



INDRILL

Ø 0.015 - 3.00 mm

MMP
TECHNOLOGY

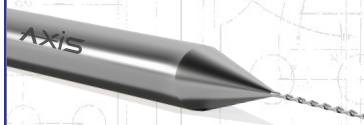
Embedded



T301-SN

T302-SN

T303-SN



Dia Tolerance

Uncoated : h6

Coated : ±0.003

Steel
Low/
Unalloyed

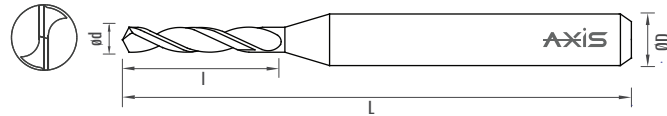
Non-
Ferrous

Plastics

Steel
High
Alloyed

SS

Cast
Iron



Ød < 0.40mm

Ød ≥ 0.40mm

		T301-SN Stub Length		T302-SN Standard Length		T303-SN Long Length	
Ød	ØD h6	I	L	I	L	I	L
0.015 (+0.003)	3.00					0.15	38
0.020 (+0.003)	3.00					0.2	38
0.030 (+0.003)	3.00					0.3	38
0.040 (+0.003)	3.00					0.4	38
0.050 (-0.004)	3.00					0.5	38
0.060 (-0.004)	3.00					0.6	38
0.070 (-0.004)	3.00					0.7	38
0.080 (-0.004)	3.00					0.8	38
0.090 (-0.004)	3.00					0.9	38
0.10	3.00			0.8	38	1.0	38
0.11	3.00			0.8	38	1.0	38
0.12	3.00			1.0	38	1.5	38
0.13	3.00			1.0	38	1.5	38
0.14	3.00			1.0	38	1.5	38
0.15	3.00			1.0	38	2.0	38
0.16	3.00			1.0	38	2.0	38
0.17	3.00			1.0	38	2.0	38
0.18	3.00			1.5	38	2.5	38
0.19	3.00			1.5	38	2.5	38
0.20	3.00			1.5	38	2.5	38
0.21	3.00			1.5	38	2.5	38
0.22	3.00			1.5	38	2.5	38
0.23	3.00			2.0	38	4.0	38
0.24	3.00			2.0	38	4.0	38
0.25	3.00			2.0	38	4.0	38
0.26	3.00			2.0	38	4.0	38
0.27	3.00			2.0	38	4.0	38
0.28	3.00			2.0	38	4.0	38
0.29	3.00			2.0	38	4.0	38
0.30	3.00	1.5	38	3.0	38	5.5	38
0.31	3.00	1.5	38	3.0	38	5.5	38
0.32	3.00	1.5	38	3.0	38	5.5	38
0.33	3.00	1.5	38	3.0	38	5.5	38
0.34	3.00	1.5	38	3.0	38	5.5	38
0.35	3.00	1.5	38	3.0	38	5.5	38
0.36	3.00	1.5	38	3.0	38	5.5	38
0.37	3.00	1.5	38	3.0	38	5.5	38
0.38	3.00	1.5	38	3.0	38	5.5	38
0.39	3.00	1.5	38	3.0	38	5.5	38
0.40	3.00	1.5	38	3.0	38	6.0	38
0.41	3.00	2.0	38	4.0	38	6.0	38
0.42	3.00	2.0	38	4.0	38	6.0	38
0.43	3.00	2.0	38	4.0	38	6.0	38
0.44	3.00	2.0	38	4.0	38	6.0	38
0.45	3.00	2.0	38	4.0	38	6.0	38
0.46	3.00	2.0	38	4.0	38	6.0	38
0.47	3.00	2.0	38	4.0	38	6.0	38
0.48	3.00	2.0	38	4.0	38	6.0	38
0.49	3.00	2.0	38	4.0	38	6.0	38
0.50	3.00	2.0	38	4.0	38	6.0	38
0.51	3.00	2.5	38	4.0	38	6.0	38
0.52	3.00	2.5	38	4.0	38	6.0	38
0.53	3.00	2.5	38	4.0	38	6.0	38
0.54	3.00	2.5	38	4.0	38	6.0	38
0.55	3.00	2.5	38	5.0	38	8.0	38
0.56	3.00	2.5	38	5.0	38	8.0	38
0.57	3.00	2.5	38	5.0	38	8.0	38
0.58	3.00	2.5	38	5.0	38	8.0	38
0.59	3.00	2.5	38	5.0	38	8.0	38
0.60	3.00	2.5	38	5.0	38	8.0	38

