

NEW

TN - 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	0.2-0.4 mm .008"-.016"		0.5-0.9 mm .020"-.035"		1.0-1.2 mm .039"-.047"		1.3-1.4 mm .051"-.055"		1.5-1.8 mm .059"-.071"		1.9-2.0 mm .075"-.079"										
S ₂	Titanium pure	3.7035	Gr.2	ASTM B348 / F67	20 66	50 164	Mid	High	Q _i	Q _x	Q _i	Q _x	Q _i	Q _x	Q _i	Q _x	Q _i	Q _x	Q _i	Q _x	Q _i	Q _x	Q _i	Q _x	Q _i	Q _x	
		3.7065	GR.4	ASTM B348 / F68																							
	Titanium alloys		3.7165	TiAl6V4																							ASTM B348 / F136
	9.9367	TiAl6Nb7	ASTM F1295																								

