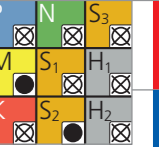


NEW

Pre-hole drilling

v_c [SFM] | [m/min]
 f [IPR] | [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 [SFM] [m/min]	T4	T5	T6	T7	T8	T10	T15	T20	T25	T30
						$\varnothing d_1$ f	$\varnothing d_1$ f	$\varnothing d_1$ f	$\varnothing d_1$ f	$\varnothing d_1$ f	$\varnothing d_1$ f	$\varnothing d_1$ f	$\varnothing d_1$ f	$\varnothing d_1$ f	$\varnothing d_1$ f
M	Stainless steel austenitic	1.4435	X2CrNiMo 18-14-3	AISI 316L	82 - 115 25 - 35	.0008 - .0012 0.02 - 0.03	.0008 - .0012 0.02 - 0.03	.0012 - .0016 0.03 - 0.04	.0012 - .0016 0.03 - 0.04	.0012 - .0016 0.03 - 0.04	.0020 - .0024 0.05 - 0.06	.0020 - .0024 0.05 - 0.06	.0024 - .0028 0.06 - 0.07	.0028 - .0032 0.07 - 0.08	.0028 - .0032 0.07 - 0.08
		1.4441	X2CrNiMo 18-15-3	AISI 316LM											
S₂	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	66 - 98 20 - 30	.00039 - .00059 0.010 - 0.015	.00039 - .00059 0.010 - 0.015	.00047 - .00071 0.012 - 0.018	.00055 - .00079 0.014 - 0.020	.00059 - .00098 0.015 - 0.025	.00079 - .00118 0.020 - 0.030	.00098 - .00138 0.025 - 0.035	.00098 - .00157 0.025 - 0.040	.00118 - .00177 0.030 - 0.045	.00177 - .00276 0.045 - 0.070
		9.9367	TiAl6Nb7	ASTM F1295											

