

DURONTO Drills: 3xd

Without internal cooling

With internal cooling

| Material | Tensile strength | Hardness | Diameter | Vc (m/min) | | | f (mm/min) | Vc (m/min) | | | f (mm/min) |
|------------------------|------------------|----------|-----------|------------|-------|-----|------------|------------|-------|-----|------------|
| | | | | Min | Ideal | Max | | Min | Ideal | Max | |
| Steels Stähle | > 400 ≤ 750 | ≤ 20 | 3.00-5.60 | 60 | 70 | 100 | 0.18 | 90 | 100 | 130 | 0.18 |
| | | | 5.70-8.30 | 60 | 70 | 100 | 0.24 | 90 | 100 | 130 | 0.24 |
| | | | 8.40-11.5 | 60 | 70 | 100 | 0.30 | 90 | 100 | 130 | 0.30 |
| | | | 12.0-16.0 | 60 | 70 | 100 | 0.35 | 90 | 100 | 130 | 0.35 |
| | | | 16.5-20.0 | 60 | 70 | 100 | 0.37 | 90 | 100 | 130 | 0.37 |
| Steels Stähle | > 750 ≤ 900 | ≤ 28 | 3.00-5.60 | 55 | 65 | 80 | 0.15 | 70 | 80 | 95 | 0.15 |
| | | | 5.70-8.30 | 55 | 65 | 80 | 0.21 | 70 | 80 | 95 | 0.21 |
| | | | 8.40-11.5 | 55 | 65 | 80 | 0.27 | 70 | 80 | 95 | 0.27 |
| | | | 12.0-16.0 | 55 | 65 | 80 | 0.32 | 70 | 80 | 95 | 0.32 |
| | | | 16.5-20.0 | 55 | 65 | 80 | 0.35 | 70 | 80 | 95 | 0.35 |
| Steels Stähle | > 900 ≤ 1100 | ≤ 38 | 3.00-5.60 | 40 | 50 | 60 | 0.15 | 50 | 60 | 70 | 0.15 |
| | | | 5.70-8.30 | 40 | 50 | 60 | 0.20 | 50 | 60 | 70 | 0.20 |
| | | | 8.40-11.5 | 40 | 50 | 60 | 0.26 | 50 | 60 | 70 | 0.26 |
| | | | 12.0-16.0 | 40 | 50 | 60 | 0.31 | 50 | 60 | 70 | 0.31 |
| | | | 16.5-20.0 | 40 | 50 | 60 | 0.34 | 50 | 60 | 70 | 0.34 |
| Steels Stähle | ≤ 1400 | ≤ 45 | 3.00-5.60 | 25 | 35 | 40 | 0.08 | 25 | 35 | 40 | 0.08 |
| | | | 5.70-8.30 | 25 | 35 | 40 | 0.12 | 25 | 35 | 40 | 0.12 |
| | | | 8.40-11.5 | 25 | 35 | 40 | 0.15 | 25 | 35 | 40 | 0.15 |
| | | | 12.0-16.0 | 25 | 35 | 40 | 0.20 | 25 | 35 | 40 | 0.20 |
| | | | 16.5-20.0 | 25 | 35 | 40 | 0.22 | 25 | 35 | 40 | 0.22 |
| Cast Irons Gußeisen | 240 HB | | 3.00-5.60 | 60 | 70 | 120 | 0.23 | 60 | 70 | 120 | 0.23 |
| | | | 5.70-8.30 | 60 | 70 | 120 | 0.33 | 60 | 70 | 120 | 0.33 |
| | | | 8.40-11.5 | 60 | 70 | 120 | 0.42 | 60 | 70 | 120 | 0.42 |
| | | | 12.0-16.0 | 60 | 70 | 120 | 0.52 | 60 | 70 | 120 | 0.52 |
| | | | 16.5-20.0 | 60 | 70 | 120 | 0.55 | 60 | 70 | 120 | 0.55 |
| Steels Stähle | > 1400 ≤ 1600 | 42-48 | 3.00-8.00 | 35 | 35 | 35 | 0.06-0.15 | | | | |
| | | | 8.1-14.0 | 35 | 35 | 35 | 0.16-0.23 | | | | |
| | | | 14.1-20.0 | 35 | 35 | 35 | 0.23-0.31 | | | | |
| Steels Stähle | > 1600 ≤ 1800 | 48-52 | 3.00-8.00 | 30 | 30 | 30 | 0.05-0.13 | | | | |
| | | | 8.1-14.0 | 30 | 30 | 30 | 0.13-0.19 | | | | |
| | | | 14.1-20.0 | 30 | 30 | 30 | 0.19-0.26 | | | | |
| Steels Stähle | > 1800 ≤ 2000 | 52-56 | 3.00-8.00 | 20 | 20 | 20 | 0.04-0.08 | | | | |
| | | | 8.1-14.0 | 20 | 20 | 20 | 0.09-0.12 | | | | |
| | | | 14.1-20.0 | 20 | 20 | 20 | 0.12-0.16 | | | | |
| Steels Stähle | > 2000 | 56-60 | 3.00-8.00 | 15 | 15 | 15 | 0.02-0.05 | | | | |
| | | | 8.1-14.0 | 15 | 15 | 15 | 0.05-0.07 | | | | |
| | | | 14.1-20.0 | 15 | 15 | 15 | 0.07-0.09 | | | | |

