

N4000-6 / N4000-6 FC

TYPICAL DRILLING PARAMETERS

Typical Stack Height: .120" - .180"

DRILL SIZE	DRILL DIAM.	FEED IPM	SPEED RPM (k)	RETRACT IPM	SFM	MAX HITS	Z AXIS OFFSET	CHIPLOAD (mils)
0.10mm	0.0039	20	100.0	150	102	150	-0.004	0.20
97	0.0059	25	100.0	200	154	150	-0.006	0.25
96	0.0063	25	100.0	200	165	150	-0.006	0.25
95	0.0067	25	100.0	200	175	150	-0.007	0.25
94	0.0071	30	100.0	250	186	150	-0.007	0.30
93	0.0075	40	100.0	250	196	150	-0.008	0.40
92	0.0079	50	100.0	250	207	250	-0.008	0.50
0.20mm	0.0079	50	100.0	250	207	250	-0.008	0.50
91	0.0083	50	100.0	500	217	250	-0.008	0.50
90	0.0087	50	100.0	500	228	250	-0.009	0.50
89	0.0091	60	100.0	500	238	250	-0.009	0.60
88	0.0095	60	100.0	500	249	250	-0.010	0.60
0.25mm	0.0098	60	100.0	500	256	500	-0.010	0.60
87	0.0100	75	100.0	500	262	500	-0.010	0.75
86	0.0105	75	100.0	500	275	500	-0.011	0.75
85	0.0110	75	100.0	750	288	500	-0.011	0.75
84	0.0115	75	100.0	750	301	500	-0.012	0.75
0.30mm	0.0118	75	100.0	750	309	750	-0.012	0.75
83	0.0120	80	100.0	750	314	750	-0.012	0.80
82	0.0125	80	100.0	750	327	750	-0.013	0.80
81	0.0130	80	100.0	750	340	1000	-0.013	0.80
80	0.0135	95	100.0	1000	353	1000	-0.013	0.95
0.35mm	0.0138	95	100.0	1000	361	1000	-0.013	0.95
79	0.0145	100	100.0	1000	379	1000	-0.014	1.00
1/64"	0.0156	100	100.0	1000	408	1000	-0.014	1.00
0.40mm	0.0157	100	100.0	1000	411	1000	-0.015	1.00
78	0.0160	109	99.0	1000	414	1000	-0.016	1.10
0.45mm	0.0177	98	89.5	1000	415	1000	-0.017	1.10
77	0.0180	97	88.5	1000	417	1000	-0.018	1.10
0.50mm	0.0197	97	80.8	1000	417	1000	-0.019	1.20
76	0.0200	114	81.2	1000	425	1000	-0.020	1.40
75	0.0210	108	77.3	1000	425	1200	-0.021	1.40
0.55mm	0.0217	112	74.8	1000	425	1200	-0.021	1.50
74	0.0225	108	72.2	1000	425	1200	-0.022	1.50
0.60mm	0.0236	103	68.8	1000	425	1200	-0.024	1.50
73	0.0240	112	67.7	1000	425	1200	-0.024	1.65
72	0.0250	107	65.0	1000	425	1200	-0.025	1.65
0.65mm	0.0256	105	63.4	1000	425	1200	-0.025	1.65
71	0.0260	109	62.5	1000	425	1200	-0.025	1.75
0.70mm	0.0276	103	58.8	1000	425	1200	-0.025	1.75
70	0.0280	116	58.0	1000	425	1200	-0.026	2.00
69	0.0292	111	55.6	1000	425	1500	-0.026	2.00
0.75mm	0.0295	110	55.1	1000	425	1500	-0.030	2.00
68	0.0310	105	52.4	1000	425	1500	-0.030	2.00
1/32"	0.0312	104	52.1	1000	425	1500	-0.030	2.00
0.80mm	0.0315	116	51.6	1000	425	1500	-0.030	2.25
67	0.0320	114	50.8	1000	425	1500	-0.030	2.25
