

**DH450** SERIES

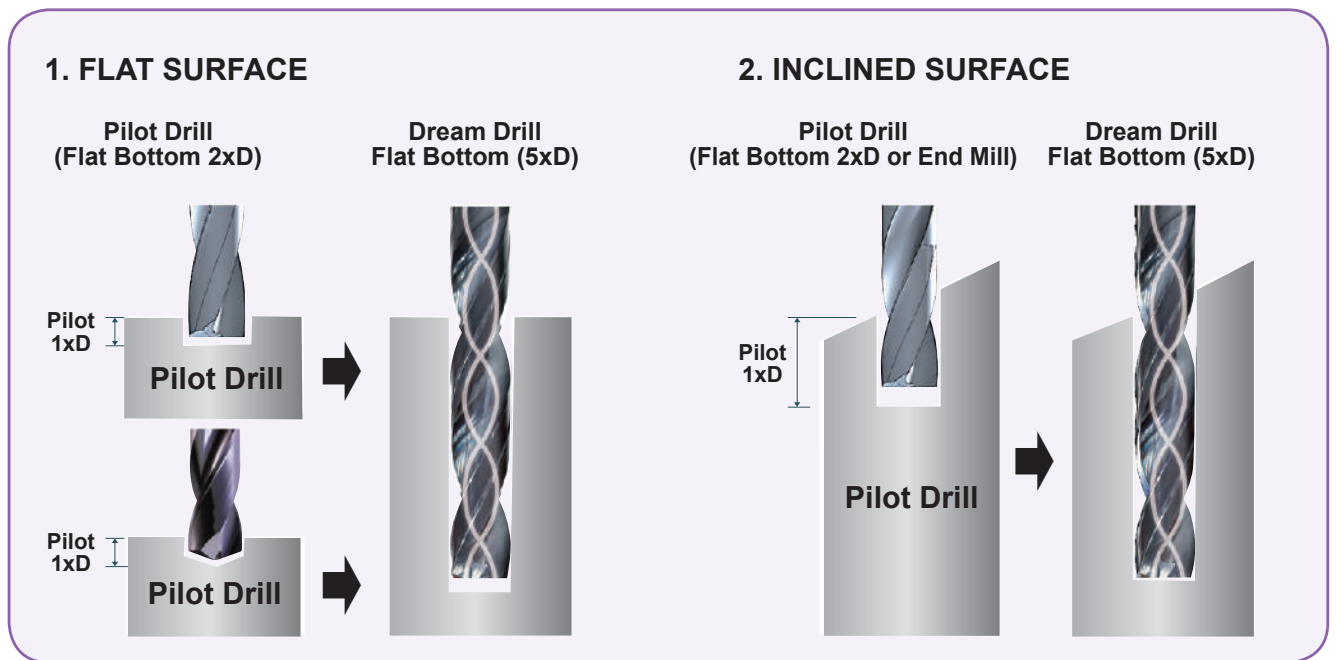
with COOLANT HOLES (5XD)

Vc = m/min  
RPM = rev./min.  
FEED = mm/rev.

