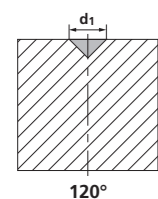
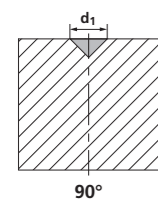
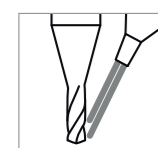


# MiquDrill Centro 90° / 120° - uncoated

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

P	N	S <sub>3</sub>
M	S <sub>1</sub>	H <sub>1</sub>
K	S <sub>2</sub>	H <sub>2</sub>

## CENTERING WITH EXTERNAL COOLING | CUTTING DATA OVERVIEW



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v <sub>c</sub> [m/min]	f [mm/rev]						
						0.5 mm f	1.0 mm f	2.0 mm f	Ød1			6.0 mm f
						3.0 mm f	4.0 mm f	5.0 mm f				
P	Unalloyed carbon steel Rm < 800 N/mm <sup>2</sup>	1.0301	C10	AISI 1010	20 - 50	0.030	0.050	0.060	0.080	0.100	0.150	0.150
		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/mm <sup>2</sup>	1.5752	15NiCr13	ASTM 3415 / AISI 3310	20 - 50	0.030	0.050	0.060	0.080	0.100	0.150	0.150
		1.7131	16MnCr5	AISI 5115								
		1.3505	100Cr6	AISI 52100								
		1.7225	42CrMo4	AISI 4140								
		1.2842	90MnCrV8	AISI O2								
	High alloyed tool steel Rm < 1200 N/mm <sup>2</sup>	1.2379	X153CrMoV12	AISI D2	20 - 40	0.020	0.030	0.040	0.060	0.080	0.120	0.130
		1.2436	X210CrW12	AISI D4/D6								
1.3343		HS6-5-2C	AISI M2 / UNS T11302									
1.3355		HS18-0-1	AISI T1 / UNS T12001									
M	Stainless steel ferritic	1.4016	X6Cr17	AISI 430 / UNS S43000	20 - 50	0.030	0.050	0.060	0.080	0.100	0.150	0.150
		1.4105	X6CrMoS17	AISI 430F								
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	20 - 40	0.020	0.030	0.040	0.060	0.080	0.120	0.130
		1.4112	X90CrMoV18	AISI 440B								
	Stainless steel martensitic - PH	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH	15 - 25	0.020	0.030	0.030	0.040	0.060	0.080	0.080
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH								
	Stainless steel austenitic	1.4301	X5CrNi 18-10	AISI 304	15 - 25							
		1.4435	X2CrNiMo 18-14-3	AISI 316L								
1.4441		X2CrNiMo 18-15-3	AISI 316LM									
1.4539		X1NiCrMoCu 25-20-5	AISI 904L									
K	Cast iron	0.6020	GG20	ASTM 30	20 - 50	0.030	0.050	0.060	0.080	0.100	0.150	0.150
		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	40 - 80	0.030	0.050	0.060	0.080	0.100	0.150	0.150
		3.4365	AlZnMgCu1.5	ASTM 7075								
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380	40 - 80	0.030	0.050	0.060	0.080	0.100	0.150	0.150
		3.2381	GD-AlSi10Mg	UNS A03590								
	Copper	2.0040	Cu-OF / CW008A	UNS C10100	40 - 80	0.030	0.050	0.060	0.080	0.100	0.150	0.150
		2.0065	Cu-ETP / CW004A	UNS C11000								
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	40 - 80	0.030	0.050	0.060	0.080	0.100	0.150	0.150
		2.0360	CuZn40 CW509L	UNS C28000								
	Brass, Bronze Rm < 400 N/mm <sup>2</sup>	2.0401	CuZn39Pb3 / CW614N	UNS C38500	40 - 80	0.030	0.050	0.060	0.080	0.100	0.150	0.150
		2.1020	CuSn6	UNS C51900								
Bronze Rm < 600 N/mm <sup>2</sup>	2.0966	CuAl10Ni5Fe4	UNS C63000	40 - 80	0.030	0.050	0.060	0.080	0.100	0.150	0.150	
	2.0960	CuAl9Mn2	UNS C63200									
S <sub>1</sub>	Super alloys	2.4856		Inconel 625								
		2.4668		Inconel 718								
		2.4617	NiMo28	Hastelloy B-2								
		2.4665	NiCr22Fe18Mo	Hastelloy X								
S <sub>2</sub>	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	15 - 25	0.020	0.030	0.030	0.040	0.060	0.080	0.080
		3.7065	Gr.4	ASTM B348 / F68								
S <sub>3</sub>	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	15 - 25	0.020	0.030	0.030	0.040	0.060	0.080	0.080
		9.9367	TiAl6Nb7	ASTM F1295								
H <sub>1</sub>	Hardened steel < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25								
			CrCoMo28	ASTM F1537								
H <sub>2</sub>	Hardened steel ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1								
		1.2379	X153CrMoV12	AISI D2								

Recommended: MiquDrill Centro 90° / 120° - coated