




















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













Type: Long drill with reinforced shank

d1	d2	l1	l2
1,15	3,00	53	8,30

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	140°	30°	2

Coated	Coating type	Material	Material type	Norm
Yes	TiAlN	MD	SMG SP	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		80 : 120	0,115
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		60 : 100	0,115
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		40 : 80	0,090
M01	Ferritic stainless steels		20 : 40	0,030
M02	Martensitic stainless steels		25 : 50	0,045
M03	Martensitic stainless steels - PH		20 : 30	0,030
M04	Austenitic stainless steels		20 : 30	0,030
K01	Gray/lamellar cast iron		80 : 120	0,190
K02	Nodular/nodular cast iron		80 : 120	0,190
N01	Drawn aluminum alloys		150 : 200	0,080
N02	Die-cast aluminum alloys		150 : 200	0,072
N03	Copper		80 : 120	0,055
N04	Brass - Bronze		60 : 100	0,068
N05	Lead-free brass		100 : 140	0,055
S01	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 40	0,004
S02	Pure titanium (Grade 2 - Grade 4)		20 : 40	0,030
S03	Titanium alloys (Grade 5)		15 : 30	0,040
S04	Cobalt Chrome Alloys		20 : 40	0,015
H01	Hardened steels up to 55 HRC		20 : 40	0,008

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H02	Hardened steels from 55 HRC		15 : 30	0,004



SWISS HIGH PRECISION TOOLS
