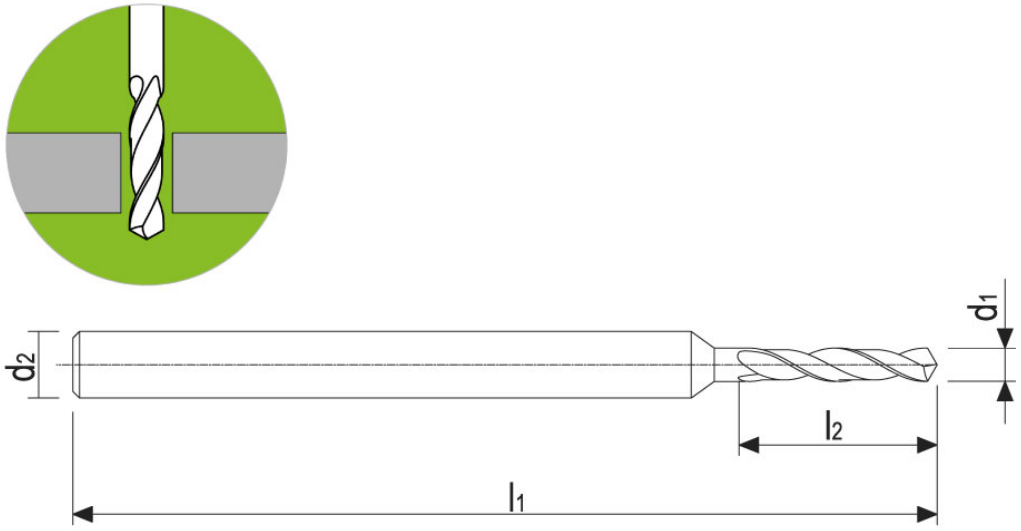

MTB1040330

Type: Pre-hole drill for thread whirl cutter

d1	d2	l1	l2
3,30	6,00	66	17,00

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	140°	30°	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	0.070 - 0.130
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		35 : 60	0.070 - 0.130
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		35 : 60	0.070 - 0.130
M01	Ferritic stainless steels		25 : 50	0.050 - 0.080
M02	Martensitic stainless steels		25 : 50	0.050 - 0.080
M03	Martensitic stainless steels - PH		20 : 35	0.050 - 0.080
M04	Austenitic stainless steels		-	-
K01	Gray/lamellar cast iron		35 : 60	0.100 - 0.150
K02	Nodular/nodular cast iron		35 : 60	0.100 - 0.150
N01	Drawn aluminum alloys		45 : 80	0.090 - 0.150
N02	Die-cast aluminum alloys		35 : 65	0.090 - 0.150
N03	Copper		40 : 70	0.090 - 0.150
N04	Brass - Bronze		35 : 65	0.090 - 0.150
N05	Lead-free brass		35 : 65	0.090 - 0.150
S01	Super alloys (Inconel - Hastelloy - Nimonic)		18 : 35	0.030 - 0.060
S02	Pure titanium (Grade 2 - Grade 4)		18 : 35	0.030 - 0.060
S03	Titanium alloys (Grade 5)		12 : 20	0.030 - 0.060
S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		12 : 20	0.030 - 0.060

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S03	Titanium alloys (Grade 5)		12 : 20	0.030 - 0.060
S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		12 : 20	0.030 - 0.060
H02	Hardened steels from 55 HRC		-	-