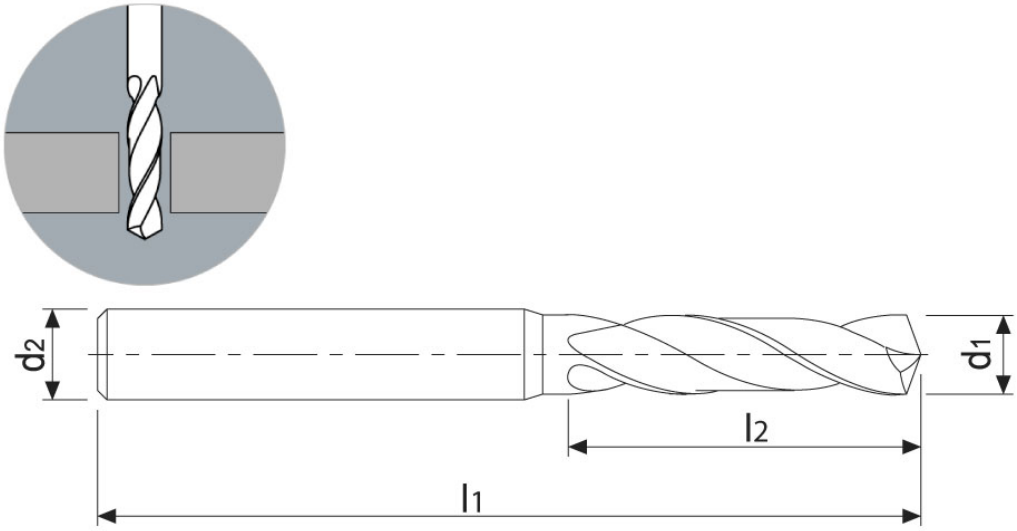

TTD2030275

Type: Short drill with reinforced shank

d1	d2	l1	l2
2,75	3,00	45	11,70

Coolant holes	Cut	Point angle	Spiral angle	Cutting edges Z
No	Right	140°	30°	2

Coated	Coating type	Material	Material type	Norm
Yes	TiAlN	MD	SMG SP	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		80 : 120	0,275
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		60 : 100	0,275
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		40 : 80	0,220
M01	Ferritic stainless steels		20 : 40	0,075
M02	Martensitic stainless steels		25 : 50	0,110
M03	Martensitic stainless steels - PH		20 : 30	0,075
M04	Austenitic stainless steels		20 : 30	0,075
K01	Gray/lamellar cast iron		80 : 120	0,385
K02	Nodular/nodular cast iron		80 : 120	0,385
N01	Drawn aluminum alloys		150 : 200	0,170
N02	Die-cast aluminum alloys		150 : 200	0,150
N03	Copper		80 : 120	0,110
N04	Brass - Bronze		60 : 100	0,140
N05	Lead-free brass		100 : 140	0,120
S01	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 40	0,013
S02	Pure titanium (Grade 2 - Grade 4)		20 : 40	0,080
S03	Titanium alloys (Grade 5)		15 : 30	0,090
S04	Cobalt Chrome Alloys		20 : 40	0,035
H01	Hardened steels up to 55 HRC		20 : 40	0,020

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H01	Hardened steels up to 55 HRC		20 : 40	0,020
H02	Hardened steels from 55 HRC		15 : 30	0,013