118	71	55	45	
MGPC2-1070-5XD	10.70	MF12x1.5	12	118	71	54	45	
MGPC2-1080-5XD	10.80		12	118	71	54	45	
MGPC2-1090-5XD	10.90		12	118	71	54	45	
MGPC2-1100-5XD	11.00	1/2-13 UNC	12	118	71	54	45	
MGPC2-1110-5XD	11.10		12	118	71	54	45	



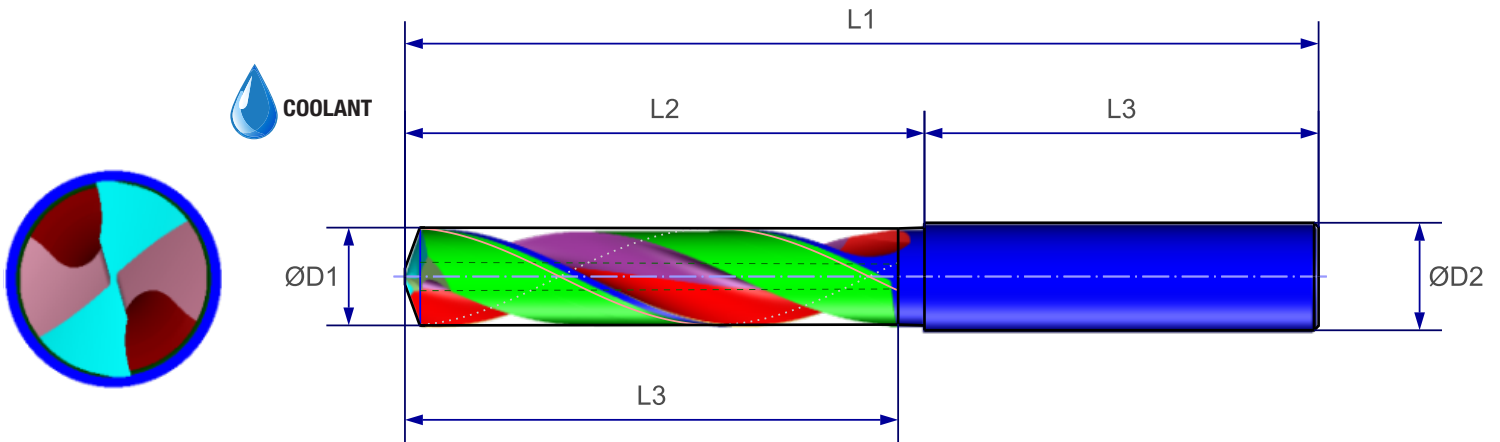
DESCRIPTION EXAMPLE... I=INCH GP= General Pur- pose C= Cool- ant 2=FLUTES 125=DIA, 7XD=FLUTE LENGTH	DRILL DIAM- ETER D1 inch m7	DRILLS FRACTION- AL & FOR THREADS	SHANK DI- AMETER D2 metric	OAL L1 inch	FLUTE LENGTH L2 inch	DRILLING DEPTH L3 inch	SHANK	
IGPC2- 1250-7XD	.125	1/8	6	2.756	1.181	0.994	1.417	
IGPC2- 1406-7XD	.141	9/64	6	2.953	1.476	1.265	1.417	
IGPC2- 1540-7XD	.154	10-24 UNC	6	2.953	1.476	1.245	1.417	
IGPC2- 1562-7XD	.156	5/32	6	2.953	1.476	1.242	1.417	
IGPC2- 1610-7XD	.161	10-32 UNF	6	2.953	1.476	1.235	1.417	
IGPC2- 1690-7XD	.169	M5	6	3.346	1.772	1.519	1.417	
IGPC2- 1719-7XD	.172	11/64	6	3.346	1.772	1.514	1.417	
IGPC2- 1875-7XD	.188	3/16	6	3.543	1.969	1.688	1.417	
IGPC2- 1890-7XD	.189	12-32 UNF	6	3.543	1.969	1.686	1.417	
IGPC2- 2010-7XD	.201	M6	6	3.543	1.969	1.668	1.417	



