

# CARBIDE



Being the best through innovation



# GENERAL CARBIDE DRILLS




- 普通长度 和 超短型  
普通用途, DIN338 和 DIN6539

**JOBBER & STUB LENGTH**  
General Purpose, DIN338 & DIN6539

# SELECTION GUIDE

## 普通整体硬质合金钻头

用于加工普通材料, 铸钢, 铸铁, 有色金属材料

项目	型号	规格	尺寸		页	
			最小	最大		
ITEM	MODEL	DESCRIPTION	SIZE		PAGE	
			MIN	MAX		
<b>D5405</b>		硬质合金钻头 CARBIDE DRILLS	超短 STUB	D1.0	D13.0	<b>100</b>
<b>D5407</b>		硬质合金钻头 CARBIDE DRILLS	细长 JOBBER	D1.0	D13.0	<b>102</b>
<b>D5401</b>		硬质合金钻头 CARBIDE DRILLS	常规 REGULAR	D1.0	D13.0	<b>104</b>
		推荐的切削条件 RECOMMENDED CUTTING CONDITIONS				<b>106</b>

# GENERAL SOLID CARBIDE DRILLS

## GENERAL SOLID CARBIDE DRILLS

For General materials, Cast steels, Cast iron, Non-ferrous materials

◎ : 优(Excellent)  
○ : 良(Good)

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
~HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○	○	○	○	◎		
◎	◎				○	○	○	○	◎		
◎	◎				○	○	○	○	◎		



**GENERAL CARBIDE DRILLS**

**D5405 SERIES**

**硬质合金钻头**

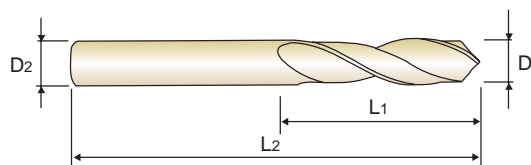
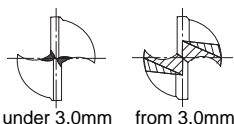
**CARBIDE DRILLS**

超硬

**STUB**

▶ 应用：用于加工一般的钢件，铸钢，铸铁，冷硬铸铁，可锻铸铁，非铁重金属，非铁轻金属，耐磨塑料等材料

▶ Application : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.



D1=D2

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D1	L1	L2	TiAlN	D1	L1	L2
D5405010	1.0	6	26	D5405035	3.5	20	52
D5405011	1.1	7	28	D5405036	3.6	20	52
D5405012	1.2	8	30	D5405037	3.7	20	52
D5405013	1.3	8	30	D5405038	3.8	20	52
D5405014	1.4	9	32	D5405039	3.9	22	55
D5405015	1.5	9	32	D5405040	4.0	22	55
D5405016	1.6	10	34	D5405041	4.1	22	55
D5405017	1.7	10	34	D5405042	4.2	22	55
D5405018	1.8	11	36	D5405043	4.3	24	58
D5405019	1.9	11	36	D5405044	4.4	24	58
D5405020	2.0	12	38	D5405045	4.5	24	58
D5405021	2.1	12	38	D5405046	4.6	24	58
D5405022	2.2	13	40	D5405047	4.7	24	58
D5405023	2.3	13	40	D5405048	4.8	26	62
D5405024	2.4	14	43	D5405049	4.9	26	62
D5405025	2.5	14	43	D5405050	5.0	26	62
D5405026	2.6	14	43	D5405051	5.1	26	62
D5405027	2.7	16	46	D5405052	5.2	26	62
D5405028	2.8	16	46	D5405053	5.3	26	62
D5405029	2.9	16	46	D5405054	5.4	28	66
D5405030	3.0	16	46	D5405055	5.5	28	66
D5405031	3.1	18	49	D5405056	5.6	28	66
D5405032	3.2	18	49	D5405057	5.7	28	66
D5405033	3.3	18	49	D5405058	5.8	28	66
D5405034	3.4	20	52	D5405059	5.9	28	66

▶ TiN (D6405), TiCN (DG405), TiAlN (DH405) 可根据客户需求进行加工。  
TiN(D6405), TiCN(DG405) and TiAlN(DH405) are available on your request.