ISO	VDI 3323	Material Description	Vc	Parameter	Drill Diameter (mm)								
					3.0	4.0	5.0	6.0	8.0	10.0	12.0	16.0	20.0
P	1	Non-alloy steel	100	RPM	10610	7960	6370	5310	3980	3180	2650	1990	1590
				FEED	0.05-0.09	0.08-0.12	0.09-0.15	0.12-0.18	0.18-0.24	0.24-0.30	0.26-0.36	0.38-0.48	0.50-0.60
			90	RPM	9550	7160	5730	4770	3580	2860	2390	1790	1430
	FEED			0.02-0.05	0.04-0.08	0.04-0.10	0.06-0.12	0.10-0.16	0.14-0.20	0.14-0.24	0.22-0.32	0.30-0.40	
	90		RPM	9550	7160	5730	4770	3580	2860	2390	1790	1430	
			FEED	0.02-0.05	0.04-0.08	0.04-0.10	0.06-0.12	0.10-0.16	0.14-0.20	0.14-0.24	0.22-0.32	0.30-0.40	
	75	RPM	7960	5970	4770	3980	2980	2390	1990	1490	1190		
		FEED	0.02-0.04	0.03-0.06	0.05-0.08	0.05-0.09	0.06-0.12	0.09-0.15	0.08-0.18	0.14-0.24	0.20-0.30		
	75	RPM	7960	5970	4770	3980	2980	2390	1990	1490	1190		
FEED		0.02-0.04	0.03-0.06	0.05-0.08	0.05-0.09	0.06-0.12	0.09-0.15	0.08-0.18	0.14-0.24	0.20-0.30			
Low alloy steel	6	85	RPM	9020	6760	5410	4510	3380	2710	2250	1690	1350	
			FEED	0.02-0.05	0.04-0.08	0.04-0.10	0.06-0.12	0.10-0.16	0.14-0.20	0.14-0.24	0.22-0.32	0.30-0.40	
	75	RPM	7960	5970	4770	3980	2980	2390	1990	1490	1190		
		FEED	0.02-0.05	0.04-0.08	0.04-0.10	0.06-0.12	0.10-0.16	0.14-0.20	0.14-0.24	0.22-0.32	0.30-0.40		
	75	RPM	7960	5970	4770	3980	2980	2390	1990	1490	1190		
		FEED	0.02-0.04	0.03-0.06	0.05-0.08	0.05-0.09	0.06-0.12	0.09-0.15	0.08-0.18	0.14-0.24	0.20-0.30		
50	RPM	5310	3980	3180	2650	1990	1590	1330	990	800			
	FEED	0.02-0.04	0.03-0.06	0.05-0.08	0.05-0.09	0.06-0.12	0.09-0.15	0.08-0.18	0.14-0.24	0.20-0.30			
M	12	Stainless steel	60	RPM	6370	4770	3820	3180	2390	1910	1590	1190	950
K	15	Grey cast iron	90	RPM	9550	7160	5730	4770	3580	2860	2390	1790	1430
				FEED	0.02-0.05	0.03-0.06	0.05-0.08	0.05-0.09	0.06-0.12	0.09-0.15	0.08-0.18	0.14-0.24	0.20-0.30
75	RPM		7960	5970	4770	3980	2980	2390	1990	1490	1190		
	FEED		0.02-0.05	0.02-0.05	0.03-0.06	0.03-0.07	0.04-0.10	0.07-0.13	0.06-0.16	0.11-0.21	0.15-0.25		
N	21	Aluminum-wrought alloy	160	RPM	16980	12730	10190	8490	6370	5090	4240	3180	2550
				FEED	0.05-0.09	0.08-0.12	0.09-0.15	0.12-0.18	0.18-0.24	0.24-0.30	0.26-0.36	0.38-0.48	0.50-0.60
	160		RPM	16980	12730	10190	8490	6370	5090	4240	3180	2550	
			FEED	0.05-0.09	0.08-0.12	0.09-0.15	0.12-0.18	0.18-0.24	0.24-0.30	0.26-0.36	0.38-0.48	0.50-0.60	

- ▶ Required pilot hole of the same diameter before using the 5xD Flat bottom Drills.
- ▶ The above table values is for under 5xD depth with pilot drilling operation.

**DREAM DRILLS FLAT BOTTOM - Pilot Drilling for 5 X D**



- ▶ For Flat bottom 5xD drilling depth, Slope surface needs Pilot Drilling with YG-1 Flat Bottom Drill (2XD) and Flat surface needs Pilot Drilling with YG-1 Dream Drill General.
- ▶ Pilot Drilling Depth : around 1XD
- ▶ Pilot Drilling Diameter : same size diameter