



## TTD2040240

**Type:** Short high-performance twist drill with coolant holes

| d1   | d2   | l1 | l2    |
|------|------|----|-------|
| 2,40 | 4,00 | 53 | 15,00 |

| 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<br>Part.<br>recommended Not<br>recommended                              | (m/min)          | (mm/rev)                      |
| P01                  | Unalloyed steels up to 800 N/mm2                    |    | 45 : 75          | 0.23                          |
| P02                  | Low alloy steels from 800 N/mm2 to 1100 N/mm2       |    | 40 : 70          | 0.22                          |
| P03                  | Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2 |    | 35 : 70          | 0.19                          |
| M01                  | Ferritic stainless steels                           |    | 30 : 50          | 0.08                          |
| M02                  | Martensitic stainless steels                        |    | 30 : 50          | 0.12                          |
| M03                  | Martensitic stainless steels - PH                   |    | 30 : 50          | 0.06                          |
| M04                  | Austenitic stainless steels                         |   | 20 : 40          | 0.06                          |
| K01                  | Gray/lamellar cast iron                             |  | 20 : 60          | 0.35                          |
| K02                  | Nodular/nodular cast iron                           |  | 15 : 40          | 0.35                          |
| N01                  | Drawn aluminum alloys                               |  | 100 : 300        | 0.13                          |
| N02                  | Die-cast aluminum alloys                            |  | 80 : 250         | 0.15                          |
| N03                  | Copper                                              |  | 60 : 120         | 0.13                          |
| N04                  | Brass - Bronze                                      |  | 80 : 140         | 0.15                          |
| N05                  | Lead-free brass                                     |  | 80 : 140         | 0.17                          |
| S01                  | Super alloys (Inconel - Hastelloy - Nimonic)        |  | 15 : 25          | 0.023                         |
| S02                  | Pure titanium (Grade 2 - Grade 4)                   |  | 15 : 25          | 0.09                          |
| S03                  | Titanium alloys (Grade 5)                           |  | 15 : 30          | 0.09                          |
| S04                  | Cobalt Chrome Alloys                                |  | 15 : 30          | 0.032                         |
| H01                  | Hardened steels up to 55 HRC                        |  | 20 : 40          | 0.023                         |
| H02                  | Hardened steels from 55 HRC                         |  | -                | -                             |