

$$\text{rpm} = (\text{mt}/\text{min} \times 1000) / (D \times 3,14)$$

$$\text{mm}/\text{min} = \text{mm}/\text{rev} \times \text{rpm}$$

$$= \text{mt}/\text{min}$$

$$= \text{mm}/\text{rev} \text{ (vedi tabella - see table page pag. 9)}$$

PUNTE EXTRA CORTE TWIST DRILLS, STUB LENGHT												PUNTE CORTE TWIST DRILLS, JOBBER LENGHT					
DIN 1897						DIN 338											
HSS		HSS+8%Co				HSS+5%Co				HSS			HSS+5%Co				

Pag. 330	TIPO DI ACCIAIO TYPE OF STEEL	N/mm ²	HV	rml/min		mm/rev		rml/min		mm/rev		rml/min		mm/rev		rml/min		mm/rev	
				b	d	c	d	c	d	c	d	c	d	c	d	c	d	c	d
ACCIAI COMUNI COMMON STEEL	Acciai teneri Soft steel 1	500	157	30 b	42 d	55 c	60 c	38 c	50 c	57 c	30 b	37 c				30 b	35 c	50 c	
	Acciai da costruzione Structural steel 2	700	219	22 c	35 c	45 b	55 b	30 c	40 b	50 b	22 c	30 b				22 c	28 b	40 b	
	Acciai da tempra Hardening steel 3	900	280	13 c		35 b	40 b		30 b	38 b	13 c	20 b				13 c	18 b	30 b	
	Acciaio automatico Automatic steel 4	1200	373																
ACCIAI INOX STAINLESS STEEL	Acciaio automatico Automatic steel 3	850	265	17 b	26 c	32 b	36 b	22 b	28 b	34 b	17 b	22 b				17 b	20 b	28 b	
	Austenitico Austenitic 3	850	265	8 c	18 d	18 c	22 c	12 c	15 c	20 c	8 c	12 c				8 c	10 c	15 c	
	Ferritico+austenitico Ferritic austenitic 4	1000	311	10 b		22 c	26 c	15 b	18 c	24 c	10 b	15 b				10 b	13 b	18 c	
GHISA CAST IRON	Ghisa fino a 180 hb Cast iron up to 180hb 2	500	157	30 d	38 d	45 c	48 d	36 d	42 c	45 d	30 d	37 d				30 d	35 d	42 c	
	Ghisa oltre 180 hb Cast iron over 180hb 3	700	219	20 b	28 c	32 c	35 d	26 b	30 c	32 d	20 b	25 b				20 b	23 b	30 c	
TITANIO TITANIUM	Titanio non legato Unalloyed titanium 5	500	157	22 b	33 d	36 d	40 d	28 c	31 c	38 d	22 b	26 b				22 b	24 b	31 c	
	Leghe di titanio Titanium alloys 5	900	280	10 a	24 d	27 d	30 d	18 c	21 c	28 d	10 a	14 a				10 a	12 a	21 c	
RAME COPPER	Rame Copper 9	350	110	30 c	42 d			40 c			30 c	40 c		30 c	30 c	30 c	38 c		
	Ottone Brass 9	700	219	33 c	45 d	55 c		43 b	50 c		33 c	43 b	33 c		33 c	41 b	50 c		
	Bronzo Bronze 9	700	219	15 c	24 d	50 c		22 b	45 c		15 c	23 b	15 c		15 c	20 b	45 c		
NICHEL NICKEL	Nichel non legato Unalloyed nichel 6	700	219	10 b	18 c	22 c	26 d	16 c	20 c	24 d	10 b	16 c				10 b	14 c	20 c	
	Leghe di nichel Nichel alloys 6	900	280	5 a	15 c	12 c	16 d	12 b	10 c	14 d	5 a	11 b				5 a	9 b	10 c	
ALLUMINIO ALUMINIUM	Alluminio non legato Unalloyed aluminium 7	350	110	35 d	40 d	70 d		38 d	60 d		35 d	39 d		35 d	35 d	37 d	60 d		
	Alluminio con leghe Alloyed aluminium 7	400	125	30 d	35 d	60 d		33 d	55 d		30 d	34 d		30 d	30 d	32 d	55 d		
	Alluminio con leghe Alloyed aluminium 7	500	157	25 c	30 c	45 c		28 c	40 c		25 c	29 c		25 c	25 c	27 c	40 c		

