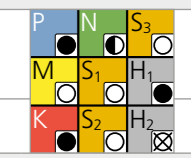
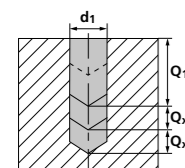
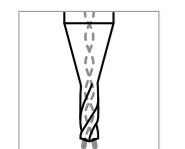


CrazyDrill Cool 15 x d - coated

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



DRILLING WITH INTERNAL COOLING | CUTTING DATA OVERVIEW



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v _c		Q ₁	Q ₂	f [mm/rev] [IPR]													
					[m/min] [SFM]				1/32"		1/16"		Ød1		3/32"		1/8"		5/32"		3/16" - 7/32"	
					Mid	High			0.8 mm .032"	1.0 mm .039"	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"				
P	Unalloyed carbon steel Rm < 800 N/mm²	1.0301	C10	AISI 1010	60 197	140 459	6xd1	2xd1	0.050 .0020	0.060 .0024	0.070 .0028	0.080 .0031	0.100 .0039	0.120 .0047	0.140 .0055	0.180 .0071	0.210 .0083	0.240 .0094				
		1.0401	C15	AISI 1015																		
		1.1191	C45E/CK45	AISI 1045																		
		1.0044	S275JR	AISI 1020																		
		1.0715	11SMn30	AISI 1215																		
		1.5752	15NiCr13	ASTM 3415 / AISI 3310																		
	Low alloyed steel Rm > 900 N/mm²	1.7131	16MnCr5	AISI 5115	60 197	120 394	6xd1	2xd1	0.040 .0016	0.050 .0020	0.060 .0024	0.070 .0028	0.090 .0035	0.110 .0043	0.120 .0047	0.150 .0059	0.170 .0067	0.180 .0071				
		1.3505	100Cr6	AISI 52100																		
		1.7225	42CrMo4	AISI 4140																		
		1.2842	90MnCrV8	AISI O2																		
		1.2379	X153CrMoV12	AISI D2																		
		1.2436	X210CrW12	AISI D4/D6																		
High alloyed tool steel Rm < 1200 N/mm²	1.3343	HS6-5-2C	AISI M2 / UNS T11302	40 131	80 262	6xd1	2xd1	0.030 .0012	0.040 .0016	0.050 .0020	0.060 .0024	0.070 .0028	0.090 .0035	0.100 .0039	0.120 .0047	0.150 .0059	0.170 .0067					
	1.3355	HS18-0-1	AISI T1 / UNS T12001																			
	1.4016	X6Cr17	AISI 430 / UNS S43000																			
	1.4105	X6CrMoS17	AISI 430F																			
	1.4034	X46Cr13	AISI 420C																			
	1.4112	X90CrMoV18	AISI 440B																			
M	Stainless steel ferritic	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH	20 131	40 131	0.5xd1	0.25xd1	0.010 .0004	0.020 .0008	0.030 .0012	0.040 .0016	0.060 .0024	0.080 .0031	0.090 .0035	0.110 .0043	0.120 .0047	0.130 .0051	0.140 .0055			
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH																		
	Stainless steel martensitic	1.4301	X5CrNi 18-10	AISI 304	20 131	40 131	0.5xd1	0.25xd1	0.010 .0004	0.020 .0008	0.030 .0012	0.040 .0016	0.060 .0024	0.080 .0031	0.090 .0035	0.110 .0043	0.120 .0047	0.130 .0051	0.140 .0055			
		1.4435	X2CrNiMo 18-14-3	AISI 316L																		
	Stainless steel austenitic	1.4441	X2CrNiMo 18-15-3	AISI 316LM	20 131	40 131	0.5xd1	0.25xd1	0.010 .0004	0.020 .0008	0.030 .0012	0.040 .0016	0.060 .0024	0.080 .0031	0.090 .0035	0.110 .0043	0.120 .0047	0.130 .0051	0.140 .0055			
		1.4539	X1NiCrMoCu 25-20-5	AISI 904L																		
		0.6020	GG20	ASTM 30																		
