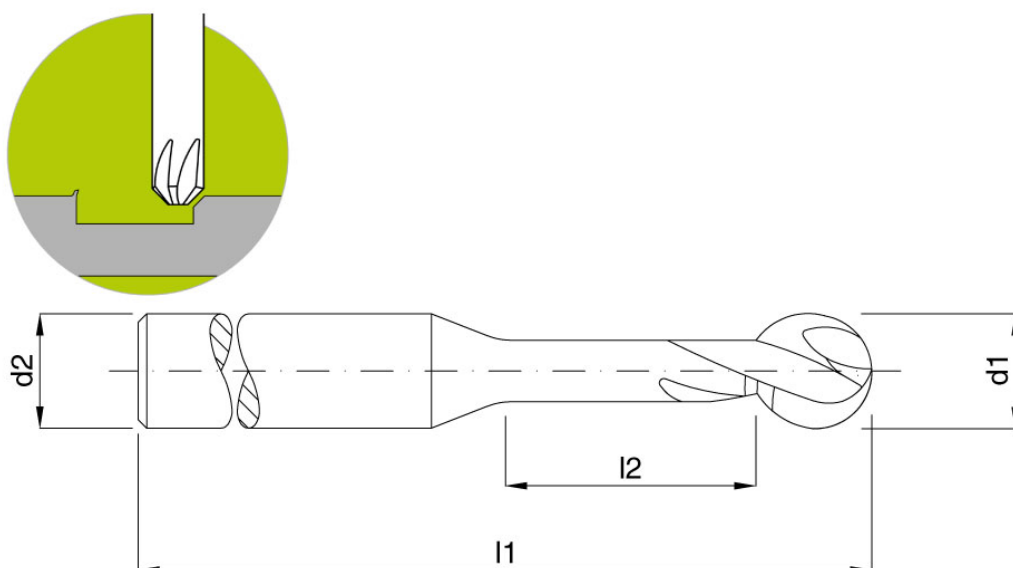




TTMCR90020

Type: Radius chamfer

d1	d2	r	l1	l2
2,00	4,00	1,00	64	64

Coolant holes	Cut	Spiral angle	Cutting edges Z
No	Right	10°	3

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	0,020
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		80	0,050
M01	Ferritic stainless steels		50	0,010
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	0,030
N02	Die-cast aluminum alloys		200	0,030
N03	Copper		40	0,020
N04	Brass - Bronze		200	0,030
N05	Lead-free brass		40	0,020
S01	Super alloys (Inconel - Hastelloy - Nimonic)		40	0,020
S02	Pure titanium (Grade 2 - Grade 4)		40	0,020
S03	Titanium alloys (Grade 5)		40	0,020
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	0,020
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		80	0,050
M01	Ferritic stainless steels		50	0,010
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	0,030
N02	Die-cast aluminum alloys		200	0,030
N03	Copper		40	0,020
N04	Brass - Bronze		200	0,030
N05	Lead-free brass		40	0,020
S01	Super alloys (Inconel - Hastelloy - Nimonic)		40	0,020
S02	Pure titanium (Grade 2 - Grade 4)		40	0,020
S03	Titanium alloys (Grade 5)		40	0,020
S04	Cobalt Chrome Alloys		50	0,015
H01	Hardened steels up to 55 HRC		60	0.015
H02	Hardened steels from 55 HRC		-	-