		T301-SN Stub Length		T302-SN Standard Length		T303-SN Long Length	
od	OD h6	I	L	I	L	I	L
0.61	3.00	2.5	38	5.0	38	8.0	38
0.62	3.00	2.5	38	5.0	38	8.0	38
0.63	3.00	2.5	38	5.0	38	8.0	38
0.64	3.00	2.5	38	5.0	38	8.0	38
0.65	3.00	2.5	38	5.0	38	8.0	38
0.66	3.00	2.5	38	5.0	38	8.0	38
0.67	3.00	3.0	38	5.0	38	8.0	38
0.68	3.00	3.0	38	5.0	38	8.0	38
0.69	3.00	3.0	38	5.0	38	8.0	38
0.70	3.00	3.0	38	5.0	38	8.0	38
0.71	3.00	3.0	38	5.0	38	8.0	38
0.72	3.00	3.0	38	5.0	38	8.0	38
0.73	3.00	3.0	38	5.0	38	8.0	38
0.74	3.00	3.0	38	5.0	38	8.0	38
0.75	3.00	3.0	38	5.0	38	8.0	38
0.76	3.00	3.0	38	5.0	38	8.0	38
0.77	3.00	3.0	38	5.0	38	8.0	38
0.78	3.00	3.0	38	5.0	38	8.0	38
0.79	3.00	3.0	38	5.0	38	8.0	38
0.80	3.00	4.0	38	6.0	38	8.0	38
0.81	3.00	4.0	38	6.0	38	8.0	38
0.82	3.00	4.0	38	6.0	38	8.0	38
0.83	3.00	4.0	38	6.0	38	8.0	38
0.84	3.00	4.0	38	6.0	38	8.0	38
0.85	3.00	4.0	38	6.0	38	8.0	38
0.86	3.00	4.0	38	6.0	38	8.0	38
0.87	3.00	4.0	38	6.0	38	8.0	38
0.88	3.00	4.0	38	6.0	38	8.0	38
0.89	3.00	4.0	38	6.0	38	8.0	38
0.90	3.00	5.0	38	6.0	38	8.0	38
0.91	3.00	5.0	38	8.0	38	10.0	38
0.92	3.00	5.0	38	8.0	38	10.0	38
0.93	3.00	5.0	38	8.0	38	10.0	38
0.94	3.00	5.0	38	8.0	38	10.0	38
0.95	3.00	5.0	38	8.0	38	10.0	38
0.96	3.00	5.0	38	8.0	38	10.0	38
0.97	3.00	5.0	38	8.0	38	10.0	38
0.98	3.00	5.0	38	8.0	38	10.0	38
0.99	3.00	5.0	38	8.0	38	10.0	38
1.00	3.00	5.0	38	8.0	38	10.0	38
1.01	3.00	5.0	38	8.0	38	10.0	38
1.02	3.00	5.0	38	8.0	38	10.0	38
1.03	3.00	5.0	38	8.0	38	10.0	38
1.04	3.00	5.0	38	8.0	38	10.0	38
1.05	3.00	5.0	38	8.0	38	10.0	38
1.06	3.00	5.0	38	8.0	38	10.0	38
1.07	3.00	5.0	38	8.0	38	10.0	38
1.08	3.00	5.0	38	8.0	38	10.0	38
1.09	3.00	5.0	38	8.0	38	10.0	38
1.10	3.00	6.0	38	10.0	38	12.0	38
1.11	3.00	6.0	38	10.0	38	12.0	38
1.12	3.00	6.0	38	10.0	38	12.0	38
1.13	3.00	6.0	38	10.0	38	12.0	38
1.14	3.00	6.0	38	10.0	38	12.0	38
1.15	3.00	6.0	38	10.0	38	12.0	38
1.16	3.00	6.0	38	10.0	38	12.0	38
1.17	3.00	6.0	38	10.0	38	12.0	38
1.18	3.00	6.0	38	10.0	38	12.0	38
1.19	3.00	6.0	38	10.0	38	12.0	38
1.20	3.00	6.0	38	10.0	38	12.0	38
1.21	3.00	6.0	38	10.0	38	12.0	38
1.22	3.00	6.0	38	10.0	38	12.0	38
1.23	3.00	6.0	38	10.0	38	12.0	38
1.24	3.00	6.0	38	10.0	38	12.0	38
1.25	3.00	6.0	38	10.0	38	12.0	38
1.26	3.00	6.0	38	10.0	38	12.0	38
1.27	3.00	6.0	38	10.0	38	12.0	38
1.28	3.00	6.0	38	10.0	38	12.0	38
1.29	3.00	6.0	38	10.0	38	12.0	38
1.30	3.00	6.0	38	10.0	38	14.0	45
1.31	3.00	6.0	38	10.0	38	14.0	45
1.32	3.00	6.0	38	10.0	38	14.0	45
1.33	3.00	6.0	38	10.0	38	14.0	45
1.34	3.00	6.0	38	10.0	38	14.0	45
1.35	3.00	6.0	38	10.0	38	14.0	45
1.36	3.00	6.0	38	10.0	38	14.0	45
1.37	3.00	6.0	38	10.0	38	14.0	45
1.38	3.00	6.0	38	10.0	38	14.0	45
1.39	3.00	6.0	38	10.0	38	14.0	45
1.40	3.00	6.0	38	10.0	38	14.0	45

