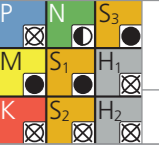


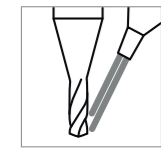
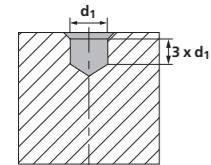
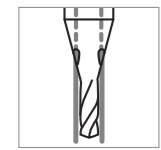
# CrazyDrill Pilot SST-Inox - 3 x d - 90° Senkung

ANWENDUNGSEMPFEHLUNG

● Sehr gut geeignet | ● Gut geeignet | ○ bedingt geeignet | ☒ Nicht empfohlen



## BOHREN MIT INTEGRIERTER KÜHLUNG | SCHNITTDATENÜBERSICHT



**Bemerkung:**  
Bei Aussenkühlung  
 $v_c$  und  $f$  um 20%  
reduzieren

| Werkstoffgruppe  | Werkstoff   | Wr.Nr.             | DIN                     | AISI/ASTM/UNS         | $v_c$<br>[m/min] | $f$ [mm/U]    |                        |                        |               |                                    |               |                        |               |               |  |
|--|---|--------------------|-------------------------|-----------------------|------------------|---------------|------------------------|------------------------|---------------|------------------------------------|---------------|------------------------|---------------|---------------|--|
|  |   |                    |                         |                       |                  | 0.2 mm<br>$f$ | 0.5 mm<br>1/64"<br>$f$ | 0.8 mm<br>1/32"<br>$f$ | 1.0 mm<br>$f$ | $\varnothing d_1$<br>1.2 mm<br>$f$ | 1.2 mm<br>$f$ | 1.6 mm<br>1/16"<br>$f$ | 1.8 mm<br>$f$ | 2.0 mm<br>$f$ |  |
| P  | Stähle unlegiert<br>$R_m < 800 \text{ N/mm}^2$      | 1.0301             | C10                     | AISI 1010             |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 1.0401             | C15                     | AISI 1015             |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 1.1191             | C45E/CK45               | AISI 1045             |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 1.0044             | S275JR                  | AISI 1020             |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 1.0715             | 11SMn30                 | AISI 1215             |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 1.5752             | 15NiCr13                | ASTM 3415 / AISI 3310 |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  | Stähle niedriglegiert<br>$R_m > 900 \text{ N/mm}^2$ | 1.7131             | 16MnCr5                 | AISI 5115             |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 1.3505             | 100Cr6                  | AISI 52100            |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 1.7225             | 42CrMo4                 | AISI 4140             |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 1.2842             | 90MnCrV8                | AISI O2               |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 1.2379             | X153CrMoV12             | AISI D2               |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 1.2436             | X210CrW12               | AISI D4/D6            |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
| Werkzeugstähle<br>hochlegiert<br>$R_m < 1200 \text{ N/mm}^2$ | 1.3343  | HS6-5-2C           | AISI M2 / UNS T11302    |                       |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  | 1.3355  | HS18-0-1           | AISI T1 / UNS T12001    |                       |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  | Rostfreie Stähle-<br>ferritisch                     | 1.4016             | X6Cr17                  | AISI 430 / UNS S43000 | 35 - 50          | 0.015         | 0.020                  | 0.030                  | 0.035         | 0.040                              | 0.050         | 0.055                  | 0.060         | 0.070         |  |
|  |   | 1.4105             | X6CrMoS17               | AISI 430F             |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  | Rostfreie Stähle-<br>martensitisch                  | 1.4034             | X46Cr13                 | AISI 420C             | 35 - 50          | 0.020         | 0.030                  | 0.040                  | 0.055         | 0.060                              | 0.070         | 0.075                  | 0.080         | 0.100         |  |
|  |   | 1.4112             | X90CrMoV18              | AISI 440B             |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
| Rostfreie Stähle-<br>martensitisch - PH                      | 1.4542  | X5CrNiCuNb 16-4    | AISI 630 / ASTM 17-4 PH | 35 - 50               | 0.015            | 0.020         | 0.025                  | 0.030                  | 0.040         | 0.050                              | 0.055         | 0.060                  | 0.070         |               |  |
|  | 1.4545  | X5CrNiCuNb 15-5    | ASTM 15-5 PH            |                       |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
| Rostfreie Stähle-<br>austenitisch                            | 1.4301  | X5CrNi 18-10       | AISI 304                |                       |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  | 1.4435  | X2CrNiMo 18-14-3   | AISI 316L               | 30 - 45               | 0.010            | 0.020         | 0.025                  | 0.030                  | 0.035         | 0.045                              | 0.050         | 0.055                  | 0.060         |               |  |
