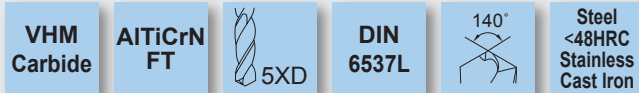
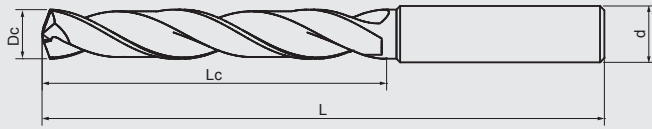


D432FT / D436FT

High Performance Drills / Oil-Feed High Performance Drills

140° S-type drill point design with centring and positioning function, reduce axial drilling force.
Designed with high chip evacuating flutes.
Good wear resistance and lubricating effect with Nano multilayer coating.
D436FT Oil-feed design for internal coolant supply.



Application for drilling steels below 48HRC, cast iron...and etc.
Suitable for drilling with 5XD depth.



DIN 6537L Standard Length

Dc m7	Lc mm	L mm	d h6	D432FT AlTiCrN	D436FT AlTiCrN
3	28	66	6	●	●
3.1	28	66	6	●	●
3.2	28	66	6	●	●
3.3	28	66	6	●	●
3.4	28	66	6	●	●
3.5	28	66	6	●	●
3.6	28	66	6	●	●
3.7	28	66	6	●	●
3.8	36	74	6	●	●
3.9	36	74	6	●	●
4	36	74	6	●	●
4.1	36	74	6	●	●
4.2	36	74	6	●	●
4.3	36	74	6	●	●
4.4	36	74	6	●	●
4.5	36	74	6	●	●
4.6	36	74	6	●	●
4.7	36	74	6	●	●
4.8	44	82	6	●	●
4.9	44	82	6	●	●
5	44	82	6	●	●
5.1	44	82	6	●	●
5.2	44	82	6	●	●
5.3	44	82	6	●	●
5.4	44	82	6	●	●
5.5	44	82	6	●	●
5.6	44	82	6	●	●
5.7	44	82	6	●	●
5.8	44	82	6	●	●
5.9	44	82	6	●	●
6	44	82	6	●	●
6.1	53	91	8	●	●
6.2	53	91	8	●	●
6.3	53	91	8	●	●
6.4	53	91	8	●	●
6.5	53	91	8	●	●
6.6	53	91	8	●	●
6.7	53	91	8	●	●



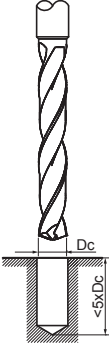
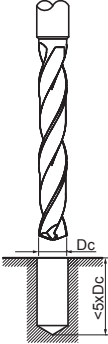
D432FT / D436FT

High Performance Drills / Oil-Feed High Performance Drills

Dc m7	Lc mm	L mm	d h6	D432FT AlTiCrN	D436FT AlTiCrN	
6.8	53	91	8	●	●	
6.9	53	91	8	●	●	
7	53	91	8	●	●	
7.1	53	91	8	●	●	
7.2	53	91	8	●	●	
7.3	53	91	8	●	●	
7.4	53	91	8	●	●	
7.5	53	91	8	●	●	
7.6	53	91	8	●	●	
7.7	53	91	8	●	●	
7.8	53	91	8	●	●	
7.9	53	91	8	●	●	
8	53	91	8	●	●	
8.1	61	103	10	●	●	
8.2	61	103	10	●	●	
8.3	61	103	10	●	●	
8.4	61	103	10	●	●	
8.5	61	103	10	●	●	
8.6	61	103	10	●	●	
8.7	61	103	10	●	●	
8.8	61	103	10	●	●	
8.9	61	103	10	●	●	
9	61	103	10	●	●	
9.1	61	103	10	●	●	
9.2	61	103	10	●	●	
9.3	61	103	10	●	●	
9.4	61	103	10	●	●	
9.5	61	103	10	●	●	
9.6	61	103	10	●	●	
9.7	61	103	10	●	●	
9.8	61	103	10	●	●	
9.9	61	103	10	●	●	
10	61	103	10	●	●	
10.1	71	118	12	●	●	
10.2	71	118	12	●	●	
10.5	71	118	12	●	●	
10.8	71	118	12	●	●	
11	71	118	12	●	●	
11.5	71	118	12	●	●	
12	71	118	12	●	●	
12.5	77	124	14	●	●	
13	77	124	14	●	●	
13.5	77	124	14	●	●	
14	77	124	14	●	●	
14.5	83	133	16	●	●	
15	83	133	16	●	●	
15.5	83	133	16	●	●	
16	83	133	16	●	●	
16.5	93	143	18	●	●	
17	93	143	18	●	●	
17.5	93	143	18	●	●	
18	93	143	18	●	●	
18.5	101	153	20	●	●	
19	101	153	20	●	●	
19.5	101	153	20	●	●	
20	101	153	20	●	●	

Please refer to page 301 for parameters.

Cutting Conditions

Cutting Conditions										
	D431FT		D435FT		D432FT		D436FT			
										
	cutting speed Vc (m/min)	feed per tooth fz (mm)	cutting speed Vc (m/min)	feed per tooth fz (mm)	cutting speed Vc (m/min)	feed per tooth fz (mm)	cutting speed Vc (m/min)	feed per tooth fz (mm)	cutting speed Vc (m/min)	feed per tooth fz (mm)
Carbon Steel Materials										
P	GR1 Carbon Steel	80	0.023xDc	100	0.023xDc	70	0.023xDc	100	0.023xDc	
	GR2 <24HRC Low-alloyed Steel	80	0.023xDc	100	0.023xDc	70	0.023xDc	100	0.023xDc	
	GR3 <30HRC Hi-alloyed Steel	70	0.021xDc	90	0.021xDc	60	0.021xDc	90	0.021xDc	
Hardened Steel Materials										
H	GR4 30-38HRC Hardened Steel	50	0.020xDc	50	0.020xDc	40	0.020xDc	50	0.020xDc	
	GR5 38-48HRC Hardened Steel	40	0.015xDc	40	0.015xDc	30	0.015xDc	40	0.015xDc	
Stainless Steel Materials										
M	GR8-1 Ferritic \ Martensitic			50	0.013xDc			50	0.013xDc	
	GR8-2 Austenitic			50	0.013xDc			50	0.013xDc	
	GR8-3 Austenitic-ferritic			50	0.013xDc			50	0.013xDc	
	GR8-4 Austenitic-ferritic Heat-resistant			40	0.012xDc			40	0.012xDc	
Cast Iron Materials										
K	GR9-1 Grey cast iron	80	0.023xDc	100	0.023xDc	70	0.023xDc	100	0.023xDc	
	GR9-2 Nodular cast iron	80	0.023xDc	100	0.023xDc	70	0.023xDc	100	0.023xDc	

All cutting data serve for orientation only and should be adapted individually to the technical conditions on location

1. Please work with good rigidity / high precision facilities and collet chuck.
2. Please choose proper cutting fluid.
3. The cutting data is reference value only. Please adjust it according to your real working conditions.
4. If RPM is lower the reference value, the Feed rate (fz) and RPM should be reduced by the same proportion.
5. If vibration occurs during cutting, please reduce cutting parameter.