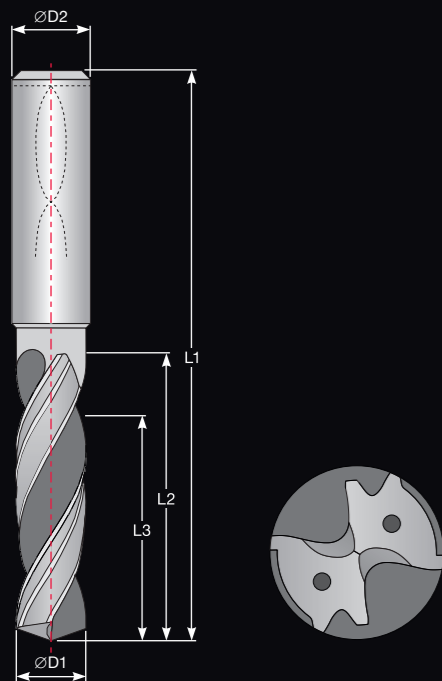


SPEED DREAMER 3xD MK23703

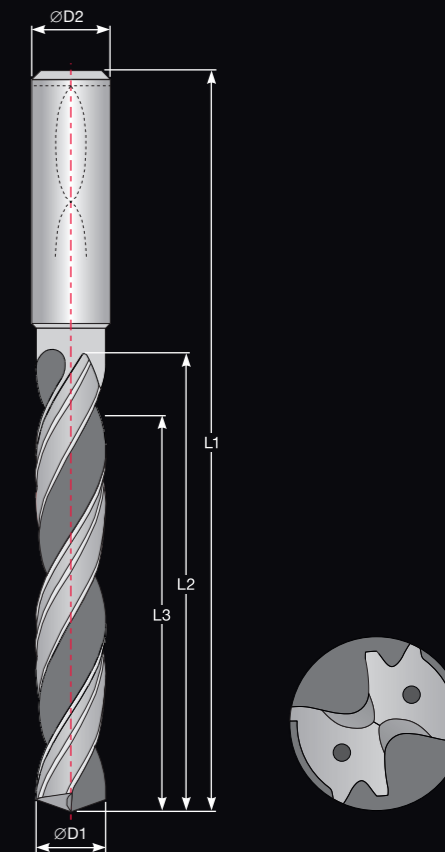


DESIGN

HELIX // 30° RIGHT HELIX
 CUTTING DIRECTION // R.H.C.
 POINT ANGLE // 140°
 POINT GRINDING // RELIEVED CONE
 COATING // GTX
 COOLANT // INTERNAL
 SHANK // DIN 6535 HA

