



TA80300086

Type: Centesimal drill without coolant holes for steel

d1	d2	l1	l2	l3
0,86	3,00	38	7,00	7,70

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 V _c	Advancement per revolution f _n
		Recommended Part. recommended Not recommended	(m/min)	(mm/rev)
P01	Unalloyed steels up to 800 N/mm ²		12 : 35	0.007-0.015
P02	Low alloy steels from 800 N/mm ² to 1100 N/mm ²		9 : 28	0.006-0.0014
P03	Highly alloyed steels from 1100 N/mm ² to 1400 N/mm ²		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		-	-