

## Drilling Feed & Speed Chart for

### PTFE – TEFLON<sup>®</sup> - DUROID<sup>®</sup> PCB Material Back Panel Format

(Panel Thickness > 0.200-inch) TEFLON<sup>®</sup> is a registered trademark of DuPont; DUROID<sup>®</sup> is a registered trademark of Rogers Corp.

**Recommended Tycom Drill Series: Series 100, 150, 480, 490**

(Note: Chart is based on 120K RPM Spindle Capability. Please use maximum spindle speed if listed RPM is unattainable)

| Size   | Diameter | Feed         | Speed   | Retract      | Z-Axis Offset | Max Hits | Chipload   | SFM |
|--------|----------|--------------|---------|--------------|---------------|----------|------------|-----|
|        | (inch)   | (Inches/min) | (k-rpm) | (inches/min) | (inches)      |          | (mils/rev) |     |
| 0.25mm | 0.0098   | 77           | 120     | 250          | -0.012        | 150      | 0.64       | 308 |
| #87    | 0.0100   | 77           | 120     | 350          | -0.012        | 150      | 0.64       | 314 |
| #86    | 0.0105   | 83           | 120     | 400          | -0.012        | 150      | 0.69       | 330 |
| #85    | 0.0110   | 89           | 120     | 400          | -0.013        | 150      | 0.74       | 345 |
| #84    | 0.0115   | 96           | 116     | 400          | -0.013        | 150      | 0.83       | 350 |
| 0.30mm | 0.0118   | 100          | 113     | 500          | -0.013        | 150      | 0.88       | 350 |
| #83    | 0.0120   | 102          | 111     | 500          | -0.013        | 150      | 0.92       | 350 |
| #82    | 0.0125   | 109          | 107     | 500          | -0.013        | 150      | 1.02       | 350 |
| #81    | 0.0130   | 115          | 103     | 500          | -0.013        | 150      | 1.12       | 350 |
| #80    | 0.0135   | 121          | 99      | 500          | -0.013        | 200      | 1.22       | 350 |
| 0.35mm | 0.0138   | 124          | 97      | 600          | -0.013        | 200      | 1.28       | 350 |
| #79    | 0.0145   | 128          | 92      | 600          | -0.013        | 200      | 1.39       | 350 |
| 1/64   | 0.0156   | 128          | 86      | 600          | -0.014        | 200      | 1.49       | 350 |
| 0.40mm | 0.0158   | 128          | 85      | 600          | -0.014        | 200      | 1.51       | 350 |
| #78    | 0.0160   | 128          | 84      | 700          | -0.014        | 200      | 1.52       | 350 |
| 0.45mm | 0.0177   | 130          | 76      | 700          | -0.014        | 200      | 1.71       | 350 |
| #77    | 0.0180   | 132          | 74      | 700          | -0.014        | 200      | 1.78       | 350 |
| 0.50mm | 0.0197   | 132          | 68      | 700          | -0.015        | 200      | 1.94       | 350 |
| #76    | 0.0200   | 132          | 67      | 800          | -0.015        | 200      | 1.97       | 350 |
| #75    | 0.0210   | 132          | 64      | 800          | -0.015        | 250      | 2.06       | 350 |
| 0.55mm | 0.0217   | 132          | 62      | 800          | -0.015        | 250      | 2.13       | 350 |
| #74    | 0.0225   | 132          | 59      | 800          | -0.015        | 250      | 2.24       | 350 |
| 0.60mm | 0.0236   | 133          | 57      | 800          | -0.016        | 250      | 2.33       | 350 |
| #73    | 0.0240   | 133          | 56      | 900          | -0.016        | 250      | 2.38       | 350 |
| #72    | 0.0250   | 133          | 54      | 900          | -0.016        | 250      | 2.46       | 350 |
| 0.65mm | 0.0256   | 133          | 52      | 900          | -0.016        | 250      | 2.56       | 350 |
| #71    | 0.0260   | 133          | 51      | 1000         | -0.016        | 250      | 2.61       | 350 |
| 0.70mm | 0.0276   | 132          | 48      | 1000         | -0.016        | 250      | 2.75       | 350 |
| #70    | 0.0280   | 132          | 48      | 1000         | -0.017        | 250      | 2.75       | 350 |
| #69    | 0.0292   | 130          | 46      | 1000         | -0.017        | 300      | 2.83       | 350 |
| 0.75mm | 0.0295   | 130          | 45      | 1000         | -0.017        | 300      | 2.89       | 350 |
| #68    | 0.0310   | 130          | 43      | 1000         | -0.017        | 300      | 3.02       | 350 |
| 1/32   | 0.0312   | 129          | 43      | 1000         | -0.017        | 300      | 3.00       | 350 |
| 0.80mm | 0.0315   | 129          | 42      | 1000         | -0.017        | 300      | 3.07       | 350 |
| #67    | 0.0320   | 128          | 42      | 1000         | -0.017        | 300      | 3.05       | 350 |
| #66    | 0.0330   | 128          | 41      | 1000         | -0.018        | 300      | 3.12       | 350 |

