



rpm
= (mt/min x 1000) / (D x 3,14)



mm/min
= mm/rev x rpm



= mt/min



= mm/rev (vedi tabella - see table page pag. 9)

		PUNTE EXTRA CORTE TWIST DRILLS, STUB LENGHT								PUNTE CORTE TWIST DRILLS, JOBBER LENGHT									
		CL100 CL101 CL104 CL104R CL107 CL108				CL106 CL105													
		DIN 1897				DIN 338													
		HSS				HSS				HSS+5%Co				HSS+8%Co					
		Pagina Page				10				14				20					
Pag. 228	TIPO DI ACCIAIO TYPE OF STEEL	N/mm ²	HV	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	
ACCIAI COMUNI COMMON STEEL	Acciai teneri Soft steel 1	500	157	30 b	42 d	55 c	60 c	30 b	37 c					35 c	50 c	57 c	42 d	55 c	60 c
	Acciai da costruzione Structural steel 2	700	219	22 c	35 c	45 b	55 b	22 c	30 b					28 b	40 b	50 b	35 c	45 b	55 b
	Acciai da tempra Hardening steel 3	900	280	13 c		35 b	40 b	13 c	20 b					18 b	30 b	38 b		35 b	40 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	17 b	22 b					20 b	28 b	34 b	26 c	32 b	36 b
	Austenitico Austenitic 3	850	265	8 c	18 d	18 c	22 c	8 c	12 c					10 c	15 c	20 c	18 d	18 c	22 c
	Ferritico+austenitico Ferritic austenitic 4	1000	311	10 b		22 c	26 c	10 b	15 b					13 b	18 c	24 c		22 c	26 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	30 d	37 d					35 d	42 c	45 d	38 d	45 c	48 d
	Ghisa oltre 180 hb Cast iron over 180hb 3	700	219	20 b	28 c	32 c	35 d	20 b	25 b					23 b	30 c	32 d	28 c	32 c	35 d
TITANIO TITANIUM	Titanio non legato Unalloyed titanium 5	500	157	22 b	33 d	36 d	40 d	22 b	26 b					24 b	31 c	38 d	33 d	36 d	40 d
	Leghe di titanio Titanium alloys 5	900	280	10 a	24 d	27 d	30 d	10 a	14 a					12 a	21 c	28 d	24 d	27 d	30 d
RAME COPPER	Rame Copper 9	350	110	30 c	42 d			30 c	40 c		30 c	38 c					42 d		
	Ottone Brass 9	700	219	33 c	45 d	55 c		33 c	43 b	33 c		41 b	50 c				45 d	55 c	
	Bronzo Bronze 9	700	219	15 c	24 d	50 c		15 c	23 b	15 c		20 b	45 c				24 d	50 c	
NICHEL NICKEL	Nichel non legato Unalloyed nichel 6	700	219	10 b	18 c	22 c	26 d	10 b	16 c					14 c	20 c	24 d	18 c	22 c	26 d
	Leghe di nichel Nichel alloys 6	900	280	5 a	15 c	12 c	16 d	5 a	11 b					9 b	10 c	14 d	15 c	12 c	16 d
ALLUMINIO ALUMINIUM	Alluminio non legato Unalloyed aluminium 7	350	110	35 d	40 d	70 d		35 d	39 d		35 d	37 d	60 d				40 d	70 d	
	Alluminio con leghe Alloyed aluminium 7	400	125	30 d	35 d	60 d		30 d	34 d		30 d	32 d	55 d				35 d	60 d	
	Alluminio con leghe Alloyed aluminium 7	500	157	25 c	30 c	45 c		25 c	29 c		25 c	27 c	40 c				30 c	45 c	



