CRAZYMILL™ by Mikron Tool Frontchamfer

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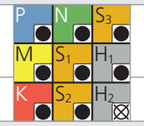
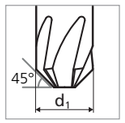
DEBURRING TOOLS
CRAZYMILL FRONTCHAMFER

CrazyMill Frontchamfer

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



DEBURRING WITH EXTERNAL COOLING | CUTTING DATA OVERVIEW



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v_c [m/min] | [SFM]	Ød1 1.0–2.0 mm | .039" – .079" f [mm] | [IPT]	Ød1 3.0–6.0 mm | .118" – .236" f [mm] | [IPT]
P	Unalloyed carbon steel Rm < 800 N/mm²	1.0301	C10	AISI 1010	120 | 394	0.01 – 0.04 | .0004 – .0016	0.03 – 0.05 | .0012 – .0020
		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/mm²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	100 | 328	0.01 – 0.03 | .0004 – .0012	0.02 – 0.04 | .0008 – .0016
		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/mm²	1.2379	X153CrMoV12	AISI D2	80 | 262	0.01 – 0.02 | .0004 – .0008	0.01 – 0.03 | .0004 – .0012
		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	50 | 164	0.01 – 0.02 | .0004 – .0008	0.02 – 0.03 | .0008 – .0012
		1.4105	X6CrMoS17	AISI 430F			
	Stainless steel martensitic	1.4034	X46Cr13	AISI 420C	80 | 262	0.01 – 0.02 | .0004 – .0008	0.01 – 0.03 | .0004 – .0012
		1.4112	X90CrMoV18	AISI 440B			
	Stainless steel martensitic – PH	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH			
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH			
	Stainless steel austenitic	1.4301	X5CrNi 18-10	AISI 304	50 | 164	0.01 – 0.02 | .0004 – .0008	0.02 – 0.03 | .0008 – .0012
		1.4435	X2CrNiMo 18-14-3	AISI 316L			
		1.4441	X2CrNiMo 18-15-3	AISI 316LM			
		1.4539	X1NiCrMoCu 25-20-5	AISI 904L			
K	Cast iron	0.6020	GG20	ASTM 30	60 | 197	0.01 – 0.02 | .0004 – .0008	0.01 – 0.03 | .0004 – .0012
		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	200 | 656	0.02 – 0.05 | .0008 – .0020	0.03 – 0.07 | .0012 – .0028
		3.4365	AlZnMgCu1.5	ASTM 7075			
	Aluminium alloy cast	3.2163	GD-AlSi9Cu3	ASTM A380	200 | 656	0.02 – 0.05 | .0008 – .0020	0.03 – 0.07 | .0012 – .0028
		3.2381	GD-AlSi10Mg	UNS A03590			
	Copper	2.004	Cu-OF / CW008A	UNS C10100	40 | 131	0.01 – 0.02 | .0004 – .0008	0.02 – 0.03 | .0008 – .0012
		2.0065	Cu-ETP / CW004A	UNS C11000			
	Brass lead free	2.0321	CuZn37 CW508L	UNS C27400	40 | 131	0.01 – 0.02 | .0004 – .0008	0.02 – 0.03 | .0008 – .0012
		2.036	CuZn40 CW509L	UNS C28000			
	Brass, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	200 | 656	0.02 – 0.05 | .0008 – .0020	0.03 – 0.07 | .0012 – .0028
		2.102	CuSn6	UNS C51900			
	Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	200 | 656	0.02 – 0.05 | .0008 – .0020	0.03 – 0.07 | .0012 – .0028
		2.096	CuAl9Mn2	UNS C63200			
S_1	Super alloys	2.4856		Inconel 625	40 | 131	0.01 – 0.02 | .0004 – .0008	0.02 – 0.03 | .0008 – .0012
		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	40 | 131	0.01 – 0.02 | .0004 – .0008	0.02 – 0.03 | .0008 – .0012
		3.7065	Gr.4	ASTM B348 / F68			
	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	40 | 131	0.01 – 0.02 | .0004 – .0008	0.02 – 0.03 | .0008 – .0012
		9.9367	TiAl6Nb7	ASTM F1295			
S_3	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	50 | 164	0.01 – 0.02 | .0004 – .0008	0.02 – 0.03 | .0008 – .0012
			CrCoMo28	ASTM F1537			
H_1	Hardened steel < 55 HRC	1.2510	100MnCrMoW4	AISI O1	60 | 197	0.01 – 0.02 | .0004 – .0008	0.01 – 0.03 | .0004 – .0012
H_2	Hardened steel ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2			