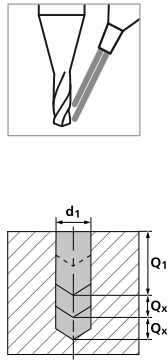


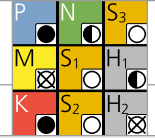
CrazyDrill Steel 6 x d / 7 x d

DRILLING WITH EXTERNAL COOLING | CUTTING DATA OVERVIEW

Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v _c [m/min] [SFM]	Q ₁		Q _x		Q ₁		Q _x	
						6xd	7xd	6xd	7xd	6xd	7xd	6xd	7xd
 <p>P</p>	Unalloyed carbon steel Rm < 800 N/mm ²	1.0301	C10	AISI 1010	120 394	6xd1	-	7xd1	-				
		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 ²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	80 262	6xd1	-	7xd1	-				
		1.7131	16MnCr5	AISI 5115									
		1.3505	100Cr6	AISI 52100									
		1.7225	42CrMo4	AISI 4140									
	High alloyed tool steel Rm < 1200 N/mm ²	1.2842	90MnCrV8	AISI O2	60 197	6xd1	-	7xd1	-				
		1.2379	X153CrMoV12	AISI D2									
		1.2436	X210CrW12	AISI D4/D6									
		1.3343	H56-5-2C	AISI M2 / UNS T11302									
1.3355		H518-0-1	AISI T1 / UNS T12001										
<p>M</p>	Stainless steel ferritic	1.4016	X6Cr17	AISI 430 / UNS S43000									
		1.4105	X6CrMoS17	AISI 430F									
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C									
		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									
		1.4435	X2CrNiMo 18-14-3	AISI 316L									
1.4441		X2CrNiMo 18-15-3	AISI 316LM										
1.4539		X1NiCrMoCu 25-20-5	AISI 904L										
<p>K</p>	Cast iron	0.6020	GG20	ASTM 30	150 492	6xd1	-	7xd1	-				
		0.6030	GG30	ASTM 40B									
		0.7040	GGG40	ASTM 60-40-18									
		0.7060	GGG60	ASTM 80-60-03									
<p>N</p>	Aluminium alloy wrought	3.2315	AlMgSi1	ASTM 6351	220 722	4xd1	2xd1	4xd1	2xd1				
		3.4365	AlZnMgCu1.5	ASTM 7075									
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380	200 656	4xd1	2xd1	4xd1	2xd1				
		3.2381	GD-AlSi10Mg	UNS A03590									
	Copper	2.004	Cu-OF / CW008A	UNS C10100	120 394	1.5xd1	1xd1	1.5xd1	1xd1				
		2.0065	Cu-ETP / CW004A	UNS C11000									
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	150 492	1.5xd1	1xd1	1.5xd1	1xd1				
		2.036	CuZn40 CW509L	UNS C28000									
	Brass, Bronze Rm < 400 N/mm ²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	100 328	1.5xd1	1xd1	1.5xd1	1xd1				
		2.102	CuSn6	UNS C51900									
	Bronze Rm < 600 N/mm ²	2.0966	CuAl10Ni5Fe4	UNS C63000	100 328	4xd1	2xd1	4xd1	3xd1				
		2.096	CuAl9Mn2	UNS C63200									
<p>S₁</p>	Super alloys	2.4856		Inconel 625	40 131	1xd1	0.25xd1	1xd1	0.25xd1				
		2.4668		Inconel 718									
		2.4617	NiMo28	Hastelloy B-2									
		2.4665	NiCr22Fe18Mo	Hastelloy X									
<p>S₂</p>	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	40 131	1xd1	0.25xd1	1xd1	0.25xd1				
		3.7065	Gr.4	ASTM B348 / F68									
<p>S₂</p>	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	20 66	1xd1	0.3xd1	1xd1	0.3xd1				
		9.9367	TiAl6Nb7	ASTM F1295									
<p>S₃</p>	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	30 98	4xd1	0.25xd1	4xd1	0.25xd1				
			CrCoMo28	ASTM F1537									
<p>H₁</p> <p>H₂</p>	Hardened steel ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1	30 98	4xd1	1xd1	4xd1	1xd1				
		1.2379	X153CrMoV12	AISI D2									