Art. Nr.	D1	Tol.	D2	L1	L2	L3
Order No.	∅	±	h6	L2	L2	L3
MK23703-0397	3,97	0,003	6	66	24	17
MK23703-0398	3,98	0,003	6	66	24	17
MK23703-0399	3,99	0,003	6	66	24	17
MK23703-0400	4	0,003	6	66	24	17
MK23703-04H7	4	H7	6	66	24	17
MK23703-0401	4,01	0,003	6	66	24	17
MK23703-0402	4,02	0,003	6	66	24	17
MK23703-0403	4,03	0,003	6	66	24	17
MK23703-0497	4,97	0,003	6	66	28	20
MK23703-0498	4,98	0,003	6	66	28	20
MK23703-0499	4,99	0,003	6	66	28	20
MK23703-0500	5	0,003	6	66	28	20
MK23703-05H7	5	H7	6	66	28	20
MK23703-0501	5,01	0,003	6	66	28	20
MK23703-0502	5,02	0,003	6	66	28	20
MK23703-0503	5,03	0,003	6	66	28	20
MK23703-0597	5,97	0,003	6	66	28	20
MK23703-0598	5,98	0,003	6	66	28	20
MK23703-0599	5,99	0,003	6	66	28	20
MK23703-0600	6	0,003	6	66	28	20
MK23703-06H7	6	H7	6	66	28	20
MK23703-0601	6,01	0,003	6	66	28	20
MK23703-0602	6,02	0,003	6	66	28	20
MK23703-0603	6,03	0,003	6	66	28	20
MK23703-07H7	7	H7	8	79	34	24
MK23703-0797	7,97	0,003	8	79	34	24
MK23703-0798	7,98	0,003	8	79	34	24
MK23703-0799	7,99	0,003	8	79	34	24
MK23703-0800	8	0,003	8	79	34	24
MK23703-08H7	8	H7	8	79	34	24
MK23703-0801	8,01	0,003	8	79	34	24
MK23703-0802	8,02	0,003	8	79	34	24
MK23703-0803	8,03	0,003	8	79	34	24
MK23703-09H7	9	H7	10	89	47	35
MK23703-0997	9,97	0,003	10	89	47	35
MK23703-0998	9,98	0,003	10	89	47	35
MK23703-0999	9,99	0,003	10	89	47	35
MK23703-1000	10	0,003	10	89	47	35
MK23703-10H7	10	H7	10	89	47	35
MK23703-1001	10,01	0,003	10	89	47	35
MK23703-1002	10,02	0,003	10	89	47	35
MK23703-1003	10,03	0,003	10	89	47	35
MK23703-1197	11,97	0,003	12	102	55	40
MK23703-1198	11,98	0,003	12	102	55	40
MK23703-1199	11,99	0,003	12	102	55	40
MK23703-1200	12	0,003	12	102	55	40
MK23703-12H7	12	H7	12	102	55	40
MK23703-1201	12,01	0,003	12	102	55	40
MK23703-1202	12,02	0,003	12	102	55	40
MK23703-1203	12,03	0,003	12	102	55	40
MK23703-14H7	14	H7	14	107	60	43
MK23703-16H7	16	H7	16	115	65	45
MK23703-18H7	18	H7	18	123	73	51
MK237033-20H7	20	H7	20	131	79	55

SPEED DREAMER 5xD MK23705



DESIGN

HELIX // 30° RIGHT HELIX
 CUTTING DIRECTION // R.H.C.
 POINT ANGLE // 140°
 POINT GRINDING // RELIEVED CONE
 COATING // GTX
 COOLANT // INTERNAL
 SHANK // DIN 6535 HA

Art. Nr.	D1	Tol.	D2	L1	L2	L3
Order No.	∅	±	h6	L2	L2	L3
MK23705-0397	3,97	0,003	6	74	36	29
MK23705-0398	3,98	0,003	6	74	36	29
MK23705-0399	3,99	0,003	6	74	36	29
MK23705-0400	4	0,003	6	74	36	29
MK23705-04H7	4	H7	6	74	36	29
MK23705-0401	4,01	0,003	6	74	36	29
MK23705-0402	4,02	0,003	6	74	36	29
MK23705-0403	4,03	0,003	6	74	36	29
MK23705-0497	4,97	0,003	6	82	44	35
MK23705-0498	4,98	0,003	6	82	44	35
MK23705-0499	4,99	0,003	6	82	44	35
MK23705-0500	5	0,003	6	82	44	35
MK23705-05H7	5	H7	6	82	44	35
MK23705-0501	5,01	0,003	6	82	44	35
MK23705-0502	5,02	0,003	6	82	44	35
MK23705-0503	5,03	0,003	6	82	44	35
MK23705-0597	5,97	0,003	6	82	44	35
MK23705-0598	5,98	0,003	6	82	44	35
MK23705-0599	5,99	0,003	6	82	44	35
MK23705-0600	6	0,003	6	82	44	35
MK23705-06H7	6	H7	6	82	44	35
MK23705-0601	6,01	0,003	6	82	44	35
MK23705-0602	6,02	0,003	6	82	44	35
MK23705-0603	6,03	0,003	6	82	44	35
MK23705-07H7	7	H7	8	91	53	43
MK23705-0797	7,97	0,003	8	91	53	43
MK23705-0798	7,98	0,003	8	91	53	43
MK23705-0799	7,99	0,003	8	91	53	43
MK23705-0800	8	0,003	8	91	53	43
MK23705-08H7	8	H7	8	91	53	43
MK23705-0801	8,01	0,003	8	91	53	43
MK23705-0802	8,02	0,003	8	91	53	43
MK23705-0803	8,03	0,003	8	91	53	43
MK23705-09H7	9	H7	10	103	61	49
MK23705-0997	9,97	0,003	10	103	61	49
MK23705-0998	9,98	0,003	10	103	61	49
MK23705-0999	9,99	0,003	10	103	61	49
MK23705-1000	10	0,003	10	103	61	49
MK23705-10H7	10	H7	10	103	61	49
MK23705-1001	10,01	0,003	10	103	61	49
MK23705-1002	10,02	0,003	10	103	61	49
MK23705-1003	10,03	0,003	10	103	61	49
MK23705-1197	11,97	0,003	12	118	71	56
MK23705-1198	11,98	0,003	12	118	71	56
MK23705-1199	11,99	0,003	12	118	71	56
MK23705-1200	12	0,003	12	118	71	56
MK23705-12H7	12	H7	12	118	71	56
MK23705-1201	12,01	0,003	12	118	71	56
MK23705-1202	12,02	0,003	12	118	71	56
MK23705-1203	12,03	0,003	12	118	71	56
MK23705-14H7	14	H7	14	124	77	60
MK23705-16H7	16	H7	16	133	83	63
MK23705-18H7	18	H7	18	143	93	71
MK23705-20H7	20	H7	20	153	101	77

