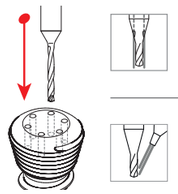
NEW CONCEPT

Lobe drilling

V_c **[SFM] |** [m/min]
f **[IPR] |** [mm/rev]



Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	V_c [SFM] | [m/min]	Q_1	Q_x	T4 Ød1 .0098" | 0.25 mm f	T5 Ød1 .0118" | 0.30 mm f	T6 Ød1 .0138" | 0.30 mm f	T7 Ød1 .0138" | 0.30 mm f	T8 Ød1 .0157" | 0.40 mm f	T10 Ød1 .0197" | 0.50 mm f	T15 Ød1 .0236" | 0.60 mm f	T20 Ød1 .0276" | 0.70 mm f	T25 Ød1 .0315" | 0.80 mm f	T30 Ød1 .0394" | 1.00 mm f
M	Stainless steel austenitic	1.4435	X2CrNiMo 18-14-3	AISI 316L	**98 – 148** 30 – 45	1 - 4 x d1	1 - 2 x d1	**.0004 - .0008** 0.01 - 0.02	**.0004 - .0008** 0.01 - 0.02	**.0004 - .0008** 0.01 - 0.02	**.0004 - .0008** 0.01 - 0.02	**.0004 - .0008** 0.01 - 0.02	**.0004 - .0008** 0.01 - 0.02	**.0006 - .0010** 0.015 - 0.025	**.0006 - .0010** 0.015 - 0.025	**.0006 - .0010** 0.015 - 0.025	**.0010 - .0014** 0.025 - 0.035
		1.4441	X2CrNiMo 18-15-3	AISI 316LM													
S_3	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	**131 – 164** 40 – 50	1 - 3 x d1	1 - 2 x d1	**.0008 - .0012** 0.02 - 0.03	**.0008 - .0012** 0.02 - 0.03	**.0008 - .0012** 0.02 - 0.03	**.0008 - .0012** 0.02 - 0.03	**.0008 - .0012** 0.02 - 0.03	**.0008 - .0012** 0.02 - 0.03	**.0006 - .0008** 0.015 - 0.020	**.0006 - .0008** 0.015 - 0.020	**.0006 - .0008** 0.015 - 0.020	**.0020 - .0024** 0.05 - 0.06
			CrCoMo28	ASTM F1537													
M	Stainless steel austenitic	1.4435	X2CrNiMo 18-14-3	AISI 316L	**98 – 148** 30 – 45	1 - 4 x d1	1 - 2 x d1	**.0004 - .0006** 0.010 - 0.015	**.0004 - .0006** 0.010 - 0.015	**.0004 - .0006** 0.010 - 0.015	**.0004 - .0006** 0.010 - 0.015	**.0004 - .0006** 0.010 - 0.015	**.0004 - .0006** 0.010 - 0.015	**.0006 - .0010** 0.015 - 0.020	**.0006 - .0010** 0.015 - 0.020	**.0006 - .0008** 0.015 - 0.025	**.0008 - .0012** 0.02 - 0.03
		1.4441	X2CrNiMo 18-15-3	AISI 316LM													
S_3	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	**131 – 164** 40 – 50	1 - 3 x d1	1 - 2 x d1	**.0006 - .0010** 0.015 - 0.025	**.0006 - .0010** 0.015 - 0.025	**.0006 - .0010** 0.015 - 0.025	**.0006 - .0010** 0.015 - 0.025	**.0006 - .0010** 0.015 - 0.025	**.0006 - .0010** 0.015 - 0.025	**.0010 - .0014** 0.025 - 0.035	**.0010 - .0014** 0.025 - 0.035	**.0006 - .0008** 0.015 - 0.020	**.0016 - .0020** 0.04 - 0.05
			CrCoMo28	ASTM F1537													

Pre-hole drilling

V_c **[SFM] |** [m/min]
f **[IPR] |** [mm/rev]

Materials group	Material	Mat. no.	DIN	AISI/ASTM/UNS	V_c [SFM] | [m/min]	T4 Ød1 .039" | 0.9 mm f	T5 Ød1 .039" | 1.0 mm f	T6 Ød1 .047" | 1.2 mm f	T7 Ød1 .055" | 1.4 mm f	T8 Ød1 .063" | 1.6 mm f	T10 Ød1 .075" | 1.9 mm f	T15 Ød1 .091" | 2.3 mm f	T20 Ød1 .106" | 2.7 mm f	T25 Ød1 .122" | 3.1 mm f	T30 Ød1 .150" | 3.8 mm f
M	Stainless steel austenitic	1.4435	X2CrNiMo 18-14-3	AISI 316L	**82 – 115** 25 – 35	**.0008 - .0012** 0.02 - 0.03	**.0008 - .0012** 0.02 - 0.03	**.0012 - .0016** 0.03 - 0.04	**.0012 - .0016** 0.03 - 0.04	**.0012 - .0016** 0.03 - 0.04	**.0020 - .0024** 0.05 - 0.06	**.0020 - .0024** 0.05 - 0.06	**.0024 - .0028** 0.06 - 0.07	**.0028 - .0032** 0.07 - 0.08	**.0028 - .0032** 0.07 - 0.08
		1.4441	X2CrNiMo 18-15-3	AISI 316LM											
S_2	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136	**66 – 98** 20 – 30	**.00039 - .00059** 0.010 - 0.015	**.00039 - .00059** 0.010 - 0.015	**.00047 - .00071** 0.012 - 0.018	**.00055 - .00079** 0.014 - 0.020	**.00059 - .00098** 0.015 - 0.025	**.00079 - .00118** 0.020 - 0.030	**.00098 - .00138** 0.025 - 0.035	**.00098 - .00157** 0.025 - 0.040	**.00118 - .00177** 0.030 - 0.045	**.00177 - .00276** 0.045 - 0.070
		9.9367	TiAl6Nb7	ASTM F1295											
S_3	CrCo alloys	2.4964	CoCr20W15Ni	Haynes 25	**82 – 115** 25 – 35	**.00020 - .00059** 0.005 - 0.015	**.00020 - .00059** 0.005 - 0.015	**.00024 - .00071** 0.006 - 0.018	**.00028 - .00079** 0.007 - 0.020	**.00031 - .00098** 0.008 - 0.025	**.00039 - .00118** 0.010 - 0.030	**.00047 - .00138** 0.012 - 0.035	**.00055 - .00157** 0.014 - 0.040	**.00063 - .00197** 0.016 - 0.050	**.00079 - .00217** 0.020 - 0.055
			CrCoMo28	ASTM F1537											