

HSS CENTRE DRILLS (BS_)



MATERIAL GROUP	Vc (m/min)	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	Ø14.0 - 15.5	Ø16.0 - 17.5	Ø18.0 - 19.5	Ø20.0
P	20 (25 - 25)	0.010	0.025	0.050	0.055	0.063	0.080	0.100	0.130	0.145	0.160	0.180	0.200	0.230	0.240
	18 (15 - 20)	0.009	0.020	0.045	0.050	0.060	0.075	0.095	0.125	0.140	0.150	0.170	0.210	0.220	0.230
M	8 (6 - 10)	0.010	0.025	0.050	0.055	0.063	0.080	0.100	0.130	0.145	0.160	0.180	0.200	0.230	0.240
K	8 (6 - 10)	0.010	0.025	0.050	0.055	0.063	0.080	0.100	0.130	0.145	0.160	0.180	0.200	0.230	0.240
S	5 (4 - 6)	0.080	0.020	0.025	0.031	0.038	0.045	0.060	0.075	0.090	0.100	0.110	0.120	0.130	0.140
N	40 (40 - 45)	0.020	0.038	0.063	0.070	0.076	0.120	0.160	0.180	0.200	0.225	0.250	0.275	0.300	0.325

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

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.