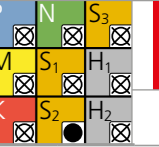


NEW

PTC - 3 x d - 6 x d

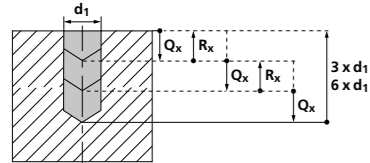
RECOMMENDATION FOR USE
● Excellent | ● Good | ○ Acceptable | ☒ Not recommended



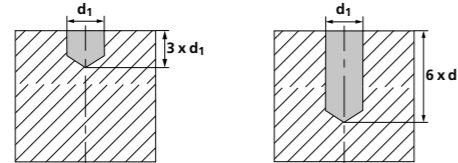
DRILLING WITH INTERNAL COOLING | CUTTING DATA OVERVIEW

Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v_c [m/min]		Q_x [mm]	R_x [mm]	f [mm/rev]																	
					Mid	High	0.2 - 0.5 x d1	0.2 - 0.5 x d1	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
S ₂	Pure titanium	3.7035	Ti Gr.2	ASTM B348 / F67	30	60	0.2 - 0.5 x d1	0.2 - 0.5 x d1	0.010	0.020	0.013	0.025	0.015	0.030	0.020	0.040	0.025	0.050	0.030	0.055	0.040	0.070	0.050	0.080	0.060	0.090
		3.7065	Ti Gr.4	ASTM B348 / F68			-	-																		

For Ti Gr.2



For Ti Gr.4



Chip breaking cycle (e.g.: G73)