

# DV303, DV333, DV334, D1303, D1343, D1313, D1353, D1363, D1373, DV383

SERIES

## 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              |
| <b>P</b> | 1        | Non-alloy steel      | 30 | RPM<br>FEED | 19100<br>0.01-0.03  | 40 | RPM<br>FEED | 12730<br>0.02-0.04  | 6370<br>0.03-0.06  | 4240<br>0.04-0.08  | 3180<br>0.05-0.09 | 2550<br>0.06-0.10 | 2120<br>0.07-0.12 | 1590<br>0.09-0.15 | 1270<br>0.12-0.18 |
|          | 2        |                      | 25 | RPM<br>FEED | 15920<br>0.01-0.03  | 30 | RPM<br>FEED | 9550<br>0.02-0.04   | 4770<br>0.03-0.06  | 3180<br>0.04-0.08  | 2390<br>0.05-0.09 | 1910<br>0.06-0.10 | 1590<br>0.07-0.12 | 1190<br>0.09-0.15 | 950<br>0.12-0.18  |
|          | 3        |                      | 20 | RPM<br>FEED | 12730<br>0.005-0.02 | 25 | RPM<br>FEED | 7960<br>0.01-0.03   | 3980<br>0.01-0.035 | 2650<br>0.015-0.05 | 1990<br>0.02-0.06 | 1590<br>0.03-0.07 | 1330<br>0.04-0.08 | 990<br>0.06-0.12  | 800<br>0.08-0.14  |
|          | 6        | Low alloy steel      | 25 | RPM<br>FEED | 15920<br>0.01-0.03  | 30 | RPM<br>FEED | 9550<br>0.02-0.04   | 4770<br>0.03-0.06  | 3180<br>0.04-0.08  | 2390<br>0.05-0.09 | 1910<br>0.06-0.10 | 1590<br>0.07-0.12 | 1190<br>0.09-0.15 | 950<br>0.12-0.18  |
|          | 7        |                      | 15 | RPM<br>FEED | 9550<br>0.005-0.02  | 20 | RPM<br>FEED | 6370<br>0.01-0.03   | 3180<br>0.01-0.035 | 2120<br>0.015-0.05 | 1590<br>0.02-0.06 | 1270<br>0.03-0.07 | 1060<br>0.04-0.08 | 800<br>0.06-0.12  | 640<br>0.08-0.14  |
| <b>M</b> | 12       | Stainless steel      | 8  | RPM<br>FEED | 5090<br>0.005-0.02  | 10 | RPM<br>FEED | 3180<br>0.01-0.03   | 1590<br>0.01-0.035 | 1060<br>0.015-0.05 | 800<br>0.02-0.06  | 640<br>0.03-0.07  | 530<br>0.04-0.08  | 400<br>0.06-0.12  | 320<br>0.08-0.14  |
| <b>K</b> | 15       | Grey cast iron       | 30 | RPM<br>FEED | 19100<br>0.01-0.03  | 40 | RPM<br>FEED | 12730<br>0.02-0.04  | 6370<br>0.03-0.06  | 4240<br>0.04-0.08  | 3180<br>0.05-0.09 | 2550<br>0.06-0.10 | 2120<br>0.07-0.12 | 1590<br>0.09-0.15 | 1270<br>0.12-0.18 |
|          | 16       |                      | 25 | RPM<br>FEED | 15920<br>0.005-0.02 | 30 | RPM<br>FEED | 9550<br>0.01-0.03   | 4770<br>0.01-0.035 | 3180<br>0.015-0.05 | 2390<br>0.02-0.06 | 1910<br>0.03-0.07 | 1590<br>0.04-0.08 | 1190<br>0.06-0.12 | 950<br>0.08-0.14  |
|          | 17       | Nodular cast iron    | 30 | RPM<br>FEED | 19100<br>0.01-0.03  | 40 | RPM<br>FEED | 12730<br>0.02-0.04  | 6370<br>0.03-0.06  | 4240<br>0.04-0.08  | 3180<br>0.05-0.09 | 2550<br>0.06-0.10 | 2120<br>0.07-0.12 | 1590<br>0.09-0.15 | 1270<br>0.12-0.18 |
|          | 19       | Malleable cast iron  | 20 | RPM<br>FEED | 12730<br>0.01-0.03  | 25 | RPM<br>FEED | 7960<br>0.02-0.04   | 3980<br>0.03-0.06  | 2650<br>0.04-0.08  | 1990<br>0.05-0.09 | 1590<br>0.06-0.10 | 1330<br>0.07-0.12 | 990<br>0.06-0.12  | 800<br>0.12-0.18  |