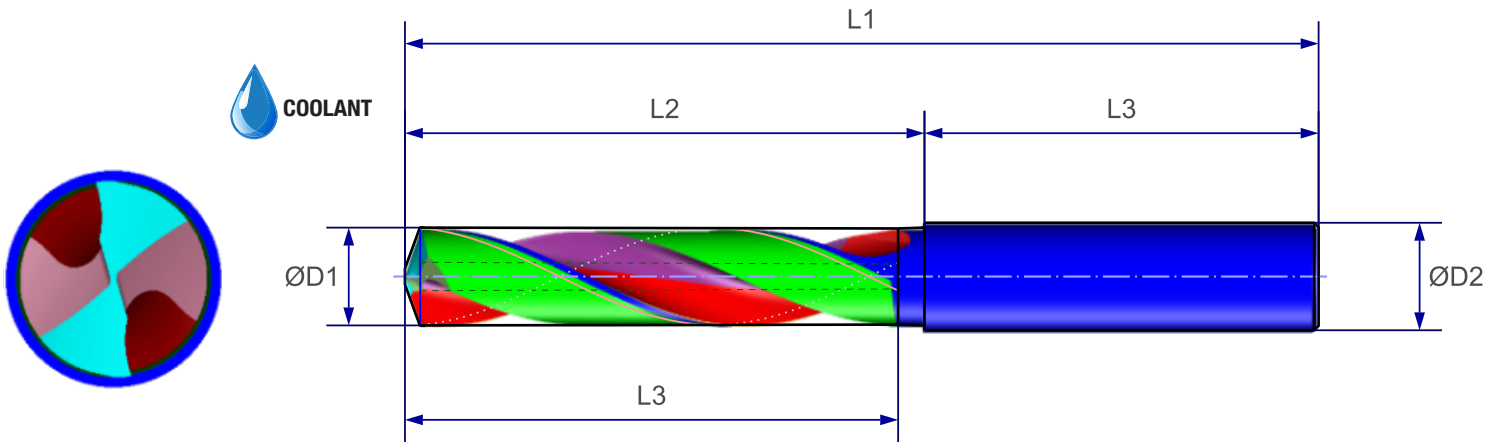
IGPC2-2031-7XD	.203	13/64	6	3.543	1.969	1.664	1.417	
IGPC2-2188-7XD	.219	7/32	6	3.819	2.244	1.916	1.417	
IGPC2-2344-7XD	.234	15/64	6	3.819	2.244	1.892	1.417	
IGPC2-2500-7XD	.250	1/4	8	4.173	2.598	2.223	1.417	
IGPC2-2620-7XD	.262	5/18-18UNF	8	4.173	2.598	2.205	1.417	
IGPC2-2656-7XD	.266	17/64	8	4.173	2.598	2.200	1.417	
IGPC2-2800-7XD	.280	MF8x1	8	4.567	2.992	2.572	1.417	
IGPC2-2813-7XD	.281	9/32	8	4.567	2.992	2.570	1.417	
IGPC2-2969-7XD	.297	19/64	8	4.567	2.992	2.547	1.417	
IGPC2-3125-7XD	.313	5/16	8	4.567	2.992	2.523	1.417	
IGPC2-3281-7XD	.328	21/64	10	5.157	3.425	2.933	1.575	
IGPC2-3438-7XD	.344	11/32	10	5.157	3.425	2.909	1.575	



