



TA80300068

Type: Centesimal drill without coolant holes for steel

d1	d2	l1	l2	l3
0,68	3,00	38	5,50	6,10

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	130°	35°	2

Coated	Coating type	Material	Material type	Norm
Yes	ALCRONOS	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		12 : 35	0.007-0.015
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		9 : 28	0.006-0.0014
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		7 : 23	0.005-0.013
M01	Ferritic stainless steels		9 : 28	0.004-0.011
M02	Martensitic stainless steels		8 : 20	0.003-0.009
M03	Martensitic stainless steels - PH		8 : 20	0.003-0.009
M04	Austenitic stainless steels		8 : 20	0.003-0.009
K01	Gray/lamellar cast iron		12 : 35	0.005-0.0013
K02	Nodular/nodular cast iron		10 : 30	0.006-0.014
N01	Drawn aluminum alloys		19 : 45	0.05-0.013
N02	Die-cast aluminum alloys		17 : 45	0.006-0.015
N03	Copper		15 : 35	0.006-0.013
N04	Brass - Bronze		15 : 35	0.004-0.010
N05	Lead-free brass		18 : 40	0.005-0.013
S01	Super alloys (Inconel - Hastelloy - Nimonic)		7 : 23	0.005-0.013
S02	Pure titanium (Grade 2 - Grade 4)		8 : 18	0.003-0.007
S03	Titanium alloys (Grade 5)		8 : 18	0.003-0.007
S04	Cobalt Chrome Alloys		7 : 12	0.003-0.007
H01	Hardened steels up to 55 HRC		7 : 12	0.003-0.007

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		12 : 35	0.007-0.015
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		9 : 28	0.006-0.0014
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		7 : 23	0.005-0.013
M01	Ferritic stainless steels		9 : 28	0.004-0.011
M02	Martensitic stainless steels		8 : 20	0.003-0.009
M03	Martensitic stainless steels - PH		8 : 20	0.003-0.009
M04	Austenitic stainless steels		8 : 20	0.003-0.009
K01	Gray/lamellar cast iron		12 : 35	0.005-0.0013
K02	Nodular/nodular cast iron		10 : 30	0.006-0.014
N01	Drawn aluminum alloys		19 : 45	0.05-0.013
N02	Die-cast aluminum alloys		17 : 45	0.006-0.015
N03	Copper		15 : 35	0.006-0.013
N04	Brass - Bronze		15 : 35	0.004-0.010
N05	Lead-free brass		18 : 40	0.005-0.013
S01	Super alloys (Inconel - Hastelloy - Nimonic)		7 : 23	0.005-0.013
S02	Pure titanium (Grade 2 - Grade 4)		8 : 18	0.003-0.007
S03	Titanium alloys (Grade 5)		8 : 18	0.003-0.007
S04	Cobalt Chrome Alloys		7 : 12	0.003-0.007
H01	Hardened steels up to 55 HRC		7 : 12	0.003-0.007
H02	Hardened steels from 55 HRC		-	-