

## HSS Flute Ground 135° Split Point Drill Bits

### MATERIAL RECOMMENDATIONS

Mild Steel	●	● Very suitable ● Suitable
Stainless Steel	●	
Cast Iron	●	
Aluminium	●	
Brass	●	
Wood	●	
Plastic	●	



### OPERATIONAL SPEED CHART

Diameter Size (mm)	Mild Steel RPM	Free-Cutting Stainless Steel	Grey Cast Iron RPM	Aluminium RPM	Copper RPM	Brass RPM
1	7003	4456	10504	12732	12732	12732
1.5	4669	2971	7003	8488	8488	8488
2	3501	2228	5252	6366	6366	6366
2.5	2801	1783	4202	5093	5093	5093
3	2334	1485	3501	4244	4244	4244
3.3	2122	1350	3183	3858	3858	3858
3.5	2001	1273	3001	3638	3638	3638
4	1751	1114	2626	3183	3183	3183
4.2	1667	1061	2501	3032	3032	3032
4.5	1556	990	2334	2829	2829	2829
5	1401	891	2101	2546	2546	2546
5.5	1273	810	1910	2315	2315	2315
6	1167	743	1751	2122	2122	2122
6.5	1077	686	1616	1959	1959	1959
7	1000	637	1501	1819	1819	1819
7.5	934	594	1401	1698	1698	1698
8	875	557	1313	1592	1592	1592
8.5	824	524	1236	1498	1498	1498
9	778	495	1167	1415	1415	1415
9.5	737	469	1106	1340	1340	1340
10	700	446	1050	1273	1273	1273
10.5	667	424	1000	1213	1213	1213
11	637	405	955	1157	1157	1157
11.5	609	388	913	1107	1107	1107
12	584	371	875	1061	1061	1061
12.5	560	357	840	1019	1019	1019
13	539	343	808	979	979	979

## TECH TIP

Our HSS Split Point drills can be re-sharpened for longer life (providing the drill bit has not been over heated in use)



Min Chuck  
Requirement 13mm



When drilling steel  
and alloys



Wear eye  
protection



Wear hearing  
protection



Wear a face  
mask



Wear hand  
protection