

i-DREAM DRILLS - INOX
SERIES

ISO	VDI 3323	Material Description	Vc	Ø12.00-14.99	Ø15.00-17.99	Feed Ø18.00-21.90	Ø22.00-26.99	Ø27.00-31.99
P	1	Non-alloy steel	95-120	0.16-0.28	0.21-0.35	0.27-0.40	0.34-0.52	0.37-0.55
	2		80-105	0.14-0.24	0.21-0.35	0.27-0.40	0.34-0.52	0.37-0.55
	3		60-80	0.12-0.20	0.17-0.28	0.22-0.32	0.30-0.46	0.33-0.49
	4	Low alloy steel	55-70	0.10-0.16	0.15-0.25	0.21-0.30	0.25-0.38	0.29-0.43
	6		70-90	0.12-0.20	0.17-0.28	0.22-0.32	0.30-0.46	0.34-0.50
	7		60-80	0.12-0.20	0.15-0.25	0.22-0.32	0.30-0.46	0.34-0.50
	10	High alloyed steel, and tool steel	50-65	0.10-0.16	0.13-0.21	0.18-0.26	0.20-0.31	0.24-0.35
M	12	Stainless steel	30-45	0.08-0.14	0.09-0.15	0.10-0.16	0.12-0.20	0.14-0.22
	13		30-45	0.08-0.14	0.09-0.15	0.10-0.16	0.12-0.20	0.14-0.22
	14		45-60	0.10-0.16	0.12-0.18	0.14-0.20	0.15-0.26	0.18-0.28
N	21	Aluminum-wrought alloy	250-330	0.30-0.40	0.35-0.45	0.40-0.50	0.45-0.55	0.50-0.60
	22		200-250	0.30-0.40	0.35-0.45	0.40-0.50	0.45-0.55	0.50-0.60
	23		200-250	0.25-0.35	0.30-0.40	0.35-0.45	0.40-0.50	0.45-0.55
	24	Aluminum-cast, alloyed	150-220	0.25-0.35	0.30-0.40	0.35-0.45	0.40-0.50	0.45-0.55
	25		100-200	0.20-0.30	0.25-0.35	0.30-0.40	0.35-0.45	0.40-0.50
	26		115-145	0.16-0.28	0.23-0.36	0.29-0.36	0.37-0.45	0.41-0.48
	27	Copper and Copper Alloys (Bronze / Brass)	145-185	0.17-0.29	0.24-0.37	0.30-0.38	0.38-0.46	0.42-0.49
	28		95-120	0.06-0.09	0.09-0.13	0.11-0.13	0.15-0.18	0.19-0.22

- The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.
- Speed and feed reductions (20% reduction in speed and 10% reduction in feed) are recommended.
- Recommend you to reduce the feed rate to 85%, 70% when you use 5xD, 7xD holders.
- For use of 7xD holder, we recommend to use a pilot drill with equal or larger than 140° point angle (0.5xD - 1.5xD). The use of the centering pre-hole improves hole location, roundness and surface finish.