◎ : 优(Excellent) ○ : 良(Good)

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
-HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○	○	○	○	◎		

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

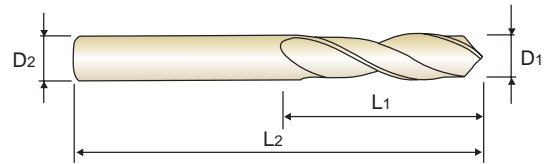
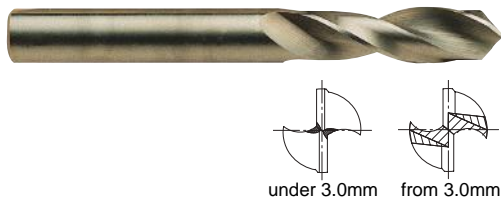
TECHNICAL DATA

**硬质合金钻头  
CARBIDE DRILLS**

超短型  
**STUB**

▶ 应用：用于加工一般的钢件，铸钢，铸铁，冷硬铸铁，可锻铸铁，非铁重金属，非铁轻金属，耐磨塑料等材料

▶ Application : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.



DIN 6539
MG
N 30°
h6
h7
118°
P.106

D<sub>1</sub>=D<sub>2</sub>

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D <sub>1</sub>	L <sub>1</sub>	L <sub>2</sub>	TiAlN	D <sub>1</sub>	L <sub>1</sub>	L <sub>2</sub>
D5405060	6.0	28	66	D5405084	8.4	37	79
D5405061	6.1	31	70	D5405085	8.5	37	79
D5405062	6.2	31	70	D5405086	8.6	40	84
D5405063	6.3	31	70	D5405087	8.7	40	84
D5405064	6.4	31	70	D5405088	8.8	40	84
D5405065	6.5	31	70	D5405089	8.9	40	84
D5405066	6.6	31	70	D5405090	9.0	40	84
D5405067	6.7	31	70	D5405091	9.1	40	84
D5405068	6.8	34	74	D5405092	9.2	40	84
D5405069	6.9	34	74	D5405093	9.3	40	84
D5405070	7.0	34	74	D5405094	9.4	40	84
D5405071	7.1	34	74	D5405095	9.5	40	84
D5405072	7.2	34	74	D5405096	9.6	43	89
D5405073	7.3	34	74	D5405097	9.7	43	89
D5405074	7.4	34	74	D5405098	9.8	43	89
D5405075	7.5	34	74	D5405099	9.9	43	89
D5405076	7.6	37	79	D5405100	10.0	43	89
D5405077	7.7	37	79	D5405102	10.2	43	89
D5405078	7.8	37	79	D5405105	10.5	43	89
D5405079	7.9	37	79	D5405110	11.0	47	95
D5405080	8.0	37	79	D5405115	11.5	47	95
D5405081	8.1	37	79	D5405120	12.0	51	102
D5405082	8.2	37	79	D5405130	13.0	51	102
D5405083	8.3	37	79				

▶ TiN (D6405), TiCN (DG405), TiAlN (DH405) 可根据客户需求进行加工。  
TiN(D6405), TiCN(DG405) and TiAlN(DH405) are available on your request.

◎ : 优(Excellent)    ○ : 良(Good)

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
-HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎				○	○	○	○	◎		

I-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA

**硬质合金钻头**

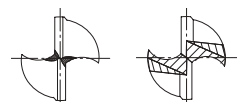
**CARBIDE DRILLS**

细长

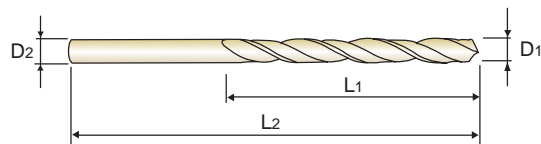
**JOBBER**

▶ 应用：用于加工一般的钢件，铸钢，铸铁，冷硬铸铁，可锻铸铁，非铁重金属，非铁轻金属，耐磨塑料等材料

▶ Application : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.



