



## MTB25N0191

**Type:** Short twist drill

| d1   | d2   | l1 | l2    |
|------|------|----|-------|
| 1,91 | 1,91 | 40 | 18,00 |

| 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        | TUSA |

Machinable Materials

| Cod. | Material type                                       | Machinability                                                                                        | Cutting speed<br>Vc | Advancementper<br>revolution fn |
|------|-----------------------------------------------------|------------------------------------------------------------------------------------------------------|---------------------|---------------------------------|
|      |                                                     | <div>Recommended</div> <div>Part.</div> <div>recommended</div> <div>Not</div> <div>recommended</div> | (m/min)             | (mm/rev)                        |
| P01  | Unalloyed steels up to 800 N/mm2                    |                     | 40 : 60             | 0,01 - 0,03                     |
| P02  | Low alloy steels from 800 N/mm2 to 1100 N/mm2       |                     | 30 : 50             | 0,01 - 0,02                     |
| P03  | Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2 |                     | 20 : 40             | 0,008 - 0,017                   |
| M01  | Ferritic stainless steels                           |                     | 15 : 30             | 0,005 - 0,015                   |
| M02  | Martensitic stainless steels                        |                     | 15 : 30             | 0,005 - 0,015                   |
| M03  | Martensitic stainless steels - PH                   |                     | 15 : 30             | 0,005 - 0,015                   |
| M04  | Austenitic stainless steels                         |                    | 15 : 30             | 0,005 - 0,015                   |
| K01  | Gray/lamellar cast iron                             |                   | 30 : 50             | 0,01 - 0,03                     |
| K02  | Nodular/nodular cast iron                           |                   | 30 : 50             | 0,01 - 0,03                     |
| N01  | Drawn aluminum alloys                               |                   | 60 : 100            | 0,03 - 0,06                     |
| N02  | Die-cast aluminum alloys                            |                   | 50 : 80             | 0,01 - 0,04                     |
| N03  | Copper                                              |                   | 30 : 60             | 0,03 - 0,06                     |
| N04  | Brass - Bronze                                      |                   | 40 : 70             | 0,03 - 0,06                     |
| N05  | Lead-free brass                                     |                   | 30 : 60             | 0,03 - 0,06                     |
| 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 |                                                     |                                                                                     |                  |                               |
|----------------------|-----------------------------------------------------|-------------------------------------------------------------------------------------|------------------|-------------------------------|
| Cod.                 | Material type                                       | Machinability                                                                       | Cutting speed Vc | Advancement per revolution fn |
|                      |                                                     | Recommended<br>Part.<br>recommended<br>Not<br>recommended                           | (m/min)          | (mm/rev)                      |
| P01                  | Unalloyed steels up to 800 N/mm2                    |    | 40 : 60          | 0,01 - 0,03                   |
| P02                  | Low alloy steels from 800 N/mm2 to 1100 N/mm2       |    | 30 : 50          | 0,01 - 0,02                   |
| P03                  | Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2 |    | 20 : 40          | 0,008 - 0,017                 |
| M01                  | Ferritic stainless steels                           |    | 15 : 30          | 0,005 - 0,015                 |
| M02                  | Martensitic stainless steels                        |    | 15 : 30          | 0,005 - 0,015                 |
| M03                  | Martensitic stainless steels - PH                   |    | 15 : 30          | 0,005 - 0,015                 |
| M04                  | Austenitic stainless steels                         |   | 15 : 30          | 0,005 - 0,015                 |
| K01                  | Gray/lamellar cast iron                             |  | 30 : 50          | 0,01 - 0,03                   |
| K02                  | Nodular/nodular cast iron                           |  | 30 : 50          | 0,01 - 0,03                   |
| N01                  | Drawn aluminum alloys                               |  | 60 : 100         | 0,03 - 0,06                   |
| N02                  | Die-cast aluminum alloys                            |  | 50 : 80          | 0,01 - 0,04                   |
| N03                  | Copper                                              |  | 30 : 60          | 0,03 - 0,06                   |
| N04                  | Brass - Bronze                                      |  | 40 : 70          | 0,03 - 0,06                   |
| N05                  | Lead-free brass                                     |  | 30 : 60          | 0,03 - 0,06                   |
| 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                        |  | -                | -                             |
| H02                  | Hardened steels from 55 HRC                         |  | -                | -                             |



SWISS HIGH PRECISION TOOLS

