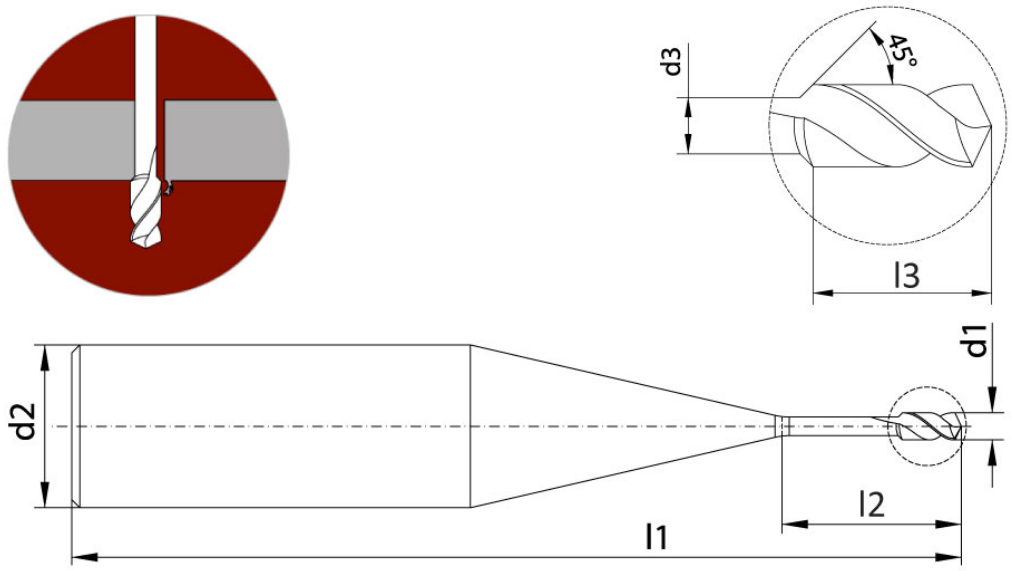

TA303B0240

Type: Combined Micro drill

d1	d2	l1	l2	l3
2,40	6,00	70	14,40	7,20

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

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

Machinable Materials				
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	0,01 - 0,02
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		30 : 50	0,007 - 0,015
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		-	-
M01	Ferritic stainless steels		-	-
M02	Martensitic stainless steels		-	-
M03	Martensitic stainless steels - PH		-	-
M04	Austenitic stainless steels		-	-
K01	Gray/lamellar cast iron		-	-
K02	Nodular/nodular cast iron		-	-
N01	Drawn aluminum alloys		30 : 50	0,01 - 0,025
N02	Die-cast aluminum alloys		60 : 100	0,01 - 0,025
N03	Copper		50 : 80	0,01 - 0,025
N04	Brass - Bronze		30 : 60	0,01 - 0,025
N05	Lead-free brass		40 : 70	0,01 - 0,025
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	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	0,01 - 0,02
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		30 : 50	0,007 - 0,015
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		-	-
M01	Ferritic stainless steels		-	-
M02	Martensitic stainless steels		-	-
M03	Martensitic stainless steels - PH		-	-
M04	Austenitic stainless steels		-	-
K01	Gray/lamellar cast iron		-	-
K02	Nodular/nodular cast iron		-	-
N01	Drawn aluminum alloys		30 : 50	0,01 - 0,025
N02	Die-cast aluminum alloys		60 : 100	0,01 - 0,025
N03	Copper		50 : 80	0,01 - 0,025
N04	Brass - Bronze		30 : 60	0,01 - 0,025
N05	Lead-free brass		40 : 70	0,01 - 0,025
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		-	-