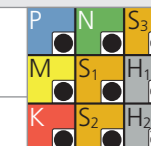
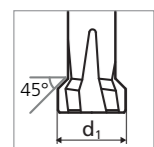
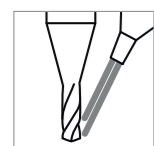


CrazyMill Backchamfer 3 x d / 5 x d

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



DEBURRING WITH EXTERNAL COOLING | CUTTING DATA OVERVIEW



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v _c [m/min]	f _z [mm]			
						Ød1			
						0.36 - 1.90 mm f _z	2.90 - 5.70 mm f _z		
P	Unalloyed carbon steel Rm < 800 N/mm²	1.0301	C10	AISI 1010	120	0.030	0.040		
		1.0401	C15	AISI 1015					
		1.1191	C45E/CK45	AISI 1045					
		1.0044	S275JR	AISI 1020					
		1.0715	11SMn30	AISI 1215					
	Low alloyed steel Rm > 900 N/mm²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	100	0.020	0.030		
		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					
	High alloyed tool steel Rm < 1200 N/mm²	1.2436	X210CrW12	AISI D4/D6	80	0.015	0.030		
		1.3343	HS6-5-2C	AISI M2 / UNS T11302					
1.3355		HS18-0-1	AISI T1 / UNS T12001						
1.4016		X6Cr17	AISI 430 / UNS S43000	50				0.010	0.030
1.4105		X6CrMoS17	AISI 430F						
1.4034	X46Cr13	AISI 420C							
1.4112	X90CrMoV18	AISI 440B							
1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH							
M	Stainless steel ferritic	1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH	50	0.015	0.030		
		1.4301	X5CrNi 18-10	AISI 304					
	Stainless steel martensitic	1.4435	X2CrNiMo 18-14-3	AISI 316L	80	0.015	0.030		
		1.4441	X2CrNiMo 18-15-3	AISI 316LM					
		1.4539	X1NiCrMoCu 25-20-5	AISI 904L					
	K	Cast iron	0.6020	GG20	ASTM 30	60	0.015	0.030	
			0.6030	GG30	ASTM 40B				
			0.7040	GGG40	ASTM 60-40-18				
0.7060			GGG60	ASTM 80-60-03					
N	Aluminium alloy wrought	3.2315	AlMgSi1	ASTM 6351	200	0.030	0.040		
		3.4365	AlZnMgCu1.5	ASTM 7075					
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380	200	0.030	0.040		
		3.2381	GD-AlSi10Mg	UNS A03590					
	Copper	2.004	Cu-OF / CW008A	UNS C10100	40	0.020	0.030		
		2.0065	Cu-ETP / CW004A	UNS C11000					
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	40	0.020	0.030		
		2.036	CuZn40 CW509L	UNS C28000					
	Brass, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	200	0.030	0.040		
		2.102	CuSn6	UNS C51900					
	Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	200	0.030	0.040		
2.096		CuAl9Mn2	UNS C63200						
S ₁	Super alloys	2.4856		Inconel 625	40	0.020	0.030		
		2.4668		Inconel 718					
		2.4617	NiMo28	Hastelloy B-2					
		2.4665	NiCr22Fe18Mo	Hastelloy X					
S ₂	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	40	0.020	0.030		
		3.7065	Gr.4	ASTM B348 / F68					
S ₃	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	40	0.020	0.030		
		9.9367	TiAl6Nb7	ASTM F1295					
H ₁	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	50	0.015	0.030		
			CrCoMo28	ASTM F1537					
H ₂	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1	60	0.015	0.020		
		1.2379	X153CrMoV12	AISI D2					