



















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















Type: Pre-hole drill for thread whirl cutter

| d1 | d2 | l1 | l2 |
|------|------|----|------|
| 1,18 | 3,00 | 38 | 8,20 |

| 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 |  | 35 : 60 | 0.015 - 0.030 |
| P02 | Low alloy steels from 800 N/mm2 to 1100 N/mm2 |  | 35 : 60 | 0.015 - 0.030 |
| P03 | Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2 |  | 35 : 60 | 0.015 - 0.030 |
| M01 | Ferritic stainless steels |  | 25 : 50 | 0.012 - 0.024 |
| M02 | Martensitic stainless steels |  | 25 : 50 | 0.012 - 0.024 |
| M03 | Martensitic stainless steels - PH |  | 20 : 35 | 0.009 - 0.022 |
| M04 | Austenitic stainless steels |  | - | - |
| K01 | Gray/lamellar cast iron |  | 35 : 60 | 0.015 - 0.030 |
| K02 | Nodular/nodular cast iron |  | 35 : 60 | 0.015 - 0.030 |
| N01 | Drawn aluminum alloys |  | 45 : 80 | 0.012 - 0.024 |
| N02 | Die-cast aluminum alloys |  | 35 : 65 | 0.012 - 0.024 |
| N03 | Copper |  | 40 : 70 | 0.012 - 0.024 |
| N04 | Brass - Bronze |  | 35 : 65 | 0.012 - 0.024 |
| N05 | Lead-free brass |  | 35 : 65 | 0.012 - 0.024 |
| S01 | Super alloys (Inconel - Hastelloy - Nimonic) |  | 18 : 35 | 0.012 - 0.024 |
| S02 | Pure titanium (Grade 2 - Grade 4) |  | 18 : 35 | 0.012 - 0.024 |
| S03 | Titanium alloys (Grade 5) |  | 12 : 20 | 0.009 - 0.015 |
| S04 | Cobalt Chrome Alloys |  | - | - |
| H01 | Hardened steels up to 55 HRC |  | 12 : 20 | 0.009 - 0.015 |

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| S04 | Cobalt Chrome Alloys |  | - | - |
| H01 | Hardened steels up to 55 HRC |  | 12 : 20 | 0.009 - 0.015 |
| H02 | Hardened steels from 55 HRC |  | - | - |