





## TA80300117

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





















d1	d2	l1	l2	l3
1,17	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. recommended Not recommended	(m/min)	(mm/rev)
<b>P01</b>	Unalloyed steels up to 800 N/mm2		35 : 65	0.014-0.025
<b>P02</b>	Low alloy steels from 800 N/mm2 to 1100 N/mm2		28 : 55	0.012-0.023
<b>P03</b>	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		23 : 50	0.011-0.020
<b>M01</b>	Ferritic stainless steels		28 : 55	0.010-0.018
<b>M02</b>	Martensitic stainless steels		20 : 35	0.008-0.016
<b>M03</b>	Martensitic stainless steels - PH		20 : 35	0.008-0.016
<b>M04</b>	Austenitic stainless steels		20 : 35	0.008-0.016
<b>K01</b>	Gray/lamellar cast iron		35 : 65	0.017-0.025
<b>K02</b>	Nodular/nodular cast iron		30 : 55	0.012-0.022
<b>N01</b>	Drawn aluminum alloys		45 : 80	0.012-0.020
<b>N02</b>	Die-cast aluminum alloys		45 : 70	0.014-0.022
<b>N03</b>	Copper		35 : 65	0.012-0.020
<b>N04</b>	Brass - Bronze		35 : 65	0.009-0.016
<b>N05</b>	Lead-free brass		40 : 70	0.012-0.020
<b>S01</b>	Super alloys (Inconel - Hastelloy - Nimonic)		23 : 50	0.012-0.020
<b>S02</b>	Pure titanium (Grade 2 - Grade 4)		18 : 35	0.006-0.011
<b>S03</b>	Titanium alloys (Grade 5)		18 : 35	0.006-0.011
<b>S04</b>	Cobalt Chrome Alloys		12 : 20	0.006-0.011
<b>H01</b>	Hardened steels up to 55 HRC		12 : 20	0.006-0.011

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<b>H01</b>	Hardened steels up to 55 HRC		12 : 20	0.006-0.011
<b>H02</b>	Hardened steels from 55 HRC		-	-