66	0.0330	111	49.2	1000	425	1500	-0.030	2.25
0.85mm	0.0335	109	48.5	1000	425	1500	-0.030	2.25

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65	0.0350	104	46.4	1000	425	1500	-0.030	2.25
0.90mm	0.0354	103	45.9	1000	425	1500	-0.030	2.25
64	0.0360	102	45.1	1000	425	1500	-0.030	2.25
63	0.0367	111	44.3	1000	425	1500	-0.030	2.50
0.95mm	0.0374	109	43.4	1000	425	1500	-0.030	2.50
62	0.0380	107	42.7	1000	425	1500	-0.030	2.50
61	0.0390	104	41.6	1000	425	1500	-0.030	2.50
1.00mm	0.0394	103	41.2	1000	425	1500	-0.030	2.50
60	0.0400	102	40.6	1000	425	1500	-0.030	2.50
59	0.0410	99	39.6	1000	425	1500	-0.030	2.50
1.05mm	0.0413	98	39.3	1000	425	1500	-0.030	2.50
58	0.0420	97	38.7	1000	425	1500	-0.030	2.50
57	0.0430	94	37.8	1000	425	1500	-0.030	2.50
1.10mm	0.0433	94	37.5	1000	425	1500	-0.030	2.50
1.15mm	0.0453	90	35.9	1000	425	1500	-0.030	2.50
56	0.0465	87	34.9	1000	425	1500	-0.030	2.50
3/64"	0.0469	87	34.6	1000	425	1500	-0.030	2.50
1.20mm	0.0472	95	34.4	1000	425	1500	-0.030	2.75
1.25mm	0.0492	91	33.0	1000	425	1200	-0.030	2.75
1.30mm	0.0512	87	31.7	1000	425	1200	-0.030	2.75
55	0.0520	86	31.2	1000	425	1200	-0.030	2.75
1.35mm	0.0531	84	30.6	1000	425	1200	-0.030	2.75
54	0.0550	81	29.5	1000	425	1200	-0.030	2.75
1.40mm	0.0551	81	29.5	1000	425	1200	-0.030	2.75
1.45mm	0.0571	78	28.4	1000	425	1200	-0.030	2.75
1.50mm	0.0591	76	27.5	1000	425	1200	-0.030	2.75
53	0.0595	75	27.3	1000	425	1200	-0.030	2.75
1.55mm	0.0610	73	26.6	1000	425	1200	-0.030	2.75
1/16"	0.0625	71	26.0	1000	425	1200	-0.030	2.75
1.60mm	0.0630	71	25.8	1000	425	1200	-0.030	2.75
52	0.0635	70	25.6	1000	425	1200	-0.030	2.75
1.65mm	0.0650	69	25.0	1000	425	1200	-0.030	2.75
1.70mm	0.0669	67	24.3	1000	425	1200	-0.034	2.75
51	0.0670	67	24.2	1000	425	1200	-0.034	2.75
1.75mm	0.0689	65	23.6	1000	425	1200	-0.035	2.75
50	0.0700	64	23.2	1000	425	1200	-0.035	2.75
1.80mm	0.0709	63	22.9	1000	425	1200	-0.035	2.75
1.85mm	0.0728	61	22.3	1000	425	1200	-0.035	2.75
49	0.0730	61	22.2	1000	425	1200	-0.035	2.75
1.90mm	0.0748	54	21.7	1000	425	1200	-0.035	2.50
48	0.0760	53	21.4	1000	425	1200	-0.035	2.50
1.95mm	0.0768	50	20.0	1000	402	1200	-0.035	2.50
5/64"	0.0781	50	20.0	1000	409	1200	-0.035	2.50
47	0.0785	50	20.0	1000	411	1200	-0.035	2.50
2.00mm	0.0787	50	20.0	1000	412	1200	-0.035	2.50
2.05mm	0.0807	50	20.0	1000	422	1000	-0.035	2.50
