



## TTD1800140E

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

d1	d2	d3	l1	l2	l3
1,40	4,00	2,80	40	4,90	9,80

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
		<b>Recommended</b> Part. recommended <b>Not</b> recommended	(m/min)	(mm/rev)
<b>P01</b>	Unalloyed steels up to 800 N/mm2		65 : 80	0.010-0.015
<b>P02</b>	Low alloy steels from 800 N/mm2 to 1100 N/mm2		50 : 60	0.008-0.013
<b>P03</b>	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		40 : 50	0.008-0.013
<b>M01</b>	Ferritic stainless steels		35 : 40	0.005-0.006
<b>M02</b>	Martensitic stainless steels		40 : 50	0.010-0.012
<b>M03</b>	Martensitic stainless steels - PH		40 : 50	0.010-0.012
<b>M04</b>	Austenitic stainless steels		25 : 30	0.005-0.006
<b>K01</b>	Gray/lamellar cast iron		70 : 80	0.010-0.015
<b>K02</b>	Nodular/nodular cast iron		60 : 70	0.010-0.015
<b>N01</b>	Drawn aluminum alloys		115 : 125	0.015-0.020
<b>N02</b>	Die-cast aluminum alloys		115 : 125	0.015-0.020
<b>N03</b>	Copper		65 : 80	0.008-0.013
<b>N04</b>	Brass - Bronze		90 : 100	0.015-0.020
<b>N05</b>	Lead-free brass		80 : 90	0.008-0.013
<b>S01</b>	Super alloys (Inconel - Hastelloy - Nimonic)		15 : 20	0.004-0.005
<b>S02</b>	Pure titanium (Grade 2 - Grade 4)		20 : 30	0.010-0.012
<b>S03</b>	Titanium alloys (Grade 5)		20 : 30	0.010-0.012
<b>S04</b>	Cobalt Chrome Alloys		15 : 20	0.005-0.006
<b>H01</b>	Hardened steels up to 55 HRC		15 : 20	0.004-0.005
<b>H02</b>	Hardened steels from 55 HRC		-	-