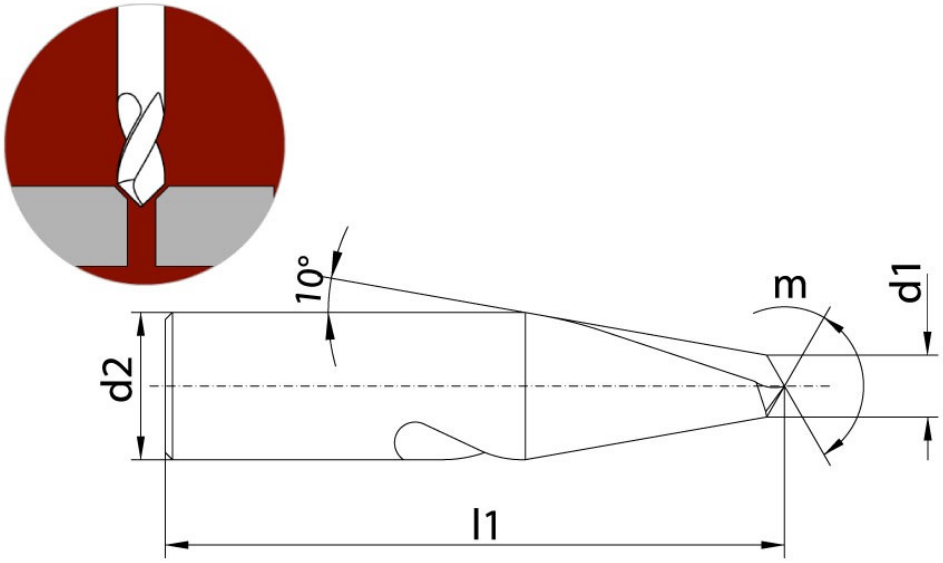

MTB4400120

Type: Micro-center drill 90°

d1	d2	l1	l2
1,20	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	0,006 - 0,02
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		30 : 50	0,006 - 0,15
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		20 : 40	0,003 - 0,01
M01	Ferritic stainless steels		20 : 40	0,003 - 0,01
M02	Martensitic stainless steels		20 : 40	0,003 - 0,01
M03	Martensitic stainless steels - PH		20 : 40	0,003 - 0,01
M04	Austenitic stainless steels		20 : 40	0,003 - 0,01
K01	Gray/lamellar cast iron		50 : 80	0,01 - 0,02
K02	Nodular/nodular cast iron		30 : 60	0,01 - 0,02
N01	Drawn aluminum alloys		70 : 100	0,01 - 0,03
N02	Die-cast aluminum alloys		70 : 100	0,008 - 0,02
N03	Copper		40 : 80	0,008 - 0,03
N04	Brass - Bronze		40 : 80	0,008 - 0,03
N05	Lead-free brass		30 : 70	0,008 - 0,03
S01	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 40	0,003 - 0,007
S02	Pure titanium (Grade 2 - Grade 4)		25 : 50	0,005 - 0,01
S03	Titanium alloys (Grade 5)		20 : 40	0,005 - 0,01
S04	Cobalt Chrome Alloys		20 : 40	0,003 - 0,007
H01	Hardened steels up to 55 HRC		20 : 40	0,003 - 0,007
H02	Hardened steels from 55 HRC		20 : 40	0,002 - 0,005