

RECOMMENDED CUTTING CONDITIONS

	Work material	Hardness	Vc (m/min)	Inner Breaker	φ14—φ16.5		
					fr (mm/rev)		
					L/D=2, 3	4	5
P	Mild Steel (C15, Ck15)	≤180HB	200 (180—235)	UM	0.05 (0.04—0.06)	0.05 (0.04—0.06)	0.05 (0.04—0.06)
				UH	—	—	—
	Carbon Steel, Alloy Steel (Ck45, 41CrMo4)	180—280HB	140 (115—180)	UM	0.08 (0.06—0.14)	0.08 (0.06—0.09)	0.08 (0.06—0.09)
				UH	—	—	—
	Carbon Steel, Alloy Steel (100Cr6)	280—350HB	100 (75—140)	UM	0.08 (0.06—0.14)	0.08 (0.06—0.09)	0.08 (0.06—0.09)
				UH	—	—	—
	Alloy Tool Steel (X210Cr12)	≤350HB	135 (100—170)	UM	0.08 (0.06—0.14)	0.08 (0.06—0.09)	0.08 (0.06—0.09)
				UH	—	—	—
M	Austenitic Stainless Steel (X5CrNi18-10, X5CrNiMo17-12-2)	≤200HB	130 (80—180)	US	—	—	—
				UM	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.05 (0.04—0.06)
	Austenitic Stainless Steel (X2CrNiN18-9, X5CrNiMoN17-11-2)	>200HB	130 (80—180)	US	—	—	—
				UM	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.05 (0.04—0.06)
	Ferritic and Martensitic Stainless Steel (X12Cr13, X6Cr17)	≤200HB	120 (80—165)	US	—	—	—
				UM	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.05 (0.04—0.06)
	Ferritic and Martensitic Stainless Steel (X17CrNi16-2, X30Cr13)	>200HB	120 (80—165)	US	—	—	—
				UM	0.06 (0.04—0.08)	0.05 (0.04—0.06)	0.05 (0.04—0.06)
K	Gray Cast Iron (GG25, GG30)	≤350MPa	160 (130—195)	UM	0.10 (0.06—0.14)	0.08 (0.06—0.10)	0.08 (0.06—0.10)
	Ductile Cast Iron (GG40)	≤450MPa	100 (80—135)	UM	0.10 (0.06—0.14)	0.08 (0.06—0.10)	0.08 (0.06—0.10)
	Ductile Cast Iron (GGG70)	≤800HB	100 (70—125)	UM	0.08 (0.06—0.12)	0.07 (0.06—0.08)	0.07 (0.06—0.08)
N	Aluminium Alloy (A6061, A7075)	Si<5%	200 (100-350)	UN	—	—	—
	Aluminium Alloy (AC4B)	5%≤Si≤10%	150 (100-200)	UN	—	—	—
	Aluminium Alloy (ADC12, A390)	Si>10%	150 (100-200)	UN	—	—	—
H	Hardened Steel (X40CrMoV51, 55NiCrMoV6)	38 - 45HRC	50 (30-80)	UH	—	—	—

Note 1) Reduce the cutting speed by 30% when VP15TF is used as an outer insert.

Note 2) L/D=3 is the recommended maximum depth when only external coolant is used.

Note 3) Internal through coolant is a necessity when drilling stainless steel.

