



MTB4001400

Type: Center drill 120°

d1	d2	l1	l2
14,00	14,00	75	30,00

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	120°	22°	2

Coated	Coating type	Material	Material type	Norm
No	-	MD	SMG 10	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		40 : 60	0,14 - 0,25
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		30 : 50	0,13 - 0,20
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		-	-
M01	Ferritic stainless steels		20 : 40	0,09 - 0,17
M02	Martensitic stainless steels		20 : 40	0,09 - 0,17
M03	Martensitic stainless steels - PH		20 : 40	0,09 - 0,17
M04	Austenitic stainless steels		20 : 40	0,09 - 0,17
K01	Gray/lamellar cast iron		50 : 80	0,09 - 0,17
K02	Nodular/nodular cast iron		30 : 60	0,09 - 0,17
N01	Drawn aluminum alloys		70 : 100	0,15 - 0,30
N02	Die-cast aluminum alloys		70 : 100	0,15 - 0,30
N03	Copper		40 : 80	0,15 - 0,30
N04	Brass - Bronze		40 : 80	0,15 - 0,30
N05	Lead-free brass		30 : 70	0,14 - 0,25
S01	Super alloys (Inconel - Hastelloy - Nimonic)		-	-
S02	Pure titanium (Grade 2 - Grade 4)		25 : 50	0,10 - 0,17
S03	Titanium alloys (Grade 5)		25 : 50	0,10 - 0,17
S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		-	-

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H01	Hardened steels up to 55 HRC		-	-
H02	Hardened steels from 55 HRC		-	-



SWISS HIGH PRECISION TOOLS

