

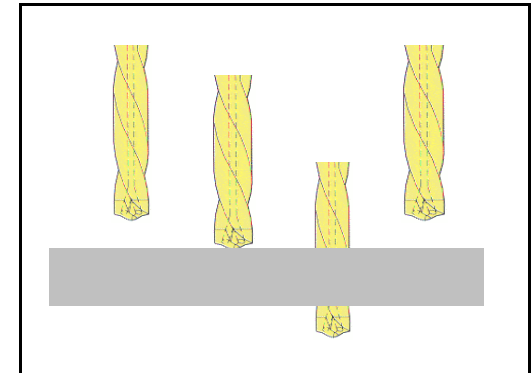
Carbide - Drilling times

Material thickness [mm]	Drill diameters [mm]								
	up to 16	up to 19	up to 22	up to 25	up to 28	up to 31	up to 34	up to 37	up to 40
4	4	4	4	5	5	5	6	6	7
5	4	4	4	4	5	5	5	6	6
6	4	4	4	5	5	5	6	6	6
7	4	4	4	5	5	5	6	6	6
8	4	4	5	5	5	6	6	6	7
9	4	4	5	5	6	6	6	7	7
10	4	5	5	5	6	6	6	7	7
11	5	5	5	6	6	6	7	7	7
12	5	5	5	6	6	7	7	7	8
13	5	5	5	6	6	7	7	8	8
14	5	5	6	6	7	7	7	8	8
15	5	5	6	6	7	7	8	8	9
16	5	6	6	7	7	7	8	8	9
17	5	6	6	7	7	8	8	9	9
18	6	6	6	7	7	8	8	9	9
19	6	6	7	7	8	8	9	9	10
20	6	6	7	7	8	8	9	9	10
21	6	6	7	7	8	9	9	10	10
22	6	6	7	8	8	9	9	10	10
23	6	7	7	8	8	9	10	10	11
24	6	7	7	8	9	9	10	10	11
25	7	7	8	8	9	9	10	11	11
26	7	7	8	8	9	10	10	11	12
27	7	7	8	9	9	10	11	11	12
28	7	7	8	9	10	10	11	11	12
29	7	8	8	9	10	10	11	12	12
30	7	8	8	9	10	11	11	12	13
31	7	8	9	9	10	11	12	12	13
32	8	8	9	10	10	11	12	12	13
33	8	8	9	10	11	11	12	13	13
34	8	8	9	10	11	11	12	13	14
35	8	8	9	10	11	12	13	13	14
36	8	9	9	10	11	12	13	13	14
37	8	9	10	11	11	12	13	14	14
38	8	9	10	11	12	12	13	14	15
39	9	9	10	11	12	13	14	14	15
40	9	9	10	11	12	13	14	14	15
41	9	9	10	11	12	13	14	15	16
42	9	10	10	12	12	13	14	15	16
43	9	10	11	12	13	13	15	15	16
44	9	10	11	12	13	14	15	16	16
45	9	10	11	12	13	14	15	16	17

Formular for drilling time calculation:

Forward stroke:	3	mm
Flange:	???	mm
Top of drill:	0,2 x D	mm
Overrun:	2	mm
=		path
/		feed
+	forward/return motion	

Drill time including forward stroke and overrun +
drill feed + return motion in seconds



Drilling time carbid drills