| Size   | Diameter | Feed         | Speed   | Retract      | Z-Axis Offset | Hits | Chipload   | SFM |
|--------|----------|--------------|---------|--------------|---------------|------|------------|-----|
|        | (inch)   | (Inches/min) | (k-rpm) | (inches/min) | (inches)      |      | (mils/rev) |     |
| 0.85mm | 0.0335   | 126          | 40      | 1000         | -0.018        | 300  | 3.15       | 350 |
| #65    | 0.0350   | 125          | 38      | 1000         | -0.018        | 300  | 3.29       | 350 |
| 0.90mm | 0.0354   | 125          | 38      | 1000         | -0.018        | 300  | 3.29       | 350 |
| #64    | 0.0360   | 124          | 37      | 1000         | -0.018        | 300  | 3.35       | 350 |
| #63    | 0.0370   | 123          | 36      | 1000         | -0.019        | 300  | 3.42       | 350 |
| 0.95mm | 0.0374   | 121          | 36      | 1000         | -0.019        | 300  | 3.36       | 350 |
| #62    | 0.0380   | 121          | 35      | 1000         | -0.019        | 300  | 3.46       | 350 |
| #61    | 0.0390   | 120          | 34      | 1000         | -0.019        | 300  | 3.53       | 350 |
| 1.00mm | 0.0394   | 120          | 34      | 1000         | -0.019        | 300  | 3.53       | 350 |
| #60    | 0.0400   | 120          | 33      | 1000         | -0.019        | 300  | 3.64       | 350 |
| #59    | 0.0410   | 119          | 33      | 1000         | -0.020        | 300  | 3.61       | 350 |
| 1.05mm | 0.0413   | 119          | 32      | 1000         | -0.020        | 300  | 3.72       | 350 |
| #58    | 0.0420   | 117          | 32      | 1000         | -0.020        | 300  | 3.66       | 350 |
| #57    | 0.0430   | 117          | 31      | 1000         | -0.020        | 300  | 3.77       | 350 |
| 1.10mm | 0.0433   | 117          | 31      | 1000         | -0.020        | 300  | 3.77       | 350 |
| 1.15mm | 0.0453   | 116          | 30      | 1000         | -0.021        | 300  | 3.87       | 350 |
| #56    | 0.0465   | 115          | 29      | 1000         | -0.021        | 300  | 3.97       | 350 |
| 3/64   | 0.0469   | 115          | 29      | 1000         | -0.021        | 300  | 3.97       | 350 |
| 1.20mm | 0.0472   | 115          | 28      | 1000         | -0.021        | 300  | 4.11       | 350 |
| 1.25mm | 0.0492   | 114          | 27      | 1000         | -0.021        | 300  | 4.22       | 350 |
| 1.30mm | 0.0512   | 109          | 26      | 1000         | -0.022        | 300  | 2.50       | 350 |
| #55    | 0.0520   | 109          | 26      | 1000         | -0.022        | 300  | 2.50       | 350 |
| 1.35mm | 0.0531   | 106          | 25      | 1000         | -0.022        | 300  | 2.50       | 350 |
| #54    | 0.0550   | 102          | 24      | 1000         | -0.023        | 300  | 2.50       | 350 |
| 1.40mm | 0.0551   | 102          | 24      | 1000         | -0.023        | 300  | 2.50       | 350 |
| 1.45mm | 0.0571   | 100          | 23      | 1000         | -0.023        | 300  | 4.35       | 350 |
| 1.50mm | 0.0591   | 96           | 23      | 1000         | -0.024        | 300  | 4.17       | 350 |
| #53    | 0.0595   | 93           | 22      | 1000         | -0.024        | 300  | 4.23       | 350 |
| 1.55mm | 0.0610   | 93           | 22      | 1000         | -0.024        | 300  | 4.23       | 350 |
| 1/16   | 0.0625   | 89           | 21      | 1000         | -0.025        | 300  | 4.24       | 350 |
| 1.60mm | 0.0630   | 89           | 21      | 1000         | -0.025        | 300  | 4.24       | 350 |
| #52    | 0.0635   | 89           | 21      | 1000         | -0.025        | 300  | 4.24       | 350 |
| 1.65mm | 0.0650   | 87           | 21      | 1000         | -0.025        | 300  | 4.14       | 350 |
| 1.70mm | 0.0669   | 83           | 20      | 1000         | -0.026        | 300  | 4.15       | 350 |
| #51    | 0.0670   | 83           | 20      | 1000         | -0.026        | 300  | 4.15       | 350 |
| 1.75mm | 0.0689   | 80           | 20      | 1000         | -0.026        | 300  | 4.00       | 361 |
| #50    | 0.0700   | 80           | 20      | 1000         | -0.026        | 250  | 4.00       | 366 |
| 1.80mm | 0.0709   | 80           | 20      | 1000         | -0.027        | 250  | 4.00       | 371 |
| 1.85mm | 0.0728   | 77           | 20      | 1000         | -0.027        | 250  | 3.85       | 381 |
| #49    | 0.0730   | 77           | 20      | 1000         | -0.027        | 250  | 3.85       | 382 |
| 1.90mm | 0.0748   | 74           | 20      | 1000         | -0.027        | 250  | 3.70       | 391 |
| #48    | 0.0760   | 74           | 20      | 1000         | -0.028        | 250  | 3.70       | 398 |
| 1.95mm | 0.0768   | 74           | 20      | 1000         | -0.028        | 250  | 3.70       | 402 |
| 5/64   | 0.0781   | 70           | 20      | 1000         | -0.028        | 250  | 3.50       | 409 |
| #47    | 0.0785   | 70           | 20      | 1000         | -0.028        | 250  | 3.50       | 411 |
| 2.00mm | 0.0787   | 70           | 20      | 1000         | -0.028        | 250  | 3.50       | 412 |
| 2.05mm | 0.0807   | 70           | 20      | 1000         | -0.029        | 250  | 3.50       | 422 |
| #46    | 0.0810   | 68           | 20      | 1000         | -0.029        | 250  | 3.40       | 424 |
|        |          |              |         |              |               |      |            |     |

