HPD DRILLS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

D4541, D4542 SERIES — HPD DRILLS for STEELS

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

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)							
					2.0	3.0	4.0	5.0	6.0	8.0	10.0	12.0
P	1	Non-alloy steel	35	RPM	5570	3710	2790	2230	1860	1390	1110	930
				FEED	0.04-0.10	0.07-0.13	0.09-0.15	0.12-0.18	0.13-0.19	0.18-0.24	0.20-0.30	0.22-0.32
	2		25	RPM	3980	2650	1990	1590	1330	990	800	660
				FEED	0.04-0.10	0.07-0.13	0.09-0.15	0.12-0.18	0.13-0.19	0.18-0.24	0.20-0.30	0.22-0.32
	3		25	RPM	3980	2650	1990	1590	1330	990	800	660
				FEED	0.04-0.10	0.07-0.13	0.09-0.15	0.12-0.18	0.13-0.19	0.18-0.24	0.20-0.30	0.22-0.32
	6	Low alloy steel	30	RPM	4770	3180	2390	1910	1590	1190	950	800
				FEED	0.04-0.10	0.07-0.13	0.09-0.15	0.12-0.18	0.13-0.19	0.18-0.24	0.20-0.30	0.22-0.32
	7		25	RPM	3980	2650	1990	1590	1330	990	800	660
				FEED	0.04-0.10	0.07-0.13	0.09-0.15	0.12-0.18	0.13-0.19	0.18-0.24	0.20-0.30	0.22-0.32
	10	High alloyed steel, and tool steel	15	RPM	2390	1590	1190	950	800	600	480	400
				FEED	0.04-0.10	0.07-0.13	0.09-0.15	0.12-0.18	0.13-0.19	0.18-0.24	0.20-0.30	0.22-0.32
K	15	Grey cast iron	40	RPM	6370	4240	3180	2550	2120	1590	1270	1060
				FEED	0.06-0.12	0.09-0.15	0.12-0.18	0.15-0.21	0.16-0.22	0.22-0.28	0.26-0.36	0.28-0.38

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)									
					14.0	16.0	18.0	20.0	22.0	24.0	26.0	28.0	30.0	32.0
P	1	Non-alloy steel	35	RPM	800	700	620	560	510	460	430	400	370	350
				FEED	0.25-0.35	0.28-0.38	0.34-0.44	0.35-0.45	0.40-0.50	0.44-0.54	0.48-0.58	0.52-0.62	0.56-0.66	0.60-0.70
	2		25	RPM	570	500	440	400	360	330	310	280	270	250
				FEED	0.25-0.35	0.28-0.38	0.34-0.44	0.35-0.45	0.40-0.50	0.44-0.54	0.48-0.58	0.52-0.62	0.56-0.66	0.60-0.70
	3		25	RPM	570	500	440	400	360	330	310	280	270	250
				FEED	0.25-0.35	0.28-0.38	0.34-0.44	0.35-0.45	0.40-0.50	0.44-0.54	0.48-0.58	0.52-0.62	0.56-0.66	0.60-0.70
	6	Low alloy steel	30	RPM	680	600	530	480	430	400	370	340	320	300
				FEED	0.25-0.35	0.28-0.38	0.34-0.44	0.35-0.45	0.40-0.50	0.44-0.54	0.48-0.58	0.52-0.62	0.56-0.66	0.60-0.70
	7		25	RPM	570	500	440	400	360	330	310	280	270	250
				FEED	0.25-0.35	0.28-0.38	0.34-0.44	0.35-0.45	0.40-0.50	0.44-0.54	0.48-0.58	0.52-0.62	0.56-0.66	0.60-0.70
	10	High alloyed steel, and tool steel	15	RPM	340	300	270	240	220	200	180	170	160	150
				FEED	0.25-0.35	0.28-0.38	0.34-0.44	0.35-0.45	0.40-0.50	0.44-0.54	0.48-0.58	0.52-0.62	0.56-0.66	0.60-0.70
K	15	Grey cast iron	40	RPM	910	800	710	640	580	530	490	450	420	400
				FEED	0.32-0.42	0.35-0.45	0.42-0.52	0.44-0.54	0.50-0.60	0.54-0.64	0.59-0.69	0.64-0.74	0.69-0.79	0.74-0.84

Please decrease the feed rate (15~20%) in D4542 SERIES HPD drills.
Den Vorschub in der D4542 Gruppe HPD Bohrer bitte verringern.