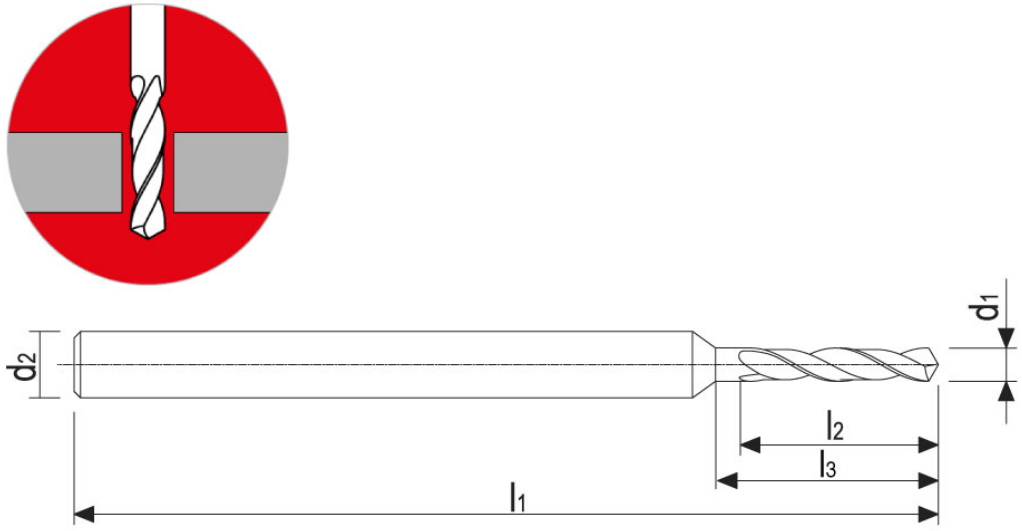

TA80300184

Type: Centesimal drill without coolant holes for steel

d1	d2	l1	l2	l3
1,84	3,00	38	12,00	13,20

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		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
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				
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		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
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
H02	Hardened steels from 55 HRC		-	-