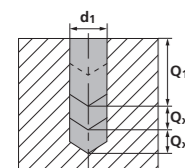
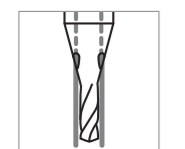


# SST-Inox - 50 x d

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 <sub>c</sub>		Q <sub>1</sub>	Q <sub>2</sub>	f [mm/rev]   [IPR]							
					[m/min]   [SFM]				1/64"		Ød1 1/32"		1/16"		2.0 mm   .079"	
					Ød1 ≤ 0.4   .016"	Ød1 > 0.4   .016"			0.3 mm   .012" f	0.4 mm   .016" f	0.6 mm   .024" f	0.8 mm   .032" f	1.0 mm   .039" f	1.5 mm   .059" f	2.0 mm   .079" f	
P	Unalloyed carbon steel Rm < 800 N/mm <sup>2</sup>	1.0301	C10	AISI 1010					Recommended: CrazyDrill Flex Steel 50 x d1							
		1.0401	C15	AISI 1015					Recommended: CrazyDrill Flex Steel 50 x d1							
		1.1191	C45E/CK45	AISI 1045					Recommended: CrazyDrill Flex Steel 50 x d1							
		1.0044	S275JR	AISI 1020					Recommended: CrazyDrill Flex Steel 50 x d1							
		1.0715	11SMn30	AISI 1215					Recommended: CrazyDrill Flex Steel 50 x d1							
		1.5752	15NiCr13	ASTM 3415 / AISI 3310					Recommended: CrazyDrill Flex Steel 50 x d1							
	Low alloyed steel Rm > 900 N/mm <sup>2</sup>	1.7131	16MnCr5	AISI 5115					Recommended: CrazyDrill Flex Steel 50 x d1							
		1.3505	100Cr6	AISI 52100					Recommended: CrazyDrill Flex Steel 50 x d1							
		1.7225	42CrMo4	AISI 4140					Recommended: CrazyDrill Flex Steel 50 x d1							
		1.2842	90MnCrV8	AISI O2					Recommended: CrazyDrill Flex Steel 50 x d1							
		1.2379	X153CrMoV12	AISI D2					Recommended: CrazyDrill Flex Steel 50 x d1							
		1.2436	X210CrW12	AISI D4/D6					Recommended: CrazyDrill Flex Steel 50 x d1							
High alloyed tool steel Rm < 1200 N/mm <sup>2</sup>	1.3343	HS6-5-2C	AISI M2 / UNS T11302					Recommended: CrazyDrill Flex Steel 50 x d1								
	1.3355	HS18-0-1	AISI T1 / UNS T12001					Recommended: CrazyDrill Flex Steel 50 x d1								
	Stainless steel ferritic	1.4016	X6Cr17	AISI 430 / UNS S43000	25-35   82-115	35-40   115-131	2xd1-3xd1	0.2xd1-0.5xd1	0.010-0.015 .0004-.0006	0.010-0.015 .0004-.0006	0.015-0.020 .0006-.0008	0.015-0.020 .0006-.0008	0.030-0.040 .0012-.0016	0.040-0.050 .0016-.0020	0.050-0.060 .0020-.0024	
		1.4105	X6CrMoS17	AISI 430F												
		1.4034	X46Cr13	AISI 420C	25-35   82-115	35-40   115-131	2xd1-3xd1	0.2xd1-0.5xd1	0.010-0.015 .0004-.0006	0.010-0.015 .0004-.0006	0.015-0.020 .0006-.0008	0.015-0.020 .0006-.0008	0.030-0.040 .0012-.0016	0.040-0.050 .0016-.0020	0.050-0.060 .0020-.0024	
	Stainless steel martensitic	1.4112	X90CrMoV18	AISI 440B	25-35   82-115	35-40   115-131	2xd1-3xd1	0.2xd1-0.5xd1	0.010-0.015 .0004-.0006	0.010-0.015 .0004-.0006	0.015-0.020 .0006-.0008	0.015-0.020 .0006-.0008	0.030-0.040 .0012-.0016	0.040-0.050 .0016-.0020	0.050-0.060 .0020-.0024	
1.4542		X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH	25-35   82-115	35-40   115-131	2xd1-3xd1	0.2xd1-0.5xd1	0.010-0.015 .0004-.0006	0.010-0.015 .0004-.0006	0.015-0.020 .0006-.0008	0.015-0.020 .0006-.0008	0.030-0.040 .0012-.0016	0.040-0.050 .0016-.0020	0.050-0.060 .0020-.0024		