under 3.0mm from 3.0mm



D1=D2

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D1	L1	L2	TiAlN	D1	L1	L2
D5407010	1.0	12	34	D5407032	3.2	36	65
D5407011	1.1	14	36	D5407033	3.3	36	65
D5407012	1.2	16	38	D5407034	3.4	39	70
D5407013	1.3	16	38	D5407035	3.5	39	70
D5407014	1.4	18	40	D5407036	3.6	39	70
D5407015	1.5	18	40	D5407037	3.7	39	70
D5407016	1.6	20	43	D5407038	3.8	43	75
D5407017	1.7	20	43	D5407039	3.9	43	75
D5407018	1.8	22	46	D5407040	4.0	43	75
D5407019	1.9	22	46	D5407041	4.1	43	75
D5407020	2.0	24	49	D5407042	4.2	43	75
D5407021	2.1	24	49	D5407043	4.3	47	80
D5407022	2.2	27	53	D5407044	4.4	47	80
D5407023	2.3	27	53	D5407045	4.5	47	80
D5407024	2.4	30	57	D5407046	4.6	47	80
D5407025	2.5	30	57	D5407047	4.7	47	80
D5407026	2.6	30	57	D5407048	4.8	52	86
D5407027	2.7	33	61	D5407049	4.9	52	86
D5407028	2.8	33	61	D5407050	5.0	52	86
D5407029	2.9	33	61	D5407051	5.1	52	86
D5407030	3.0	33	61	D5407052	5.2	52	86
D5407031	3.1	36	65	D5407053	5.3	52	86

▶ TiN (D6407), TiCN (DG407), TiAlN (DH407) 可根据客户需求进行加工。  
TiN(D6407), TiCN(DG407) and TiAlN(DH407) are available on your request.

◎ : 优(Excellent) ○ : 良(Good)

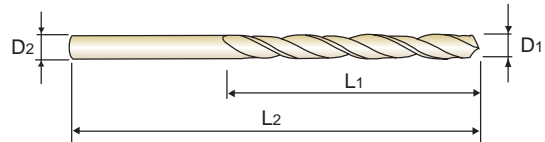
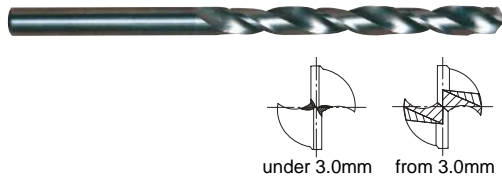
碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
-HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○	○	○	○	◎		

**硬质合金钻头  
CARBIDE DRILLS**

细长  
**JOBBER**

▶ 应用：用于加工一般的钢件，铸钢，铸铁，冷硬铸铁，可锻铸铁，非铁重金属，非铁轻金属，耐磨塑料等材料

▶ Application : Drilling steels in general, cast steels, cast iron, chilled cast iron, malleable cast iron, non-ferrous heavy metals, non-ferrous light metals, abrasive plastics.



DIN 338
MG
N 30°
h6
h7
118°
P.106

D<sub>1</sub>=D<sub>2</sub>

				单位(Unit) : mm			
型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D <sub>1</sub>	L <sub>1</sub>	L <sub>2</sub>	TiAlN	D <sub>1</sub>	L <sub>1</sub>	L <sub>2</sub>
D5407054	5.4	57	93	D5407070	7.0	69	109
D5407055	5.5	57	93	D5407075	7.5	69	109
D5407056	5.6	57	93	D5407080	8.0	75	117
D5407057	5.7	57	93	D5407085	8.5	75	117
D5407058	5.8	57	93	D5407090	9.0	81	125
D5407059	5.9	57	93	D5407095	9.5	81	125
D5407060	6.0	57	93	D5407100	10.0	87	133
D5407061	6.1	63	101	D5407102	10.2	87	133
D5407062	6.2	63	101	D5407105	10.5	87	133
D5407063	6.3	63	101	D5407110	11.0	94	142
D5407064	6.4	63	101	D5407115	11.5	94	142
D5407065	6.5	63	101	D5407120	12.0	101	151
D5407068	6.8	69	109	D5407130	13.0	101	151

▶ TiN (D6407), TiCN (DG407), TiAlN (DH407) 可根据客户需求进行加工。  
TiN(D6407), TiCN(DG407) and TiAlN(DH407) are available on your request.

