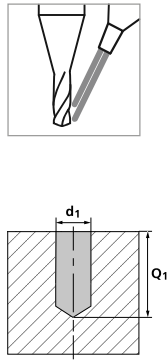


CrazyDrill Alu 5 x d

DRILLING WITH EXTERNAL COOLING | CUTTING DATA OVERVIEW

Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v_c [m/min] [SFM]	Q_1
	P Unalloyed carbon steel Rm < 800 N/mm²	1.0301	C10	AISI 1010	300 984	5xd1
		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		
		1.7131	16MnCr5	AISI 5115		
		1.3505	100Cr6	AISI 52100		
		1.7225	42CrMo4	AISI 4140		
	High alloyed tool steel Rm < 1200 N/mm²	1.2842	90MnCrV8	AISI O2		
		1.2379	X153CrMoV12	AISI D2		
		1.2436	X210CrW12	AISI D4/D6		
		1.3343	HS6-5-2C	AISI M2 / UNS T11302		
M	Stainless steel ferritic	1.3355	HS18-0-1	AISI T1 / UNS T12001		
		1.4016	X6Cr17	AISI 430 / UNS S43000		
	Stainless steel martensitic	1.4105	X6CrMoS17	AISI 430F		
		1.4034	X46Cr13	AISI 420C		
	Stainless steel martensitic – PH	1.4112	X90CrMoV18	AISI 440B		
		1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH		
	Stainless steel austenitic	1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH		
		1.4301	X5CrNi 18-10	AISI 304		
		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		
		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	200 656	5xd1
		3.4365	AlZnMgCu1.5	ASTM 7075		
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380		
		3.2381	GD-AlSi10Mg	UNS A03590		
	Copper	2.004	Cu-OF / CW008A	UNS C10100		
		2.0065	Cu-ETP / CW004A	UNS C11000		
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400		
		2.036	CuZn40 CW509L	UNS C28000		
	Brass, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500		
		2.102	CuSn6	UNS C51900		
Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000			
	2.096	CuAl9Mn2	UNS C63200			
S ₁	Super alloys	2.4856		Inconel 625		
		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		
		3.7065	Gr.4	ASTM B348 / F68		
S ₃	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136		
		9.9367	TiAl6Nb7	ASTM F1295		
H ₁	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25		
			CrCoMo28	ASTM F1537		
H ₁	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1		
H ₂	Hardened steel ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2		

