

TECHNICAL DATA | NC SPOT DRILLS |

LDS Series

Work Material	S15C · S5400 ~500N/mm ²		S45C		SCM440		SKD61 28HRc		SKD61 34HRc		FC250		AC4D	
Drilling Speed (V)	63~80 m/min		43~60 m/min		32~50 m/min		20~28 m/min		16~22 m/min		63~100 m/min		80~160 m/min	
Cutting Diameter (metric)	RPM	FEED (mm/rev)	RPM	FEED (mm/rev)	RPM	FEED (mm/rev)	RPM	FEED (mm/rev)	RPM	FEED (mm/rev)	RPM	FEED (mm/rev)	RPM	FEED (mm/rev)
3	7,500	0.04~0.08	5,500	0.04~0.08	4,500	0.04~0.08	2,500	0.04~0.08	1,500	0.04~0.08	8,000	0.05~0.09	12,000	0.10~0.22
4	5,700	0.05~0.10	4,100	0.05~0.10	3,300	0.05~0.10	1,900	0.05~0.10	1,100	0.05~0.10	6,500	0.07~0.12	9,500	0.12~0.25
6	3,800	0.06~0.12	2,700	0.06~0.12	2,300	0.06~0.12	1,250	0.06~0.12	750	0.06~0.12	4,300	0.12~0.18	6,400	0.14~0.28
8	2,800	0.08~0.15	2,000	0.08~0.15	1,700	0.08~0.15	950	0.08~0.15	550	0.08~0.15	3,200	0.13~0.20	4,800	0.18~0.32
10	2,300	0.10~0.18	1,700	0.10~0.18	1,400	0.10~0.18	750	0.10~0.18	450	0.10~0.18	2,600	0.17~0.25	3,800	0.22~0.36
12	1,900	0.12~0.21	1,400	0.12~0.21	1,200	0.12~0.21	650	0.12~0.21	370	0.12~0.21	2,200	0.21~0.30	3,200	0.25~0.40
16	1,400	0.16~0.28	1,000	0.16~0.28	900	0.16~0.28	500	0.16~0.28	280	0.16~0.28	1,600	0.24~0.32	2,400	0.32~0.48
20	1,150	0.20~0.34	820	0.20~0.34	700	0.20~0.34	400	0.20~0.34	220	0.20~0.34	1,300	0.26~0.40	1,900	0.40~0.60
25	900	0.25~0.45	650	0.25~0.45	560	0.25~0.45	300	0.25~0.45	180	0.25~0.45	1,000	0.30~0.50	1,500	0.50~0.75