

Processdata Centerdrill & Centertap

Flow drilling & threadforming



Reference values for material S235JR (St37/2) with 2 mm wall thickness:

Thread	core hole Ø mm	Centerdrill Flow Forming			Centertap Thread Forming	
		RPM	Torque Nm	machine output kW	RPM	Torque Nm

Metric ISO thread per DIN 13

M3 x 0,5	2,7	3000	2,5	0,7	1500	1,3
M4 x 0,7	3,7	2600	3	0,8	1100	3
M5 x 0,8	4,5	2500	4	0,9	900	4,9
M6 x 1	5,4	2400	5	1,1	800	9,3
M8 x 1,25	7,3	2100	7	1,5	600	19
M10 x 1,5	9,2	1800	10	1,7	380	39
M12 x 1,75	10,9	1500	14	1,9	300	50
M14 x 2	13	1500	16	2,2	300	55
M16 x 2	14,8	1400	19	2,4	200	57
M20 x 2,5	18,7	1200	29	3	160	105

Whitworth pipe thread

G1/8"	9,2	1800	10	1,7	380	13
G1/4"	12,4	1600	16	2,1	280	34
G3/8"	15,9	1400	24	2,6	200	46
G1/2"	19,9	1200	32	3,2	140	94
G3/4"	25,4	1000	55	3,8	100	128

Please note:

Processing of stainless steel:

- Centerdrill core hole diameter + 0,1 mm from M8 to M12
- 10 - 20% lower speed (RPM)
- Higher machine performance => approx. 30%

Processing of non-ferrous metals:

- Up to 50% higher speed (RPM)

Feed rate: 50 - 150mm/min

By using the centerdrill with flat cutters the feed rate should be substantially increased at the end of the process => 900mm/min

Feed rate + RPM + wall thickness influence the torque!

Find more details for different materials in our „Toolfinder“, called Centerdrill-Explorer.
Simply go online at www.centerdrill.de

