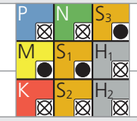
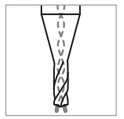
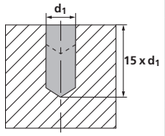
CrazyDrill Cool SST-Inox 15 x d

RECOMMENDATION FOR USE
● Excellent | ◐ Good | ○ Acceptable | ⊠ Not recommended



DRILLING WITH INTERNAL COOLING | CUTTING DATA OVERVIEW





f [mm/rev] | **[IPR]**

Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v_c [m/min] | **[SFM]** Low	v_c **Mid**	v_c High	Ød1 1.0 mm | **.039"** Low	Mid	High	Ød1 1.25 mm | **.049"** Low	Mid	High	Ød1 1.5 mm | **.059"** Low	Mid	High	Ød1 2.0 mm | **.079"** Low	Mid	High	Ød1 2.5 mm | **.098"** Low	Mid	High	Ød1 3.0 mm | **.118"** Low	Mid	High	Ød1 4.0 mm | **.157"** Low	Mid	High	Ød1 5.0 mm | **.197"** Low	Mid	High	Ød1 6.0 mm | **.236"** Low	Mid	High
P	Unalloyed carbon steel Rm < 800 N/mm²	1.0301	C10	AISI 1010																																		
		1.0401	C15	AISI 1015																																		
		1.1191	C45E/CK45	AISI 1045																																		
		1.0044	S275JR	AISI 1020																																		
		1.0715	11SMn30	AISI 1215																																		
	Low alloyed steel Rm > 900 N/mm²	1.5752	15NiCr13	ASTM 3415 / AISI 3310																																		
		1.7131	16MnCr5	AISI 5115																																		
		1.3505	100Cr6	AISI 52100																																		
		1.7225	42CrMo4	AISI 4140																																		
		1.2842	90MnCrV8	AISI O2																																		
	High alloyed tool steel Rm < 1200 N/mm²	1.2379	X153CrMoV12	AISI D2																																		
		1.2436	X210CrW12	AISI D4/D6																																		
		1.3343	HS6-5-2C	AISI M2 / UNS T11302																																		
		1.3355	HS18-0-1	AISI T1 / UNS T12001																																		
M	Stainless steel ferritic	1.4016	X6Cr17	AISI 430 / UNS S43000	60 | **197**	80 | **262**	100 | **328**	0.010 **.0004**	0.020 **.0008**	0.030 **.0012**	0.013 **.0005**	0.025 **.0010**	0.038 **.0015**	0.015 **.0006**	0.030 **.0012**	0.045 **.0018**	0.020 **.0008**	0.040 **.0016**	0.060 **.0024**	0.025 **.0010**	0.050 **.0020**	0.075 **.0030**	0.030 **.0012**	0.060 **.0024**	0.090 **.0035**	0.040 **.0016**	0.080 **.0031**	0.120 **.0047**	0.050 **.0020**	0.100 **.0039**	0.150 **.0059**	0.060 **.0024**	0.120 **.0047**	0.180 **.0071**
		1.4105	X6CrMoS17	AISI 430F																																		
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	60 | **197**	80 | **262**	100 | **328**	0.030 **.0012**	0.040 **.0016**	0.050 **.0020**	0.038 **.0015**	0.050 **.0020**	0.063 **.0025**	0.045 **.0018**	0.060 **.0024**	0.075 **.0030**	0.060 **.0024**	0.080 **.0031**	0.100 **.0039**	0.075 **.0030**	0.100 **.0039**	0.125 **.0049**	0.090 **.0035**	0.120 **.0047**	0.150 **.0059**	0.120 **.0047**	0.160 **.0063**	0.200 **.0079**	0.150 **.0059**	0.200 **.0079**	0.250 **.0098**	0.180 **.0071**	0.240 **.0094**	0.300 **.0118**
		1.4112	X90CrMoV18	AISI 440B																																		
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH	60 | **197**	80 | **262**	100 | **328**	0.020 **.0008**	0.030 **.0012**	0.040 **.0016**	0.025 **.0010**	0.038 **.0015**	0.050 **.0020**	0.030 **.0012**	0.045 **.0018**	0.060 **.0024**	0.040 **.0016**	0.060 **.0024**	0.080 **.0031**	0.050 **.0020**	0.075 **.0030**	0.100 **.0039**	0.060 **.0024**	0.090 **.0035**	0.120 **.0047**	0.080 **.0031**	0.120 **.0047**	0.160 **.0063**	0.100 **.0039**	0.150 **.0059**	0.200 **.0079**	0.120 **.0047**	0.180 **.0071**	0.240 **.0094**
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH																																		
