

NEW

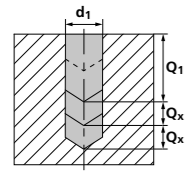
Titanium ATK - 50 x d

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 [m/min] [SFM]				Q ₁	Q _x		f [mm/rev] [IPR]									
					Ød1 ≤ 0.4		Ød1 > 0.4			Ød1 < 0.5	Ød1 ≥ 0.5	Ød1									
					Mid	High	Mid	High		f	f	0.3mm .012"	1/64"	0.6mm .024"	1/32"	1.0mm .039"	1.2mm .047"	1.4mm .055"	1/16"	1.8mm .071"	2.0mm .079"
S ₂	Titanium alloy	3.7165	TiAl6V4	ASTM B348 / F136	5 16	20 66	20 66	40 131	2xd1	0.25 - 0.5	0.5 - 1.0	0.003	0.004	0.006	0.008	0.010	0.012	0.014	0.016	0.018	0.020
		9.9367	TiAl6Nb7	ASTM F1295							xd1	xd1	.00012	.00016	.00024	.00031	.00039	.00047	.00055	.00063	.00071