















## TA80300100





















**Type:** Centesimal drill without coolant holes for steel

d1	d2	l1	l2	l3
1,00	3,00	38	9,00	9,90

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
		<b>Recommended</b> Part. <b>recommended</b> Not <b>recommended</b>	(m/min)	(mm/rev)
<b>P01</b>	Unalloyed steels up to 800 N/mm2		12 : 35	0.007-0.015
<b>P02</b>	Low alloy steels from 800 N/mm2 to 1100 N/mm2		9 : 28	0.006-0.0014
<b>P03</b>	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		7 : 23	0.005-0.013
<b>M01</b>	Ferritic stainless steels		9 : 28	0.004-0.011
<b>M02</b>	Martensitic stainless steels		8 : 20	0.003-0.009
<b>M03</b>	Martensitic stainless steels - PH		8 : 20	0.003-0.009
<b>M04</b>	Austenitic stainless steels		8 : 20	0.003-0.009
<b>K01</b>	Gray/lamellar cast iron		12 : 35	0.005-0.0013
<b>K02</b>	Nodular/nodular cast iron		10 : 30	0.006-0.014
<b>N01</b>	Drawn aluminum alloys		19 : 45	0.05-0.013
<b>N02</b>	Die-cast aluminum alloys		17 : 45	0.006-0.015
<b>N03</b>	Copper		15 : 35	0.006-0.013
<b>N04</b>	Brass - Bronze		15 : 35	0.004-0.010
<b>N05</b>	Lead-free brass		18 : 40	0.005-0.013
<b>S01</b>	Super alloys (Inconel - Hastelloy - Nimonic)		7 : 23	0.005-0.013
<b>S02</b>	Pure titanium (Grade 2 - Grade 4)		8 : 18	0.003-0.007
<b>S03</b>	Titanium alloys (Grade 5)		8 : 18	0.003-0.007
<b>S04</b>	Cobalt Chrome Alloys		7 : 12	0.003-0.007
<b>H01</b>	Hardened steels up to 55 HRC		7 : 12	0.003-0.007

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<b>H01</b>	Hardened steels up to 55 HRC		7 : 12	0.003-0.007
<b>H02</b>	Hardened steels from 55 HRC		-	-