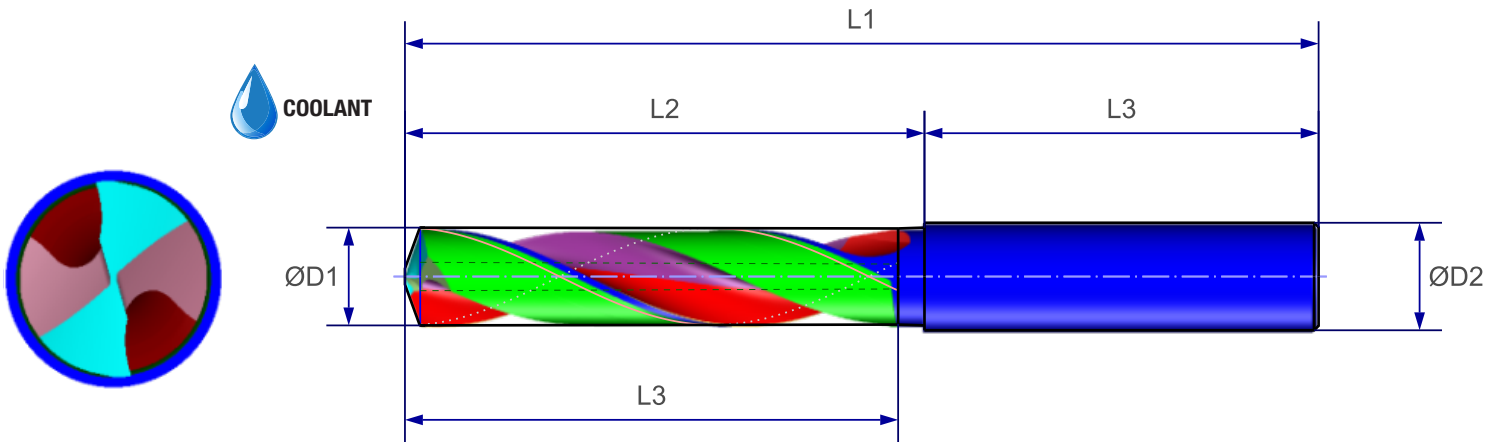
DESCRIPTION EXAMPLE... M=METRIC, GP= General Purpose, C=COOLANT 2=FLUTES 3=Metric DIA, -7XD=FLUTE LENGTH	DRILL DIAMETER D1 mm m7	DRILLS FOR THREADS	SHANK DIAMETER D2	OAL L1 mm	FLUTE LENGTH L2 mm	DRILLING DEPTH L3 mm	SHANK	
MGPC2-0300-7XD	3.00		6	70	30	25	36	
MGPC2-0310-7XD	3.10		6	70	30	25	36	
MGPC2-0320-7XD	3.20		6	70	30	25	36	
MGPC2-0330-7XD	3.30		6	70	30	25	36	
MGPC2-0340-7XD	3.40	M4	6	75	38	32	36	
MGPC2-0350-7XD	3.50		6	75	38	32	36	
MGPC2-0360-7XD	3.60		6	75	38	32	36	
MGPC2-0370-7XD	3.70		6	75	38	31	36	
MGPC2-0380-7XD	3.80		6	75	38	31	36	
MGPC2-0390-7XD	3.90	10-24 UNC	6	75	38	31	36	



