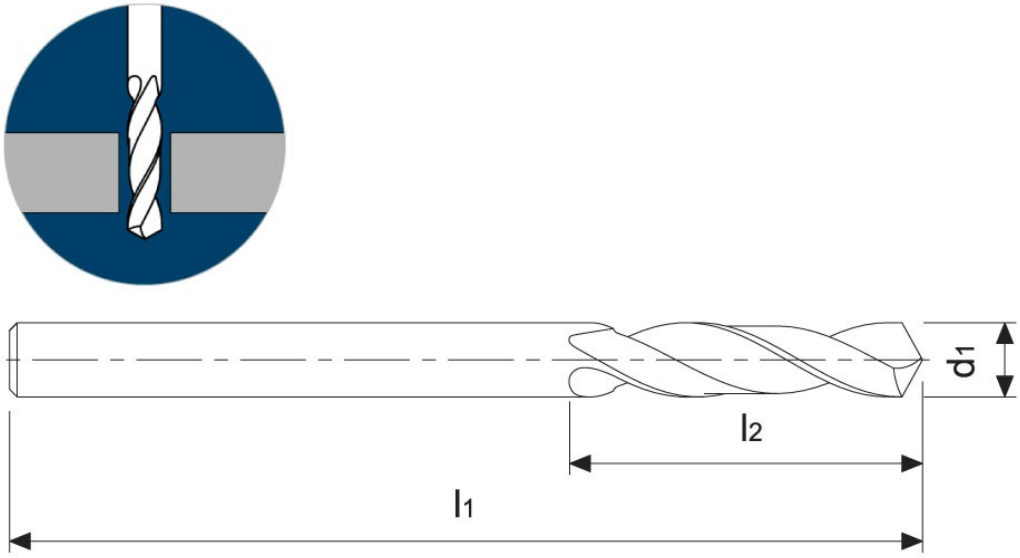

MTB2501500

Type: Short twist drill

d1	d2	l1	l2
15,00	11,40	111	56,00

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	118°	25°	2

Coated	Coating type	Material	Material type	Norm
No	-	MD	SMG 10	DIN 6539

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		40 : 60	0,08 - 0,12
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		30 : 50	0,06 - 0,08
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		20 : 40	0,06 - 0,08
M01	Ferritic stainless steels		15 : 30	0,06 - 0,10
M02	Martensitic stainless steels		15 : 30	0,06 - 0,10
M03	Martensitic stainless steels - PH		15 : 30	0,06 - 0,10
M04	Austenitic stainless steels		15 : 30	0,06 - 0,10
K01	Gray/lamellar cast iron		30 : 50	0,09 - 0,14
K02	Nodular/nodular cast iron		30 : 50	0,09 - 0,14
N01	Drawn aluminum alloys		60 : 100	0,13 - 0,16
N02	Die-cast aluminum alloys		50 : 80	0,09 - 0,12
N03	Copper		30 : 60	0,13 - 0,16
N04	Brass - Bronze		40 : 70	0,13 - 0,16
N05	Lead-free brass		30 : 60	0,13 - 0,16
S01	Super alloys (Inconel - Hastelloy - Nimonic)		-	-
S02	Pure titanium (Grade 2 - Grade 4)		-	-
S03	Titanium alloys (Grade 5)		-	-
S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		-	-

Machinable Materials				
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S02	Pure titanium (Grade 2 - Grade 4)		-	-
S03	Titanium alloys (Grade 5)		-	-
S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		-	-
H02	Hardened steels from 55 HRC		-	-