| Size   | Diameter | Feed         | Speed   | Retract      | Z-Axis Offset | Hits | Chipload   | SFM |
|--------|----------|--------------|---------|--------------|---------------|------|------------|-----|
|        | (inch)   | (Inches/min) | (k-rpm) | (inches/min) | (inches)      |      | (mils/rev) |     |
| #45    | 0.0820   | 68           | 20      | 1000         | -0.029        | 250  | 3.40       | 429 |
| 2.10mm | 0.0827   | 68           | 20      | 1000         | -0.029        | 250  | 3.40       | 433 |
| 2.15mm | 0.0846   | 68           | 20      | 1000         | -0.030        | 250  | 3.40       | 443 |
| #44    | 0.0860   | 64           | 20      | 1000         | -0.030        | 250  | 3.20       | 450 |
| 2.20mm | 0.0866   | 64           | 20      | 1000         | -0.030        | 250  | 3.20       | 453 |
| 2.25mm | 0.0886   | 64           | 20      | 1000         | -0.031        | 250  | 3.20       | 464 |
| #43    | 0.0890   | 64           | 20      | 1000         | -0.031        | 250  | 3.20       | 466 |
| 2.30mm | 0.0906   | 64           | 20      | 1000         | -0.031        | 250  | 3.20       | 474 |
| 2.35mm | 0.0925   | 64           | 20      | 1000         | -0.032        | 250  | 3.20       | 484 |
| #42    | 0.0935   | 64           | 20      | 1000         | -0.032        | 250  | 3.20       | 489 |
| 3/32   | 0.0938   | 64           | 20      | 1000         | -0.032        | 250  | 3.20       | 491 |
| 2.40mm | 0.0945   | 64           | 20      | 1000         | -0.032        | 250  | 3.20       | 495 |
| #41    | 0.0960   | 64           | 20      | 1000         | -0.032        | 250  | 3.20       | 502 |
| 2.45mm | 0.0965   | 64           | 20      | 1000         | -0.033        | 250  | 3.20       | 505 |
| #40    | 0.0980   | 64           | 20      | 1000         | -0.033        | 250  | 3.20       | 513 |
| 2.50mm | 0.0984   | 64           | 20      | 1000         | -0.033        | 250  | 3.20       | 515 |
| #39    | 0.0995   | 64           | 20      | 1000         | -0.033        | 250  | 3.20       | 521 |
| 2.55mm | 0.1004   | 64           | 20      | 1000         | -0.033        | 200  | 3.20       | 525 |
| #38    | 0.1015   | 64           | 20      | 1000         | -0.034        | 200  | 3.20       | 531 |
| 2.60mm | 0.1024   | 64           | 20      | 1000         | -0.034        | 200  | 3.20       | 536 |
| #37    | 0.1040   | 64           | 20      | 1000         | -0.034        | 200  | 3.20       | 544 |
| 2.65mm | 0.1043   | 64           | 20      | 1000         | -0.034        | 200  | 3.20       | 546 |
| 2.70mm | 0.1063   | 64           | 20      | 1000         | -0.035        | 200  | 3.20       | 556 |
