

NEW

PTC - 3 x d - 6 x d

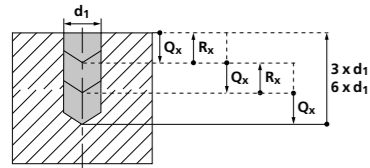
RECOMMENDATION FOR USE
● Excellent | ● Good | ○ Acceptable | ☒ Not recommended

P	N	S ₃
M	S ₁	H ₁
K	S ₂	H ₂

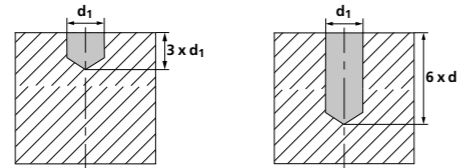
DRILLING WITH INTERNAL COOLING | CUTTING DATA OVERVIEW

Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v _c [m/min] [SFM]	Q _s [mm] [inch]	R _s [mm] [inch]	f [mm/rev] [IPR]																		
								1.0 mm .039"		1.25 mm .049"		1/16"		3/32"		Ød1		1/8"		5/32"		3/16" - 7/32"		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 98	60 197	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			-	-	.0004	.0008	.0005	.0010	.0006	.0012	.0008	.0016	.0010	.0020	.0012	.0022	.0016	.0028	.0020	.0031	.0024	.0035

For Ti Gr.2



For Ti Gr.4



Chip breaking cycle (e.g.: G73)