

821223 (Pulsar HRc70)



Material Group		Hardness HRc	v _c (m/min)	f _n (mm/rev)											
				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
H	15 16	50-55	18 (14-22)	0.04	0.04	0.04	0.04	-	0.04	0.04	0.04	0.04	-	-	-
		55-60	13 (10-16)	0.04	0.04	0.04	0.04	-	0.04	0.04	0.04	0.04	-	-	-
		60-70	10 (8-13)	0.04	0.04	0.04	0.04	-	0.04	0.04	0.04	0.04	-	-	-

v_c - cutting speed (m/min)

n - RPM (rev/min)

f_n - feed rate (mm/rev)

ø - drill diameter (mm)

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

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

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.