





































## MS40200325

d1	d2	l1	l2
3,25	3,25	65	16,00

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	-	-	4

Coated	Coating type	Material	Material type	Norm
No	-	MD	SMG 10	Similar DIN 212

Machinable Materials				
Cod.	Material type	Machinability	Cutting speed Vc	Advancement per revolution fn
		<b>Recommended</b> Part. <b>recommended</b> Not <b>recommended</b>	(m/min)	(mm/rev)
<b>P01</b>	Unalloyed steels up to 800 N/mm2		15 : 22	0,08 - 0,12
<b>P02</b>	Low alloy steels from 800 N/mm2 to 1100 N/mm2		10 : 18	0,06 - 0,10
<b>P03</b>	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		5 : 12	0,02 - 0,04
<b>M01</b>	Ferritic stainless steels		5 : 12	0,02 - 0,04
<b>M02</b>	Martensitic stainless steels		5 : 12	0,02 - 0,04
<b>M03</b>	Martensitic stainless steels - PH		5 : 12	0,02 - 0,04
<b>M04</b>	Austenitic stainless steels		5 : 12	0,02 - 0,04
<b>K01</b>	Gray/lamellar cast iron		8 : 14	0,10 - 0,20
<b>K02</b>	Nodular/nodular cast iron		8 : 14	0,08 - 0,16
<b>N01</b>	Drawn aluminum alloys		20 : 35	0,12 - 0,20
<b>N02</b>	Die-cast aluminum alloys		15 : 25	0,10 - 0,18
<b>N03</b>	Copper		15 : 40	0,08 - 0,18
<b>N04</b>	Brass - Bronze		15 : 40	0,08 - 0,18
<b>N05</b>	Lead-free brass		12 : 35	0,10 - 0,18
<b>S01</b>	Super alloys (Inconel - Hastelloy - Nimonic)		5 : 10	0,02 - 0,04
<b>S02</b>	Pure titanium (Grade 2 - Grade 4)		6 : 10	0,04 - 0,08
<b>S03</b>	Titanium alloys (Grade 5)		6 : 10	0,04 - 0,08
<b>S04</b>	Cobalt Chrome Alloys		6 : 10	0,02 - 0,04
<b>H01</b>	Hardened steels up to 55 HRC		5 : 10	0,01 - 0,03

Machinable Materials				
Cod.	Material type	Machinability	Cutting speed Vc	Advancement per revolution fn
		Recommended Part. recommended Not recommended	(m/min)	(mm/rev)
<b>P01</b>	Unalloyed steels up to 800 N/mm <sup>2</sup>		15 : 22	0,08 - 0,12
<b>P02</b>	Low alloy steels from 800 N/mm <sup>2</sup> to 1100 N/mm <sup>2</sup>		10 : 18	0,06 - 0,10
<b>P03</b>	Highly alloyed steels from 1100 N/mm <sup>2</sup> to 1400 N/mm <sup>2</sup>		5 : 12	0,02 - 0,04
<b>M01</b>	Ferritic stainless steels		5 : 12	0,02 - 0,04
<b>M02</b>	Martensitic stainless steels		5 : 12	0,02 - 0,04
<b>M03</b>	Martensitic stainless steels - PH		5 : 12	0,02 - 0,04
<b>M04</b>	Austenitic stainless steels		5 : 12	0,02 - 0,04
<b>K01</b>	Gray/lamellar cast iron		8 : 14	0,10 - 0,20
<b>K02</b>	Nodular/nodular cast iron		8 : 14	0,08 - 0,16
<b>N01</b>	Drawn aluminum alloys		20 : 35	0,12 - 0,20
<b>N02</b>	Die-cast aluminum alloys		15 : 25	0,10 - 0,18
<b>N03</b>	Copper		15 : 40	0,08 - 0,18
<b>N04</b>	Brass - Bronze		15 : 40	0,08 - 0,18
<b>N05</b>	Lead-free brass		12 : 35	0,10 - 0,18
<b>S01</b>	Super alloys (Inconel - Hastelloy - Nimonic)		5 : 10	0,02 - 0,04
<b>S02</b>	Pure titanium (Grade 2 - Grade 4)		6 : 10	0,04 - 0,08
<b>S03</b>	Titanium alloys (Grade 5)		6 : 10	0,04 - 0,08
<b>S04</b>	Cobalt Chrome Alloys		6 : 10	0,02 - 0,04
<b>H01</b>	Hardened steels up to 55 HRC		5 : 10	0,01 - 0,03
<b>H02</b>	Hardened steels from 55 HRC		-	-



SWISS HIGH PRECISION TOOLS

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