

# Table of cutting speeds for **tube and sheet drills**

Material:		High carbon struc. steel up to 700 N/mm <sup>2</sup>	High carbon struc. steel over 700 N/mm <sup>2</sup>	Alloyed steel over 1000 N/mm <sup>2</sup>	Cast iron up to 250 N/mm <sup>2</sup>	Cast iron over 250 N/mm <sup>2</sup>	CuZn-alloy brittle	CuZn-alloy tough	Al-alloy up to 11% Si	Thermo-plastics	Duro-plastics
Sheet thickness:		up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0	up to 4,0
Vc = m/min		30	20	20	15	10	60	35	30	20	15
Cooling lubricant:		Cutting spray	Cutting spray	Cutting spray	Cutting spray	Air	Air	Air	Cutting spray	Water	Air
Size	Ø mm	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.	n = r.p.m.
No. 1	3,0-14,0	3185-682	2123-455	2123-455	1592-341	1062-227	6369-1365	3715-796	3185-682	2123-455	1592-341
No. 2	4,0-20,0	1911-478	1274-318	1274-318	955-239	637-159	3822- 955	2229-557	1911-478	1274-318	955-239
No. 3	16,0-30,5	597-313	398-209	398-209	299-157	199-104	1194- 627	697-365	597-313	398-209	299-157
No. 4	24,0-40,0	398-239	265-159	265-159	199-119	133- 80	796- 478	464-279	398-239	265-159	199-119
No. 5	36,0-50,0	265-191	177-127	177-127	133- 96	88- 64	531- 382	310-223	265-191	177-127	133- 96
No. 6	40,0-61,0	239-157	159-104	159-104	119- 78	80- 52	478- 313	279-183	239-157	159-104	119- 78
No. 7	5,0-25,4	1911-376	1274-251	1274-251	955-188	637-125	3822- 752	2229-439	1911-376	1274-251	955-188
No. 8	5,0-31,0	1911-308	1274-205	1274-205	955-154	637-103	3822- 616	2229-360	1911-308	1274-205	955-154
No. 9	5,0-22,5	1911-425	1274-283	1274-283	955-212	637-142	3822- 849	2229-495	1911-425	1274-283	955-212



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