

**NEW**

# ATC - 6 x d - 10 x d

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

P	N	S <sub>3</sub>
M	S <sub>1</sub>	H <sub>1</sub>
K	S <sub>2</sub>	H <sub>2</sub>

## DRILLING WITH INTERNAL COOLING | CUTTING DATA OVERVIEW

Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v <sub>c</sub> [m/min]		f [mm/rev]																							
							1.0 mm		1.25 mm		1.5 mm 1/16"		2.0 mm		Ød1 2.5 mm 3/32"		3.0 mm 1/8"		4.0 mm 5/32"		5.0 mm 3/16" - 7/32"		6.0 mm 1/4"							
							Mid	High	Mid	High	Mid	High	Mid	High	Mid	High	Mid	High	Mid	High	Mid	High	Mid	High	Mid	High				
S <sub>2</sub>	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	40	60	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						
		9.9367	TiAl6Nb7	ASTM F1295																										