碳钢 Carbon Steels	合金钢 Alloy Steels	预硬钢 Prehardened Steels	硬化钢 Hardened Steels		铸铁 Cast Iron	铝 Aluminum	不锈钢 Stainless Steels	钛 Titanium	低碳钢 Mild Steels	铜 Copper	青铜 Bronze
-HB225	HB225~325	HRC30~45	HRC45~55	HRC55~							
◎	◎				○	○	○	○	◎		

I-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA





**GENERAL CARBIDE DRILLS**

**D5401 SERIES**

**硬质合金钻头**

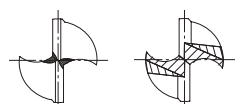
**CARBIDE DRILLS**

常规

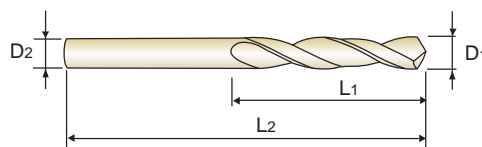
**REGULAR**

▶ 应用：用于加工一般的钢件，铸钢，铸铁，冷硬铸铁，可锻铸铁，非铁重金属，非铁轻金属，耐磨塑料等材料

▶ **Application** : Drilling into steel in general, cast steel, cast iron, chilled cast iron, malleable cast iron, nonferrous heavy metal, non-ferrous light metal, abrasive plastic.



under 3.0mm from 3.0mm



D1=D2

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D1	L1	L2	TiAlN	D1	L1	L2
D5401010	1.0	10	32	D5401041	4.1	34	60
D5401011	1.1	10	32	D5401042	4.2	34	60
D5401012	1.2	10	32	D5401043	4.3	34	60
D5401013	1.3	10	32	D5401044	4.4	34	60
D5401014	1.4	10	32	D5401045	4.5	34	60
D5401015	1.5	13	35	D5401046	4.6	38	65
D5401016	1.6	13	35	D5401047	4.7	38	65
D5401017	1.7	13	35	D5401048	4.8	38	65
D5401018	1.8	13	35	D5401049	4.9	38	65
D5401019	1.9	13	35	D5401050	5.0	38	65
D5401020	2.0	18	40	D5401051	5.1	38	65
D5401021	2.1	18	40	D5401052	5.2	38	65
D5401022	2.2	18	40	D5401053	5.3	38	65
D5401023	2.3	18	40	D5401054	5.4	38	65
D5401024	2.4	18	40	D5401055	5.5	38	65
D5401025	2.5	22	45	D5401056	5.6	40	75
D5401026	2.6	22	45	D5401057	5.7	40	75
D5401027	2.7	22	45	D5401058	5.8	40	75
D5401028	2.8	22	45	D5401059	5.9	40	75
D5401029	2.9	22	45	D5401060	6.0	40	75
D5401030	3.0	25	50	D5401061	6.1	40	75
D5401031	3.1	25	50	D5401062	6.2	40	75
D5401032	3.2	25	50	D5401063	6.3	40	75
D5401033	3.3	28	50	D5401064	6.4	40	75
D5401034	3.4	28	50	D5401065	6.5	40	75
D5401035	3.5	28	50	D5401066	6.6	46	80
D5401036	3.6	30	55	D5401067	6.7	46	80
D5401037	3.7	30	55	D5401068	6.8	46	80
D5401038	3.8	30	55	D5401069	6.9	46	80
D5401039	3.9	30	55	D5401070	7.0	46	80
D5401040	4.0	30	55	D5401071	7.1	46	80

▶ TiN (D6401), TiCN (DG401), TiAlN (H4401) 可根据客户需求进行加工。  
TiN(D6401), TiCN(DG401) and TiAlN(H4401) are available on your request.

