



TTD1800420E

Type: 180° Pilot Drill with reinforced shank

d1	d2	d3	l1	l2	l3
4,20	6,00	-	60	14,7	-

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	0.040-0.045
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		50 : 60	0.038-0.043
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		40 : 50	0.038-0.043
M01	Ferritic stainless steels		35 : 40	0.020-0.022
M02	Martensitic stainless steels		40 : 50	0.040-0.044
M03	Martensitic stainless steels - PH		40 : 50	0.040-0.044
M04	Austenitic stainless steels		25 : 30	0.020-0.022
K01	Gray/lamellar cast iron		70 : 80	0.040-0.045
K02	Nodular/nodular cast iron		60 : 70	0.040-0.045
N01	Drawn aluminum alloys		115 : 125	0.065-0.075
N02	Die-cast aluminum alloys		115 : 125	0.065-0.075
N03	Copper		65 : 80	0.038-0.043
N04	Brass - Bronze		90 : 100	0.065-0.075
N05	Lead-free brass		80 : 90	0.038-0.043
S01	Super alloys (Inconel - Hastelloy - Nimonic)		15 : 20	0.016-0.017
S02	Pure titanium (Grade 2 - Grade 4)		20 : 30	0.040-0.044
S03	Titanium alloys (Grade 5)		20 : 30	0.040-0.044
S04	Cobalt Chrome Alloys		15 : 20	0.020-0.022
H01	Hardened steels up to 55 HRC		15 : 20	0.016-0.017
H02	Hardened steels from 55 HRC		-	-