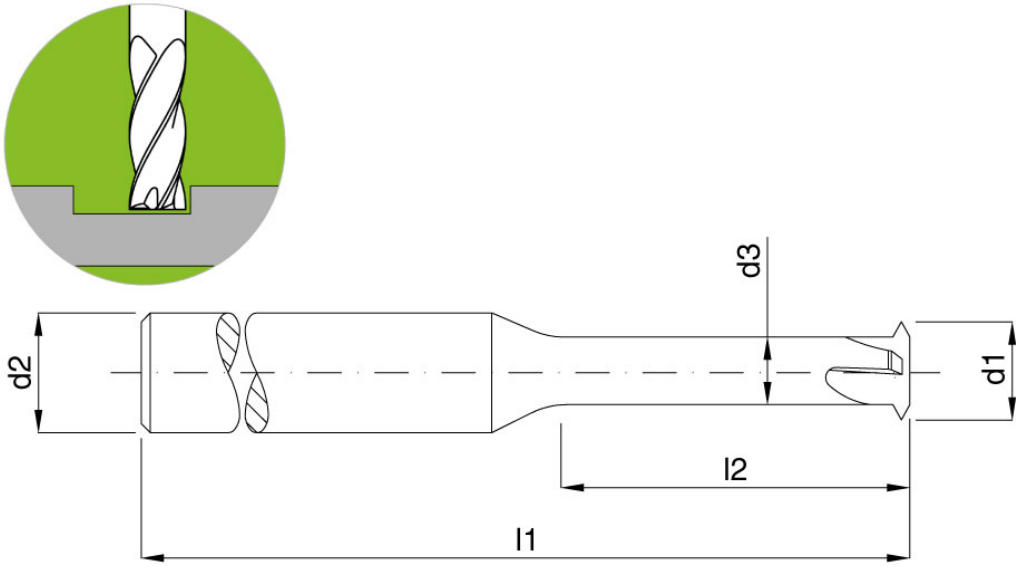

FF1C090225

Type: Thread whirl cutter

M	P	d1	d2	d3	l1	l2
0,90	225	0,65	3,00	0,33	39,00	2,50

Coolant holes	Cut	Cutting edges Z
No	Right	3

Coated	Coating type	Material	Material type	Norm
Yes	ALCRONOS	MD	SMG 10	DIN14-DIN13

Machinable Materials				
Cod.	Material type	Machinability	Cutting speed Vc	Advancement per revolution fn
		Recommended Part. recommended Not recommended	(m/min)	(mm/rev)
P01	Unalloyed steels up to 800 N/mm2		80 : 110	0.004 - 0.009
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		80 : 110	0.004 - 0.009
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		60 : 90	0.004 - 0.009
M01	Ferritic stainless steels		40 : 60	0.003 - 0.008
M02	Martensitic stainless steels		40 : 60	0.003 - 0.008
M03	Martensitic stainless steels - PH		40 : 60	0.003 - 0.008
M04	Austenitic stainless steels		-	-
K01	Gray/lamellar cast iron		90 : 120	0.004 - 0.009
K02	Nodular/nodular cast iron		90 : 120	0.004 - 0.009
N01	Drawn aluminum alloys		220 : 280	0.004 - 0.009
N02	Die-cast aluminum alloys		220 : 280	0.004 - 0.009
N03	Copper		200 : 250	0.004 - 0.009
N04	Brass - Bronze		200 : 250	0.004 - 0.009
N05	Lead-free brass		200 : 250	0.004 - 0.009
S01	Super alloys (Inconel - Hastelloy - Nimonic)		30 : 50	0.003 - 0.008
S02	Pure titanium (Grade 2 - Grade 4)		15 : 35	0.003 - 0.008
S03	Titanium alloys (Grade 5)		30 : 50	0.003 - 0.008
S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		20 : 40	0.003 - 0.008

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S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		20 : 40	0.003 - 0.008
H02	Hardened steels from 55 HRC		-	-