Stainless steel martensitic - PH	1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH	25-35   82-115	35-40   115-131	2xd1-3xd1	0.2xd1-0.5xd1	0.010-0.015 .0004-.0006	0.010-0.015 .0004-.0006	0.015-0.020 .0006-.0008	0.015-0.020 .0006-.0008	0.030-0.040 .0012-.0016	0.040-0.050 .0016-.0020	0.050-0.060 .0020-.0024		
	1.4301	X5CrNi 18-10	AISI 304	25-35   82-115	35-40   115-131	2xd1-3xd1	0.2xd1-0.5xd1	0.005-0.010 .0002-.0004	0.005-0.010 .0002-.0004	0.010-0.015 .0004-.0006	0.010-0.015 .0004-.0006	0.020-0.030 .0008-.0012	0.030-0.040 .0012-.0016	0.045-0.055 .0018-.0022		
Stainless steel austenitic	1.4435	X2CrNiMo 18-14-3	AISI 316L	25-35   82-115	35-40   115-131	2xd1-3xd1	0.2xd1-0.5xd1	0.005-0.010 .0002-.0004	0.005-0.010 .0002-.0004	0.010-0.015 .0004-.0006	0.010-0.015 .0004-.0006	0.020-0.030 .0008-.0012	0.030-0.040 .0012-.0016	0.045-0.055 .0018-.0022		
	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 50 x d1							
		0.6030	GG30	ASTM 40B					Recommended: CrazyDrill Flex Steel 50 x d1							
		0.7040	GGG40	ASTM 60-40-18					Recommended: CrazyDrill Flex Steel 50 x d1							
		0.7060	GGG60	ASTM 80-60-03					Recommended: CrazyDrill Flex Steel 50 x d1							
N	Aluminium alloy wrought	3.2315	AlMgSi1	ASTM 6351					Recommended: CrazyDrill Flex Steel 50 x d1							
		3.4365	AlZnMgCu1.5	ASTM 7075					Recommended: CrazyDrill Flex Steel 50 x d1							
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380					Recommended: CrazyDrill Flex Steel 50 x d1							
		3.2381	GD-AlSi10Mg	UNS A03590					Recommended: CrazyDrill Flex Steel 50 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	0.100 .0039	
		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	0.100 .0039	
		2.036	CuZn40 CW509L	UNS C28000												
Brass, Bronze Rm < 400 N/mm <sup>2</sup>	2.0401	CuZn39Pb3 / CW614N	UNS C38500					Recommended: CrazyDrill Flex Steel 50 x d1								
Bronze Rm < 600 N/mm <sup>2</sup>	2.102	CuSn6	UNS C51900					Recommended: CrazyDrill Flex Steel 50 x d1								
	2.0966	CuAl10Ni5Fe4	UNS C63000					Recommended: CrazyDrill Flex Steel 50 x d1								
S <sub>1</sub>	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	0.045-0.055 .0018-.0022	
		2.4617	NiMo28	Hastelloy B-2												
		2.4665	NiCr22Fe18Mo	Hastelloy X												
S <sub>2</sub>	Titanium pure	3.7035	Gr.2	ASTM B348 / F67					Recommended: CrazyDrill Flex Titanium 50 x d1							
		3.7065	Gr.4	ASTM B348 / F68					Recommended: CrazyDrill Flex Titanium 50 x d1							
S <sub>3</sub>	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136					Recommended: CrazyDrill Flex Titanium 50 x d1							
		9.9367	TiAl6Nb7	ASTM F1295					Recommended: CrazyDrill Flex Titanium 50 x d1							
H <sub>1</sub>	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	0.045-0.055 .0018-.0022	
			CrCoMo28	ASTM F1537												
H <sub>2</sub>	Hardened steel ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1					Recommended: CrazyDrill Flex Steel 50 x d1							
		1.2379	X153CrMoV12	AISI D2					Recommended: CrazyDrill Flex Steel 50 x d1							