

Machine Parameters



FLOWDRILL

RPM table to use in different material thickness



Thread	Flowdrill diameter	1 mm Material thickness			1.5 mm Material thickness			2 mm Material thickness			2.5 mm Material thickness		
		Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed
M2	1.8	3400	0.5	100	3400	0.5	80	3200	0.5	80	3200	0.6	80
M2.5	2.3	3400	0.5	100	3400	0.5	80	3200	0.5	80	3200	0.6	80
M3	2.7	3200	0.6	120	3200	0.6	100	3000	0.6	100	3000	0.6	100
M4	3.7	3000	0.7	120	2800	0.7	120	2600	0.7	120	2600	0.7	120
M4x0.5	3.8	3000	0.7	120	2800	0.7	120	2600	0.7	120	2600	0.7	120
M5	4.5	2800	0.8	150	2800	0.8	150	2500	0.8	150	2500	0.8	150
M5x0.5	4.8	2800	0.8	150	2800	0.8	150	2500	0.8	150	2500	0.8	150
M6	5.3	2800	1.0	150	2600	1.0	150	2400	1.0	150	2400	1.0	150
M6x0.75	5.6	2800	1.0	150	2600	1.0	150	2400	1.0	150	2400	1.0	150
M6x0.5	5.8	2800	1.0	150	2600	1.0	150	2400	1.0	150	2400	1.0	150
M8	7.3	2800	1.3	150	2400	1.3	150	2200	1.3	150	2200	1.3	150
M8x1	7.5	2800	1.3	150	2400	1.3	150	2200	1.3	150	2200	1.3	150
M8x0.75	7.6	2800	1.3	150	2400	1.3	150	2200	1.3	150	2200	1.3	150
M10	9.2	2400	1.5	150	2200	1.5	150	2000	1.5	150	2000	1.5	150
M10x1.25	9.3	2400	1.5	150	2200	1.5	150	2000	1.5	150	2000	1.5	150
M10x1	9.5	2400	1.5	150	2200	1.5	150	2000	1.5	150	2000	1.5	150
M12	10.9	2200	1.7	150	2000	1.7	150	1800	1.7	150	1800	1.7	150
M12x1.5	11.2	2200	1.7	150	2000	1.7	150	1800	1.7	150	1800	1.7	150
M12x1	11.5	2200	1.7	150	2000	1.7	150	1800	1.7	150	1800	1.7	150
M14	13.0				1800	2.0	150	1600	2.0	150	1600	2.0	150
M14x1.5	13.2				1800	2.0	150	1600	2.0	150	1600	2.0	150
M16	14.8				1600	2.2	150	1400	2.2	150	1400	2.2	150
M16x1.5	15.2				1600	2.2	150	1400	2.2	150	1400	2.2	150
M18	16.7				1600	2.5	150	1400	2.5	150	1400	2.5	150
M18x1.5	17.3				1600	2.5	150	1400	2.5	150	1400	2.5	150
M18x1	17.5				1600	2.5	150	1400	2.5	150	1400	2.5	150
M20	18.7				1600	2.7	150	1200	2.7	150	1200	2.7	150
M20x1.5	19.2				1600	2.7	150	1200	2.7	150	1200	2.7	150
M20x1	19.5				1600	2.7	150	1200	2.7	150	1200	2.7	150
G1/8	9.2				2200	1.5	150	2000	1.5	150	2000	1.5	150
G1/4	12.4				1800	2.0	150	1600	2.0	150	1600	2.0	150
G3/8	15.9				1600	2.2	150	1400	2.2	150	1400	2.2	150
G1/2	19.9				1400	3.0	150	1200	3.0	150	1200	3.0	150
G3/4	25.4				1400	3.5	150	1000	3.5	150	1000	3.5	150