| #36    | 0.1065   | 64           | 20      | 1000         | -0.035        | 200  | 3.20       | 557 |
| 2.75mm | 0.1083   | 64           | 20      | 1000         | -0.035        | 200  | 3.20       | 567 |
| 7/64   | 0.1094   | 64           | 20      | 1000         | -0.036        | 200  | 3.20       | 573 |
| #35    | 0.1100   | 64           | 20      | 1000         | -0.036        | 200  | 3.20       | 576 |
| 2.80mm | 0.1102   | 64           | 20      | 1000         | -0.036        | 200  | 3.20       | 577 |
| #34    | 0.1110   | 64           | 20      | 1000         | -0.036        | 200  | 3.20       | 581 |
| 2.85mm | 0.1122   | 64           | 20      | 1000         | -0.036        | 200  | 3.20       | 587 |
| #33    | 0.1130   | 64           | 20      | 1000         | -0.036        | 200  | 3.20       | 591 |
| 2.90mm | 0.1142   | 64           | 20      | 1000         | -0.037        | 200  | 3.20       | 598 |
| #32    | 0.1160   | 64           | 20      | 1000         | -0.037        | 200  | 3.20       | 607 |
| 2.95mm | 0.1161   | 64           | 20      | 1000         | -0.037        | 200  | 3.20       | 608 |
| 3.00mm | 0.1181   | 64           | 20      | 1000         | -0.038        | 200  | 3.20       | 618 |
| #31    | 0.1200   | 64           | 20      | 1000         | -0.038        | 200  | 3.20       | 628 |
| 3.05mm | 0.1201   | 64           | 20      | 1000         | -0.038        | 200  | 3.20       | 629 |
| 3.10mm | 0.1220   | 64           | 20      | 1000         | -0.038        | 200  | 3.20       | 638 |
| 3.15mm | 0.1240   | 64           | 20      | 1000         | -0.039        | 200  | 3.20       | 649 |
| 1/8    | 0.1250   | 64           | 20      | 1000         | -0.039        | 200  | 3.20       | 654 |
| 3.20mm | 0.1260   | 61           | 20      | 1000         | -0.018        | 150  | 3.05       | 659 |
| 3.25mm | 0.1280   | 61           | 20      | 1000         | -0.018        | 150  | 3.05       | 670 |
| #30    | 0.1285   | 61           | 20      | 1000         | -0.019        | 150  | 3.05       | 672 |
| 3.30mm | 0.1299   | 61           | 20      | 1000         | -0.019        | 150  | 3.05       | 680 |
| 3.35mm | 0.1319   | 61           | 20      | 1000         | -0.019        | 150  | 3.05       | 690 |
| 3.40mm | 0.1339   | 61           | 20      | 1000         | -0.019        | 150  | 3.05       | 701 |
| 3.45mm | 0.1358   | 61           | 20      | 1000         | -0.019        | 150  | 3.05       | 711 |
| #29    | 0.1360   | 61           | 20      | 1000         | -0.019        | 150  | 3.05       | 712 |
|        |          |              |         |              |               |      |            |     |

