

NEW

TK - 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		f [mm/rev] [IPR]																			
					[m/min] [SFM]		1/64"				1/32"				Ød1				1/16"				1.9-2.0 mm .075"-.079"			
					Mid	High	Mid	High	Q _i	Q _x	Mid	High	Q _i	Q _x	Mid	High	Q _i	Q _x	Mid	High	Q _i	Q _x	Mid	High	Q _i	Q _x
S ₂	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	30 98	60 197																				
		3.7065	GR.4	ASTM B348 / F68																						
	Titanium alloys	3.7165	TiAl6V4	ASTM B348 / F136																						
		9.9367	TiAl6Nb7	ASTM F1295			0.002 .00008	0.004 .00016	1.0xd1	0.5-1.0 xd1	0.005 .00020	0.009 .00035	1.5xd1	1.0xd1	0.010 .00039	0.012 .00047	2.0xd1	1.0xd1	0.013 .00051	0.014 .00055	2.0xd1	1.0xd1	0.015 .00059	0.018 .00071	3.0xd1	1.0xd1

