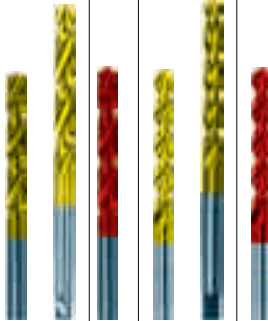
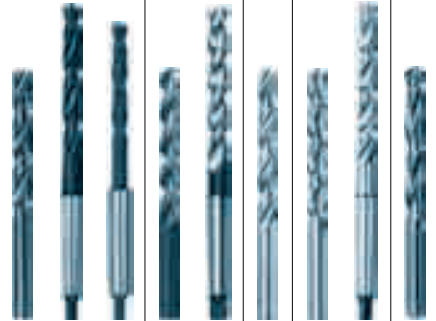


# ≤5×D drilling depth

Guh. no.	Surface finish	HSS			
		N		GT 100	
		Type	Type	Type	Type
straight shank	DIN 338 [R]	651	2456	652	2457
	DIN 345 [R]	664		665	
MT	DIN 346 [R]		654		606
	DIN 346 [R]				



HSCO					M42
N	GT 100	Ti	VA	N	
305	622	605	1260		1146
308		608			
345	645		1262		
351					



Vc m/min	Vc m/min	Feed column no.			
		6	7	6	7
30	32	6	7	6	7
24	26	5	6	5	6
33	36	6	7	6	7
33	36	5	6	5	6
28	31	5	6	5	6
28	31	5	6	5	6
25	28	4	5	4	5
22	24	4	5	4	5
33	36	6	7	6	7
20	22	4	5	4	5
14	16	4	5	4	5
18	20	4	5	4	5
33	36	6	7	6	7
33	36	6	7	6	7
28	31	6	7	6	7
22	24	6	7	6	7
85		8		8	
85		8		8	
60		8		8	
60		8		8	
80	90	6	7	6	7
65	70	5	6	5	6
75	80	5	6	5	6
45	50	5	6	5	6
33	36	4	5	4	5
27	33	4	5	4	5
16	18	4	5	4	5
15	18	4	5	4	5
22	29	4	5	4	5
36	47	5			

Vc m/min	Feed column no.				
	5	5	5	5	5
35	5	5		5	5
30	5	5		5	5
40	5	5		5	5
40	5	5		5	5
40	5	5		5	5
40	5	5		5	5
35	4	4			5
20	4	4			4
16	3	3			3
36	6	6	3	6	6
20	4	4			3
15	3	3	3		3
16	4	4			3
12	3	3	3		3
15	4	4			3
12	3	3	3		3
15	3	3	3		3
8	2		2		2
18	4		4	4	3
14	3			3	3
16	3		3	3	3
4					1
8				1	1
35	6	6			5
30	6	6			5
30	6	6			5
28	6	6			5
10	3	3		3	3
10				2	2
6				2	2
90				2	7
90					7
90					7
80		7			7
70		6			6
70					6
40	5*	5			5
60					5
40	5*	4			5
35	4*				4
33	4*				4
20	4*	4			4
15	4*	4			1
20	4*	4			4
30				4	4

Material chart page 17