



MTB2700220

Type: Pilot drill

d1	d2	d3	l1	l2	l3
2,20	4,00	3,20	53	4,40	11,10

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	140°	25°	2

Coated	Coating type	Material	Material type	Norm
Yes	TiAlN	MD	SMG SP	TUSA

Machinable Materials				
Cod.	Material type	Machinability	Cutting speed V _c	Advancement per revolution f _n
		Recommended Part. recommended Not recommended	(m/min)	(mm/rev)
P01	Unalloyed steels up to 800 N/mm ²		80 : 120	0,155
P02	Low alloy steels from 800 N/mm ² to 1100 N/mm ²		60 : 100	0,150
P03	Highly alloyed steels from 1100 N/mm ² to 1400 N/mm ²		40 : 80	0,095
M01	Ferritic stainless steels		20 : 40	0,053
M02	Martensitic stainless steels		25 : 50	0,073
M03	Martensitic stainless steels - PH		20 : 30	0,053
M04	Austenitic stainless steels		20 : 30	0,053
K01	Gray/lamellar cast iron		80 : 120	0,155
K02	Nodular/nodular cast iron		80 : 120	0,155
N01	Drawn aluminum alloys		150 : 200	0,100
N02	Die-cast aluminum alloys		150 : 200	0,085
N03	Copper		80 : 120	0,055
N04	Brass - Bronze		60 : 100	0,080
N05	Lead-free brass		100 : 140	0,055
S01	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 40	0,008
S02	Pure titanium (Grade 2 - Grade 4)		20 : 40	0,055
S03	Titanium alloys (Grade 5)		15 : 30	0,060
S04	Cobalt Chrome Alloys		20 : 40	0,025
H01	Hardened steels up to 55 HRC		20 : 40	0,013

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		Recommended Part. recommended Not recommended	(m/min)	(mm/rev)
P01	Unalloyed steels up to 800 N/mm2		80 : 120	0,155
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		60 : 100	0,150
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		40 : 80	0,095
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S04	Cobalt Chrome Alloys		20 : 40	0,025
H01	Hardened steels up to 55 HRC		20 : 40	0,013
H02	Hardened steels from 55 HRC		15 : 30	0,008



SWISS HIGH PRECISION TOOLS