|  | 1.4441  | X2CrNiMo 18-15-3   | AISI 316LM              |                       |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  | 1.4539  | X1NiCrMoCu 25-20-5 | AISI 904L               |                       |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
| K  | Gusseisen   | 0.6020             | GG20                    | ASTM 30               |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 0.6030             | GG30                    | ASTM 40B              |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 0.7040             | GGG40                   | ASTM 60-40-18         |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 0.7060             | GGG60                   | ASTM 80-60-03         |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
| N  | Aluminium<br>Knetlegierungen                        | 3.2315             | AlMgSi1                 | ASTM 6351             |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 3.4365             | AlZnMgCu1.5             | ASTM 7075             |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  | Aluminium<br>Druckgusslegierungen                   | 3.2163             | GD-AlSi9Cu3             | ASTM A380             |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 3.2381             | GD-AlSi10Mg             | UNS A03590            |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  | Kupfer  | 2.0040             | Cu-OF / CW008A          | UNS C10100            | 40 - 100         | 0.040         | 0.060                  | 0.080                  | 0.090         | 0.100                              | 0.120         | 0.140                  | 0.160         | 0.180         |  |
|  |   | 2.0065             | Cu-ETP / CW004A         | UNS C11000            |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  | Messing bleifrei                                    | 2.0321             | CuZn37 CW508L           | UNS C27400            | 40 - 100         | 0.040         | 0.060                  | 0.080                  | 0.090         | 0.100                              | 0.120         | 0.140                  | 0.160         | 0.180         |  |
|  |   | 2.0360             | CuZn40 CW509L           | UNS C28000            |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  | Messing, Bronze<br>$R_m < 400 \text{ N/mm}^2$       | 2.0401             | CuZn39Pb3 / CW614N      | UNS C38500            |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 2.1020             | CuSn6                   | UNS C51900            |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
| Bronze<br>$R_m < 600 \text{ N/mm}^2$                         | 2.0966  | CuAl10Ni5Fe4       | UNS C63000              |                       |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  | 2.0960  | CuAl9Mn2           | UNS C63200              |                       |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
| S <sub>1</sub>   | Hitzebeständige<br>Stähle                           | 2.4856             |                         | Inconel 625           | 15 - 30          | 0.010         | 0.015                  | 0.020                  | 0.022         | 0.025                              | 0.035         | 0.037                  | 0.045         | 0.055         |  |
|  |   | 2.4668             |                         | Inconel 718           |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 2.4617             | NiMo28                  | Hastelloy B-2         |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 2.4665             | NiCr22Fe18Mo            | Hastelloy X           |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
| S <sub>2</sub>   | Titan rein  | 3.7035             | Gr.2                    | ASTM B348 / F67       |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 3.7065             | Gr.4                    | ASTM B348 / F68       |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
| S <sub>3</sub>   | Titan Legierungen                                   | 3.7165             | TiAl6V4                 | ASTM B348 / F136      |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 9.9367             | TiAl6Nb7                | ASTM F1295            |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
| H <sub>1</sub>   | Stähle gehärtet<br>< 55 HRC                         | 2.4964             | CoCr20W15Ni             | Haynes 25             | 40 - 50          | 0.020         | 0.030                  | 0.040                  | 0.055         | 0.060                              | 0.070         | 0.075                  | 0.080         | 0.100         |  |
|  |   |                    | CrCoMo28                | ASTM F1537            |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
| H <sub>2</sub>   | Stähle gehärtet<br>≥ 55 HRC                         | 1.2510             | 100MnCrMoW4             | AISI O1               |                  |               |                        |                        |               |                                    |               |                        |               |               |  |
|  |   | 1.2379             | X153CrMoV12             | AISI D2               |                  |               |                        |                        |               |                                    |               |                        |               |               |  |