

911: Solid carbide deep hole drill DEEPMAX 30xD



Material	911 [inch]	0,07870 - 0,09448		0,09840 - 0,12204		0,12600 - 0,16141		0,16540 - 0,21259		0,21650 - 0,23622		0,24020 - 0,33070		0,33464 - 0,39370		0,39764 - 0,47244
	sfm [feet/min]	f [inch/rev]	sfm [feet/min]	f [inch/rev]	sfm [feet/min]	f [inch/rev]	sfm [feet/min]	f [inch/rev]	sfm [feet/min]	f [inch/rev]	sfm [feet/min]	f [inch/rev]	sfm [feet/min]	f [inch/rev]	sfm [feet/min]	f [inch/rev]
General steels <500 N/mm² (<150 HB)	177	0.0026	177	0.0033	236	0.0047	266	0.0063	266	0.0075	295	0.0087	295	0.0110	341	0.0138
General steels <700 N/mm² (<205 HB)	167	0.0026	167	0.0033	223	0.0043	253	0.0059	253	0.0071	279	0.0083	279	0.0102	322	0.0130
Tempering steel <850 N/mm² (<25 HRC)	157	0.0024	157	0.0032	210	0.0039	236	0.0051	236	0.0059	262	0.0071	262	0.0091	302	0.0118
Tempering steel <1000 N/mm² (<32 HRC)	148	0.0024	148	0.0032	197	0.0039	223	0.0051	223	0.0059	246	0.0071	246	0.0091	282	0.0118
Tempering steel <1400 N/mm² (<44 HRC)	128	0.0020	128	0.0030	171	0.0035	194	0.0043	194	0.0055	213	0.0063	213	0.0079	246	0.0098
Hardened steel 45-55 HRC (1400-2000 N/mm²)																
Hardened steel 55-60 HRC (>2000 N/mm²)																
Hardened steel 60-65 HRC																
Cast iron <180HB	177	0.0026	177	0.0033	236	0.0047	266	0.0063	266	0.0075	295	0.0087	295	0.0110	341	0.0138
Malleable cast iron	138	0.0020	138	0.0030	184	0.0039	207	0.0051	207	0.0059	230	0.0071	230	0.0091	266	0.0118
Cast iron with nodular graphite	138	0.0020	138	0.0030	184	0.0039	207	0.0051	207	0.0059	230	0.0071	230	0.0091	266	0.0118
Plastics - duroplast																
Graphite																
Aluminium long-chipping																
Aluminium short-chipping																
Aluminium alloyed over >8% S																
Copper, brass, bronze, red brass																
Plastics - thermoplast																
GFK/CFK (fibreglass/carbon fibre plastics)																
Rust and acid constant steels <700 N/mm² (<205 HB)	98	0.0020	98	0.0022	131	0.0026	148	0.0031	148	0.0039	164	0.0047	164	0.0059	190	0.0071
Rust and acid constant steels >700 N/mm² (>205 HB)																
Titanium																
Inconel, Hastelloy, Nimonic, Monel																
								Dia 3-5	Dia 5-8	Dia 8-12	Dia 12-20					
Recommended internal coolant pressure [PSI]:								870	580	435	363					
Recommended MQL coolant pressure [PSI]:								174	145	130	116					
** if oil is used as the cooling medium, we recommend increasing the pressure by an additional 10%																



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Material	911 [mm] vc [m/min]	2 - 2,4 f [mm/rev]	vc [m/min]	2,5 - 3,1 f [mm/rev]	vc [m/min]	3,2 - 4,1 f [mm/rev]	vc [m/min]	4,2 - 5,4 f [mm/rev]	vc [m/min]	5,5 - 6 f [mm/rev]	vc [m/min]	6,1 - 8,4 f [mm/rev]	vc [m/min]	8,5 - 10 f [mm/rev]	vc [m/min]	10,1 - 12 f [mm/rev]
General steels <500 N/mm² (<150 HB)	54	0.0650	54	0.0850	72	0.1200	81	0.1600	81	0.1900	90	0.2200	90	0.2800	104	0.3500
General steels <700 N/mm² (<205 HB)	51	0.0650	51	0.0850	68	0.1100	77	0.1500	77	0.1800	85	0.2100	85	0.2600	98	0.3300
Tempering steel <850 N/mm² (<25 HRC)	48	0.0600	48	0.0820	64	0.1000	72	0.1300	72	0.1500	80	0.1800	80	0.2300	92	0.3000
Tempering steel <1000 N/mm² (<32 HRC)	45	0.0600	45	0.0820	60	0.1000	68	0.1300	68	0.1500	75	0.1800	75	0.2300	86	0.3000
Tempering steel <1400 N/mm² (<44 HRC)	39	0.0500	39	0.0750	52	0.0900	59	0.1100	59	0.1400	65	0.1600	65	0.2000	75	0.2500
Hardened steel 45-55 HRC (1400-2000 N/mm²)																
Hardened steel 55-60 HRC (>2000 N/mm²)																
Hardened steel 60-65 HRC																
Cast iron <180HB	54	0.0650	54	0.0850	72	0.1200	81	0.1600	81	0.1900	90	0.2200	90	0.2800	104	0.3500
Malleable cast iron	42	0.0500	42	0.0750	56	0.1000	63	0.1300	63	0.1500	70	0.1800	70	0.2300	81	0.3000
Cast iron with nodular graphite	42	0.0500	42	0.0750	56	0.1000	63	0.1300	63	0.1500	70	0.1800	70	0.2300	81	0.3000
Plastics - duroplast																
Graphite																
Aluminium long-chipping																
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Aluminium alloyed over >8% S																
Copper, brass, bronze, red brass																
Plastics - thermoplast																
GFK/CFK (fibreglass/carbon fibre plastics)																
Rust and acid constant steels <700 N/mm² (<205 HB)	30	0.0500	30	0.0550	40	0.0650	45	0.0800	45	0.1000	50	0.1200	50	0.1500	58	0.1800
Rust and acid constant steels >700 N/mm² (>205 HB)																
Titanium																
Inconel, Hastelloy, Nimonic, Monel																
								Dia 3-5	Dia 5-8	Dia 8-12	Dia 12-20					
Recommended internal coolant pressure [bar]:								60	40	30	25					
Recommended MQL coolant pressure [bar]:								12	10	9	8					
** if oil is used as the cooling medium, we recommend increasing the pressure by an additional 10%																

