



STRAIGHT SHANK DRILLS

RECOMMENDED CUTTING CONDITIONS EMPFOHLENE SCHNEIDPARAMETER

DL507 SERIES

HSS-E, DH50 WORM PATTERN DRILLS

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	6.0	8.0	10.0	13.0
P	1	Non-alloy steel	15	RPM	2390	1590	1190	800	600	480	370
				FEED	0.01~0.03	0.02~0.04	0.03~0.06	0.04~0.08	0.04~0.10	0.07~0.13	0.09~0.15
N	21	Aluminum-wrought alloy	55	RPM	8750	5840	4380	2920	2190	1750	1350
				FEED	0.02~0.04	0.03~0.06	0.04~0.08	0.08~0.12	0.10~0.16	0.14~0.20	0.16~0.26
	22	Aluminum-wrought alloy	45	RPM	7160	4770	3580	2390	1790	1430	1100
				FEED	0.02~0.04	0.03~0.06	0.04~0.08	0.08~0.12	0.10~0.16	0.14~0.20	0.16~0.26
	23	Aluminum-cast, alloyed	40	RPM	6370	4240	3180	2120	1590	1270	980
				FEED	0.02~0.04	0.03~0.06	0.04~0.08	0.08~0.12	0.10~0.16	0.14~0.20	0.16~0.26