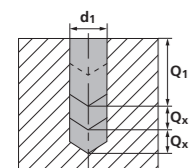
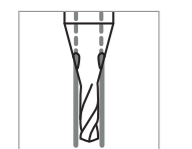


# SST-Inox - 50 x d

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



## DRILLING WITH INTEGRATED COOLING | CUTTING DATA OVERVIEW



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v <sub>c</sub> [m/min]		Q <sub>1</sub>	Q <sub>2</sub>	f [mm/rev]					
					∅d1 ≤ 0.4	∅d1 > 0.4			0.3 mm	0.4 mm 1/64"	0.6 mm	∅d1 0.8 mm 1/32"	1.0 mm	1.2 mm
									f	f	f	f	f	f
P	Unalloyed carbon steel Rm < 800 N/mm <sup>2</sup>	1.0301	C10	AISI 1010					Recommended: CrazyDrill Flex Steel 50 x d1					
		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 <sup>2</sup>	1.5752	15NiCr13	ASTM 3415 / AISI 3310										
		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/mm <sup>2</sup>	1.2379	X153CrMoV12	AISI D2										
		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	25-35	35-40	2xd1 - 3xd1	0.2xd1 - 0.5xd1	0.010-0.015	0.010-0.015	0.015-0.020	0.015-0.020	0.030-0.040	0.040-0.050
		1.4105	X6CrMoS17	AISI 430F										
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	25-35	35-40	2xd1 - 3xd1	0.2xd1 - 0.5xd1	0.010-0.015	0.010-0.015	0.015-0.020	0.015-0.020	0.030-0.040	0.040-0.050
		1.4112	X90CrMoV18	AISI 440B										
	Stainless steel martensitic - PH	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH	25-35	35-40	2xd1 - 3xd1	0.2xd1 - 0.5xd1	0.010-0.015	0.010-0.015	0.015-0.020	0.015-0.020	0.030-0.040	0.040-0.050
		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	25-35	35-40	2xd1 - 3xd1	0.2xd1 - 0.5xd1	0.005-0.010	0.005-0.010	0.010-0.015	0.010-0.015	0.020-0.030	0.030-0.040
1.4441		X2CrNiMo 18-15-3	AISI 316LM											
K	Cast iron	0.6020	GG20	ASTM 30					Recommended: CrazyDrill Flex Steel 50 x d1					
		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					Recommended: CrazyDrill Flex Steel 50 x d1					
		3.4365	AlZnMgCu1.5	ASTM 7075										
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380					Recommended: CrazyDrill Flex Steel 50 x d1					
		3.2381	GD-AlSi10Mg	UNS A03590										
	Copper	2.004	Cu-OF / CW008A	UNS C10100	20-30	35-60	2xd1 - 3xd1	0.5xd1	0.040	0.045	0.050	0.060	0.070	0.080
		2.0065	Cu-ETP / CW004A	UNS C11000										
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	20-30	35-60	2xd1 - 3xd1	0.5xd1	0.040	0.045	0.050	0.060	0.070	0.080
		2.036	CuZn40 CW509L	UNS C28000										
Brass, Bronze Rm < 400 N/mm <sup>2</sup>	2.0401	CuZn39Pb3 / CW614N	UNS C38500					Recommended: CrazyDrill Flex Steel 50 x d1						
	2.102	CuSn6	UNS C51900											
Bronze Rm < 600 N/mm <sup>2</sup>	2.0966	CuAl10Ni5Fe4	UNS C63000					Recommended: CrazyDrill Flex Steel 50 x d1						
	2.096	CuAl9Mn2	UNS C63200											
S <sub>1</sub>	Super alloys	2.4856		Inconel 625	10-20	20-30	2xd1 - 3xd1	0.2xd1	0.010-0.020	0.010-0.020	0.015-0.025	0.020-0.030	0.025-0.035	0.035-0.045
		2.4668		Inconel 718										
		2.4617	NiMo28	Hastelloy B-2										
		2.4665	NiCr22Fe18Mo	Hastelloy X										
S <sub>2</sub>	Titanium pure	3.7035	Gr.2	ASTM B348 / F67					Recommended: CrazyDrill Flex Titanium 50 x d1					
		3.7065	Gr.4	ASTM B348 / F68										
S <sub>3</sub>	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136					Recommended: CrazyDrill Flex Titanium 50 x d1					
		9.9367	TiAl6Nb7	ASTM F1295										
H <sub>1</sub>	Hardened steel < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25	20-30	30-40	2xd1 - 3xd1	0.5xd1	0.010-0.020	0.010-0.020	0.015-0.025	0.020-0.030	0.025-0.035	0.035-0.045
			CrCoMo28	ASTM F1537										
H <sub>2</sub>	Hardened steel ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1										
		1.2379	X153CrMoV12	AISI D2										