



HSS-EX, HPD-SUS TWIST DRILLS SPEED and FEED DATA

DJ543, DJ544 SERIES

Please decrease the feed rate 15% in JOBBERS SERIES.
 Please decrease the feed and speed 20% for cast surface.

WORK MATERIAL	STAINLESS STEELS (SUS304, 200)		STAINLESS STEELS (SUS420, 440)		ALUMINUM & ALUMINUM ALLOY		PLASTICS, COPPER, COPPER ALLOYS		MILD STEELS, LOW CARBON STEELS	
	N	S	N	S	N	S	N	S	N	S
DIAMETER										
2.0	2600	0.003	3100	0.003	11000	0.004	5600	0.002	6300	0.003
3.0	1800	0.003	2100	0.003	7350	0.005	3750	0.003	4200	0.005
4.0	1300	0.004	1600	0.004	7050	0.007	2800	0.004	3200	0.006
5.0	1050	0.006	1250	0.006	5500	0.009	2250	0.005	2500	0.006
6.0	900	0.007	1050	0.007	4600	0.010	1850	0.006	2100	0.007
8.0	650	0.009	800	0.009	3500	0.013	1350	0.008	1550	0.009
10.0	550	0.010	630	0.012	2800	0.016	1100	0.010	1250	0.010
12.0	450	0.013	530	0.014	2300	0.020	950	0.012	1050	0.013
14.0	400	0.014	450	0.017	2050	0.022	800	0.013	900	0.014
16.0	350	0.016	390	0.019	1750	0.024	700	0.014	790	0.016
18.0	300	0.017	350	0.020	1600	0.028	620	0.016	700	0.018
20.0	260	0.018	320	0.021	1450	0.030	560	0.016	620	0.019

N = R.P.M

S = Inch per Revolution(inch/rev.)