

DRILLING (SOLID CARBIDE)**VCHSM**

Medium, For hardened material

CARBIDE

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardened steel X40CrMoV51, X20Cr13 etc. (50—55HRC)		Hardened steel Cr12Mo1V1, Powder high-speed steel etc. (55—60HRC)	
	Revolution (min ⁻¹)	Feed rate (mm/rev)	Revolution (min ⁻¹)	Feed rate (mm/rev)
2.5	1900	0.06	1300	0.04
3.0	1600	0.06	1100	0.04
4.0	1200	0.06	800	0.04
5.0	1000	0.06	600	0.04
6.0	800	0.06	530	0.04
8.0	600	0.07	400	0.05
10.0	480	0.07	320	0.05
12.0	400	0.07	270	0.05
14.0	340	0.07	230	0.05
16.0	300	0.07	200	0.05

- 1) Use rigid machines.
- 2) Collet chuck is recommended to maintain shank condition.
- 3) Use emulsion as cutting fluid.
- 4) Recommended depth of drilling is 3D (D:drill diameter) under these cutting conditions.