		0.6030	GG30	ASTM 40B																		
K	Cast iron	0.7040	GGG40	ASTM 60-40-18	60 197	80 262	15xd1	-	0.040 .0016	0.060 .0024	0.075 .0030	0.090 .0035	0.110 .0043	0.140 .0055	0.166 .0065	0.200 .0079	0.230 .0091	0.250 .0098				
		0.7060	GGG60	ASTM 80-60-03																		
		3.2315	AlMgSi1	ASTM 6351																		
		3.4365	AlZnMgCu1.5	ASTM 7075																		
N	Aluminium alloy wrought	3.2163	GD-AlSi9Cu3	ASTM A380	100 328	200 656	5xd1	1xd1	0.050 .0020	0.055 .0022	0.065 .0026	0.080 .0031	0.100 .0039	0.120 .0047	0.140 .0055	0.180 .0071	0.210 .0083	0.230 .0091				
		3.2381	GD-AlSi10Mg	UNS A03590																		
	Aluminium alloy cast	2.004	Cu-OF / CW008A	UNS C10100	100 328	200 656	1.5xd1	1xd1	0.040 .0016	0.050 .0020	0.060 .0024	0.070 .0028	0.090 .0035	0.110 .0043	0.130 .0051	0.160 .0063	0.190 .0075	0.210 .0083				
		2.0065	Cu-ETP / CW004A	UNS C11000																		
	Copper	2.0321	CuZn37 CW508L	UNS C27400	100 328	140 459	1xd1	0.5xd1	0.035 .0014	0.040 .0016	0.060 .0024	0.070 .0028	0.090 .0035	0.110 .0043	0.120 .0047	0.150 .0059	0.180 .0071	0.200 .0079				
		2.036	CuZn40 CW509L	UNS C28000																		
	Brass lead free	2.0401	CuZn39Pb3 / CW614N	UNS C38500	80 262	120 394	2xd1	1xd1	0.050 .0020	0.055 .0022	0.065 .0026	0.080 .0031	0.100 .0039	0.120 .0047	0.140 .0055	0.180 .0071	0.210 .0083	0.230 .0091				
		2.102	CuSn6	UNS C51900																		
	Brass, Bronze Rm < 400 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	80 262	150 492	10xd1	5xd1	0.020 .0008	0.030 .0012	0.040 .0016	0.055 .0022	0.070 .0028	0.090 .0035	0.110 .0043	0.130 .0051	0.150 .0059	0.200 .0079				
		2.096	CuAl9Mn2	UNS C63200																		
	S ₁	Super alloys	2.4856		Inconel 625	15 49	20 66	0.5xd1	0.25xd1	0.007 .0003	0.010 .0004	0.012 .0005	0.015 .0006	0.018 .0007	0.022 .0009	0.020 .0008	0.022 .0009	0.032 .0013	0.042 .0017			
			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	15 49	20 66	0.5xd1	0.25xd1	0.020 .0008	0.020 .0008	0.030 .0012	0.035 .0014	0.040 .0016	0.050 .0020	0.060 .0024	0.065 .0026	0.070 .0028	0.075 .0030				
		3.7065	Gr.4	ASTM B348 / F68																		
S ₃	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	15 49	20 66	0.5xd1	0.25xd1	0.020 .0008	0.020 .0008	0.030 .0012	0.035 .0014	0.040 .0016	0.050 .0020	0.060 .0024	0.065 .0026	0.070 .0028	0.075 .0030				
		9.9367	TiAl6Nb7	ASTM F1295																		
H ₁	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	15 49	20 66	0.5xd1	0.25xd1	0.007 .0003	0.010 .0004	0.012 .0005	0.017 .0007	0.022 .0009	0.027 .0011	0.032 .0013	0.037 .0015	0.042 .0017	0.052 .0020				
			CrCoMo28	ASTM F1537																		
H ₂	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1	20 66	40 131	0.5xd1	0.25xd1	0.008 .0003	0.010 .0004	0.012 .0005	0.015 .0006	0.020 .0008	0.025 .0010	0.030 .0012	0.040 .0016	0.050 .0020	0.060 .0024				
		1.2379	X153CrMoV12	AISI D2																		