



17763 State Hwy 198 ❖

Saegertown, PA 16433 ❖

PH: (814) 763-2032 ❖

FAX: (814) 763-2521

www.Laser-Tool.com

DESIGNED FOR USE ON RIGID CNC MACHINING CENTERS

Recommended Feeds and Speeds

Drill Size ⇨	0.750	0.812	0.875	0.937	1.000	1.062	1.125	1.187	1.250	1.312	1.375	1.437	1.500	1.625	1.750	1.875	2.000	2.125		
	3/4	13/16	7/8	15/16	1	1 1/16	1 1/8	1 3/16	1 1/4	1 5/16	1 3/8	1 7/16	1 1/2	1 5/8	1 3/4	1 7/8	2	2 1/8		
Material ↓																				
Cold Roll	500	500	500	500	500	500	500	500	450	450	450	450	400	400	400	400	400	350	SFM	
	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.003	FEED	
Hot Roll	350	350	350	350	350	350	350	350	350	350	400	400	500	500	400	400	350	350	SFM	
	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	FEED	
S-7	300	300	300	300	300	300	300	300	350	350	350	400	450	450	500	500	500	500	SFM	
	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	FEED	
H-13	300	300	300	300	300	300	300	300	350	350	350	400	450	450	500	500	500	500	SFM	
	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	FEED	
O-1	300	300	300	300	300	300	300	300	350	350	350	400	450	450	500	500	500	500	SFM	
	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.002	0.002	0.002	FEED	
PreHard	300	300	250	250	250	250	300	300	300	300	350	350	400	400	400	350	350	350	SFM	
4140/4150	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.003	0.0025	0.0025	0.002	0.002	FEED	
Stainless Steel	250	250	250	250	250	250	300	300	300	300	300	300	300	350	350	350	375	375	SFM	
304/303	0.003	0.003	0.003	0.003	0.003	0.003	0.0025	0.0025	0.0025	0.0025	0.0025	0.0025	0.0025	0.002	0.002	0.002	0.002	0.002	FEED	
Stainless Steel	300	300	300	300	300	300	300	300	350	350	350	350	400	400	400	400	400	400	SFM	
416/420	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.0025	0.0025	0.002	0.002	0.002	0.002	0.002	0.002	FEED	
STAVAX	300	300	300	300	300	300	300	300	350	350	350	350	400	400	400	400	400	400	SFM	
	0.004	0.004	0.004	0.004	0.003	0.003	0.003	0.003	0.003	0.003	0.0025	0.0025	0.002	0.002	0.002	0.002	0.002	0.002	FEED	
Nickel, Bronze	350	350	350	350	350	350	400	400	400	400	400	400	450	450	475	500	500	500	SFM	
Aluminum	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.0025	0.002	0.002	0.002	FEED	
Brass	350	350	350	350	350	350	400	400	400	400	400	400	450	450	475	500	500	500	SFM	
	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.004	0.004	0.004	0.003	0.003	0.0025	0.002	0.002	0.002	FEED	
Aluminum	500	500	500	500	600	600	600	600	600	600	600	600	600	600	600	600	600	600	SFM	
6061/2024	0.006	0.006	0.006	0.006	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.005	0.004	0.004	0.004	0.003	0.003	FEED	