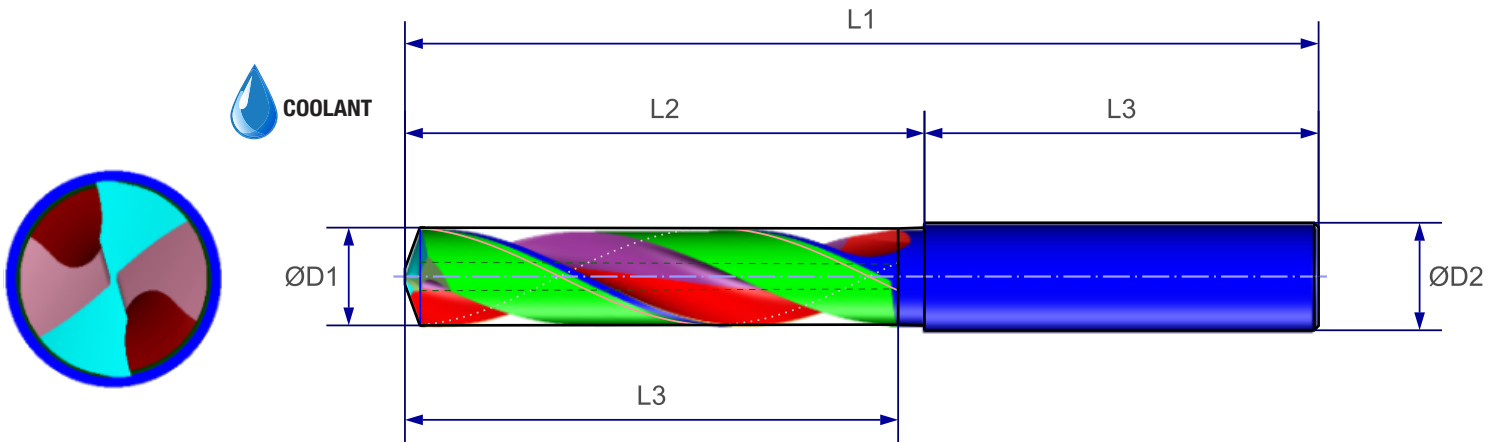
MGPC2-0400-7XD	4.00		6	75	38	31	36	
MGPC2-0410-7XD	4.10	10-32 UNC	6	75	38	31	36	
MGPC2-0420-7XD	4.20		6	75	38	31	36	
MGPC2-0430-7XD	4.30	M5	6	85	45	38	36	
MGPC2-0440-7XD	4.40		6	85	45	38	36	
MGPC2-0450-7XD	4.50		6	85	45	38	36	
MGPC2-0470-7XD	4.70		6	85	45	37	36	
MGPC2-0480-7XD	4.80	12-32 UNC	6	90	50	42	36	
MGPC2-0490-7XD	4.90		6	90	50	42	36	
MGPC2-0500-7XD	5.00		6	90	50	42	36	
MGPC2-0510-7XD	5.10	M6	6	90	50	42	36	
MGPC2-0520-7XD	5.20		6	90	50	42	36	
MGPC2-0530-7XD	5.30	1/4-20 UNC	6	90	50	42	36	
MGPC2-0540-7XD	5.40		6	90	50	41	36	
MGPC2-0550-7XD	5.50		6	97	57	48	36	



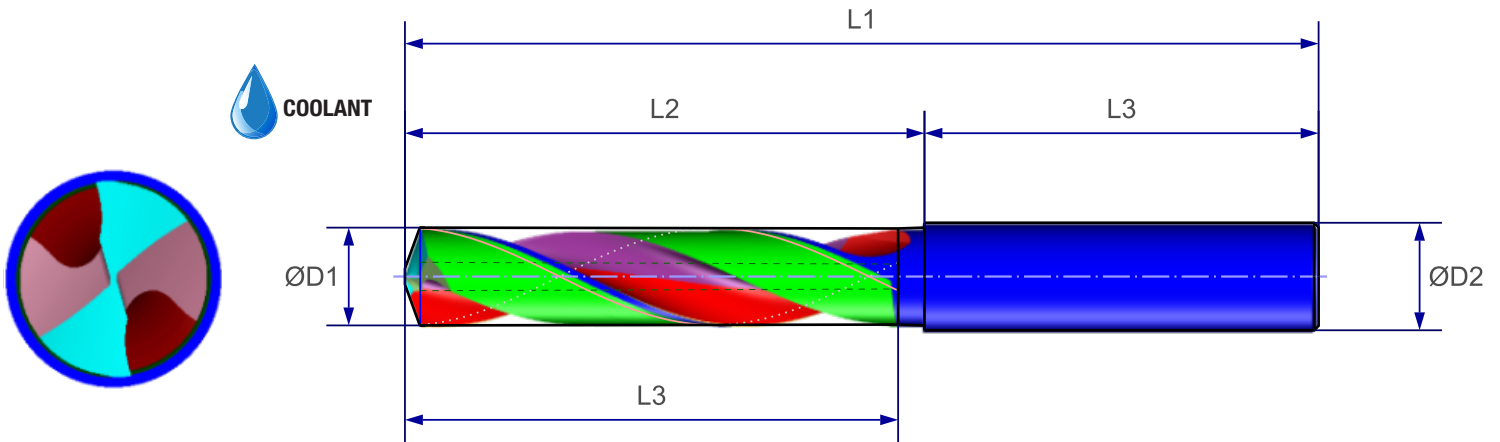
MGPC2-0560-7XD	5.60		6	97	57	48	36	
MGPC2-0570-7XD	5.70		6	97	57	48	36	
MGPC2-0580-7XD	5.80		6	97	57	48	36	
MGPC2-0590-7XD	5.90		6	97	57	48	36	
MGPC2-0600-7XD	6.00		8	106	66	57	36	
MGPC2-0610-7XD	6.10		8	106	66	56	36	
MGPC2-0620-7XD	6.20		8	106	66	56	36	
MGPC2-0630-7XD	6.30		8	106	66	56	36	
MGPC2-0640-7XD	6.40		8	106	66	56	36	
MGPC2-0650-7XD	6.50		8	106	66	56	36	
MGPC2-0660-7XD	6.60		8	106	66	56	36	
MGPC2-0670-7XD	6.70	5/18-18UNF	8	106	66	55	36	
MGPC2-0675-7XD	6.75		8	106	66	55	36	
MGPC2-0680-7XD	6.80		8	106	66	55	36	
MGPC2-0690-7XD	6.90	M8	8	116	76	65	36	



