

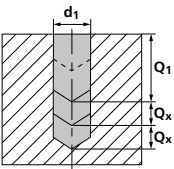
NEW

Titanium ATK - 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



											f [mm/rev] [IPR]																			
Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v _c				Q ₁	Q _x	Ød1																			
					[m/min] [SFM]						0.3 mm .012"		1/64"		0.6 mm .024"		1/32"		1.0 mm .039"		1.2 mm .047"		1.4 mm .055"		1/16"		1.8 mm .071"		2.0 mm .079"	
					Ød1 ≤ 0.4		Ød1 > 0.4				Ød1 < 0.5		Ød1 ≥ 0.5		f		f		f		f		f		f		f		f	
					Mid	High	Mid	High																						
S ₂	Titanium alloy	3.7165	TiAl6V4	ASTM B348 / F136	5 16	20 66	20 66	40 131				2xd1	0.25 - 0.5 xd1	0.5 - 1.0 xd1	0.003	0.004	0.006	0.008	0.010	0.012	0.014	0.016	0.018	0.020						
		.00012	.00016	.00024											.00031	.00039	.00047	.00055	.00063	.00071	.00079									
		9.9367	TiAl6Nb7	ASTM F1295																										