46	0.0810	50	20.0	1000	424	1000	-0.035	2.50
45	0.0820	50	20.0	1000	429	1000	-0.035	2.50
2.10mm	0.0827	50	20.0	1000	433	1000	-0.035	2.50

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2.15mm	0.0846	50	20.0	1000	443	1000	-0.035	2.50
44	0.0860	50	20.0	1000	450	1000	-0.035	2.50
2.20mm	0.0866	50	20.0	1000	453	1000	-0.035	2.50
2.25mm	0.0886	50	20.0	1000	464	1000	-0.035	2.50
43	0.0890	50	20.0	1000	466	1000	-0.035	2.50
2.30mm	0.0906	50	20.0	1000	474	1000	-0.035	2.50
2.35mm	0.0925	50	20.0	1000	484	1000	-0.035	2.50
42	0.0935	50	20.0	1000	489	1000	-0.035	2.50
3/32"	0.0938	50	20.0	1000	491	1000	-0.035	2.50
2.40mm	0.0945	50	20.0	1000	495	1000	-0.035	2.50
41	0.0969	50	20.0	1000	507	1000	-0.035	2.50
2.45mm	0.0965	50	20.0	1000	505	1000	-0.035	2.50
40	0.0980	50	20.0	1000	513	1000	-0.035	2.50
2.50mm	0.0984	50	20.0	1000	515	1000	-0.035	2.50
39	0.0995	60	20.0	1000	521	1000	-0.035	3.00
2.55mm	0.1004	60	20.0	1000	525	1000	-0.035	3.00
38	0.1015	60	20.0	1000	531	750	-0.035	3.00
2.60mm	0.1024	60	20.0	1000	536	750	-0.035	3.00
37	0.1040	60	20.0	1000	544	750	-0.035	3.00
2.65mm	0.1043	60	20.0	1000	546	750	-0.035	3.00
2.70mm	0.1063	60	20.0	1000	556	750	-0.035	3.00
36	0.1065	60	20.0	1000	557	750	-0.035	3.00
2.75mm	0.1083	60	20.0	1000	567	750	-0.035	3.00
7/64"	0.1094	60	20.0	1000	573	750	-0.035	3.00
35	0.1100	60	20.0	1000	576	750	-0.035	3.00
2.80mm	0.1102	60	20.0	1000	577	750	-0.035	3.00
34	0.1110	60	20.0	1000	581	750	-0.035	3.00
2.85mm	0.1122	60	20.0	1000	587	750	-0.035	3.00
33	0.1130	60	20.0	1000	591	750	-0.035	3.00
2.90mm	0.1142	60	20.0	1000	598	750	-0.035	3.00
32	0.1160	60	20.0	1000	607	750	-0.035	3.00
2.95mm	0.1161	60	20.0	1000	608	750	-0.035	3.00
3.00mm	0.1181	60	20.0	1000	618	750	-0.035	3.00
31	0.1200	60	20.0	1000	628	750	-0.035	3.00
3.05mm	0.1201	60	20.0	1000	629	750	-0.035	3.00
3.10mm	0.1220	60	20.0	1000	638	750	-0.035	3.00
3.15mm	0.1240	60	20.0	1000	649	750	-0.035	3.00
1/8"	0.1250	60	20.0	1000	654	750	-0.035	3.00
3.20mm	0.1260	50	20.0	1000	659	500	-0.035	2.50
3.25mm	0.1280	50	20.0	1000	670	500	-0.035	2.50
30	0.1285	50	20.0	1000	672	500	-0.035	2.50
3.30mm	0.1299	50	20.0	1000	680	500	-0.035	2.50
3.35mm	0.1319	50	20.0	1000	690	500	-0.035	2.50
3.40mm	0.1339	50	20.0	1000	701	500	-0.035	2.50
3.45mm	0.1358	50	20.0	1000	711	500	-0.035	2.50
29	0.1360	50	20.0	1000	712	500	-0.035	2.50
3.50mm	0.1378	50	20.0	1000	721	500	-0.035	2.50
