

CUTTING SPEED BY THE METRE/MINUTE (VC M/MIN)



CONVERSION TABLE

Ø DRILL BIT													Example Stainless Steel		
mm	inch	3	4	5	6	8	10	12	15	18	20	25	30	35	40
2	5/64	480	640	800	960	1270	1590	1910	2390	2870	3180	3980	4780	5570	3670
3	1/8	320	420	530	640	850	1060	1270	1590	1910	2120	2650	3180	3720	4250
4	5/32	240	320	400	480	640	800	960	1190	1430	1590	1990	2390	2790	3180
5	13/64	190	250	320	380	510	640	760	960	1150	1270	1590	1910	2230	2550
6	15/64	160	210	270	320	420	530	640	800	960	1060	1330	1590	1860	2120
8	5/16	120	160	200	240	320	400	480	600	720	800	1000	1190	1390	1590
10	25/64	95	130	160	190	250	320	380	480	570	640	800	960	1110	1270
12	15/32	80	110	130	160	210	270	320	400	480	530	660	800	930	1060
14	35/64	70	90	110	140	180	230	270	340	410	450	570	680	800	910
16	5/8	60	80	100	120	160	200	240	300	360	400	500	600	700	800
18	23/32	55	70	90	110	140	180	210	270	320	350	440	530	620	710
20	25/32	50	65	80	100	130	160	190	240	290	320	400	480	560	640
22	7/8	45	60	70	85	120	140	170	220	260	290	360	430	510	580
24	15/16	40	55	65	80	110	130	160	200	240	270	330	400	460	530
27		35	45	60	70	95	120	140	180	210	240	290	350	410	470
30	1"1/8	30	40	55	65	85	110	130	160	190	210	270	320	370	420
32	1"1/4	30	40	50	60	80	100	120	150	180	200	250	300	350	400
34	1"3/8	30	35	45	55	75	95	110	140	170	190	230	280	330	370
36		25	35	45	55	70	90	110	130	160	180	220	270	310	350
38	1"1/2	25	35	40	50	65	85	100	130	150	170	210	250	290	340
40	1"9/16	25	30	40	50	65	80	100	120	140	160	200	240	280	320
42		25	30	40	45	60	75	90	110	140	150	190	230	270	300
44	1"3/4	20	30	35	45	60	70	85	110	130	140	180	220	250	290
46	1"13/16	20	30	35	40	55	70	85	100	120	140	170	210	240	280
48	1"7/8	20	25	35	40	55	65	80	100	120	130	170	200	230	270
50		20	25	30	40	50	65	75	100	110	130	160	190	220	270

HSS + TIN : +20% WITH WATER

HSS + TiAIN : +30-50% DRY, WARNING - NO TEMPERATURES > 850°C

CONVERSION FORMULA FOR ROTATION SPEED BETWEEN METRE/MIN AND ROTATION/MIN TAKING INTO ACCOUNT THE TOOL'S DIMENSIONS

$$N = \frac{1000 \times VC}{\pi \times D}$$

N = Drehzahl pro Minute
Rotations per minute

D = Bohrerdurchmesser
Diameter of drill bit

VC = Schnittgeschwindigkeit
Cutting speed

$\pi = 3.1416$

Example Stainless Steel

$$480 \text{ rpm} = \frac{1000 \times 12}{3,1416 \times 8 \text{ mm}}$$