










METRIC

METRIC CARBIDE CENTER DRILLS

| Material | Property | Vc : m/min Uncoated | Vc : m/min AlTiN | Feed : (mm/t) | | | | |
|---|--------------|------------------------|---------------------|---------------|------|------|------|------|
| | | | | Ø2 | Ø3 | Ø6 | Ø10 | Ø16 |
|  | <500 MPa | 70 ~ 80 | 80 ~ 90 | 0.10 | 0.12 | 0.22 | 0.33 | 0.45 |
| | <800 MPa | 60 ~ 75 | 70 ~ 90 | 0.10 | 0.12 | 0.22 | 0.33 | 0.45 |
|  | <1,000 MPa | 50 ~ 60 | 60 ~ 70 | 0.07 | 0.08 | 0.15 | 0.23 | 0.31 |
| | <1,300 MPa | 25 ~ 40 | 30 ~ 50 | 0.06 | 0.07 | 0.13 | 0.20 | 0.27 |
|  | - | 20 ~ 30 | 30 ~ 40 | 0.06 | 0.08 | 0.15 | 0.20 | 0.30 |
|  | - | 20 ~ 25 | 30 ~ 40 | 0.50 | 0.70 | 0.13 | 0.18 | 0.27 |
|  | <900 MPa | 20 ~ 30 | 30 ~ 40 | 0.06 | 0.08 | 0.15 | 0.20 | 0.30 |
| | >900 MPa | | | | | | | |
|  | <180 HB | 50 ~ 60 | 60 ~ 70 | 0.10 | 0.12 | 0.22 | 0.33 | 0.45 |
| | >180 HB | 35 ~ 50 | 40 ~ 60 | 0.08 | 0.10 | 0.17 | 0.30 | 0.40 |
|  | Silicon <10% | 100 ~ 150 | 100 ~ 150 | 0.12 | 0.15 | 0.20 | 0.25 | 0.40 |
| | Silicon >10% | 70 ~ 90 | 70 ~ 90 | 0.12 | 0.15 | 0.20 | 0.25 | 0.40 |
|  | - | 70 ~ 90 | 70 ~ 90 | 0.12 | 0.15 | 0.20 | 0.25 | 0.40 |
|  | - | 150 ~ 200 | 150 ~ 200 | 0.13 | 0.15 | 0.25 | 0.40 | 0.50 |

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