

DH414, DH722, DH404, DH423, DH424 SERIES

without COOLANT HOLES

SFM = ft/min.
RPM = rev./min.
FEED = inch/rev.

ISO	VDI 3323	Material Description	SFM		Drill Diameter		SFM		Drill Diameter		SFM		Drill Diameter																
			1.0~2.9	METRIC	1.0	2.0	3.0~20.0	METRIC	3.0	-	4.0	-	5.0	6.0	-	-	8.0	-	10.0	12.0	-	14.0	-	-	16.0	18.0	-	20.0	
			-	FRACTIONAL	-	-	1/8~3/4	FRACTIONAL	-	1/8	-	3/16	-	-	1/4	5/16	-	3/8	-	-	-	1/2	-	9/16	5/8	-	-	3/4	-
			.0394~.0787	DECIMAL	.0394	.0787	.1181~.7874	DECIMAL	.1181	.1250	.1575	.1875	.1969	.2362	.2500	.3125	.3150	.3750	.3937	.4724	.5000	.5512	.5625	.6250	.6299	.7087	.7500	.7874	
P	2	Non-alloy steel	230	RPM	22280	11140	329	RPM	10610	7960	6370	5310	3980	3180	2650	2510	2270	1990	1770	1680	1590								
				FEED	.0012-.002	.002-.0028		FEED	.0024-.0047	.0031-.0055	.0055-.0079	.0063-.0087	.0071-.0094	.0087-.011	.0079-.0118	.0079-.0118	.0087-.0126	.0094-.0134	.011-.015	.011-.015	.011-.015	.0118-.0157							
			3	230	RPM	22280	11140	329	RPM	10610	7960	6370	5310	3980	3180	2650	2510	2270	1990	1770	1680	1590							
	FEED	.0012-.002			.002-.0028	FEED	.0024-.0047		.0031-.0055	.0055-.0079	.0063-.0087	.0071-.0094	.0087-.011	.0079-.0118	.0079-.0118	.0087-.0126	.0094-.0134	.011-.015	.011-.015	.011-.015	.0118-.0157								
	4	230	RPM	22280	11140	329	RPM	10610	7960	6370	5310	3980	3180	2650	2510	2270	1990	1770	1680	1590									
			FEED	.0012-.002	.002-.0028		FEED	.0016-.0039	.0028-.0051	.0039-.0063	.0047-.0071	.0055-.0079	.0071-.0094	.0055-.0094	.0055-.0094	.0063-.0102	.0071-.011	.0079-.0118	.0079-.0118	.0087-.0126									
	5	197	RPM	19100	9550	263	RPM	8490	6370	5090	4240	3180	2550	2120	2010	1820	1590	1410	1340	1270									
			FEED	.0012-.002	.002-.0028		FEED	.0016-.0039	.0028-.0051	.0039-.0063	.0047-.0071	.0055-.0079	.0071-.0094	.0055-.0094	.0055-.0094	.0063-.0102	.0071-.011	.0079-.0118	.0079-.0118	.0087-.0126									
	6	230	RPM	22280	11140	329	RPM	10610	7960	6370	5310	3980	3180	2650	2510	2270	1990	1770	1680	1590									
			FEED	.0012-.002	.002-.0028		FEED	.0024-.0047	.0031-.0055	.0055-.0079	.0063-.0087	.0071-.0094	.0087-.011	.0079-.0118	.0079-.0118	.0087-.0126	.0094-.0134	.011-.015	.011-.015	.011-.015	.0118-.0157								
	7	197	RPM	19100	9550	263	RPM	8490	6370	5090	4240	3180	2550	2120	2010	1820	1590	1410	1340	1270									
FEED			.0012-.002	.002-.0028	FEED		.0024-.0047	.0031-.0055	.0039-.0063	.0047-.0071	.0055-.0079	.0071-.0094	.0055-.0079	.0055-.0094	.0063-.0102	.0071-.011	.0079-.0118	.0079-.0118	.0087-.0126										
8	197	RPM	19100	9550	263	RPM	8490	6370	5090	4240	3180	2550	2120	2010	1820	1590	1410	1340	1270										
		FEED	.0008-.0016	.0012-.002		FEED	.0016-.0039	.0028-.0051	.0039-.0063	.0047-.0071	.0055-.0079	.0071-.0094	.0055-.0094	.0055-.0094	.0063-.0102	.0071-.011	.0079-.0118	.0079-.0118	.0087-.0126										
9	99	RPM	9550	4770	132	RPM	4240	3180	2550	2120	1590	1270	1060	1010	910	800	710	670	640										
		FEED	.0008-.0016	.0012-.002		FEED	.0012-.0031	.002-.0043	.0031-.0055	.0039-.0063	.0047-.0071	.0055-.0079	.0047-.0087	.0047-.0087	.0051-.0091	.0055-.0094	.0063-.0102	.0063-.0102	.0071-.011										
10	165	RPM	15920	7960	230	RPM	7430	5570	4460	3710	2790	2230	1860	1760	1590	1390	1240	1170	1110										
		FEED	.0012-.002	.002-.0028		FEED	.0016-.0039	.0028-.0051	.0039-.0063	.0047-.0071	.0055-.0079	.0071-.0094	.0055-.0094	.0055-.0094	.0063-.0102	.0071-.011	.0079-.0118	.0079-.0118	.0087-.0126										
