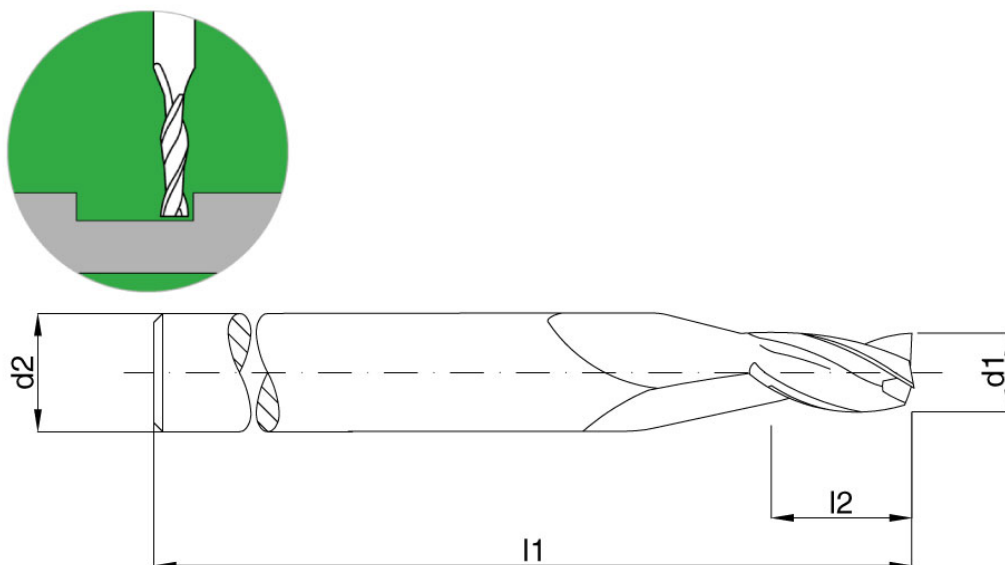




## MS32000100

**Type:** Micro-milling cutter

| d1   | d2   | l1 | l2   |
|------|------|----|------|
| 1,00 | 3,00 | 39 | 2,00 |

| Coolant holes | Cut   | Spiral angle | Cutting edges Z |
|---------------|-------|--------------|-----------------|
| No            | Right | 30°          | 3               |

| Coated | Coating type | Material | Material type | Norm |
|--------|--------------|----------|---------------|------|
| Yes    | ALCRONOS     | MD       | SMG SP        | TUSA |

## Machinable Materials

| Cod.       | Material type                                       | Machinability                                                                                | Cutting speed Vc | Advancement per revolution fn |
|------------|-----------------------------------------------------|----------------------------------------------------------------------------------------------|------------------|-------------------------------|
|            |                                                     | <b>Recommended</b><br><b>Part.</b><br><b>recommended</b><br><b>Not</b><br><b>recommended</b> | (m/min)          | (mm/dente)                    |
| <b>P01</b> | Unalloyed steels up to 800 N/mm2                    |             | 60 : 90          | 0.008 - 0.020                 |
| <b>P02</b> | Low alloy steels from 800 N/mm2 to 1100 N/mm2       |             | 60 : 90          | 0.008 - 0.020                 |
| <b>P03</b> | Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2 |             | 40 : 60          | 0.008 - 0.020                 |
| <b>M01</b> | Ferritic stainless steels                           |             | 50 : 70          | 0.007 - 0.015                 |
| <b>M02</b> | Martensitic stainless steels                        |             | 50 : 70          | 0.007 - 0.015                 |
| <b>M03</b> | Martensitic stainless steels - PH                   |             | 50 : 70          | 0.007 - 0.015                 |
| <b>M04</b> | Austenitic stainless steels                         |            | 50 : 70          | 0.007 - 0.015                 |
| <b>K01</b> | Gray/lamellar cast iron                             |           | 90 : 120         | 0.008 - 0.025                 |
| <b>K02</b> | Nodular/nodular cast iron                           |           | 90 : 120         | 0.008 - 0.025                 |
| <b>N01</b> | Drawn aluminum alloys                               |           | 200 : 250        | 0.008 - 0.025                 |
| <b>N02</b> | Die-cast aluminum alloys                            |           | 200 : 250        | 0.008 - 0.025                 |
| <b>N03</b> | Copper                                              |           | 140 : 180        | 0.008 - 0.025                 |
| <b>N04</b> | Brass - Bronze                                      |           | 140 : 180        | 0.008 - 0.025                 |
| <b>N05</b> | Lead-free brass                                     |           | 110 : 160        | 0.008 - 0.025                 |
| <b>S01</b> | Super alloys (Inconel - Hastelloy - Nimonic)        |           | 30 : 50          | 0.008 - 0.015                 |
| <b>S02</b> | Pure titanium (Grade 2 - Grade 4)                   |           | 25 : 35          | 0.008 - 0.015                 |
| <b>S03</b> | Titanium alloys (Grade 5)                           |           | 30 : 50          | 0.008 - 0.015                 |
| <b>S04</b> | Cobalt Chrome Alloys                                |           | 30 : 50          | 0.008 - 0.015                 |
| <b>H01</b> | Hardened steels up to 55 HRC                        |           | 25 : 35          | 0.003-0.005                   |

