

HSS Goldex Drills Jobber Drills TiN Coated (820504)



MATERIAL GROUP	HRC	Fn(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	40 (35-45)	0.02	0.06	0.08	0.11	0.11	0.13	0.15	0.18	0.22	0.22
	23 (20-25)	0.02	0.06	0.08	0.10	0.10	0.12	0.14	0.15	0.18	0.20
M	23 (20-25)	0.02	0.06	0.08	0.10	0.10	0.12	0.14	0.15	0.18	0.20
S	23 (20-25)	0.02	0.06	0.08	0.09	0.10	0.12	0.14	0.15	0.18	0.20
N	90 (85-95)	0.02	0.06	0.10	0.11	0.12	0.14	0.16	0.18	0.23	0.23

Key	
Vc	Cutting speed (m/min)
n	RPM (rev/min)
Fz	Feed rate (mm/tooth)
f	Feed rate (mm/rev)
HRC	Hardness of metal

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

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

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 this chart are nominal recommendations and should be considered only as good starting points.