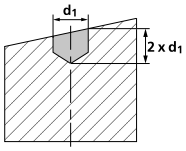
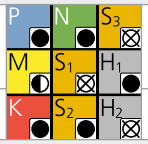
CrazyDrill Crosspilot - 2 x d (nominal)

DRILLING WITH EXTERNAL COOLING | CUTTING DATA OVERVIEW



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v_c [m/min] | [SFM]
P	Unalloyed carbon steel Rm < 800 N/mm²	1.0301	C10	AISI 1010	80 | **262**
		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	60 | **197**
		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/mm²	1.2379	X153CrMoV12	AISI D2	50 | **164**
		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	40 | **131**
		1.4105	X6CrMoS17	AISI 430F	
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	50 | **164**
		1.4112	X90CrMoV18	AISI 440B	
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH	
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH	
	Stainless steel austenitic	1.4301	X5CrNi 18-10	AISI 304	30 | **98**
		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	80 | **262**
		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	125 | **410**
		3.4365	AlZnMgCu1.5	ASTM 7075	
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380	125 | **410**
		3.2381	GD-AlSi10Mg	UNS A03590	
	Copper	2.004	Cu-OF / CW008A	UNS C10100	80 | **262**
		2.0065	Cu-ETP / CW004A	UNS C11000	
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	80 | **262**
		2.036	CuZn40 CW509L	UNS C28000	
	Brass, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	100 | **328**
		2.102	CuSn6	UNS C51900	
	Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	80 | **262**
		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	25 | **82**
		3.7065	Gr.4	ASTM B348 / F68	
	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	25 | **82**
		9.9367	TiAl6Nb7	ASTM F1295	
S_3	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	
			CrCoMo28	ASTM F1537	
H_1	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1	20 | **66**
H_2	Hardened steel ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2	

RECOMMENDATION FOR USE
● Excellent | ◐ Good | ○ Acceptable | ⊠ Not recommended



f [mm/rev] | **[IPR]**

	Ød1 0.4 mm | .016" f	Ød1 0.8 mm | .032" f	Ød1 1.0 mm | .039" f	Ød1 1.5 mm | .059" f	Ød1 2.0 mm | .079" f	Ød1 3.0 mm | .118" f	Ød1 4.0 mm | .158" f	Ød1 5.0 mm | .197" f	Ød1 6.0 mm | .236" f
	0.005 | **.00020**	0.011 | **.00043**	0.013 | **.0005**	0.020 | **.0008**	0.027 | **.0011**	0.040 | **.0016**	0.053 | **.0021**	0.067 | **.0026**	0.080 | **.0031**
	0.004 | **.00016**	0.008 | **.00031**	0.010 | **.0004**	0.015 | **.0006**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.050 | **.0020**	0.060 | **.0024**
	0.004 | **.00016**	0.008 | **.00031**	0.010 | **.0004**	0.015 | **.0006**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.050 | **.0020**	0.060 | **.0024**
	0.002 | **.00008**	0.004 | **.00016**	0.005 | **.0002**	0.008 | **.0003**	0.010 | **.0004**	0.015 | **.0006**	0.020 | **.0008**	0.025 | **.0010**	0.030 | **.0012**
	0.004 | **.00016**	0.008 | **.00031**	0.010 | **.0004**	0.015 | **.0006**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.050 | **.0020**	0.060 | **.0024**
	0.002 | **.00008**	0.004 | **.00016**	0.005 | **.0002**	0.008 | **.0003**	0.010 | **.0004**	0.015 | **.0006**	0.020 | **.0008**	0.025 | **.0010**	0.030 | **.0012**
	0.004 | **.00016**	0.008 | **.00031**	0.010 | **.0004**	0.015 | **.0006**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.050 | **.0020**	0.060 | **.0024**
	0.008 | **.00031**	0.016 | **.00063**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.060 | **.0024**	0.080 | **.0031**	0.100 | **.0039**	0.120 | **.0047**
	0.008 | **.00031**	0.016 | **.00063**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.060 | **.0024**	0.080 | **.0031**	0.100 | **.0039**	0.120 | **.0047**
	0.004 | **.00016**	0.008 | **.00031**	0.010 | **.0004**	0.015 | **.0006**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.050 | **.0020**	0.060 | **.0024**
	0.004 | **.00016**	0.008 | **.00031**	0.010 | **.0004**	0.015 | **.0006**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.050 | **.0020**	0.060 | **.0024**
	0.008 | **.00031**	0.016 | **.00063**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.060 | **.0024**	0.080 | **.0031**	0.100 | **.0039**	0.120 | **.0047**
	0.004 | **.00016**	0.008 | **.00031**	0.010 | **.0004**	0.015 | **.0006**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.050 | **.0020**	0.060 | **.0024**
	0.004 | **.00016**	0.008 | **.00031**	0.010 | **.0004**	0.015 | **.0006**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.050 | **.0020**	0.060 | **.0024**
	0.004 | **.00016**	0.008 | **.00031**	0.010 | **.0004**	0.015 | **.0006**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.050 | **.0020**	0.060 | **.0024**
	0.001 | **.00004**	0.003 | **.00012**	0.003 | **.00012**	0.005 | **.00020**	0.007 | **.00028**	0.010 | **.0004**	0.013 | **.0005**	0.017 | **.0007**	0.020 | **.0008**