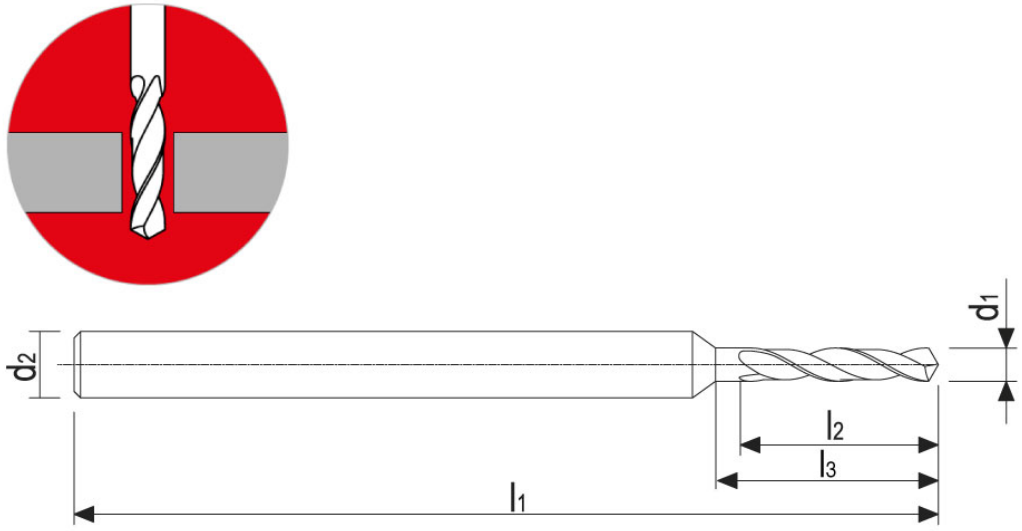

TA80300250

Type: Centesimal drill without coolant holes for steel

d1	d2	l1	l2	l3
2,50	3,00	50	15,00	16,50

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	0.023-0.035
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		28 : 55	0.021-0.032
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		23 : 50	0.018-0.03
M01	Ferritic stainless steels		28 : 55	0.016-0.028
M02	Martensitic stainless steels		20 : 35	0.016-0.028
M03	Martensitic stainless steels - PH		20 : 35	0.016-0.028
M04	Austenitic stainless steels		20 : 35	0.016-0.028
K01	Gray/lamellar cast iron		35 : 65	0.023-0.035
K02	Nodular/nodular cast iron		30 : 55	0.020-0.032
N01	Drawn aluminum alloys		45 : 80	0.018-0.030
N02	Die-cast aluminum alloys		45 : 70	0.020-0.035
N03	Copper		35 : 65	0.018-0.032
N04	Brass - Bronze		35 : 65	0.015-0.025
N05	Lead-free brass		40 : 70	0.018-0.032
S01	Super alloys (Inconel - Hastelloy - Nimonic)		23 : 50	0.018-0.030
S02	Pure titanium (Grade 2 - Grade 4)		18 : 35	0.010-0.018
S03	Titanium alloys (Grade 5)		18 : 35	0.010-0.018
S04	Cobalt Chrome Alloys		12 : 20	0.010-0.018
H01	Hardened steels up to 55 HRC		12 : 20	0.010-0.018

Machinable Materials				
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N03	Copper		35 : 65	0.018-0.032
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N05	Lead-free brass		40 : 70	0.018-0.032
S01	Super alloys (Inconel - Hastelloy - Nimonic)		23 : 50	0.018-0.030
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S03	Titanium alloys (Grade 5)		18 : 35	0.010-0.018
S04	Cobalt Chrome Alloys		12 : 20	0.010-0.018
H01	Hardened steels up to 55 HRC		12 : 20	0.010-0.018
H02	Hardened steels from 55 HRC		-	-