SPEED DREAMER.

MAIN APPLICATION: unalloyed steel, cast steel, alloyed steel up to 1000 N/mm², cast iron (>= GGG50)

For manufacturing of fit bores with quality IT7 and burr-free hole exits.

GEOMETRY: cone relief point, cross web thinning (Form C), parabolic flute, straight cutting edge, honed cutting edge, 6 guide lands

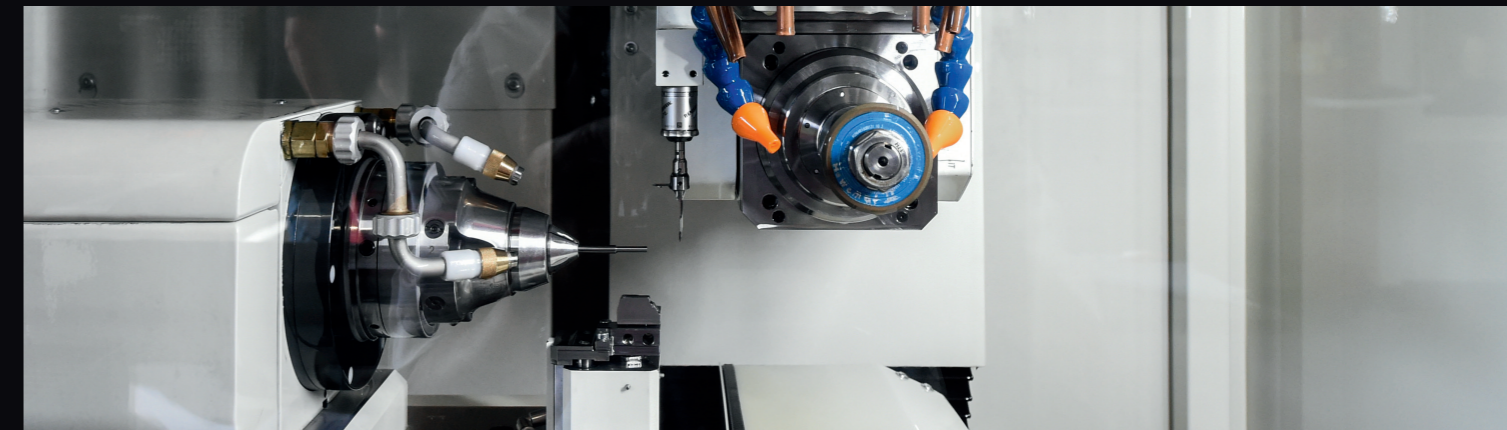
CUTTING DATA.

