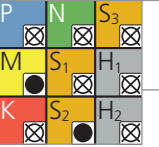


NEW

Pre-hole drilling

v_c [m/min]
 f [mm/rev]

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



DRILLING WITH EXTERNAL COOLING | CUTTING DATA OVERVIEW

| Materials group | Material | Mat. no. | DIN | AISI/ASTM/UNS | v_c [m/min] | T4 | T5 | T6 | T7 | T8 | T10 | T15 | T20 | T25 | T30 |
|----------------------|----------------------------|----------|------------------|------------------|---------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|------------------------------------|
| | | | | | | $\varnothing d_1$ 0.9 mm f | $\varnothing d_1$ 1.0 mm f | $\varnothing d_1$ 1.2 mm f | $\varnothing d_1$ 1.4 mm f | $\varnothing d_1$ 1.6 mm f | $\varnothing d_1$ 1.9 mm f | $\varnothing d_1$ 2.3 mm f | $\varnothing d_1$ 2.7 mm f | $\varnothing d_1$ 3.1 mm f | $\varnothing d_1$ 3.8 mm f |
| M | Stainless steel austenitic | 1.4435 | X2CrNiMo 18-14-3 | AISI 316L | 25 – 35 | 0.02 - 0.03 | 0.02 - 0.03 | 0.03 - 0.04 | 0.03 - 0.04 | 0.03 - 0.04 | 0.05 - 0.06 | 0.05 - 0.06 | 0.06 - 0.07 | 0.07 - 0.08 | 0.07 - 0.08 |
| | | 1.4441 | X2CrNiMo 18-15-3 | AISI 316LM | | | | | | | | | | | |
| S₂ | Titanium alloys | 3.7165 | TiAl6V4 | ASTM B348 / F136 | 20 – 30 | 0.010 - 0.015 | 0.010 - 0.015 | 0.012 - 0.018 | 0.014 - 0.020 | 0.015 - 0.025 | 0.020 - 0.030 | 0.025 - 0.035 | 0.025 - 0.040 | 0.030 - 0.045 | 0.045 - 0.070 |
| | | 9.9367 | TiAl6Nb7 | ASTM F1295 | | | | | | | | | | | |

