



MTB4400200

Type: Micro-center drill 90°

d1	d2	l1	l2
2,00	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/mm ²		40 : 60	0,01 - 0,03
P02	Low alloy steels from 800 N/mm ² to 1100 N/mm ²		30 : 50	0,01 - 0,02
P03	Highly alloyed steels from 1100 N/mm ² to 1400 N/mm ²		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	0,015 - 0,040
N02	Die-cast aluminum alloys		70 : 100	0,01 - 0,03
N03	Copper		40 : 80	0,015 - 0,040
N04	Brass - Bronze		40 : 80	0,015 - 0,040
N05	Lead-free brass		30 : 70	0,01 - 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



SWISS HIGH PRECISION TOOLS

