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







**Type:** Extra long twist drill

d1	d2	l1	l2
1,20	1,20	100	50,00

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	118°/130°	25°/30°	2

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

Machinable Materials				
Cod.	Material type	Machinability	Cutting speed Vc	Advancement per revolution fn
		<b>Recommended</b> Part. recommended Not recommended	(m/min)	(mm/rev)
<b>P01</b>	Unalloyed steels up to 800 N/mm2		40 : 60	0,003 - 0,007
<b>P02</b>	Low alloy steels from 800 N/mm2 to 1100 N/mm2		30 : 50	0,003 - 0,007
<b>P03</b>	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		-	-
<b>M01</b>	Ferritic stainless steels		15 : 30	0,003 - 0,007
<b>M02</b>	Martensitic stainless steels		15 : 30	0,003 - 0,007
<b>M03</b>	Martensitic stainless steels - PH		15 : 30	0,003 - 0,007
<b>M04</b>	Austenitic stainless steels		15 : 30	0,003 - 0,007
<b>K01</b>	Gray/lamellar cast iron		30 : 50	0,004 - 0,008
<b>K02</b>	Nodular/nodular cast iron		30 : 50	0,004 - 0,008
<b>N01</b>	Drawn aluminum alloys		60 : 100	0,005 - 0,012
<b>N02</b>	Die-cast aluminum alloys		50 : 80	0,005 - 0,012
<b>N03</b>	Copper		30 : 60	0,005 - 0,012
<b>N04</b>	Brass - Bronze		40 : 70	0,005 - 0,012
<b>N05</b>	Lead-free brass		30 : 60	0,005 - 0,012
<b>S01</b>	Super alloys (Inconel - Hastelloy - Nimonic)		-	-
<b>S02</b>	Pure titanium (Grade 2 - Grade 4)		-	-
<b>S03</b>	Titanium alloys (Grade 5)		-	-
<b>S04</b>	Cobalt Chrome Alloys		-	-
<b>H01</b>	Hardened steels up to 55 HRC		-	-

Machinable Materials				
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		<b>Recommended</b> <b>Part.</b> <b>recommended</b> <b>Not</b> <b>recommended</b>	(m/min)	(mm/rev)
<b>P01</b>	Unalloyed steels up to 800 N/mm2		40 : 60	0,003 - 0,007
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<b>S02</b>	Pure titanium (Grade 2 - Grade 4)		-	-
<b>S03</b>	Titanium alloys (Grade 5)		-	-
<b>S04</b>	Cobalt Chrome Alloys		-	-
<b>H01</b>	Hardened steels up to 55 HRC		-	-
<b>H02</b>	Hardened steels from 55 HRC		-	-



SWISS HIGH PRECISION TOOLS

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