RECOMMENDATION FOR USE

● Excellent | ● Good | ○ Acceptable | ⊗ Not recommended



f [mm/rev] | [IPR]

Ød1	Ød1	Ød1	Ød1	Ød1	Ød1	Ød1	Ød1	Ød1	Ød1	Ød1	Ød1	Ød1
0.4 mm .016"	0.8 mm .032"	1.0 mm .039"	1.2 mm .047"	1.25 mm .049"	1.5 mm .059"	2.0 mm .079"	2.5 mm .098"	3.0 mm .118"	4.0 mm .158"	5.0 mm .197"	6.0 mm .236"	
f	f	f	f	f	f	f	f	f	f	f	f	f
0.040 .0016	0.100 .0039	0.120 .0047	0.140 .0055	0.150 .0059	0.200 .0079	0.250 .0098	0.270 .0106	0.350 .0138	0.370 .0146	0.390 .0154	0.400 .0157	
0.015 .0006	0.030 .0012	0.080 .0031	0.110 .0043	0.120 .0047	0.160 .0063	0.200 .0079	0.230 .0091	0.250 .0098	0.270 .0106	0.300 .0118	0.320 .0126	
0.020 .0008	0.070 .0028	0.120 .0047	0.140 .0055	0.150 .0059	0.200 .0079	0.250 .0098	0.280 .0110	0.300 .0118	0.320 .0126	0.340 .0134	0.350 .0138	
0.040 .0016	0.150 .0059	0.200 .0079	0.240 .0094	0.250 .0098	0.300 .0118	0.350 .0138	0.400 .0157	0.450 .0177	0.470 .0185	0.490 .0193	0.500 .0197	
0.045 .0018	0.060 .0024	0.080 .0031	0.090 .0035	0.095 .0037	0.110 .0043	0.130 .0051	0.150 .0059	0.180 .0071	0.190 .0075	0.210 .0083	0.250 .0098	
0.040 .0016	0.055 .0022	0.075 .0030	0.080 .0031	0.085 .0033	0.100 .0039	0.120 .0047	0.140 .0055	0.170 .0067	0.180 .0071	0.200 .0079	0.240 .0094	
0.030 .0012	0.050 .0020	0.060 .0024	0.063 .0025	0.065 .0026	0.075 .0030	0.080 .0031	0.095 .0037	0.110 .0043	0.130 .0051	0.160 .0063	0.200 .0079	
0.030 .0012	0.050 .0020	0.065 .0026	0.068 .0027	0.070 .0028	0.075 .0030	0.090 .0035	0.110 .0043	0.140 .0055	0.160 .0063	0.200 .0079	0.220 .0087	
0.035 .0014	0.055 .0022	0.070 .0028	0.075 .0030	0.080 .0031	0.090 .0035	0.110 .0043	0.130 .0051	0.150 .0059	0.180 .0071	0.220 .0087	0.240 .0094	
0.015 .0006	0.025 .0010	0.035 .0014	0.045 .0018	0.050 .0020	0.050 .0020	0.065 .0026	0.085 .0033	0.100 .0039	0.120 .0047	0.150 .0059	0.200 .0079	
0.002 .0001	0.004 .0002	0.005 .0002	0.006 .0002	0.006 .0002	0.007 .0003	0.010 .0004	0.012 .0005	0.015 .0006	0.020 .0008	0.025 .0010	0.030 .0012	
0.012 .0005	0.024 .0009	0.030 .0012	0.035 .0014	0.040 .0016	0.045 .0018	0.060 .0024	0.075 .0030	0.090 .0035	0.120 .0047	0.150 .0059	0.180 .0071	
0.020 .0008	0.030 .0012	0.040 .0016	0.045 .0018	0.050 .0020	0.055 .0022	0.070 .0028	0.080 .0031	0.100 .0039	0.140 .0055	0.160 .0063	0.200 .0079	
0.006 .0002	0.012 .0005	0.015 .0006	0.018 .0007	0.020 .0008	0.025 .0010	0.030 .0012	0.035 .0014	0.045 .0018	0.060 .0024	0.075 .0030	0.090 .0035	
0.005 .0002	0.007 .0003	0.010 .0004	0.011 .0004	0.011 .0004	0.012 .0005	0.015 .0006	0.020 .0008	0.025 .0010	0.030 .0012	0.035 .0014	0.040 .0016	