

HOLE-MAKING

**MEDITAN**

High Performance  
Drilling



General  
Engineering



Mold & Die



Automotive



Defence



Rail  
Systems



Medical

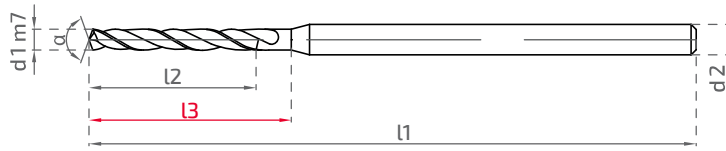
## New Crazy and Wild Member of Karcan Hole Making Series

Karcan Proudly Presents...  
Meditan By D-Tech Hole Making Technologies

new  
*product*

Extreme Cutting Speeds and Long Lasting Tool Life.

As Well As General Steels, Stainless Steels and Cast Irons, Meditan Offers Extremely High Performance In A Large Scale Of The Most Challenging Workpiece Materials To Machine Are Heat Resistant Superalloys (HRSA's) and Titanium Alloys. Classified As ISO-S Materials or Simply S-Materials.



| Stock | Order No     | Code                                                | d1m7 | d2h6 | L1 | L2   | L3   |
|-------|--------------|-----------------------------------------------------|------|------|----|------|------|
|       | <b>50100</b> | MED.2.0130.0600.A0140.0100.0130.0135.00.S03C1B04.01 | 1,3  | 3    | 60 | 10   | 13,5 |
|       | <b>50102</b> | MED.2.0150.0600.A0140.0160.0150.0185.00.S03C1B04.01 | 1,5  | 3    | 60 | 16   | 18,5 |
|       | <b>50104</b> | MED.2.0165.0600.A0140.0125.0165.0160.00.S03C1B04.01 | 1,65 | 3    | 60 | 12,5 | 16   |
|       | <b>50106</b> | MED.2.0165.0600.A0140.0190.0165.0220.00.S03C1B04.01 | 1,65 | 3    | 60 | 19   | 22   |
|       | <b>50108</b> | MED.2.0205.0600.A0140.0165.0205.0200.00.S03C1B04.01 | 2,05 | 3    | 60 | 16,5 | 20   |
|       | <b>50110</b> | MED.2.0205.0600.A0140.0220.0205.0260.00.S03C1B04.01 | 2,05 | 3    | 60 | 22   | 26   |
|       | <b>50112</b> | MED.2.0245.0600.A0140.0195.0245.0235.00.S03C1B04.01 | 2,45 | 3    | 60 | 19,5 | 23,5 |
|       | <b>50114</b> | MED.2.0245.0600.A0140.0280.0245.0310.00.S03C1B04.01 | 2,45 | 3    | 60 | 28   | 31   |

| Cutting Parameters Vc(m/min) |        |   |
|------------------------------|--------|---|
| Unalloyed Steel              | 80-180 | ● |
| Steel                        | 75-160 | ● |
| Tempered Steel               | 75-150 | ○ |
| Cold Work Tool Steel         | 60-120 | ○ |
| Hot Work Tool Steel          | 60-120 | ○ |
| AISI 304 - 416 - 420         | 40-80  | ● |
| AISI 316 - 440               | 40-80  | ● |
| 17-4 PH 15-5 PH              | 35-65  | ● |
| Cobalt-Chrome alloys         | 30-50  | ● |
| Duplex F51                   | 30-50  | ● |
| Gray Cast                    | 90-150 | ● |
| Alloyed Cast                 | 90-130 | ● |
| Precision Cast               | 90-120 | ● |
| Grafit                       | 95-110 | ○ |
| Titanium                     | 40-70  | ● |
| Titanium Alloys              | 40-70  | ● |

| Feed Per Revolution (mm/rev) |        |
|------------------------------|--------|
| Ø                            | mm/dev |
| 1,3-1,5                      | 0,022  |
| 1,5-1,7                      | 0,029  |
| 1,7-2,1                      | 0,039  |
| 2,1-2,45                     | 0,052  |
| 2,45-3                       | 0,068  |
| 17-20                        | 0,220  |



α  
140°



+TiAlN

FORM  
HA DIN  
6535

