



## MTB2531800

**Type:** 3-fluted twist drill

d1	d2	l1	l2
18,00	18,00	123	62,00

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	130°	30°	3

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
		<b>Recommended</b> Part. <b>recommended</b> Not <b>recommended</b>	(m/min)	(mm/rev)
<b>P01</b>	Unalloyed steels up to 800 N/mm2		40 : 60	0,15 - 0,30
<b>P02</b>	Low alloy steels from 800 N/mm2 to 1100 N/mm2		-	-
<b>P03</b>	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		-	-
<b>M01</b>	Ferritic stainless steels		-	-
<b>M02</b>	Martensitic stainless steels		-	-
<b>M03</b>	Martensitic stainless steels - PH		-	-
<b>M04</b>	Austenitic stainless steels		-	-
<b>K01</b>	Gray/lamellar cast iron		60 : 100	-
<b>K02</b>	Nodular/nodular cast iron		50 : 80	0,13 - 0,20
<b>N01</b>	Drawn aluminum alloys		70 : 150	0,13 - 0,27
<b>N02</b>	Die-cast aluminum alloys		70 : 150	0,13 - 0,27
<b>N03</b>	Copper		50 : 80	0,13 - 0,27
<b>N04</b>	Brass - Bronze		60 : 100	0,13 - 0,27
<b>N05</b>	Lead-free brass		50 : 80	0,10 - 0,22
<b>S01</b>	Super alloys (Inconel - Hastelloy - Nimonic)		-	-
<b>S02</b>	Pure titanium (Grade 2 - Grade 4)		20 : 40	0,08 - 0,14
<b>S03</b>	Titanium alloys (Grade 5)		20 : 40	0,08 - 0,14
<b>S04</b>	Cobalt Chrome Alloys		-	-
<b>H01</b>	Hardened steels up to 55 HRC		-	-

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<b>S03</b>	Titanium alloys (Grade 5)		20 : 40	0,08 - 0,14
<b>S04</b>	Cobalt Chrome Alloys		-	-
<b>H01</b>	Hardened steels up to 55 HRC		-	-
<b>H02</b>	Hardened steels from 55 HRC		-	-



SWISS HIGH PRECISION TOOLS

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