		T301-SN Stub Length		T302-SN Standard Length		T303-SN Long Length	
ød	OD h6	I	L	I	L	I	L
1.41	3.00	6.0	38	10.0	38	14.0	45
1.42	3.00	6.0	38	10.0	38	14.0	45
1.43	3.00	6.0	38	10.0	38	14.0	45
1.44	3.00	6.0	38	10.0	38	14.0	45
1.45	3.00	6.0	38	10.0	38	14.0	45
1.46	3.00	6.0	38	10.0	38	14.0	45
1.47	3.00	6.0	38	10.0	38	14.0	45
1.48	3.00	6.0	38	10.0	38	14.0	45
1.49	3.00	6.0	38	10.0	38	14.0	45
1.50	3.00	8.0	38	12.0	38	16.0	45
1.51	3.00	8.0	38	12.0	38	16.0	45
1.52	3.00	8.0	38	12.0	38	16.0	45
1.53	3.00	8.0	38	12.0	38	16.0	45
1.54	3.00	8.0	38	12.0	38	16.0	45
1.55	3.00	8.0	38	12.0	38	16.0	45
1.56	3.00	8.0	38	12.0	38	16.0	45
1.57	3.00	8.0	38	12.0	38	16.0	45
1.58	3.00	8.0	38	12.0	38	16.0	45
1.59	3.00	8.0	38	12.0	38	16.0	45
1.60	3.00	8.0	38	12.0	38	16.0	45
1.61	3.00	8.0	38	12.0	38	16.0	45
1.62	3.00	8.0	38	12.0	38	16.0	45
1.63	3.00	8.0	38	12.0	38	16.0	45
1.64	3.00	8.0	38	12.0	38	16.0	45
1.65	3.00	8.0	38	12.0	38	16.0	45
1.66	3.00	8.0	38	12.0	38	16.0	45
1.67	3.00	8.0	38	12.0	38	16.0	45
1.68	3.00	8.0	38	12.0	38	16.0	45
1.69	3.00	8.0	38	12.0	38	16.0	45
1.70	3.00	8.0	38	12.0	38	18.0	45
1.71	3.00	8.0	38	12.0	38	18.0	45
1.72	3.00	8.0	38	12.0	38	18.0	45
1.73	3.00	8.0	38	12.0	38	18.0	45
1.74	3.00	8.0	38	12.0	38	18.0	45
1.75	3.00	8.0	38	12.0	38	18.0	45
1.76	3.00	8.0	38	12.0	38	18.0	45
1.77	3.00	8.0	38	12.0	38	18.0	45
1.78	3.00	8.0	38	12.0	38	18.0	45
1.79	3.00	8.0	38	12.0	38	18.0	45
1.80	3.00	8.0	38	12.0	38	18.0	45
1.81	3.00	8.0	38	12.0	38	18.0	45
1.82	3.00	8.0	38	12.0	38	18.0	45
1.83	3.00	8.0	38	12.0	38	18.0	45
1.84	3.00	8.0	38	12.0	38	18.0	45
1.85	3.00	8.0	38	12.0	38	18.0	45
1.86	3.00	8.0	38	12.0	38	18.0	45
1.87	3.00	8.0	38	12.0	38	18.0	45
1.88	3.00	8.0	38	12.0	38	18.0	45
1.89	3.00	8.0	38	12.0	38	18.0	45
1.90	3.00	8.0	38	12.0	38	18.0	45
1.91	3.00	8.0	38	12.0	38	18.0	45
1.92	3.00	8.0	38	12.0	38	18.0	45
1.93	3.00	8.0	38	12.0	38	18.0	45
1.94	3.00	8.0	38	12.0	38	18.0	45
1.95	3.00	8.0	38	12.0	38	18.0	45
1.96	3.00	8.0	38	12.0	38	18.0	45
1.97	3.00	8.0	38	12.0	38	18.0	45
1.98	3.00	8.0	38	12.0	38	18.0	45
1.99	3.00	8.0	38	12.0	38	18.0	45
2.00	3.00	8.0	38	12.0	38	18.0	45
2.01	3.00	12.0	38	14.0	45	20.0	50
2.02	3.00	12.0	38	14.0	45	20.0	50
2.03	3.00	12.0	38	14.0	45	20.0	50
2.04	3.00	12.0	38	14.0	45	20.0	50
2.05	3.00	12.0	38	14.0	45	20.0	50
2.06	3.00	12.0	38	14.0	45	20.0	50
2.07	3.00	12.0	38	14.0	45	20.0	50
2.08	3.00	12.0	38	14.0	45	20.0	50
2.09	3.00	12.0	38	14.0	45	20.0	50
2.10	3.00	12.0	38	14.0	45	20.0	50
2.11	3.00	12.0	38	14.0	45	20.0	50
2.12	3.00	12.0	38	14.0	45	20.0	50
2.13	3.00	12.0	38	14.0	45	20.0	50
2.14	3.00	12.0	38	14.0	45	20.0	50
2.15	3.00	12.0	38	14.0	45	20.0	50
2.16	3.00	12.0	38	14.0	45	20.0	50
2.17	3.00	12.0	38	14.0	45	20.0	50
2.18	3.00	12.0	38	14.0	45	20.0	50
2.19	3.00	12.0	38	14.0	45	20.0	50
2.20	3.00	12.0	38	14.0	45	20.0	50