PUNTE LUNGHE TWIST DRILLS, LONG SERIES									PUNTE EXTRA LUNGHE TWIST DRILLS, EXTRA LONG SERIES																	
CL109			CL200	CL230				CL111	CL110				CL111/2		CL110/2		CL111/3		CL110/3							
DIN 338			DIN 340				DIN 1869				DIN 1869/2				DIN 1869/3											
HSS+5%Co			HSS	HSS+5%Co				HSS	HSS+5%Co				HSS	HSS+5%Co		HSS	HSS+5%Co									
24	24	24	26	26	26	26	30	30	30	30	30	30	30	30	31	31	31	31	31	31	31	31	32	32	32	32
mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev
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	50 c	57 c	30 b	38 c	50 c	57 c	30 b	38 c	50 c	57 c	30 b	38 c	50 c	57 c
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	40 b	50 b	22 c	30 c	40 b	50 b	22 c	30 c	40 b	50 b	22 c	30 c	40 b	50 b
	30 b	38 b	13 c		30 b	38 b	13 c		30 b	38 b	13 c		30 b	38 b	13 c		30 b	38 b	13 c		30 b	38 b	13 c		30 b	38 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	28 b	34 b	17 b	22 b	28 b	34 b	17 b	22 b	28 b	34 b	17 b	22 b	28 b	34 b
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	15 c	20 c	8 c	12 c	15 c	20 c	8 c	12 c	15 c	20 c	8 c	12 c	15 c	20 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	18 c	24 c	10 b	15 b	18 c	24 c	10 b	15 b	18 c	24 c	10 b	15 b	18 c	24 c
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	42 c	45 d	30 d	36 d	42 c	45 d	30 d	36 d	42 c	45 d	30 d	36 d	42 c	45 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	30 c	32 d	20 b	26 b	30 c	32 d	20 b	26 b	30 c	32 d	20 b	26 b	30 c	32 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	31 c	38 d	22 b	28 c	31 c	38 d	22 b	28 c	31 c	38 d	22 b	28 c	31 c	38 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	21 c	28 d	10 a	18 c	21 c	28 d	10 a	18 c	21 c	28 d	10 a	18 c	21 c	28 d
40 c			30 c	40 c			30 c	40 c			30 c	40 c			30 c	40 c			30 c	40 c			30 c	40 c		
43 b	50 c		33 c	43 b	50 c		33 c	43 b	50 c		33 c	43 b	50 c		33 c	43 b	50 c		33 c	43 b	50 c		33 c	43 b	50 c	
22 b	45 c		15 c	22 b	45 c		15 c	22 b	45 c		15 c	22 b	45 c		15 c	22 b	45 c		15 c	22 b	45 c		15 c	22 b	45 c	
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	20 c	24 d	10 b	16 c	20 c	24 d	10 b	16 c	20 c	24 d	10 b	16 c	20 c	24 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	10 c	14 d	5 a	12 b	10 c	14 d	5 a	12 b	10 c	14 d	5 a	12 b	10 c	14 d
38 d	60 d		35 d	38 d	60 d		35 d	38 d	60 d		35 d	38 d	60 d		35 d	38 d	60 d		35 d	38 d	60 d		35 d	38 d	60 d	
33 d	55 d		30 d	33 d	55 d		30 d	33 d	55 d		30 d	33 d	55 d		30 d	33 d	55 d		30 d	33 d	55 d		30 d	33 d	55 d	
28 c	40 c		25 c	28 c	40 c		25 c	28 c	40 c		25 c	28 c	40 c		25 c	28 c	40 c		25 c	28 c	40 c		25 c	28 c	40 c	