RPM table to use in different material thickness



Thread	Flowdrill diameter	3 mm Material thickness			3.5 mm Material thickness			4 mm Material thickness			4.5 mm Material thickness		
		Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed
M2	1.8	3000	0.6	80									
M2.5	2.3	3000	0.6	80									
M3	2.7	3000	0.8	100									
M4	3.7	2600	0.8	120	2400	1.0	100	2400	1.3	100			
M4x0.5	3.8	2600	0.8	120	2400	1.0	100	2400	1.3	100			
M5	4.5	2400	1.0	120	2400	1.0	120	2200	1.3	100	2200	1.5	100
M5x0.5	4.8	2400	1.0	120	2400	1.0	120	2200	1.3	100	2200	1.5	100
M6	5.3	2200	1.0	150	2200	1.3	150	2000	1.3	120	2000	1.5	120
M6x0.75	5.6	2200	1.0	150	2200	1.3	150	2000	1.3	120	2000	1.5	120
M6x0.5	5.8	2200	1.0	150	2200	1.3	150	2000	1.3	120	2000	1.5	120
M8	7.3	2200	1.3	150	2000	1.3	150	2000	1.5	120	1800	2.0	120
M8x1	7.5	2200	1.3	150	2000	1.3	150	2000	1.5	120	1800	2.0	120
M8x0.75	7.6	2200	1.3	150	2000	1.3	150	2000	1.5	120	1800	2.0	120
M10	9.2	2000	1.5	150	2000	1.5	150	1800	2.0	120	1800	2.0	120
M10x1.25	9.3	2000	1.5	150	2000	1.5	150	1800	2.0	120	1800	2.0	120
M10x1	9.5	2000	1.5	150	2000	1.5	150	1800	2.0	120	1800	2.0	120
M12	10.9	1800	1.7	150	1800	1.7	150	1800	2.0	120	1600	2.0	120
M12x1.5	11.2	1800	1.7	150	1800	1.7	150	1800	2.0	120	1600	2.0	120
M12x1	11.5	1800	1.7	150	1800	1.7	150	1800	2.0	120	1600	2.0	120
M14	13.0	1600	2.0	150	1600	2.0	150	1600	2.5	120	1600	2.5	120
M14x1.5	13.2	1600	2.0	150	1600	2.0	150	1600	2.5	120	1600	2.5	120
M16	14.8	1400	2.2	150	1400	2.2	120	1400	2.5	120	1400	2.5	120
M16x1.5	15.2	1400	2.2	150	1400	2.2	120	1400	2.5	120	1400	2.5	120
M18	16.7	1400	2.5	150	1400	2.5	120	1400	3.0	120	1400	3.0	120
M18x1.5	17.3	1400	2.5	150	1400	2.5	120	1400	3.0	120	1400	3.0	120
M18x1	17.5	1400	2.5	150	1400	2.5	120	1400	3.0	120	1400	3.0	120
M20	18.7	1200	2.7	150	1200	2.7	120	1200	3.0	120	1200	3.0	150
M20x1.5	19.2	1200	2.7	150	1200	2.7	120	1200	3.0	120	1200	3.0	150
M20x1	19.5	1200	2.7	150	1200	2.7	120	1200	3.0	120	1200	3.0	150
G1/8	9.2	2000	1.5	150	2000	1.5	150	1800	2.0	120	1800	2.0	120
G1/4	12.4	1600	2.0	150	1600	2.0	150	1600	2.5	120	1400	2.5	120
G3/8	15.9	1400	2.2	150	1400	2.2	120	1400	2.5	120	1400	2.5	120
G1/2	19.9	1200	3.0	150	1200	3.0	120	1200	3.0	120	1200	3.0	120
G3/4	25.4	1000	3.5	150	1000	3.5	120	1000	3.5	150	1000	3.5	150

RPM table to use in different material thickness



Thread	Flowdrill diameter	5 mm Material thickness			5.5 mm Material thickness			6 mm Material thickness			6.5 mm Material thickness		
		Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed
M2	1.8												
M2.5	2.3												
M3	2.7												
M4	3.7												
M4x0.5	3.8												
M5	4.5												
M5x0.5	4.8												
M6	5.3	1800	2.0	100									
M6x0.75	5.6	1800	2.0	100									
M6x0.5	5.8	1800	2.0	100									
M8	7.3	1800	2.5	120	1600	2.5	100	1600	2.5	100			
M8x1	7.5	1800	2.5	120	1600	2.5	100	1600	2.5	100			
M8x0.75	7.6	1800	2.5	120	1600	2.5	100	1600	2.5	100			
M10	9.2	1600	2.5	120	1600	2.5	100	1400	3.0	100	1400	3.0	100
M10x1.25	9.3	1600	2.5	120	1600	2.5	100	1400	3.0	100	1400	3.0	100
M10x1	9.5	1600	2.5	120	1600	2.5	100	1400	3.0	100	1400	3.0	100
M12	10.9	1600	3.0	120	1400	3.0	100	1400	3.0	100	1400	3.0	100
M12x1.5	11.2	1600	3.0	120	1400	3.0	100	1400	3.0	100	1400	3.0	100
M12x1	11.5	1600	3.0	120	1400	3.0	100	1400	3.0	100	1400	3.0	100
M14	13.0	1400	3.0	120	1400	3.0	100	1400	3.0	100	1200	3.0	100
M14x1.5	13.2	1400	3.0	120	1400	3.0	100	1400	3.0	100	1200	3.0	100
M16	14.8	1400	3.0	120	1400	3.0	100	1200	3.0	100	1200	3.0	100
M16x1.5	15.2	1400	3.0	120	1400	3.0	100	1200	3.0	100	1200	3.0	100
M18	16.7	1400	3.0	120	1200	3.0	120	1200	3.5	120	1200	3.5	100
M18x1.5	17.3	1400	3.0	120	1200	3.0	120	1200	3.5	120	1200	3.5	100
M18x1	17.5	1400	3.0	120	1200	3.0	120	1200	3.5	120	1200	3.5	100
M20	18.7	1200	3.0	120	1000	3.0	120	1000	3.5	120	1000	3.5	120
M20x1.5	19.2	1200	3.0	120	1000	3.0	120	1000	3.5	120	1000	3.5	120
M20x1	19.5	1200	3.0	120	1000	3.0	120	1000	3.5	120	1000	3.5	120
G1/8	9.2	1600	2.5	120	1600	2.5	100	1400	3.0	100	1400	3.0	100
G1/4	12.4	1400	3.0	120	1400	3.0	100	1400	3.0	100	1200	3.0	100
G3/8	15.9	1200	3.0	120	1200	3.0	100	1200	3.5	100	1200	3.5	100
G1/2	19.9	1000	3.0	120	1000	3.0	120	1000	3.5	120	1000	3.5	120
G3/4	25.4	900	3.5	120	900	3.5	120	900	4.0	120	900	4.0	120

