

CHOICE OF THE MOST SUITABLE DRILL FOR EACH MATERIAL

MATÉRIEL	Drill type	Quality	Point angle	Cutting speed m/min.	Feed	Coolant
CARBON STEEL Up to 500 N/mm ²	*N	HSS	118°	20-25	D	EMULSION
	N	HSSCo	135°	25-30		
	N	TIN	118°/135°	45-50		
NON ALLOY STEEL" 0,4%. Up to 800 N/mm ²	*N	HSS	118°	15-20	D	EMULSION
	*N	HSSCo	135°	20-25		
	N	TIN	118°/135°	35-40		
NON ALLOY STEEL" 0,4%. Up to 1000 N/mm ²	N	HSS	118°	12-15	C	EMULSION
	*N	HSSCo	135°	15-20		
	*N	TIN	118°/135°	25-30		
NON ALLOY STEEL" 0,4%. Up to 1200 N/mm ²	N	HSS	118°	10-12	C	EMULSION
	*N	HSSCo	135°	15-17		
	*N	TIN	118°/135°	20-25		
STEEL FOR MANUFACTURING TOOLS	--	--	--	--	B	EMULSION
	*N	HSSCo	135°	10-12		
	*N	TIN	118°/135°	18-20		
HEAT TREATED STEEL over 1200 N/mm ²	--	--	--	--	A	EMULSION (Oil)
	*N	HSSCo	135°	4-5		
	*N	TIN	118°/235°	8-10		
MARTHENSITHYC STAINLESS STEEL	--	--	--	--	A	EMULSION (Oil)
	*W/INOX	HSSCo	135°	8-10		
	W/INOX	TIN	135°	18-20		
AUSTENITHYC STAINLESS STEEL	--	--	--	--	A	OIL
	*N	HSSCo	135°	8-10		
	*N	TIN	118°/135°	15-20		
MANGANESEIUM STEEL > 10% Mn	--	--	--	--	A	DRY
	*N	HSSCo	135°	3		
	*N	TIN	118°/135°	5-6		
SPRING STEEL	--	--	--	--	A	DRY
	*N	HSSCo	135°	5		
	*N	TIN	118°/135°	8-10		
HASTELLOY	--	--	--	--	A	OIL
	*N	HSSCo	135°	4		
	*N	TIN	118°/135°	6-8		
FERRO TIC	--	--	--	--	A	DRY (Air)
	*N	HSSCo	135°	3		
	*N	TIN	118°/135°	5-6		
TITANIUM AND TITANIUM ALLOYS	--	--	--	--	A	OIL
	*N	HSSCo	135°	5		
	*N	TIN	118°/135°	8-10		
DIE CAST MALLEABLE CAST	*N	HSS	118°	20-25	E	DRY (Emulsion)
	*N	HSSCo	135°	30-35		
	N	TIN	118°/135°	40-50		
HARD CAST (MALLEABLE)	--	--	--	--	D	DRY (Emulsion)
	*N	HSSCo	135°	8-10		
	*N	TIN	118°/135°	15-16		
BRASS	*H	HSS	118°	50-60	F	DRY (Oil)
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	H	TIN	118°	90-100		
THOUGH BRASS	*H/N	HSS	118°	40-50	E	EMULSION
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	H/N	TIN	118°	80-85		
SIDERURGYC COPPER	*W	HSS	118°	25-30	E	EMULSION
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	W	TIN	118°	50-60		

* Type de foret de coupe recommandé suivant les matériaux

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ELECTROLITHYC COPPER	--	--	--	--	E	EMULSION (Oil)
	N	HSSCo	135°	20-25		
ARGETON	N	TIN	118°/135°	45-50	C	OIL (Emulsion)
	N/H	HSS	118°	18/20		
	N/H	HSSCo	135°	22-25		
Cu-N ALLOY Cu-Sn ALLOY	--	--	--	--	C	OIL (Emulsion)
	N	HSSCo	135°	22-25		
	N	TIN	118°/135°	35-40		
Cu-Al ALLOY	--	--	--	--	C	OIL (Emulsion)
	N/INOX	HSSCo	135°	10-13		
Cu-Be ALLOY	N/INOX	TIN	118°/135°	20-25	B	OIL (Emulsion)
	N/H	HSS	118°	8-10		
	N/H	HSSCo	135°	12-13		
Cu-Mn ALLOY Cu-Si ALLOY	N/H	TIN	118°/135°	18-20	C	OIL (Emulsion)
	N	HSS	118°	20-25		
	N	HSSCo	135°	30-35		
PURE ALUMINIUM	--	--	--	--	E	EMULSION
	W/	HSS	135°	40-50		
	W/INOX	HSSCo	135°	50-55		
Al-Mn ALLOY Al-Cr ALLOY	--	--	--	--	E	EMULSION
	W/	HSS	135°	40-50		
	W/INOX	HSSCo	135°	50-55		
Al-Pb ALLOY Sb Sn	--	--	--	--	E	EMULSION
	W/	HSS	135°	70-80		
	W/INOX	HSSCo	135°	90-100		
Al-Cu-Si-Mg-Pb-Sn-Ti-BeALLOY	--	--	--	--	E	EMULSION
	W/	HSS	135°	40-45		
	W/INOX	HSSCo	135°	50-55		
Al-Si-Mg-Mn-Cu-Cr ALLOY	--	--	--	--	E	EMULSION
	W/	HSS	135°	40-45		
	W/INOX	HSSCo	135°	50-55		
Al-Si-Mg-Mn-Cr ALLOY	W/	TIN	135°	75-80	E	EMULSION
	W/	HSS	135°	70-80		
	W/INOX	HSSCo	135°	90-100		
* Mg ALLOY	--	--	--	--	E	DRY (Without water)
	W/N	HSS	118°/135°	70-80		
	W/N	HSSCo	135°	90-100		
ZINC, ZAMAC	--	--	--	--	D	EMULSION
	N	HSS	118°	30-35		
	N	HSSCo	135°	40-45		
HARD PLASTIC	N	TIN	118°/135°	60-65	C	DRY (Air)
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	H	HSSCo	90°	10-15		
THERMOPLASTIC	H	TIN	118°/90°	20-25	C	DRY (Air)
	W	HSS	130°	20-25		
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PAPER	W	TIN	130°	45-50	C	DRY (Air)
	H	HSS	118°/90°	15-20		
	W	HSSCo	135°	20-25		
GOME	H	TIN	118°/135°	35-40	F	DRY (Air)
	H	HSS	90°	10-12		
	H	HSSCo	90°	18-20		
	H	TIN	90°	25-30		

* Recommended drill for each material

W= Depth holes N= Short holes