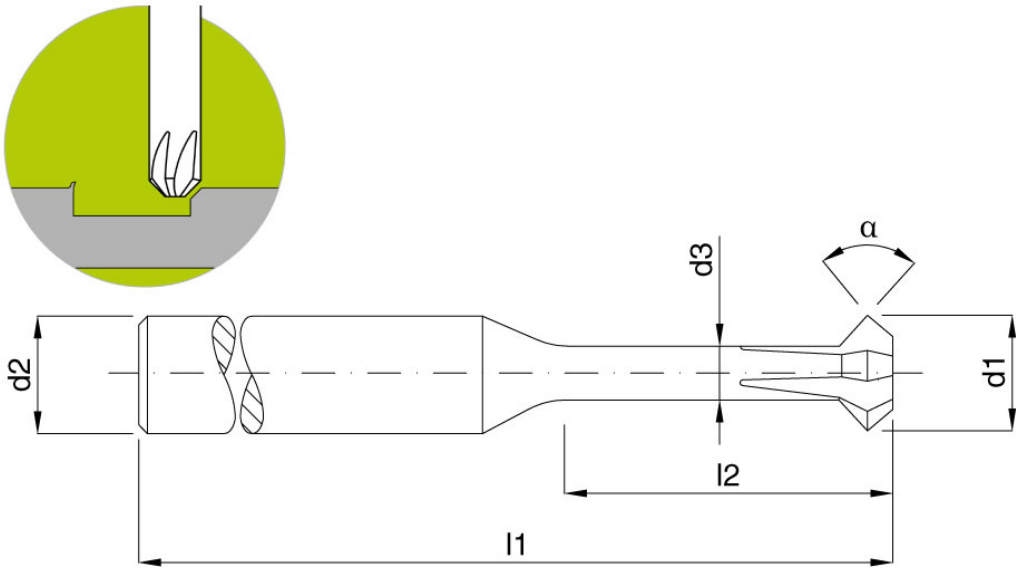

TTMCD90040

d1	d2	d3	l1

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
		90°	10°	

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

Machinable Materials				
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S03	Titanium alloys (Grade 5)		40	
S04	Cobalt Chrome Alloys		50	
H01	Hardened steels up to 55 HRC		60	
H02	Hardened steels from 55 HRC		-	