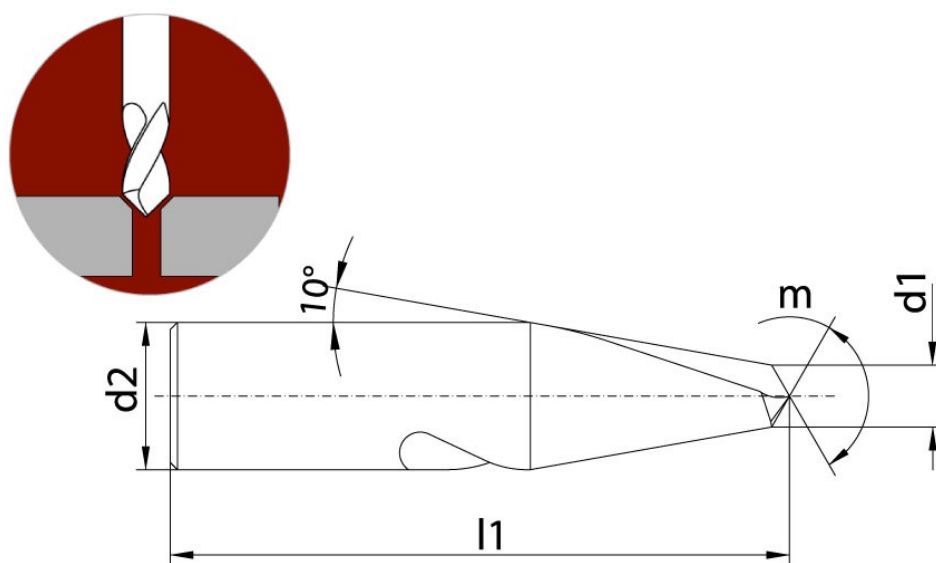




MTB4400060

Type: Micro-center drill 90°

d1	d2	l1	l2
0,60	2,00	28	-

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	90°	0°	2

Machinable Materials				
Coated	Coating type	Material	Material type	Norm
Yes	TiAlN	MD	SMG 10	TUSA

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	0,005 - 0,01
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		30 : 50	0,005 - 0,01
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		20 : 40	0,003 - 0,008
M01	Ferritic stainless steels		20 : 40	0,003 - 0,008
M02	Martensitic stainless steels		20 : 40	0,003 - 0,008
M03	Martensitic stainless steels - PH		20 : 40	0,003 - 0,008
M04	Austenitic stainless steels		20 : 40	0,003 - 0,008
K01	Gray/lamellar cast iron		50 : 80	0,005 - 0,01
K02	Nodular/nodular cast iron		30 : 60	0,005 - 0,01
N01	Drawn aluminum alloys		70 : 100	0,005 - 0,015
N02	Die-cast aluminum alloys		70 : 100	0,005 - 0,015
N03	Copper		40 : 80	0,005 - 0,015
N04	Brass - Bronze		40 : 80	0,005 - 0,015
N05	Lead-free brass		30 : 70	0,005 - 0,015
S01	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 40	0,001 - 0,005
S02	Pure titanium (Grade 2 - Grade 4)		25 : 50	0,002 - 0,007
S03	Titanium alloys (Grade 5)		20 : 40	0,002 - 0,007
S04	Cobalt Chrome Alloys		20 : 40	0,001 - 0,005
H01	Hardened steels up to 55 HRC		20 : 40	0,001 - 0,005
H02	Hardened steels from 55 HRC		20 : 40	0,001 - 0,004



SWISS HIGH PRECISION TOOLS

