

DH463, DH714, DH464, DH715, DH451, DH452, DH453 SERIES

with COOLANT HOLES

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

ISO	VDI 3323	Material Description	SFM	Drill Diameter			SFM	Drill Diameter												SFM									
				METRIC	1.0	2.0		METRIC	3.0	-	4.0	-	5.0	6.0	-	-	8.0	-	10.0		12.0	-	14.0	-	-	16.0	18.0	-	20.0
				FRACTIONAL	-	-		FRACTIONAL	-	1/8	-	3/16	-	-	1/4	5/16	-	3/8	-		-	1/2	-	9/16	5/8	-	-	3/4	-
DECIMAL	.0394	.0787	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	.0008-.0016	.0016-.0024		FEED	.0016-.0039	.0024-.0047	.0047-.0071	.0055-.0079	.0063-.0087	.0079-.0102	.0071-.011	.0071-.011	.0079-.0118	.0087-.0126	.0102-.0142	.0102-.0142	.011-.015								
	3	Non-alloy steel	230	RPM	22280	11140	329	RPM	10610	7960	6370	5310	3980	3180	2650	2510	2270	1990	1770	1680	1590								
				FEED	.0008-.0016	.0016-.0024		FEED	.0016-.0039	.0024-.0047	.0047-.0071	.0055-.0079	.0063-.0087	.0079-.0102	.0071-.011	.0071-.011	.0079-.0118	.0087-.0126	.0102-.0142	.0102-.0142	.011-.015								
6	Low alloy steel	230	RPM	22280	11140	329	RPM	10610	7960	6370	5310	3980	3180	2650	2510	2270	1990	1770	1680	1590									
			FEED	.0008-.0016	.0016-.0024		FEED	.0016-.0039	.0024-.0047	.0047-.0071	.0055-.0079	.0063-.0087	.0079-.0102	.0071-.011	.0071-.011	.0079-.0118	.0087-.0126	.0102-.0142	.0102-.0142	.011-.015									
7	Low alloy steel	160	RPM	15920	7960	230	RPM	7430	5570	4460	3710	2790	2230	1860	1760	1590	1390	1240	1170	1110									
			FEED	.0008-.0016	.0016-.0024		FEED	.0016-.0039	.0024-.0047	.0047-.0071	.0055-.0079	.0063-.0087	.0079-.0102	.0071-.011	.0071-.011	.0079-.0118	.0087-.0126	.0102-.0142	.0102-.0142	.011-.015									
M	12	Stainless steel	130	RPM	12730	6370	165	RPM	5310	3980	3180	2650	1990	1590	1330	1260	1140	990	880	840	800								
				FEED	.0008-.0016	.0008-.0016		FEED	.0012-.002	.002-.0035	.0028-.0043	.0035-.0051	.0035-.0051	.0039-.0059	.0043-.0063	.0043-.0063	.0047-.0067	.0051-.0071	.0055-.0075	.0055-.0075	.0059-.0079								
				RPM	7960	3980		132	RPM	4240	3180	2550	2120	1590	1270	1060	1010	910	800	710	670	640							
FEED	.0008-.0016	.0008-.0016	FEED	.0012-.002	.002-.0035	.0028-.0043	.0035-.0051		.0035-.0051	.0039-.0059	.0043-.0063	.0043-.0063	.0047-.0067	.0051-.0071	.0055-.0075	.0055-.0075	.0059-.0079												
RPM	14320	7160	198	RPM	6370	4770	3820		3180	2390	1910	1590	1510	1360	1190	1060	1010	950											
FEED	.0008-.0016	.0008-.0016		FEED	.0016-.0024	.0024-.0039	.0031-.0047	.0039-.0055	.0039-.0055	.0043-.0063	.0047-.0067	.0047-.0067	.0051-.0071	.0055-.0075	.0059-.0079	.0059-.0079	.0063-.0083												
RPM	41380	20690		659	RPM	21220	15920	12730	10610	7960	6370	5310	5030	4550	3980	3540	3360	3180											
FEED	.0016-.0039	.0031-.0055	FEED		.0055-.0079	.0075-.0098	.0079-.0102	.0087-.011	.0094-.0118	.0114-.0138	.0114-.0138	.0114-.0138	.0114-.0138	.0118-.0157	.0118-.0157	.013-.0169	.013-.0169	.0138-.0177											
RPM	41380	20690	659		RPM	21220	15920	12730	10610	7960	6370	5310	5030	4550	3980	3540	3360	3180											
FEED	.0016-.0039	.0031-.0055		FEED	.0055-.0079	.0075-.0098	.0079-.0102	.0087-.011	.0094-.0118	.0114-.0138	.0114-.0138	.0114-.0138	.0114-.0138	.0118-.0157	.0118-.0157	.013-.0169	.013-.0169	.0138-.0177											
RPM	35010	17510		593	RPM	19100	14320	11460	9550	7160	5730	4770	4530	4090	3580	3180	3020	2860											
FEED	.0016-.0039	.0031-.0055	FEED		.0055-.0079	.0075-.0098	.0079-.0102	.0087-.011	.0094-.0118	.0114-.0138	.0114-.0138	.0114-.0138	.0114-.0138	.0118-.0157	.0118-.0157	.013-.0169	.013-.0169	.0138-.0177											
RPM	35010	17510	593		RPM	19100	14320	11460	9550	7160	5730	4770	4530	4090	3580	3180	3020	2860											
FEED	.0016-.0039	.0031-.0055		FEED	.0055-.0079	.0075-.0098	.0079-.0102	.0087-.011	.0094-.0118	.0114-.0138	.0114-.0138	.0114-.0138	.0114-.0138	.0118-.0157	.0118-.0157	.013-.0169	.013-.0169	.0138-.0177											
RPM	28650	14320		494	RPM	15920	11940	9550	7960	5970	4770	3980	3770	3410	2980	2650	2520	2390											
FEED	.0016-.0031	.0024-.0039	FEED		.0047-.0071	.0063-.0087	.0067-.0091	.0075-.0098	.0087-.011	.0094-.0118	.0094-.0118	.0094-.0118	.0094-.0118	.0098-.0138	.0098-.0138	.011-.015	.011-.015	.0118-.0157											
RPM	7960	3980	132		RPM	4240	3180	2550	2120	1590	1270	1060	1010	910	800	710	670	640											
FEED	.0004-.0012	.0004-.0012		FEED	.0008-.0016	.0016-.0031	.0024-.0039	.0031-.0047	.0031-.0047	.0035-.0055	.0039-.0059	.0039-.0059	.0043-.0063	.0047-.0067	.0051-.0071	.0051-.0071	.0055-.0075												

► Recommend to reduce the feed rate as following
Feed 100% : DH463/DH714/DH451(3xD), DH464/DH714/DH452(5xD)
Feed 85% : DH453(8xD)