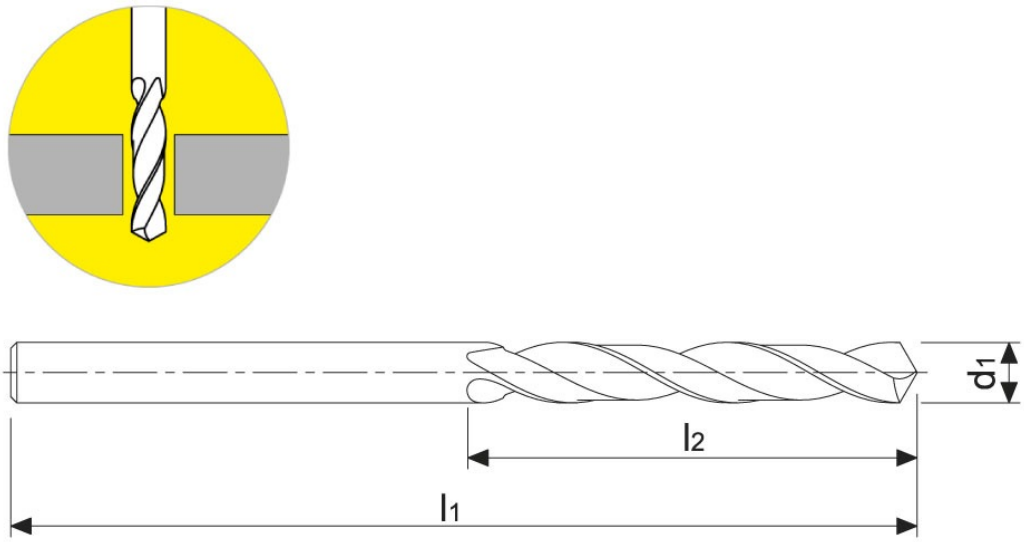

MTB4500430

Type: Long twist drill

d1	d2	l1	l2
4,30	4,30	83	40,00

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	120°	30°	2

Coated	Coating type	Material	Material type	Norm
No	-	MD	SMG 10	TUSA

Machinable Materials				
Cod.	Material type	Lavorabilità	Velocità di taglio Vc	Advancementper revolution fn
		Recommended Part. recommended Not recommended	(m/min)	(mm/rev)
P01	Unalloyed steels up to 800 N/mm2		40 : 60	0,015 - 0,05
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		30 : 50	0,015 - 0,03
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		-	-
M01	Ferritic stainless steels		15 : 30	0,015 - 0,04
M02	Martensitic stainless steels		15 : 30	0,015 - 0,04
M03	Martensitic stainless steels - PH		15 :30	0,015 - 0,04
M04	Austenitic stainless steels		15 : 30	0,015 - 0,04
K01	Gray/lamellar cast iron		30 : 50	0,03 - 0,05
K02	Nodular/nodular cast iron		30 : 50	0,03 - 0,05
N01	Drawn aluminum alloys		60 : 100	0,03 - 0,05
N02	Die-cast aluminum alloys		50 : 80	0,02 - 0,04
N03	Copper		30 : 60	0,04 - 0,06
N04	Brass - Bronze		40 : 70	0,04 - 0,06
N05	Lead-free brass		30 : 60	0,02 - 0,05
S01	Super alloys (Inconel - Hastelloy - Nimonic)		-	-
S02	Pure titanium (Grade 2 - Grade 4)		-	-
S03	Titanium alloys (Grade 5)		-	-
S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		-	-

Machinable Materials				
Cod.	Material type	Lavorabilità	Velocità di taglio Vc	Advancementper revolution fn
		Recommended Part. recommended Not recommended	(m/min)	(mm/rev)
P01	Unalloyed steels up to 800 N/mm2		40 : 60	0,015 - 0,05
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		30 : 50	0,015 - 0,03
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M01	Ferritic stainless steels		15 : 30	0,015 - 0,04
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K01	Gray/lamellar cast iron		30 : 50	0,03 - 0,05
K02	Nodular/nodular cast iron		30 : 50	0,03 - 0,05
N01	Drawn aluminum alloys		60 : 100	0,03 - 0,05
N02	Die-cast aluminum alloys		50 : 80	0,02 - 0,04
N03	Copper		30 : 60	0,04 - 0,06
N04	Brass - Bronze		40 : 70	0,04 - 0,06
N05	Lead-free brass		30 : 60	0,02 - 0,05
S01	Super alloys (Inconel - Hastelloy - Nimonic)		-	-
S02	Pure titanium (Grade 2 - Grade 4)		-	-
S03	Titanium alloys (Grade 5)		-	-
S04	Cobalt Chrome Alloys		-	-
H01	Hardened steels up to 55 HRC		-	-
H02	Hardened steels from 55 HRC		-	-