

710: Solid carbide drill with internal coolant hole 12xD



Material	710	0,03937 - 0,074803	0,07874 - 0,11417	0,118110 - 019291	0,19685 - 0,35039	0,35433 - 0,46850	0,47244 - 0,64566	0,64960 - 0,78740
	[inch] sfm [feet/min]	f [inch/rev]	f [inch/rev]	f [inch/rev]	f [inch/rev]	f [inch/rev]	f [inch/rev]	f [inch/rev]
General steels <500 N/mm ² (<150 HB)	262	0.00197	0.00276	0.00394	0.00394	0.00669	0.00984	0.01181
General steels <700 N/mm ² (<205 HB)	246	0.00197	0.00276	0.00394	0.00394	0.00669	0.00984	0.01181
Tempering steel <850 N/mm ² (<25 HRC)	230	0.00118	0.00197	0.00276	0.00276	0.00591	0.00787	0.00984
Tempering steel <1000 N/mm ² (<32 HRC)	197	0.00118	0.00197	0.00276	0.00276	0.00591	0.00787	0.00984
Tempering steel <1400 N/mm ² (<44 HRC)	164	0.00079	0.00118	0.00197	0.00197	0.00394	0.00591	0.00787
Hardened steel 45-55 HRC (1400-2000 N/mm ²)								
Hardened steel 55-60 HRC (>2000 N/mm ²)								
Hardened steel 60-65 HRC								
Cast iron <180HB	230	0.00118	0.00197	0.00276	0.00276	0.00669	0.00984	0.01181
Malleable cast iron	197	0.00118	0.00197	0.00276	0.00276	0.00669	0.00984	0.01181
Cast iron with nodular graphite	197	0.00118	0.00197	0.00276	0.00276	0.00669	0.00984	0.01181
Plastics - duroplast								
Graphite								
Aluminium long-chipping								
Aluminium short-chipping	525	0.00197	0.00276	0.00394	0.00394	0.00669	0.00984	0.01181
Aluminium alloyed over >8% S	394	0.00197	0.00276	0.00394	0.00394	0.00669	0.00984	0.01181
Copper, brass, bronze, red brass	262	0.00118	0.00197	0.00276	0.00276	0.00591	0.00787	0.00984
Plastics - thermoplast								
GFK/CFK (fibreglass/carbon fibre plastics)								
Rust and acid constant steels <700 N/mm ² (<205 HB)	148	0.00118	0.00197	0.00276	0.00276	0.00591	0.00787	0.00984
Rust and acid constant steels >700 N/mm ² (>205 HB)	98	0.00079	0.00118	0.00197	0.00197	0.00394	0.00591	0.00787
Titanium								
Inconel, Hastelloy, Nimonic, Monel								
						Dia 3-5	Dia 5-8	Dia 8-12
								Dia 12-20
Recommended internal coolant pressure [PSI]:					797	507	363	290
** if oil is used as the cooling medium, we recommend increasing the pressure by an additional 10%								



