

Description Code Key

Modular Head

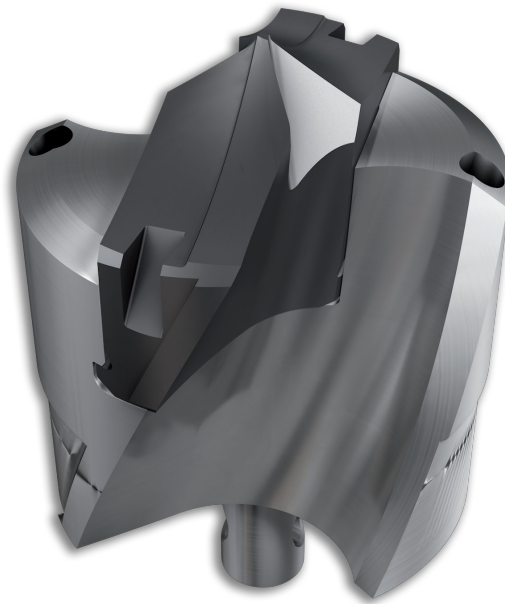
MD-DFN ### HEAD

Modular head size

Drilling Head

HFP ### - IQ IC908

Drilling head size



MD-DFN Cutting Parameters

ISO	Material	Condition	Tensile Strength Rm [N/mm ²]	Hardness HB	Material No.	V _c [m/min]	Feed Vs. Drill Diameter	
							33<ØD<40 (mm)	
							f [mm/rev]	
P	Non-alloy steel and cast steel, free cutting steel	< 0.25 %C	Annealed	420	125	1	80-110-140	0.30 0.40 0.50
		≥ 0.25 %C	Annealed	650	190	2	90-105-130	
		< 0.55 %C	Quenched and tempered	850	250	3	80-100-120	
		≥ 0.55 %C	Annealed	750	220	4	70-90-110	
			Quenched and tempered	1000	300	5	50-70-90	
	Low alloy and cast steel (less than 5% of alloying elements)	Annealed	600	200	6	80-100-120	0.30 0.40 0.50	
		Quenched and tempered	930	275	7	70-90-110		
			1000	300	8	50-70-90		
			1200	350	9	40-55-70		
	High alloyed steel, cast steel and tool steel	Annealed	680	200	10	50-70-90	0.25 0.30 0.35	
		Quenched and tempered	1100	325	11	40-60-80		
K	Grey cast iron (GG)	Ferritic / pearlitic		180	15	90-125-160	0.40 0.50 0.60	
		Pearlitic / martensitic		260	16	80-110-140		
	Nodular cast iron (GGG)	Ferritic		160	17	90-135-180		
		Pearlitic		250	18	80-110-140		
	Malleable cast iron	Ferritic		130	19	90-125-160		
		Pearlitic		230	20	80-110-140		

*Reduce speed by 50% when using the MD-Extension

*The MD-Extension is recommended for machining ISO K materials **only**