MGPC2-0700-7XD	7.00		8	116	76	65	36	
MGPC2-0710-7XD	7.10	MF8x1	8	116	76	65	36	
MGPC2-0720-7XD	7.20		8	116	76	65	36	
MGPC2-0730-7XD	7.30		8	116	76	65	36	
MGPC2-0740-7XD	7.40		8	116	76	64	36	
MGPC2-0750-7XD	7.50		8	116	76	64	36	
MGPC2-0760-7XD	7.60		8	116	76	64	36	
MGPC2-0770-7XD	7.70		8	116	76	64	36	
MGPC2-0780-7XD	7.80		8	116	76	64	36	
MGPC2-0790-7XD	7.90		8	116	76	64	36	
MGPC2-0800-7XD	8.00		10	131	87	75	40	
MGPC2-0810-7XD	8.10		10	131	87	74	40	
MGPC2-0820-7XD	8.20	3/8-16 UNC	10	131	87	74	40	
MGPC2-0830-7XD	8.30		10	131	87	74	40	
MGPC2-0840-7XD	8.40		10	131	87	74	40	



MGPC2-0850-7XD	8.50		10	131	87	74	40	
MGPC2-0860-7XD	8.60	3/8-24 UNF	10	131	87	74	40	
MGPC2-0870-7XD	8.70	M10	10	131	87	73	40	
MGPC2-0880-7XD	8.80		10	131	87	73	40	
MGPC2-0890-7XD	8.90	MF10x1.25	10	131	87	73	40	
MGPC2-0900-7XD	9.00		10	131	87	73	40	
MGPC2-0910-7XD	9.10		10	139	95	81	40	
MGPC2-0920-7XD	9.20		10	139	95	81	40	
MGPC2-0930-7XD	9.30		10	139	95	81	40	
MGPC2-0940-7XD	9.40		10	139	95	80	40	
MGPC2-0950-7XD	9.50		10	139	95	80	40	
MGPC2-0960-7XD	9.60		10	139	95	80	40	
MGPC2-0970-7XD	9.70		10	139	95	80	40	
MGPC2-0980-7XD	9.70		10	139	95	80	40	
MGPC2-0990-7XD	9.90		10	139	95	80	40	



MGPC2-1000-7XD	10.00	7/16-20 UNF	12	155	106	91	45	
MGPC2-1010-7XD	10.10		12	155	106	90	45	
MGPC2-1020-7XD	10.20		12	155	106	90	45	
MGPC2-1030-7XD	10.30		12	155	106	90	45	
MGPC2-1040-7XD	10.40	M12	12	155	106	90	45	
MGPC2-1050-7XD	10.50		12	155	106	90	45	
MGPC2-1060-7XD	10.60		12	155	106	90	45	
MGPC2-1070-7XD	10.70	MF12x1.5	12	155	106	89	45	

## SPEED & FEED

Tool Diameter									
inch	0.125	0.188	0.25	0.313	0.375	0.5	0.625	0.75	
mm	3.0	4.0	6.0	8.0	10.0	12.0	16.0	20.0	