		T301-SN Stub Length		T302-SN Standard Length		T303-SN Long Length	
ød	OD h6	I	L	I	L	I	L
2.21	3.00	12.0	38	14.0	45	20.0	50
2.22	3.00	12.0	38	14.0	45	20.0	50
2.23	3.00	12.0	38	14.0	45	20.0	50
2.24	3.00	12.0	38	14.0	45	20.0	50
2.25	3.00	12.0	38	14.0	45	20.0	50
2.26	3.00	12.0	38	14.0	45	22.0	50
2.27	3.00	12.0	38	14.0	45	22.0	50
2.28	3.00	12.0	38	14.0	45	22.0	50
2.29	3.00	12.0	38	14.0	45	22.0	50
2.30	3.00	12.0	38	14.0	45	22.0	50
2.31	3.00	12.0	38	14.0	45	22.0	50
2.32	3.00	12.0	38	14.0	45	22.0	50
2.33	3.00	12.0	38	14.0	45	22.0	50
2.34	3.00	12.0	38	14.0	45	22.0	50
2.35	3.00	12.0	38	14.0	45	22.0	50
2.36	3.00	12.0	38	14.0	45	22.0	50
2.37	3.00	12.0	38	14.0	45	22.0	50
2.38	3.00	12.0	38	14.0	45	22.0	50
2.39	3.00	12.0	38	14.0	45	22.0	50
2.40	3.00	12.0	38	14.0	45	22.0	50
2.41	3.00	12.0	38	16.0	45	22.0	50
2.42	3.00	12.0	38	16.0	45	22.0	50
2.43	3.00	12.0	38	16.0	45	22.0	50
2.44	3.00	12.0	38	16.0	45	22.0	50
2.45	3.00	12.0	38	16.0	45	22.0	50
2.46	3.00	12.0	38	16.0	45	22.0	50
2.47	3.00	12.0	38	16.0	45	22.0	50
2.48	3.00	12.0	38	16.0	45	22.0	50
2.49	3.00	12.0	38	16.0	45	22.0	50
2.50	3.00	12.0	38	16.0	45	24.0	50
2.51	3.00	12.0	38	16.0	45	24.0	50
2.52	3.00	12.0	38	16.0	45	24.0	50
2.53	3.00	12.0	38	16.0	45	24.0	50
2.54	3.00	12.0	38	16.0	45	24.0	50
2.55	3.00	12.0	38	16.0	45	24.0	50
2.56	3.00	12.0	38	16.0	45	24.0	50
2.57	3.00	12.0	38	16.0	45	24.0	50
2.58	3.00	12.0	38	16.0	45	24.0	50
2.59	3.00	12.0	38	16.0	45	24.0	50
2.60	3.00	12.0	38	16.0	45	24.0	50
2.61	3.00	12.0	38	16.0	45	24.0	50
2.62	3.00	12.0	38	16.0	45	24.0	50
2.63	3.00	12.0	38	16.0	45	24.0	50
2.64	3.00	12.0	38	16.0	45	24.0	50
2.65	3.00	12.0	38	16.0	45	24.0	50
2.66	3.00	12.0	38	16.0	45	24.0	50
2.67	3.00	12.0	38	16.0	45	24.0	50
2.68	3.00	12.0	38	16.0	45	24.0	50
2.69	3.00	12.0	38	16.0	45	24.0	50
2.70	3.00	12.0	38	16.0	45	24.0	50
2.71	3.00	12.0	38	18.0	45	26.0	50
2.72	3.00	12.0	38	18.0	45	26.0	50
2.73	3.00	12.0	38	18.0	45	26.0	50
2.74	3.00	12.0	38	18.0	45	26.0	50
2.75	3.00	12.0	38	18.0	45	26.0	50
2.76	3.00	12.0	38	18.0	45	26.0	50
2.77	3.00	12.0	38	18.0	45	26.0	50
2.78	3.00	12.0	38	18.0	45	26.0	50
2.79	3.00	12.0	38	18.0	45	26.0	50
2.80	3.00	12.0	38	18.0	45	26.0	50
2.81	3.00	12.0	38	18.0	45	26.0	50
2.82	3.00	12.0	38	18.0	45	26.0	50
2.83	3.00	12.0	38	18.0	45	26.0	50
2.84	3.00	12.0	38	18.0	45	26.0	50
2.85	3.00	12.0	38	18.0	45	26.0	50
2.86	3.00	12.0	38	18.0	45	26.0	50
2.87	3.00	12.0	38	18.0	45	26.0	50
2.88	3.00	12.0	38	18.0	45	26.0	50
2.89	3.00	12.0	38	18.0	45	26.0	50
2.90	3.00	12.0	38	18.0	45	26.0	50
2.91	3.00	12.0	38	18.0	45	26.0	50
2.92	3.00	12.0	38	18.0	45	26.0	50
2.93	3.00	12.0	38	18.0	45	26.0	50
2.94	3.00	12.0	38	18.0	45	26.0	50
2.95	3.00	12.0	38	18.0	45	26.0	50
2.96	3.00	12.0	38	18.0	45	26.0	50
2.97	3.00	12.0	38	18.0	45	26.0	50
2.98	3.00	12.0	38	18.0	45	26.0	50
2.99	3.00	12.0	38	18.0	45	26.0	50
3.00	3.00	12.0	38	18.0	45	26.0	50

