

752: Solid carbide drill with internal coolant hole 3xD
 753: Solid carbide drill with internal coolant hole 5xD



Material	752 / 753 [inch] sfm [feet/min]	0,03937 - 0,074803 f [inch/U]	0,07874 - 0,11417 f [inch/U]	0,118110 - 0,19291 f [inch/U]	0,19685 - 0,35039 f [inch/U]	0,35433 - 0,46850 f [inch/U]	0,47244 - 0,62598 f [inch/U]	0,62992 - 0,78740 f [inch/U]
General steels <500 N/mm² (<150 HB)	361	0.00236	0.00315	0.00472	0.00630	0.00827	0.01063	0.01378
General steels <700 N/mm² (<205 HB)	344	0.00236	0.00315	0.00472	0.00630	0.00827	0.01063	0.01378
General steels <850 N/mm² (<25 HRC)	328	0.00236	0.00315	0.00472	0.00630	0.00827	0.01063	0.01378
Tempering steel <850 N/mm² (<25 HRC)	262	0.00157	0.00236	0.00335	0.00433	0.00591	0.00748	0.00984
Tempering steel <1000 N/mm² (<32 HRC)	230	0.00157	0.00236	0.00335	0.00433	0.00591	0.00748	0.00984
Tempering steel <1400 N/mm² (<44 HRC)	131	0.00079	0.00118	0.00177	0.00236	0.00354	0.00512	0.00669
Hardened steel 45-55 HRC (1400-2000 N/mm²)	98	0.00079	0.00118	0.00177	0.00236	0.00354	0.00512	0.00669
Hardened steel 55-60 HRC (>2000 N/mm²)								
Hardened steel 60-65 HRC								
Cast iron <180HB	312	0.00236	0.00315	0.00472	0.00630	0.00827	0.01063	0.01378
Malleable cast iron	279	0.00236	0.00315	0.00472	0.00630	0.00827	0.01063	0.01378
Cast iron with nodular graphite	279	0.00236	0.00315	0.00472	0.00630	0.00827	0.01063	0.01378
Plastics - duroplast	131	0.00157	0.00236	0.00335	0.00433	0.00591	0.00748	0.00984
Graphite								
Aluminium long-chipping	607	0.00236	0.00315	0.00472	0.00630	0.00827	0.01063	0.01378
Aluminium short-chipping	574	0.00236	0.00315	0.00472	0.00630	0.00827	0.01063	0.01378
Aluminium alloyed over >8% S	443	0.00236	0.00315	0.00472	0.00630	0.00827	0.01063	0.01378
Copper, brass, bronze, red brass	394	0.00236	0.00315	0.00472	0.00630	0.00827	0.01063	0.01378
Plastics - thermoplast	148	0.00157	0.00236	0.00335	0.00433	0.00591	0.00748	0.00984
GFK/CFK (fibreglass/carbon fibre plastics)								
Rust and acid constant steels <700 N/mm² (<205 HB)	148	0.00157	0.00236	0.00335	0.00433	0.00591	0.00748	0.00984
Rust and acid constant steels >700 N/mm² (>205 HB)	98	0.00118	0.00177	0.00236	0.00354	0.00512	0.00669	0.00827
Titanium	131	0.00118	0.00177	0.00236	0.00354	0.00512	0.00669	0.00827
Inconel, Hastelloy, Nimonic, Monel	115	0.00118	0.00177	0.00236	0.00354	0.00512	0.00669	0.00827
					Dia 3-5	Dia 5-8	Dia 8-12	Dia 12-20
					797	507	363	290
Recommended internal coolant pressure [PSI]:								
** if oil is used as the cooling medium, we recommend increasing the pressure by an additional 10%								

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Material	752 / 753 [mm] vc [m/min]	1 - 1,9 f [mm/rev]	2 - 2,9 f [mm/rev]	3 - 4,9 f [mm/rev]	5 - 8,9 f [mm/rev]	9 - 11,9 f [mm/rev]	12 - 15,9 f [mm/rev]	16 - 20 f [mm/rev]
General steels <500 N/mm ² (<150 HB)	110	0.060	0.080	0.120	0.160	0.210	0.270	0.350
General steels <700 N/mm ² (<205 HB)	105	0.060	0.080	0.120	0.160	0.210	0.270	0.350
General steels <850 N/mm ² (<25 HRC)	100	0.060	0.080	0.120	0.160	0.210	0.270	0.350
Tempering steel <850 N/mm ² (<25 HRC)	80	0.040	0.060	0.085	0.110	0.150	0.190	0.250
Tempering steel <1000 N/mm ² (<32 HRC)	70	0.040	0.060	0.085	0.110	0.150	0.190	0.250
Tempering steel <1400 N/mm ² (<44 HRC)	40	0.020	0.030	0.045	0.060	0.090	0.130	0.170
Hardened steel 45-55 HRC (1400-2000 N/mm ²)	30	0.020	0.030	0.045	0.060	0.090	0.130	0.170
Hardened steel 55-60 HRC (>2000 N/mm ²)								
Hardened steel 60-65 HRC								
Cast iron <180HB	95	0.060	0.080	0.120	0.160	0.210	0.270	0.350
Malleable cast iron	85	0.060	0.080	0.120	0.160	0.210	0.270	0.350
Cast iron with nodular graphite	85	0.060	0.080	0.120	0.160	0.210	0.270	0.350
Plastics - duroplast	40	0.040	0.060	0.085	0.110	0.150	0.190	0.250
Graphite								
Aluminium long-chipping	185	0.060	0.080	0.120	0.160	0.210	0.270	0.350
Aluminium short-chipping	175	0.060	0.080	0.120	0.160	0.210	0.270	0.350
Aluminium alloyed over >8% S	135	0.060	0.080	0.120	0.160	0.210	0.270	0.350
Copper, brass, bronze, red brass	120	0.060	0.080	0.120	0.160	0.210	0.270	0.350
Plastics - thermoplast	45	0.040	0.060	0.085	0.110	0.150	0.190	0.250
GFK/CFK (fibreglass/carbon fibre plastics)								
Rust and acid constant steels <700 N/mm ² (<205 HB)	45	0.040	0.060	0.085	0.110	0.150	0.190	0.250
Rust and acid constant steels >700 N/mm ² (>205 HB)	30	0.030	0.045	0.060	0.090	0.130	0.170	0.210
Titanium	40	0.030	0.045	0.060	0.090	0.130	0.170	0.210
Inconel, Hastelloy, Nimonic, Monel	35	0.030	0.045	0.060	0.090	0.130	0.170	0.210
					Dia 3-5	Dia 5-8	Dia 8-12	Dia 12-20
					55	35	25	20
Recommended internal coolant pressure [bar]:								
** if oil is used as the cooling medium, we recommend increasing the pressure by an additional 10%								