

D1GP113, D1GP182, D1GP138, D1GP139, D1GP134, D1GP136, D2GP185, D2GP186, D2GP187 Series

Work Material	Carbon Steels		Carbon Steels		Alloy Steels		Stainless Steels	
Hardness			~ HRc23		HRc23 ~ 34		~ HRc23	
Strength	~ 570N/mm ²		~ 830N/mm ²		830~1110N/mm ²		~ 830N/mm ²	
Diameter(inch)	N	S	N	S	N	S	N	S
3/64(.0469)	14000	0.0008	12500	0.0008	7700	0.0008	7000	0.0008
#47(.0785)	7000	0.0023	6100	0.0024	3850	0.0024	3500	0.0024
#32(.1160)	4650	0.0038	4100	0.0031	2550	0.0031	2350	0.0031
#22(.1570)	3500	0.0044	3050	0.0043	1950	0.0039	1750	0.0039
#9(.1960)	2800	0.0049	2450	0.0043	1550	0.0039	1400	0.0039
B(.2380)	2350	0.0056	2050	0.0051	1300	0.0047	1150	0.0047
J(.2770)	2000	0.0064	1750	0.0059	1100	0.0055	1000	0.0055
O(.3160)	1750	0.0072	1550	0.0071	960	0.0059	875	0.0059
T(.3580)	1550	0.0077	1350	0.0087	855	0.0071	780	0.0071
X(.3970)	1400	0.0084	1250	0.0087	770	0.0071	700	0.0071
7/16(.4375)	1250	0.0087	1100	0.0087	700	0.0071	650	0.0071
15/32(.4688)	1150	0.0090	1000	0.0087	650	0.0079	585	0.0079
1/2(.5000)	1050	0.0090	950	0.0087	595	0.0079	540	0.0079

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Work Material	Titanium Alloys		Aluminum Alloys, Zinc Alloys		Magnesium Alloys	
Hardness						
Strength	~410N/mm ²					
Diameter(inch)	N	S	N	S	N	S
3/64(.0469)	8050	0.0008	30000	0.0008	11500	0.0012
#47(.0785)	4050	0.0024	15000	0.0023	5800	0.0035
#32(.1160)	2700	0.0031	9900	0.0038	3850	0.0051
#22(.1570)	2000	0.0035	7450	0.0044	2900	0.0059
#9(.1960)	1600	0.0039	5950	0.0049	2300	0.0067
B(.2380)	1350	0.0047	4950	0.0056	1950	0.0075
J(.2770)	1150	0.0055	4250	0.0064	1650	0.0087
O(.3160)	1000	0.0059	3700	0.0072	1450	0.0094
T(.3580)	895	0.0067	3300	0.0079	1280	0.0106
X(.3970)	805	0.0071	3000	0.0090	1150	0.0114
7/16(.4375)	730	0.0071	2700	0.0090	1050	0.0118
15/32(.4688)	670	0.0079	2480	0.0090	960	0.0122
1/2(.5000)	620	0.0079	2300	0.0090	890	0.0122

N=rev/min

S=inch/rev