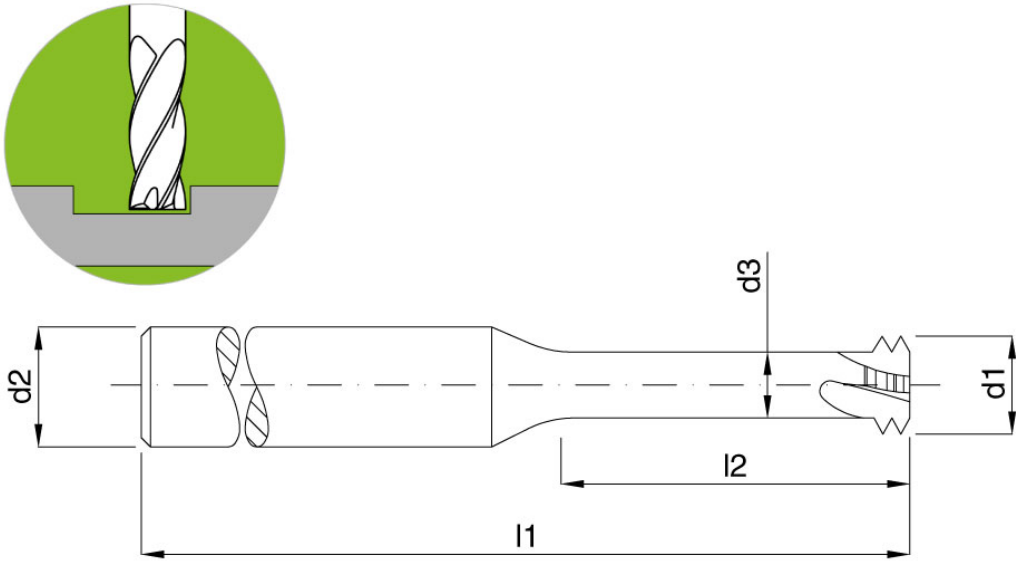

FF2C500800

Type: Thread whirl cutter

M	P	d1	d2	d3	l1	l2
5.0	0.8	4,09	5,00	2,97	51,00	13,30

Coolant holes	Cut	Cutting edges Z
No	Right	4

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	0.050 - 0.100
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2	🟢	80 : 110	0.050 - 0.100
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2	🟢	60 : 90	0.050 - 0.100
M01	Ferritic stainless steels	🟢	40 : 60	0.030 - 0.05
M02	Martensitic stainless steels	🟢	40 : 60	0.030 - 0.05
M03	Martensitic stainless steels - PH	🟢	40 : 60	0.030 - 0.05
M04	Austenitic stainless steels	🔴	-	-
K01	Gray/lamellar cast iron	🟢	90 : 120	0.050 - 0.100
K02	Nodular/nodular cast iron	🟢	90 : 120	0.050 - 0.100
N01	Drawn aluminum alloys	🟢	220 : 280	0.050 - 0.100
N02	Die-cast aluminum alloys	🟢	220 : 280	0.050 - 0.100
N03	Copper	🟢	200 : 250	0.050 - 0.100
N04	Brass - Bronze	🟢	200 : 250	0.050 - 0.100
N05	Lead-free brass	🟢	200 : 250	0.050 - 0.100
S01	Super alloys (Inconel - Hastelloy - Nimonic)	🟢	30 : 50	0.02 - 0.04
S02	Pure titanium (Grade 2 - Grade 4)	🟢	15 : 35	0.02 - 0.04
S03	Titanium alloys (Grade 5)	🟢	30 : 50	0.02 - 0.04
S04	Cobalt Chrome Alloys	🔴	-	-
H01	Hardened steels up to 55 HRC	🟢	20 : 40	0.015 - 0.03

Machinable Materials				
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		Recommended Part. recommended Not recommended	(m/min)	(mm/rev)
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S01	Super alloys (Inconel - Hastelloy - Nimonic)		30 : 50	0.02 - 0.04
S02	Pure titanium (Grade 2 - Grade 4)		15 : 35	0.02 - 0.04
S03	Titanium alloys (Grade 5)		30 : 50	0.02 - 0.04
S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		20 : 40	0.015 - 0.03
H02	Hardened steels from 55 HRC		-	-