CENTRE DRILLS

DRILLING

ISO **P** **M** K N S H



MATERIAL	MILD STEEL		ALLOY STEELS				STAINLESS STEEL	
HARDNESS	< 700 N/mm²		~ HRc23		~ HRc32		-	
DIAMETER	Speed	Feed	RPM	Feed	RPM	Feed	RPM	Feed
ø 2	30 – 45	0.02 – 0.05	25 – 30	0.02 – 0.05	15 – 25	0.01 – 0.03	6 – 10	0.01 – 0.03
ø 3		0.06		0.06		0.04		0.04
ø 6		0.08		0.08		0.06		0.06
ø 10		0.15		0.15		0.10		0.10

i Speed / RPM ranges apply across all diameters shown for each material.