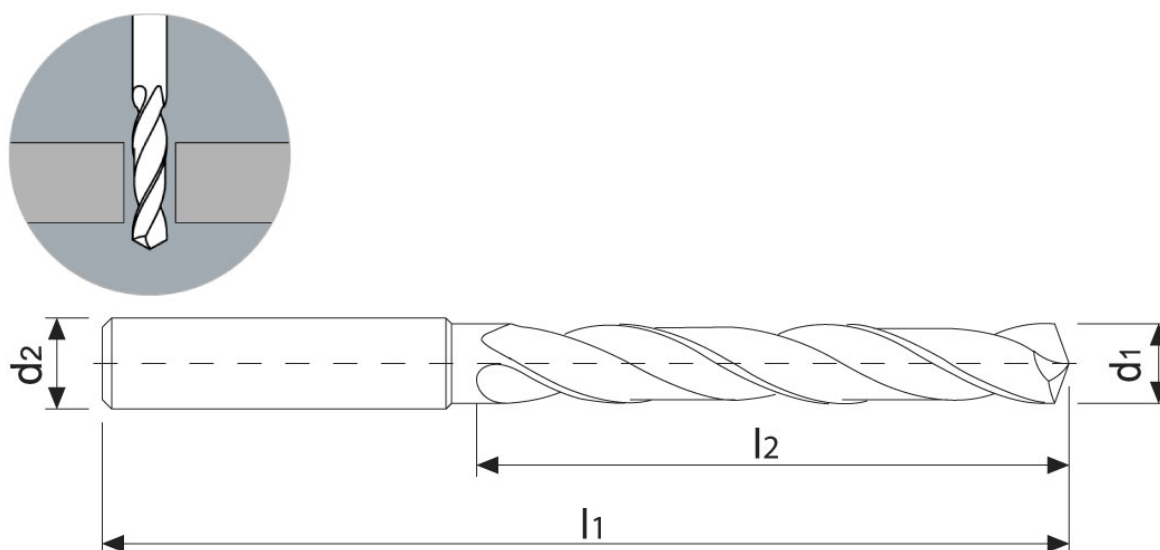




TTD2070105

Type: Long drill with reinforced shank

d1	d2	l1	l2
1,05	3,00	53	7,60

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 V _c	Advancement per revolution f _n
		Recommended Part. recommended Not recommended	(m/min)	(mm/rev)
P01	Unalloyed steels up to 800 N/mm ²		80 : 120	0,105
P02	Low alloy steels from 800 N/mm ² to 1100 N/mm ²		60 : 100	0,105
P03	Highly alloyed steels from 1100 N/mm ² to 1400 N/mm ²		40 : 80	0,080
M01	Ferritic stainless steels		20 : 40	0,020
M02	Martensitic stainless steels		25 : 50	0,040
M03	Martensitic stainless steels - PH		20 : 30	0,020
M04	Austenitic stainless steels		20 : 30	0,020
K01	Gray/lamellar cast iron		80 : 120	0,180
K02	Nodular/nodular cast iron		80 : 120	0,180
N01	Drawn aluminum alloys		150 : 200	0,075
N02	Die-cast aluminum alloys		150 : 200	0,070
N03	Copper		80 : 120	0,050
N04	Brass - Bronze		60 : 100	0,065
N05	Lead-free brass		100 : 140	0,050
S01	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 40	0,004
S02	Pure titanium (Grade 2 - Grade 4)		20 : 40	0,025
S03	Titanium alloys (Grade 5)		15 : 30	0,035
S04	Cobalt Chrome Alloys		20 : 40	0,015
H01	Hardened steels up to 55 HRC		20 : 40	0,008

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	0,105
P02	Low alloy steels from 800 N/mm2 to 1100 N/mm2		60 : 100	0,105
P03	Highly alloyed steels from 1100 N/mm2 to 1400 N/mm2		40 : 80	0,080
M01	Ferritic stainless steels		20 : 40	0,020
M02	Martensitic stainless steels		25 : 50	0,040
M03	Martensitic stainless steels - PH		20 : 30	0,020
M04	Austenitic stainless steels		20 : 30	0,020
K01	Gray/lamellar cast iron		80 : 120	0,180
K02	Nodular/nodular cast iron		80 : 120	0,180
N01	Drawn aluminum alloys		150 : 200	0,075
N02	Die-cast aluminum alloys		150 : 200	0,070
N03	Copper		80 : 120	0,050
N04	Brass - Bronze		60 : 100	0,065
N05	Lead-free brass		100 : 140	0,050
S01	Super alloys (Inconel - Hastelloy - Nimonic)		20 : 40	0,004
S02	Pure titanium (Grade 2 - Grade 4)		20 : 40	0,025
S03	Titanium alloys (Grade 5)		15 : 30	0,035
S04	Cobalt Chrome Alloys		20 : 40	0,015
H01	Hardened steels up to 55 HRC		20 : 40	0,008
H02	Hardened steels from 55 HRC		15 : 30	0,004



SWISS HIGH PRECISION TOOLS