| Size   | Diameter | Feed         | Speed   | Retract      | Z-Axis Offset | Hits | Chipload   | SFM |
|--------|----------|--------------|---------|--------------|---------------|------|------------|-----|
|        | (inch)   | (Inches/min) | (k-rpm) | (inches/min) | (inches)      |      | (mils/rev) |     |
| 3.50mm | 0.1378   | 61           | 20      | 1000         | -0.019        | 150  | 3.05       | 721 |
| 3.55mm | 0.1398   | 61           | 20      | 1000         | -0.019        | 150  | 3.05       | 732 |
| #28    | 0.1405   | 57           | 20      | 1000         | -0.019        | 150  | 2.85       | 735 |
| 9/64   | 0.1406   | 57           | 20      | 1000         | -0.019        | 150  | 2.85       | 736 |
| 3.60mm | 0.1417   | 57           | 20      | 1000         | -0.019        | 150  | 2.85       | 742 |
| 3.65mm | 0.1437   | 57           | 20      | 1000         | -0.020        | 150  | 2.85       | 752 |
| #27    | 0.1440   | 57           | 20      | 1000         | -0.020        | 150  | 2.85       | 754 |
| 3.70mm | 0.1457   | 57           | 20      | 1000         | -0.020        | 150  | 2.85       | 762 |
| #26    | 0.1470   | 51           | 20      | 1000         | -0.020        | 150  | 2.55       | 769 |
| 3.75mm | 0.1476   | 51           | 20      | 1000         | -0.020        | 150  | 2.55       | 772 |
| #25    | 0.1495   | 51           | 20      | 1000         | -0.020        | 150  | 2.55       | 782 |
| 3.80mm | 0.1496   | 51           | 20      | 1000         | -0.020        | 150  | 2.55       | 783 |
| 3.85mm | 0.1516   | 51           | 20      | 1000         | -0.020        | 150  | 2.55       | 793 |
| #24    | 0.1520   | 51           | 20      | 1000         | -0.020        | 150  | 2.55       | 795 |
| 3.90mm | 0.1535   | 51           | 20      | 1000         | -0.020        | 150  | 2.55       | 803 |
| #23    | 0.1540   | 51           | 20      | 1000         | -0.020        | 150  | 2.55       | 806 |
| 3.95   | 0.1555   | 51           | 20      | 1000         | -0.020        | 150  | 2.55       | 814 |
| 5/32   | 0.1562   | 51           | 20      | 1000         | -0.020        | 150  | 2.55       | 817 |
| #22    | 0.1570   | 51           | 20      | 1000         | -0.020        | 150  | 2.55       | 822 |
| 4.00mm | 0.1575   | 51           | 20      | 1000         | -0.020        | 150  | 2.55       | 824 |
| #21    | 0.1590   | 45           | 20      | 1000         | -0.021        | 125  | 2.25       | 832 |
| 4.05mm | 0.1594   | 45           | 20      | 1000         | -0.021        | 125  | 2.25       | 834 |
| #20    | 0.1610   | 45           | 20      | 1000         | -0.021        | 125  | 2.25       | 843 |
| 4.10mm | 0.1614   | 45           | 20      | 1000         | -0.021        | 125  | 2.25       | 845 |
| 4.15mm | 0.1634   | 45           | 20      | 1000         | -0.021        | 125  | 2.25       | 855 |
| 4.20mm | 0.1654   | 45           | 20      | 1000         | -0.021        | 125  | 2.25       | 866 |
| #19    | 0.1660   | 45           | 20      | 1000         | -0.021        | 125  | 2.25       | 869 |
| 4.25mm | 0.1673   | 45           | 20      | 1000         | -0.021        | 125  | 2.25       | 876 |
| 4.30mm | 0.1693   | 45           | 20      | 1000         | -0.021        | 125  | 2.25       | 886 |
| #18    | 0.1695   | 45           | 20      | 1000         | -0.021        | 125  | 2.25       | 887 |
| 4.35mm | 0.1713   | 38           | 20      | 1000         | -0.021        | 125  | 1.90       | 896 |
| 11/64  | 0.1719   | 38           | 20      | 1000         | -0.021        | 125  | 1.90       | 900 |
| #17    | 0.1730   | 38           | 20      | 1000         | -0.021        | 125  | 1.90       | 905 |
| 4.40mm | 0.1732   | 38           | 20      | 1000         | -0.021        | 125  | 1.90       | 906 |
| 4.45mm | 0.1752   | 38           | 20      | 1000         | -0.022        | 125  | 1.90       | 917 |
| #16    | 0.1770   | 38           | 20      | 1000         | -0.022        | 125  | 1.90       | 926 |
| 4.50mm | 0.1772   | 38           | 20      | 1000         | -0.022        | 125  | 1.90       | 927 |
| 4.55mm | 0.1792   | 38           | 20      | 1000         | -0.022        | 125  | 1.90       | 938 |
| #15    | 0.1800   | 38           | 20      | 1000         | -0.022        | 125  | 1.90       | 942 |
| 4.60mm | 0.1811   | 38           | 20      | 1000         | -0.022        | 125  | 1.90       | 948 |
| #14    | 0.1820   | 38           | 20      | 1000         | -0.022        | 125  | 1.90       | 952 |
| 4.65mm | 0.1831   | 38           | 20      | 1000         | -0.022        | 125  | 1.90       | 958 |
| #13    | 0.1850   | 38           | 20      | 1000         | -0.022        | 125  | 1.90       | 968 |
| 4.70mm | 0.1850   | 38           | 20      | 1000         | -0.022        | 125  | 1.90       | 968 |
| 4.75mm | 0.1870   | 38           | 20      | 1000         | -0.022        | 100  | 1.90       | 979 |
| 3/16   | 0.1875   | 38           | 20      | 1000         | -0.022        | 100  | 1.90       | 981 |
| 4.80mm | 0.1890   | 38           | 20      | 1000         | -0.023        | 100  | 1.90       | 989 |
| #12    | 0.1890   | 32           | 20      | 1000         | -0.023        | 100  | 1.60       | 989 |
|        |          |              |         |              |               |      |            |     |

