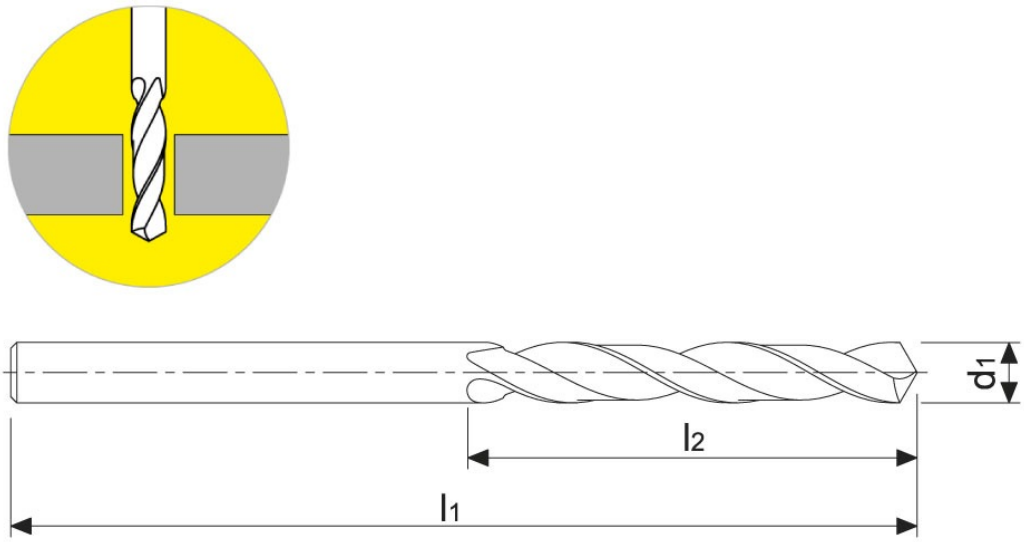

MTB4500680

Type: Long twist drill

d1	d2	l1	l2
6,80	6,80	105	50,00

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	0,02 - 0,05
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		30 : 50	0,02 - 0,03
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		-	-
M01	Ferritic stainless steels		15 : 30	0,02 - 0,04
M02	Martensitic stainless steels		15 : 30	0,02 - 0,04
M03	Martensitic stainless steels - PH		15 :30	0,02 - 0,04
M04	Austenitic stainless steels		15 : 30	0,02 - 0,04
K01	Gray/lamellar cast iron		30 : 50	0,04 - 0,06
K02	Nodular/nodular cast iron		30 : 50	0,04 - 0,06
N01	Drawn aluminum alloys		60 : 100	0,06 - 0,11
N02	Die-cast aluminum alloys		50 : 80	0,04 - 0,09
N03	Copper		30 : 60	0,06 - 0,08
N04	Brass - Bronze		40 : 70	0,06 - 0,08
N05	Lead-free brass		30 : 60	0,06 - 0,08
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	0,02 - 0,05
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		30 : 50	0,02 - 0,03
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		-	-
M01	Ferritic stainless steels		15 : 30	0,02 - 0,04
M02	Martensitic stainless steels		15 : 30	0,02 - 0,04
M03	Martensitic stainless steels - PH		15 :30	0,02 - 0,04
M04	Austenitic stainless steels		15 : 30	0,02 - 0,04
K01	Gray/lamellar cast iron		30 : 50	0,04 - 0,06
K02	Nodular/nodular cast iron		30 : 50	0,04 - 0,06
N01	Drawn aluminum alloys		60 : 100	0,06 - 0,11
N02	Die-cast aluminum alloys		50 : 80	0,04 - 0,09
N03	Copper		30 : 60	0,06 - 0,08
N04	Brass - Bronze		40 : 70	0,06 - 0,08
N05	Lead-free brass		30 : 60	0,06 - 0,08
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		-	-