PUNTE CORTE TWIST DRILLS, JOBBER LENGTH										PUNTE LUNGHE TWIST DRILLS, LONG SERIES				PUNTE EXTRA LUNGHE TWIST DRILLS, EXTRA LONG SERIES									
CL106			CL105			CL109			CL119			CL200		CL230		CL111/1		CL110/1		CL111/2		CL110/2	
DIN 338										DIN 340				DIN 1869/1						DIN 1869/2			
HSS+8%Co					HSS+5%Co					HSS		HSS+5%Co		HSS		HSS+5%Co		HSS		HSS+5%Co			
mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev	mm/rev
57 c	42 d	55 c	60 c	38 c	50 c	57 c	38 c	50 c	57 c	30 b	38 c	50 c	57 c	30 b	38 c	50 c	57 c	30 b	38 c	30 b	38 c		
50 b	35 c	45 b	55 b	30 c	40 b	50 b	30 c	40 b	50 b	22 c	30 c	40 b	50 b	22 c	30 c	40 b	50 b	22 c	30 c	22 c	30 c		
38 b		35 b	40 b		30 b	38 b		30 b	38 b	13 c		30 b	38 b	13 c		30 b	38 b	13 c					
34 b	26 c	32 b	36 b	22 b	28 b	34 b	22 b	28 b	34 b	17 b	22 b	28 b	34 b	17 b	22 b	28 b	34 b	17 b	22 b	17 b	22 b		
20 c	18 d	18 c	22 c	12 c	15 c	20 c	12 c	15 c	20 c	8 c	12 c	15 c	20 c	8 c	12 c	15 c	20 c	8 c	12 c	8 c	12 c		
24 c		22 c	26 c	15 b	18 c	24 c	15 b	18 c	24 c	10 b	15 b	18 c	24 c	10 b	15 b	18 c	24 c	10 b	15 b	10 b	15 b		
45 d	38 d	45 c	48 d	36 d	42 c	45 d	36 d	42 c	45 d	30 d	36 d	42 c	45 d	30 d	36 d	42 c	45 d	30 d	36 d	30 d	36 d		
32 d	28 c	32 c	35 d	26 b	30 c	32 d	26 b	30 c	32 d	20 b	26 b	30 c	32 d	20 b	26 b	30 c	32 d	20 b	26 b	20 b	26 b		
38 d	33 d	36 d	40 d	28 c	31 c	38 d	28 c	31 c	38 d	22 b	28 c	31 c	38 d	22 b	28 c	31 c	38 d	22 b	28 c	22 b	28 c		
28 d	24 d	27 d	30 d	18 c	21 c	28 d	18 c	21 c	28 d	10 a	18 c	21 c	28 d	10 a	18 c	21 c	28 d	10 a	18 c	10 a	18 c		
	42 d			40 c			40 c			30 c	40 c			30 c	40 c			30 c	40 c	30 c	40 c		
	45 d	55 c		43 b	50 c		43 b	50 c		33 c	43 b	50 c		33 c	43 b	50 c		33 c	43 b	33 c	43 b		
	24 d	50 c		22 b	45 c		22 b	45 c		15 c	22 b	45 c		15 c	22 b	45 c		15 c	22 b	15 c	22 b		
24 d	18 c	22 c	26 d	16 c	20 c	24 d	16 c	20 c	24 d	10 b	16 c	20 c	24 d	10 b	16 c	20 c	24 d	10 b	16 c	10 b	16 c		
14 d	15 c	12 c	16 d	12 b	10 c	14 d	12 b	10 c	14 d	5 a	12 b	10 c	14 d	5 a	12 b	10 c	14 d	5 a	12 b	5 a	12 b		
	40 d	70 d		38 d	60 d		38 d	60 d		35 d	38 d	60 d		35 d	38 d	60 d		35 d	38 d	35 d	38 d		
	35 d	60 d		33 d	55 d		33 d	55 d		30 d	33 d	55 d		30 d	33 d	55 d		30 d	33 d	30 d	33 d		
	30 c	45 c		28 c	40 c		28 c	40 c		25 c	28 c	40 c		25 c	28 c	40 c		25 c	28 c	25 c	28 c		