

820502, 820702, 820902 (HSSCo Stub, Jobber, Long Series)



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	
P	11 12	25 (22-27)	0.010	0.025	0.050	0.055	0.063	0.080	0.100	0.130	0.145	0.160
	13 14	22 (20-25)	0.009	0.020	0.045	0.050	0.060	0.075	0.095	0.125	0.140	0.150
M	21 22	18 (15-20)	0.010	0.025	0.050	0.055	0.063	0.080	0.100	0.130	0.145	0.160
	31 32 33	18 (15-20)	0.010	0.025	0.050	0.055	0.063	0.080	0.100	0.130	0.145	0.160
S	41 42	10 (8-12)	0.08	0.020	0.025	0.031	0.038	0.045	0.060	0.075	0.090	0.100
	71 72 73	48 (45-50)	0.020	0.038	0.063	0.070	0.076	0.120	0.160	0.180	0.200	0.225
O	81 82	23 (22-25)	0.010	0.025	0.050	0.055	0.063	0.080	0.100	0.130	0.145	0.160

Material Group	vc (m/min)	fn (mm/rev)									
		ø14.0 -15.5	ø16.0 -17.5	ø18.0 -19.5	ø20.0 -21.5	ø22.0 -23.5	ø24.0 -25.5	ø26.0 -27.5	ø28.0 -29.5	ø30.0 -31.0	
P	11 12	25 (22-27)	0.180	0.200	0.230	0.240	0.250	0.260	0.270	0.275	0.280
	13 14	22 (20-25)	0.170	0.210	0.220	0.230	0.240	0.250	0.260	0.265	0.270
M	21 22	18 (15-20)	0.180	0.200	0.230	0.240	0.250	0.260	0.270	0.275	0.280
	31 32 33	18 (15-20)	0.180	0.200	0.230	0.240	0.250	0.260	0.270	0.275	0.280
S	41 42	10 (8-12)	0.110	0.120	0.130	0.140	0.150	0.160	0.170	0.175	0.180
	71 72 73	48 (45-50)	0.250	0.275	0.300	0.325	0.350	0.360	0.370	0.375	0.380
O	81 82	23 (22-25)	0.180	0.200	0.230	0.240	0.250	0.260	0.270	0.275	0.280

vc - cutting speed (m/min)

n - RPM (rev/min)

fn - feed rate (mm/rev)

ø - drill diameter (mm)

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.