



## TTD1800250E

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

d1	d2	d3	l1	l2	l3
2,50	6,00	4,00	50	8,80	14,00

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)
<b>P01</b>	Unalloyed steels up to 800 N/mm2		65 : 80	0.025-0.03
<b>P02</b>	Low alloy steels from 800 N/mm2 to 1100 N/mm2		50 : 60	0.023-0.028
<b>P03</b>	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		40 : 50	0.023-0.028
<b>M01</b>	Ferritic stainless steels		35 : 40	0.009-0.010
<b>M02</b>	Martensitic stainless steels		40 : 50	0.018-0.020
<b>M03</b>	Martensitic stainless steels - PH		40 : 50	0.018-0.020
<b>M04</b>	Austenitic stainless steels		25 : 30	0.009-0.010
<b>K01</b>	Gray/lamellar cast iron		70 : 80	0.025-0.03
<b>K02</b>	Nodular/nodular cast iron		60 : 70	0.025-0.03
<b>N01</b>	Drawn aluminum alloys		115 : 125	0.035-0.045
<b>N02</b>	Die-cast aluminum alloys		115 : 125	0.035-0.045
<b>N03</b>	Copper		65 : 80	0.023-0.028
<b>N04</b>	Brass - Bronze		90 : 100	0.035-0.045
<b>N05</b>	Lead-free brass		80 : 90	0.023-0.028
<b>S01</b>	Super alloys (Inconel - Hastelloy - Nimonic)		15 : 20	0.010-0.011
<b>S02</b>	Pure titanium (Grade 2 - Grade 4)		20 : 30	0.022-0.026
<b>S03</b>	Titanium alloys (Grade 5)		20 : 30	0.022-0.026
<b>S04</b>	Cobalt Chrome Alloys		15 : 20	0.009-0.010
<b>H01</b>	Hardened steels up to 55 HRC		15 : 20	0.010-0.011
<b>H02</b>	Hardened steels from 55 HRC		-	-