Low Carbon Steels, Long Chipping	Tensile Strength RM (MPa): <530	Hardness (HB) or HRC: <125
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Cutting Speed	Min.	Start	Max	Feed Rate by Diameter									
					IPR	.003-.005	.003-.006	.004-.007	.005-.011	.006-.013	.007-.015	.007-.017	.009-.019
<b>SFM</b>	Solid	225	355	485	IPR	.003-.005	.003-.006	.004-.007	.005-.011	.006-.013	.007-.015	.007-.017	.009-.019
<b>SFM</b>	Thru-Coolant	425	785	945	IPR	.003-.007	.004-.008	.006-.013	.006-.013	.007-.015	.008-.015	.009-.019	.010-.022

Low Carbon Steels, Free Machining and Short Chipping	Content C <.25%	Tensile Strength RM (MPa): <650	Hardness (HB) or HRC: <220
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Cutting Speed	Min.	Start	Max	Feed Rate by Diameter									
					IPR	.003-.005	.003-.006	.004-.007	.005-.011	.006-.013	.007-.015	.007-.017	.009-.019
<b>SFM</b>	Solid	290	380	500	IPR	.003-.005	.003-.006	.004-.007	.005-.011	.006-.013	.007-.015	.007-.017	.009-.019
<b>SFM</b>	Thru-Coolant	600	720	875	IPR	.003-.007	.004-.008	.006-.013	.006-.013	.007-.015	.008-.015	.009-.019	.010-.022

Low Alloyed	Content <.25%	Tensile Strength RM (MPa): 600-850	Hardness (HB) or HRC: <330
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Cutting Speed	Min.	Start	Max	Feed Rate by Diameter									
					IPR	.004-.006	.004-.008	.005-.009	.006-.011	.007-.013	.008-.015	.010-.017	.011-.019
<b>SFM</b>	Solid	200	290	375	IPR	.004-.006	.004-.008	.005-.009	.006-.011	.007-.013	.008-.015	.010-.017	.011-.019
<b>SFM</b>	Thru-Coolant	425	500	600	IPR	.003-.007	.004-.008	.006-.013	.006-.013	.007-.015	.008-.015	.009-.019	.010-.022

Tool Steels	Content C >.25%	Tensile Strength RM (MPa): 800-1100	Hardness (HB) or HRC: 350-450
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Cutting Speed	Min.	Start	Max	Feed Rate by Diameter									
					IPR	.003-.006	.004-.007	.004-.007	.006-.011	.006-.012	.007-.014	.008-.016	.009-.018
<b>SFM</b>	Solid	150	250	375	IPR	.003-.006	.004-.007	.004-.007	.006-.011	.006-.012	.007-.014	.008-.016	.009-.018
<b>SFM</b>	Thru-Coolant	350	475	550	IPR	.003-.007	.004-.008	.006-.013	.006-.013	.007-.015	.008-.015	.009-.019	.010-.022

Austenitic Stainless Steel	Tensile Strength RM (MPa): <650	Hardness (HB) or HRC: 130 - 200
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Cutting Speed	Min.	Start	Max	Feed Rate by Diameter									
					IPR	.003-.005	.003-.006	.004-.007	.005-.011	.006-.013	.007-.015	.007-.017	.009-.019
<b>SFM</b>	Solid	95	125	150	IPR	.003-.005	.003-.006	.004-.007	.005-.011	.006-.013	.007-.015	.007-.017	.009-.019
<b>SFM</b>	Thru-Coolant	190	250	300	IPR	.001-.003	.002-.005	.003-.007	.004-.008	.005-.008	.005-.009	.006-.010	.007-.011

