

CrazyDrill Cool SST-Inox 30 x d

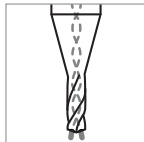
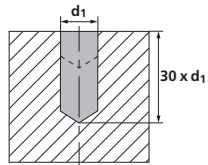
RECOMMENDATION FOR USE

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

P	N	S ₃
M	S ₁	H ₁
K	S ₂	H ₂

DRILLING WITH INTERNAL COOLING | CUTTING DATA OVERVIEW

Materials group	Material	AISI/ASTM/UNS	f [mm/rev] [IPR]																							
			v _c [m/min] [SFM]			Ød1 1.45 mm .057"			Ød1 2.0 mm .079"			Ød1 2.5 mm .098"			Ød1 3.0 mm .118"			Ød1 4.0 mm .157"			Ød1 5.0 mm .197"			Ød1 6.0 mm .236"		
			Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High	Low	Mid	High
P	Unalloyed carbon steel Rm < 800 N/mm ²	AISI 1010																								
		AISI 1015																								
		AISI 1045																								
		AISI 1020																								
		AISI 1215																								
	Low alloyed steel Rm > 900 N/mm ²	ASTM 3415 / AISI 3310																								
		AISI 5115																								
		AISI 52100																								
		AISI 4140																								
		AISI O2																								
	High alloyed tool steel Rm < 1200 N/mm ²	AISI D2																								
		AISI D4/D6																								
AISI M2 / UNS T11302																										
	AISI T1 / UNS T12001																									
M	Stainless steel ferritic	AISI 430 / UNS S43000	60 197	80 262	100 328	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	0.100 .0039	0.100 .0039	0.060 .0024	0.090 .0035	0.120 .0047
		AISI 430F																								
	Stainless steel martensitic	AISI 420C	60 197	80 262	100 328	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
		AISI 440B																								
	Stainless steel martensitic – PH	AISI 630 / ASTM 17-4 PH	60 197	80 262	100 328	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
		ASTM 15-5 PH																								
	Stainless steel austenitic	AISI 304																								
		AISI 316L	60 197	80 262	100 328	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
AISI 316LM																										
	AISI 904L																									
K	Cast iron	ASTM 30																								
		ASTM 40B																								
		ASTM 60-40-18																								
		ASTM 80-60-03																								



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			v _c [m/min] [SFM]			Ød1 1.45 mm .057"			Ød1 2.0 mm .079"			Ød1 2.5 mm .098"			Ød1 3.0 mm .118"			Ød1 4.0 mm .157"			Ød1 5.0 mm .197"			Ød1 6.0 mm .236"		
			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	ASTM 6351 ASTM 7075																								
	Aluminium alloy cast	ASTM A380 UNS A03590																								
	Copper	UNS C10100																								
		UNS C11000																								
	Brass lead free	UNS C27400																								
		UNS C28000																								
	Brass, Bronze Rm < 400 N/mm ²	UNS C38500 UNS C51900																								
Brass, Bronze Rm < 600 N/mm ²	UNS C63000 UNS C63200																									
S ₁	Super alloys	Inconel 625																								
		Inconel 718	25 82	35 115	45 148	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
		Hastelloy B-2				.0006	.0009	.0012	.0008	.0012	.0016	.0010	.0015	.0020	.0012	.0018	.0024	.0016	.0024	.0031	.0020	.0030	.0039	.0024	.0035	.0047
		Hastelloy X																								
S ₂	Titanium pure	ASTM B348 / F67																								
		ASTM B348 / F68																								
S ₃	Titanium alloys	ASTM B348 / F136																								
		ASTM F1295																								
H ₁	Hardened steel < 55 HRC	AISI O1	50 164	70 230	90 295	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
			.0006	.0012	.0018	.0008	.0016	.0024	.0010	.0020	.0030	.0012	.0024	.0035	.0016	.0031	.0047	.0020	.0039	.0059	.0024	.0047	.0071			
H ₂	Hardened steel ≥ 55 HRC	AISI D2																								

