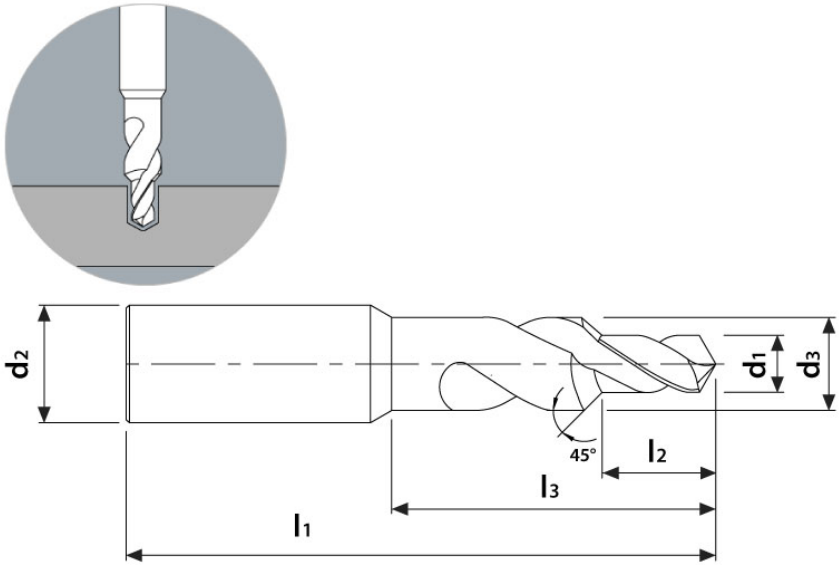

MTB2700300

Type: Pilot drill

d1	d2	d3	l1	l2	l3
3,00	4,00	4,00	53	6,00	-

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	0,200
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		60 : 100	0,195
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		40 : 80	0,125
M01	Ferritic stainless steels		20 : 40	0,068
M02	Martensitic stainless steels		25 : 50	0,098
M03	Martensitic stainless steels - PH		20 : 30	0,068
M04	Austenitic stainless steels		20 : 30	0,068
K01	Gray/lamellar cast iron		80 : 120	0,200
K02	Nodular/nodular cast iron		80 : 120	0,200
N01	Drawn aluminum alloys		150 : 200	0,135
N02	Die-cast aluminum alloys		150 : 200	0,130
N03	Copper		80 : 120	0,080
N04	Brass - Bronze		60 : 100	0,110
N05	Lead-free brass		100 : 140	0,100
S01	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 40	0,012
S02	Pure titanium (Grade 2 - Grade 4)		20 : 40	0,075
S03	Titanium alloys (Grade 5)		15 : 30	0,085
S04	Cobalt Chrome Alloys		20 : 40	0,035
H01	Hardened steels up to 55 HRC		20 : 40	0,018

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H02	Hardened steels from 55 HRC		15 : 30	0,012