

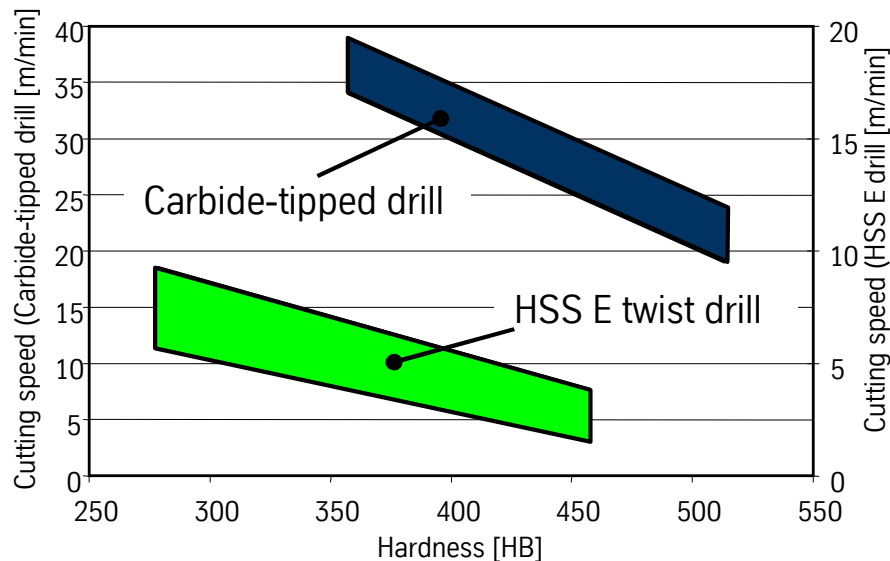
Machining of XAR[®] - steels

Guide values for drilling

Steel grade	Cutting speed [m/min.]	6 mm Ø		8 mm Ø		10 mm Ø		12 mm Ø	
		Rpm	Feed	Rpm	Feed	Rpm	Feed	Rpm	Feed
XAR [®] 300	6 - 8	360	0.08	280	0.10	225	0.15	190	0.20
XAR [®] 400/450	3 - 5	210	0.05	160	0.08	130	0.10	100	0.15
XAR [®] 500 ¹⁾	20 - 25	1300	0.05	1000	0.05	800	0.08	670	0.08
XAR [®] 600 ¹⁾	upon request								

¹⁾ Carbide-tipped drills

Cutting speed



Conditions for drilling

- Avoid vibrations
- Firm clamping of the work piece as close to the point of drilling as possible
- Positioning of the work piece and the drilling head as close to the machine column as possible
- Use of short drills in a short machine spindle
- Heavy duty special cutting oil is recommended as a coolant
- Usage of countersinking and -boring cutters with additional tip guidance to avoid any lateral movement of the tool in the case of countersinking work