High Strength Austenitic Stainless & Cast Stainless	Content C = .05%-.15%	Tensile Strength RM (Mpa):500-700	Hardness (HB) or HRC:150-230
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Cutting Speed	Min.	Start	Max	Feed Rate by Diameter									
					IPR	.003-.005	.003-.006	.004-.007	.005-.011	.006-.013	.007-.015	.007-.017	.009-.019
<b>SFM</b>	Solid	75	125	130	IPR	.003-.005	.003-.006	.004-.007	.005-.011	.006-.013	.007-.015	.007-.017	.009-.019
<b>SFM</b>	Thru-Coolant	150	250	260	IPR	.001-.003	.002-.005	.003-.007	.004-.008	.005-.008	.005-.009	.006-.010	.007-.011

Duplex Steel	Content C = .05-.2%	Tensile Strength RM (Mpa) < 900	Hardness (HP) or HRC: 135-275
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Cutting Speed	Min.	Start	Max	Feed Rate by Diameter									
					IPR	.004-.006	.004-.008	.005-.009	.006-.011	.007-.013	.008-.015	.010-.017	.011-.019
<b>SFM</b>	Solid	60	85	110	IPR	.004-.006	.004-.008	.005-.009	.006-.011	.007-.013	.008-.015	.010-.017	.011-.019
<b>SFM</b>	Thru-Coolant	120	190	220	IPR	.001-.003	.002-.005	.003-.007	.004-.008	.005-.008	.005-.009	.006-.010	.007-.011

2-Flute	Cast and Low-Strength Ductile Irons	Tensile Strength RM (MPa): 150-400	Hardness (HB) or HRC: 12-290
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Cutting Speed	Min.	Start	Max	Feed Rate by Diameter									
					IPR	.003-.005	.006-.008	.008-.011	.010-.014	.011-.016	.013-.017	.014-.02	.016-.021
<b>SFM</b>	Solid	225	355	485	IPR	.003-.005	.006-.008	.008-.011	.010-.014	.011-.016	.013-.017	.014-.02	.016-.021
<b>SFM</b>	Thru-Coolant	390	520	650	IPR	.003-.005	.006-.008	.008-.011	.010-.014	.011-.016	.013-.017	.014-.02	.016-.021

Low and Medium Strength CGI and Ductile Irons	Tensile Strength RM (MPa): 400-600	Hardness (HB) or HRC:130-260
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Cutting Speed	Min.	Start	Max	Feed Rate by Diameter								
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<b>SFM</b>	Solid	230	300	400	<b>IPR</b>	.003-.004	.005-.007	.007-.01	.009-.012	.010-.014	.012-.016	.013-.018	.015-.028
<b>SFM</b>	Thru-Coolant	260	395	525	<b>IPR</b>	.003-.004	.005-.007	.007-.01	.009-.012	.010-.014	.012-.016	.013-.018	.015-.028
<b>Normalized Ductile Iron</b>		Tensile Strength RM (MPa): 600-850			Hardness (HB) or HRC: 180-350								
Cutting Speed					Feed Rate by Diameter								
<b>SFM</b>	Solid	200	290	375	<b>IPR</b>	.003-.004	.004-.006	.006-.018	.007-.010	.009-.012	.009-.013	.011-.015	.012-.016
<b>SFM</b>	Thru-Coolant	200	265	400	<b>IPR</b>	.003-.004	.004-.006	.006-.018	.007-.010	.009-.012	.009-.013	.011-.015	.012-.016
<b>3-Flute</b>		<b>Wrought Aluminum Alloys</b>											
Cutting Speed	Min. Start Max			Feed Rate by Diameter									
<b>SFM</b>	Solid /Coolant	320	700	1300	<b>IPR</b>	.003-.007	.004-.008	.007-.013	.008-.015	.010-.017	.013-.020	.017-.023	.025-.031
<b>Cast Aluminum</b>													
Cutting Speed					Feed Rate by Diameter								
<b>SFM</b>	Solid /Coolant	320	650	800	<b>IPR</b>	.003-.007	.004-.008	.007-.013	.008-.015	.010-.017	.013-.020	.017-.023	.025-.031
<b>Copper and Copper Alloys</b>													
Cutting Speed					Feed Rate by Diameter								
<b>SFM</b>	Solid /Coolant	200	570	700	<b>IPR</b>	.003-.007	.004-.008	.007-.013	.008-.015	.010-.017	.013-.020	.017-.023	.025-.031
<b>2-Flute</b>		<b>Iron-Based, Heat-Resistant Alloys</b>			Tensile Strength RM (MPa)*: 500-1200				Hardness (Hb) or HRC: 160-260				
Cutting Speed	Min. Start Max			Feed Rate by Diameter									
<b>SFM</b>	Thru-Coolant	60	75	100	<b>IPR</b>	.001-.003	.002-.004	.002-.004	.002-.004	0.003-.005	.004-.006	.005-.007	.006-.008
<b>Nickel-Based or Cobalt-Based, Heat-Resistant Alloys</b>		Tensile Strength RM (MPa)8: 1000-1450			Hardness (Hb) or HRC: 250-450								
Cutting Speed					Feed Rate by Diameter								
<b>SFM</b>	Thru-Coolant	30	50	70	<b>IPR</b>	.001-.003	.002-.004	.002-.004	.002-.004	0.003-.005	.004-.006	.005-.007	.006-.008
<b>Titanium Alloys</b>		Tensile Strength RM (MPa): 600-850			Hardness (HB) or HRC: 180-350								
Cutting Speed					Feed Rate by Diameter								
<b>SFM</b>	Thru-Coolant	70	110	150	<b>IPR</b>	.001-.002	.001-.002	.002-.003	.002-.003	.003-.004	.003-.004	.004-.005	.004-.005

