HPD DRILLS

RECOMMENDED CUTTING CONDITIONS
EMPFOHLENE SCHNEIDPARAMETER

DJ543, DJ544 SERIES — HPD-SUS DRILLS for STAINLESS STEELS

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

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)				
					2.0	3.0	4.0	5.0	6.0
P	1	Non-alloy steel	35	RPM	5570	3710	2790	2230	1860
				FEED	0.04-0.1	0.07-0.13	0.09-0.15	0.12-0.18	0.13-0.19
M	12	Stainless steel	20	RPM	3180	2120	1590	1270	1060
				FEED	0.03-0.07	0.05-0.09	0.06-0.12	0.09-0.15	0.12-0.18
	13		18	RPM	2860	1910	1430	1150	950
				FEED	0.03-0.07	0.05-0.09	0.06-0.12	0.09-0.15	0.12-0.18
	14		15	RPM	2390	1590	1190	950	800
				FEED	0.02-0.05	0.03-0.07	0.04-0.10	0.06-0.12	0.07-0.13
N	21	Aluminum-wrought alloy	90	RPM	14320	9550	7160	5730	4770
				FEED	0.05-0.12	0.10-0.18	0.12-0.22	0.15-0.25	0.17-0.27
	22		90	RPM	14320	9550	7160	5730	4770
				FEED	0.05-0.12	0.10-0.18	0.12-0.22	0.15-0.25	0.17-0.27
	26	Copper and Copper Alloys (Bronze / Brass)	35	RPM	5570	3710	2790	2230	1860
				FEED	0.03-0.06	0.05-0.09	0.05-0.11	0.08-0.14	0.11-0.17

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)						
					8.0	10.0	12.0	14.0	16.0	18.0	20.0
P	1	Non-alloy steel	35	RPM	1390	1110	930	800	700	620	560
				FEED	0.18-0.24	0.20-0.30	0.22-0.32	0.25-0.35	0.28-0.38	0.34-0.44	0.35-0.45
M	12	Stainless steel	20	RPM	800	640	530	450	400	350	320
				FEED	0.18-0.24	0.20-0.30	0.26-0.36	0.34-0.44	0.38-0.48	0.40-0.50	0.43-0.53
	13		18	RPM	720	570	480	410	360	320	290
				FEED	0.18-0.24	0.20-0.30	0.26-0.36	0.34-0.44	0.38-0.48	0.40-0.50	0.43-0.53
	14		15	RPM	600	480	400	340	300	270	240
				FEED	0.10-0.160	0.12-0.22	0.14-0.24	0.24-0.34	0.28-0.38	0.30-0.40	0.33-0.43
N	21	Aluminum-wrought alloy	90	RPM	3580	2860	2390	2050	1790	1590	1430
				FEED	0.25-0.35	0.35-0.45	0.40-0.55	0.45-0.60	0.55-0.70	0.60-0.75	0.65-0.80
	22		90	RPM	3580	2860	2390	2050	1790	1590	1430
				FEED	0.25-0.35	0.35-0.45	0.40-0.55	0.45-0.60	0.55-0.70	0.60-0.75	0.65-0.80
	26	Copper and Copper Alloys (Bronze / Brass)	35	RPM	1390	1110	930	800	700	620	560
				FEED	0.14-0.20	0.16-0.26	0.18-0.28	0.22-0.32	0.26-0.36	0.28-0.38	0.30-0.40

Please decrease the feed rate (15~20%) in DJ544 SERIES HPD-SUS drills.
Den Vorschub in der DJ544 Gruppe HPD-SUS Bohrer bitte verringern