

Recommended Cutting Conditions

DRC Series (Internal Coolant)

Work Material		Drill Diameter	Ø3-6mm		Ø6.1~10mm		Ø10.1-12mm	
		Hardness	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)
P	Mild Steel	(<180HB)	40~70	0.1~0.2	40~70	0.1~0.24	40~70	0.1~0.3
	Carbon Steel	(180~280HB)	25~50	0.1~0.2	25~50	0.1~0.24	25~50	0.1~0.3
	Alloy Steel	(280~350HB)	15~25	0.08~0.16	15~25	0.08~0.2	15~25	0.08~0.24
M	Stainless Steel	(<200HB)	8~15	0.08~0.16	8~15	0.08~0.18	8~15	0.08~0.2
K	Cast Iron	(<350Mpa)	35~60	0.1~0.32	35~60	0.1~0.36	35~60	0.1~0.4
	Ductile Cast Iron	(<450Mpa)	20~45	0.1~0.24	20~45	0.1~0.28	20~45	0.1~0.32
N	Aluminum <12% Si	-	110~195	0.12~0.32	110~195	0.12~0.36	110~195	0.12~0.4
	Aluminum >12% Si	-	105~180	0.12~0.32	105~180	0.12~0.36	105~180	0.12~0.4
S	Heat Resistant Alloy	-	8~15	0.08~0.16	8~15	0.08~0.18	8~15	0.08~0.2
H	Hardened Material	-	-	-	-	-	-	-

DRN Series (External Coolant)

Work Material		Drill Diameter	Ø3-6mm		Ø6.1~10mm		Ø10.1-12mm	
		Hardness	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)	Vc (m/min)	Feed (mm/rev)
P	Mild Steel	(<180HB)	10~20	0.03~0.12	10~20	0.06~0.2	10~20	0.1~0.22
	Carbon Steel	(180~280HB)	10~16	0.03~0.12	10~16	0.06~0.2	10~16	0.1~0.22
	Alloy Steel	(280~350HB)	8~12	0.03~0.12	8~12	0.06~0.2	8~12	0.1~0.22
M	Stainless Steel	-	-	-	-	-	-	-
K	Cast Iron	(<350Mpa)	8~16	0.03~0.12	8~16	0.06~0.02	8~16	0.1~0.22
	Ductile Cast Iron	(<450Mpa)	8~16	0.03~0.12	8~16	0.06~0.02	8~16	0.1~0.22
N	Aluminum <12% Si	-	20~30	0.03~0.13	20~30	0.07~0.23	20~30	0.1~0.28
	Aluminum >12% Si	-	20~30	0.03~0.13	20~30	0.07~0.23	20~30	0.1~0.28
S	Heat Resistant Alloy	-	-	-	-	-	-	-
H	Hardened Material	-	-	-	-	-	-	-