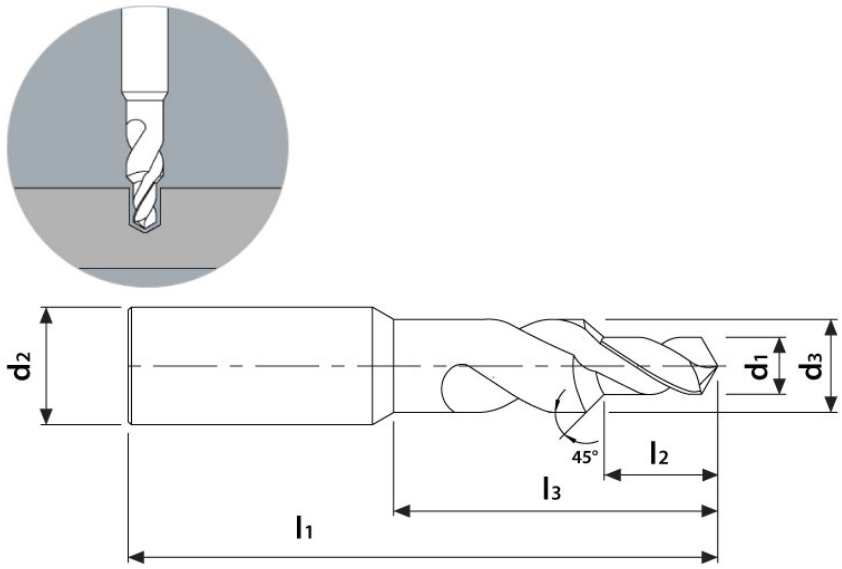

MTB2700225

Type: Pilot drill

d1	d2	d3	l1	l2	l3
2,25	4,00	3,40	53	4,50	11,60

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 Vc	Advancement per revolution fn
		Recommended Part. recommended Not recommended	(m/min)	(mm/rev)
P01	Unalloyed steels up to 800 N/mm2		80 : 120	0,160
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		60 : 100	0,155
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		40 : 80	0,100
M01	Ferritic stainless steels		20 : 40	0,058
M02	Martensitic stainless steels		25 : 50	0,078
M03	Martensitic stainless steels - PH		20 : 30	0,058
M04	Austenitic stainless steels		20 : 30	0,058
K01	Gray/lamellar cast iron		80 : 120	0,160
K02	Nodular/nodular cast iron		80 : 120	0,160
N01	Drawn aluminum alloys		150 : 200	0,100
N02	Die-cast aluminum alloys		150 : 200	0,090
N03	Copper		80 : 120	0,060
N04	Brass - Bronze		60 : 100	0,080
N05	Lead-free brass		100 : 140	0,060
S01	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 40	0,009
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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H01	Hardened steels up to 55 HRC		20 : 40	0,013
H02	Hardened steels from 55 HRC		15 : 30	0,009