








## MTB1040450





















**Type:** Pre-hole drill for thread whirl cutter

d1	d2	l1	l2
4,50	6,00	74	23,00

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
		<b>Recommended</b> Part. recommended Not recommended	(m/min)	(mm/rev)
<b>P01</b>	Unalloyed steels up to 800 N/mm2		35 : 60	0.070 - 0.130
<b>P02</b>	Low alloy steels from 800 N/mm2 to 1100 N/mm2		35 : 60	0.070 - 0.130
<b>P03</b>	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		35 : 60	0.070 - 0.130
<b>M01</b>	Ferritic stainless steels		25 : 50	0.050 - 0.080
<b>M02</b>	Martensitic stainless steels		25 : 50	0.050 - 0.080
<b>M03</b>	Martensitic stainless steels - PH		20 : 35	0.050 - 0.080
<b>M04</b>	Austenitic stainless steels		-	-
<b>K01</b>	Gray/lamellar cast iron		35 : 60	0.100 - 0.150
<b>K02</b>	Nodular/nodular cast iron		35 : 60	0.100 - 0.150
<b>N01</b>	Drawn aluminum alloys		45 : 80	0.090 - 0.150
<b>N02</b>	Die-cast aluminum alloys		35 : 65	0.090 - 0.150
<b>N03</b>	Copper		40 : 70	0.090 - 0.150
<b>N04</b>	Brass - Bronze		35 : 65	0.090 - 0.150
<b>N05</b>	Lead-free brass		35 : 65	0.090 - 0.150
<b>S01</b>	Super alloys (Inconel - Hastelloy - Nimonic)		18 : 35	0.030 - 0.060
<b>S02</b>	Pure titanium (Grade 2 - Grade 4)		18 : 35	0.030 - 0.060
<b>S03</b>	Titanium alloys (Grade 5)		12 : 20	0.030 - 0.060
<b>S04</b>	Cobalt Chrome Alloys		-	-
<b>H01</b>	Hardened steels up to 55 HRC		12 : 20	0.030 - 0.060

Machinable Materials				
Cod.	Material type	Machinability	Cutting speed Vc	Advancement per revolution fn
		<b>Recommended</b> Part. recommended Not recommended	(m/min)	(mm/rev)
<b>P01</b>	Unalloyed steels up to 800 N/mm2		35 : 60	0.070 - 0.130
<b>P02</b>	Low alloy steels from 800 N/mm2 to 1100 N/mm2		35 : 60	0.070 - 0.130
<b>P03</b>	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		35 : 60	0.070 - 0.130
<b>M01</b>	Ferritic stainless steels		25 : 50	0.050 - 0.080
<b>M02</b>	Martensitic stainless steels		25 : 50	0.050 - 0.080
<b>M03</b>	Martensitic stainless steels - PH		20 : 35	0.050 - 0.080
<b>M04</b>	Austenitic stainless steels		-	-
<b>K01</b>	Gray/lamellar cast iron		35 : 60	0.100 - 0.150
<b>K02</b>	Nodular/nodular cast iron		35 : 60	0.100 - 0.150
<b>N01</b>	Drawn aluminum alloys		45 : 80	0.090 - 0.150
<b>N02</b>	Die-cast aluminum alloys		35 : 65	0.090 - 0.150
<b>N03</b>	Copper		40 : 70	0.090 - 0.150
<b>N04</b>	Brass - Bronze		35 : 65	0.090 - 0.150
<b>N05</b>	Lead-free brass		35 : 65	0.090 - 0.150
<b>S01</b>	Super alloys (Inconel - Hastelloy - Nimonic)		18 : 35	0.030 - 0.060
<b>S02</b>	Pure titanium (Grade 2 - Grade 4)		18 : 35	0.030 - 0.060
<b>S03</b>	Titanium alloys (Grade 5)		12 : 20	0.030 - 0.060
<b>S04</b>	Cobalt Chrome Alloys		-	-
<b>H01</b>	Hardened steels up to 55 HRC		12 : 20	0.030 - 0.060
<b>H02</b>	Hardened steels from 55 HRC		-	-