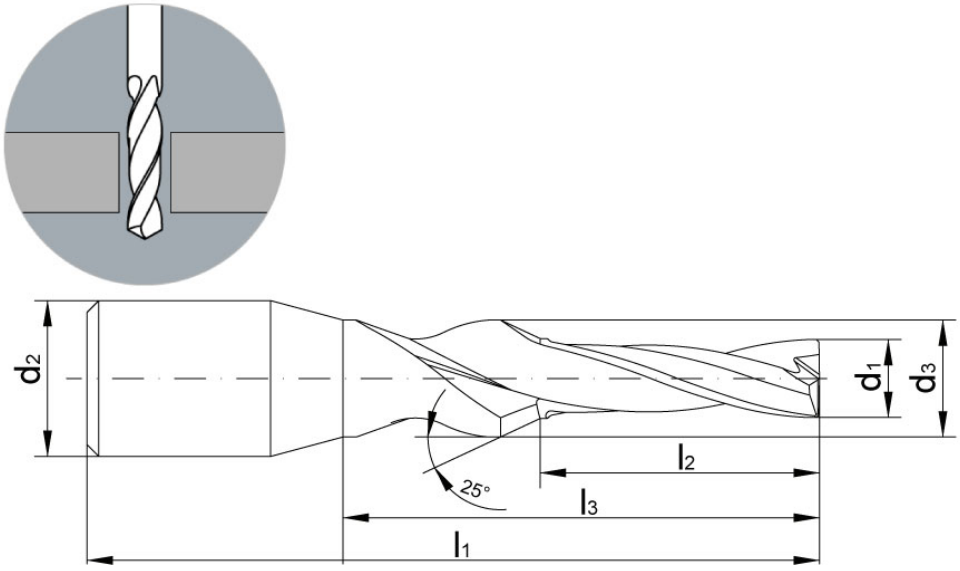


# TTD1800100E

**Type:** 180° Pilot Drill with reinforced shank

| d1 | d2 | d3 | l1 | l2 | l3 |
|---|---|---|---|---|---|
| 1,00 | 4,00 | 2,00 | 40 | 3,50 | 7,00 |

| Coolant holes | Cut | Point angle | Spiral angle | Chamfer | Cutting edges Z |
|---|---|---|---|---|---|
| No | Right | 180° | Variabile | 25° | 2 |

| 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 | | 65 : 80 | 0.08-0.10 |
| P02 | Low alloy steels from 800 N/mm2 to 1100 N/mm2 | | 50 : 60 | 0.006-0.008 |
| P03 | Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2 | | 40 : 50 | 0.006-0.008 |
| M01 | Ferritic stainless steels | | 35 : 40 | 0.003-0.004 |
| M02 | Martensitic stainless steels | | 40 : 50 | 0.006 -0.008 |
| M03 | Martensitic stainless steels - PH | | 40 : 50 | 0.006 -0.008 |
| M04 | Austenitic stainless steels | | 25 : 30 | 0.003-0.004 |
| K01 | Gray/lamellar cast iron | | 70 : 80 | 0.008-0.010 |
| K02 | Nodular/nodular cast iron | | 60 : 70 | 0.008-0.010 |
| N01 | Drawn aluminum alloys | | 115 : 125 | 0.010-0.015 |
| N02 | Die-cast aluminum alloys | | 115 : 125 | 0.010-0.015 |
| N03 | Copper | | 65 : 80 | 0.006-0.008 |
| N04 | Brass - Bronze | | 90 : 100 | 0.010-0.015 |
| N05 | Lead-free brass | | 80 : 90 | 0.006-0.008 |
| S01 | Super alloys (Inconel - Hastelloy - Nimonic) | | 15 : 20 | 0.002-0.003 |
| S02 | Pure titanium (Grade 2 - Grade 4) | | 20 : 30 | 0.006-0.008 |
| S03 | Titanium alloys (Grade 5) | | 20 : 30 | 0.006-0.008 |
| S04 | Cobalt Chrome Alloys | | 15 : 20 | 0.003-0.004 |
| H01 | Hardened steels up to 55 HRC | | 15 : 20 | 0.002-0.003 |
| H02 | Hardened steels from 55 HRC | | - | - |