

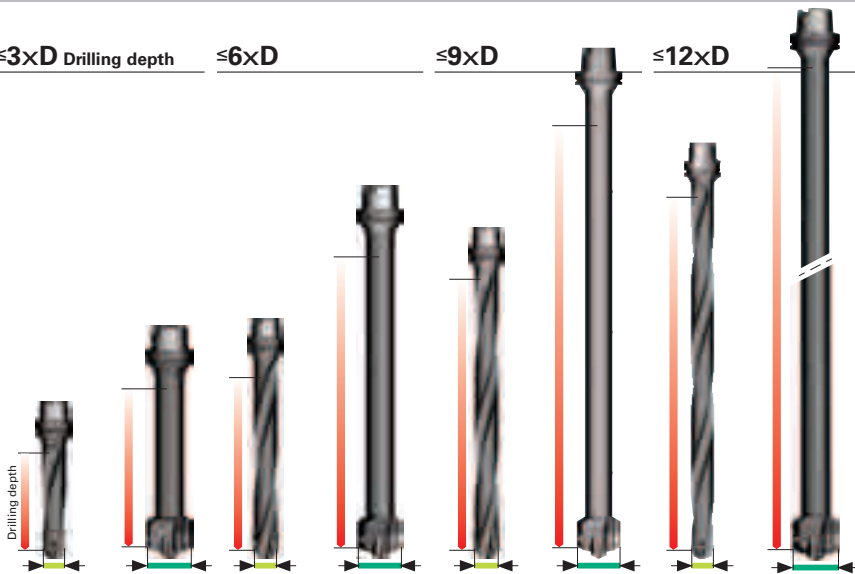


≤3xD Drilling depth

≤6xD

≤9xD

≤12xD



Insert material

Carbide

Carbide

Carbide

Carbide

Carbide grade

depending on insert

depending on insert

depending on insert

depending on insert

Holder size

400...560

600...950

400...560

600...950

400...560

600...950

400...560

600...950

Ø range mm

40...<60

60...100

40...<60

60...100

40...<60

60...100

40...<60

60...100

Feed rate f(mm/rev)	Carbide		Carbide		Carbide		Carbide	
	V _c m/min	V _c m/min	V _c m/min	V _c m/min	V _c m/min	V _c m/min	V _c m/min	V _c m/min
0.20...0.40	110...150	130...180	100...130	120...155	70...120	85...145	60...110	70...130
0.20...0.40	100...130	120...155	90...120	110...145	70...110	85...130	60...110	70...130
0.20...0.40	110...150	130...180	100...130	120...155	70...120	85...145	60...120	70...145
0.15...0.30	100...130	120...160	90...120	110...145	70...110	85...130	60...110	70...130
0.20...0.40	100...130	120...155	90...120	110...145	80...110	100...130	70...100	85...120
0.20...0.40	90...120	110...145	80...110	100...130	70...100	85...120	60...90	70...110
0.15...0.35	80...110	100...130	70...100	85...120	60...90	70...110	55...80	65...100
0.20...0.40	80...110	100...130	70...100	85...120	60...90	70...110	55...80	65...100
0.15...0.35	70...100	85...120	65...90	80...110	60...80	70...100	55...75	65...90
0.20...0.40	90...120	110...145	80...110	100...130	70...100	85...120	60...90	70...110
0.20...0.40	80...110	100...130	70...100	85...120	60...90	70...110	55...80	65...100
0.15...0.35	70...100	85...120	65...90	80...110	60...80	70...100	55...75	65...90
0.20...0.40	80...110	100...130	70...100	85...120	60...90	70...110	55...80	65...100
0.15...0.35	70...100	85...120	65...90	80...110	60...80	70...100	55...75	65...90
0.20...0.40	70...100	85...120	65...95	80...115	60...90	70...110	55...80	65...100
0.15...0.35	70...90	85...110	65...90	80...110	60...80	70...100	55...75	65...90
0.15...0.35	70...100	85...120	65...95	80...115	60...90	70...110	55...85	65...100
0.15...0.35	60...90	70...110	55...85	65...100	50...80	55...100	45...75	55...90
0.15...0.35	55...85	65...100	50...80	60...100	45...75	55...90	40...70	50...85
0.30...0.60	120...200	145...240	110...180	130...220	100...160	120...190	90...150	110...180
0.30...0.60	100...160	120...190	90...150	110...180	85...140	100...170	80...130	100...155
0.30...0.60	100...160	120...190	90...150	110...180	85...140	100...170	80...130	100...155
0.20...0.40	80...120	100...145	70...110	85...130	60...100	70...120	55...90	65...110
0.30...0.60	200...300	240...360	180...280	220...340	160...260	190...310	140...240	170...290
0.30...0.60	180...280	220...340	170...260	200...310	155...250	185...300	135...235	160...280
0.30...0.60	160...240	190...290	150...230	180...280	140...220	170...260	130...210	155...250
0.30...0.60	140...200	170...240	130...190	160...230	120...180	145...220	110...170	130...200
0.30...0.60	120...200	145...240	110...180	130...220	100...160	120...190	90...150	110...180
0.20...0.40	140...200	170...240	130...190	160...230	120...180	145...220	110...170	130...200
0.15...0.35	140...200	170...240	130...190	160...230	120...180	145...220	110...170	130...200

A AITN **C** TiCN **F** FIRE **P** AlCrN **S** TiN **M** MolyGlide