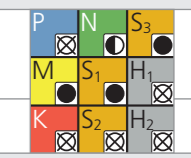
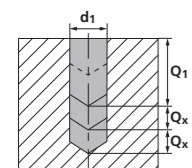
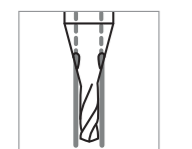


SST-Inox - 30 x d

RECOMMENDATION FOR USE
● Excellent | ● Good | ○ Acceptable | ⊗ Not recommended



DRILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v _c		Q ₁	Q ₂	f [mm/rev] [IPR]							
					[m/min] [SFM]				1/64"		Ød1 1/32"		1.0 mm .039"		1.2 mm .047"	
					Ød1 ≤ 0.4 .016"	Ød1 > 0.4 .016"			0.2 mm .008"	0.4 mm .016"	0.6 mm .024"	0.8 mm .032"	1.0 mm .039"	1.2 mm .047"	f	f
P	Unalloyed carbon steel Rm < 800 N/mm²	1.0301	C10	AISI 1010					Recommended: CrazyDrill Flex Steel 30 x d1							
		1.0401	C15	AISI 1015					Recommended: CrazyDrill Flex Steel 30 x d1							
		1.1191	C45E/CK45	AISI 1045					Recommended: CrazyDrill Flex Steel 30 x d1							
		1.0044	S275JR	AISI 1020					Recommended: CrazyDrill Flex Steel 30 x d1							
		1.0715	11SMn30	AISI 1215					Recommended: CrazyDrill Flex Steel 30 x d1							
	Low alloyed steel Rm > 900 N/mm²	1.5752	15NiCr13	ASTM 3415 / AISI 3310					Recommended: CrazyDrill Flex Steel 30 x d1							
		1.7131	16MnCr5	AISI 5115					Recommended: CrazyDrill Flex Steel 30 x d1							
		1.3505	100Cr6	AISI 52100					Recommended: CrazyDrill Flex Steel 30 x d1							
		1.7225	42CrMo4	AISI 4140					Recommended: CrazyDrill Flex Steel 30 x d1							
		1.2842	90MnCrV8	AISI O2					Recommended: CrazyDrill Flex Steel 30 x d1							
	High alloyed tool steel Rm < 1200 N/mm²	1.2379	X153CrMoV12	AISI D2					Recommended: CrazyDrill Flex Steel 30 x d1							
		1.2436	X210CrW12	AISI D4/D6					Recommended: CrazyDrill Flex Steel 30 x d1							
1.3343		HS6-5-2C	AISI M2 / UNS T11302					Recommended: CrazyDrill Flex Steel 30 x d1								
1.3355		HS18-0-1	AISI T1 / UNS T12001					Recommended: CrazyDrill Flex Steel 30 x d1								
M	Stainless steel ferritic	1.4016	X6Cr17	AISI 430 / UNS S43000	30 – 40 98 – 131	40 – 50 131 – 164	2xd1 – 3xd1	0.5xd1	0.015–0.020 .0006–.0008	0.015–0.020 .0006–.0008	0.020–0.030 .0008–.0012	0.020–0.030 .0008–.0012	0.030–0.040 .0012–.0016	0.040–0.050 .0016–.0020		
		1.4105	X6CrMoS17	AISI 430F												
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	20 – 30 66 – 98	30 – 40 98 – 131	2xd1 – 3xd1	0.5xd1	0.015–0.020 .0006–.0008	0.015–0.020 .0006–.0008	0.020–0.025 .0008–.0010	0.020–0.025 .0008–.0010	0.025–0.035 .0010–.0014	0.040–0.050 .0016–.0020		
		1.4112	X90CrMoV18	AISI 440B												
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH	20 – 30 66 – 98	30 – 40 98 – 131	2xd1 – 3xd1	0.5xd1	0.015–0.020 .0006–.0008	0.015–0.020 .0006–.0008	0.020–0.025 .0008–.0010	0.020–0.025 .0008–.0010	0.025–0.035 .0010–.0014	0.040–0.050 .0016–.0020		
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH												
	Stainless steel austenitic	1.4301	X5CrNi 18-10	AISI 304												
		1.4435	X2CrNiMo 18-14-3	AISI 316L	20 – 30 66 – 98	30 – 40 98 – 131	2xd1 – 3xd1	0.5xd1	0.010–0.020 .0004–.0008	0.010–0.020 .0004–.0008	0.015–0.025 .0006–.0010	0.020–0.030 .0008–.0012	0.025–0.035 .0010–.0014	0.035–0.045 .0014–.0018		