	Stainless steel austenitic	1.4301	X5CrNi 18-10	AISI 304	60 | **197**	80 | **262**	100 | **328**	0.020 **.0008**	0.030 **.0012**	0.040 **.0016**	0.025 **.0010**	0.038 **.0015**	0.050 **.0020**	0.030 **.0012**	0.045 **.0018**	0.060 **.0024**	0.040 **.0016**	0.060 **.0024**	0.080 **.0031**	0.050 **.0020**	0.075 **.0030**	0.100 **.0039**	0.060 **.0024**	0.090 **.0035**	0.120 **.0047**	0.080 **.0031**	0.120 **.0047**	0.160 **.0063**	0.100 **.0039**	0.150 **.0059**	0.200 **.0079**	0.120 **.0047**	0.180 **.0071**	0.240 **.0094**
		1.4435	X2CrNiMo 18-14-3	AISI 316L																																		
		1.4441	X2CrNiMo 18-15-3	AISI 316LM																																		
		1.4539	X1NiCrMoCu 25-20-5	AISI 904L																																		
K	Cast iron	0.6020	GG20	ASTM 30																																		
		0.6030	GG30	ASTM 40B																																		
		0.7040	GGG40	ASTM 60-40-18																																		
		0.7060	GGG60	ASTM 80-60-03																																		
N	Aluminium alloy wrought	3.2315	AlMgSi1	ASTM 6351																																		
		3.4365	AlZnMgCu1.5	ASTM 7075																																		
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380																																		
		3.2381	GD-AlSi10Mg	UNS A03590																																		
	Copper	2.004	Cu-OF / CW008A	UNS C10100																																		
		2.0065	Cu-ETP / CW004A	UNS C11000																																		
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400																																		
		2.036	CuZn40 CW509L	UNS C28000																																		
	Brass, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500																																		
		2.102	CuSn6	UNS C51900																																		
	Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000																																		
		2.096	CuAl9Mn2	UNS C63200																																		
S_1	Super alloys	2.4856		Inconel 625	30 | **98**	40 | **131**	50 | **164**	0.010 **.0004**	0.015 **.0006**	0.020 **.0008**	0.013 **.0005**	0.019 **.0007**	0.025 **.0010**	0.015 **.0006**	0.023 **.0009**	0.030 **.0012**	0.020 **.0008**	0.030 **.0012**	0.040 **.0016**	0.025 **.0010**	0.038 **.0015**	0.050 **.0020**	0.030 **.0012**	0.045 **.0018**	0.060 **.0024**	0.040 **.0016**	0.060 **.0024**	0.080 **.0031**	0.050 **.0020**	0.075 **.0030**	0.100 **.0039**	0.060 **.0024**	0.090 **.0035**	0.120 **.0047**
		2.4668		Inconel 718																																		
		2.4617	NiMo28	Hastelloy B-2																																		
		2.4665	NiCr22Fe18Mo	Hastelloy X																																		
S_2	Titanium pure	3.7035	Gr.2	ASTM B348 / F67																																		
		3.7065	Gr.4	ASTM B348 / F68																																		
	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136																																		
		9.9367	TiAl6Nb7	ASTM F1295																																		
S_3	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	50 | **164**	70 | **230**	90 | **295**	0.020 **.0008**	0.030 **.0012**	0.040 **.0016**	0.025 **.0010**	0.038 **.0015**	0.050 **.0020**	0.030 **.0012**	0.045 **.0018**	0.060 **.0024**	0.040 **.0016**	0.060 **.0024**	0.080 **.0031**	0.050 **.0020**	0.075 **.0030**	0.100 **.0039**	0.060 **.0024**	0.090 **.0035**	0.120 **.0047**	0.080 **.0031**	0.120 **.0047**	0.160 **.0063**	0.100 **.0039**	0.150 **.0059**	0.200 **.0079**	0.120 **.0047**	0.180 **.0071**	0.240 **.0094**
			CrCoMo28	ASTM F1537																																		
H_1	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1																																		
H_2	Hardened steel ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2																																		

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