

CARBIDE

HSS

NC-SPOTTING
DRILLS



RECOMMENDED CUTTING CONDITIONS

EMPFOHLENE SCHNEIDPARAMETER

D5306, D5307, D5320 SERIES

CARBIDE, NC-SPOTTING DRILLS

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

i-ONE
DRILLS

i-DREAM
DRILLS

DREAM
DRILLS
-PRO

DREAM
DRILLS
-GENERAL

DREAM
DRILLS
-HIGH FEED

DREAM
DRILLS
-FLAT BOTTOM

DREAM
DRILLS
-INOX

DREAM
DRILLS
-ALU

DREAM
DRILLS
-MQL

DREAM DRILLS
for HIGH
HARDENED STEELS

GENERAL
CARBIDE
DRILLS

MULTI-1
DRILLS

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)									
					2.0	3.0	4.0	6.0	8.0	10.0	12.0	16.0	20.0	
P	1	Non-alloy steel	75	RPM	11940	7960	5970	3980	2980	2390	1990	1490	1190	
				FEED	0.02-0.04	0.04-0.06	0.05-0.08	0.07-0.10	0.08-0.12	0.09-0.14	0.11-0.17	0.13-0.19	0.15-0.21	
	2		70	RPM	11140	7430	5570	3710	2790	2230	1860	1390	1110	
				FEED	0.02-0.04	0.04-0.06	0.05-0.08	0.07-0.10	0.08-0.12	0.09-0.14	0.11-0.17	0.13-0.19	0.15-0.21	
	3	65	RPM	10350	6900	5170	3450	2590	2070	1720	1290	1030		
			FEED	0.01-0.03	0.03-0.05	0.04-0.07	0.05-0.08	0.07-0.10	0.08-0.12	0.09-0.14	0.11-0.17	0.13-0.19		
	6	Low alloy steel	70	RPM	11140	7430	5570	3710	2790	2230	1860	1390	1110	
				FEED	0.02-0.04	0.04-0.06	0.05-0.08	0.07-0.10	0.08-0.12	0.09-0.14	0.11-0.17	0.13-0.19	0.15-0.21	
			7	55	RPM	8750	5840	4380	2920	2190	1750	1460	1090	880
					FEED	0.01-0.03	0.03-0.05	0.04-0.07	0.05-0.08	0.07-0.10	0.08-0.12	0.09-0.14	0.11-0.17	0.13-0.19
M	12	Stainless steel	35	RPM	5570	3710	2790	1860	1390	1110	930	700	560	
				FEED	0.02-0.04	0.04-0.06	0.05-0.08	0.07-0.10	0.08-0.12	0.09-0.14	0.11-0.17	0.13-0.19	0.15-0.21	
K	15	Grey cast iron	90	RPM	14320	9550	7160	4770	3580	2860	2390	1790	1430	
				FEED	0.03-0.05	0.05-0.07	0.06-0.09	0.08-0.11	0.10-0.13	0.12-0.16	0.15-0.20	0.18-0.24	0.22-0.28	
			70	RPM	11140	7430	5570	3710	2790	2230	1860	1390	1110	
				FEED	0.01-0.03	0.03-0.05	0.04-0.07	0.05-0.08	0.07-0.10	0.08-0.12	0.09-0.14	0.11-0.17	0.13-0.19	
	17	Nodular cast iron	90	RPM	14320	9550	7160	4770	3580	2860	2390	1790	1430	
				FEED	0.03-0.05	0.05-0.07	0.06-0.09	0.08-0.11	0.10-0.13	0.12-0.16	0.15-0.20	0.18-0.24	0.22-0.28	
	19	Malleable cast iron	60	RPM	9550	6370	4770	3180	2390	1910	1590	1190	950	
				FEED	0.03-0.05	0.05-0.07	0.06-0.09	0.08-0.11	0.10-0.13	0.12-0.16	0.15-0.2	0.18-0.24	0.22-0.28	
N	21	Aluminum-wrought alloy	165	RPM	26260	17510	13130	8750	6570	5250	4380	3280	2630	
				FEED	0.04-0.06	0.06-0.09	0.08-0.11	0.10-0.13	0.12-0.15	0.15-0.19	0.18-0.23	0.21-0.27	0.25-0.31	
	22		130	RPM	20690	13790	10350	6900	5170	4140	3450	2590	2070	
				FEED	0.04-0.06	0.06-0.09	0.08-0.11	0.10-0.13	0.12-0.15	0.15-0.19	0.18-0.23	0.21-0.27	0.25-0.31	
	23	Aluminum-cast, alloyed	110	RPM	17510	11670	8750	5840	4380	3500	2920	2190	1750	
				FEED	0.04-0.06	0.06-0.09	0.08-0.11	0.10-0.13	0.12-0.15	0.15-0.19	0.18-0.23	0.21-0.27	0.25-0.31	
S	36	Titanium Alloys	35	RPM	5570	3710	2790	1860	1390	1110	930	700	560	
				FEED	0.01-0.03	0.03-0.05	0.04-0.06	0.05-0.08	0.07-0.10	0.08-0.12	0.09-0.14	0.11-0.17	0.13-0.19	