

### D5432, D5433, D5434 SERIES

### with COOLANT HOLES

Vc = m/min  
RPM = rev./min.  
FEED = mm/rev.

| ISO | VDI 3323 | Material Description   | Vc  | Parameter | Drill Diameter (mm) |           |           |           |           |           |           |           |           |           |           |
|-----|----------|------------------------|-----|-----------|---------------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
|     |          |                        |     |           | 3.0                 | 4.0       | 5.0       | 6.0       | 8.0       | 10.0      | 12.0      | 14.0      | 16.0      | 18.0      | 20.0      |
| N   | 21       | Aluminum-wrought alloy | 200 | RPM       | 21220               | 15920     | 12730     | 10610     | 7960      | 6370      | 5310      | 4550      | 3980      | 3540      | 3180      |
|     |          |                        |     | FEED      | 0.12-0.18           | 0.14-0.22 | 0.15-0.23 | 0.17-0.25 | 0.21-0.28 | 0.24-0.30 | 0.24-0.30 | 0.25-0.35 | 0.25-0.35 | 0.28-0.38 | 0.30-0.40 |
|     | 22       | Aluminum-wrought alloy | 160 | RPM       | 16980               | 12730     | 10190     | 8490      | 6370      | 5090      | 4240      | 3640      | 3180      | 2830      | 2550      |
|     |          |                        |     | FEED      | 0.12-0.18           | 0.14-0.22 | 0.15-0.23 | 0.17-0.25 | 0.21-0.28 | 0.24-0.30 | 0.24-0.30 | 0.25-0.35 | 0.25-0.35 | 0.28-0.38 | 0.30-0.40 |
|     | 23       | Aluminum-cast, alloyed | 150 | RPM       | 15920               | 11940     | 9550      | 7960      | 5970      | 4770      | 3980      | 3410      | 2980      | 2650      | 2390      |
|     |          |                        |     | FEED      | 0.15-0.21           | 0.17-0.25 | 0.19-0.27 | 0.21-0.28 | 0.24-0.31 | 0.29-0.45 | 0.33-0.55 | 0.35-0.60 | 0.35-0.60 | 0.39-0.73 | 0.39-0.85 |
|     | 24       | Aluminum-cast, alloyed | 140 | RPM       | 14850               | 11140     | 8910      | 7430      | 5570      | 4460      | 3710      | 3180      | 2790      | 2480      | 2230      |
|     |          |                        |     | FEED      | 0.15-0.21           | 0.17-0.25 | 0.19-0.27 | 0.21-0.28 | 0.24-0.31 | 0.29-0.45 | 0.33-0.55 | 0.35-0.60 | 0.35-0.60 | 0.39-0.73 | 0.39-0.85 |