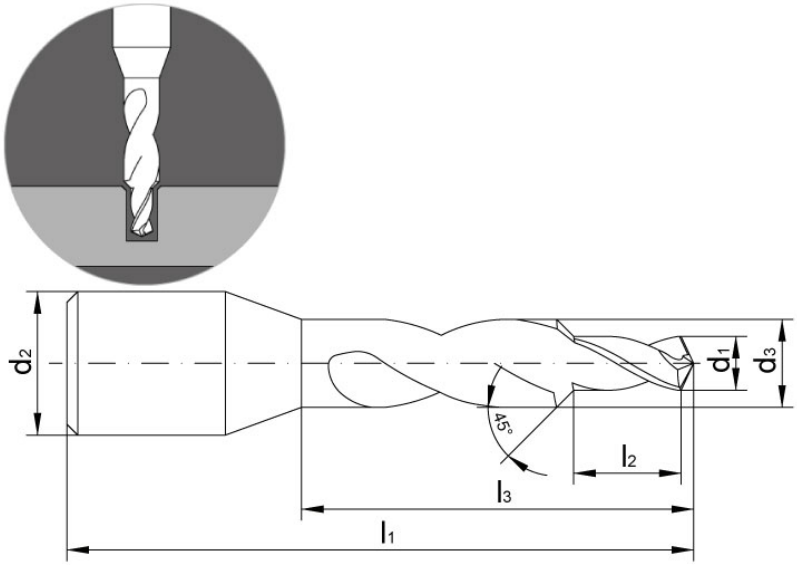

MTB2700150E

Type: High-performance Pilot Drill with reinforced shank

d1	d2	d3	l1	l2	l3
1,50	4,00	2,45	48	3,0	10,95

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	130°	Variable	2

Coated	Coating type	Material	Material type	Norm
Yes	Alcrona	MD	SMG SP	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		65 : 80	0.08-0.10
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		50 : 60	0.07-0.09
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		40 : 50	0.06-0.08
M01	Ferritic stainless steels		35 : 40	0.04-0.05
M02	Martensitic stainless steels		40 : 50	0.04-0.05
M03	Martensitic stainless steels - PH		40 : 50	0.04-0.05
M04	Austenitic stainless steels		25 : 30	0.03-0.04
K01	Gray/lamellar cast iron		70 : 80	0.07-0.08
K02	Nodular/nodular cast iron		60 : 70	0.06-0.07
N01	Drawn aluminum alloys		115 : 125	0.07-0.09
N02	Die-cast aluminum alloys		115 : 125	0.075-0.09
N03	Copper		65 : 80	0.06-0.07
N04	Brass - Bronze		90 : 100	0.08-0.095
N05	Lead-free brass		80 : 90	0.06-0.075
S01	Super alloys (Inconel - Hastelloy - Nimonic)		15 : 20	0.02-0.03
S02	Pure titanium (Grade 2 - Grade 4)		20 : 30	0.03-0.04
S03	Titanium alloys (Grade 5)		20 : 30	0.05-0.06
S04	Cobalt Chrome Alloys		15 : 20	0.045-0.06
H01	Hardened steels up to 55 HRC		15 : 20	0.008-0.012
H02	Hardened steels from 55 HRC		-	-

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