



RECOMMENDED SPEED AND FEED for HERBA CARBIDE INSERT

Diameter (MM)	VC Meters/min	F Feed/rev	Recommended RPM			Recommended feed		
			Optimum	Minimum	Maximum	Optimum	Minimum	Maximum
14	80-90	0.19-0.27	1704	1364	2047	375	259	552
16	80-90	0.19-0.27	1491	1194	1791	328	226	483
17	80-90	0.19-0.27	1365	1124	1686	300	213	455
18	80-90	0.19-0.27	1325	1061	1592	292	201	429
20	80-90	0.22-0.3	1193	955	1433	262	210	429
21	80-90	0.22-0.3	1136	909	1364	284	199	409
22	80-90	0.22-0.3	1084	868	1302	271	190	390
23	80-90	0.22-0.3	1037	830	1246	259	182	373
24	80-90	0.22-0.3	994	796	1134	278	175	340
25	80-90	0.25-0.33	954	764	1146	267	191	378
25.4	80-90	0.25-0.33	939	752	1128	263	188	372
26	80-90	0.25-0.33	917	734	1102	257	183	363
27	80-90	0.25-0.33	883	707	1061	247	176	350
28	80-90	0.25-0.33	852	682	1023	239	170	337
29	80-90	0.25-0.33	822	658	988	230	164	326
30	80-90	0.25-0.33	795	636	955	223	159	315
31	80-90	0.25-0.33	769	616	924	231	154	304
32	80-90	0.28-0.38	745	597	895	224	167	340
33	80-90	0.28-0.38	723	579	868	217	162	329
35	80-90	0.28-0.38	681	545	818	204	152	310
36	80-90	0.28-0.38	663	530	796	199	148	302
38	80-90	0.28-0.38	628	502	754	188	140	286
39	80-90	0.28-0.38	612	489	739	183	136	280
40	80-90	0.3-0.42	596	477	716	179	143	300

Recommended speed and feed are for reference , Please adjust the the data according to the actual working conditions

Use only designated insert blade with each drill body

***when chip evacuation not ideal, please increase the Feed,

***when the Surface Roughness no ideal, please increase the RPM accordingly

***when sparks occur , it may due to impurities ; or you may decrease the RPM to avoid the sparks only when it occur often