◎ : 优(Excellent) ○ : 良(Good)

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
-HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○	○	○	○	◎		

i-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

DREAM DRILLS for HARDENED STEELS

GENERAL CARBIDE DRILLS

NC-SPOTTING DRILLS

MULTI-1 DRILLS

HPD DRILLS

GOLD-P DRILLS

WORM PATTERN DRILLS

STRAIGHT SHANK DRILLS

TAPER SHANK DRILLS

NC-SPOTTING DRILLS

CENTER DRILLS

SPADE DRILLS

TECHNICAL DATA



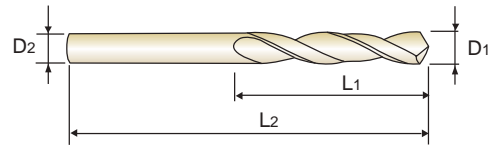
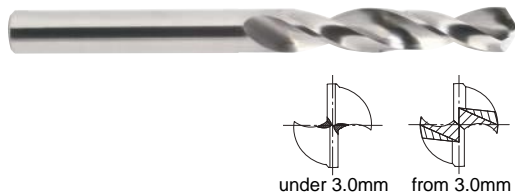
**硬质合金钻头  
CARBIDE DRILLS**

常规

**REGULAR**

▶ 应用：用于加工一般的钢件，铸钢，铸铁，冷硬铸铁，可锻铸铁，非铁重金属，非铁轻金属，耐磨塑料等材料

▶ Application : Drilling into steel in general, cast steel, cast iron, chilled cast iron, malleable cast iron, nonferrous heavy metal, non-ferrous light metal, abrasive plastic.



MG N 30° h6 h7 118° P.106

D<sub>1</sub>=D<sub>2</sub>

单位(Unit) : mm

型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length	型号 EDP No.	刃径 Drill Diameter	刃长 Flute Length	全长 Overall Length
TiAlN	D <sub>1</sub>	L <sub>1</sub>	L <sub>2</sub>	TiAlN	D <sub>1</sub>	L <sub>1</sub>	L <sub>2</sub>
D5401072	7.2	46	80	D5401102	10.2	60	115
D5401073	7.3	46	80	D5401103	10.3	60	115
D5401074	7.4	46	80	D5401104	10.4	60	115
D5401075	7.5	46	80	D5401105	10.5	60	115
D5401076	7.6	50	85	D5401106	10.6	60	115
D5401077	7.7	50	85	D5401107	10.7	60	115
D5401078	7.8	50	85	D5401108	10.8	60	115
D5401079	7.9	50	85	D5401109	10.9	60	115
D5401080	8.0	50	85	D5401110	11.0	60	115
D5401081	8.1	50	85	D5401111	11.1	65	120
D5401082	8.2	50	85	D5401112	11.2	65	120
D5401083	8.3	50	85	D5401113	11.3	65	120
D5401084	8.4	50	85	D5401114	11.4	65	120
D5401085	8.5	50	85	D5401115	11.5	65	120
D5401086	8.6	50	95	D5401116	11.6	65	120
D5401087	8.7	50	95	D5401117	11.7	65	120
D5401088	8.8	50	95	D5401118	11.8	65	120
D5401089	8.9	50	95	D5401119	11.9	65	120
D5401090	9.0	50	95	D5401120	12.0	65	120
D5401091	9.1	50	95	D5401121	12.1	65	125
D5401092	9.2	50	95	D5401122	12.2	65	125
D5401093	9.3	50	95	D5401123	12.3	65	125
D5401094	9.4	50	95	D5401124	12.4	65	125
D5401095	9.5	50	95	D5401125	12.5	65	125
D5401096	9.6	50	100	D5401126	12.6	65	125
D5401097	9.7	50	100	D5401127	12.7	65	125
D5401098	9.8	50	100	D5401128	12.8	65	125
D5401099	9.9	50	100	D5401129	12.9	65	125
D5401100	10.0	50	100	D5401130	13.0	65	125
D5401101	10.1	60	115				

▶ TiN (D6401), TiCN (DG401), TiAlN (H4401) 可根据客户需求进行加工。  
TiN(D6401), TiCN(DG401) and TiAlN(H4401) are available on your request.

