

MAGIC DRILLS - HIGH HARDENED STEELS

RPM : rev/min.

FEED : mm/min

Cutting Condition

RTDH30

Material	Hardened Steels					
Hardness	HRc 50~55		HRc 55~60		HRc 60~70	
Drilling Speed	12~22 m/min		10~16 m/min		8~13 m/min	
Diameter	RPM	FEED	RPM	FEED	RPM	FEED
3.0	1,900	0.040	1,330	0.040	1,250	0.040
4.0	1,430	0.040	1,000	0.040	950	0.040
5.0	1,150	0.040	800	0.040	750	0.040
6.0	960	0.040	670	0.040	630	0.040
8.0	720	0.040	500	0.040	480	0.040
10.0	570	0.040	400	0.040	380	0.040
12.0	480	0.040	330	0.040	320	0.040
14.0	438	0.040	282	0.040	272	0.040

ECO-CUT

WIDE-CUT

HARD-CUT

ALU-CUT

D-CUT

SUS CUT

MAGIC DRILLS