

CUTTING DATA



810504, 820504, 810505, 820404, 820604 (Goldex)														
VDI MATERIAL GROUP		HRC	v _c (m/min)	f _n (mm/rev)										
				ø1.0 -1.9	ø2.0 -2.9	ø3.0 -3.9	ø4.0 -4.9	ø5.0 -5.9	ø6.0 -6.9	ø7.0 -7.9	ø8.0 -9.9	ø10.0 -11.9	ø12.0 -13.5	
P	1-5	Non-alloy Steel	<25	40 (35-45)	0.02	0.06	0.08	0.11	0.11	0.13	0.15	0.18	0.22	0.22
	6-9	Low alloy Steel	25-35	23 (20-25)	0.02	0.06	0.08	0.10	0.10	0.12	0.14	0.15	0.18	0.20
M	12-13	Stainless Steel		23 (20-25)	0.02	0.06	0.08	0.10	0.10	0.12	0.14	0.15	0.18	0.20
S	36-37	Titanium & Titanium Alloys		23 (20-25)	0.02	0.06	0.08	0.09	0.10	0.12	0.14	0.15	0.18	0.20
N	21-24	Aluminium Si<12%		90 (85-95)	0.02	0.06	0.10	0.11	0.12	0.14	0.16	0.18	0.23	0.23

v_c - cutting speed (m/min)
 n - RPM (rev/min)
 f_n - feed rate (mm/rev)
 ø - drill diameter (mm)

$$\text{To calculate RPM from cutting speed: } n = \frac{v_c \cdot 1000}{\pi \cdot \varnothing}$$

$$\text{To calculate cutting speed from RPM: } v_c = \frac{n \cdot \pi \cdot \varnothing}{1000}$$

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up. The recommendations for speeds, feeds and other parameters presented in these charts are nominal recommendations and should be considered only as good starting points.