Duronto drills 8xd with internal cooling

| Material | Tensile Strength | Hardness | Diameter | Vc (m/min) | | | f (mm/min) |
|------------------------|------------------|----------|-----------|------------|-------|-----|---------------|
| | | | | Min | Ideal | Max | |
| Steels Stähle | > 400 ≤ 750 | ≤ 20 | 3.00-5.60 | 80 | 90 | 100 | 0.14 |
| | | | 5.70-8.30 | 80 | 90 | 100 | 0.20 |
| | | | 8.40-11.5 | 80 | 90 | 100 | 0.30 |
| | | | 12.0-16.0 | 80 | 90 | 100 | 0.35 |
| | | | 16.5-20.0 | 80 | 90 | 100 | 0.37 |
| Steels Stähle | > 750 ≤ 900 | ≤ 28 | 3.00-5.60 | 70 | 80 | 90 | 0.12 |
| | | | 5.70-8.30 | 70 | 80 | 90 | 0.20 |
| | | | 8.40-11.5 | 70 | 80 | 90 | 0.27 |
| | | | 12.0-16.0 | 70 | 80 | 90 | 0.32 |
| | | | 16.5-20.0 | 70 | 80 | 90 | 0.35 |
| Steels Stähle | > 900 ≤ 1100 | ≤ 38 | 3.00-5.60 | 40 | 50 | 60 | 0.10 |
| | | | 5.70-8.30 | 40 | 50 | 60 | 0.15 |
| | | | 8.40-11.5 | 40 | 50 | 60 | 0.26 |
| | | | 12.0-16.0 | 40 | 50 | 60 | 0.31 |
| | | | 16.5-20.0 | 40 | 50 | 60 | 0.34 |
| Steels Stähle | ≤ 1400 | ≤ 45 | 3.00-5.60 | 30 | 35 | 40 | 0.10 |
| | | | 5.70-8.30 | 30 | 35 | 40 | 0.15 |
| | | | 8.40-11.5 | 30 | 35 | 40 | 0.15 |
| | | | 12.0-16.0 | 30 | 35 | 40 | 0.20 |
| | | | 16.5-20.0 | 30 | 35 | 40 | 0.22 |
| Cast Irons Gußeisen | 240 HB | | 3.00-5.60 | 60 | 70 | 80 | 0.18 |
| | | | 5.70-8.30 | 60 | 70 | 80 | 0.25 |
| | | | 8.40-11.5 | 60 | 70 | 80 | 0.36 |
| | | | 12.0-16.0 | 60 | 70 | 80 | 0.38 |
| | | | 16.5-20.0 | 60 | 70 | 80 | 0.38 |