

DJ543, DJ544 SERIES

HPD-SUS DRILLS for STAINLESS STEELS

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 FEED	5570 0.04-0.1	3710 0.07-0.13	2790 0.09-0.15	2230 0.12-0.18	1860 0.13-0.19
M	12	Stainless steel	20	RPM FEED	3180 0.03-0.07	2120 0.05-0.09	1590 0.06-0.12	1270 0.09-0.15	1060 0.12-0.18
	13		18	RPM FEED	2860 0.03-0.07	1910 0.05-0.09	1430 0.06-0.12	1150 0.09-0.15	950 0.12-0.18
	14		15	RPM FEED	2390 0.02-0.05	1590 0.03-0.07	1190 0.04-0.10	950 0.06-0.12	800 0.07-0.13
N	21	Aluminum- wrought alloy	90	RPM FEED	14320 0.05-0.12	9550 0.10-0.18	7160 0.12-0.22	5730 0.15-0.25	4770 0.17-0.27
	22		90	RPM FEED	14320 0.05-0.12	9550 0.10-0.18	7160 0.12-0.22	5730 0.15-0.25	4770 0.17-0.27
	26	Copper and Copper Alloys (Bronze / Brass)	35	RPM FEED	5570 0.03-0.06	3710 0.05-0.09	2790 0.05-0.11	2230 0.08-0.14	1860 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 FEED	1390 0.18-0.24	1110 0.20-0.30	930 0.22-0.32	800 0.25-0.35	700 0.28-0.38	620 0.34-0.44	560 0.35-0.45
M	12	Stainless steel	20	RPM FEED	800 0.18-0.24	640 0.20-0.30	530 0.26-0.36	450 0.34-0.44	400 0.38-0.48	350 0.40-0.50	320 0.43-0.53
	13		18	RPM FEED	720 0.18-0.24	570 0.20-0.30	480 0.26-0.36	410 0.34-0.44	360 0.38-0.48	320 0.40-0.50	290 0.43-0.53
	14		15	RPM FEED	600 0.10-0.160	480 0.12-0.22	400 0.14-0.24	340 0.24-0.34	300 0.28-0.38	270 0.30-0.40	240 0.33-0.43
N	21	Aluminum- wrought alloy	90	RPM FEED	3580 0.25-0.35	2860 0.35-0.45	2390 0.40-0.55	2050 0.45-0.60	1790 0.55-0.70	1590 0.60-0.75	1430 0.65-0.80
	22		90	RPM FEED	3580 0.25-0.35	2860 0.35-0.45	2390 0.40-0.55	2050 0.45-0.60	1790 0.55-0.70	1590 0.60-0.75	1430 0.65-0.80
	26	Copper and Copper Alloys (Bronze / Brass)	35	RPM FEED	1390 0.14-0.20	1110 0.16-0.26	930 0.18-0.28	800 0.22-0.32	700 0.26-0.36	620 0.28-0.38	560 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