

NEW

ATC - 6 x d - 10 x d

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

P	N	S ₃
M	S ₁	H ₁
K	S ₂	H ₂

DRILLING WITH INTERNAL COOLING | CUTTING DATA OVERVIEW

Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v _c		f [mm/rev] [IPR]																	
					[m/min] [SFM]		1.0 mm .039"		1.25 mm .049"		1/16"		3/32"		Ød1		1/8"		5/32"		3/16" - 7/32"		1/4"	
					Mid	High	Mid	High	Mid	High	Mid	High	Mid	High	Mid	High	Mid	High	Mid	High	Mid	High	Mid	High
S ₂	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	40 131	60 197	0.020	0.025	0.025	0.030	0.030	0.035	0.035	0.045	0.045	0.055	0.050	0.065	0.060	0.075	0.070	0.085	0.075	0.090
		.0008	.0010	.0010			.0012	.0012	.0014	.0014	.0018	.0018	.0022	.0020	.0026	.0024	.0030	.0028	.0033	.0030	.0035			
		9.9367	TiAl6Nb7	ASTM F1295																				