11	99	RPM	9550	4770	132	RPM	4240	3180	2550	2120	1590	1270	1060	1010	910	800	710	670	640										
		FEED	.0008-.0016	.0012-.002		FEED	.0012-.0031	.002-.0043	.0031-.0055	.0039-.0063	.0047-.0071	.0055-.0079	.0047-.0087	.0047-.0087	.0051-.0091	.0055-.0094	.0063-.0102	.0063-.0102	.0071-.011										
M	12	Stainless steel	165	RPM	15920	7960	230	RPM	7430	5570	4460	3710	2790	2230	1860	1760	1590	1390	1240	1170	1110								
				FEED	.0012-.002	.002-.0028		FEED	.0024-.0047	.0031-.0055	.0055-.0079	.0063-.0087	.0071-.0094	.0087-.011	.0079-.0118	.0079-.0118	.0087-.0126	.0094-.0134	.011-.015	.011-.015	.0118-.0157								
13	115	RPM	11140	5570	148	RPM	4770	3580	2860	2390	1790	1430	1190	1130	1020	900	800	750	720										
		FEED	.0008-.0016	.0012-.002		FEED	.0016-.0039	.0028-.0051	.0039-.0063	.0047-.0071	.0055-.0079	.0071-.0094	.0055-.0094	.0055-.0094	.0063-.0102	.0071-.011	.0079-.0118	.0079-.0118	.0087-.0126										
K	15	Grey cast iron	230	RPM	22280	11140	329	RPM	10610	7960	6370	5310	3980	3180	2650	2510	2270	1990	1770	1680	1590								
				FEED	.0016-.0024	.0016-.0024		FEED	.0031-.0055	.0047-.0071	.0071-.0094	.0055-.0102	.0063-.011	.0094-.0134	.0102-.0142	.0102-.0142	.011-.015	.0118-.0157	.0126-.0165	.0126-.0165	.0134-.0173								
	16	214	RPM	20690	10350	263	RPM	8490	6370	5090	4240	3180	2550	2120	2010	1820	1590	1410	1340	1270									
			FEED	.0016-.0024	.0016-.0024		FEED	.0024-.0047	.0031-.0055	.0055-.0079	.0063-.0087	.0071-.0094	.0087-.011	.0079-.0118	.0079-.0118	.0087-.0126	.0094-.0134	.011-.015	.011-.015	.0118-.0157									
	17	230	RPM	22280	11140	329	RPM	10610	7960	6370	5310	3980	3180	2650	2510	2270	1990	1770	1680	1590									
			FEED	.0016-.0024	.0016-.0024		FEED	.0031-.0055	.0047-.0071	.0071-.0094	.0055-.0102	.0063-.011	.0094-.0134	.0102-.0142	.0102-.0142	.011-.015	.0118-.0157	.0126-.0165	.0126-.0165	.0134-.0173									
18	165	RPM	15920	7960	230	RPM	7430	5570	4460	3710	2790	2230	1860	1760	1590	1390	1240	1170	1110										
		FEED	.0016-.0024	.0016-.0024		FEED	.0024-.0047	.0031-.0055	.0055-.0079	.0063-.0087	.0071-.0094	.0087-.011	.0079-.0118	.0079-.0118	.0087-.0126	.0094-.0134	.011-.015	.011-.015	.0118-.0157										
19	197	RPM	19100	9550	263	RPM	8490	6370	5090	4240	3180	2550	2120	2010	1820	1590	1410	1340	1270										
		FEED	.0016-.0024	.0016-.0024		FEED	.0031-.0055	.0047-.0071	.0071-.0094	.0055-.0102	.0063-.011	.0094-.0134	.0102-.0142	.0102-.0142	.011-.015	.0118-.0157	.0126-.0165	.0126-.0165	.0134-.0173										
20	165	RPM	15920	7960	230	RPM	7430	5570	4460	3710	2790	2230	1860	1760	1590	1390	1240	1170	1110										
		FEED	.0012-.002	.002-.0028		FEED	.0024-.0047	.0031-.0055	.0055-.0079	.0063-.0087	.0071-.0094	.0087-.011	.0079-.0118	.0079-.0118	.0087-.0126	.0094-.0134	.011-.015	.011-.015	.0118-.0157										
H	38	Hardened steel	66	RPM	7960	3980	82	RPM	2650	1990	1590	1330	990	800	660	630	570	500	440	420	400								
				FEED	.0004-.0008	.0004-.0012		FEED	.0004-.0012	.0004-.0016	.0008-.002	.0012-.0024	.0012-.0024	.0016-.0028	.0016-.0031	.002-.0035	.002-.0035	.002-.0039	.002-.0039	.002-.0039	.002-.0039	.002-.0039	.002-.0039	.002-.0039	.002-.0039	.002-.0039	.002-.0039		

▶ Recommend to reduce the feed rate as following
Feed 100% : DH414(3xD), DH404(3xD), DH423(3xD) **Feed 80%** : DH722(5xD), DH424(5xD)