3.55mm	0.1398	50	20.0	1000	732	500	-0.035	2.50
28	0.1405	50	20.0	1000	735	500	-0.035	2.50

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DRILL SIZE	DRILL DIAM.	FEED IPM	SPEED RPM (k)	RETRACT IPM	SFM	MAX HITS	Z AXIS OFFSET	CHIPLOAD (mils)
9/64"	0.1406	50	20.0	1000	736	500	-0.035	2.50
3.60mm	0.1417	50	20.0	1000	742	500	-0.035	2.50
3.65mm	0.1437	50	20.0	1000	752	500	-0.035	2.50
27	0.1440	50	20.0	1000	754	500	-0.035	2.50
3.70mm	0.1457	50	20.0	1000	762	500	-0.035	2.50
26	0.1470	50	20.0	1000	769	500	-0.035	2.50
3.75mm	0.1476	50	20.0	1000	772	500	-0.035	2.50
25	0.1495	50	20.0	1000	782	500	-0.035	2.50
3.80mm	0.1496	50	20.0	1000	783	500	-0.035	2.50
3.85mm	0.1516	50	20.0	1000	793	250	-0.035	2.50
24	0.1520	50	20.0	1000	795	250	-0.035	2.50
3.90mm	0.1535	50	20.0	1000	803	250	-0.035	2.50
23	0.1540	50	20.0	1000	806	250	-0.035	2.50
3.95mm	0.1555	50	20.0	1000	814	250	-0.035	2.50
5/32"	0.1562	50	20.0	1000	817	250	-0.035	2.50
22	0.1570	40	20.0	1000	822	250	-0.035	2.00
4.00mm	0.1575	40	20.0	1000	824	250	-0.035	2.00
21	0.1590	40	20.0	1000	832	250	-0.035	2.00
4.05mm	0.1594	40	20.0	1000	834	250	-0.035	2.00
20	0.1610	40	20.0	1000	843	250	-0.035	2.00
4.10mm	0.1614	40	20.0	1000	845	250	-0.035	2.00
4.15mm	0.1634	40	20.0	1000	855	250	-0.035	2.00
4.20mm	0.1654	40	20.0	1000	866	250	-0.035	2.00
19	0.1660	40	20.0	1000	869	250	-0.035	2.00
4.25mm	0.1673	40	20.0	1000	876	250	-0.035	2.00
4.30mm	0.1693	40	20.0	1000	886	250	-0.035	2.00
18	0.1695	40	20.0	1000	887	250	-0.035	2.00
4.35mm	0.1713	40	20.0	1000	896	250	-0.035	2.00
11/64"	0.1719	40	20.0	1000	900	250	-0.035	2.00
17	0.1730	40	20.0	1000	905	250	-0.035	2.00
4.40mm	0.1732	40	20.0	1000	906	250	-0.035	2.00
4.45mm	0.1752	40	20.0	1000	917	200	-0.035	2.00
16	0.1770	40	20.0	1000	926	200	-0.035	2.00
4.50mm	0.1772	40	20.0	1000	927	200	-0.035	2.00
4.55mm	0.1791	40	20.0	1000	937	200	-0.035	2.00
15	0.1800	40	20.0	1000	942	200	-0.035	2.00
4.60mm	0.1811	40	20.0	1000	948	200	-0.035	2.00
14	0.1820	40	20.0	1000	952	200	-0.035	2.00
4.65mm	0.1831	40	20.0	1000	958	200	-0.035	2.00
13	0.1850	40	20.0	1000	968	200	-0.035	2.00
4.70mm	0.1850	40	20.0	1000	968	200	-0.035	2.00
4.75mm	0.1870	40	20.0	1000	979	200	-0.035	2.00
3/16"	0.1875	40	20.0	1000	981	200	-0.035	2.00
12	0.1890	30	20.0	1000	989	200	-0.035	1.50
4.80mm	0.1890	30	20.0	1000	989	200	-0.035	1.50