Machining Parameters

Materials			Dia Range					
			0.015	0.02-0.03	0.04-0.05	0.06-0.07	0.08-0.09	0.10-0.20
P	Low/Unalloyed Steel <600 N/mm ²	N min-1	35000-30000	30000-28000	27000-26000	24000	23000	23000-21000
		F mm/rev	0.0003	0.0005	0.0007	0.0008	0.001-0.0012	0.002-0.005
	Low/Unalloyed Steel 600-1000 N/mm ²	N min-1	35000-30000	30000-28000	27000-26000	24000	23000	23000-21000
		F mm/rev	0.0003	0.0005	0.0007	0.0008	0.0010-0.0012	0.002-0.005
	High Alloyed Steel 700-1500 N/mm ²	N min-1	32000	28000	26000	24000	22000	22000-20000
		F mm/rev	0.0003	0.0005	0.0007	0.0008	0.0010-0.0012	0.002-0.005
M	Ferritic/Martensitic	N min-1	32000	28000	26000	24000	22000	20000
		F mm/rev	0.0003	0.0003	0.0005	0.0006	0.0008	0.0010-0.0015
	Austenitic	N min-1	32000	28000	26000	24000	22000	20000
		F mm/rev	0.0003	0.0004	0.0006	0.0007	0.0009	0.0010-0.0015
	Duplex/PH > 800 N/mm ²	N min-1	30000	25200	23400	21600	19800	18000
		F mm/rev	0.0003	0.0003	0.0005	0.0006	0.0008	0.0010-0.0015
K	GCI/NCI <180 BHN	N min-1	35000-30000	30000-28000	27000-26000	24000	23000	23000-21000
		F mm/rev	0.0003	0.0005	0.0007	0.0008	0.0010-0.0012	0.002-0.005
	GCI/NCI 200-250 BHN	N min-1	32000	28000	26000	24000	22000	20000
		F mm/rev	0.0003	0.0005	0.0007	0.0008	0.0010-0.0012	0.002-0.005
N	Al Alloy	N min-1	37000-32000	30000-28000	27000-26000	25000	23000	23000-21000
		F mm/rev	0.0005	0.001	0.0015-0.0025	0.0025-0.0035	0.0035-0.0040	0.005-0.010
	Cu Alloy	N min-1	37000-32000	30000-28000	27000-26000	25000	23000	23000-21000
		F mm/rev	0.0003	0.0005	0.0010-0.0015	0.0015-0.0020	0.002-0.003	0.004-0.007