				PUNTE DOPPIE DOUBLE TWIST DRILLS		PUNTE PER CENTRI NC NC-SPOTTING DRILLS						PUNTE DA CENTRO CENTRE DRILLS						PUNTE A ELICHE DRILLS WITH									
rpm $= (mt/min \times 1000) / (D \times 3,14)$																											
mm/min $= mm/rev \times rpm$				CL150		CL102		CL103		CL910		CL920		CL930		CL270											
= mt/min				CARMON NORM.		CARMON NORM.		CARMON NORM.		DIN 333/A		DIN 333/R		DIN 333/B		DIN 8376											
= mm/rev (vedi tabella - see table page pag. 9)				HSS		HSS+8% Co						HSS															
Pagina Page				33		34		34		34		34		35		35		35		36		36		37		37	
Pag. 228	TIPO DI ACCIAIO TYPE OF STEEL	N/mm ²	HV	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	
ACCIAI COMUNI COMMON STEEL	Acciai teneri Soft steel	1	500	157	35 c	50 c	57 c	35 c	50 c	57 c	30 b	37 c	30 b	37 c	30 b	37 c	30 b	37 c	30 b	37 c	30 b	37 c	30 b	37 c	30 b	37 c	
	Acciai da costruzione Structural steel	2	700	219	28 b	40 b	50 b	28 b	40 b	50 b	22 c	30 b	22 c	30 b	22 c	30 b	22 c	30 b	22 c	30 b	22 c	30 b	22 c	30 b	22 c	30 b	22 c
	Acciai da tempra Hardening steel	3	900	280	18 b	30 b	38 b	18 b	30 b	38 b	13 c	20 b	13 c	20 b	13 c	20 b	13 c	20 b	13 c	20 b	13 c	20 b	13 c	20 b	13 c	20 b	13 c
	Acciaio automatico Automatic steel	4	1200	373																							
ACCIAI INOX STAINLESS STEEL	Acciaio automatico Automatic steel	3	850	265	20 b	28 b	34 b	20 b	28 b	34 b	17 b	22 b	17 b	22 b	17 b	22 b	17 b	22 b	17 b	22 b	17 b	22 b	17 b	22 b	17 b	22 b	
	Austenitico Austenitic	3	850	265	10 c	15 c	20 c	10 c	15 c	20 c	8 c	12 c	8 c	12 c	8 c	12 c	8 c	12 c	8 c	12 c	8 c	12 c	8 c	12 c	8 c	12 c	
	Ferritico+austenitico Ferritic austenitic	4	1000	311	13 b	18 c	24 c	13 b	18 c	24 c	10 b	15 b	10 b	15 b	10 b	15 b	10 b	15 b	10 b	15 b	10 b	15 b	10 b	15 b	10 b	15 b	
GHISA CAST IRON	Ghisa fino a 180 hb Cast iron up to 180hb	2	500	157	35 d	42 c	45 d	35 d	42 c	45 d	30 d	37 d	30 d	37 d	30 d	37 d	30 d	37 d	30 d	37 d	30 d	37 d	30 d	37 d	30 d	37 d	
	Ghisa oltre 180 hb Cast iron over 180hb	3	700	219	23 b	30 c	32 d	23 b	30 c	32 d	20 b	25 b	20 b	25 b	20 b	25 b	20 b	25 b	20 b	25 b	20 b	25 b	20 b	25 b	20 b	25 b	
TITANIO TITANIUM	Titanio non legato Unalloyed titanium	5	500	157	24 b	31 c	38 d	24 b	31 c	38 d	22 b	26 b	22 b	26 b	22 b	26 b	22 b	26 b	22 b	26 b	22 b	26 b	22 b	26 b	22 b	26 b	
	Leghe di titanio Titanium alloys	5	900	280	12 a	21 c	28 d	12 a	21 c	28 d	10 a	14 a	10 a	14 a	10 a	14 a	10 a	14 a	10 a	14 a	10 a	14 a	10 a	14 a	10 a	14 a	
RAME COPPER	Rame Copper	9	350	110	38 c			38 c			30 c	40 c	30 c	40 c	30 c	40 c	30 c	40 c	30 c	40 c	30 c	40 c	30 c	40 c	30 c	40 c	
	Ottone Brass	9	700	219	41 b	50 c		41 b	50 c		33 c	43 b	33 c	43 b	33 c	43 b	33 c	43 b	33 c	43 b	33 c	43 b	33 c	43 b	33 c	43 b	
	Bronzo Bronze	9	700	219	20 b	45 c		20 b	45 c		15 c	23 b	15 c	23 b	15 c	23 b	15 c	23 b	15 c	23 b	15 c	23 b	15 c	23 b	15 c	23 b	
NICHEL NICKEL	Nichel non legato Unalloyed nickel	6	700	219	14 c	20 c	24 d	14 c	20 c	24 d	10 b	16 c	10 b	16 c	10 b	16 c	10 b	16 c	10 b	16 c	10 b	16 c	10 b	16 c	10 b	16 c	
	Leghe di nichel Nickel alloys	6	900	280	9 b	10 c	14 d	9 b	10 c	14 d	5 a	11 b	5 a	11 b	5 a	11 b	5 a	11 b	5 a	11 b	5 a	11 b	5 a	11 b	5 a	11 b	
ALLUMINIO ALUMINIUM	Alluminio non legato Unalloyed aluminium	7	350	110	37 d	60 d		37 d	60 d		35 d	39 d	35 d	39 d	35 d	39 d	35 d	39 d	35 d	39 d	35 d	39 d	35 d	39 d	35 d	39 d	
	Alluminio con leghe Alloyed aluminium	7	400	125	32 d	55 d		32 d	55 d		30 d	34 d	30 d	34 d	30 d	34 d	30 d	34 d	30 d	34 d	30 d	34 d	30 d	34 d	30 d	34 d	
	Alluminio con leghe Alloyed aluminium	7	500	157	27 c	40 c		27 c	40 c		25 c	29 c	25 c	29 c	25 c	29 c	25 c	29 c	25 c	29 c	25 c	29 c	25 c	29 c	25 c	29 c	

