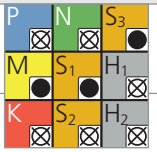
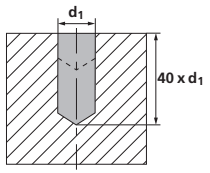
CrazyDrill Cool SST-Inox 40 x d

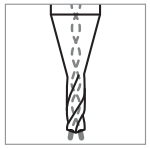
RECOMMENDATION FOR USE
● Excellent | ◐ Good | ○ Acceptable | ⊠ Not recommended



DRILLING WITH INTERNAL COOLING | CUTTING DATA OVERVIEW

Materials group	Material	Mat. no.	DIN	v_c [m/min]			f [mm/rev] Ød1 1.45 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	Tief	**Mid**	High
P	Unalloyed carbon steel Rm < 800 N/mm²	1.0301	C10																							
		1.0401	C15																							
		1.1191	C45E/CK45																							
		1.0044	S275JR																							
		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	X153CrMoV12																							
		1.2436	X210CrW12																							
		1.3343	HS6-5-2C																							
		1.3355	HS18-0-1																							
M	Stainless steel ferritic	1.4016	X6Cr17	60	80	100	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
		1.4105	X6CrMoS17																							
	Stainless steel martensitic	1.4034	X46Cr13	60	80	100	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
		1.4112	X90CrMoV18																							
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb 16-4	60	80	100	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
		1.4545	X5CrNiCuNb 15-5																							
	Stainless steel austenitic	1.4301	X5CrNi 18-10	60	80	100	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
		1.4435	X2CrNiMo 18-14-3																							
		1.4441	X2CrNiMo 18-15-3																							
		1.4539	X1NiCrMoCu 25-20-5																							
K	Cast iron	0.6020	GG20																							
		0.6030	GG30																							
		0.7040	GGG40																							
		0.7060	GGG60																							





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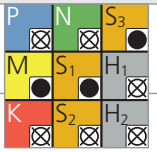

DRILLING WITH INTERNAL COOLING | CUTTING DATA OVERVIEW

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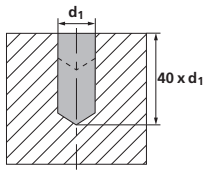
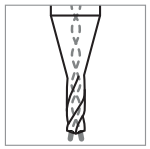
				Low	**Mid**	High	Low	**Mid**	High	Low	**Mid**	High	Low	**Mid**	High	Low	**Mid**	High	Low	**Mid**	High	Low	**Mid**	High	Tief	**Mid**	High
N	Aluminium alloy wrought	3.2315	AlMgSi1																								
		3.4365	AlZnMgCu1.5																								
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3																								
		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_1	Super alloys	2.4856		25	35	45	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_2	Titanium pure	3.7035	Gr.2																								
		3.7065	Gr.4																								
	Titanium alloys	3.7165	TiAl6V4																								
		9.9367	TiAl6Nb7																								
S_3	CrCo alloys	2.4964	CoCr20W15Ni	50	70	90	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
			CrCoMo28																								
H_1	Hardened steel < 55 HRC	1.2510	100MnCrMoW4																								
H_2	Hardened steel ≥ 55 HRC	1.2379	X153CrMoV12																								





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