



SPEED & FEED INFORMATION OCEAN PENETRATOR DRILLS

Penetrator Drills - (ALWAYS START AT LOWER RPM)

Speed & Feed		RPM		Feed		Feed/min (related to/rev feed & RPM)			
						From		To	
Size	Dec Equiv	From	To	In/rev	Mm/rev	In/min	Mm/min	In/min	Mm/min
7/16	0.4375	710	1050	0.012	0.30	8.52	216	12.60	320
1/2	0.5	611	840	0.013	0.33	7.94	202	10.92	277
9/16	0.5625	590	810	0.014	0.36	8.26	210	11.34	288
5/8	0.625	562	773	0.015	0.38	8.43	214	11.60	295
11/16	0.6875	480	670	0.016	0.41	7.68	195	10.72	272
3/4	0.75	469	644	0.017	0.43	7.97	203	10.95	278
13/16	0.8125	410	560	0.018	0.46	7.38	187	10.08	256
7/8	0.875	370	510	0.019	0.48	7.03	179	9.69	246
15/16	0.9375	350	480	0.020	0.51	7.00	178	9.60	244
1	1	320	440	0.021	0.53	6.72	171	9.24	235
1.1/16	1.0625	300	420	0.022	0.56	6.60	168	9.24	235
1.1/8	1.125	280	400	0.023	0.58	6.44	164	9.20	234
1.3/16	1.1875	270	380	0.024	0.61	6.48	165	9.12	232
1.1/4	1.25	260	360	0.024	0.61	6.24	158	8.64	219
1.5/16	1.3125	250	350	0.026	0.66	6.5	165	9.10	231
1.3/8	1.375	222	306	0.027	0.69	5.99	152	8.26	210
1.7/16	1.4375	213	292	0.028	0.71	5.96	151	8.18	208
1.1/2	1.5	204	280	0.030	0.76	6.12	155	8.40	213
1.9/16	1.5625	196	269	0.032	0.81	6.27	159	8.61	219
1.5/8	1.625	188	259	0.033	0.84	6.20	158	8.55	217
1.11/16	1.6875	180	248	0.034	0.86	6.12	155	8.43	214
1.3/4	1.75	175	240	0.036	0.91	6.30	160	8.64	219
1.13/16	1.8125	168	230	0.037	0.94	6.22	158	8.51	216
1.7/8	1.875	160	222	0.038	0.97	6.08	154	8.44	214
1.15/16	1.9375	156	216	0.039	0.99	6.08	155	8.42	214
2	2	150	210	0.040	1.02	6.00	152	8.40	213

**** THESE SPEEDS ARE FOR DRILLING DEPTHS UP TO 2" AND MUST BE CONSIDERED TO BE "A STARTING POINT" AS INDIVIDUAL DRILL RIGS AND OPERATIONS DO CHANGE.**

**** IT IS RECOMMENDED THAT THE FEED RATE IS NOT CHANGED BUT THE RPM.**

(Fractional) Feed Rate (Inch/min) = Feed Rate (in/rev) x RPM

(Metric) Feed Rate (mm/min) = Feed Rate (mm/rev) x RPM



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