| Size   | Diameter | Feed | Speed | Retract | Z-Axis Offset | Hits | Chipload | SFM  |
|--------|----------|------|-------|---------|---------------|------|----------|------|
| 4.85mm | 0.1909   | 32   | 20    | 1000    | -0.023        | 100  | 1.60     | 999  |
| #11    | 0.1910   | 32   | 20    | 1000    | -0.023        | 100  | 1.60     | 1000 |
| 4.90mm | 0.1929   | 32   | 20    | 1000    | -0.023        | 100  | 1.60     | 1010 |
| #10    | 0.1935   | 32   | 20    | 1000    | -0.023        | 100  | 1.60     | 1013 |
| 4.95mm | 0.1949   | 32   | 20    | 1000    | -0.023        | 100  | 1.60     | 1020 |
| #9     | 0.1960   | 32   | 20    | 1000    | -0.023        | 100  | 1.60     | 1026 |
| 5.00mm | 0.1968   | 32   | 20    | 1000    | -0.023        | 100  | 1.60     | 1030 |
| 5.05mm | 0.1988   | 32   | 20    | 1000    | -0.023        | 100  | 1.60     | 1040 |
| #8     | 0.1990   | 32   | 20    | 1000    | -0.023        | 100  | 1.60     | 1041 |
| 5.10mm | 0.2008   | 32   | 20    | 1000    | -0.023        | 100  | 1.60     | 1051 |
| #7     | 0.2010   | 32   | 20    | 1000    | -0.023        | 100  | 1.60     | 1052 |
| 5.15mm | 0.2028   | 32   | 20    | 1000    | -0.023        | 100  | 1.60     | 1061 |
| 13/64  | 0.2031   | 32   | 20    | 1000    | -0.023        | 100  | 1.60     | 1063 |
| #6     | 0.2040   | 32   | 20    | 1000    | -0.024        | 100  | 1.60     | 1068 |
| 5.20mm | 0.2047   | 32   | 20    | 1000    | -0.024        | 100  | 1.60     | 1071 |
| #5     | 0.2055   | 32   | 20    | 1000    | -0.024        | 100  | 1.60     | 1075 |
| 5.25mm | 0.2067   | 32   | 20    | 1000    | -0.024        | 100  | 1.60     | 1082 |
| 5.30mm | 0.2087   | 32   | 20    | 1000    | -0.024        | 100  | 1.60     | 1092 |
| #4     | 0.2090   | 32   | 20    | 1000    | -0.024        | 100  | 1.60     | 1094 |
| 5.35mm | 0.2106   | 32   | 20    | 1000    | -0.024        | 100  | 1.60     | 1102 |
| 5.40mm | 0.2126   | 26   | 20    | 1000    | -0.024        | 100  | 1.30     | 1113 |
| #3     | 0.2130   | 26   | 20    | 1000    | -0.024        | 100  | 1.30     | 1115 |
| 5.45mm | 0.2146   | 26   | 20    | 1000    | -0.024        | 100  | 1.30     | 1123 |
| 5.50mm | 0.2165   | 26   | 20    | 1000    | -0.024        | 100  | 1.30     | 1133 |
| 5.55mm | 0.2185   | 26   | 20    | 1000    | -0.024        | 100  | 1.30     | 1143 |
| 7/32   | 0.2188   | 26   | 20    | 1000    | -0.024        | 100  | 1.30     | 1145 |
| 5.60mm | 0.2205   | 26   | 20    | 1000    | -0.025        | 100  | 1.30     | 1154 |
| #2     | 0.2210   | 26   | 20    | 1000    | -0.025        | 100  | 1.30     | 1157 |
| 5.65mm | 0.2224   | 26   | 20    | 1000    | -0.025        | 100  | 1.30     | 1164 |
| 5.70mm | 0.2244   | 26   | 20    | 1000    | -0.025        | 100  | 1.30     | 1174 |