GRADINO CON INDIPENDENTI SUBLAND INDEPENDENT SPIRAL		PUNTE EXTRA CORTE TWIST DRILLS, STUB LENGHT		PUNTE CORTE TWIST DRILLS, JOBBER LENGHT		PUNTE CON CODOLO RINFORZATO TWIST DRILLS WITH REINFORCED SHANK					PUNTE CODOLO CONICO TAPER SHANK TWIST DRILLS				PUNTE LUNGHE CODOLO CONICO TAPER SHANK DRILLS, LONG SERIES				
CL271	CL272	CL400		CL410	CL415	CL420	CL425	CL430	CL435	CM300	CM303		CM301	CM302					
HSS		HM		HM		HM					HSS	HSS+5% Co		HSS	HSS+5% Co				
37	38	39	39	41	41	42	45	42	45	48	50	50	50	50	56	56	56	56	
mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev	mi/min mm/rev
30 b	30 b	85 a	120 f	85 a	120 f	120 c	120 c	150 c	150 c	150 c	30 c	35 c	50 c	57 c	30 c	38 c	50 c	57 c	
22 c	22 c	70 a	115 f	70 a	115 f	100 b	100 b	120 b	120 b	120 b	22 b	28 b	40 b	50 b	22 b	30 c	40 b	50 b	
13 c	13 c	45 a	90 f	45 a	90 f	80 b	80 b	100 b	100 b	100 b	13 b	18 b	30 b	38 b	13 b		30 b	38 b	
		40 a	50 f	40 a	50 f	60 a	60 a	70 a	70 a	70 a									
17 b	17 b	50 g	55 f	50 g	55 f	70 c	70 c	80 c	80 c	80 c	17 b	20 b	28 b	34 b	17 b	22 b	28 b	34 b	
8 c	8 c	45 g	50 f	45 g	50 f	60 c	60 c	70 c	70 c	70 c	8 c	10 c	15 c	20 c	8 c	12 c	15 c	20 c	
10 b	10 b					40 e	40 e	50 e	50 e	50 e	10 b	13 b	18 c	24 c	10 b	15 b	18 c	24 c	
30 d	30 d	75 b	90 f	75 b	90 f	75 c	80 c	75 c	80 c	80 c	30 d	35 d	42 c	45 d	30 d	36 d	42 c	45 d	
20 b	20 b	55 b	70 f	55 b	70 f	65 b	65 b	65 b	65 b	65 b	20 b	23 b	30 c	32 d	20 b	26 b	30 c	32 d	
22 b	22 b	45 a	55 a	45 a	55 a	55 c	55 c	65 c	65 c	65 c	22 b	24 b	31 c	38 d	22 b	28 c	31 c	38 d	
10 a	10 a	30 a	40 a	30 a	40 a	45 b	45 b	55 b	55 b	55 b	10 a	12 a	21 c	28 d	10 a	18 c	21 c	28 d	
30 c	30 c	300 f		300 f							18 c	30 c	40 c		18 c	38 c	40 c		
33 c	33 c	300 f		300 f							20 c	33 c	43 b	50 c	20 c	41 b	43 b	50 c	
15 c	15 c	300 f		300 f							12 c	15 c	22 b	45 c	12 c	20 b	22 b	45 c	
10 b	10 b	45 a	55 f	45 a	55 f	40 b	40 b	50 b	50 b	50 b	10 b	14 c	20 c	24 d	10 b	16 c	20 c	24 d	
5 a	5 a	30 a	45 f	30 a	45 f	30 a	30 a	40 a	40 a	40 a	5 a	9 b	10 c	14 d	5 a	12 b	10 c	14 d	
35 d	35 d										35 d	37 d	60 d		35 d	38 d	60 d		
30 d	30 d										30 d	32 d	55 d		30 d	33 d	55 d		
25 c	25 c										25 c	27 c	40 c		25 c	28 c	40 c		

