

**We have taken the guess work out  
of your Drill selection!**

## HSS M4 Blue Series Pg. 172

- :: TOOL STEELS
- :: CARBON STEELS
- :: ALLOY STEEL
- :: CAST IRON
- :: ALUMINUM
- :: STAINLESS STEEL



## SUPER HSCO T15 Yellow Series Pg 174

- :: TOOL STEELS
- :: CARBON STEELS
- :: ALLOYS
- :: HIGH TEMP ALLOYS
- :: CAST IRON



## DRILL SPEEDS AND FEEDS



<b>HSS M4 Blue Series Spade Drills</b>			
Materials Main Group	Materials Sub-Group	Hardness (HRC)	Cutting Speed (SFM)
Free Machining Steel	118, 1215, 12L14, etc.	<25	160-280
Low Carbon Steel	1010, 1018, 1020, 1025, 1144, etc.	<28	140-150
Medium Carbon Steel	1030, 1040, 1050, 1527, 1140, etc.	<28	140-240
Alloy Steel	4140, 5140, 8640, etc.	<28	130-210
Structural Steel	A36, A285, A516, etc.	<25	120-200
Stainless Steel	300 Series, 400 Series, 17-4PH, etc.	<28	60-105
Aluminum		<18	300-850
Cast Iron	Gray, Nodular Ductile	<22	130-250

<b>SUPER HSCO T15 Yellow Series Spade Drills</b>			
Materials Main Group	Materials Sub-Group	Hardness (HRC)	Cutting Speed (SFM)
Medium Carbon Steel	1030, 1040, 1050, 1527, 1140, etc.	<33	130-195
Alloy Steel	4140, 5140, 8640, etc.	<38	110-170
Alloy Steel (High Strength)	4340, 4330V, etc.	<35	60-110
Structural Steel	A36, A285, A516, etc.	<35	100-140
High Temp Alloys	Hastelloy, Inconel, etc.	<31	25-40
Tool Steel	A2, A4, O2, H13, etc.	<25	60-110
Cast Iron	Gray, Nodular Ductile	<32	90-165

**Application - Yellow Spade Blades should be used for drilling High Alloy or Exotic materials.**

**Yellow blades can also be used in regular applications to increase surface speed (SFM) and reduce tool wear.**