

MULTI-1
DRILLS

HPD
DRILLS

GOLD-P
DRILLS

SUPER-GP
DRILLS

STRAIGHT
SHANK
DRILLS

TAPER SHANK
DRILLS

NC-
SPOTTING
DRILLS

CENTER
DRILLS

SPADE
DRILLS

REAMERS

COUNTER
SINKS

COUNTER
BORES

TECHNICAL
DATA

D2320, D2321, D2322,
D2323, D2306, D2307
SERIES

HSSCo8, NC-SPOTTING 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	25	RPM FEED	3980 0.02-0.04	2650 0.04-0.06	1990 0.05-0.08	1330 0.07-0.10	990 0.08-0.12	800 0.09-0.14	660 0.11-0.17	500 0.13-0.19	400 0.15-0.21
	2		25	RPM FEED	3980 0.02-0.04	2650 0.04-0.06	1990 0.05-0.08	1330 0.07-0.10	990 0.08-0.12	800 0.09-0.14	660 0.11-0.17	500 0.13-0.19	400 0.15-0.21
	3		15	RPM FEED	2390 0.01-0.03	1590 0.03-0.05	1190 0.04-0.07	800 0.05-0.08	600 0.07-0.10	480 0.08-0.12	400 0.09-0.14	300 0.11-0.17	240 0.13-0.19
	6	Low alloy steel	20	RPM FEED	3180 0.02-0.04	2120 0.04-0.06	1590 0.05-0.08	1060 0.07-0.10	800 0.08-0.12	640 0.09-0.14	530 0.11-0.17	400 0.13-0.19	320 0.15-0.21
	7		15	RPM FEED	2390 0.01-0.03	1590 0.03-0.05	1190 0.04-0.07	800 0.05-0.08	600 0.07-0.10	480 0.08-0.12	400 0.09-0.14	300 0.11-0.17	240 0.13-0.19
M	12	Stainless steel	15	RPM FEED	2390 0.02-0.04	1590 0.04-0.06	1190 0.05-0.08	800 0.07-0.10	600 0.08-0.12	480 0.09-0.14	400 0.11-0.17	300 0.13-0.19	240 0.15-0.21
K	15	Grey cast iron	30	RPM FEED	4770 0.03-0.05	3180 0.05-0.07	2390 0.06-0.09	1590 0.08-0.11	1190 0.10-0.13	950 0.12-0.16	800 0.15-0.20	600 0.18-0.24	480 0.22-0.28
	16		25	RPM FEED	3980 0.01-0.03	2650 0.03-0.05	1990 0.04-0.07	1330 0.05-0.08	990 0.07-0.10	800 0.08-0.12	660 0.09-0.14	500 0.11-0.17	400 0.13-0.19
	17	Nodular cast iron	30	RPM FEED	4770 0.03-0.05	3180 0.05-0.07	2390 0.06-0.09	1590 0.08-0.11	1190 0.10-0.13	950 0.12-0.16	800 0.15-0.20	600 0.18-0.24	480 0.22-0.28
	19	Malleable cast iron	20	RPM FEED	3180 0.03-0.05	2120 0.05-0.07	1590 0.06-0.09	1060 0.08-0.11	800 0.10-0.13	640 0.12-0.16	530 0.15-0.20	400 0.18-0.24	320 0.22-0.28
N	21	Aluminum-wrought alloy	65	RPM FEED	10350 0.04-0.06	6900 0.06-0.09	5170 0.08-0.11	3450 0.10-0.13	2590 0.12-0.15	2070 0.15-0.19	1720 0.18-0.23	1290 0.21-0.27	1030 0.25-0.31
	22		60	RPM FEED	9550 0.04-0.06	6370 0.06-0.09	4770 0.08-0.11	3180 0.10-0.13	2390 0.12-0.15	1910 0.15-0.19	1590 0.18-0.23	1190 0.21-0.27	950 0.25-0.31
	23	Aluminum-cast, alloyed	50	RPM FEED	7960 0.04-0.06	5310 0.06-0.09	3980 0.08-0.11	2650 0.10-0.13	1990 0.12-0.15	1590 0.15-0.19	1330 0.18-0.23	990 0.21-0.27	800 0.25-0.31