				PUNTE EXTRA LUNGHE CODOLO CONICO TWIST DRILLS TAPER SHANK EXTRALONG						PUNTE A DUE DIAMETRI SUBLAND TWIST DRILLS							
				CM304	CM306		CM305	CM307	CM370	CM371	CM372	CL104					
				DIN 1870/1				DIN 1870/2		DIN 8377	DIN 8375	DIN 8379	DIN 338				
				HSS	HSS+5%Co		HSS	HSS+5%Co	HSS			HSS					
				180°				90°		90°							
				Pagina Page				58	58	58	58	60	60	62	62	62	64
Pag. 228	TIPO DI ACCIAIO TYPE OF STEEL	N/mm ²	HV	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev	mt/min mm/rev		
ACCIAI COMUNI COMMON STEEL	Acciai teneri Soft steel	1	500	157	30 c	38 c	50 c	57 c	30 c	38 c	30 c	30 c	30 c	30 c	30 c		
	Acciai da costruzione Structural steel	2	700	219	22 b	30 c	40 b	50 b	22 b	30 c	22 b	22 b	22 b	22 b	22 b		
	Acciai da tempra Hardening steel	3	900	280	13 b		30 b	38 b	13 b		13 b	13 b	13 b	13 b	13 b		
	Acciaio automatico Automatic steel	4	1200	373													
ACCIAI INOX STAINLESS STEEL	Acciaio automatico Automatic steel	3	850	265	17 b	22 b	28 b	34 b	17 b	22 b	17 b	17 b	17 b	17 b	17 b		
	Austenitico Austenitic	3	850	265	8 c	12 c	15 c	20 c	8 c	12 c	8 c	8 c	8 c	8 c	8 c		
	Ferritico+austenitico Ferritic austenitic	4	1000	311	10 b	15 b	18 c	24 c	10 b	15 b	10 b	10 b	10 b	10 b	10 b		
GHISA CAST IRON	Ghisa fino a 180 hb Cast iron up to 180hb	2	500	157	30 d	36 d	42 c	45 d	30 d	36 d	30 d	30 d	30 d	30 d	30 d		
	Ghisa oltre 180 hb Cast iron over 180hb	3	700	219	20 b	26 b	30 c	32 d	20 b	26 b	20 b	20 b	20 b	20 b	20 b		
TITANIO TITANIUM	Titanio non legato Unalloyed titanium	5	500	157	22 b	28 c	31 c	38 d	22 b	28 c	22 b	22 b	22 b	22 b	22 b		
	Leghe di titanio Titanium alloys	5	900	280	10 a	18 c	21 c	28 d	10 a	18 c	10 a	10 a	10 a	10 a	10 a		
RAME COPPER	Rame Copper	9	350	110	18 c	38 c	40 c		18 c	38 c	18 c	18 c	18 c	18 c	18 c		
	Ottone Brass	9	700	219	20 c	41 b	43 b	50 c	20 c	41 b	20 c	20 c	20 c	20 c	20 c		
	Bronzo Bronze	9	700	219	12 c	20 b	22 b	45 c	12 c	20 b	12 c	12 c	12 c	12 c	12 c		
NICHEL NICKEL	Nichel non legato Unalloyed nichel	6	700	219	10 b	16 c	20 c	24 d	10 b	16 c	10 b	10 b	10 b	10 b	10 b		
	Leghe di nichel Nichel alloys	6	900	280	5 a	12 b	10 c	14 d	5 a	12 b	5 a	5 a	5 a	5 a	5 a		
ALLUMINIO ALUMINIUM	Alluminio non legato Unalloyed aluminium	7	350	110	35 d	38 d	60 d		35 d	38 d	35 d	35 d	35 d	35 d	35 d		
	Alluminio con leghe Alloyed aluminium	7	400	125	30 d	33 d	55 d		30 d	33 d	30 d	30 d	30 d	30 d	30 d		
	Alluminio con leghe Alloyed aluminium	7	500	157	25 c	28 c	40 c		25 c	28 c	25 c	25 c	25 c	25 c	25 c		