4.85mm	0.1909	30	20.0	1000	999	200	-0.035	1.50
11	0.1910	30	20.0	1000	1000	200	-0.035	1.50
4.90mm	0.1929	30	20.0	1000	1010	200	-0.035	1.50
10	0.1935	30	20.0	1000	1013	200	-0.035	1.50

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4.95mm	0.1949	30	20.0	1000	1020	200	-0.035	1.50
9	0.1960	30	20.0	1000	1026	200	-0.035	1.50
5.00mm	0.1969	30	20.0	1000	1030	200	-0.035	1.50
8	0.1990	30	20.0	1000	1041	200	-0.035	1.50
5.10mm	0.2008	30	20.0	1000	1051	125	-0.035	1.50
7	0.2010	30	20.0	1000	1052	125	-0.035	1.50
5.15mm	0.2028	30	20.0	1000	1061	125	-0.035	1.50
13/64"	0.2031	30	20.0	1000	1063	125	-0.035	1.50
6	0.2040	30	20.0	1000	1068	125	-0.035	1.50
5.20mm	0.2047	30	20.0	1000	1071	125	-0.035	1.50
5	0.2055	30	20.0	1000	1075	125	-0.035	1.50
5.25mm	0.2067	30	20.0	1000	1082	125	-0.035	1.50
5.30mm	0.2087	30	20.0	1000	1092	125	-0.035	1.50
4	0.2090	30	20.0	1000	1094	125	-0.035	1.50
5.35mm	0.2106	30	20.0	1000	1102	125	-0.035	1.50
5.40mm	0.2126	30	20.0	1000	1113	125	-0.035	1.50
3	0.2130	30	20.0	1000	1115	125	-0.035	1.50
5.45mm	0.2146	30	20.0	1000	1123	125	-0.035	1.50
5.50mm	0.2165	30	20.0	1000	1133	125	-0.035	1.50
5.55mm	0.2185	30	20.0	1000	1143	125	-0.035	1.50
7/32"	0.2188	30	20.0	1000	1145	125	-0.035	1.50
5.60mm	0.2205	20	20.0	1000	1154	125	-0.035	1.00
2	0.2210	20	20.0	1000	1157	125	-0.035	1.00
5.65mm	0.2224	20	20.0	1000	1164	125	-0.035	1.00
5.70mm	0.2244	20	20.0	1000	1174	125	-0.035	1.00
5.75mm	0.2264	20	20.0	1000	1185	125	-0.035	1.00
1	0.2280	20	20.0	1000	1193	125	-0.035	1.00
5.80mm	0.2283	20	20.0	1000	1195	125	-0.035	1.00
5.85mm	0.2303	20	20.0	1000	1205	125	-0.035	1.00
5.90mm	0.2323	20	20.0	1000	1216	125	-0.035	1.00
A	0.2340	20	20.0	1000	1225	125	-0.035	1.00
5.95mm	0.2343	20	20.0	1000	1226	125	-0.035	1.00
15/64"	0.2344	20	20.0	1000	1227	125	-0.035	1.00
6.00mm	0.2362	20	20.0	1000	1236	125	-0.035	1.00
B	0.2380	20	20.0	1000	1246	125	-0.035	1.00
6.05mm	0.2382	20	20.0	1000	1247	125	-0.035	1.00
6.10mm	0.2402	20	20.0	1000	1257	125	-0.035	1.00
C	0.2420	20	20.0	1000	1266	125	-0.035	1.00
6.15mm	0.2421	20	20.0	1000	1267	125	-0.035	1.00
6.20mm	0.2441	20	20.0	1000	1277	125	-0.035	1.00
D	0.2460	20	20.0	1000	1287	125	-0.035	1.00
6.25mm	0.2461	20	20.0	1000	1288	125	-0.035	1.00
6.30mm	0.2480	20	20.0	1000	1298	125	-0.035	1.00
1/4"	0.2500	20	20.0	1000	1308	50	-0.035	1.00
6.35mm	0.2500	20	20.0	1000	1308	50	-0.035	1.00