

HSS, HSS-E & HSSCo8 COBALT DRILLS

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	6.0	8.0	10.0	13.0	16.0	18.0	20.0	30.0
DREAM DRILLS	P	1	Non-alloy steel	30	RPM	4770	3180	2390	1590	1190	950	730	600	530	480	320
DREAM DRILLS -PRO		2		25	FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
DREAM DRILLS -GENERAL					RPM	3980	2650	1990	1330	990	800	610	500	440	400	270
DREAM DRILLS -HIGH FEED		3		20	FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
			RPM		3180	2120	1590	1060	800	640	490	400	350	320	210	
DREAM DRILLS -FLAT BOTTOM		4	20	FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28	
				RPM	3180	2120	1590	1060	800	640	490	400	350	320	210	
DREAM DRILLS -INOX		6	25	FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28	
				RPM	3980	2650	1990	1330	990	800	610	500	440	400	270	
DREAM DRILLS -ALU		7	20	FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28	
	RPM			3180	2120	1590	1060	800	640	490	400	350	320	210		
DREAM DRILLS -MQL	8	20	FEED	0.01~0.02	0.01~0.03	0.02~0.04	0.02~0.05	0.03~0.06	0.03~0.06	0.04~0.10	0.06~0.12	0.08~0.14	0.10~0.16	0.12~0.18		
			RPM	3180	2120	1590	1060	800	640	490	400	350	320	210		
DREAM DRILLS for HIGH HARDENED STEELS	M	10	High alloyed steel, and tool steel	15	RPM	2390	1590	1190	800	600	480	370	300	270	240	160
		12		20	FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28
					RPM	3180	2120	1590	1060	800	640	490	400	350	320	210
GENERAL CARBIDE DRILLS	13	15	Stainless steel	FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28	
				RPM	2390	1590	1190	800	600	480	370	300	270	240	160	
				FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28	
MULTI-1 DRILLS	14	10	Stainless steel	RPM	1590	1060	800	530	400	320	240	200	180	160	110	
				FEED	0.01~0.02	0.01~0.03	0.02~0.04	0.02~0.05	0.03~0.06	0.03~0.06	0.04~0.10	0.06~0.12	0.08~0.14	0.10~0.16	0.12~0.18	
				RPM	4770	3180	2390	1590	1190	950	730	600	530	480	320	
HPD DRILLS	15	30	Grey cast iron	FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28	
				RPM	3980	2650	1990	1330	990	800	610	500	440	400	270	
				FEED	0.01~0.02	0.01~0.03	0.02~0.04	0.02~0.05	0.03~0.06	0.03~0.06	0.04~0.10	0.06~0.12	0.08~0.14	0.10~0.16	0.12~0.18	
GOLD-P DRILLS	16	25	Grey cast iron	RPM	4770	3180	2390	1590	1190	950	730	600	530	480	320	
				FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28	
				RPM	3980	2650	1990	1330	990	800	610	500	440	400	270	
SUPER-GP DRILLS	17	30	Nodular cast iron	FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28	
				RPM	4770	3180	2390	1590	1190	950	730	600	530	480	320	
				FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28	
STRAIGHT SHANK DRILLS	19	25	Malleable cast iron	RPM	3980	2650	1990	1330	990	800	610	500	440	400	270	
				FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28	
				RPM	8750	5840	4380	2920	2190	1750	1350	1090	970	880	580	
TAPER SHANK DRILLS	21	55	Aluminum-wrought alloy	FEED	0.03~0.06	0.05~0.09	0.07~0.11	0.12~0.16	0.12~0.18	0.14~0.20	0.16~0.22	0.18~0.24	0.20~0.28	0.20~0.30	0.28~0.38	
				RPM	8750	5840	4380	2920	2190	1750	1350	1090	970	880	580	
				FEED	0.03~0.06	0.05~0.09	0.07~0.11	0.12~0.16	0.12~0.18	0.14~0.20	0.16~0.22	0.18~0.24	0.20~0.28	0.20~0.30	0.28~0.38	
TAPER SHANK DRILLS	22	55	Aluminum-wrought alloy	RPM	6370	4240	3180	2120	1590	1270	980	800	710	640	420	
				FEED	0.03~0.06	0.05~0.09	0.07~0.11	0.12~0.16	0.12~0.18	0.14~0.20	0.16~0.22	0.18~0.24	0.20~0.28	0.20~0.30	0.28~0.38	
				RPM	3180	2120	1590	1060	800	640	490	400	350	320	210	
TAPER SHANK DRILLS	23	40	Aluminum-cast, alloyed	FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28	
				RPM	3180	2120	1590	1060	800	640	490	400	350	320	210	
				FEED	0.02~0.04	0.03~0.05	0.04~0.06	0.05~0.08	0.10~0.13	0.11~0.15	0.11~0.17	0.12~0.18	0.14~0.20	0.19~0.25	0.22~0.28	
TAPER SHANK DRILLS	29	20	Non Metallic Materials	RPM	1590	1060	800	530	400	320	240	200	180	160	110	
				FEED	0.01~0.03	0.02~0.04	0.03~0.05	0.04~0.07	0.05~0.08	0.05~0.09	0.06~0.10	0.05~0.11	0.06~0.12	0.09~0.13	0.12~0.18	
				RPM	1590	1060	800	530	400	320	240	200	180	160	110	