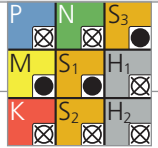


# CrazyDrill Cool SST-Inox 15 x d

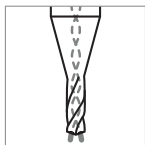
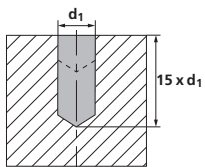
RECOMMENDATION FOR USE

● Excellent | ● Good | ○ Acceptable | ⊗ Not recommended



## DRILLING WITH INTERNAL COOLING | CUTTING DATA OVERVIEW

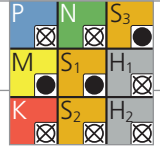
Materials group	Material	Mat. no.	DIN	v <sub>c</sub> [m/min]	f [mm/rev]																												
					Ød1 1.0 mm			Ød1 1.25 mm			Ød1 1.5 mm			Ød1 2.0 mm			Ød1 2.5 mm			Ød1 3.0 mm			Ød1 4.0 mm			Ød1 5.0 mm			Ød1 6.0 mm				
					Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Tief	Mid
<b>P</b>	Unalloyed carbon steel Rm < 800 N/mm²	1.0301	C 10																														
		1.0401	C 15																														
		1.1191	C 45E/CK45																														
		1.0044	S 275JR																														
		1.0715	11SMn30																														
	Low alloyed steel Rm > 900 N/mm²	1.5752	15NiCr13																														
		1.7131	16MnCr5																														
		1.3505	100Cr6																														
		1.7225	42CrMo4																														
		1.2842	90MnCrV8																														
	High alloyed tool steel Rm < 1200 N/mm²	1.2379	X 153CrMoV12																														
		1.2436	X 210CrW12																														
1.3343		HS 6-5-2C																															
1.3355		HS 18-0-1																															
<b>M</b>	Stainless steel ferritic	1.4016	X 6Cr17	60	80	100	0.010	0.020	0.030	0.013	0.025	0.038	0.015	0.030	0.045	0.020	0.040	0.060	0.025	0.050	0.075	0.030	0.060	0.090	0.040	0.080	0.120	0.050	0.100	0.150	0.060	0.120	0.180
		1.4105	X 6CrMoS17																														
	Stainless steel martensitic	1.4034	X 46Cr13	60	80	100	0.030	0.040	0.050	0.038	0.050	0.063	0.045	0.060	0.075	0.060	0.080	0.100	0.075	0.100	0.125	0.090	0.120	0.150	0.120	0.160	0.200	0.150	0.200	0.250	0.180	0.240	0.300
		1.4112	X 90CrMoV18																														
	Stainless steel martensitic – PH	1.4542	X 5CrNiCuNb 16-4	60	80	100	0.020	0.030	0.040	0.025	0.038	0.050	0.030	0.045	0.060	0.040	0.060	0.080	0.050	0.075	0.100	0.060	0.090	0.120	0.080	0.120	0.160	0.100	0.150	0.200	0.120	0.180	0.240
		1.4545	X 5CrNiCuNb 15-5																														
	Stainless steel austenitic	1.4301	X 5CrNi 18-10	60	80	100	0.020	0.030	0.040	0.025	0.038	0.050	0.030	0.045	0.060	0.040	0.060	0.080	0.050	0.075	0.100	0.060	0.090	0.120	0.080	0.120	0.160	0.100	0.150	0.200	0.120	0.180	0.240
		1.4435	X 2CrNiMo 18-14-3																														
1.4441		X 2CrNiMo 18-15-3																															
<b>K</b>	Cast iron	0.6020	GG 20																														
		0.6030	GG 30																														
		0.7040	GGG 40																														
		0.7060	GGG 60																														



# CrazyDrill Cool SST-Inox 15 x d

RECOMMENDATION FOR USE

● Excellent | ● Good | ○ Acceptable | ☒ Not recommended



## DRILLING WITH INTERNAL COOLING | CUTTING DATA OVERVIEW

Materials group	Material	Mat. no.	DIN	f [mm/rev]																																		
				v <sub>c</sub> [m/min]			Ød1 1.0 mm			Ød1 1.25 mm			Ød1 1.5 mm			Ød1 2.0 mm			Ød1 2.5 mm			Ød1 3.0 mm			Ød1 4.0 mm			Ød1 5.0 mm			Ød1 6.0 mm							
				Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High					
N	Aluminium alloy wrought	3.2315	AlMgSi1																																			
		3.4365	AlZnMgCu1.5																																			
	Aluminium alloy cast	3.2163	GD-ALSi9Cu3																																			
		3.2381	GD-ALSi10Mg																																			
	Copper	2.004	Cu-OF / CW008A																																			
		2.0065	Cu-ETP / CW004A																																			
	Brass lead free	2.0321	CuZn37 CW508L																																			
		2.036	CuZn40 CW509L																																			
Brass, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N																																				
	2.102	CuSn6																																				
Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4																																				
	2.096	CuAl9Mn2																																				
S <sub>1</sub>	Super alloys	2.4856		30	40	50	0.010	0.015	0.020	0.013	0.019	0.025	0.015	0.023	0.030	0.020	0.030	0.040	0.025	0.038	0.050	0.030	0.045	0.060	0.040	0.060	0.080	0.050	0.075	0.100	0.060	0.090	0.120					
		2.4668																																				
		2.4617	NiMo28																																			
		2.4665	NiCr22Fe18Mo																																			
S <sub>2</sub>	Titanium pure	3.7035	Gr.2																																			
		3.7065	Gr.4																																			
S <sub>3</sub>	Titanium alloys	3.7165	TiAl6V4																																			
		9.9367	TiAl6Nb7																																			
H <sub>1</sub>	Hardened steel < 55 HRC	2.4964	CoCr20W15Ni	50	70	90	0.020	0.030	0.040	0.025	0.038	0.050	0.030	0.045	0.060	0.040	0.060	0.080	0.050	0.075	0.100	0.060	0.090	0.120	0.080	0.120	0.160	0.100	0.150	0.200	0.120	0.180	0.240					
			CrCoMo28																																			
H <sub>2</sub>	Hardened steel ≥ 55 HRC	1.2510	100MnCrMoW4																																			
		1.2379	X153CrMoV12																																			

