

DH416, DH418, DH711, DH712, DH406, DH408, DH421 SERIES

with COOLANT HOLES

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

ISO	VDI 3323	Material Description	SFM		Drill Diameter						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	263	RPM	25460	12730	362	RPM	11670	8750	7000	5840	4380	3500	2920	2770	2500	2190	1950	1840	1750							
				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							
			3	263	RPM	25460	12730	362	RPM	11670	8750	7000	5840	4380	3500	2920	2770	2500	2190	1950	1840	1750						
					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						
	4	263	RPM	25460	12730	362	RPM	11670	8750	7000	5840	4380	3500	2920	2770	2500	2190	1950	1840	1750								
			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	230	RPM	22280	11140	296	RPM	9550	7160	5730	4770	3580	2860	2390	2260	2050	1790	1590	1510	1430								
			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	263	Low alloy steel	RPM	25460	12730	362	RPM	11670	8750	7000	5840	4380	3500	2920	2770	2500	2190	1950	1840	1750							
				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							
RPM				22280	11140	296		RPM	9550	7160	5730	4770	3580	2860	2390	2260	2050	1790	1590	1510	1430							
FEED				.0012-.002	.002-.0028			FEED	.0024-.0047	.0031-.0055	.0039-.0079	.0047-.0094	.0063-.011	.0079-.0118	.0083-.0118	.0083-.0118	.0087-.0138	.0098-.0142	.011-.015	.011-.015	.0118-.0157							
8	230	RPM	22280	11140	296	RPM	9550	7160	5730	4770	3580	2860	2390	2260	2050	1790	1590	1510	1430									
		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	132	RPM	12730	6370	165	RPM	5310	3980	3180	2650	1990	1590	1330	1260	1140	990	880	840	800									
		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	198	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									
11	132	RPM	12730	6370	148	RPM	4770	3580	2860	2390	1790	1430	1190	1130	1020	900	800	750	720									
		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	198	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	.0055-.0079	.0063-.0087	.0071-.0094	.0087-.011	.0079-.0118	.0079-.0118	.0087-.0126	.0094-.0134	.011-.015	.011-.015	.0118-.0157								
13	148	RPM	14320	7160	181	RPM	5840	4380	3500	2920	2190	1750	1460	1380	1250	1090	970	920	880									
		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	263	RPM	25460	12730	362	RPM	11670	8750	7000	5840	4380	3500	2920	2770	2500	2190	1950	1840	1750								
			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	247	RPM	23870	11940	313	RPM	10080	7560	6050	5040	3780	3020	2520	2390	2160	1890	1680	1590	1510								
			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	296	RPM	28650	14320	395	RPM	12730	9550	7640	6370	4770	3820	3180	3020	2730	2390	2120	2010	1910								
			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	198	RPM	19100	9550	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									
19	230	RPM	22280	11140	296	RPM	9550	7160	5730	4770	3580	2860	2390	2260	2050	1790	1590	1510	1430									
		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	198	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	.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	82	RPM	9550	4770	99	RPM	3180	2390	1910	1590	1190	950	800	750	680	600	530	500	480							
				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							

▶ Recommend to reduce the feed rate as following
Feed 100% : DH416/DH711(3xD), DH406(3xD) **Feed 80%** : DH418/DH712(5xD), DH408(5xD) **Feed 70%** : DH421(8xD)