◎ : 优(Excellent) ○ : 良(Good)

碳钢	合金钢	预硬钢	硬化钢		铸铁	铝	不锈钢	钛	低碳钢	铜	青铜
Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		Cast Iron	Aluminum	Stainless Steels	Titanium	Mild Steels	Copper	Bronze
-HB225	HB225~325	HRc30~45	HRc45~55	HRc55~							
◎	◎				○	○	○	○	◎		

I-DREAM DRILLS

DREAM DRILLS -GENERAL

DREAM DRILLS -SOFT

DREAM DRILLS -INOX

DREAM DRILLS -MQL TYPE

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**GENERAL CARBIDE DRILLS**

推荐的切削条件

RECOMMENDED CUTTING CONDITIONS

**硬质合金钻头, DIN6539, DIN338  
CARBIDE DRILLS, DIN6539, DIN338**

**D5405, D5407, D5401 SERIES**

单位(Unit) : mm

被加工材料	普通钢		合金钢		软灰铸铁		硬灰铸铁		不锈钢		铝硅合金 Si < 10%		铝硅合金 Si > 10%		钛, 镍合金钢	
WORK MATERIAL	NON-ALLOY STEELS		ALLOY STEELS		SOFT GREY CAST IRON		HARD GREY CAST IRON		STAINLESS STEELS		Al-Si ALLOYS, Si < 10%		Al-Si ALLOYS, Si > 10%		Ti, Ni ALLOY STEELS	
STRENGTH	< 700 N/mm <sup>2</sup>		< 1000 N/mm <sup>2</sup>		< HB240, GG25		< HB300, GG40									
DIAMETER	N	S	N	S	N	S	N	S	N	S	N	S	N	S	N	S
1.0	23000	0.03	17200	0.03	32000	0.04	23000	0.04	12000	0.04	54000	0.05	42000	0.05	11800	0.02
2.0	11500	0.04	8600	0.04	16000	0.05	11500	0.05	6000	0.03	27000	0.06	21000	0.06	5900	0.03
3.0	7800	0.05	5750	0.05	10500	0.06	7600	0.06	4000	0.04	18000	0.07	14000	0.07	3900	0.04
4.0	5800	0.06	4300	0.06	7800	0.07	5700	0.07	3000	0.05	13000	0.08	10500	0.08	2950	0.05
5.0	4700	0.07	3450	0.07	6200	0.08	4550	0.08	2400	0.06	10500	0.09	8500	0.09	2350	0.06
6.0	3900	0.08	2850	0.08	5200	0.09	3800	0.09	2000	0.07	8800	0.11	7100	0.11	1950	0.07
7.0	3350	0.09	2450	0.09	4500	0.10	3250	0.10	1700	0.08	7600	0.13	6100	0.13	1700	0.08
8.0	2900	0.10	2150	0.10	3900	0.12	2850	0.12	1500	0.09	6600	0.15	5350	0.15	1450	0.09
9.0	2600	0.11	1900	0.11	3450	0.14	2550	0.14	1350	0.10	5900	0.17	4750	0.17	1300	0.10
10.0	2350	0.12	1700	0.12	3100	0.16	2300	0.16	1200	0.11	5300	0.19	4250	0.19	1200	0.11
11.0	2150	0.13	1600	0.13	2850	0.18	2100	0.18	1100	0.12	4850	0.21	3900	0.21	1050	0.12
12.0	1950	0.14	1450	0.14	2600	0.20	1900	0.20	1000	0.13	4450	0.23	3550	0.23	980	0.13
13.0	1800	0.16	1350	0.16	2400	0.20	1750	0.20	950	0.13	4100	0.25	3300	0.25	905	0.13

N = R.P.M

S = Feed per Revolution (mm/rev.)

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