

MS32000190














Type: Micro-milling cutter

d1	d2	l1	l2
1,90	3,00	39	3,80



















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 (m/min)	Advancement per revolution fn (mm/dente)
		Recommended Part. recommended Not recommended		
P01	Unalloyed steels up to 800 N/mm2		60 : 90	0.015 - 0.030
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		60 : 90	0.015 - 0.030
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		40 : 60	0.015 - 0.030
M01	Ferritic stainless steels		50 : 70	0.010 - 0.030
M02	Martensitic stainless steels		50 : 70	0.010 - 0.030
M03	Martensitic stainless steels - PH		50 : 70	0.010 - 0.030
M04	Austenitic stainless steels		50 : 70	0.010 - 0.030
K01	Gray/lamellar cast iron		90 : 120	0.020 - 0.040
K02	Nodular/nodular cast iron		90 : 120	0.020 - 0.040
N01	Drawn aluminum alloys		200 : 250	0.020 - 0.040
N02	Die-cast aluminum alloys		200 : 250	0.020 - 0.040
N03	Copper		140 : 180	0.020 - 0.040
N04	Brass - Bronze		140 : 180	0.020 - 0.040
N05	Lead-free brass		110 : 160	0.020 - 0.040
S01	Super alloys (Inconel - Hastelloy - Nimonic)		30 : 50	0.015 - 0.03
S02	Pure titanium (Grade 2 - Grade 4)		25 : 35	0.015 - 0.03
S03	Titanium alloys (Grade 5)		30 : 50	0.015 - 0.03
S04	Cobalt Chrome Alloys		30 : 50	0.015 - 0.03
H01	Hardened steels up to 55 HRC		25 : 35	0.004-0.006

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H02	Hardened steels from 55 HRC		-	-