### Machinable Materials

| Cod. | Material type                                       | Machinability                                                                                        | Cutting speed Vc | Advancement per revolution fn |
|------|-----------------------------------------------------|------------------------------------------------------------------------------------------------------|------------------|-------------------------------|
|      |                                                     | <div>Recommended</div> <div>Part.</div> <div>recommended</div> <div>Not</div> <div>recommended</div> | (m/min)          | (mm/dente)                    |
| P01  | Unalloyed steels up to 800 N/mm2                    |                     | 60 : 90          | 0.008 - 0.020                 |
| P02  | Low alloy steels from 800 N/mm2 to 1100 N/mm2       |                     | 60 : 90          | 0.008 - 0.020                 |
| P03  | Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2 |                     | 40 : 60          | 0.008 - 0.020                 |
| M01  | Ferritic stainless steels                           |                     | 50 : 70          | 0.007 - 0.015                 |
| M02  | Martensitic stainless steels                        |                     | 50 : 70          | 0.007 - 0.015                 |
| M03  | Martensitic stainless steels - PH                   |                     | 50 : 70          | 0.007 - 0.015                 |
| M04  | Austenitic stainless steels                         |                    | 50 : 70          | 0.007 - 0.015                 |
| K01  | Gray/lamellar cast iron                             |                   | 90 : 120         | 0.008 - 0.025                 |
| K02  | Nodular/nodular cast iron                           |                   | 90 : 120         | 0.008 - 0.025                 |
| N01  | Drawn aluminum alloys                               |                   | 200 : 250        | 0.008 - 0.025                 |
| N02  | Die-cast aluminum alloys                            |                   | 200 : 250        | 0.008 - 0.025                 |
| N03  | Copper                                              |                   | 140 : 180        | 0.008 - 0.025                 |
| N04  | Brass - Bronze                                      |                   | 140 : 180        | 0.008 - 0.025                 |
| N05  | Lead-free brass                                     |                   | 110 : 160        | 0.008 - 0.025                 |
| S01  | Super alloys (Inconel - Hastelloy - Nimonic)        |                   | 30 : 50          | 0.008 - 0.015                 |
| S02  | Pure titanium (Grade 2 - Grade 4)                   |                   | 25 : 35          | 0.008 - 0.015                 |
| S03  | Titanium alloys (Grade 5)                           |                   | 30 : 50          | 0.008 - 0.015                 |
| S04  | Cobalt Chrome Alloys                                |                   | 30 : 50          | 0.008 - 0.015                 |
| H01  | Hardened steels up to 55 HRC                        |                   | 25 : 35          | 0.003-0.005                   |

|     |                             |                                                                                     |   |   |
|-----|-----------------------------|-------------------------------------------------------------------------------------|---|---|
| H02 | Hardened steels from 55 HRC |  | - | - |
|-----|-----------------------------|-------------------------------------------------------------------------------------|---|---|