












TTD2040190

Type: Short high-performance twist drill with coolant holes

| d1 | d2 | l1 | l2 |
|------|------|----|-------|
| 1,90 | 3,00 | 46 | 11,90 |

| Coolant holes | Cut | Point angle | Spiral angle | Cutting edges Z |
|---------------|-------|-------------|--------------|-----------------|
| Yes | Right | 140° | 25° | 2 |

| Coated | Coating type | Material | Material type | Norm |
|--------|--------------|----------|---------------|------|
| Yes | TISINOS | 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 |  | 45 : 75 | 0.22 |
| P02 | Low alloy steels from 800 N/mm2 to 1100 N/mm2 |  | 40 : 70 | 0.21 |
| P03 | Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2 |  | 35 : 70 | 0.18 |
| M01 | Ferritic stainless steels |  | 30 : 50 | 0.08 |
| M02 | Martensitic stainless steels |  | 30 : 50 | 0.12 |
| M03 | Martensitic stainless steels - PH |  | 30 : 50 | 0.05 |
| M04 | Austenitic stainless steels |  | 20 : 40 | 0.05 |
| K01 | Gray/lamellar cast iron |  | 20 : 60 | 0.32 |
| K02 | Nodular/nodular cast iron |  | 15 : 40 | 0.32 |
| N01 | Drawn aluminum alloys |  | 100 : 300 | 0.12 |
| N02 | Die-cast aluminum alloys |  | 80 : 250 | 0.14 |
| N03 | Copper |  | 60 : 120 | 0.12 |
| N04 | Brass - Bronze |  | 80 : 140 | 0.14 |
| N05 | Lead-free brass |  | 80 : 140 | 0.16 |
| S01 | Super alloys (Inconel - Hastelloy - Nimonic) |  | 15 : 25 | 0.022 |
| S02 | Pure titanium (Grade 2 - Grade 4) |  | 15 : 25 | 0.085 |
| S03 | Titanium alloys (Grade 5) |  | 15 : 30 | 0.085 |
| S04 | Cobalt Chrome Alloys |  | 15 : 30 | 0.026 |
| H01 | Hardened steels up to 55 HRC |  | 20 : 40 | 0.02 |
| H02 | Hardened steels from 55 HRC |  | - | - |