1.4441		X2CrNiMo 18-15-3	AISI 316LM													
1.4539	X1NiCrMoCu 25-20-5	AISI 904L														
K	Cast iron	0.6020	GG20	ASTM 30					Recommended: CrazyDrill Flex Steel 30 x d1							
		0.6030	GG30	ASTM 40B					Recommended: CrazyDrill Flex Steel 30 x d1							
		0.7040	GGG40	ASTM 60-40-18					Recommended: CrazyDrill Flex Steel 30 x d1							
		0.7060	GGG60	ASTM 80-60-03					Recommended: CrazyDrill Flex Steel 30 x d1							
N	Aluminium alloy wrought	3.2315	AlMgSi1	ASTM 6351					Recommended: CrazyDrill Flex Steel 30 x d1							
		3.4365	AlZnMgCu1.5	ASTM 7075					Recommended: CrazyDrill Flex Steel 30 x d1							
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380					Recommended: CrazyDrill Flex Steel 30 x d1							
		3.2381	GD-AlSi10Mg	UNS A03590					Recommended: CrazyDrill Flex Steel 30 x d1							
	Copper	2.004	Cu-OF / CW008A	UNS C10100	20 – 30 66 – 98	35 – 60 115 – 197	2xd1 – 3xd1	0.5xd1	0.040 .0016	0.045 .0018	0.050 .0020	0.060 .0024	0.070 .0028	0.080 .0031		
		2.0065	Cu-ETP / CW004A	UNS C11000												
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	20 – 30 66 – 98	35 – 60 115 – 197	2xd1 – 3xd1	0.5xd1	0.040 .0016	0.045 .0018	0.050 .0020	0.060 .0024	0.070 .0028	0.080 .0031		
		2.036	CuZn40 CW509L	UNS C28000												
Brass, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500					Recommended: CrazyDrill Flex Steel 30 x d1								
Bronze Rm < 600 N/mm²	2.102	CuSn6	UNS C51900					Recommended: CrazyDrill Flex Steel 30 x d1								
2.0966	CuAl10Ni5Fe4	UNS C63000						Recommended: CrazyDrill Flex Steel 30 x d1								
2.096	CuAl9Mn2	UNS C63200						Recommended: CrazyDrill Flex Steel 30 x d1								
S ₁	Super alloys	2.4856		Inconel 625												
		2.4668		Inconel 718	10 – 20 33 – 66	20 – 30 66 – 98	2xd1 – 3xd1	0.2xd1	0.010–0.020 .0004–.0008	0.010–0.020 .0004–.0008	0.015–0.025 .0006–.0010	0.020–0.030 .0008–.0012	0.025–0.035 .0010–.0014	0.035–0.045 .0014–.0018		
		2.4617	NiMo28	Hastelloy B-2												
		2.4665	NiCr22Fe18Mo	Hastelloy X												
S ₂	Titanium pure	3.7035	Gr.2	ASTM B348 / F67					Recommended: CrazyDrill Flex Titanium 30 x d1							
		3.7065	Gr.4	ASTM B348 / F68					Recommended: CrazyDrill Flex Titanium 30 x d1							
S ₃	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136					Recommended: CrazyDrill Flex Titanium 30 x d1							
		9.9367	TiAl6Nb7	ASTM F1295					Recommended: CrazyDrill Flex Titanium 30 x d1							
H ₁	Hardened steel < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25	20 – 30 66 – 98	30 – 40 98 – 131	2xd1 – 3xd1	0.5xd1	0.010–0.020 .0004–.0008	0.010–0.020 .0004–.0008	0.015–0.025 .0006–.0010	0.020–0.030 .0008–.0012	0.025–0.035 .0010–.0014	0.035–0.045 .0014–.0018		
			CrCoMo28	ASTM F1537												
H ₂	Hardened steel ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1					Recommended: CrazyDrill Flex Steel 30 x d1							
		1.2379	X153CrMoV12	AISI D2					Recommended: CrazyDrill Flex Steel 30 x d1							