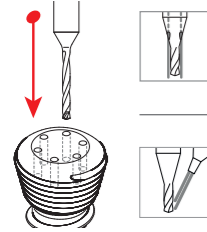
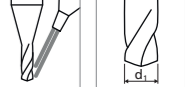


Lobe drilling

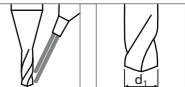
v_c [m/min]
 f [mm/rev]



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v_c [m/min]	Q_1	Q_2	T4 Ød1 0.25 mm f	T5 Ød1 0.30 mm f	T6 Ød1 0.30 mm f	T7 Ød1 0.30 mm f	T8 Ød1 0.40 mm f	T10 Ød1 0.50 mm f	T15 Ød1 0.60 mm f	T20 Ød1 0.70 mm f	T25 Ød1 0.80 mm f	T30 Ød1 1.00 mm f
M	Stainless steel austenitic	1.4435	X2CrNiMo 18-14-3	AISI 316L	30 - 45	1-4xd1	1-2xd1	0.01 - 0.02	0.01 - 0.02	0.01 - 0.02	0.01 - 0.02	0.01 - 0.02	0.01 - 0.02	0.015 - 0.025	0.015 - 0.025	0.015 - 0.025	0.025 - 0.035
		1.4441	X2CrNiMo 18-15-3	AISI 316LM													
S ₃	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	40 - 50	1-3xd1	1-2xd1	0.02 - 0.03	0.02 - 0.03	0.02 - 0.03	0.02 - 0.03	0.02 - 0.03	0.02 - 0.03	0.015 - 0.020	0.015 - 0.020	0.015 - 0.020	0.05 - 0.06
			CrCoMo28	ASTM F1537													
M	Stainless steel austenitic	1.4435	X2CrNiMo 18-14-3	AISI 316L	25 - 30	0.5-1xd1	0.5xd1	0.010 - 0.015	0.010 - 0.015	0.010 - 0.015	0.010 - 0.015	0.010 - 0.015	0.010 - 0.015	0.015 - 0.020	0.015 - 0.020	0.015 - 0.020	0.02 - 0.03
		1.4441	X2CrNiMo 18-15-3	AISI 316LM													
S ₃	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	25 - 35	0.5-1xd1	0.5xd1	0.015 - 0.025	0.015 - 0.025	0.015 - 0.025	0.015 - 0.025	0.015 - 0.025	0.015 - 0.025	0.025 - 0.035	0.025 - 0.035	0.025 - 0.035	0.04 - 0.05
			CrCoMo28	ASTM F1537													

Pre-hole drilling

v_c [m/min]
 f [mm/rev]



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	v_c [m/min]	T4 Ød1 0.9 mm f	T5 Ød1 1.0 mm f	T6 Ød1 1.2 mm f	T7 Ød1 1.4 mm f	T8 Ød1 1.6 mm f	T10 Ød1 1.9 mm f	T15 Ød1 2.3 mm f	T20 Ød1 2.7 mm f	T25 Ød1 3.1 mm f	T30 Ød1 3.8 mm f
M	Stainless steel austenitic	1.4435	X2CrNiMo 18-14-3	AISI 316L	25 - 35	0.02 - 0.03	0.02 - 0.03	0.03 - 0.04	0.03 - 0.04	0.03 - 0.04	0.05 - 0.06	0.05 - 0.06	0.06 - 0.07	0.07 - 0.08	0.07 - 0.08
		1.4441	X2CrNiMo 18-15-3	AISI 316LM											
S ₂	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	20 - 30	0.010 - 0.015	0.010 - 0.015	0.012 - 0.018	0.014 - 0.020	0.015 - 0.025	0.020 - 0.030	0.025 - 0.035	0.025 - 0.040	0.030 - 0.045	0.045 - 0.070
		9.9367	TiAl6Nb7	ASTM F1295											
S ₃	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	25 - 35	0.005 - 0.015	0.005 - 0.015	0.006 - 0.018	0.007 - 0.020	0.008 - 0.025	0.010 - 0.030	0.012 - 0.035	0.015 - 0.040	0.015 - 0.050	0.020 - 0.055
			CrCoMo28	ASTM F1537											