



STRAIGHT SHANK DRILLS

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

D1106 SERIES

HSS, TWIST DRILLS for ALUMINUM

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

| ISO | VDI 3323 | Material Description | Vc | Parameter | Drill Diameter (mm) | | | | | | | | |
|-----|------------------------|------------------------|------|-----------|---------------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| | | | | | 1.5 | 2.0 | 3.0 | 4.0 | 5.0 | 6.0 | 8.0 | 10.0 | 13.0 |
| N | 21 | Aluminum-wrought alloy | 50 | RPM | 10610 | 7960 | 5310 | 3980 | 3180 | 2650 | 1990 | 1590 | 1220 |
| | | | | FEED | 0.03-0.06 | 0.05~0.08 | 0.06~0.10 | 0.08~0.12 | 0.10~0.14 | 0.14~0.18 | 0.14~0.20 | 0.19~0.25 | 0.25~0.35 |
| | 22 | Aluminum-wrought alloy | 50 | RPM | 10610 | 7960 | 5310 | 3980 | 3180 | 2650 | 1990 | 1590 | 1220 |
| | | | | FEED | 0.03-0.06 | 0.05~0.08 | 0.06~0.10 | 0.08~0.12 | 0.10~0.14 | 0.14~0.18 | 0.14~0.20 | 0.19~0.25 | 0.25~0.35 |
| 23 | Aluminum-cast, alloyed | 40 | RPM | 8490 | 6370 | 4240 | 3180 | 2550 | 2120 | 1590 | 1270 | 980 | |
| | | | FEED | 0.03-0.06 | 0.05~0.08 | 0.06~0.10 | 0.08~0.12 | 0.10~0.14 | 0.14~0.18 | 0.14~0.20 | 0.19~0.25 | 0.25~0.35 | |
| 24 | Aluminum-cast, alloyed | 30 | RPM | 6370 | 4770 | 3180 | 2390 | 1910 | 1590 | 1190 | 950 | 730 | |
| | | | FEED | 0.01-0.04 | 0.03~0.06 | 0.03~0.07 | 0.04~0.08 | 0.05~0.09 | 0.04~0.10 | 0.06~0.12 | 0.10~0.16 | 0.12~0.22 | |