



**CENTER
DRILLS**

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDKONDITIONEN

**DV303, DV333, DV334, D1303, D1343,
D1313, D1353, D1363, D1373, DV383** SERIES

VC = M/MIN
RPM = rev./min.
FEED = mm/rev.

HSS & HSS-E, CENTER DRILLS

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)	Vc	Parameter	Drill Diameter (mm)							
					0.5			1.0	2.0	3.0	4.0	5.0	6.0	8.0	10.0
P	1	Non-alloy steel	30	RPM	19100	40	RPM	12730	6370	4240	3180	2550	2120	1590	1270
				FEED	0.01-0.03		FEED	0.02-0.04	0.03-0.06	0.04-0.08	0.05-0.09	0.06-0.10	0.07-0.12	0.09-0.15	0.12-0.18
	2		25	RPM	15920	30	RPM	9550	4770	3180	2390	1910	1590	1190	950
				FEED	0.01-0.03		FEED	0.02-0.04	0.03-0.06	0.04-0.08	0.05-0.09	0.06-0.10	0.07-0.12	0.09-0.15	0.12-0.18
	3	Low alloy steel	20	RPM	12730	25	RPM	7960	3980	2650	1990	1590	1330	990	800
				FEED	0.005-0.02		FEED	0.01-0.03	0.01-0.035	0.015-0.05	0.02-0.06	0.03-0.07	0.04-0.08	0.06-0.12	0.08-0.14
	6		25	RPM	15920	30	RPM	9550	4770	3180	2390	1910	1590	1190	950
				FEED	0.01-0.03		FEED	0.02-0.04	0.03-0.06	0.04-0.08	0.05-0.09	0.06-0.10	0.07-0.12	0.09-0.15	0.12-0.18
	7		15	RPM	9550	20	RPM	6370	3180	2120	1590	1270	1060	800	640
				FEED	0.005-0.02		FEED	0.01-0.03	0.01-0.035	0.015-0.05	0.02-0.06	0.03-0.07	0.04-0.08	0.06-0.12	0.08-0.14
M	12	Stainless steel	8	RPM	5090	10	RPM	3180	1590	1060	800	640	530	400	320
				FEED	0.005-0.02		FEED	0.01-0.03	0.01-0.035	0.015-0.05	0.02-0.06	0.03-0.07	0.04-0.08	0.06-0.12	0.08-0.14
K	15	Grey cast iron	30	RPM	19100	40	RPM	12730	6370	4240	3180	2550	2120	1590	1270
				FEED	0.01-0.03		FEED	0.02-0.04	0.03-0.06	0.04-0.08	0.05-0.09	0.06-0.10	0.07-0.12	0.09-0.15	0.12-0.18
	16		25	RPM	15920	30	RPM	9550	4770	3180	2390	1910	1590	1190	950
				FEED	0.005-0.02		FEED	0.01-0.03	0.01-0.035	0.015-0.05	0.02-0.06	0.03-0.07	0.04-0.08	0.06-0.12	0.08-0.14
	17	Nodular cast iron	30	RPM	19100	40	RPM	12730	6370	4240	3180	2550	2120	1590	1270
				FEED	0.01-0.03		FEED	0.02-0.04	0.03-0.06	0.04-0.08	0.05-0.09	0.06-0.10	0.07-0.12	0.09-0.15	0.12-0.18
	19	Malleable cast iron	20	RPM	12730	25	RPM	7960	3980	2650	1990	1590	1330	990	800
				FEED	0.01-0.03		FEED	0.02-0.04	0.03-0.06	0.04-0.08	0.05-0.09	0.06-0.10	0.07-0.12	0.06-0.12	0.12-0.18