

[ HPI503, 505, 508 series ]

피삭재	비합금강		합금강		연회주철		강회주철	
강도	< 700N/mm <sup>2</sup>		< 1000N/mm <sup>2</sup>		< HB240, GG25		< HB300, GG40	
외경(mm)	RPM	FEED (mm/rev)	RPM	FEED (mm/rev)	RPM	FEED (mm/rev)	RPM	FEED (mm/rev)
1.0	16,250	0.05	14,800	0.05	26,600	0.05	17,300	0.05
2.0	16,250	0.07	14,800	0.07	26,600	0.07	17,300	0.07
3.0	16,000	0.16	14,500	0.16	26,000	0.16	17,000	0.16
4.0	12,000	0.17	11,000	0.17	20,000	0.17	13,000	0.17
5.0	9,550	0.18	8,600	0.18	16,000	0.18	10,000	0.18
6.0	8,000	0.20	7,200	0.20	13,000	0.20	8,500	0.20
7.0	6,800	0.22	6,100	0.22	11,500	0.22	7,300	0.22
8.0	6,000	0.24	5,400	0.24	9,900	0.24	6,400	0.24
9.0	5,300	0.27	4,800	0.27	8,800	0.27	5,700	0.27
10.0	4,800	0.30	4,300	0.30	8,000	0.30	5,100	0.30
12.0	4,000	0.33	3,600	0.33	6,600	0.33	4,250	0.33
14.0	3,400	0.36	3,050	0.36	5,700	0.36	3,650	0.36
16.0	3,000	0.39	2,700	0.39	5,000	0.39	3,200	0.39
18.0	2,650	0.42	2,400	0.42	4,400	0.42	2,850	0.42
20.0	2,400	0.45	2,150	0.45	4,000	0.45	2,550	0.45

[ PDS, PDM series ] ▶ 파워드릴

V : m/min, f : mm/rev

피삭재		연강 합금강, 탄소강		합금강 단조강		열처리강		스테인리스강		덕타일		주철		
경도		≤HRc25		HRc25 ~ HRc35		HRc35 ~ HRc45								
TYPE	Dia.	COD	V	f	V	f	V	f	V	f	V	f	V	f
SOLID TYPE	ø3-5	PDS030-050	40~70	0.15-0.25	35~55	0.10-0.20	15~25	0.05-0.15	15~25	0.05-0.15	35~70	0.15-0.25	45~75	0.15-0.30
	ø5-8	PDS051-080	50~75	0.20-0.30	45~60	0.15-0.25	15~30	0.10-0.20	15~30	0.10-0.20	45~75	0.20-0.35	55~85	0.20-0.40
	ø8-10	PDS081-100	50~75	0.25-0.35	45~60	0.15-0.30	20~35	0.10-0.20	15~30	0.10-0.20	45~75	0.25-0.40	55~85	0.20-0.40
	ø10-12	PDS101-120	50~75	0.25-0.35	45~60	0.15-0.30	20~35	0.10-0.25	15~30	0.10-0.25	45~75	0.25-0.40	55~85	0.20-0.45
	ø12-14	PDS121-140	55~80	0.25-0.40	50~70	0.20-0.35	20~35	0.10-0.25	15~30	0.10-0.25	50~80	0.25-0.45	60~90	0.25-0.50
	ø14-20	PDS141-200	55~80	0.30-0.45	50~70	0.20-0.35	20~35	0.10-0.30	15~30	0.10-0.25	50~80	0.25-0.50	60~100	0.25-0.55

[ PDSI, PDMI series ] ▶ 오일 홀 파워 드릴

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피삭재	연강 합금강, 탄소강		합금강 단조강		열처리강		스테인리스강		덕타일		주철	
경도	≤HRc25		HRc25 ~ HRc35		HRc35 ~ HRc45							
Dia.	V	f	V	f	V	f	V	f	V	f	V	f
7~8	80~110	0.15-0.25	70~100	0.15-0.25	50~80	0.10-0.20	30~60	0.10-0.20	50~80	0.15-0.25	80~120	0.15-0.30
8~10	90~120	0.20-0.30	80~110	0.15-0.30	60~90	0.15-0.25	30~70	0.10-0.20	60~90	0.20-0.30	100~130	0.25-0.35
10~12	100~130	0.25-0.35	90~120	0.20-0.30	70~100	0.20-0.30	30~70	0.10-0.20	70~100	0.25-0.35	110~140	0.25-0.35
12~16	110~140	0.25-0.35	100~130	0.25-0.35	80~100	0.20-0.30	40~70	0.15-0.25	80~110	0.30-0.40	120~150	0.30-0.40
16~20	120~150	0.25-0.40	110~140	0.25-0.35	90~110	0.20-0.30	40~70	0.15-0.30	90~120	0.30-0.40	130~160	0.30-0.40