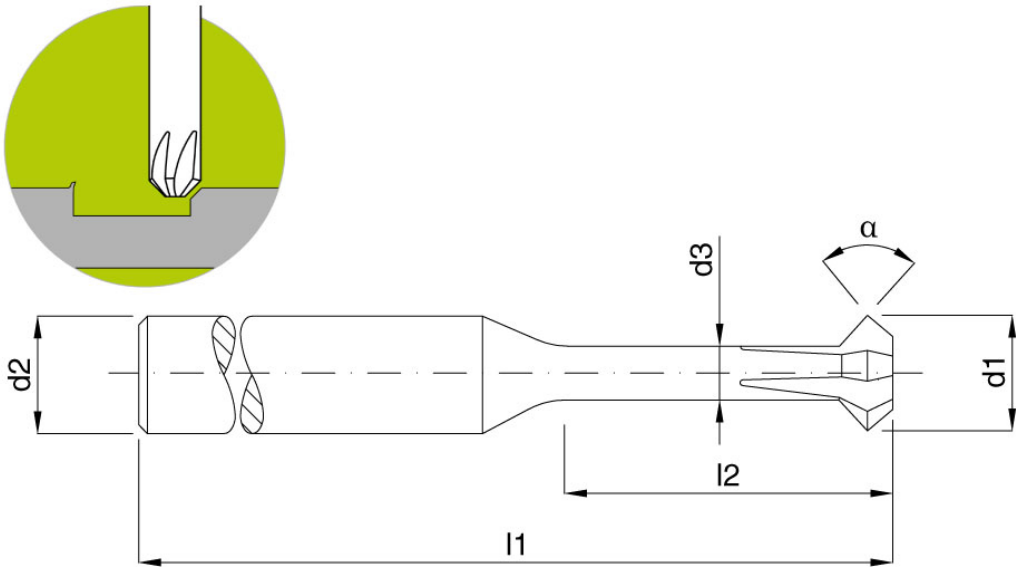

TTMCD90020

Type: Smussatore doppio 90°

d1	d2	d3	l1
1,80	4,00	0,90	64

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	90°	10°	5

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		120	0.03
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		100	0.02
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		80	0.05
M01	Ferritic stainless steels		50	0.01
M02	Martensitic stainless steels		80	0.015
M03	Martensitic stainless steels - PH		-	-
M04	Austenitic stainless steels		50	0,015
K01	Gray/lamellar cast iron		60	0.015
K02	Nodular/nodular cast iron		60	0.015
N01	Drawn aluminum alloys		200	0.03
N02	Die-cast aluminum alloys		200	0.03
N03	Copper		40	0.02
N04	Brass - Bronze		200	0.03
N05	Lead-free brass		40	0.02
S01	Super alloys (Inconel - Hastelloy - Nimonic)		40	0.02
S02	Pure titanium (Grade 2 - Grade 4)		40	0.02
S03	Titanium alloys (Grade 5)		40	0.02
S04	Cobalt Chrome Alloys		50	0,015
H01	Hardened steels up to 55 HRC		60	0.015

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	🟢	120	0.03
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2	🟢	100	0.02
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2	🟢	80	0.05
M01	Ferritic stainless steels	🟢	50	0.01
M02	Martensitic stainless steels	🟢	80	0.015
M03	Martensitic stainless steels - PH	🔴	-	-
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S02	Pure titanium (Grade 2 - Grade 4)	🟢	40	0.02
S03	Titanium alloys (Grade 5)	🟢	40	0.02
S04	Cobalt Chrome Alloys	🟢	50	0,015
H01	Hardened steels up to 55 HRC	🟢	60	0.015
H02	Hardened steels from 55 HRC	🔴	-	-