



TA80300101

Type: Centesimal drill without coolant holes for steel

d1	d2	l1	l2	l3
1,01	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 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		35 : 65	0.014-0.025
P02	Low alloy steels from 800 N/mm ² to 1100 N/mm ²		28 : 55	0.012-0.023
P03	Highly alloyed steels from 1100 N/mm ² to 1400 N/mm ²		23 : 50	0.011-0.020
M01	Ferritic stainless steels		28 : 55	0.010-0.018
M02	Martensitic stainless steels		20 : 35	0.008-0.016
M03	Martensitic stainless steels - PH		20 : 35	0.008-0.016
M04	Austenitic stainless steels		20 : 35	0.008-0.016
K01	Gray/lamellar cast iron		35 : 65	0.017-0.025
K02	Nodular/nodular cast iron		30 : 55	0.012-0.022
N01	Drawn aluminum alloys		45 : 80	0.012-0.020
N02	Die-cast aluminum alloys		45 : 70	0.014-0.022
N03	Copper		35 : 65	0.012-0.020
N04	Brass - Bronze		35 : 65	0.009-0.016
N05	Lead-free brass		40 : 70	0.012-0.020
S01	Super alloys (Inconel - Hastelloy - Nimonic)		23 : 50	0.012-0.020
S02	Pure titanium (Grade 2 - Grade 4)		18 : 35	0.006-0.011
S03	Titanium alloys (Grade 5)		18 : 35	0.006-0.011
S04	Cobalt Chrome Alloys		12 : 20	0.006-0.011
H01	Hardened steels up to 55 HRC		12 : 20	0.006-0.011

Machinable Materials				
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		Recommended Part. recommended Not recommended	(m/min)	(mm/rev)
P01	Unalloyed steels up to 800 N/mm2		35 : 65	0.014-0.025
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		28 : 55	0.012-0.023
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		23 : 50	0.011-0.020
M01	Ferritic stainless steels		28 : 55	0.010-0.018
M02	Martensitic stainless steels		20 : 35	0.008-0.016
M03	Martensitic stainless steels - PH		20 : 35	0.008-0.016
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K01	Gray/lamellar cast iron		35 : 65	0.017-0.025
K02	Nodular/nodular cast iron		30 : 55	0.012-0.022
N01	Drawn aluminum alloys		45 : 80	0.012-0.020
N02	Die-cast aluminum alloys		45 : 70	0.014-0.022
N03	Copper		35 : 65	0.012-0.020
N04	Brass - Bronze		35 : 65	0.009-0.016
N05	Lead-free brass		40 : 70	0.012-0.020
S01	Super alloys (Inconel - Hastelloy - Nimonic)		23 : 50	0.012-0.020
S02	Pure titanium (Grade 2 - Grade 4)		18 : 35	0.006-0.011
S03	Titanium alloys (Grade 5)		18 : 35	0.006-0.011
S04	Cobalt Chrome Alloys		12 : 20	0.006-0.011
H01	Hardened steels up to 55 HRC		12 : 20	0.006-0.011
H02	Hardened steels from 55 HRC		-	-