




















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















Type: Pre-hole drill for thread whirl cutter

d1	d2	l1	l2
0,82	3,00	38	5,00

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		12 : 35	0.008 - 0.015
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		12 : 35	0.008 - 0.015
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		12 : 35	0.008 - 0.015
M01	Ferritic stainless steels		9 : 25	0.005 - 0.012
M02	Martensitic stainless steels		9 : 25	0.005 - 0.012
M03	Martensitic stainless steels - PH		6 : 20	0.004 - 0.009
M04	Austenitic stainless steels		-	-
K01	Gray/lamellar cast iron		12 : 35	0.008 - 0.015
K02	Nodular/nodular cast iron		12 : 35	0.008 - 0.015
N01	Drawn aluminum alloys		19 : 45	0.006 - 0.012
N02	Die-cast aluminum alloys		15 : 35	0.006 - 0.012
N03	Copper		18 : 40	0.006 - 0.012
N04	Brass - Bronze		15 : 35	0.006 - 0.012
N05	Lead-free brass		15 : 35	0.006 - 0.012
S01	Super alloys (Inconel - Hastelloy - Nimonic)		9 : 18	0.006 - 0.012
S02	Pure titanium (Grade 2 - Grade 4)		9 : 18	0.006 - 0.012
S03	Titanium alloys (Grade 5)		6 : 12	0.005 - 0.009
S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		6 : 12	0.005 - 0.009

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H02	Hardened steels from 55 HRC		-	-