V-ADS

Work Materials	Carbon steels 1010, 1018, 1035, 1045, 1065		Alloy Steels 4140, 4340		Prehardened Steels Tool Steels Die Steels 30~38HRC		Stainless Steels Austenitic 304, 316		Stainless Steels Martensitic Ferritic 420, 440, 430	
Drill Diameter (mm)	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR	Speed RPM	Feed IPR
Ø0.30~0.59	14,000~12,500	0.00024~0.0005	14,000~12,500	0.00016~0.0005	11,000~9,500	0.00008~0.00032	6,600	0.00002~0.00004	10,000~8,000	0.00002~0.00004
Ø0.60~1.09	11,000~9,500	0.0005~0.001	10,000~8,000	0.00032~0.0008	8,000~6,400	0.00012~0.0004	6,600~6,200	0.00004~0.0002	8,000~6,900	0.00004~0.0002
Ø1.10~2.09	8,700~8,000	0.001~0.0028	7,200~6,400	0.0005~0.001	5,800~4,000	0.0004~0.0006	5,600~4,200	0.0002~0.0008	6,900~6,200	0.0002~0.0008
Ø2.10~2.99	7,600~5,500	0.0028~0.004	6,000~4,400	0.001~0.002	4,000~3,300	0.0006~0.0008	3,900~2,900	0.0008~0.0012	5,900~4,300	0.0008~0.0012
Ø3.00~6.00	5,300~3,200	0.004~0.005	4,200~2,500	0.002~0.004	3,200~1,900	0.0008~0.0016	2,800~1,700	0.0012~0.002	4,200~2,500	0.0012~0.002

Work Materials	Cast Iron	
Drill Diameter (mm)	Speed RPM	Feed IPR
Ø0.30~0.59	14,000~12,500	0.0005~0.001
Ø0.60~1.09	12,000	0.0005~0.002
Ø1.10~2.09	11,000~8,000	0.0028~0.008
Ø2.10~2.99	7,600~5,500	0.0028~0.008
Ø3.00~6.00	5,300~3,900	0.005~0.01

Drill Diameter	Pecking Distance
Ø0.30~Ø0.49	10% of drill diameter
Ø0.50~Ø1.00	20% of drill diameter
Above Ø1.00	*25-50% of drill diameter

*Start at 25% and increase if needed, to 50%

Remarks:

1) It is recommended to start with the lowest speed and feed shown in the table. They may be gradually increased in order to obtain the most appropriate condition.
2) To prevent vibration, overhanging of the tool from the chuck should be minimized.
3) If your machine cannot meet the recommended rotation speed, please use the higher speed and adjust the feed rate appropriately.