	Zu bearbeitendes Material Material to be machined	Zugfestigkeit Tensile strength [N/mm ²]	Beispiel Example	Schnittgeschwindigkeit V _c Cutting speed V _c [m/min]	Vorschub f feed f [mm/rev]					
					Ø6	Ø8	Ø10	Ø12	Ø16	Ø20
P	Unlegierter Stahl, Stahlguss non-alloy steels, cast steels	< 600 N/mm ²	St37, C22, GS38	100-120	0,15	0,2	0,25	0,3	0,36	0,4
		< 700 N/mm ²	St52, C35, GS52	90-110	0,15	0,2	0,25	0,3	0,36	0,4
		> 700 N/mm ²	St70, C45, GS62	80-100	0,15	0,2	0,25	0,3	0,36	0,4
	Legierter Stahl alloyed steel	< 900 N/mm ²	16MnCr5, 42CrMo4	80-95	0,15	0,2	0,25	0,3	0,36	0,4
		< 1000 N/mm ²	90MnCrV8, 100Cr6	65-80	0,14	0,18	0,22	0,26	0,3	0,35
		> 1000 N/mm ²	X210Cr12, 34CrAlNi7	45-65	0,12	0,16	0,2	0,24	0,3	0,35
M	Rostfreie und säurebest. Stähle Stainless steels		X5 CrNi 18 9 (V2A) X 10 CrNiMoTi 18 10							
K	Grauguss, legierter Grauguss Grey cast iron, grey cast iron alloy	< 200 HB	GG20 GG25, GTS45	100-130	0,22	0,28	0,34	0,38	0,44	0,5
		< 250 HB	GG30, GTW40	90-120	0,2	0,25	0,3	0,35	0,4	0,45
	> 250 HB	GG40, GTS70	80-100	0,2	0,25	0,3	0,35	0,4	0,45	
	Sphäroguss, Vermikularguss Spheroidal graphite cast iron, CGI	< 600 N/mm ²	GGG40, GGG50	90-120	0,2	0,25	0,3	0,35	0,4	0,45
> 600 N/mm ²		GGG60, GGV (CGI)	70-90	0,18	0,24	0,25	0,3	0,35	0,4	
N	Aluminium-Knetlegierungen		AlCuMgPb, AlMgSi0.5							
	Aluminium (Si < 10%)		GD-AlSi9Cu3, AISi7Mg0.6							
	Aluminium (Si > 10%)		GB.AISi12 (Cu)							
S	Kupfer, Messing, Bronze Copper, brass, bronze									
	Titanlegierungen Titanium alloys		Ti6Al4V							
	Nickellegierungen Nickel alloys		Inconel, Monel, Hasteloy							

INTERMEDIATE SIZES.

We are looking forward to manufacture any kind of drills with intermediate sizes for you. For actual lead time please ask our sales department. The price surcharge against your net price is shown adjacent.

REGRINDING SERVICE.



Of course we offer the possibility to regrind your carbide cutting tools (incl. third-party items) at MK Tools service. We are sharpening standard tools as well as any kind of special tool.

All tools are ground on CNC machining centres with original geometry, if possible. By the use of most modern measuring

technology and quality control we guarantee nearly 100% of the performance of new tools.

Our lead time (incl. coating) is maximum 10 working days.

By request we will send you a price list with regrinding prices for most common carbide tools.

SOLID CARBIDE SPECIAL TOOLS.

WHETHER DRILLING, COUNTERBORING, REAMING OR MILLING TOOL. WITH MK TOOLS SERVICE YOU MAKE THE RIGHT CHOICE.

- Exclusive production on ultra-modern CNC grinding centres (as a result we guarantee absolute repeat accuracy)
- Tool geometries for highest cutting data and tool life
- Tools for all common materials
- Use of newest premium carbide grades
- Best possible coating
- Professional consulting and service
- Decades of professional experience in the field of cutting tools
- Individual solutions for your machining problems
- Rapid and reliable delivery dates

IN ADDITION TO SOLID CARBIDE SPECIAL TOOLS MK TOOLS SERVICE OFFERS A WIDE RANGE OF HIGH-PERFORMANCE CUTTING TOOLS.

- PCD-tipped cutting tools in highest quality
- Tools with carbide-tipped cutting edges
- Special tools with ISO-indexable inserts
- Thread milling cutters, slitting saws etc.

PROJECT ENGINEERING.

- Complete tool design for your components
- OEM projects in cooperation with machine tool builders
- Optimization of existing machining processes
- CAD drawings in ISG layer format



INFORMATION.



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