Cutting Speed				Tool Diameter								
				inch	0.125	0.188	0.25	0.313	0.375	0.5	0.625	0.75
				mm	3.0	4.0	6.0	8.0	10.0	12.0	16.0	20.0
<b>Low Carbon Steels, Long Chipping</b>				Tensile Strength RM (MPa): <530					Hardness (HB) or HRC: <125			
Min. Start Max				Feed Rate by Diameter								
SFM	450	700	780	IPR	.003-.007	.004-.008	.004-.009	.006-.012	.006-.014	.007-.015	.008-.018	.009-.020
<b>Low Carbon Steels, Free Machining and Short Chipping</b>				Content C <.25%		Tensile Strength RM (MPa): <650			Hardness (HB) or HRC: <220			
				Feed Rate by Diameter								
SFM	550	680	780	IPR	.003-.006	.004-.007	.004-.008	.006-.009	.006-.011	.007-.013	.008-.015	.009-.017
<b>Medium &amp; High Plain-Carbon Steels, Low Alloyed</b>				Content <.25%		Tensile Strength RM (MPa): 600-850			Hardness (HB) or HRC: <330			
				Feed Rate by Diameter								
SFM	380	480	590	IPR	.004-.007	.005-.008	.006-.009	.007-.012	.008-.014	.009-.015	.010-.018	.011-.020
<b>Alloyed and Tempered Carbon Steels, Tool Steels</b>				Content >.25%		Tensile Strength RM (MPa): 800-1100						
				Feed Rate by Diameter								
SFM	320	450	590	IPR	.003-.007	.004-.008	.005-.009	.006-.011	.007-.013	.007-.015	.009-.017	.010-.018
<b>High Strength Ferritic, Martensitic, and PH Stainless Steels</b>				Content C .1%-.6%		Tensile Strength RM (MPa): 900-1350						
				Feed Rate by Diameter								
SFM	250	320	500	IPR	.003-.005	.004-.006	.004-.007	.005-.008	.006-.009	.007-.011	.007-.013	.008-.014
<b>Malleable Cast Iron</b>												
				Feed Rate by Diameter								
SFM	450	500	600	IPR	.004-.007	.005-.009	.005-.010	.006-.013	.007-.015	.008-.016	.009-.019	.011-.020
<b>Grey Cast Iron</b>												
				Feed Rate by Diameter								
SFM	320	480	650	IPR	.004-.006	.005-.007	.005-.009	.006-.011	.007-.013	.008-.014	.009-.016	.011-.018
<b>Nodular Cast Iron</b>												
				Feed Rate by Diameter								
SFM	320	425	550	IPR	.003-.006	.004-.007	.005-.008	.006-.009	.006-.011	.007-.013	.008-.015	.009-.015