RECOMMENDED CUTTING CONDITIONS

Work material	Hardness	Vc (m/min)	Inner Breaker	$\phi 17-\phi 19.5$				
				fr (mm/rev)				
				L/D=2, 3	4	5	6	
P	Mild Steel (C15, Ck15)	≤180HB	200 (180-235)	UM	0.05 (0.04-0.06)	0.05 (0.04-0.06)	0.05 (0.04-0.06)	0.04 (0.04-0.05)
				UH				
	Carbon Steel, Alloy Steel (Ck45, 41CrMo4)	180-280HB	140 (115-180)	UM	0.08 (0.06-0.14)	0.08 (0.06-0.09)	0.08 (0.06-0.09)	0.05 (0.04-0.06)
				UH				
	Carbon Steel, Alloy Steel (100Cr6)	280-350HB	100 (75-140)	UM	0.08 (0.06-0.14)	0.08 (0.06-0.09)	0.08 (0.06-0.09)	0.05 (0.04-0.06)
				UH				
	Alloy Tool Steel (X210Cr12)	≤350HB	135 (100-170)	UM	0.08 (0.06-0.14)	0.08 (0.06-0.09)	0.08 (0.06-0.09)	0.05 (0.04-0.06)
				UH				
M	Austenitic Stainless Steel (X5CrNi18-10, X5CrNiMo17-12-2)	≤200HB	130 (80-180)	US	0.08 (0.06-0.12)	0.06 (0.04-0.08)	0.06 (0.04-0.08)	0.05 (0.04-0.06)
				UM	0.06 (0.04-0.08)	0.05 (0.04-0.06)	0.05 (0.04-0.06)	0.04 (0.04-0.05)
	Austenitic Stainless Steel (X2CrNiN18-9, X5CrNiMoN17-11-2)	>200HB	130 (80-180)	US	0.08 (0.06-0.12)	0.06 (0.04-0.08)	0.06 (0.04-0.08)	0.05 (0.04-0.06)
				UM	0.06 (0.04-0.08)	0.05 (0.04-0.06)	0.05 (0.04-0.06)	0.04 (0.04-0.05)
	Ferritic and Martensitic Stainless Steel (X12Cr13, X6Cr17)	≤200HB	120 (80-165)	US	0.08 (0.06-0.12)	0.06 (0.04-0.08)	0.06 (0.04-0.08)	0.05 (0.04-0.06)
				UM	0.06 (0.04-0.08)	0.05 (0.04-0.06)	0.05 (0.04-0.06)	0.04 (0.04-0.05)
	Ferritic and Martensitic Stainless Steel (X17CrNi16-2, X30Cr13)	>200HB	120 (80-165)	US	0.08 (0.06-0.12)	0.06 (0.04-0.08)	0.06 (0.04-0.08)	0.05 (0.04-0.06)
				UM	0.06 (0.04-0.08)	0.05 (0.04-0.06)	0.05 (0.04-0.06)	0.04 (0.04-0.05)
K	Gray Cast Iron (GG25, GG30)	≤350MPa	160 (130-195)	UM	0.11 (0.08-0.14)	0.09 (0.08-0.10)	0.09 (0.08-0.10)	0.05 (0.04-0.06)
	Ductile Cast Iron (GG40)	≤450MPa	100 (80-135)	UM	0.11 (0.08-0.14)	0.09 (0.08-0.10)	0.09 (0.08-0.10)	0.05 (0.04-0.06)
	Ductile Cast Iron (GGG70)	≤800HB	100 (70-125)	UM	0.11 (0.08-0.14)	0.09 (0.08-0.10)	0.09 (0.08-0.10)	0.05 (0.04-0.06)
N	Aluminium Alloy (A6061, A7075)	Si<5%	200 (100-350)	UN	0.12 (0.05-0.18)	0.12 (0.05-0.18)	0.12 (0.05-0.18)	0.08 (0.05-0.12)
	Aluminium Alloy (AC4B)	5%≤Si≤10%	150 (100-200)	UN	0.12 (0.05-0.18)	0.12 (0.05-0.18)	0.12 (0.05-0.18)	0.08 (0.05-0.12)
	Aluminium Alloy (ADC12, A390)	Si>10%	150 (100-200)	UN	0.12 (0.05-0.18)	0.12 (0.05-0.18)	0.12 (0.05-0.18)	0.08 (0.05-0.12)
H	Hardened Steel (X40CrMoV51, 55NiCrMoV6)	38 - 45HRC	50 (30-80)	UH	0.08 (0.04-0.12)	0.06 (0.04-0.09)	-	-

Note 1) Reduce the cutting speed by 30% when VP15TF is used as an outer insert.

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