

# ZKDR

MATERIAL	ISO	CARBIDE SFM
Stainless Steels - Free Machining	<b>M</b>	80-125
Stainless Steels - Others	<b>M</b>	50-75
Inconels/Monels	<b>S</b>	50-75
Titaniums (6Al4V)	<b>S</b>	60-90
Steels Annealed	<b>P</b>	50-80
Steels HRc 18-24	<b>P</b>	40-60
Steels HRc 25-37	<b>P</b>	35-55
Mild Steels	<b>P</b>	80-170
Cast Iron	<b>K</b>	125-225
Malleable Iron	<b>K</b>	90-150
Aluminums Alloys	<b>N</b>	300-500
Brass (Bronze)	<b>N</b>	150-250
Magnesium	<b>N</b>	250-400
Plastics	<b>N</b>	250-400



► Multiple flute countersinks are designed for increased feed rates. A controlled feed rate will result in better surface finish.

► All ZENIT countersinks are manufactured on CNC grinders to ensure consistent and accurate flute spacing. Carbide countersinks should be used in rigid tool holders to maximize tool life.