KIT PUNTE CODOLO CILINDRICO
 STRAIGHT SHANK
 TWIST DRILLS IN SET


CL106



CL105



CL101



HSS+5%Co

HSS+8%Co



64

65

65

FORATURA DRILLING	TABELLA PARAMETRI DI AVANZAMENTO mm/giro - RECOMMENDED FEED DATA mm/rev.																
	DIAMETRO DELLA PUNTA DRILL DIAMETER																
LETTERA DI RIFERIMENTO REFERENCE LETTER	D. 1	D. 2	D. 3	D. 4	D. 5	D. 6	D. 8	D. 10	D. 12	D. 14	D. 16	D. 20	D. 25	D. 30	D. 35	D. 40	D. 50
a	0,015	0,030	0,038	0,047	0,053	0,060	0,075	0,090	0,100	0,120	0,127	0,160	0,200	0,230	0,250	0,300	0,350
b	0,020	0,050	0,070	0,085	0,100	0,120	0,150	0,180	0,200	0,230	0,250	0,270	0,290	0,330	0,350	0,380	0,400
c	0,023	0,080	0,100	0,130	0,150	0,180	0,250	0,270	0,280	0,300	0,330	0,370	0,420	0,450	0,470	0,500	0,550
d	0,030	0,100	0,160	0,180	0,220	0,240	0,300	0,370	0,400	0,450	0,480	0,500	0,530	0,550	0,580	0,600	0,630
e	0,035	0,120	0,200	0,250	0,270	0,300	0,350	0,450	0,470	0,500	0,530	0,550	0,600	0,640	0,680	0,700	0,730
f	0,050	0,150	0,220	0,250	0,320	0,400	0,490	0,620	0,650	0,720	0,850	0,900	1,100	1,130	1,170	1,200	1,250
g	0,070	0,160	0,250	0,270	0,360	0,470	0,620	0,830	0,900	0,950	1,100	1,200	1,280	1,330	1,400	1,470	1,520
h	0,090	0,200	0,270	0,300	0,400	0,520	0,750	1,000	1,100	1,200	1,300	1,350	1,430	1,500	1,650	1,700	1,800