



## TTD1800400E

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

| d1   | d2   | d3 | l1 | l2 | l3 |
|------|------|----|----|----|----|
| 4,00 | 6,00 | -  | 60 | 14 | -  |

| Coolant holes | Cut   | Point angle | Spiral angle | Chamfer | Cutting edges<br>Z |
|---------------|-------|-------------|--------------|---------|--------------------|
| No            | Right | 180°        | Variable     | 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<br>Part.<br>recommended Not<br>recommended                              | (m/min)          | (mm/rev)                      |
| P01                  | Unalloyed steels up to 800 N/mm2                    |    | 65 : 80          | 0.035-0.040                   |
| P02                  | Low alloy steels from 800 N/mm2 to 1100 N/mm2       |    | 50 : 60          | 0.033-0.038                   |
| P03                  | Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2 |    | 40 : 50          | 0.033-0.038                   |
| M01                  | Ferritic stainless steels                           |    | 35 : 40          | 0.017-0.019                   |
| M02                  | Martensitic stainless steels                        |    | 40 : 50          | 0.034-0.038                   |
| M03                  | Martensitic stainless steels - PH                   |    | 40 : 50          | 0.034-0.038                   |
| M04                  | Austenitic stainless steels                         |   | 25 : 30          | 0.017-0.019                   |
| K01                  | Gray/lamellar cast iron                             |  | 70 : 80          | 0.035-0.040                   |
| K02                  | Nodular/nodular cast iron                           |  | 60 : 70          | 0.035-0.040                   |
| N01                  | Drawn aluminum alloys                               |  | 115 : 125        | 0.055-0.065                   |
| N02                  | Die-cast aluminum alloys                            |  | 115 : 125        | 0.055-0.065                   |
| N03                  | Copper                                              |  | 65 : 80          | 0.033-0.038                   |
| N04                  | Brass - Bronze                                      |  | 90 : 100         | 0.055-0.065                   |
| N05                  | Lead-free brass                                     |  | 80 : 90          | 0.033-0.038                   |
| S01                  | Super alloys (Inconel - Hastelloy - Nimonic)        |  | 15 : 20          | 0.014-0.015                   |
| S02                  | Pure titanium (Grade 2 - Grade 4)                   |  | 20 : 30          | 0.034-0.038                   |
| S03                  | Titanium alloys (Grade 5)                           |  | 20 : 30          | 0.034-0.038                   |
| S04                  | Cobalt Chrome Alloys                                |  | 15 : 20          | 0.017-0.019                   |
| H01                  | Hardened steels up to 55 HRC                        |  | 15 : 20          | 0.014-0.015                   |
| H02                  | Hardened steels from 55 HRC                         |  | -                | -                             |