| 5.75mm | 0.2264   | 26   | 20    | 1000    | -0.025        | 100  | 1.30     | 1185 |
| #1     | 0.2280   | 26   | 20    | 1000    | -0.025        | 100  | 1.30     | 1193 |
| 5.80mm | 0.2283   | 26   | 20    | 1000    | -0.025        | 100  | 1.30     | 1195 |
| 5.85mm | 0.2302   | 26   | 20    | 1000    | -0.025        | 50   | 1.30     | 1205 |
| 5.90mm | 0.2323   | 26   | 20    | 1000    | -0.025        | 50   | 1.30     | 1216 |
| A      | 0.2340   | 26   | 20    | 1000    | -0.025        | 50   | 1.30     | 1225 |
| 5.95mm | 0.2343   | 26   | 20    | 1000    | -0.026        | 50   | 1.30     | 1226 |
| 15/64  | 0.2344   | 26   | 20    | 1000    | -0.026        | 50   | 1.30     | 1227 |
| 6.00mm | 0.2362   | 26   | 20    | 1000    | -0.026        | 50   | 1.30     | 1236 |
| B      | 0.2380   | 26   | 20    | 1000    | -0.026        | 50   | 1.30     | 1246 |
| 6.05mm | 0.2382   | 26   | 20    | 1000    | -0.026        | 50   | 1.30     | 1247 |
| 6.10mm | 0.2402   | 26   | 20    | 1000    | -0.026        | 50   | 1.30     | 1257 |
| C      | 0.2420   | 26   | 20    | 1000    | -0.026        | 50   | 1.30     | 1266 |
| 6.15mm | 0.2421   | 26   | 20    | 1000    | -0.026        | 50   | 1.30     | 1267 |
| 6.20mm | 0.2441   | 26   | 20    | 1000    | -0.026        | 50   | 1.30     | 1277 |
| D      | 0.2460   | 26   | 20    | 1000    | -0.026        | 50   | 1.30     | 1287 |
| 6.25mm | 0.2461   | 26   | 20    | 1000    | -0.026        | 50   | 1.30     | 1288 |
| 6.30mm | 0.2480   | 26   | 20    | 1000    | -0.026        | 50   | 1.30     | 1298 |
| 6.35mm | 0.2500   | 26   | 20    | 1000    | -0.027        | 50   | 1.30     | 1308 |
| 6.40mm | 0.2520   | 26   | 20    | 1000    | -0.027        | 50   | 1.30     | 1319 |

| Size   | Diameter | Feed | Speed | Retract | Z-Axis Offset | Hits | Chipload | SFM  |
|--------|----------|------|-------|---------|---------------|------|----------|------|
| 6.50mm | 0.2559   | 26   | 20    | 1000    | -0.027        | 50   | 1.30     | 1339 |
| F      | 0.2570   | 26   | 20    | 1000    | -0.027        | 50   | 1.30     | 1345 |
| 6.60mm | 0.2598   | 26   | 20    | 1000    | -0.027        | 50   | 1.30     | 1360 |
|        |          |      |       |         |               |      |          |      |

In some cases, there may be an opportunity to increase the chipload based on the application's robustness. Variables such as machine technology and condition, stack support materials, and Tycom design selection may allow the increased throughput with higher chiploads. Multiply the recommended chipload by 1.15 to reach the higher chipload.

If the application is not as robust due to heavy glass, high copper content, tight annular ring requirements, or similar, multiply the recommended chipload by 0.85.

