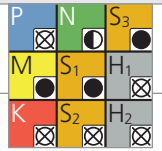
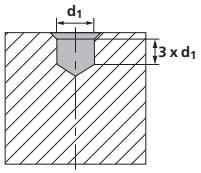
CrazyDrill Pilot SST-Inox - 3 x d - 90° countersink

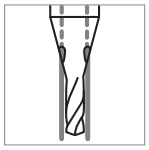
RECOMMENDATION FOR USE
● Excellent | ◐ Good | ○ Acceptable | ⊠ Not recommended



DRILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW

Materials group	Material	AISI/ASTM/UNS	v_c [m/min] | **[SFM]**	**f** [mm/rev] | **[IPR]**								
				Ød1 0.3 mm | **.012"** **f**	**Ød1** 0.5 mm | **.020"** **f**	**Ød1** 0.8 mm | **.032"** **f**	**Ød1** 1.0 mm | **.039"** **f**	**Ød1** 1.2 mm | **.047"** **f**	**Ød1** 1.4 mm | **.055"** **f**	**Ød1** 1.6 mm | **.063"** **f**	**Ød1** 1.8 mm | **.071"** **f**	**Ød1** 2.0 mm | **.079"** **f**
P	Unalloyed carbon steel Rm < 800 N/mm²	AISI 1010										
		AISI 1015										
		AISI 1045										
		AISI 1020										
		AISI 1215										
	Low alloyed steel Rm > 900 N/mm²	ASTM 3415 / AISI 3310										
		AISI 5115										
		AISI 52100										
		AISI 4140										
		AISI O2										
	High alloyed tool steel Rm < 1200 N/mm²	AISI D2										
		AISI D4/D6										
		AISI M2 / UNS T11302										
		AISI T1 / UNS T12001										
M	Stainless steel ferritic	AISI 430 / UNS S43000	35 – 50 | **115 – 164**	0.015 | **.0006**	0.020 | **.0008**	0.030 | **.0012**	0.035 | **.0014**	0.040 | **.0016**	0.050 | **.0020**	0.055 | **.0022**	0.060 | **.0024**	0.070 | **.0028**
		AISI 430F										
	Stainless steel martensitic	AISI 420C	35 – 50 | **115 – 164**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.055 | **.0022**	0.060 | **.0024**	0.070 | **.0028**	0.075 | **.0030**	0.080 | **.0031**	0.100 | **.0039**
		AISI 440B										
	Stainless steel martensitic – PH	AISI 630 / ASTM 17-4 PH	35 – 50 | **115 – 164**	0.015 | **.0006**	0.020 | **.0008**	0.025 | **.0010**	0.030 | **.0012**	0.040 | **.0016**	0.050 | **.0020**	0.055 | **.0022**	0.060 | **.0024**	0.070 | **.0028**
		ASTM 15-5 PH										
	Stainless steel austenitic	AISI 304	30 – 45 | **98 – 148**	0.010 | **.0004**	0.020 | **.0008**	0.025 | **.0010**	0.030 | **.0012**	0.035 | **.0014**	0.045 | **.0018**	0.050 | **.0020**	0.055 | **.0022**	0.060 | **.0024**
		AISI 316L										
		AISI 316LM										
		AISI 904L										
K	Cast iron	ASTM 30										
		ASTM 40B										
		ASTM 60-40-18										
		ASTM 80-60-03										





Note:
In case of external cooling reduce v_c and f of 20%

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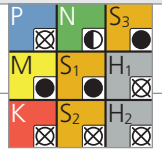
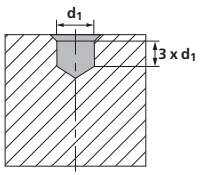
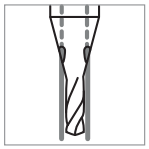


DRILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW

Materials group	Material	AISI/ASTM/UNS	v_c [m/min] | [SFM]	f [mm/rev] | [IPR] Ød1 0.3 mm | .012" f	Ød1 0.5 mm | .020" f	Ød1 0.8 mm | .032" f	Ød1 1.0 mm | .039" f	Ød1 1.2 mm | .047" f	Ød1 1.4 mm | .055" f	Ød1 1.6 mm | .063" f	Ød1 1.8 mm | .071" f	Ød1 2.0 mm | .079" f
N	Aluminium alloy wrought	ASTM 6351										
		ASTM 7075										
	Aluminium alloy cast	ASTM A380										
		UNS A03590										
	Copper	UNS C10100	40 – 100 | **131 – 328**	0.040 | **.0016**	0.060 | **.0024**	0.080 | **.0031**	0.090 | **.0035**	0.100 | **.0039**	0.120 | **.0047**	0.140 | **.0055**	0.160 | **.0063**	0.180 | **.0071**
		UNS C11000										
	Brass lead free	UNS C27400	40 – 100 | **131 – 328**	0.040 | **.0016**	0.060 | **.0024**	0.080 | **.0031**	0.090 | **.0035**	0.100 | **.0039**	0.120 | **.0047**	0.140 | **.0055**	0.160 | **.0063**	0.180 | **.0071**
		UNS C28000										
	Brass, Bronze Rm < 400 N/mm²	UNS C38500										
		UNS C51900										
	Bronze Rm < 600 N/mm²	UNS C63000										
		UNS C63200										
S_1	Super alloys	Inconel 625	15 – 30 | **49 – 98**	0.010 | **.0004**	0.015 | **.0006**	0.020 | **.0008**	0.022 | **.0009**	0.025 | **.0010**	0.035 | **.0014**	0.037 | **.0015**	0.045 | **.0018**	0.055 | **.0022**
		Inconel 718										
		Hastelloy B-2										
		Hastelloy X										
S_2	Titanium pure	ASTM B348 / F67										
		ASTM B348 / F68										
	Titanium alloys	ASTM B348 / F136										
		ASTM F1295										
S_3	CrCo alloys	Haynes 25	40 – 50 | **131 – 164**	0.020 | **.0008**	0.030 | **.0012**	0.040 | **.0016**	0.055 | **.0022**	0.060 | **.0024**	0.070 | **.0028**	0.075 | **.0030**	0.080 | **.0031**	0.100 | **.0039**
		ASTM F1537										
H_1	Hardened steel < 55 HRC	AISI O1										
H_2	Hardened steel ≥ 55 HRC	AISI D2										





Note:
In case of external cooling reduce v_c and f of 20%

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