Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition

P M K N S P K

DR Mini Oil Feed Twist Drill - Point Angle 135°, 2 Flutes, 5 x D, 8 x D - H03

Working Material	N						K				S	
	Wrought Aluminium		Cast Aluminium		Copper Alloy		Grey Cast Iron		Ductile Cast Iron		Titanium Alloy	
Properties	Si < 9%		Si ≥ 9%		-		-		-		-	
D	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1.0		0.017		0.018		0.016		0.018		0.016		0.013
1.5		0.026		0.026		0.024		0.027		0.024		0.019
2.0	145	0.035	125	0.035	115	0.032	85	0.035	65	0.032	30	0.025
2.5		0.043		0.044		0.040		0.044		0.040		0.031
3.0		0.052		0.053		0.049		0.053		0.048		0.038

DR Mini Oil Feed Twist Drill - Point Angle 135°, 2 Flutes, 5 x D, 8 x D - H03

Working Material	P						M				S		S	
	Carbon Steel		Alloy Steel		Prehardened Steel		Stainless Steel		Stainless Steel		Nickel Alloy		Cobalt Alloy	
Properties	-		520 < Rm < 1200		-		High Machinability		Low Machinability		-		-	
D	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1.0		0.017		0.016		0.014		0.015		0.014		0.009		0.022
1.5		0.026		0.024		0.022		0.022		0.021		0.016		0.036
2.0	90	0.035	80	0.031	65	0.029	60	0.029	40	0.028	20	0.025	35	0.052
2.5		0.043		0.039		0.036		0.036		0.035		0.035		0.070
3.0		0.052		0.047		0.043		0.044		0.042		0.045		0.090

DR Mini Oil Feed Twist Drill - Point Angle 135°, 2 Flutes, 12 x D, 20 x D - H03

Working Material	N						K				S	
	Wrought Aluminium		Cast Aluminium		Copper Alloy		Grey Cast Iron		Ductile Cast Iron		Titanium Alloy	
Properties	Si < 9%		Si ≥ 9%		-		-		-		-	
D	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1.0		0.016		0.016		0.015		0.014		0.014		0.010
1.5		0.025		0.024		0.022		0.021		0.021		0.016
2.0	130	0.033	115	0.032	105	0.029	80	0.028	55	0.028	30	0.021
2.5		0.041		0.039		0.037		0.035		0.035		0.026
3.0		0.049		0.047		0.044		0.042		0.042		0.031

DR Mini Oil Feed Twist Drill - Point Angle 135°, 2 Flutes, 12 x D, 20 x D - H03

Working Material	P						M				S		S	
	Carbon Steel		Alloy Steel		Prehardened Steel		Stainless Steel		Stainless Steel		Nickel Alloy		Cobalt Alloy	
Properties	-		520 < Rm < 1200		-		High Machinability		Low Machinability		-		-	
D	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1.0		0.014		0.014		0.010		0.010		0.009		0.010		0.012
1.5		0.021		0.020		0.015		0.015		0.014		0.016		0.021
2.0	85	0.028	65	0.027	55	0.020	50	0.020	40	0.019	15	0.025	35	0.045
2.5		0.035		0.034		0.025		0.025		0.024		0.035		0.070
3.0		0.042		0.041		0.031		0.030		0.028		0.044		0.060

Note: These recommended cutting data indicators are just for reference. They should be adjusted according to the different cutting condition

P M K N S P K

DR Mini Oil Feed Twist Drill - Point Angle 135°, 2 Flutes, 25 x D, 30 x D - H03

Working Material	N						K				S	
	Wrought Aluminium		Cast Aluminium		Copper Alloy		Grey Cast Iron		Ductile Cast Iron		Titanium Alloy	
Properties	Si < 9%		Si ≥ 9%		-		-		-		-	
D	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1.0		0.014		0.014		0.012		0.010		0.013		0.006
1.5		0.021		0.021		0.018		0.015		0.019		0.009
2.0	125	0.028	105	0.027	95	0.024	75	0.020	50	0.025	30	0.013
2.5		0.035		0.034		0.030		0.025		0.031		0.015
3.0		0.042		0.041		0.036		0.030		0.037		0.019

DR Mini Oil Feed Twist Drill - Point Angle 135°, 2 Flutes, 25 x D, 30 x D - H03

Working Material	P						M				S		S	
	Carbon Steel		Alloy Steel		Prehardened Steel		Stainless Steel		Stainless Steel		Nickel Alloy		Cobalt Alloy	
Properties	-		520 < Rm < 1200		-		High Machinability		Low Machinability		-		-	
D	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn	Vc	fn
1.0		0.010		0.011		0.008		0.007		0.007		0.008		0.008
1.5		0.015		0.016		0.011		0.010		0.011		0.013		0.014
2.0	80	0.020	60	0.022	50	0.015	45	0.014	35	0.014	15	0.021	30	0.022
2.5		0.025		0.027		0.019		0.017		0.018		0.030		0.031
3.0		0.031		0.033		0.022		0.021		0.021		0.038		0.060