Dia D (mm)	0.015-0.30	0.31-0.50	0.51-3.00
Peck Depth (mm)	0.1xd	(0.2-0.3)xd	0.5xd

Dia Range								
0.21-0.30	0.31-0.40	0.41-0.50	0.51-0.70	0.71-1.00	1.01-1.50	1.51-2.00	2.01-2.50	2.51-3.00
20000-19000	19000-18000	18000-17000	17000-15000	15000-12000	12000-10000	9500-8000	8000-7000	7000-6000
0.005-0.010	0.010-0.015	0.015-0.017	0.017-0.020	0.020-0.030	0.030-0.35	0.035-0.040	0.040-0.045	0.045-0.050
20000-19000	19000-18000	18000-17000	17000-15000	15000-12000	12000-10000	9500-8000	8000-7000	7000-6000
0.005-0.010	0.010-0.015	0.015-0.017	0.017-0.020	0.020-0.030	0.030-0.35	0.035-0.040	0.040-0.045	0.045-0.050
19000-18000	18000-17000	17000-15000	15000-12000	12000-10000	10000-9000	9000-7000	7000-6000	6000-5000
0.005-0.010	0.010-0.015	0.015-0.017	0.017-0.020	0.020-0.030	0.030-0.35	0.035-0.040	0.040-0.045	0.045-0.050
17500	16500	15500	12500	9000	7000	6000	5000	4000
0.0015-0.0020	0.003-0.004	0.004-0.005	0.005-0.010	0.010-0.015	0.015-0.020	0.020-0.022	0.022-0.025	0.025-0.030
17500	16500	15500	12500	9000	7000	6000	5000	4000
0.0015-0.0020	0.003-0.004	0.004-0.005	0.005-0.010	0.010-0.015	0.015-0.020	0.020-0.022	0.022-0.025	0.025-0.030
15750	14850	13950	11625	8100	6300	5400	4500	3600
0.0015-0.0020	0.003-0.004	0.004-0.005	0.005-0.007	0.007-0.010	0.010-0.015	0.015-0.020	0.020-0.022	0.025-0.030
20000-19000	19000-18000	18000-17000	17000-15000	15000-12000	12000-10000	9500-8000	8000-7000	7000-6000
0.005-0.010	0.010-0.015	0.015-0.017	0.017-0.020	0.020-0.030	0.030-0.35	0.035-0.040	0.040-0.045	0.045-0.050
18000	17000	15700	14000	11500	9500	8000	7000	6000
0.005-0.010	0.010-0.015	0.015-0.017	0.017-0.020	0.020-0.025	0.025-0.030	0.030-0.035	0.035-0.040	0.040-0.045
20000-19000	19000-18000	18000-18500	18500-17500	16000-15000	14000-12000	10000-9000	9000-8000	8000-7000
0.010-0.015	0.015-0.020	0.020-0.027	0.027-0.035	0.035-0.045	0.045-0.055	0.055-0.065	0.070-0.10	0.10-0.12
20000-19000	19000-18000	18000-18500	18500-17500	16000-15000	14000-12000	10000-9000	9000-8000	8000-7000
0.008-0.012	0.012-0.017	0.017-0.022	0.022-0.032	0.032-0.040	0.040-0.045	0.045-0.050	0.050-0.070	0.07-0.10

* When machines can not achieve a recommended rotation speed, please set maximum possible speed in stable rotation range of the machine and adjust the feed rate.

* For smaller drills under $\phi 0.5$, the most stable rotation speed of the spindle takes precedence over the recommended conditions indicated in the table.



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