

**CENTRE DRILLS**

DV503, D1311, DV334, DV303, DV333, D1313, D1363 & D1343 Series

**CUTTING DATA**

DRILLING

MATERIAL	MILD STEEL		ALLOY STEELS				STAINLESS STEEL	
Hardness	< 700 N/mm <sup>2</sup>		~ HRc23		~ HRc32		-	
Diameter	Speed	Feed	RPM	Feed	RPM	Feed	RPM	Feed
2	30 ~ 45	0.02~0.05	25 ~ 30	0.02~0.05	15 ~ 25	0.01~0.03	6 ~ 10	0.01~0.03
3		0.06		0.06		0.04		0.04
6		0.08		0.08		0.06		0.06
10		0.15		0.15		0.10		0.10

EDGE PREPARATION

HOLE MAKING

TAPS & DIES

THREAD & GROOVE MILLING

TOOL HOLDING