



Overview PCD Drills 6C Tools AG

Status: August 2019

		L/D:2	Code -1201	L/D:3	Code -1301	L/D:4	Code -1401	L/D:5	Code -1501	
Item	D	L	Code	L	Code	L	Code	L	Code	Cooling
TD-P-xxxx-030-xxx	0.3	0.6	-006	0.9	-009					•
TD-P-xxxx-040-xxx	0.4	0.8	-008	1.2	-012					•
TD-P-xxxx-050-xxx	0.5	1.0	-010	1.5	-015					•
TD-P-xxxx-060-xxx	0.6	1.2	-012	1.8	-018	2.4	-024			•
TD-P-xxxx-070-xxx	0.7	1.4	-014	2.1	-021	2.8	-028			•
TD-P-xxxx-080-xxx	0.8	1.6	-016	2.4	-024	3.2	-032	4.0	-040	•
TD-P-xxxx-090-xxx	0.9	1.8	-018	2.7	-027	3.6	-036	4.5	-045	•
TD-P-xxxx-100-xxx	1.0	2.0	-020	3.0	-030	4.0	-040	5.0	-050	•
TD-P-xxxx-110-xxx	1.1	2.2	-022	3.3	-033	4.4	-044	5.5	-055	•
TD-P-xxxx-120-xxx	1.2	2.4	-024	3.6	-036	4.8	-048	6.0	-060	•
TD-P-xxxx-130-xxx	1.3	2.6	-026	3.9	-039	5.2	-052	6.5	-065	•
TD-P-xxxx-140-xxx	1.4	2.8	-028	4.2	-042	5.6	-056	7.0	-070	-
TD-P-xxxx-150-xxx	1.5	3.0	-030	4.5	-045	6.0	-060	7.5	-075	-
TD-P-xxxx-160-xxx	1.6	3.2	-032	4.8	-048	6.4	-064	8.0	-080	-
TD-P-xxxx-170-xxx	1.7	3.4	-034	5.1	-051	6.8	-068			-
TD-P-xxxx-180-xxx	1.8	3.6	-036	5.4	-054	7.2	-072			-
TD-P-xxxx-190-xxx	1.9	3.8	-038	5.7	-057	7.6	-076			-
TD-P-xxxx-200-xxx	2.0	4.0	-040	6.0	-060					-
TD-P-xxxx-210-xxx	2.1	4.2	-042	6.3	-063					-
TD-P-xxxx-220-xxx	2.2	4.4	-044	6.6	-066					-
TD-P-xxxx-230-xxx	2.3	4.6	-046	6.9	-069					-
TD-P-xxxx-240-xxx	2.4	4.8	-048	7.2	-072					-
TD-P-xxxx-250-xxx	2.5	5.0	-050							-
TD-P-xxxx-260-xxx	2.6	5.2	-052							-
TD-P-xxxx-270-xxx	2.7	5.4	-054							-
TD-P-xxxx-280-xxx	2.8	5.6	-056							-
TD-P-xxxx-290-xxx	2.9	5.8	-058							-
TD-P-xxxx-300-xxx	3.0	6.0	-060							-

Example: Drill D=1.6mm, L/D=4 -> L=6.4mm → TD-P-1401-160-064

Parameter:

Material	V_c [m/min]	V_f [mm/min]	Cooling
Ceramic	25-35	3-5	Water
Tungsten Carbide	20-30	5-7	Air