RPM table to use in different material thickness



Thread	Flowdrill diameter	7 mm Material thickness			7.5 mm Material thickness			8 mm Material thickness			8,5 mm Material thickness		
		Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed
M2	1.8												
M2.5	2.3												
M3	2.7												
M4	3.7												
M4x0.5	3.8												
M5	4.5												
M5x0.5	4.8												
M6	5.3												
M6x0.75	5.6												
M6x0.5	5.8												
M8	7.3												
M8x1	7.5												
M8x0.75	7.6												
M10	9.2												
M10x1.25	9.3												
M10x1	9.5												
M12	10.9	1200	3.0	100	1200	3.0	100						
M12x1.5	11.2	1200	3.0	100	1200	3.0	100						
M12x1	11.5	1200	3.0	100	1200	3.0	100						
M14	13.0	1200	3.0	100	1200	3.0	100						
M14x1.5	13.2	1200	3.0	100	1200	3.0	100						
M16	14.8	1000	3.0	100	1000	3.0	100	1000	3.5	100	1000	3.5	100
M16x1.5	15.2	1000	3.0	100	1000	3.0	100	1000	3.5	100	1000	3.5	100
M18	16.7	1000	4.0	100	1000	4.0	100	1000	4.5	100	1000	4.5	100
M18x1.5	17.3	1000	4.0	100	1000	4.0	100	1000	4.5	100	1000	4.5	100
M18x1	17.5	1000	4.0	100	1000	4.0	100	1000	4.5	100	1000	4.5	100
M20	18.7	900	4.0	100	900	4.0	100	900	5.5	100	900	5.5	100
M20x1.5	19.2	900	4.0	100	900	4.0	100	900	5.5	100	900	5.5	100
M20x1	19.5	900	4.0	100	900	4.0	100	900	5.5	100	900	5.5	100
G1/8	9.2												
G1/4	12.4	1200	3.0	100	1200	3.0	100						
G3/8	15.9	1000	3.5	100	1000	3.5	100	1000	4.0	100	1000	4.0	100
G1/2	19.9	900	4.0	100	900	4.0	100	900	5.5	100	900	5.5	100
G3/4	25.4	900	4.5	100	900	4.5	100	900	5.5	100	900	5.5	100

RPM table to use in different material thickness



Thread	Flowdrill diameter	9 mm Material thickness			9.5 mm Material thickness			10 mm Material thickness		
		Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed	Rpm.	kW.	mm/min Feed
M2	1.8									
M2.5	2.3									
M3	2.7									
M4	3.7									
M4x0.5	3.8									
M5	4.5									
M5x0.5	4.8									
M6	5.3									
M6x0.75	5.6									
M6x0.5	5.8									
M8	7.3									
M8x1	7.5									
M8x0.75	7.6									
M10	9.2									
M10x1.25	9.3									
M10x1	9.5									
M12	10.9									
M12x1.5	11.2									
M12x1	11.5									
M14	13.0									
M14x1.5	13.2									
M16	14.8									
M16x1.5	15.2									
M18	16.7	1000	5.0	100	1000	5.0	100			
M18x1.5	17.3	1000	5.0	100	1000	5.0	100			
M18x1	17.5	1000	5.0	100	1000	5.0	100			
M20	18.7	900	6.0	100	900	6.0	100	900	6.0	100
M20x1.5	19.2	900	6.0	100	900	6.0	100	900	6.0	100
M20x1	19.5	900	6.0	100	900	6.0	100	900	6.0	100
G1/8	9.2									
G1/4	12.4									
G3/8	15.9	1000	4.5	100						
G1/2	19.9	900	6.0	100	900	6.0	100	900	6.0	100
G3/4	25.4	900	6.0	100	900	6.0	100	900	6.0	100



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