




















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















Type: Pre-hole drill for thread whirl cutter

d1	d2	l1	l2
0,32	3,00	38	1,80

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	130°	35°	2

Coated	Coating type	Material	Material type	Norm
Yes	TISINOS	MD	SMG 10	TUSA

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		6 : 12	0.004 - 0.008
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		6 : 12	0.004 - 0.008
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		6 : 12	0.004 - 0.008
M01	Ferritic stainless steels		4 : 9	0.002 - 0.005
M02	Martensitic stainless steels		4 : 9	0.002 - 0.005
M03	Martensitic stainless steels - PH		3 : 6	0.002 - 0.005
M04	Austenitic stainless steels		-	-
K01	Gray/lamellar cast iron		6 : 12	0.004 - 0.008
K02	Nodular/nodular cast iron		6 : 12	0.004 - 0.008
N01	Drawn aluminum alloys		7 : 19	0.003 - 0.006
N02	Die-cast aluminum alloys		6 : 15	0.003 - 0.006
N03	Copper		7 : 18	0.003 - 0.006
N04	Brass - Bronze		6 : 15	0.003 - 0.006
N05	Lead-free brass		6 : 15	0.003 - 0.006
S01	Super alloys (Inconel - Hastelloy - Nimonic)		5 : 9	0.003 - 0.006
S02	Pure titanium (Grade 2 - Grade 4)		5 : 9	0.003 - 0.006
S03	Titanium alloys (Grade 5)		3 : 6	0.002 - 0.005
S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		3 : 6	0.002 - 0.005

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H02	Hardened steels from 55 HRC		-	-