

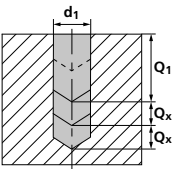
NEW

Titanium ATK - 50 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]													
Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v _c [m/min]				Q ₁	Q _x		0.3 mm	0.4 mm	0.6 mm	0.8 mm	1.0 mm	1.2 mm	1.4 mm	1.6 mm	1.8 mm	2.0 mm		
					Ød1 ≤ 0.4		Ød1 > 0.4			Ød1 < 0.5	Ød1 ≥ 0.5												
					Mid	High	Mid	High															
																						f	f
S ₂	Titanium alloy	3.7165	TiAl6V4	ASTM B348 / F136	5	20	20	40		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	
		9.9367	TiAl6Nb7	ASTM F1295																			