

DGR493, DGR495 SERIES with COOLANT HOLES

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

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)								
					5.0	6.0	8.0	10.0	12.0	14.0	16.0	18.0	20.0
P	2	Non-alloy steel	100	RPM	6370	5310	3980	3180	2650	2270	1990	1770	1590
				FEED	0.2-0.25	0.24-0.3	0.32-0.4	0.4-0.5	0.48-0.6	0.56-0.7	0.56-0.72	0.63-0.81	0.7-0.88
	3		100	RPM	6370	5310	3980	3180	2650	2270	1990	1770	1590
				FEED	0.2-0.25	0.24-0.3	0.32-0.4	0.4-0.5	0.48-0.6	0.56-0.7	0.56-0.72	0.63-0.81	0.7-0.88
	4		100	RPM	6370	5310	3980	3180	2650	2270	1990	1770	1590
				FEED	0.16-0.21	0.2-0.26	0.26-0.34	0.34-0.42	0.41-0.47	0.47-0.54	0.47-0.55	0.5-0.59	0.54-0.67
	5	80	RPM	5090	4240	3180	2550	2120	1820	1590	1410	1270	
			FEED	0.16-0.21	0.2-0.26	0.26-0.34	0.34-0.42	0.41-0.47	0.47-0.54	0.47-0.55	0.5-0.59	0.54-0.67	
	6	Low alloy steel	100	RPM	6370	5310	3980	3180	2650	2270	1990	1770	1590
				FEED	0.2-0.25	0.24-0.3	0.32-0.4	0.4-0.5	0.48-0.54	0.56-0.63	0.56-0.64	0.63-0.72	0.68-0.81
	7		80	RPM	5090	4240	3180	2550	2120	1820	1590	1410	1270
				FEED	0.2-0.25	0.24-0.3	0.32-0.4	0.4-0.5	0.48-0.54	0.56-0.63	0.56-0.64	0.63-0.72	0.68-0.81
8	80		RPM	5090	4240	3180	2550	2120	1820	1590	1410	1270	
			FEED	0.16-0.21	0.2-0.26	0.26-0.34	0.34-0.42	0.41-0.47	0.47-0.54	0.47-0.55	0.5-0.59	0.54-0.67	
9	High alloyed steel, and tool steel	40	RPM	2550	2120	1590	1270	1060	910	800	710	640	
			FEED	0.13-0.18	0.16-0.22	0.21-0.29	0.26-0.36	0.32-0.38	0.36-0.43	0.36-0.45	0.38-0.47	0.41-0.54	
10		70	RPM	4460	3710	2790	2230	1860	1590	1390	1240	1110	
			FEED	0.16-0.21	0.2-0.26	0.26-0.34	0.34-0.42	0.41-0.47	0.47-0.54	0.47-0.55	0.5-0.59	0.54-0.67	
11		40	RPM	2550	2120	1590	1270	1060	910	800	710	640	
			FEED	0.13-0.18	0.16-0.22	0.21-0.29	0.26-0.36	0.32-0.38	0.36-0.43	0.36-0.45	0.38-0.47	0.41-0.54	
K	15	Grey cast iron	100	RPM	6370	5310	3980	3180	2650	2270	1990	1770	1590
				FEED	0.23-0.30	0.27-0.36	0.36-0.48	0.45-0.60	0.54-0.72	0.63-0.84	0.64-0.80	0.72-0.90	0.80-0.98
	16		80	RPM	5090	4240	3180	2550	2120	1820	1590	1410	1270
				FEED	0.20-0.25	0.24-0.30	0.32-0.40	0.40-0.50	0.48-0.60	0.56-0.70	0.56-0.72	0.63-0.81	0.70-0.90
	17	Nodular cast iron	100	RPM	6370	5310	3980	3180	2650	2270	1990	1770	1590
				FEED	0.23-0.30	0.27-0.36	0.36-0.48	0.45-0.60	0.54-0.72	0.63-0.84	0.64-0.80	0.72-0.90	0.80-0.98
	18		70	RPM	4460	3710	2790	2230	1860	1590	1390	1240	1110
				FEED	0.20-0.25	0.24-0.30	0.32-0.40	0.40-0.50	0.48-0.60	0.56-0.70	0.56-0.72	0.63-0.81	0.70-0.90
19	Malleable cast iron	80	RPM	5090	4240	3180	2550	2120	1820	1590	1410	1270	
			FEED	0.23-0.30	0.27-0.36	0.36-0.48	0.45-0.60	0.54-0.72	0.63-0.84	0.64-0.80	0.72-0.90	0.80-0.98	
20		70	RPM	4460	3710	2790	2230	1860	1590	1390	1240	1110	
			FEED	0.20-0.25	0.24-0.30	0.32-0.40	0.40-0.50	0.48-0.60	0.56-0.70	0.56-0.72	0.63-0.81	0.70-0.90	